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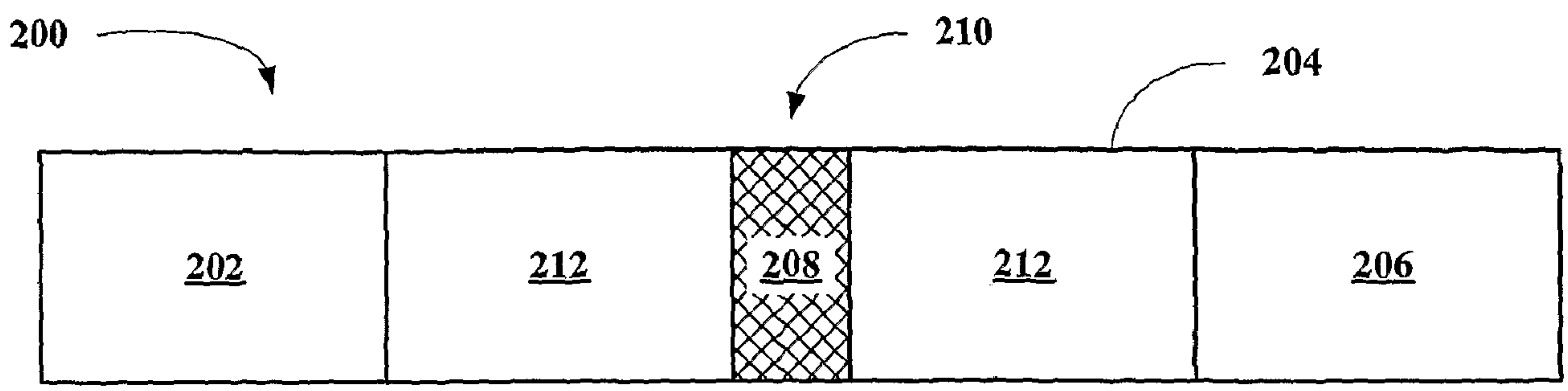
(54) Title: AN IMPROVED COMBUSTION APPARATUS AND METHODS FOR MAKING AND USING SAME



(57) Abrégé/Abstract:
A combustion apparatus (200) is disclosed that improves oxidation efficiency without increasing either combustion apparatus size or residence time, where the apparatus includes a combustion zone (204) having a static mixing zone (208) along a length of the combustion zone.

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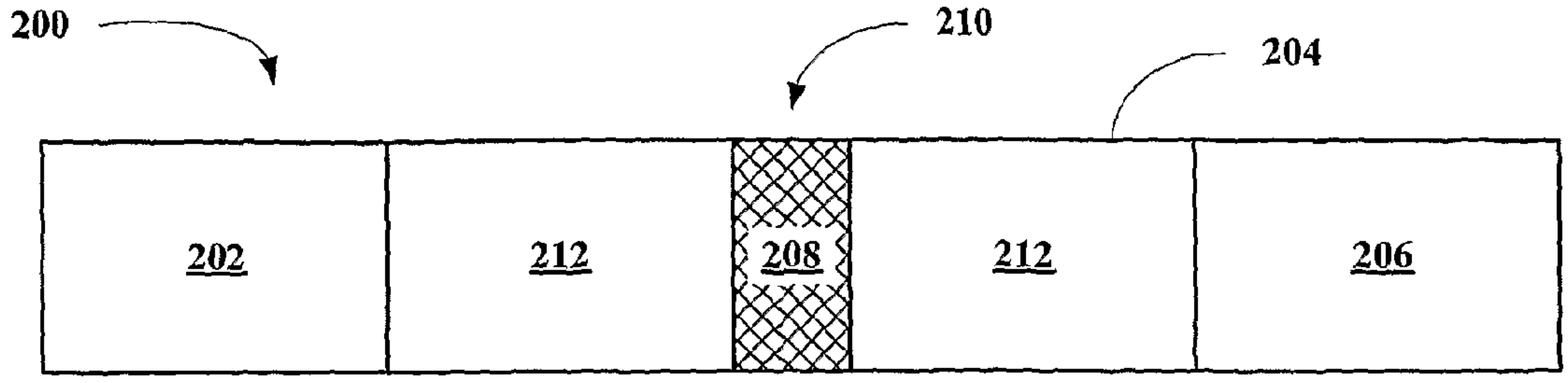

(57) Abstract: A combustion apparatus (200) is disclosed that improves oxidation efficiency without increasing either combustion apparatus size or residence time, where the apparatus includes a combustion zone (204) having a static mixing zone (208) along a length of the combustion zone.

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PCT SPECIFICATION

TITLE: AN IMPROVED COMBUSTION APPARATUS AND METHODS FOR MAKING AND USING SAME

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ASSIGNEE: PETROLEUM ANALYZER COMPANY, LP

BACKGROUND OF THE INVENTION

1. Field of the Invention

[0001] The present invention relates to an improved combustion apparatus and methods for making and using same.

[0002] More particularly, the present invention relates to an improved combustion apparatus including a combustible material inlet, an oxidizing agent inlet, a combustion gas outlet and a combustion zone having at least one in-line or static mixing zone and methods for making and using same.

2. Description of the Related Art

[0003] Combustion of combustible materials has always been a challenging and difficult undertaking, especially when the goal is complete oxidation or combustion. Such complete combustion is particularly critical in analytical detectors for determining concentrations of nitrogen and/or sulfur in a sample.

[0004] Although many combustion chambers have been designed over the years, most still lack the ability to foster complete combustion in a timely and cost effective manner. Certain combustion chambers have use static mixers to add combustion, but the mixers are either used upstream or down stream of the combustion zone to ensure that the material entering the flame, combustion tube or furnace are homogeneous or to ensure that the effluent gases are homogeneous. Such combustion systems including static mixers are disclosed in United States Pat. Nos.: 6,575,617; 6,497,098; 6,418,724; 6,302,683; 5,890,886; 5,829,967; 5,558,515; 5,513,982; 5,425,632; 5,000,757; 4,755,136; and 4213403.

[0005] Thus, there is a need in the art for an improved combustion chamber, which improves combustion efficiency by providing enhanced in-line mixing within the combustion zone or zones.

SUMMARY OF THE INVENTION

[0006] The present invention provides an improved combustion apparatus including a combustible material inlet, an oxidizing agent inlet, a combusted gas outlet, and a combustion chamber having a combustion zone including at least one in-line or static mixer or mixing zone, where the mixers or mixing zones improve combustion efficiency without increasing residence time so that larger amounts of the combustible material can be combusted in a same period of time for a same volume of the combustion zone.

[0007] The present invention also provides an improved combustion apparatus including a combustible material inlet, an oxidizing agent inlet, a combusted gas outlet, and a combustion chamber having a combustion zone including a plurality of in-line or static mixers or mixing zones, where the mixers or mixing zones improve combustion efficiency without increasing residence time so that larger amounts of the combustible material can be combusted in a same period of time for a same volume of the combustion zone.

[0008] The present invention also provides an improved combustion apparatus including a combustible material inlet, an oxidizing agent inlet, a combusted gas outlet, and a combustion chamber having a combustion zone including a plurality of spaced apart in-line or static mixers or mixing zones, where the mixers or mixing zones improve combustion efficiency without increasing residence time so that larger amounts of the combustible material can be combusted in a same period of time for a same volume of the combustion zone.

[0009] The present invention also provides an improved furnace apparatus including a combustion apparatus of this invention and a heater adapted to maintain the combustion zone(s) of the combustion apparatus at a temperatures sufficient to convert all or substantially all of the oxidizable components into their corresponding oxides.

[0010] The present invention provides an analytical instrument including an improved combustion apparatus of this invention, a sample supply unit adapted to supply a sample to the combustion apparatus, an oxidizing agent supply unit adapted to supply an oxidizing agent to the combustion apparatus, a detector/analyzer unit downstream of the combustion apparatus adapted to receive the oxidized sample and detect detectible oxidized species.

