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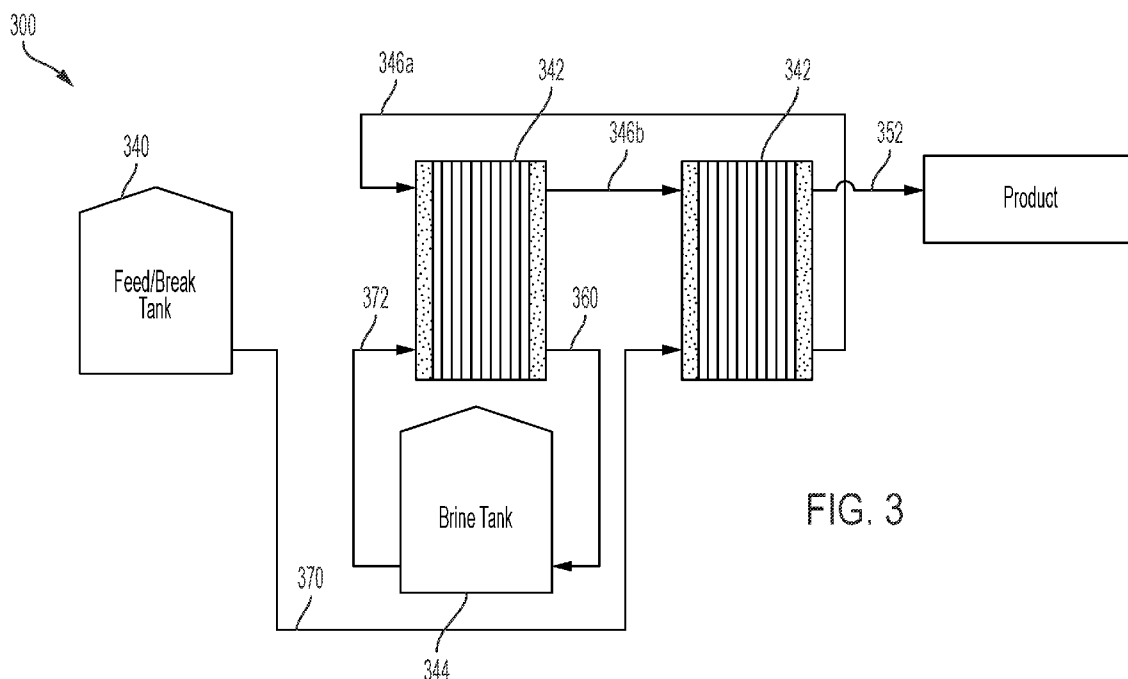


FIG. 3

(57) Abstract: Provided are electro dialysis systems comprising a plurality of electro dialysis devices, wherein each electro dialysis device of the plurality of electro dialysis devices has a product inlet stream, a product outlet stream, a brine inlet stream, and a brine outlet stream. The product inlet stream for a first electro dialysis device comprises the brine outlet stream of a second electro dialysis device. Further, a first portion of a feed stream is the brine inlet stream for the first electro dialysis device and a second portion of the feed stream is the brine inlet stream for the second electro dialysis device or a third electro dialysis device.



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ELECTRODIALYSIS SYSTEMS WITH DECREASED CONCENTRATION GRADIENTS AT HIGH RECOVERY RATES

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application claims the benefit of U.S. Provisional Application No. 62/831,508, filed April 9, 2019, the entire contents of which are incorporated herein by reference.

FIELD OF THE INVENTION

[0002] This disclosure relates to electro dialysis systems having decreased concentration gradients at high recovery rates. Specifically, this disclosure relates to electro dialysis systems comprising a plurality of electro dialysis devices, wherein the product inlet stream for a first electro dialysis device is the brine outlet stream of a second electro dialysis device.

BACKGROUND OF THE INVENTION

[0003] Electro dialysis is one example of a membrane-based large scale desalination method. Electro dialysis can be used to selectively remove positive and negative ions from a water source (e.g., brackish water or brine solution produced in reverse osmosis units) by transporting salt ions from one solution to another by way of individual electro dialysis devices. For optimal performance, an electro dialysis device utilizes an electrical current to separate charged ions from the water flowing through the device. For example, an electro dialysis device can include a pair of electrodes and alternating anionic and cationic exchange membranes. A voltage can be applied to one or more of the electrodes to initiate an electrochemical reaction. The alternating cationic exchange membranes and anionic exchange membranes can selectively remove ions from a first stream of fluid while introducing the removed ions to an adjacent, second stream of fluid. Through this exchange of ions, an electro dialysis system can result in a product stream (i.e., having a lower concentration of ions) and a brine stream (i.e., having a higher concentration of ions). The brine stream is typically waste. The product stream can be used in a variety of industries and applications including, but not limited to, oil and gas, refining and petrochemicals, power generation, food and beverage, pharmaceutical, microelectronics, pulp and paper, mining, and agriculture.

SUMMARY OF THE INVENTION

[0004] Provided are electro dialysis systems with decreased concentration gradients. In particular, provided are electro dialysis systems with decreased concentration gradients at high recovery rates. Also provided are methods of purifying water using said electro dialysis systems. The concentration gradient of an electro dialysis device compares the ionic concentration of the product stream to the ionic concentration of the brine stream. Conventional high-recovery electro dialysis systems, described in detail below, often experience high concentration gradients at high rates of recovery. High concentration gradients negatively impact the efficiency of the electro dialysis system. Thus, embodiments provided herein can improve the efficiency of electro dialysis systems by decreasing the concentration gradient in one or more electro dialysis devices. In particular, embodiments provided herein can lower the concentration gradient of a second electro dialysis device by making the product inlet stream for a first electro dialysis device the brine outlet stream of a second electro dialysis device.

[0005] A particular type of electro dialysis is high-recovery electro dialysis. High-recovery electro dialysis applications are focused on reducing the amount of waste generated (i.e., brine) to reduce the cost of waste disposal. Conventional high-recovery electro dialysis systems (e.g., electro dialysis system 200 of Figure 2, described in detail below) pass both a product stream (i.e., water to be purified) and a brine stream through a plurality of electro dialysis devices. As the product stream progresses through the plurality of electro dialysis devices, its ionic concentration decreases. As the brine stream progresses through the plurality of electro dialysis devices, its ionic concentration increases. Thus, by the time the product stream and the brine stream approach the last electro dialysis device of the plurality of electro dialysis devices, the concentration gradient between the product stream and the brine stream can be relatively high. This high concentration gradient can lead to at least two efficiency losses that have a detrimental impact on separation performance of the electro dialysis system—an increase in osmotic pressure and an increase in thermodynamic penalty. Osmotic pressure is the driving force that causes water to osmote from the dilute stream (i.e., the product stream) to the concentrate stream (i.e., brine stream).

Thermodynamic penalty, or Nernst loss, is directly proportional to the magnitude of the concentration gradient. For an electro dialysis system to operate successfully and efficiently, the rate at which the ions are transferred across the membrane must be faster than the flux of water across the ion-exchange membranes due to osmosis and electro-osmosis. However,

increases in osmotic pressure and increases in thermodynamic penalty make this difficult to achieve.

[0006] In particular, the systems and methods provided herein use a feed stream (e.g., from a feed water source) as both a product stream in a first electro dialysis device of a plurality of electro dialysis devices and a brine stream in a second electro dialysis device. In some embodiments, the feed stream may be used as the brine stream in at least a final electro dialysis device of the plurality of electro dialysis devices. Using the feed stream as the brine stream in at least one electro dialysis device can minimize the concentration gradient across the second electro dialysis device (i.e., the ionic concentration of the brine stream compared to that of the product stream) to improve the recovery of purified, or desalinated, water. In some embodiments, the brine outlet stream of the second electro dialysis device can then be routed back to one or more upstream electro dialysis devices (e.g., the first electro dialysis device). By bypassing one or more electro dialysis units and routing a portion of the feed stream to one or more downstream electro dialysis units (e.g., the second electro dialysis device), the concentration gradient of the one or more electro dialysis devices is decreased, particularly at higher rates of recovery.

[0007] Thus, the product inlet stream of an upstream electro dialysis device (e.g., the first electro dialysis device) is first a brine inlet stream for a downstream electro dialysis device (e.g., the second electro dialysis device). In other words, instead of sending a first product inlet stream to an electro dialysis device, the first product inlet stream can be used as the brine inlet stream for a downstream electro dialysis device. The brine outlet stream for the downstream electro dialysis device can then be used as the product inlet stream for the upstream electro dialysis device. By using a portion of the feed stream as a brine inlet stream in a downstream electro dialysis device, systems and methods according to embodiments provided herein actually add contaminants (i.e., ions) to the water to be purified prior to purifying the water. Once these contaminants are added (i.e., a portion of the feed stream is used as a brine inlet stream), the water to be purified is then used as the product inlet stream for an upstream electro dialysis device. Adding contaminants to increase the ionic concentration of the water to be purified and then subsequently removing the contaminants from the water to be purified is counter-intuitive. However, as discussed below, this can improve the efficiency of the electro dialysis system by minimizing the concentration gradient across one or more electro dialysis devices and fixing the concentration gradient of at least

one final electro dialysis device of the plurality of electro dialysis devices constant. In some embodiments, electro dialysis systems provided herein may be applied to low salinity applications (e.g., applications resulting in a product of 300 ppm or less).

[0008] In some embodiments, an electro dialysis system is provided, the electro dialysis system comprising: a plurality of electro dialysis devices, wherein each electro dialysis device of the plurality of electro dialysis devices comprises a product inlet stream, a product outlet stream, a brine inlet stream, and a brine outlet stream, wherein the product inlet stream for a first electro dialysis device comprises the brine outlet stream of a second electro dialysis device.

[0009] In some embodiments of the electro dialysis system, the system comprises a feed stream, wherein the brine inlet stream for the second electro dialysis device comprises the feed stream.

[0010] In some embodiments of the electro dialysis system, the system comprises a feed stream, wherein the brine inlet stream for a third electro dialysis device comprises the feed stream.

[0011] In some embodiments of the electro dialysis system, the third electro dialysis device is between the first electro dialysis device and the second electro dialysis device.

[0012] In some embodiments of the electro dialysis system, the brine inlet stream of the first electro dialysis device comprises the outlet stream of a brine tank, and the inlet stream of the brine tank comprises the brine outlet stream of the first electro dialysis device.

[0013] In some embodiments of the electro dialysis system, the brine inlet stream of the second electro dialysis device comprises the brine outlet stream of the third electro dialysis device.

[0014] In some embodiments of the electro dialysis system, the product inlet stream of the second electro dialysis device comprises the product outlet stream of the first electro dialysis device.

[0015] In some embodiments of the electro dialysis system, the product inlet stream of the third electro dialysis device comprises the product outlet stream of the first electro dialysis device.

[0016] In some embodiments of the electro dialysis system, a first portion of a feed stream is the brine inlet stream for the second electro dialysis device and a second portion of the feed stream is the brine inlet stream for a third electro dialysis device.

[0017] In some embodiments of the electro dialysis system, the product inlet stream for the first electro dialysis device comprises the brine outlet stream of the second electro dialysis device and the brine outlet stream of the third electro dialysis device.

[0018] In some embodiments of the electro dialysis system, an ionic concentration of the brine outlet stream of the second electro dialysis device is greater than an ionic concentration of the feed stream.

[0019] In some embodiments of the electro dialysis system, an ionic concentration of the product inlet stream of the first electro dialysis device is greater than an ionic concentration of the feed stream.

[0020] In some embodiments of the electro dialysis system, an ionic concentration of the brine inlet stream of the second electro dialysis device is less than 10 times an ionic concentration of the product inlet stream of the second electro dialysis device.

[0021] In some embodiments of the electro dialysis system, the electro dialysis system is configured to remove at least one of arsenic ions, fluoride ions, perchlorate ions, lithium ions, gold ions, or silver ions.