[0011] The present invention provides an analytical instrument including an improved combustion apparatus of this invention, a sample supply unit adapted to supply a sample to the combustion apparatus, an oxidizing agent supply unit adapted to supply an oxidizing agent to the combustion apparatus, a detector/analyzer unit downstream of the combustion apparatus adapted to receive the oxidized sample and detect detectible sulfur and/or nitrogen species.

[0012] The present invention provides a combustion system including an improved combustion apparatus of this invention, a fuel supply unit adapted to supply a fuel to the combustion apparatus, an oxidizing agent supply unit adapted to supply an oxidizing agent to the combustion apparatus, an exhaust unit downstream of the combustion apparatus adapted to receive and process the oxidized fuel.

[0013] The present invention provides a combustion system including an improved combustion apparatus of this invention, a fuel supply unit adapted to supply a fuel to the combustion apparatus, an oxidizing agent supply unit adapted to supply an oxidizing agent to the combustion apparatus, and an energy extraction unit downstream of the combustion apparatus adapted to receive and extract energy from the oxidized fuel.

[0014] The present invention provides a method for improving the combustion efficiency including the steps of feeding a combustible material and an oxidizing agent to a combustion apparatus of this invention and combusting or oxidizing the combustible material in the combustion zone(s) of the combustion apparatus where the mixer(s) or mixing zone(s) of the combustion apparatus improve(s) combustion efficiency and increase(s) a throughput of the material being combusted.

DESCRIPTION OF THE DRAWINGS

[0015] The invention can be better understood with reference to the following detailed description together with the appended illustrative drawings in which like elements are numbered the same:

[0016] Figure 1A depicts a block diagram of a prior art combustion apparatus;

[0017] Figure 1B depicts a block diagram of another prior art combustion apparatus;

[0018] Figure 1C depicts a block diagram of another prior art combustion apparatus;

[0019] Figure 1D depicts a block diagram of another prior art combustion apparatus;

[0020] Figure 2A depicts a block diagram of a preferred embodiment of a combustion apparatus of this invention;

[0021] Figure 2B depicts a block diagram of another preferred embodiment of a combustion apparatus of this invention;

[0022] Figure 2C depicts a block diagram of another preferred embodiment of a combustion apparatus of this invention;

[0023] Figure 2D depicts a block diagram of another preferred embodiment of a combustion apparatus of this invention;

[0024] Figure 2E depicts a block diagram of another preferred embodiment of a combustion apparatus of this invention;

[0025] Figure 3A depicts a block diagram of a preferred embodiment of a combustion tube of this invention;

[0026] Figure 3B depicts a block diagram of another preferred embodiment of a combustion tube of this invention;

[0027] Figure 3C depicts a block diagram of another preferred embodiment of a combustion tube of this invention;

[0028] Figure 3D depicts a block diagram of another preferred embodiment of a combustion tube of this invention;

[0029] Figures 4A-G depict a preferred embodiments of a static mixer;

[0030] Figure 5 depicts a block diagram of a preferred embodiment of an energy extraction unit of this invention;

[0031] Figure 6 depicts a block diagram of a preferred embodiment of an analytical instrument of this invention;

[0032] Figure 7 depicts a block diagram of a preferred embodiment of an internal combustion engine with a catalytic converter of this invention; and

[0033] Figures 8A&B depict a block diagram of a preferred embodiment of a catalytic converter monolith of this invention.

DETAILED DESCRIPTION OF THE INVENTION

[0034] The inventor has found that an improved combustion chamber can be constructed that allows for greater throughput, larger sample sizes and superior combustion profiles and efficiencies without increasing either the combustion volume or the residence time. The process of oxidation of this invention can be viewed like that of a chromatography process in which the separation process tends to broaden peak shape. Similarly, to enhance combustion efficiency, the inventor believes that one should broaden peak shape or profile of the combusting material. The inventor has found that by inserting at least one in-line or static mixer or mixing zone within a conventional combustion or oxidation zone or apparatus such as an oxidation tube, one can vastly improve oxidation efficiency. When such a combustion apparatus in used in analytical chemistry, one can improve detector sensitivity, decrease detector limits and provide greater instrument throughput without increasing either combustion volume or residence time. The combustion apparatus of this invention are ideally suited in applications such as analytical instrumentation, catalytic converters, pyrolysis tubes, conventional combustion tubes, energy extraction plant, power plants, or any other application where improvements in combustion efficiency can yield improved economics, throughput, sensitivity or the like without increasing combustion chamber size or increasing combustion residence time.

[0035] The present invention broadly relates to an improved combustion apparatus including a combustible material (fuel or sample) inlet, an oxidizing agent inlet (of course, the two inlets can be combined into a single inlet), a combustion chamber including a combustion zone maintained at an elevated temperature where zone includes at least one in-line or static mixer or mixing zone therein, and an oxidized material outlet, where the apparatus improves combustion efficiency relative to the same apparatus absence the mixing zone. In the case of analytical instrumentation, the combustion apparatuses of this invention not only improve combustion efficiency, the combustion apparatuses of this invention increase instrument throughput, decrease instrument detection limits and increase instrument sensitivity. The elevated temperature is generally above about 300°C. Preferably, the elevate temperature is between about 300°C and about 2000°C. Particularly, the elevated temperature is between about 600°C and about 1500°C. More particularly, the elevated temperature is between about 800°C and about 1300°C. The combustion apparatuses of this invention can be operated at ambient pressure, at reduced pressure down to ten of millimeters of mercury, or at higher than ambient pressures up to a 1000 or more psia.

[0036] The present invention broadly relates to a method for improved combustion including the step of feeding a combustible material and an oxidizing agent to an apparatus of this invention to form an oxidized material comprising oxides of all oxidizable components in the material, where the method improves oxidation efficiency relative to the same apparatus in the absence the mixing zone.

<u>Suitable Materials</u>

[0037] Suitable materials out of which the combustion chambers, tubes or furnaces of this invention can be made includes, without limitation, any durable material which can tolerate combustion temperatures. Preferred materials include, without limitation, metals, glasses, crystalline materials such as quartz, ceramics such as formable silicates, aluminates, zirconate, titanates, or mixed metal oxides, composites, high temperature polymers, or mixtures or combinations of any of the materials provide thermal expansion coefficient differences can be managed. Particularly preferred materials include steels, quartz, alumina, silica, zirconia, or mixtures or combinations thereof. Particularly preferred metal include stainless steels and other non-staining iron, cobalt or nickel alloys.

DETAILED DESCRIPTION OF THE DRAWINGS

Combustion Apparatuses Including In-Line Mixer(s) in the Combustion Zone(s)

[0038] Referring now to **Figures 1A-D**, four prior art combustion apparatuses, generally **100**, are shown to include an inlet zone **102** where a combustible material and an oxidizing agent are introduced, a combustion zone **104** and an oxidized material outlet zone **106**. Looking at **Figure 1A**, the prior art combustion apparatus **100** has no other parts, except for a heating means or heater for heating the combustion zone to an elevated temperature. All of the other apparatuses **100** include in-line or static mixers **108**. Looking at **Figure 1B**, the prior art combustion apparatus **100** includes an upstream in-line mixer **108**. The prior art combustion apparatus **100** of **Figure 1C** includes a downstream in-line mixer **108**. And, the prior art combustion apparatus **100** of **Figure 1D** includes both an upstream and a downstream in-line mixer **108**.

[0039] Referring now to **Figure 2A**, a preferred embodiment of a combustion apparatus of this invention, generally **200**, is shown to include an inlet zone **202**, a combustion zone **204** and an oxidized material outlet zone **206**, where the combustion zone **204** includes an in-line or static mixing zone **208** in a center **210** of the combustion zone **204** with normal combustion subzones **210** before and after the mixing zone **208**. The inlet zone **202** is adapted to introduce a combustible material and an oxidizing agent into the combustion zone **204**. The mixing zone **208** is adapted to in-line mixed and broaden an oxidizing mixture profile in the combustion zone **204** improving combustion efficiency, where the oxidizing mixture comprises un-oxidized combustible material components, partially oxidized combustible material components, completely oxidized combustible material components and un-consumed oxidizing agent, at temperature. The nature of the mixing zone **208** can be any standard in-line or static mixer regardless of exact configuration, provided that the mixer augments a flow path of the oxidizing mixture and prevents or eliminates any part of the oxidizing mixture from traveling through the combustion zone **204** in an unaltered straight flow path.