[0022] In some embodiments, a method of purifying water is provided, the method comprising: routing a brine outlet stream of a second electro dialysis device of a plurality of electro dialysis devices to a first electro dialysis device of the plurality of electro dialysis devices, wherein the product inlet stream of the first electro dialysis device comprises the brine outlet stream of the second electro dialysis device.

[0023] In some embodiments of the method, the method comprises: routing a brine inlet stream of the second electro dialysis device, wherein the brine inlet stream of the second electro dialysis device comprises a feed stream.

[0024] In some embodiments of the method, the method comprises: routing a brine inlet stream of a third electro dialysis device, wherein the brine inlet stream of the third electro dialysis device comprises a feed stream.

[0025] In some embodiments of the method, the third electro dialysis device is positioned between the first electro dialysis device and the second electro dialysis device.

[0026] In some embodiments of the method, the method comprises routing a brine inlet stream of the first electro dialysis device, wherein the brine inlet stream of the first electro dialysis device comprises a brine outlet stream of a brine tank, and a brine inlet stream of the brine tank comprises the brine outlet of the first electro dialysis device.

[0027] In some embodiments of the method, the brine inlet stream of the second electro dialysis device comprises the brine outlet stream of the third electro dialysis device.

[0028] In some embodiments of the method, the method comprises routing a product inlet of the second electro dialysis device, wherein the product inlet stream of the second electro dialysis device comprises the product outlet stream of the first electro dialysis device.

[0029] In some embodiments of the method, the method comprises routing a product inlet of the third electro dialysis device, wherein the product inlet stream of the third electro dialysis device comprises the product outlet stream of the first electro dialysis device.

[0030] In some embodiments of the method, the method comprises routing a first portion of a feed stream and a second portion of the feed stream, wherein the first portion of the feed stream is the brine inlet stream for the second electro dialysis device, and the second portion of the feed stream is the brine inlet for a third electro dialysis device.

[0031] In some embodiments of the method, the product inlet stream for the first electro dialysis device comprises the brine outlet stream of the second electro dialysis device and the brine outlet stream of the third electro dialysis device.

[0032] In some embodiments of the method, an ionic concentration of the brine outlet stream of the second electro dialysis device is greater than an ionic concentration of the feed stream.

[0033] In some embodiments of the method, an ionic concentration of the brine inlet stream of the second electro dialysis device is less than 10 times an ionic concentration of the product inlet stream of the second electro dialysis device.

[0034] In some embodiments of the method, the electro dialysis system is configured to remove at least one of arsenic ions, fluoride ions, perchlorate ions, lithium ions, gold ions, or silver ions.

BRIEF DESCRIPTION OF THE DRAWINGS

[0035] The invention will now be described, by way of example only, with reference to the accompanying drawings, in which:

[0036] FIG. 1 illustrates a schematic side view of an electro dialysis device, according to some embodiments;

[0037] FIG. 2 illustrates a conventional electro dialysis system;

[0038] FIG. 3 illustrates an electro dialysis system, according to some embodiments disclosed herein;

[0039] FIG. 4 illustrates an electro dialysis system, according to some embodiments disclosed herein;

[0040] FIG. 5 illustrates an electro dialysis system, according to some embodiments disclosed herein;

[0041] FIG. 6 illustrates an electro dialysis system, according to some embodiments disclosed herein;

[0042] FIG. 7 illustrates an electro dialysis system, according to some embodiments disclosed herein; and

[0043] FIG. 8 shows osmotic pressures of different electro dialysis systems as a function of recovery, according to some embodiments disclosed herein.

DETAILED DESCRIPTION OF THE INVENTION

[0044] Provided are electro dialysis systems having decreased concentration gradients at high recovery rates and methods of purifying water using said electro dialysis systems. As described above, the performance (i.e., recovery) of an electro dialysis system is related to osmotic pressure and thermodynamic penalty. As the recovery of an electro dialysis system increases, so too does the ionic concentration of the brine stream, as indicated in the Equation below, where C_{Brine} is the concentration of the brine stream, $C_{Product}$ is the concentration of the product stream, and C_{Inlet} is the concentration of the feed stream:

$$C_{Brine} = \frac{C_{Inlet} - Recovery * C_{Product}}{1 - Recovery}$$

[0045] Thus, as the recovery of the electro dialysis system and the ionic concentration of the brine stream both increase, the concentration gradient of the product stream and the brine stream also increases. As explained above, an increased concentration gradient leads to increased osmotic pressure and thermodynamic penalty, which in turn negatively impact the recovery of the electro dialysis system.

[0046] Accordingly, embodiments provided herein can improve recovery of a high-recovery electro dialysis system by decreasing the concentration gradient between the product stream and the brine stream in one or more electro dialysis devices.

[0047] Provided is a discussion of (1) the operation of an individual electro dialysis device, (2) a conventional high-recovery electro dialysis system, and (3) a high-recovery electro dialysis system with decreased concentration gradients. In both the conventional high-recovery electro dialysis system and the high-recovery electro dialysis system having decreased concentration gradients, a plurality of electro dialysis devices is used. As the product and brine streams pass through the plurality of electro dialysis devices, the ionic concentration of the product stream decreases and the ionic concentration of the brine stream increases.

[0048] As used herein, the term “electro dialysis device” refers to a single electro dialysis unit employing ion-exchange technology to separate ions from water. The term “electro dialysis system” refers to a process that includes two or more electro dialysis devices. Additionally, the terminology “first”, “second”, “third”, etc. is not intended to limit the configuration of electro dialysis devices, product streams, brine streams, etc. This terminology is only used for

illustrative purposes. Further, “first”, “second”, “third”, etc. is not intended to convey a specific order or configuration, but is only intended to indicate that one unit (e.g., electro dialysis device, product stream, brine stream, etc.) is different from another unit (e.g., electro dialysis device, product stream, brine stream, etc.).

OPERATION OF AN ELECTRODIALYSIS DEVICE

[0049] Provided below is a discussion of the basic operation of an individual electro dialysis device according to some embodiments and with respect to Figure 1. High-recovery electro dialysis systems and methods for desalinating water provided herein may include two or more individual electro dialysis devices.

[0050] An individual electro dialysis device (i.e., an ion-exchange device) can include at least one pair of electrodes and at least one pair of ion-exchange membranes placed there between. The at least one pair of ion-exchange membranes can include a cation-exchange membrane (“CEM”) and an anion-exchange membrane (“AEM”). In addition, at least one of the ion-exchange membranes (i.e., CEMs and/or AEMs) has a spacer on the surface of the ion-exchange membrane facing the other ion-exchange membrane in an electro dialysis device. In some embodiments, both the CEMs and the AEMs have a spacer on at least one surface facing the other ion-exchange membrane. The spacer can include a spacer border and a spacer mesh.

[0051] Figure 1 shows a schematic side view of electro dialysis device 100 according to some embodiments disclosed herein. Ion-exchange system 100 can include CEMs 104 and AEMs 106 sandwiched between two electrodes 102. In some embodiments, one or more CEM 104 and one or more AEM 106 may alternate throughout a length of the electro dialysis device 100.

[0052] An electrode 102 is shown on opposing ends of electro dialysis device 100. One electrode 102 can be a cathode and another electrode 102 can be an anode. In some embodiments, one or more electrodes 102 can encompass one or more fluid channels for electrolyte stream 112. For example, a fluid channel for electrolyte stream 112 of electrode 102 can be located between one or more CEM 104 and an electrode 102, or between one or more AEM 106 and an electrode 102. Electro dialysis device 100 may also include one or more fluid channels for influent streams 136a and 136b. Influent streams 136a and 136b may be located between a CEM 104 and an AEM 106. Influent streams 136a and 136b can

comprise water. In some embodiments, water of influent streams 136a and 136b may be purified by flowing through one or more intermembrane chambers located between two or more alternating CEM 104 and AEM 106. In particular, influent stream 136a may flow through electro dialysis device 100 and exit electro dialysis device 100 as brine stream 108. Influent stream 136b may flow through electro dialysis device 100 and exit electro dialysis device 100 as product stream 110. Thus, influent stream 136a is a brine inlet stream for electro dialysis device 100, and influent stream 136b is a product inlet stream for electro dialysis device 100 of Figure 1.

[0053] AEM 106 can allow passage of negatively charged ions and can substantially block the passage of positively charged ions. Conversely, CEM 104 can allow the passage of positively charged ions and can substantially block the passage of negatively charged ions.

[0054] Electrolyte stream 112 may be in direct contact with one or more electrodes 102. In some embodiments, electrolyte stream 112 may comprise the same fluid as the fluid of influent streams 136a and 136b. In some embodiments, electrolyte stream 112 may comprise a fluid different from the fluid of influent streams 136a and 136b. For example, electrolyte stream 112 can be any one or more of a variety of conductive fluids including, but not limited to, raw influent, a separately managed electrolyte fluid, NaCl solution, sodium sulfate solution, or iron chloride solution.

[0055] In some embodiments, electro dialysis device 100 can include one or more spacers on at least one surface of a CEM 104 or an AEM 106. In some embodiments, one or more spacer may be located on two opposing surfaces of a CEM 104 and/or an AEM 106. Further, electro dialysis device 100 may include one or more spacers between any two adjacent ion-exchange membranes (i.e., between an AEM 106 and a CEM 104). The region formed between any two adjacent ion-exchange membranes by one or more spacers forms an intermembrane chamber.

[0056] When an electric charge is applied to one or more electrodes 102 of electro dialysis device 100, the ions of influent streams 136a and 136b flowing through an intermembrane chamber between any two ion-exchange membranes (i.e., one or more CEM 104 and one or more AEM 106) can migrate towards the electrode of opposite charge. Specifically, ion-exchange membranes can comprise ionically conductive pores having either a positive or a negative charge. These pores can be permselective, meaning that they selectively permeate

ions of an opposite charge. Thus, the alternating arrangement of the ion-exchange membranes can generate alternating intermembrane chambers comprising decreasing ionic concentration and comprising increasing ionic concentration as the ions migrate towards the oppositely-charged electrode 102.

[0057] An intermembrane chamber can be formed from a spacer border and a spacer mesh and can create a path for fluids to flow. The number of intermembrane chambers may be increased by introducing additional alternating pairs of ion-exchange membranes. Introducing additional alternating pairs of CEMs 104 and AEMs 106 (and the intermembrane chambers formed between each pair of ion-exchange membranes) can also increase the capacity of electro dialysis device 100. In addition, the functioning ability of an individual ion-exchange cell (i.e., a single CEM 104 paired with a single AEM 106 to form a single intermembrane chamber) can be greatly augmented by configuring ion-exchange cells into ion-exchange stacks (i.e., a series of multiple ion-exchange cells.)

[0058] As described above, ions of influent streams 136a and 136b flowing through an intermembrane chamber can migrate towards electrode 102 of opposite charge when an electric current is applied to electro dialysis device 100. The ion-exchange membranes have a fixed charge (CEMs have a negative charge, AEMs have a positive charge). Thus, as a counter-ion approaches an ion-exchange membrane (e.g., as a cation approaches a CEM), the counter-ion is freely exchanged through the membrane. The removal of this counter-ion from the stream makes the stream a product stream. On the other hand, when a co-ion approaches the ion-exchange membrane (e.g., as an anion approaches a CEM), it is electrostatically repelled from the CEM. This separation mechanism can separate influent streams 136a and 136b into two different streams of opposite ionic charge. For example, when used for desalination, influent stream 136a may flow to brine stream 108, and influent stream 136b may flow to product stream 110. Brine stream 108 is generally a waste stream. In some embodiments, product stream 110 may have a lower ionic concentration than brine stream 108.

[0059] In some embodiments, product stream 110 may have a predetermined treatment level. For example, ion-exchange system 100 may be configured to remove several types of ions (e.g., monovalent ions, divalent ions, etc.) or it may be configured to remove a specific type of ion (e.g., arsenic, fluoride, perchlorate, lithium, gold, silver, etc.). Further, ion-exchange system 100 can be held together using a compression system that comprises using two

compression plates on opposite ends of the device. In some embodiments, a single pair of compression plates may be used (i.e., one on either end of the outside of the stack) to achieve a working, reliable seal.

CONVENTIONAL HIGH-RECOVERY ELECTRODIALYSIS SYSTEMS

[0060] Provided below is a description of conventional high-recovery electro dialysis systems. Figure 2 provides one embodiment of conventional high-recovery electro dialysis system 200. As discussed above, as the product stream and brine stream pass through the plurality of individual electro dialysis devices in a conventional high-recovery electro dialysis system, the concentration of the product stream decreases while the concentration of the brine stream increases. Accordingly, the concentration gradient between the product stream and the brine stream increases with each electro dialysis device. As this concentration gradient increases, the recovery and efficiency of the system suffers.

[0061] Figure 2 shows conventional high-recovery electro dialysis system 200 according to some embodiments. Conventional electro dialysis system 200 can include break tank 240, a plurality of electro dialysis devices 242, brine tank 244, feed stream 270, a plurality of product streams 246 (e.g., 246a, 246b, 246c), product outlet 252, a plurality of brine streams 254 (e.g., 254a, 254b, 254c, 260), brine recirculation stream 272, and/or brine outlet 262.

[0062] Feed stream 270 is shown as a product inlet stream (i.e., product stream 246a) flowing from break tank 240 to a first electro dialysis device 242. Product stream 246b is shown as a product outlet stream of the first electro dialysis device 242 and a product inlet stream of a second electro dialysis device 242. Product stream 246c is shown as a product outlet stream of the second electro dialysis device 242 and a product inlet stream of a third electro dialysis device 242. Provided the configuration shown, the ionic concentration of product stream 246a is greater than the ionic concentration of product stream 246b, which is greater than the ionic concentration of product stream 246c, which is greater than the ionic concentration of product outlet 252. Product outlet 252 may be recovered, purified water.

[0063] Feed stream 270 is also shown as a brine inlet stream (i.e., brine stream 254a) flowing from break tank 240 to electro dialysis device 242. Brine stream 254b is shown as a brine outlet stream of the first electro dialysis device 242 and a brine inlet stream of the second electro dialysis device 242. Brine stream 254c is shown as a brine outlet stream of the second electro dialysis device 242 and a brine inlet stream of the third electro dialysis device 242.

Provided the configuration shown in Figure 2, the ionic concentration of brine stream 254a is less than the ionic concentration of brine stream 254b, which is less than the ionic concentration of brine stream 254c, which is less than the ionic concentration of brine stream 260. In some embodiments of a conventional high-recovery electro dialysis system, brine streams 254a, 254b, and 254c may pass through each electro dialysis device 242 in a reversed path (i.e., counter to the product stream inlet 246a, 246b, and 246c flow direction) to reduce the concentration gradient. However, brine streams of conventional electro dialysis systems may need to be recirculated through a recirculation loop numerous times to achieve an acceptable recovery. With each circulation, the ionic concentration of brine streams 254a, 254b, and 254c steadily increase, to the point at which the rates of osmosis and electro-osmosis may overcome the rate of electro dialysis.

[0064] Figure 2 also shows a brine recirculation loop 260 including brine stream 260 (i.e., brine outlet stream of the third electro dialysis device 242), brine tank 244, and brine recirculation stream 272. The brine recirculation loop may increase the hydraulic water recovery of the process, or the ratio of product water to feed water (i.e., water entering system 200 from break tank 240).

HIGH-RECOVERY ELECTRODIALYSIS SYSTEMS HAVING DECREASED CONCENTRATION GRADIENTS AT HIGH RECOVERY RATES

[0065] Provided below is a discussion of embodiments of high-recovery electro dialysis systems having decreased concentration gradients at high recovery rates. In particular, embodiments of electro dialysis systems provided below can improve the recovery of the system by routing a feed stream to a downstream electro dialysis device as a brine inlet stream of the downstream electro dialysis device. After passing through said downstream electro dialysis device, the brine outlet stream of the downstream electro dialysis device can be routed back up to an upstream electro dialysis as a product inlet stream of the upstream electro dialysis device. In some embodiments, the brine outlet stream of the downstream electro dialysis device may be a brine inlet stream for a second electro dialysis device prior to being routed to an upstream electro dialysis device as a product inlet stream to the upstream electro dialysis device. In some embodiments, the product inlet stream of an upstream electro dialysis device comprises the brine outlet streams of two or more downstream electro dialysis devices. Electro dialysis systems according to embodiments provided herein

may be used to remove at least one of arsenic ions, fluoride ions, perchlorate ions, lithium ions, gold ions, or silver ions.

[0066] Embodiments of electro dialysis systems provided herein each include a plurality of electro dialysis devices, wherein each electro dialysis device of the plurality of electro dialysis devices has a product inlet stream, a product outlet stream, a brine inlet stream, and a brine outlet stream. In some embodiments, the product inlet stream for a first electro dialysis device is the brine outlet stream of a second electro dialysis device. In some embodiments, an electro dialysis system may have any number of two or more individual electro dialysis devices. In some embodiments, an electro dialysis system according to embodiments provided herein may have n electro dialysis devices, where n is any integer from 2 to 10. In some embodiments, n may be 3, 4, 5, 6, 7, 8, or 9. In some embodiments, n may be less than 10, less than 8, less than 6, or less than 4. In some embodiments, n may be more than 2, more than 4, or more than 8.

[0067] Figure 3 shows a high-recovery electro dialysis system 300 according to some embodiments. As shown in the Figure, high-recovery electro dialysis system 300 can include break tank 340, a plurality of electro dialysis devices 342, a plurality of product streams (e.g., 346a, 346b), a brine stream 360, product outlet 352, brine tank 344, brine recirculation stream 372, and feed stream 370. In particular, the brine outlet stream of the second, or last, electro dialysis device 342 is the product inlet stream (i.e., product stream 346a) of the first electro dialysis device 342.

[0068] In some embodiments, an electro dialysis device may comprise a feed stream, wherein the feed stream is a brine inlet stream for one or more downstream electro dialysis devices. For example, electro dialysis system 300 may have a feed stream 370. Feed stream 370 is shown as the brine inlet stream for the second electro dialysis device 342. In some embodiments, the brine outlet stream of the second, or last, electro dialysis device 342 is the product inlet stream of an upstream electro dialysis device 342. In Figure 3, the brine outlet stream of the second electro dialysis device 342 is the product inlet stream of the first electro dialysis device 342.

[0069] The product streams of Figure 3 include product stream 346a, 346b, and 352. Product stream 346a is the product inlet stream of the first electro dialysis device 342. Product stream 346b is the product outlet stream of the first electro dialysis device 342 and the product inlet

stream of the second electro dialysis device 342. The product outlet stream of the second electro dialysis device 342, product stream 352, may include recovered, purified water. The ionic concentration of product stream 346a is greater than the ionic concentration of product stream 346b, which is greater than the ionic concentration of product stream 352.

[0070] Because feed stream 370 flows to the second electro dialysis device 342, and the brine outlet stream of the second electro dialysis device 342 is the product inlet stream of the first electro dialysis device 342 (i.e., product stream 346a), the ionic concentration of product stream 346a is greater than the ionic concentration of feed stream 370. As described above with respect to conventional electro dialysis system 200 of Figure 2, conventional electro dialysis systems generally use the feed stream as the product inlet stream for the first electro dialysis device. However, because the product inlet stream of the first electro dialysis device 342 of Figure 3 is the brine outlet stream of the second electro dialysis device, the product inlet stream of the first electro dialysis device 342 has a greater ionic concentration than the product inlet stream of a first electro dialysis device of a conventional electro dialysis system, assuming feed tank concentrations, flow rates, etc. are the same.

[0071] In some embodiments, the brine inlet stream of a first electro dialysis device comprises the outlet stream of a brine tank, and the inlet stream of the brine tank comprises the brine outlet stream of the first electro dialysis device. For example, electro dialysis system 300 also includes a brine recirculation loop comprising brine stream 360, brine tank 344, and brine recirculation stream 372. As shown in the Figure, the brine outlet stream of the first electro dialysis device is brine stream 360. Brine stream 360 flows to brine tank 344, and the outlet stream of brine tank 344 is brine recirculation stream 372. Brine recirculation stream 372 is the brine inlet stream of the first electro dialysis device 342. In some embodiments, the concentration of brine recirculation stream 372 may increase as the number of passes through the brine recirculation loop increases.

[0072] Figure 4 shows another example of a high-recovery electro dialysis system 400 according to some embodiments. In particular, system 400 includes break tank 440, a plurality of electro dialysis devices 442, a plurality of product streams (e.g., 446a, 446b, 446c, 446d, 446e), a plurality of brine streams (e.g., 472a, 472b, 472c, 470b, 460), product outlet 452, brine tank 444, and feed stream 470a. In particular, the brine outlet stream of the last electro dialysis device 442 is the product inlet stream (i.e., product stream 446a) of the first electro dialysis device 442.

[0073] Feed stream 470a flows into the fourth electro dialysis device 442 as the brine inlet stream. The brine outlet stream of the fourth electro dialysis device 442 (i.e., brine stream 470b), is the brine inlet stream of the fifth, or last, electro dialysis device 442. As explained above, the brine outlet stream of the fifth electro dialysis device 442 is the product inlet stream (i.e., product stream 446a) of the first electro dialysis device 442. The ionic concentration of feed stream 470a is less than the ionic concentration of brine stream 470b, which is less than the ionic concentration of the brine outlet stream of the fifth electro dialysis device.

[0074] Electro dialysis system 400 includes several product streams. As explained above, product stream 446a is the product inlet stream of the first electro dialysis device 442. The product outlet stream of the first electro dialysis device (i.e., product stream 446b), is the product inlet stream of the second electro dialysis device. The product outlet stream of the second electro dialysis device (i.e., product stream 446c), is the product inlet stream of the third electro dialysis device. As shown, the product outlet stream of the third electro dialysis device 442 (i.e., product stream 446d), is the product inlet stream of the fourth electro dialysis device 442. The product outlet stream of the fourth electro dialysis device 442 (i.e., product stream 446e), is the product inlet stream of the fifth, or last, electro dialysis device 442. Product stream 452 is the product outlet stream of the fifth electro dialysis device 442 and may comprise recovered, or purified water. Based on this configuration, the ionic concentration of product stream 446a is greater than the ionic concentration of product stream 446b, which is greater than the ionic concentration of product stream 446c, which is greater than the ionic concentration of product stream 446d, which is greater than the ionic concentration of product stream 446e, and which is greater than the ionic concentration of product stream 452.

[0075] As shown in the Figures, the brine outlet stream of the fifth, or last, electro dialysis device 442 is the product inlet stream of the first electro dialysis device 442. Thus, the ionic concentration of the product inlet stream of the first electro dialysis device 442 (i.e., product stream 446a) is greater than the ionic concentration of feed stream 470a and brine stream 470b.

[0076] Electro dialysis system 400 also comprises a brine recirculation loop that comprises brine tank 444, brine recirculation stream 472a, brine stream 472b, brine stream 472c, and brine stream 460. As shown, the brine outlet stream of the third electro dialysis device 442,

brine stream 460, flows to brine tank 444. The outlet stream of brine tank 444, brine recirculation stream 472a, is the brine inlet stream for the first electro dialysis device 442. The brine outlet stream of the first electro dialysis device 442 (i.e., brine stream 472b), is the brine inlet stream for the second electro dialysis device 442. The brine outlet stream of the second electro dialysis device 442 (i.e., brine stream 472c), is the brine inlet stream for the third electro dialysis device 442. The brine outlet stream of the third electro dialysis device 442 is brine stream 460. Accordingly, the ionic concentration of brine recirculation stream 472a is less than the ionic concentration of brine stream 472b, which is less than the ionic concentration of brine stream 472c, which is less than the ionic concentration of brine stream 460 at any given point in time. In some embodiments, the ionic concentration of each of the brine streams may increase as the number of passes through the brine recirculation loop increases.