[0040] Referring now to **Figure 2B**, another preferred embodiment of a combustion apparatus of this invention, generally **200**, is shown to include an inlet zone **202**, a combustion zone **204** and an oxidized material outlet **206**, where the combustion zone **204** includes two spaced apart mixing zones **208** in a center portion **210** of the combustion zone **204** with normal combustion subzones **212** before, after and therebetween. The inlet zone **202** is adapted to introduce a combustible material and an oxidizing agent into the combustion zone **204**. An oxidizing mixture comprising un-oxidized combustible material components, partially oxidized combustible material components, completely oxidized combustible material components and un-consumed oxidizing agent are mixed in-line, at temperature improving combustion efficiency in the combustion zone **204** due to the mixing of the oxidizing mixture in the mixing zones **208**.

[0041] Referring now to **Figure 2C**, another preferred embodiment of a combustion apparatus of this invention, generally **200**, is shown to include an inlet zone **202**, a combustion zone **204** and an oxidized material outlet **206**, where the combustion zone **204** includes three spaced apart mixing zones **208**, one of the mixing zone **208** is located in a center **210** of the combustion zone **204**, two of the mixing zones **208** are located at a first end **214** and a second end **216** of the combustion zone **204** with normal combustion subzones **212** therebetween. The inlet zone **202** is adapted to introduce a combustible material and an oxidizing agent into the combustion zone **204**. The in-line mixing zones **208** are designed to increase a combustion efficiency of the combustion zone **204** by mixing an oxidizing mixture at temperature to ensure that a path of the oxidizing mixture is not a straight path or to reduce channeling of portions of the oxidizing mixture as it traverses the combustion zone **204**. The oxidizing mixture comprises un-oxidized combustible material components, partially oxidized combustible material components, completely oxidized combustible material components and un-consumed oxidizing agent. Of course, at the outlet zone **206** the effluent includes a completely oxidized mixture or a substantially completely oxidized mixture, where the term substantially completely oxidized means that at least 95% of all of the oxidizable components in the combustible material have been converted to their corresponding oxides, preferably, at least 98% of all of the oxidizable components in the combustible material have been converted to their corresponding oxides, particularly, at least 99% of all of the oxidizable components in the combustible material have been converted to their corresponding oxides and especially, at least 99.9% of all of the oxidizable components in the combustible material have been converted to their corresponding oxides.

[0042] Referring now to **Figure 2D**, another preferred embodiment of a combustion apparatus of this invention, generally **200**, is shown to include an inlet zone **202**, a combustion zone **204** and an oxidized material outlet **206**, where the combustion zone **204** includes three spaced apart mixing zones **208** located in a center **210** of the combustion zone **204** with normal combustion subzones **212** before, after and therebetween. The inlet zone **202** is adapted to introduce a combustible material and an oxidizing agent into the combustion zone **204**. The in-line mixing zones **208** are designed to increase a combustion efficiency of the combustion zone **204** by mixing an oxidizing mixture at temperature to ensure that a path of the oxidizing mixture is not a straight path or to reduce channeling of portions of the oxidizing mixture as it traverses the combustion zone **204**. The oxidizing mixture comprises un-oxidized combustible material components, partially oxidized combustible material components, completely oxidized combustible material components and un-consumed oxidizing agent. Of course, at the outlet zone **206** will include a substantially or completely oxidized mixture, where the term substantially means that at least 95% of the oxidizable components in the combustible material have been converted to their corresponding oxides, preferably, at least 98% of the oxidizable components in the combustible material have been converted to their corresponding oxides, particularly, at least 99% of the oxidizable components in the combustible material have been converted to their corresponding oxides and especially, at least 99.9% of the oxidizable components in the combustible material have been converted to their corresponding oxides.

[0043] Referring now to **Figure 3A**, another preferred embodiment of a combustion tube apparatus of this invention, generally **300**, is shown to include a sample inlet **302**, an oxidizing agent inlet **304**, a combustion zone **306** and an oxidized material outlet **308**, where the combustion zone **306** includes a mixing zone **310** in a center **312** of the combustion zone **306** with normal combustion subzones **314** on either side of the mixing zone **310**. The sample inlet **302** is adapted to introduce a combustible material into the combustion zone **306**, while the oxidizing agent inlet **304** is adapted to introduce an oxidizing agent into the combustion zone **306**. The in-line mixing zone **310** is designed to increase a combustion efficiency of the combustion zone **306** by mixing an oxidizing mixture at temperature to ensure that a path of the oxidizing mixture is not a straight path or to reduce channeling of portions of the oxidizing mixture as it traverses the combustion zone **306**. The oxidizing mixture comprises un-oxidized combustible material components, partially oxidized combustible material components, completely oxidized combustible material components and un-consumed oxidizing agent. Of course, at the outlet zone **308** will include a substantially or completely oxidized mixture, where the term substantially means that at least 95% of the oxidizable components in the combustible material have been converted to their corresponding oxides, preferably, at least 98% of the oxidizable components in the combustible material have been converted to their corresponding oxides, particularly, at least 99% of the oxidizable components in the combustible material have been converted to their corresponding oxides and especially, at least 99.9% of the oxidizable components in the combustible material have been converted to their corresponding oxides.

[0044] Referring now to **Figure 3B**, another preferred embodiment of a combustion tube apparatus of this invention, generally **300**, is shown to include a sample inlet **302**, an oxidizing agent inlet **304**, a combustion zone **306** and an oxidized material outlet **308**, where the combustion zone **306** includes two mixing zones **310** within the combustion zone **306** with normal combustion subzones **314** before, after and therebetween. The sample inlet **302** is adapted to introduce a combustible material into the combustion zone **306**, while the oxidizing agent inlet **304** is adapted to introduce an oxidizing agent into the combustion zone **306**. The in-line mixing zone **310** are designed to increase a combustion efficiency of the combustion zone **306** by mixing an oxidizing mixture at temperature to ensure that a path of the oxidizing mixture is not a straight path or to reduce channeling of portions of the oxidizing mixture as it traverses the combustion zone **306**. The oxidizing mixture comprises un-oxidized combustible material components, partially oxidized combustible material components, completely oxidized combustible material components and un-consumed oxidizing agent. Of course, at the outlet zone **308** will include a substantially or completely oxidized mixture, where the term substantially means that at least 95% of the oxidizable components in the combustible material have been converted to their corresponding oxides, preferably, at least 98% of the oxidizable components in the combustible material have been converted to their corresponding oxides, particularly, at least 99% of the oxidizable components in the combustible material have been converted to their corresponding oxides and especially, at least 99.9% of the oxidizable components in the combustible material have been converted to their corresponding oxides.

[0045] Referring now to **Figure 3C**, another preferred embodiment of a combustion tube apparatus of this invention, generally **300**, is shown to include a sample inlet **302**, an oxidizing agent inlet **304**, a combustion zone **306** and an oxidized material outlet **308**, where the combustion zone **306** includes three mixing zones **310** within the combustion zone **306** with normal combustion subzones **314** therebetween. The sample inlet **302** is adapted to introduce a combustible material into the combustion zone **306**, while the oxidizing agent inlet **304** is adapted to introduce an oxidizing agent into the combustion zone **306**. The in-line mixing zone **310** are designed to increase a combustion efficiency of the combustion zone **306** by mixing an oxidizing mixture at temperature to ensure that a path of the oxidizing mixture is not a straight path or to reduce channeling of portions of the oxidizing mixture as it traverses the combustion zone **306**. The oxidizing mixture comprises un-oxidized combustible material components, partially oxidized combustible material components, completely oxidized combustible material components and un-consumed oxidizing agent. Of course, at the outlet zone **308** will include a substantially or completely oxidized mixture, where the term substantially means that at least 95% of the oxidizable components in the combustible material have been converted to their corresponding oxides, preferably, at least 98% of the oxidizable components in the combustible material have been converted to their corresponding oxides, particularly, at least 99% of the oxidizable components in the combustible material have been converted to their corresponding oxides and especially, at least 99.9% of the oxidizable components in the combustible material have been converted to their corresponding oxides.

[0046] Referring now to **Figure 3D**, another preferred embodiment of a combustion tube apparatus of this invention, generally **300**, is shown to include a sample inlet **302**, an oxidizing agent inlet **304**, a combustion zone **306** and an oxidized material outlet **308**, where the combustion zone **306** includes four mixing zones **310** within the combustion zone **306** with normal combustion subzones **314** before, after and therebetween. The sample inlet **302** is adapted to introduce a combustible material into the combustion zone **306**, while the oxidizing agent inlet **304** is adapted to introduce an oxidizing agent into the combustion zone **306**. The in-line mixing zone **310** are designed to increase a combustion efficiency of the combustion zone **306** by mixing an oxidizing mixture at temperature to ensure that a path of the oxidizing mixture is not a straight path or to reduce channeling of portions of the oxidizing mixture as it traverses the combustion zone **306**. The oxidizing mixture comprises un-oxidized combustible material components, partially oxidized combustible material components, completely oxidized combustible material components and un-consumed oxidizing agent. Of course, at the outlet zone **308** will include a substantially or completely oxidized mixture, where the term substantially means that at least 95% of the oxidizable components in the combustible material have been converted to their corresponding oxides, preferably, at least 98% of the oxidizable components in the combustible material have been converted to their corresponding oxides, particularly, at least 99% of the oxidizable components in the combustible material have been converted to their corresponding oxides and especially, at least 99.9% of the oxidizable components in the combustible material have been converted to their corresponding oxides.

In-Line Mixer Designs

[0047] Referring now to **Figures 4A-G**, a number of different in-line or static mixers, generally **400**. Looking at **Figures 4A&B**, the mixer **400** includes a housing **402** and a plurality of twisted plates **404** fitted in, attached to, bonded to or integral with an interior surface **406** of the housing **402**, where the housing can be the combustion apparatus or tube. **Figure 4A** shows a single plate **404**, while **Figure 4B** shows four plates **404** oriented into a right handed configuration. Obviously, the plates can be arranged in either a right handed configuration, a left handed configuration or a combination of the two configurations.

[0048] Looking at **Figures 4C-E**, the mixer **400** includes a housing **402** and a plurality of curved protrusions **408** fitted in, attached to, bonded to or integral with (pushed in) an interior surface

406 of the housing 402, where the housing can be the combustion apparatus or tube. The protrusions 408 can be oriented in a right handed configuration 408a, a left handed configuration 408b or a combination of the two configurations as shown in **Figure 4E.**

[0049] Looking at **Figures 4F&G**, the mixer **400** includes a housing **402** and two helical protrusions **410a&b** fitted in, attached to, bonded to or integral with an interior surface **406** of the housing **402**, where the housing can be the combustion apparatus or tube. The helical protrusion **410a** is in a right handed configuration, while the helical protrusion **410b** is in a left handed configuration and the two protrusions are located in series as shown in **Figure 4F&G.** Of course, the right handed mixer **410a** and the left handed mixer **410b** can be reversed in their order of occurrence.

[0050] In all of the mixers shown above, the protrusions or mixing elements all extend more than half way into a cross-section of the combustion zone to ensure that no direct path exist for the oxidizing mixture to travel from the inlet to the outlet, *i.e.*, the mixing elements ensure that the oxidizing mixture undergoes a mixing during the combustion process to increase oxidation efficiency without increasing a volume of the combustion zone or the residence time in the combustion zone.

Energy Extraction Apparatus

[0051] Referring now to **Figure 5**, a preferred embodiment of an energy extraction system of this invention, generally **500**, is shown to include a fuel and an oxidizing agent supply unit **502**, a furnace or combustion chamber **504** and an energy generation unit **506**, where the combustion chamber **504** includes a combustion zone **508** having at least one static mixing zone **510**. The supply unit **502** can include separate supplies units **502a&b** for fuel and oxidizer and can also include a mixing or atomization unit **512** upstream of the furnace **504**. The supply unit **502** supplies fuel and oxidizing agent to the furnace **504**, which burns the fuel generating heat which is used as the heat source to the energy generation unit **506**, which can be any type of energy generator such as a Kalina type cycle. *See, e.g.,* United States Pat. Nos. 5,953,918; 5,950,433; 5,822,990; 5,649,426; 5,588,298; 5,572,871; 5,450,821; 5,440,882; 5,095,708; 5,029,444; 4,982,568; 4,899,545; 4,763,480; 4,732,005; 4,604,867; 4,586,340; 4,548,043; 4,489,563; 4,346,561; and 4,289,429, incorporated herein by reference.

Analytical Instruments

[0052] Referring now to **Figure 6**, a preferred embodiment of an instrument of this invention, generally **600**, is shown to include a sample supply system **602**, an oxidizing agent supply system **604**, a combustion chamber **606** and a detection/analyzer system **608**, where the combustion chamber **606** includes a combustion zone **610** having at least one static mixing zone **612**. The instrument **600** can also include a mixing or nebulizing unit **614** upstream of the combustion chamber **606** adapted to supply a thoroughly mixed sample and oxidizing agent mixture to the combustion chamber **606** or an atomized sample and oxidizing agent mixture to the combustion chamber **606**. The sample supply system **602** can be any sample supply system including an auto-sampler, a septum for direct injection, a sampling loop for continuous sampling, an analytical separation system such as a GC, LC, MPLC, HPLC, LPLC, or any other sample supply system used now or in the future to supply samples to analytical instrument combustion chambers or mixture or combinations thereof. The detector/analyzer system **608** can be any now know or yet to be developed oxide detection and analyzing system including, without limitation, IR spectrometers, FTIR spectrometers, MS spectrometers, UV spectrometers, UV fluorescence spectrometers, chemiluminescence spectrometers, ICR spectrometers, any other spectrographic detection and analyzing system or mixtures or combinations thereof. Preferred instruments include UV fluorescence spectrometers, chemiluminescence spectrometers, or mixtures or combinations thereof.

[0053] The improved mixing combustion chambers of this invention also increase sample throughput, decrease instrument cycle times, increase detection sensitivity, and decrease detection limits for different detectible oxides.

<u>Catalytic Converters</u>

[0054] Referring now to **Figure 7**, a preferred embodiment of an internal combustion engine equipped with a catalytic converter of this invention, generally **700**, is shown to include an internal combustion engine **702** and a catalytic converter apparatus **704**, where the catalytic converter apparatus **704** includes a combustion zone **706** having at least one static mixing zone **708** therein. The converter **704** is connected to the engine **702** via a header **710** and exhaust gases exit via an exhaust pipe **712**.

[0055] Referring now to **Figures 8A&B**, a preferred embodiment of an catalytic converter monolith, generally **800**, is shown to include a plurality of channels **802**, each channel 802 including at least one static mixer **804**.

[0056] All references cited herein are incorporated by reference. While this invention has been described fully and completely, it should be understood that, within the scope of the appended claims, the invention may be practiced otherwise than as specifically described. Although the invention has been disclosed with reference to its preferred embodiments, from reading this description those of skill in the art may appreciate changes and modification that may be made which do not depart from the scope and spirit of the invention as described above and claimed hereafter.

CLAIMS

We claim:

1. A combustion apparatus comprising an inlet and an outlet and a combustion zone including at least one static mixing zone along a length of the combustion zone.

2. The apparatus of claim 1, wherein the inlet includes a sample inlet and an oxidizing agent inlet.

3. The apparatus of claim 1, wherein the combustion zone further includes a plurality of spaced apart static mixing zones along a length of the combustion zone.