[0077] In some embodiments, a first portion of a feed stream is the brine inlet stream for a second electro dialysis device, and a second portion of the feed stream is the brine inlet stream for a third electro dialysis device, wherein both the second electro dialysis device and the third electro dialysis device are downstream of a first electro dialysis device. In some embodiments, the product inlet stream of the first electro dialysis device comprises the brine outlet stream of the second electro dialysis device and the brine outlet stream of the third electro dialysis device.

[0078] For example, Figure 5 provides an example of a high-recovery electro dialysis system 500 wherein the product inlet stream of the first electro dialysis device comprises the brine outlet streams of two different downstream electro dialysis devices. Electro dialysis system 500 comprises a plurality of electro dialysis devices 542, a plurality of product streams (e.g., 546a, 546b, 546c, 546d, 546e, 552), a plurality of brine streams (e.g., 572b, 572c, 560, 574a, 574b), a plurality of feed streams (e.g., 570a, 570b, 570c), a break tank 540, and a brine tank 544.

[0079] As shown in the figure, the brine outlet streams of the fourth and fifth electro dialysis devices 542 (i.e., brine stream 574a and 574b) merge to form product stream 546a, which is the product inlet stream of the first electro dialysis device 542. The product outlet stream of the first electro dialysis device 542 (i.e., product stream 546b), is the product inlet stream of the second electro dialysis device 542. The product outlet stream of the second electro dialysis device, (i.e., product stream 546c), is the product inlet stream of the third electro dialysis

device 542. The product outlet stream of the third electro dialysis device 542 (i.e., product stream 546d), is the product inlet stream of the fourth electro dialysis device 542. The product outlet stream of the fourth electro dialysis device 542 (i.e., product stream 546e), is the product inlet stream of the fifth electro dialysis device 542. The product outlet stream of the fifth electro dialysis device 542, (i.e., product stream 552), may comprise recovered, or purified, water. Based on this configuration, the ionic concentration of product stream 546a is greater than the ionic concentration of ionic stream 546b, which is greater than the ionic concentration of product stream 546c, which is greater than the ionic concentration of product stream 546d, which is greater than the ionic concentration of product stream 546e, and which is greater than the ionic concentration of product stream 552.

[0080] As shown in the figure, brine streams 574a and 574b, which are the brine outlet streams of the fourth and fifth electro dialysis devices, respectively, merge to form the product inlet stream of the first electro dialysis device 542 (i.e., product stream 546a). Thus, the ionic concentrations of brine stream 574a, brine stream 574b, and product stream 546a are all greater than the ionic concentration of any of the three feed streams (i.e., feed stream 570a, 570b, 570c). Feed stream 570a splits into feed stream 570b and 570c. In particular, feed stream 570a flows from break tank 540 and splits into feed stream 570b, which is the brine inlet stream of the fourth electro dialysis device 542, and feed stream 570c, which is the brine inlet stream of the fifth electro dialysis device 542.

[0081] Electro dialysis system 500 also comprises a brine recirculation loop that comprises brine tank 544, brine recirculation stream 572a, brine stream 572b, brine stream 572c, and brine stream 560. As shown, the brine outlet stream of the third electro dialysis device 542, brine stream 560, flows to brine tank 544. The outlet stream of brine tank 544 (i.e., brine recirculation stream 572a), is the brine inlet stream for the first electro dialysis device 542. The brine outlet stream of the first electro dialysis device 542 (i.e., brine stream 572b), is the brine inlet stream for the second electro dialysis device 542. The brine outlet stream of the second electro dialysis device 542 (i.e., brine stream 572c), is the brine inlet stream for the third electro dialysis device 542. The brine outlet stream of the third electro dialysis device 542 is brine stream 560. Accordingly, the ionic concentration of brine recirculation stream 572a is less than the ionic concentration of brine stream 572b, which is less than the ionic concentration of brine stream 572c, which is less than the ionic concentration of brine stream 560 at any given point in time. In some embodiments, the ionic concentration of each of the

brine streams may increase as the number of passes through the brine recirculation loop increases.

[0082] Figure 6 shows a high-recovery electro dialysis system 600 according to some embodiments. As shown in the Figure, high-recovery electro dialysis system 600 can include break tank 640, a plurality of electro dialysis devices 642, a plurality of product streams (e.g., 646a, 646b, 646c), a plurality of brine streams (e.g., 654a, 654b, 660), product outlet 652, brine outlet 662, brine tank 644, brine recirculation stream 672, and feed stream 670. In particular, the brine outlet stream of the third electro dialysis device 642 is the product inlet stream (i.e., product stream 646a) of the first electro dialysis device 642.

[0083] In some embodiments, an electro dialysis system may comprise a feed stream, wherein a first portion of the feed stream is the brine inlet stream for the first electro dialysis device and a second portion of the feed stream is the brine inlet stream for the second electro dialysis device. As shown in Figure 6, feed stream 670 flows to the first electro dialysis device 642 as a brine inlet stream (i.e., brine stream 654a). Feed stream 670 also flows to a downstream electro dialysis device 642 as a brine inlet stream for the downstream electro dialysis device 642. The brine outlet stream of this downstream electro dialysis device 642 is the product inlet stream (i.e., product stream 646a) for the first electro dialysis device 642.

[0084] As explained above, the product inlet stream for the first electro dialysis device 642 (i.e., product stream 646a) is the brine outlet stream of the third electro dialysis device 642 of Figure 6. The product outlet stream of the first electro dialysis device 642 is product stream 646b, which is the product inlet stream of a second electro dialysis device 642. The product outlet stream of the second electro dialysis device 642 is product stream 646c, which is the product inlet stream of the third electro dialysis device. Given the configuration provided in Figure 6, the ionic concentration of product stream 646a is greater than the ionic concentration of product stream 646b, which is greater than the ionic concentration of the product stream 646c, which is greater than the ionic concentration of product outlet 652. Product outlet 652 may be recovered, purified water.

[0085] Unlike conventional electro dialysis system 200 of Figure 2, which depicts product stream 246a being fed to the first electro dialysis device 242 from break tank 240, electro dialysis system 600 shows product stream 646a fed to the first electro dialysis device 642 from the brine outlet stream of the third electro dialysis device 642. As discussed above, a

product stream (i.e., feed stream 670) is fed from break tank 640 to a downstream stage of the process (e.g., the third electro dialysis device 642). At the third electro dialysis device 642, feed stream 670 is the brine inlet stream. The brine outlet stream of the third electro dialysis device 642 may be routed to the first electro dialysis device 642 as a product inlet stream (i.e., product stream 646a). By routing feed stream 670 to the third electro dialysis unit, the concentration gradient of the third electro dialysis unit can become fixed. This feature is explained in more detail in the Example, provided below.

[0086] Further, because feed stream 670 is routed to the third electro dialysis device 642 as a brine inlet stream, and the brine outlet stream of the third electro dialysis device 642 is the product inlet stream (i.e., product stream 646a) of the first electro dialysis device 642, the ionic concentration of product stream 646a is greater than the ionic concentration of brine stream 654a (assuming brine stream 654a comprises water from only feed stream 670 and not from brine recirculation stream 672).

[0087] Embodiments of electro dialysis systems having decreased concentration gradients at high recovery rates may include various configurations of electro dialysis devices, product streams, brine streams, etc. For example, feed stream 670 may be routed directly to the last (i.e., n^{th} electro dialysis device as depicted in Figure 6. In some embodiments, feed stream 670 may be routed directly to the second-to-last ($n-1$) electro dialysis device, etc. Similarly, in some embodiments, the brine outlet stream of the n^{th} electro dialysis device 642 may be routed directly to the first electro dialysis unit. In some embodiments, feed stream 670 may be routed to an intermediary electro dialysis device 642, in which case the brine outlet stream of said intermediary electro dialysis device 642 may be a brine inlet stream for a second intermediary electro dialysis device 642 or the n^{th} electro dialysis device, before the brine outlet stream of the n^{th} electro dialysis device 642 is routed to an the upstream electro dialysis device (e.g., the first electro dialysis device, the second electro dialysis device, the third electro dialysis device, etc.).

[0088] By routing feed stream 670 to a downstream electro dialysis device as a brine inlet stream, the ionic concentration of the brine inlet stream/feed stream 670 at the downstream electro dialysis device is less than that of a conventional electro dialysis system (assuming feed stream concentrations, stream flow rate and conduit dimensions, and electro dialysis devices are all identical). Because the ionic concentration of the brine inlet stream/feed stream 670 at

the downstream device is lower, so too is the concentration gradient at that downstream device. Thus, the efficiency of the system, particularly at high recovery rates, is improved.

[0089] Like brine stream 254a of Figure 2, brine stream 654a of Figure 6 is also shown flowing directly from break tank 640 to the first electro dialysis device 642. The brine outlet stream of the first electro dialysis device 642, brine stream 654b, is the brine inlet stream of the second electro dialysis device 642. The ionic concentration of brine stream 654a is less than the ionic concentration of brine stream 654b.

[0090] In some embodiments, the concentration gradient at one or more electro dialysis devices may be less than that of a conventional high-recovery electro dialysis system (i.e., electro dialysis system 200 of Figure 2). For example, the concentration gradient at a last electro dialysis device of a high-recovery electro dialysis system according to embodiments provided herein may be less than the concentration gradient at the last electro dialysis device of a conventional electro dialysis system. The concentration gradient is defined as a ratio between the ionic concentration of the brine stream and the ionic concentration of the product stream. In some embodiments, the concentration gradient of an electro dialysis device according to embodiments provided herein may be from 1-20 or from 2-10 (or, the ionic concentration of the brine stream may be from 1-20 times or from 2-10 times the ionic concentration of the product stream). In some embodiments, the concentration gradient may be more than 1, more than 2, more than 4, more than 6, more than 8, more than 10, more than 12, more than 14, more than 16, or more than 18. In some embodiments, the concentration gradient may be less than 20, less than 18, less than 16, less than 14, less than 12, less than 10, less than 8, less than 6, or less than 4.

[0091] Figure 6 also includes a brine recirculation loop, like that of Figure 2. The brine recirculation loop may include brine outlet stream 660, brine tank 644, and brine recirculation stream 672. A brine recirculation loop may increase the hydraulic water recovery of the process, or the ratio of product water to feed water (i.e., water entering system 600 from break tank 640). However, unlike the brine recirculation loop of Figure 2, brine recirculation loop of Figure 6 is shown recycling through $n-1$ devices, or all but one of the electro dialysis devices 642. In some embodiments, brine stream 652 may recirculate through a total of $n-2$ devices, $n-3$ devices, etc. Brine tank 644 is a reservoir configured to route some of the brine to brine outlet 662 and some of the brine to brine recirculation stream 672. In some embodiments, brine recirculation stream 672 may join brine stream 654a.

[0092] In some embodiments, a feed stream of an electro dialysis system according to embodiments provided herein may have an ionic concentration from 100 to 1000 ppm. In some embodiments, a feed stream may have an ionic concentration of more than 100 ppm, more than 200 ppm, more than 300 ppm, more than 400 ppm, more than 500 ppm, more than 600 ppm, more than 700 ppm, or more than 800 ppm. In some embodiments, a feed stream may have an ionic concentration of less than 1000 ppm, less than 900 ppm, less than 800 ppm, less than 700 ppm, less than 600 ppm, less than 500 ppm, less than 400 ppm, or less than 300 ppm. In some embodiments, a feed stream (and break tank) may comprise water to be purified.

[0093] In some embodiments, a product output of an electro dialysis system according to embodiments provided herein may have an ionic concentration of 5 to 300 ppm, from 10 to 200 ppm, or from 20 to 100 ppm. In some embodiments, a product output may have an ionic concentration of less than 300 ppm, less than 200 ppm, less than 100 ppm, less than 90 ppm, less than 80 ppm, less than 70 ppm, less than 60 ppm, less than 50 ppm, less than 40 ppm, less than 30 ppm, less than 20 ppm, or less than 10 ppm. In some embodiments, a product output may have an ionic concentration of more than 5 ppm, more than 10 ppm, more than 20 ppm, more than 30 ppm, more than 40 ppm, more than 50 ppm, more than 60 ppm, more than 70 ppm, more than 80 ppm, more than 90 ppm, more than 100 ppm, or more than 200 ppm.