4. The apparatus of claim 1, further comprising a heater adapted to maintain the combustion zone at an elevated temperature, where the elevated temperature is sufficient to substantially completely convert all oxidizable components in the sample into their corresponding oxides.

5. The apparatus of claim 4, wherein the elevate temperature is above about 300°C.

6. The apparatus of claim 4, wherein the elevate temperature is between about 300°C and about 2000°C.

7. The apparatus of claim 4, wherein the elevated temperature is between about 600°C and about 1500°C.

8. The apparatus of claim 4, wherein the elevated temperature is between about 800°C and about 1300°C.

9. The apparatus of claim 1, wherein the inlet comprises a nebulizer.

10. A combustion apparatus comprising a sample inlet, an oxidizing agent inlet, an outlet, and a combustion zone including at least one static mixing zone along a length of the combustion zone.

11. The apparatus of claim 10, wherein the combustion zone further includes a plurality of

spaced apart static mixing zones disposed along the length of the combustion zone.

12. The apparatus of claim 10, wherein the combustion zone is at ambient pressure, at a lower than ambient pressure or at a higher than ambient pressure.

13. The apparatus of claim 10, further comprising a heater adapted to maintain the combustion zone at an elevated temperature, where the elevated temperature is sufficient to substantially completely convert oxidizable components in the sample into their corresponding oxides.

14. The apparatus of claim 13, wherein the elevate temperature is above about 300°C.

15. The apparatus of claim 13, wherein the elevate temperature is between about 300°C and about 2000°C.

16. The apparatus of claim 13, wherein the elevated temperature is between about 600°C and about 1500°C.

17. The apparatus of claim 13, wherein the elevated temperature is between about 800°C and about 1300°C.

18. The apparatus of claim 10, further comprising a nebulizer disposed between the inlets and the combustion zone.

19. A combustion apparatus comprising an inlet, an outlet, a combustion zone including a mixing zone disposed along a length of the combustion zone, and a heater, where the inlet is adapted to feed a combustible material and an oxidizing agent to the combustion zone, and the heater is designed to maintain the combustion zone including the mixing zone at an elevated temperature.

20. The apparatus of claim 19, wherein the elevate temperature is above about 300°C.

21. The apparatus of claim 19, wherein the elevate temperature is between about 300°C and

about 2000°C.

22. The apparatus of claim 19, wherein the elevated temperature is between about 600°C and about 1500°C.

23. The apparatus of claim 19, wherein the elevated temperature is between about 800°C and about 1300°C.

24. The apparatus of claim 19, further comprising a nebulizer disposed between the inlet and the combustion zone.

25. An analytical instrument apparatus comprising:

a sample supply system,

an oxidizing supply system,

a combustion or furnace apparatus comprising:

an inlet,

an outlet,

a combustion zone including

a mixing zone disposed along a length of the combustion zone, and

a heater, and

a detector/analyzer unit,

where the supply systems are adapted to supply a sample and an oxidizing agent to the inlet of the combustion apparatus, the combustion apparatus is adapted to substantially completely oxidize the sample into oxides and the detector/analyzer is adapted to determine a concentration of at least one oxide and relate the oxide concentration back to a concentration of an element in the sample.

26. The apparatus of claim 25, wherein the heater maintains the combustion zone at an elevate temperature above about 300°C.

27. The apparatus of claim 25, wherein the heater maintains the combustion zone at an elevate temperature between about 300°C and about 2000°C.

28. The apparatus of claim 25, wherein the heater maintains the combustion zone at an elevate temperature between about 600°C and about 1500°C.

29. The apparatus of claim 25, wherein the heater maintains the combustion zone at an elevate temperature between about 800°C and about 1300°C.

30. The apparatus of claim 25, wherein the combustion apparatus further comprises a nebulizer disposed between the inlet and the combustion zone.

31. The apparatus of claim 25, wherein the sample supply system is selected from the group consisting of an auto-sampler, a septum for direct injection, a sampling loop for continuous sampling, an analytical separation system and mixture or combinations thereof.

32. The apparatus of claim 25, wherein the analytical separation system is selected from the group consisting of a GC, an LC, an MPLC, an HPLC, an LPLC, and mixtures or combinations thereof.

33. The apparatus of claim 25, wherein the detector/analyzer is selected from the group consisting of IR spectrometers, FTIR spectrometers, MS spectrometers, UV spectrometers, UV fluorescence spectrometers, chemiluminescence spectrometers, ICR spectrometers, and mixtures or combinations thereof.

34. The apparatus of claim 25, wherein the detector/analyzer is selected from the group consisting of UV fluorescence spectrometers, chemiluminescence spectrometers, and mixtures or combinations thereof.

35. A method for oxidizing a combustible material comprising the steps of:

feeding the combustible material and an oxidizing agent to a combustion apparatus comprising an inlet, an outlet, a combustion zone including a mixing zone disposed along a length of the combustion zone, and a heater, and

heating the combustion zone to a temperature sufficient to covert all or substantially all oxidizable components in the combustible material into their corresponding oxides,

where the mixing zone increases an efficiency of combustion of the combustion zone.

36. The method of claim 34, wherein the temperature is above about 300°C.

37. The method of claim 34, wherein the temperature is between about 300°C and about 2000°C.

38. The method of claim 34, wherein the temperature is between about 600°C and about 1500°C.

39. The method of claim 34, wherein the temperature is between about 800°C and about 1300°C.

40. The method of claim 34, wherein the combustion apparatus further comprises a nebulizer disposed between the inlet and the combustion zone.

41. A method for analyzing a sample comprising the steps of:

feeding the sample and an oxidizing agent to a combustion apparatus comprising an inlet, an outlet, a combustion zone including a mixing zone disposed along a length of the combustion zone, and a heater,

heating the combustion zone to a temperature sufficient to covert all or substantially all oxidizable components in the combustible material into their corresponding oxides, and

forwarding the oxides to an detector/analyzer, and

detecting a concentration of at least on oxide,

where the mixing zone increases an efficiency of combustion of the combustion zone and where the detector/analyzer relates the oxide concentration back to a concentration of an element in the sample.

42. The method of claim 41, wherein the heater maintains the combustion zone at an elevate temperature above about 300°C.

43. The method of claim 41, wherein the heater maintains the combustion zone at an elevate temperature between about 300°C and about 2000°C.

44. The method of claim 41, wherein the heater maintains the combustion zone at an elevate temperature between about 600°C and about 1500°C.

45. The method of claim 41, wherein the heater maintains the combustion zone at an elevate temperature between about 800°C and about 1300°C.

46. The method of claim 41, wherein the combustion apparatus further comprises a nebulizer disposed between the inlet and the combustion zone.

47. The method of claim 41, wherein the detector/analyzer is selected from the group consisting of IR spectrometers, FTIR spectrometers, MS spectrometers, UV spectrometers, UV fluorescence spectrometers, chemiluminescence spectrometers, ICR spectrometers, and mixtures or combinations thereof.

48. The method of claim 41, wherein the detector/analyzer is selected from the group consisting of UV fluorescence spectrometers, chemiluminescence spectrometers, and mixtures or combinations thereof.

49. An energy extraction apparatus comprising a fuel and oxidizer supply unit, a combustion or furnace apparatus comprising an inlet, an outlet, a combustion zone including a mixing zone disposed along a length of the combustion zone, and a heater and an energy conversion unit for converting a portion of the thermal energy of the oxidized fuel to a more useful form of energy.

50. An internal combustion apparatus comprising an internal combustion engine and a catalytic converting including a combustion or furnace apparatus an inlet, an outlet, a combustion zone including a mixing zone disposed along a length of the combustion zone, and a heater.

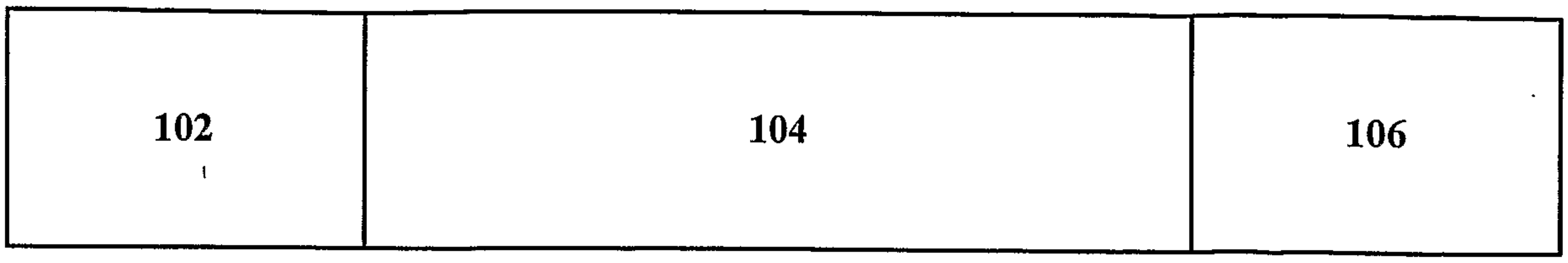

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FIG. 1A
PRIOR ART

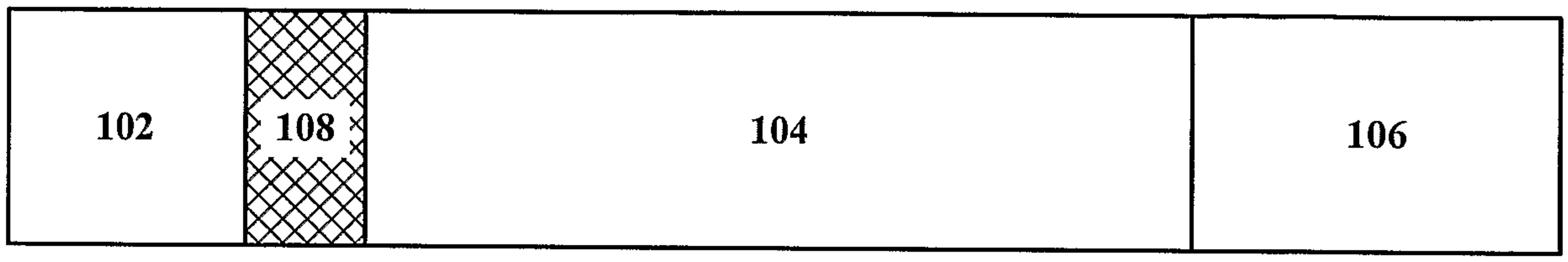

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FIG. 1B
PRIOR ART

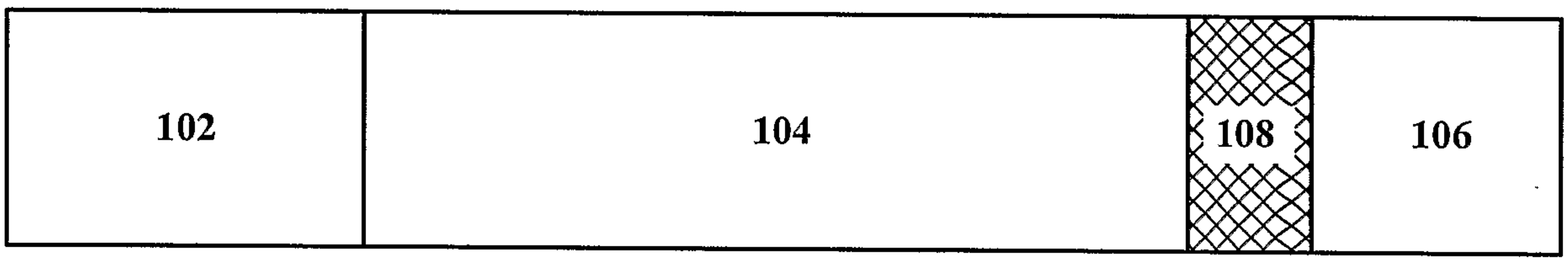

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FIG. 1C