[0094] Figure 7 provides an additional embodiment of a high-recovery electro dialysis system according to some embodiments. Specifically, Figure 7 includes electro dialysis system 700 that includes break tank 740, a plurality of electro dialysis devices 742, a plurality of product streams (e.g., 746a, 746b, 746c), brine stream 754, product outlet 752, brine outlet 762, brine tank 744, brine stream 760, brine recirculation stream 772, and feed streams 770a and 770b.

[0095] In the figure, feed stream 770a is also the brine inlet stream for an intermediary electro dialysis device 742 (i.e., the third electro dialysis device 742). The brine outlet stream of the last electro dialysis device 742 (i.e., the second electro dialysis device 742) is the product inlet stream (i.e., product stream 746a) for the first electro dialysis device 742. In some embodiments, the third electro dialysis device is between the first electro dialysis device and the second electro dialysis device. However, when describing Figure 7 below, the three electro dialysis devices 742 will be referred to as the first electro dialysis device 742, the second electro dialysis device 742, and the third electro dialysis device 742 in the order they are shown in the Figure, from left to right.

[0096] As shown in the Figure, feed stream 770 is routed from break tank 740 to the second electro dialysis device 742. In some embodiments, feed stream 770 is the brine inlet stream of the second electro dialysis device 742. In some embodiments, the brine outlet stream of the second electro dialysis device 742 (i.e., feed stream 770b) is the brine inlet stream of the third electro dialysis device 742. The brine outlet stream of third electro dialysis device 742 is routed to the first electro dialysis device 742 as the product inlet stream (i.e., product stream 746a). In some embodiments, product outlet 752 may comprise purified water.

[0097] In some embodiments, the brine outlet stream of a electro dialysis device recirculates through a brine tank and joins the brine inlet stream of the first electro dialysis device. For example, brine stream 754 of Figure 7 may recirculate through the one or more electro dialysis device 742. In some embodiments, brine stream 754 may recirculate through $n-m$ electro dialysis devices, where m is the number of electro dialysis devices that a portion of feed stream 770 passes through as a brine stream before being routed back to an upstream device as a product stream. For example, in Figure 7, feed stream 770 passes through two of three total electro dialysis devices as a brine stream. Thus, brine stream 754 recirculates through only one electro dialysis device 742. In particular, the brine recirculation loop includes brine tank 744, brine outlet stream 760, and brine recirculation stream 772.

[0098] In some embodiments, the feed stream may be both a brine inlet stream and a product inlet stream for the first electro dialysis device 742. In some embodiments, the product outlet stream of the first electro dialysis device may bypass one or more second, or intermediary, electro dialysis device 742. For example, a product outlet stream of the first electro dialysis device 742 may bypass the second electro dialysis device

[0099] Brine tank 744 and brine outlet 762 may comprise any of the embodiments of brine tank 644 and/or brine outlet 662 discussed about with respect to Figure 6. Given the configuration provided in Figure 7, the ionic concentration of product stream 746a is greater than the ionic concentration of product stream 746b, which is greater than the ionic concentration of the product stream 746c, which is greater than the ionic concentration of product out 752. Product outlet 752 may be recovered, purified water.

EXAMPLE

[0100] Provided below is data comparing a conventional electro dialysis device (e.g., electro dialysis device 200 of Figure 2) with an electro dialysis device having decreased

concentration gradients at high recovery rates (e.g., electro dialysis device 600 of Figure 6). Specifically, Table 1, below, shows data with respect to a conventional electro dialysis device, and Table 2 shows data with respect to an electro dialysis device having decreased concentration gradients. Figure 8 provides osmotic pressures observed in a last stage (i.e., n^{th} electro dialysis device of n total devices) for both processes.

[0101] The data shown in Tables 1 and 2 reflect a feed stream with an ionic content of 500 mg/L and a desired product quality of 50 mg/L. Both the conventional electro dialysis system reflected in Table 1 and the electro dialysis system with decreased concentration gradients reflected in Table 2 include three electro dialysis devices and a single brine recirculation loop. The amount of salt removal per electro dialysis device was constant for both systems. Further, the flow channels of each system had identical dimensions, the product and brine streams had identical dimensions, and the product and brine flow velocities were equivalent between the two systems. Additionally, it could be assumed that there were no losses across either system.

[0102] Tables 1 and 2 show how the ionic concentrations change with each hydraulic pass in the brine recirculation loop. The concentration gradient at each electro dialysis device is shown as a ratio between the inlet concentration of the brine stream B_i and the concentration of the process stream P_i , where i is the particular electro dialysis device at which the brine stream or product stream is entering, where i is 1, 2, or 3. The recovery after each hydraulic pass through an electro dialysis device can be calculated by rearranging the following equation to solve for recovery:

$$C_{Brine} = \frac{C_{Inlet} - Recovery * C_{Product}}{1 - Recovery}$$

[0103] As shown in Table 2 and described above, by routing feed stream past at least a first electro dialysis device and to a downstream electro dialysis device as a brine inlet stream, the concentration gradient of the downstream electro dialysis device can be decreased and/or controlled to a constant value. When comparing the two processes between Table 1 and Table 2, it is clear that fixing the concentration gradient in the one or more downstream electro dialysis devices can significantly improve the recovery and efficiency of the system. Where B_3/P_3 is roughly 36 and 76 for the 90% and 95% recovery cases of Table 1 (i.e., conventional electro dialysis system), it is always 4 in Table 2 (i.e., electro dialysis system having improved recovery).

[0104] The difference in concentrations of the brine stream and the product stream (i.e., the concentration gradient) begins to exert an osmotic pressure on the membrane. Figure 8 shows the magnitude of the osmotic pressure for both a conventional electro dialysis system and an electro dialysis system having decreased concentration gradients. For the electro dialysis system having decreased concentration gradients at high recovery rates, the osmotic pressure is constant and only about 4 psi across all recoveries. In contrast, the osmotic pressure of the conventional electro dialysis system increases sharply at recovery values beyond 80%, up to more than 50 psi for the 95% recovery case.

No. Passes	1	2	3	4	6	9	19
P ₁ (ppm)	500	500	500	500	500	500	500
B ₁ (ppm)	500	950	1400	1850	2750	4100	8600
B ₁ /P ₁	1	1.9	2.8	3.7	5.5	8.2	17.2
P ₂ (ppm)	250	250	250	250	250	250	250
B ₂ (ppm)	750	1200	1650	2100	3000	4350	8850
B ₂ /P ₂	3	4.8	6.6	8.4	12	17.4	35.4
P ₃ (ppm)	125	125	125	125	125	125	125
B ₃ (ppm)	875	1325	1775	2225	3125	4475	8975
B ₃ /P ₃	7	10.6	14.2	17.8	25	35.8	71.8
Product (ppm)	50	50	50	50	50	50	50
Brine (ppm)	950	1400	1850	2300	3200	4550	9050
Recovery	50%	67%	75%	80%	86%	90%	95%

Table 1. Stream Table for Conventional Electro dialysis System

No. Passes	1	2	3	4	6	9	19
P ₁ (ppm)	575	575	575	575	575	575	575
B ₁ (ppm)	500	950	1400	1850	2750	4100	8600
B ₁ /P ₁	0.9	1.7	2.4	3.2	4.8	7.1	15.0
P ₂ (ppm)	275	275	275	275	275	275	275
B ₂ (ppm)	800	1250	1700	2150	3050	4400	8900
B ₂ /P ₂	2.9	4.5	6.2	7.8	11.1	16.0	32.4
P ₃ (ppm)	125	125	125	125	125	125	125
B ₃ (ppm)	500	500	500	500	500	500	500
B ₃ /P ₃	4	4	4	4	4	4	4
Product (ppm)	50	50	50	50	50	50	50
Brine (ppm)	950	1400	1850	2300	3200	4550	9050
Recovery	50%	67%	75%	80%	86%	90%	95%

Table 2. Stream Table for Electro dialysis Device with Improved Recovery

METHODS FOR PURIFYING WATER USING HIGH-RECOVERY ELECTRODIALYSIS SYSTEMS WITH IMPROVED RECOVERY

[0105] Provided below is a discussion of methods for purifying water including electro dialysis systems having decreased concentration gradients at high rates of recovery disclosed above.

[0106] Methods of purifying water provided herein include routing a brine outlet stream of a downstream electro dialysis device to an upstream electro dialysis device. Specifically, the brine outlet stream of the downstream electro dialysis device is the product inlet stream of the upstream electro dialysis device. The first and second electro dialysis devices (and any other electro dialysis devices of the electro dialysis system) may include any of the ion-exchange devices described with respect to Figure 1.

[0107] In some embodiments, methods for purifying water may include a feed stream. For example, a first portion of the feed stream may be routed to the first electro dialysis device as a brine inlet stream. A second portion of the feed stream may be routed to the second electro dialysis device as a brine inlet stream. In some embodiments, the second portion of the feed stream may be routed to a third electro dialysis device as a brine inlet stream. (The third electro dialysis device may be positioned between the first and the second electro dialysis device). In some embodiments, the first portion and the second portion of the feed stream may originate from a single feed stream. In some embodiments, the first portion and the second portion of the feed stream may originate from a break tank.

[0108] In some embodiments, pumps, valves, gauges, transmitters, electronic controllers, (e.g., PLC) and/or other suitable water treatment flow devices may be used to monitor and transport water through the various conduits and electro dialysis devices.

[0109] The preceding description sets forth exemplary methods, parameters and the like. It should be recognized, however, that such description is not intended as a limitation on the scope of the present disclosure but is instead provided as a description of exemplary embodiments. The illustrative embodiments described above are not meant to be exhaustive or to limit the disclosure to the precise forms disclosed. Many modifications and variations are possible in view of the above teachings. The embodiments were chosen and described to best explain the principles of the disclosed techniques and their practical applications. Others

skilled in the art are thereby enabled to best utilize the techniques, and various embodiments with various modifications as are suited to the particular use contemplated.

[0110] Although the disclosure and examples have been thoroughly described with reference to the accompanying figures, it is to be noted that various changes and modifications will become apparent to those skilled in the art. Such changes and modifications are to be understood as being included within the scope of the disclosure and examples as defined by the claims. In the preceding description of the disclosure and embodiments, reference is made to the accompanying drawings, in which are shown, by way of illustration, specific embodiments that can be practiced. It is to be understood that other embodiments and examples can be practiced, and changes can be made without departing from the scope of the present disclosure.

[0111] Although the preceding description uses terms first, second, etc. to describe various elements, these elements should not be limited by the terms. These terms are only used to distinguish one element from another.

[0112] Also, it is also to be understood that the singular forms “a,” “an,” and “the” used in the preceding description are intended to include the plural forms as well unless the context indicates otherwise. It is also to be understood that the term “and/or” as used herein refers to and encompasses any and all possible combinations of one or more of the associated listed items. It is further to be understood that the terms “includes,” “including,” “comprises,” and/or “comprising,” when used herein, specify the presence of stated features, integers, steps, operations, elements, components, and/or units but do not preclude the presence or addition of one or more other features, integers, steps, operations, elements, components, units, and/or groups thereof.

[0113] The term “if” may be construed to mean “when” or “upon” or “in response to determining” or “in response to detecting,” depending on the context.

[0114] Although the disclosure and examples have been fully described with reference to the accompanying figures, it is to be noted that various changes and modifications will become apparent to those skilled in the art. Such changes and modifications are to be understood as being included within the scope of the disclosure and examples as defined by the claims.