PRIOR ART

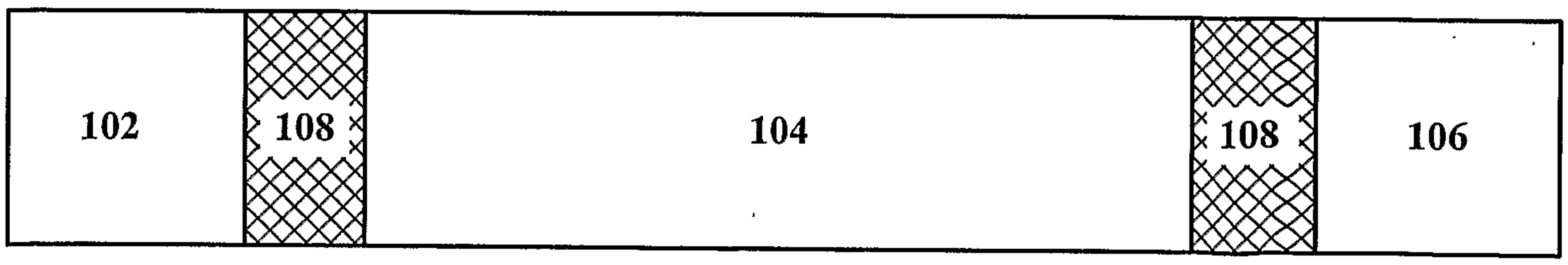

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FIG. 1D
PRIOR ART

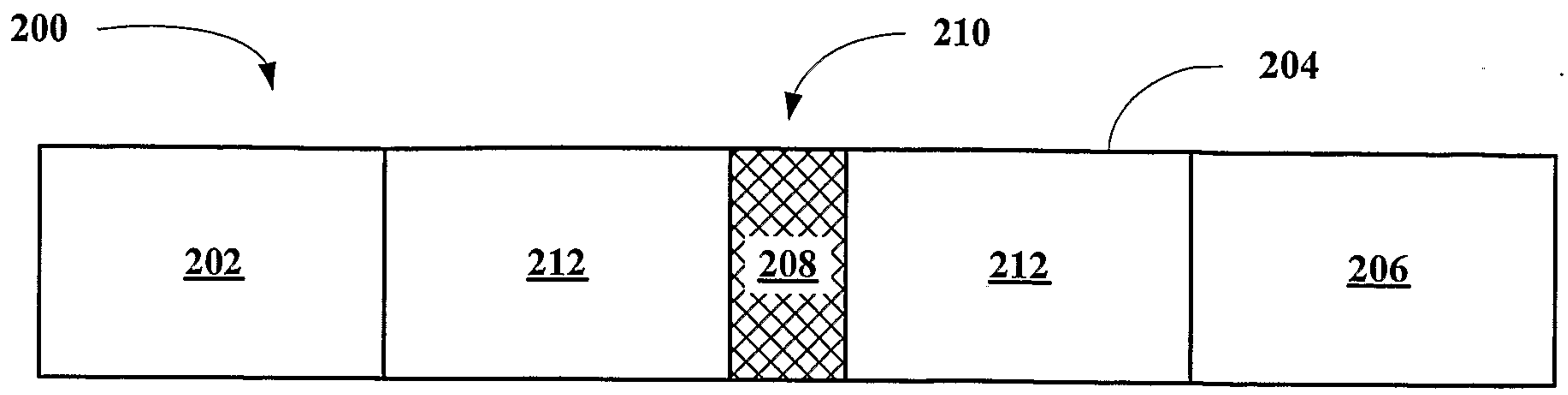


FIG. 2A

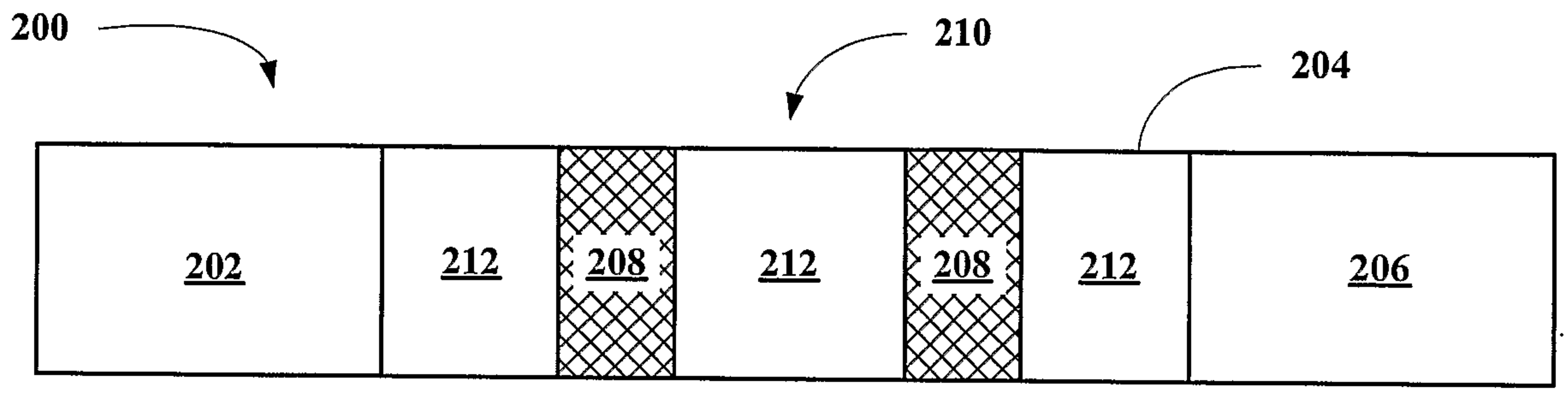


FIG. 2B

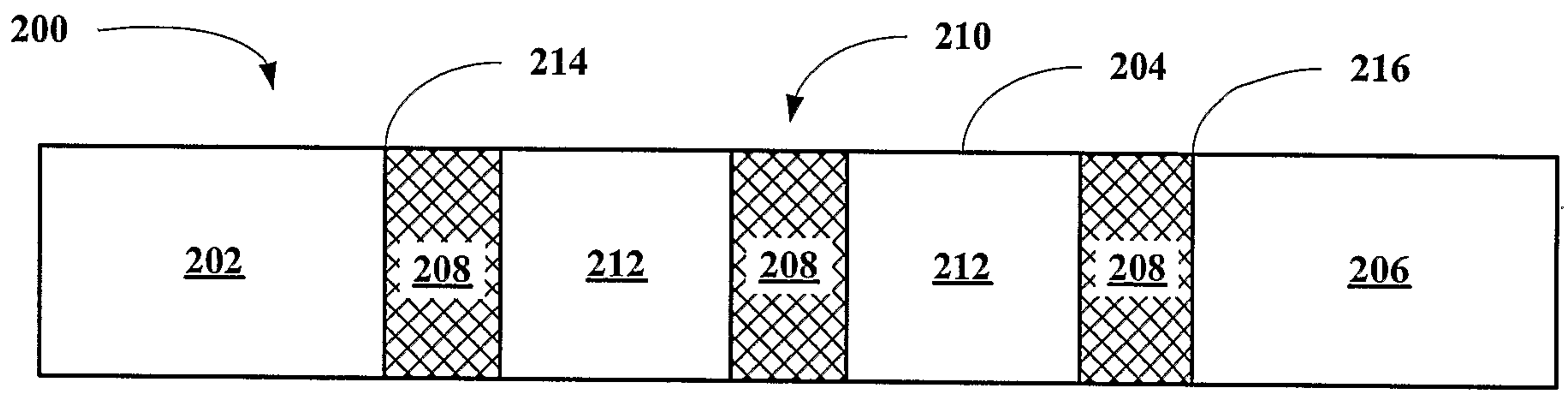


FIG. 2C