CLAIMS

1. An electro dialysis system comprising:
a plurality of electro dialysis devices, wherein each electro dialysis device of the plurality of electro dialysis devices comprises a product inlet stream, a product outlet stream, a brine inlet stream, and a brine outlet stream,
wherein the product inlet stream for a first electro dialysis device comprises the brine outlet stream of a second electro dialysis device.
2. The system of claim 1, comprising a feed stream, wherein the brine inlet stream for the second electro dialysis device comprises the feed stream.
3. The system of claim 1, comprising a feed stream, wherein the brine inlet stream for a third electro dialysis device comprises the feed stream.
4. The system of claim 3, wherein the third electro dialysis device is between the first electro dialysis device and the second electro dialysis device.
5. The system of any of claims 2-4, wherein the brine inlet stream of the first electro dialysis device comprises the outlet stream of a brine tank, and the inlet stream of the brine tank comprises the brine outlet stream of the first electro dialysis device.
6. The system of any of claims 3-5, wherein the brine inlet stream of the second electro dialysis device comprises the brine outlet stream of the third electro dialysis device.
7. The system of claim 2, wherein the product inlet stream of the second electro dialysis device comprises the product outlet stream of the first electro dialysis device.
8. The system of any of claims 3-6, wherein the product inlet stream of the third electro dialysis device comprises the product outlet stream of the first electro dialysis device.
9. The system of claim 1, wherein a first portion of a feed stream is the brine inlet stream for the second electro dialysis device and a second portion of the feed stream is the brine inlet stream for a third electro dialysis device.
10. The system of claim 9, wherein the product inlet stream for the first electro dialysis device comprises the brine outlet stream of the second electro dialysis device and the brine outlet stream of the third electro dialysis device.

11. The system of any of claims 2-10, wherein an ionic concentration of the brine outlet stream of the second electro dialysis device is greater than an ionic concentration of the feed stream.
12. The system of any of claims 2-11, wherein an ionic concentration of the product inlet stream of the first electro dialysis device is greater than an ionic concentration of the feed stream.
13. The system of any of claims 1-12, wherein an ionic concentration of the brine inlet stream of the second electro dialysis device is less than 10 times an ionic concentration of the product inlet stream of the second electro dialysis device.
14. The system of any of claims 1-13, wherein the electro dialysis system is configured to remove at least one of arsenic ions, fluoride ions, perchlorate ions, lithium ions, gold ions, or silver ions.
15. A method of purifying water comprising:
routing a brine outlet stream of a second electro dialysis device of a plurality of electro dialysis devices to a first electro dialysis device of the plurality of electro dialysis devices, wherein the product inlet stream of the first electro dialysis device comprises the brine outlet stream of the second electro dialysis device.
16. The method of claim 15, comprising:
routing a brine inlet stream of the second electro dialysis device, wherein the brine inlet stream of the second electro dialysis device comprises a feed stream.
17. The method of claim 15, comprising:
routing a brine inlet stream of a third electro dialysis device, wherein the brine inlet stream of the third electro dialysis device comprises a feed stream.
18. The method of claim 17, wherein the third electro dialysis device is positioned between the first electro dialysis device and the second electro dialysis device.
19. The method of any of claims 16-18, comprising routing a brine inlet stream of the first electro dialysis device, wherein the brine inlet stream of the first electro dialysis device comprises a brine outlet stream of a brine tank, and a brine inlet stream of the brine tank comprises the brine outlet of the first electro dialysis device.

20. The method of any of claims 17-19, wherein the brine inlet stream of the second electro dialysis device comprises the brine outlet stream of the third electro dialysis device.
21. The method of claim 16, comprising routing a product inlet of the second electro dialysis device, wherein the product inlet stream of the second electro dialysis device comprises the product outlet stream of the first electro dialysis device.
22. The method of any of claims 17-20, comprising routing a product inlet of the third electro dialysis device, wherein the product inlet stream of the third electro dialysis device comprises the product outlet stream of the first electro dialysis device.
23. The method of claim 15, comprising routing a first portion of a feed stream and a second portion of the feed stream, wherein the first portion of the feed stream is the brine inlet stream for the second electro dialysis device, and the second portion of the feed stream is the brine inlet for a third electro dialysis device.
24. The method of claim 23, wherein the product inlet stream for the first electro dialysis device comprises the brine outlet stream of the second electro dialysis device and the brine outlet stream of the third electro dialysis device.
25. The method of any of claims 16-24, wherein an ionic concentration of the brine outlet stream of the second electro dialysis device is greater than an ionic concentration of the feed stream.
26. The method of any of claims 15-25, wherein an ionic concentration of the brine inlet stream of the second electro dialysis device is less than 10 times an ionic concentration of the product inlet stream of the second electro dialysis device.
27. The method of any of claims 15-26, wherein the electro dialysis system is configured to remove at least one of arsenic ions, fluoride ions, perchlorate ions, lithium ions, gold ions, or silver ions.

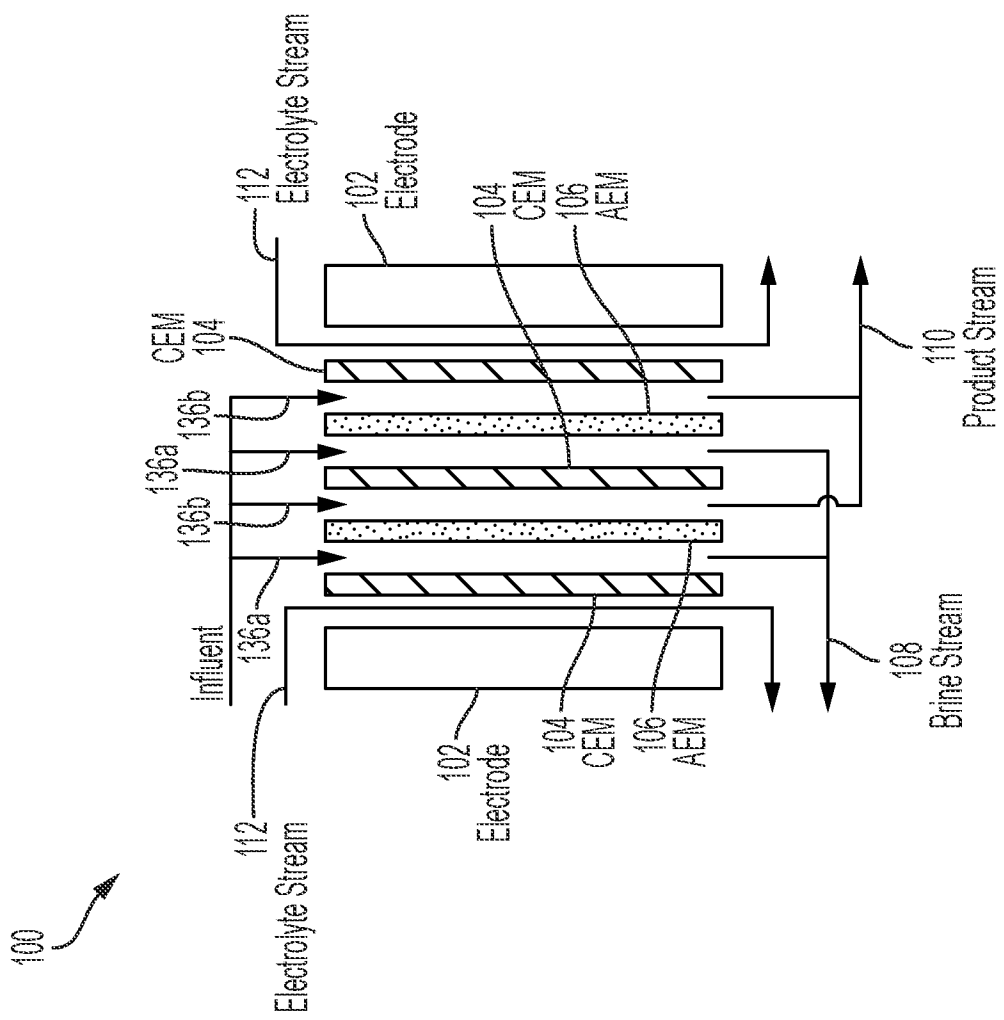


FIG. 1

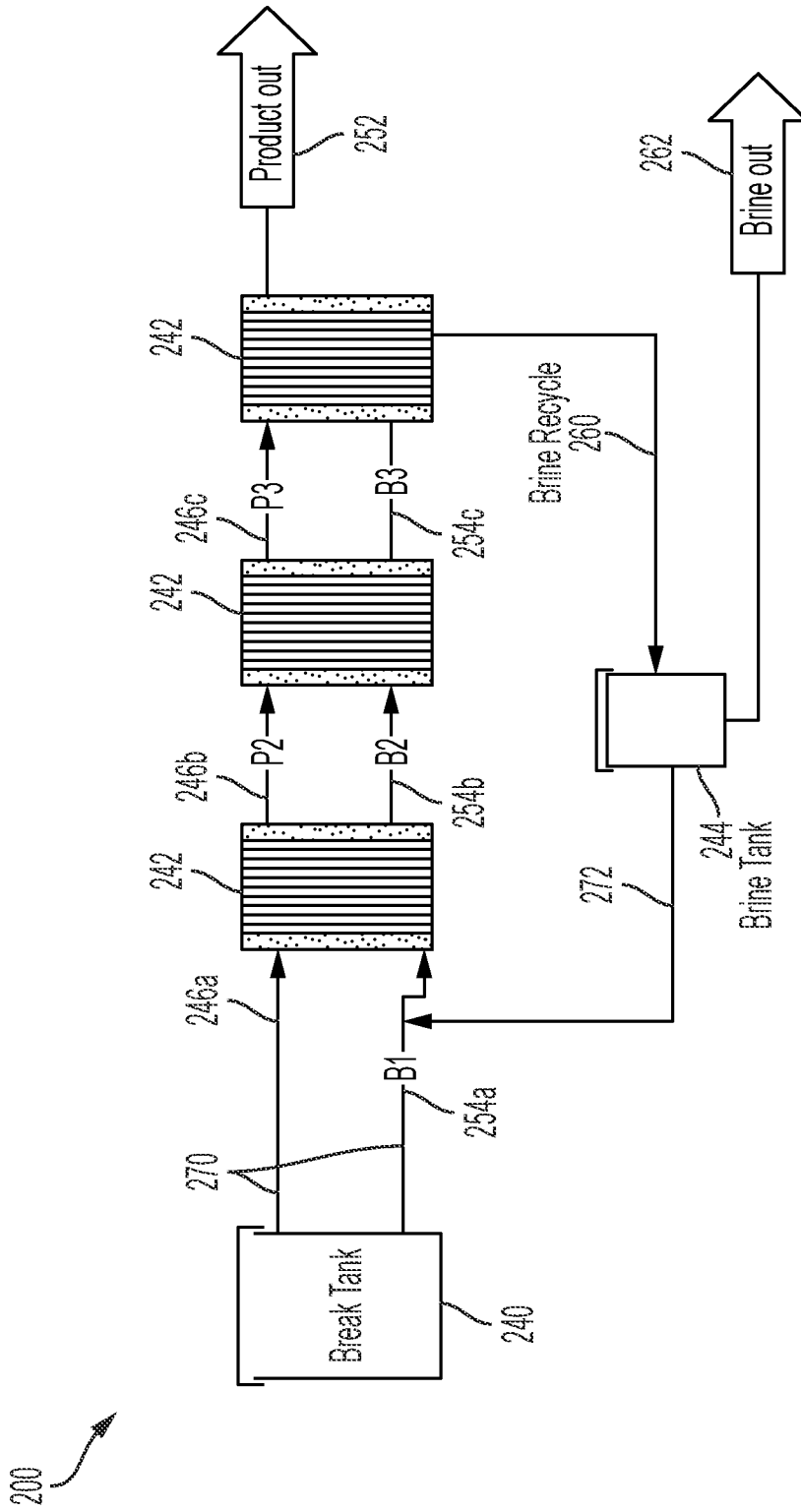


FIG. 2
PRIOR ART

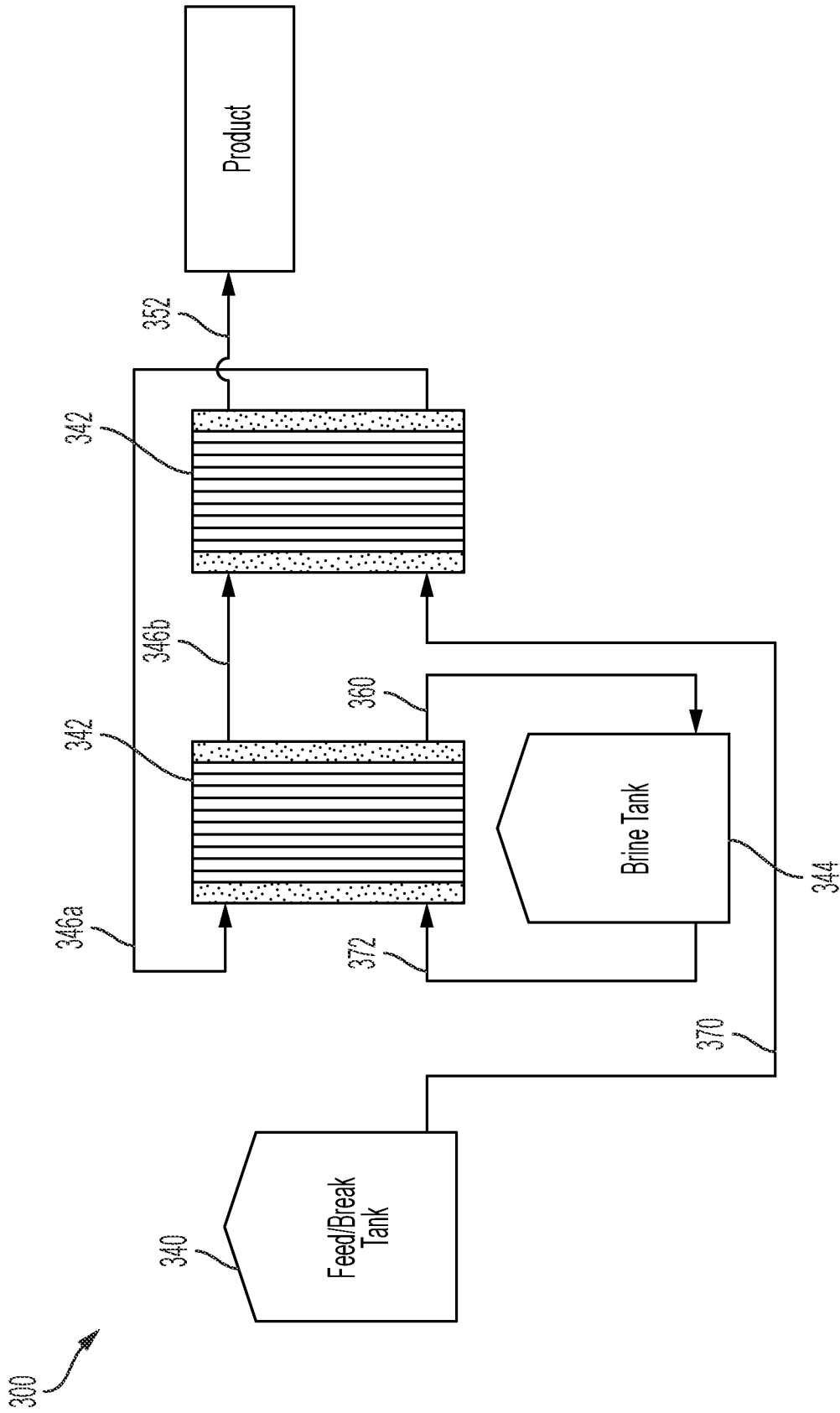


FIG. 3

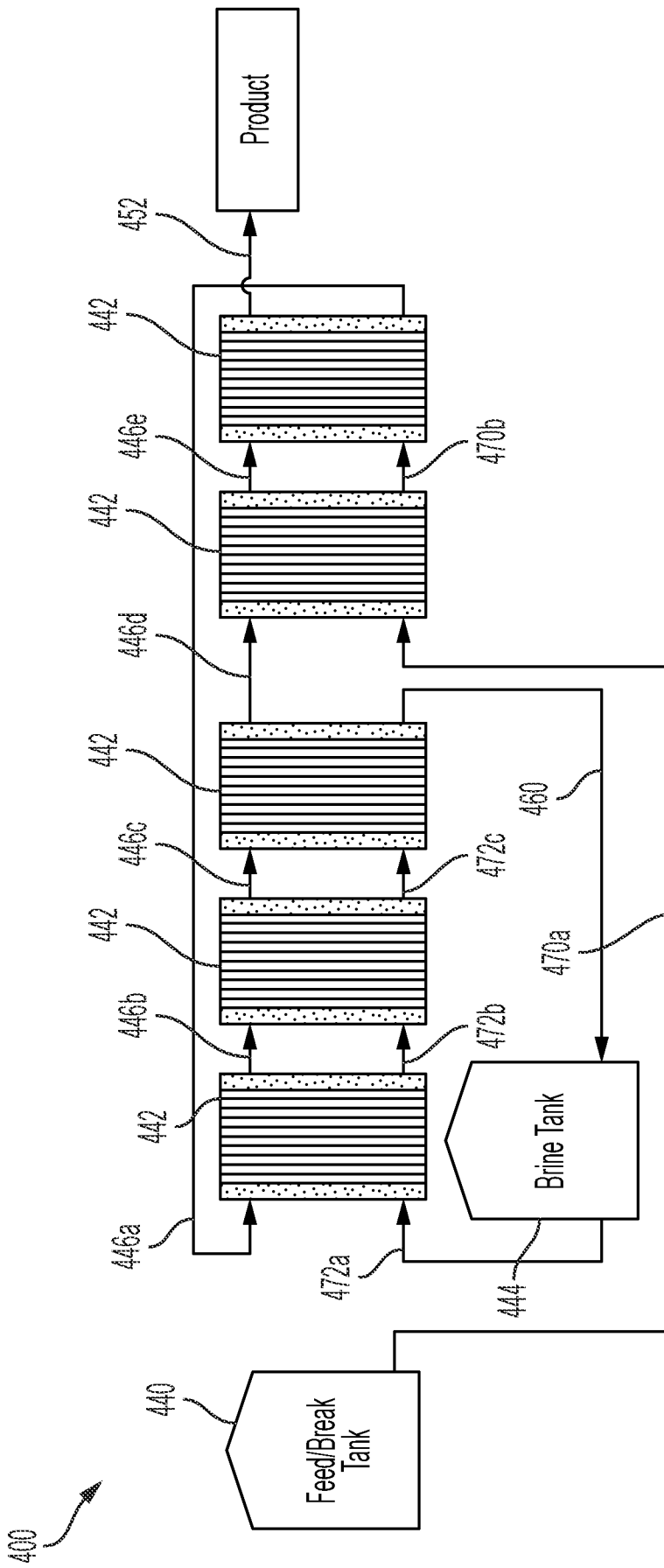


FIG. 4

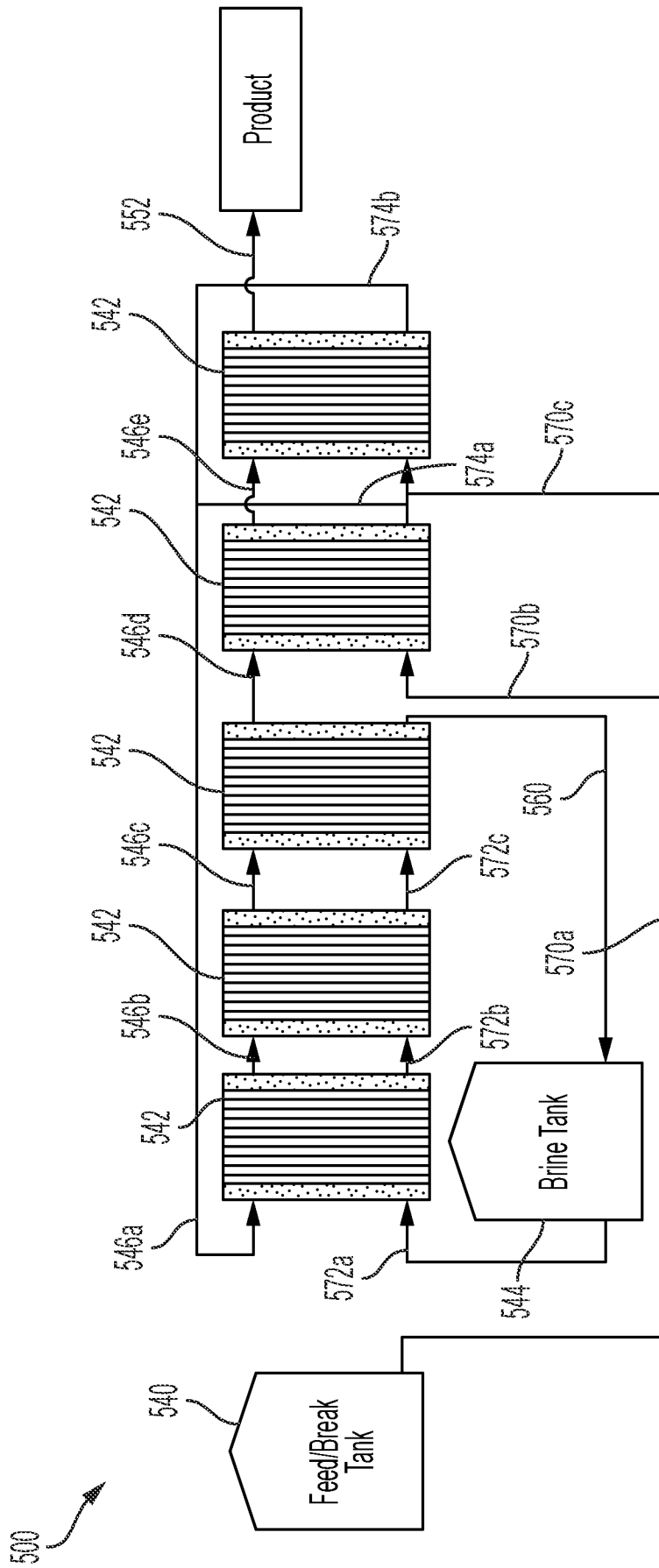


FIG. 5

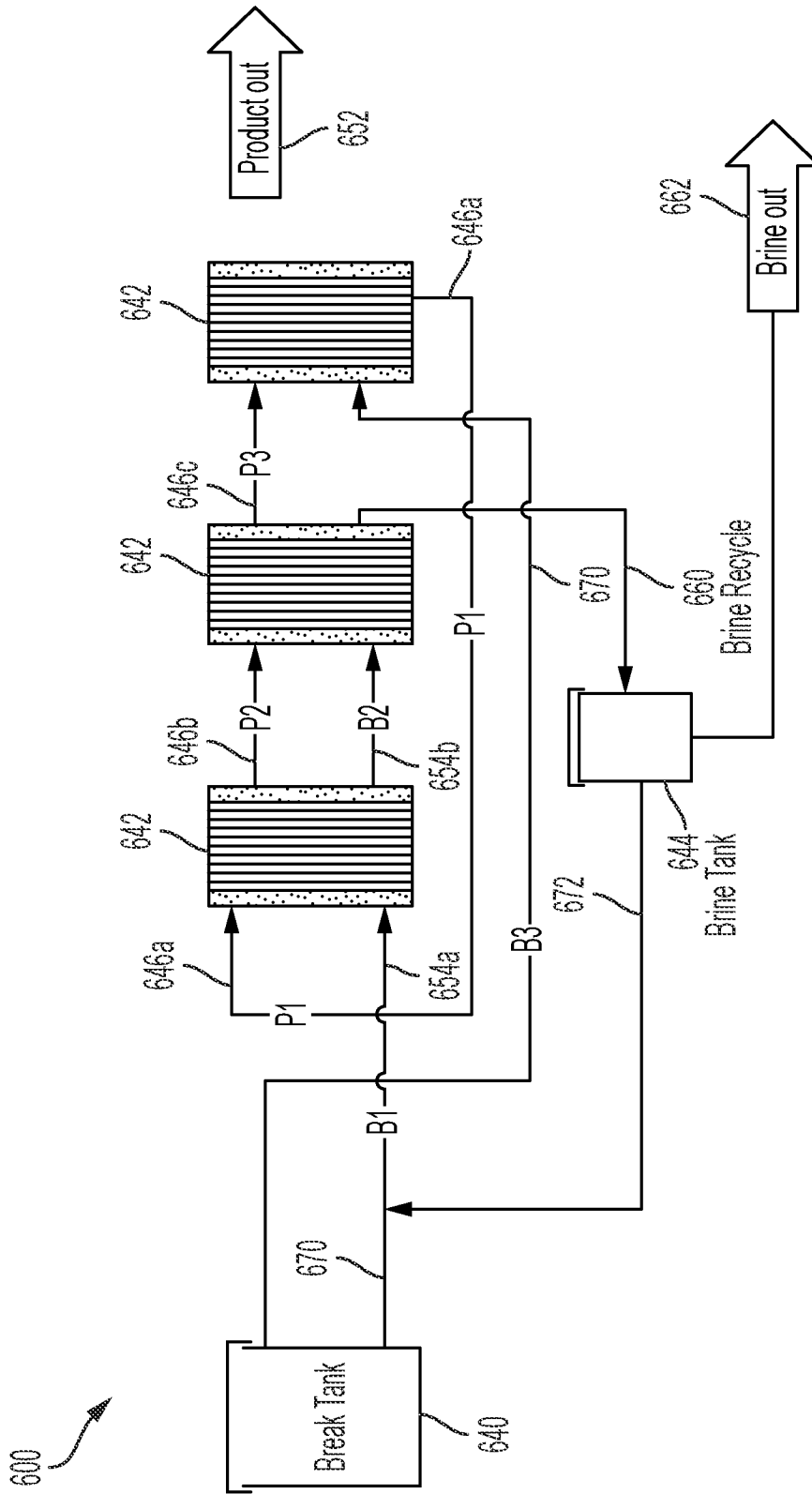


FIG. 6

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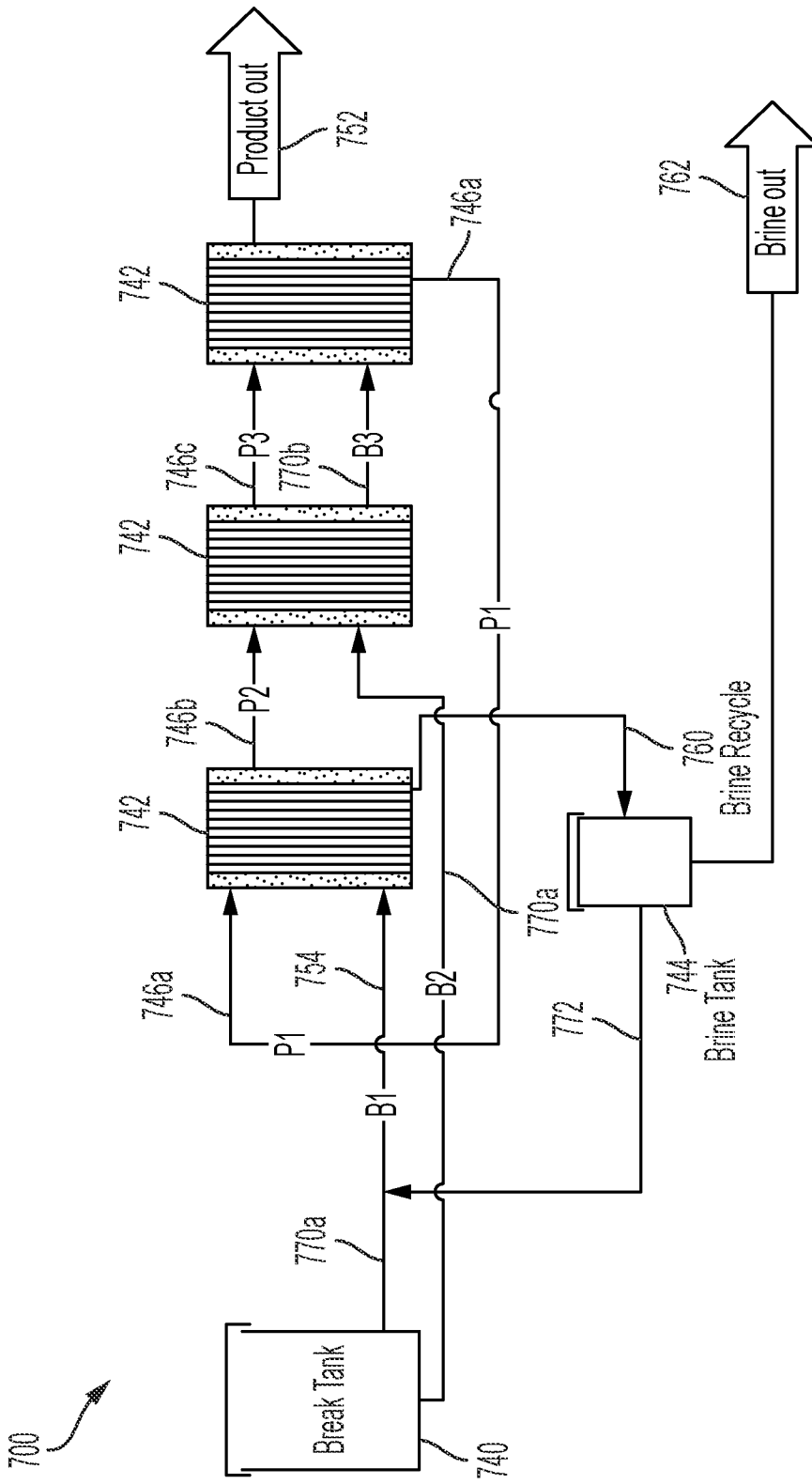


FIG. 7

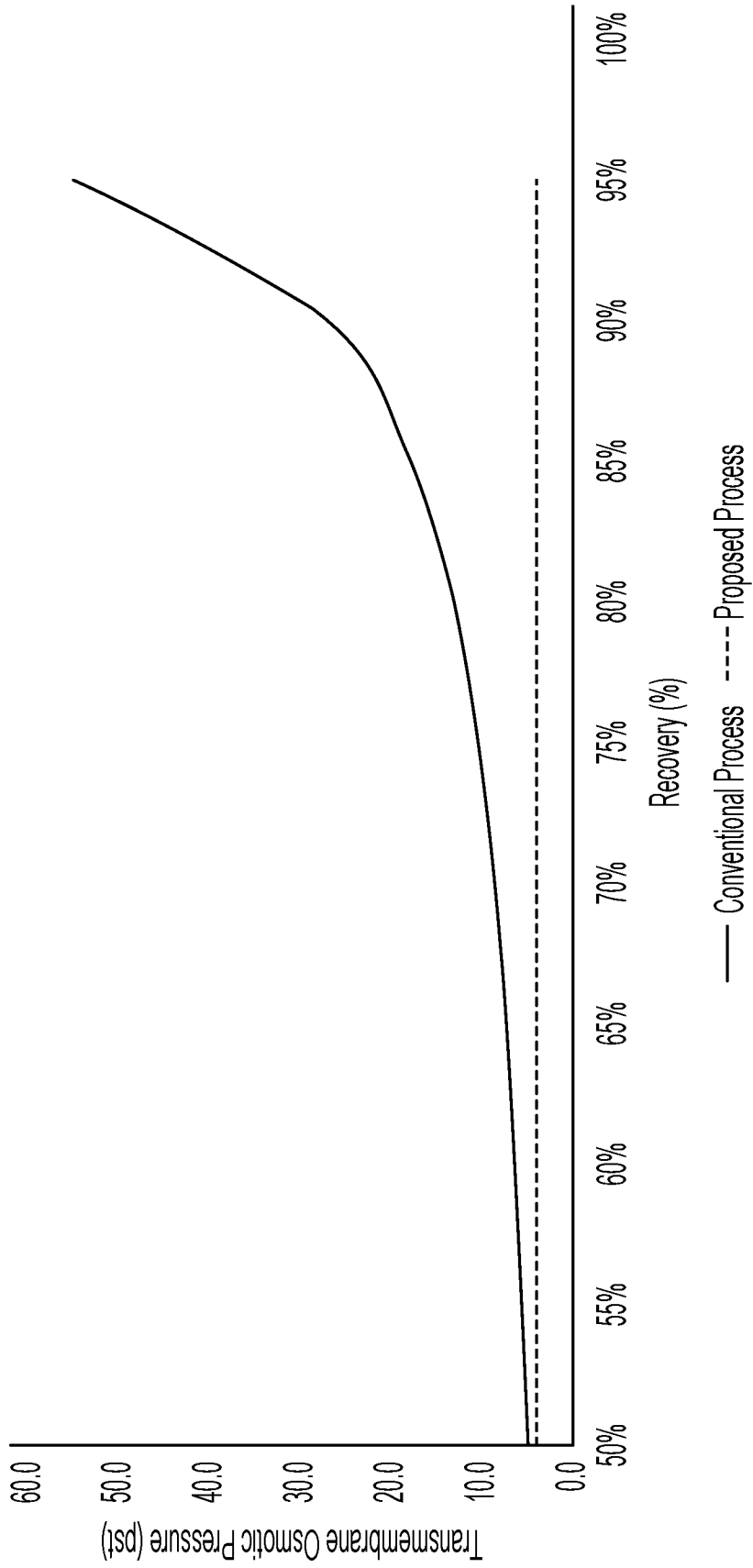


FIG. 8

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US 20/27517

A. CLASSIFICATION OF SUBJECT MATTER
IPC - C02F 1/469; B01D 61/44 (2020.01)
CPC - C02F 1/4693; B01D 61/44; C02F 1/44, 1/441, 1/442, 1/447, 1/4604, 1/461, 1/469, 2103/08; B01D 61/24, 61/243, 61/246, 61/02, 61/025, 61/027, 61/14, 61/142, 61/58; Y02A 20/134

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
See Search History document

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched
See Search History document

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
See Search History document

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X ---	US 2007/0215474 A1 (BATCHELDER et al.) 20 September 2007 (20.09.2007) entire document; especially Fig. 1; para [0001], para [0005], para [0043]	1-4, 9-10, 15-18, 23-24 ----- 5, 7, 19, 21
Y	US 2005/0150768 A1 (SFERRAZZA) 14 July 2005 (14.07.2005) entire document; especially Fig. 6, para [0017], para [0052]	5, 19
Y	US 2017/0036171 A1 (MASSACHUSETTS INSTITUTE OF TECHNOLOGY et al.) 09 February 2017 (09.02.2017) entire document; especially Fig. 8, para [0003], para [0044]	7, 21

Further documents are listed in the continuation of Box C. See patent family annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"D" document cited by the applicant in the international application	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"E" earlier application or patent but published on or after the international filing date	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"&" document member of the same patent family
"O" document referring to an oral disclosure, use, exhibition or other means	
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search 22 June 2020	Date of mailing of the international search report 17 JUL 2020
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Name and mailing address of the ISA/US Mail Stop PCT, Attn: ISA/US, Commissioner for Patents P.O. Box 1450, Alexandria, Virginia 22313-1450 Facsimile No. 571-273-8300	Authorized officer Lee Young Telephone No. PCT Helpdesk: 571-272-4300
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INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 20/27517

Box No. II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

- 1. Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:

- 2. Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:

- 3. Claims Nos.: 6, 8, 11-14, 20, 22, 25-27
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box No. III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

- 1. As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
- 2. As all searchable claims could be searched without effort justifying additional fees, this Authority did not invite payment of additional fees.
- 3. As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:

- 4. No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

- Remark on Protest**
- The additional search fees were accompanied by the applicant's protest and, where applicable, the payment of a protest fee.
 - The additional search fees were accompanied by the applicant's protest but the applicable protest fee was not paid within the time limit specified in the invitation.
 - No protest accompanied the payment of additional search fees.