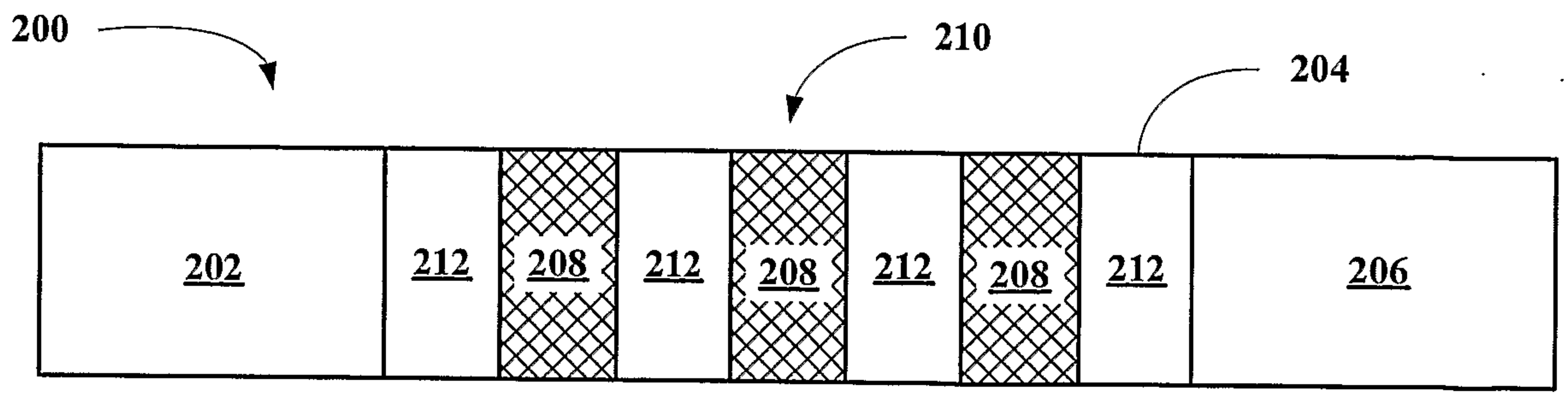


FIG. 2D

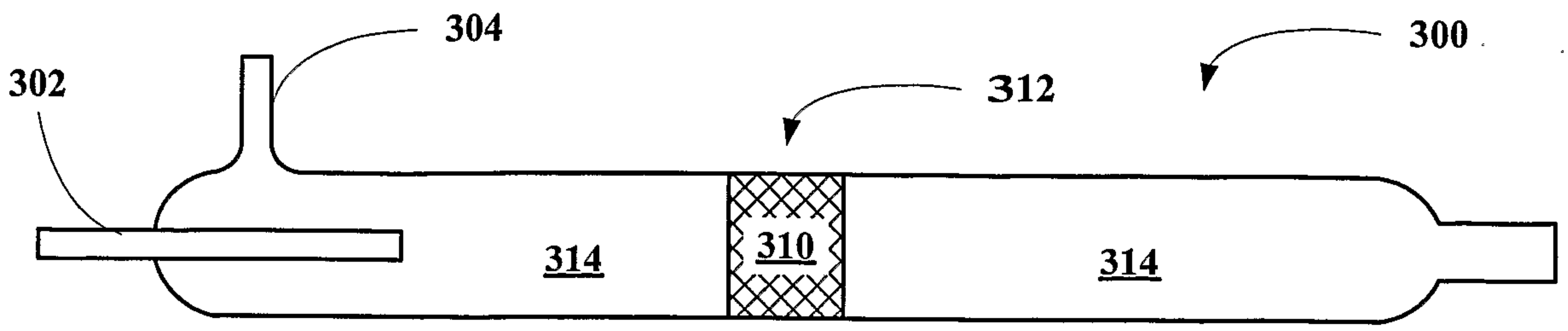


FIG. 3A

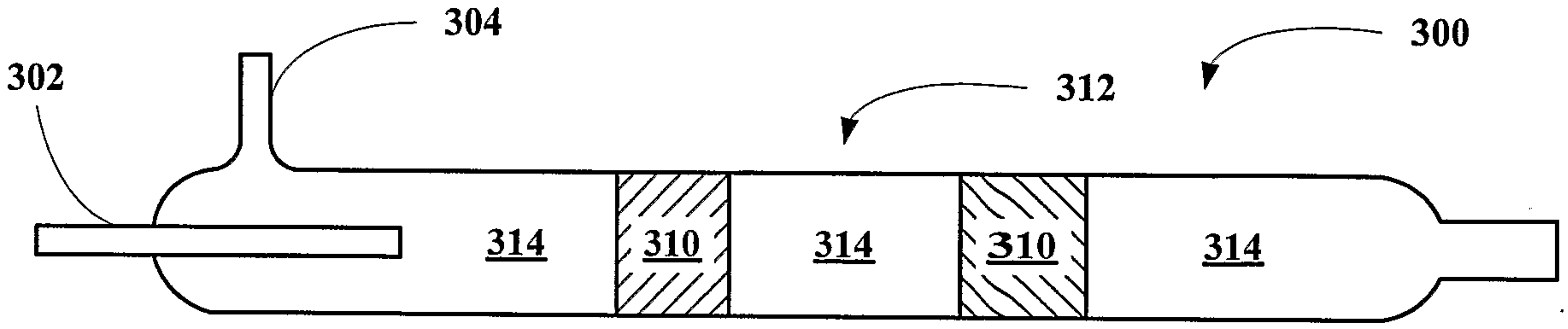


FIG. 3B

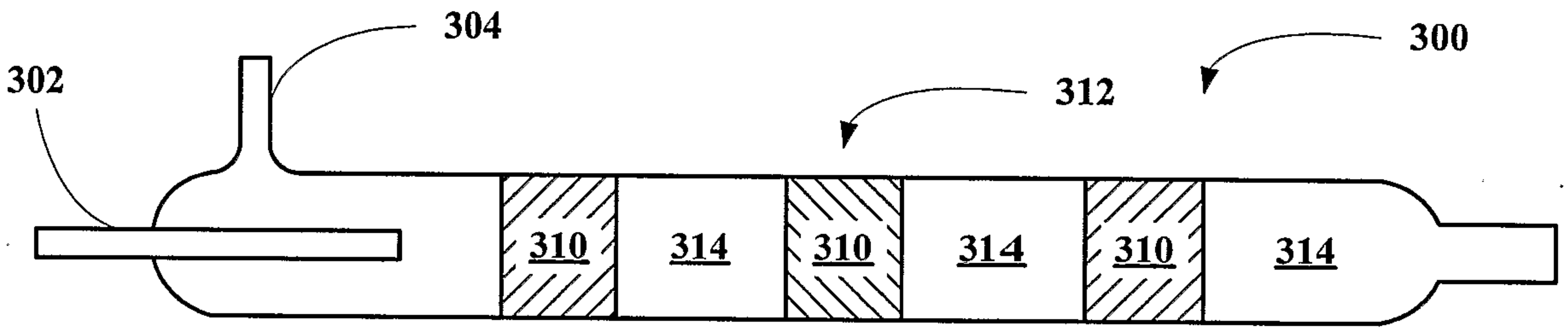


FIG. 3C

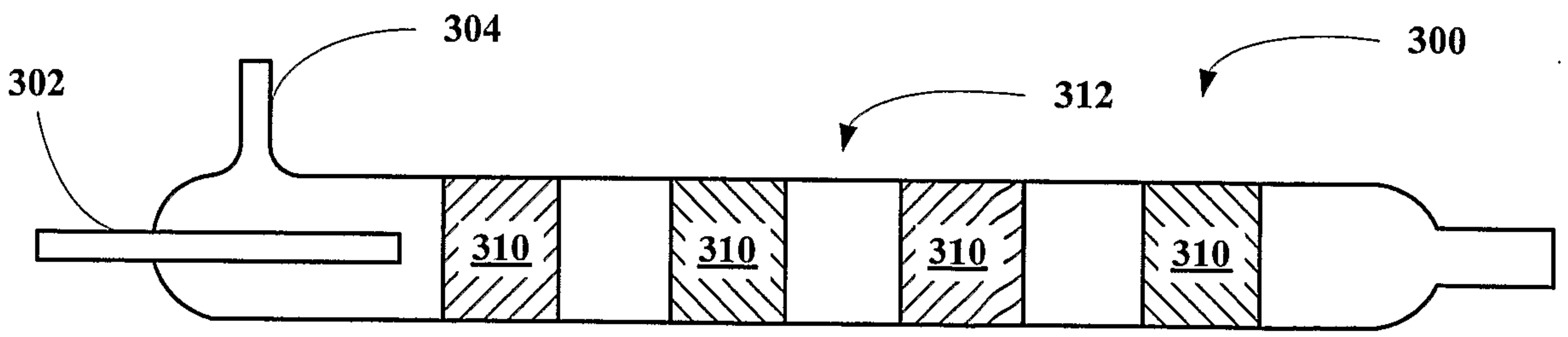


FIG. 3D

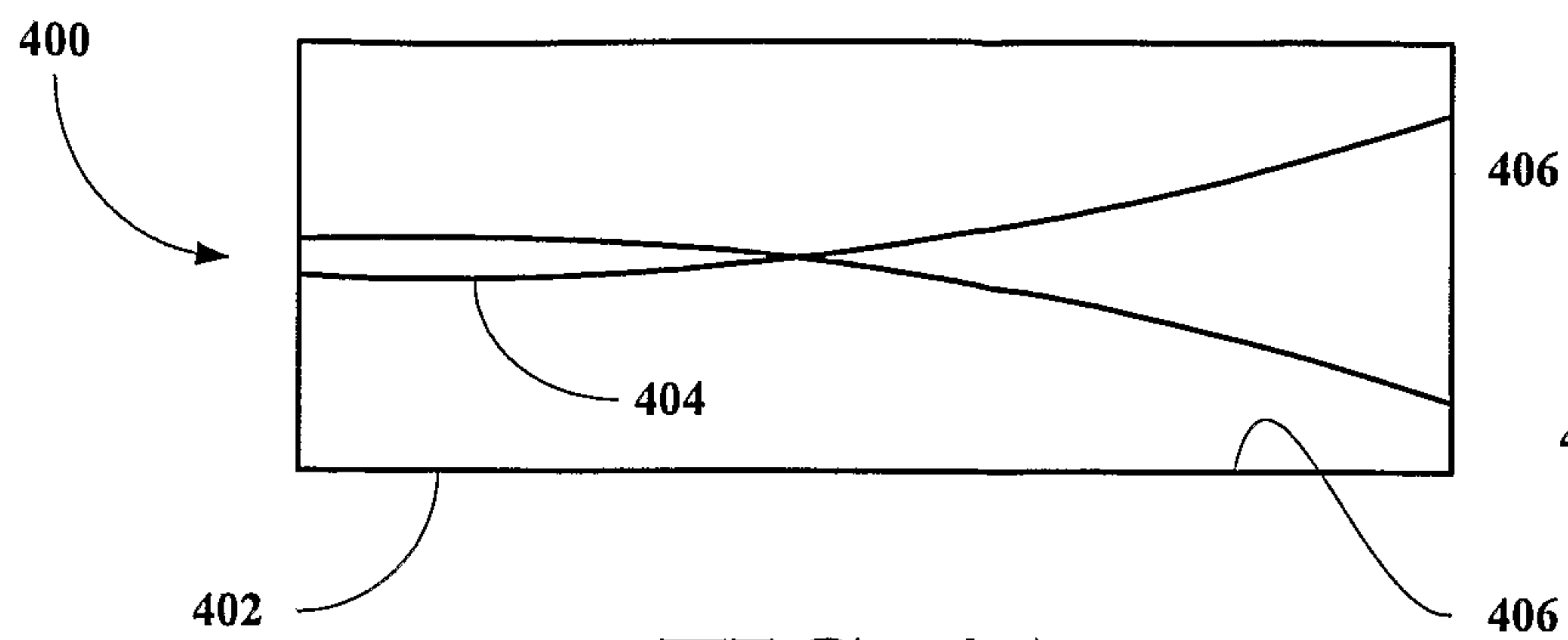


FIG. 4A

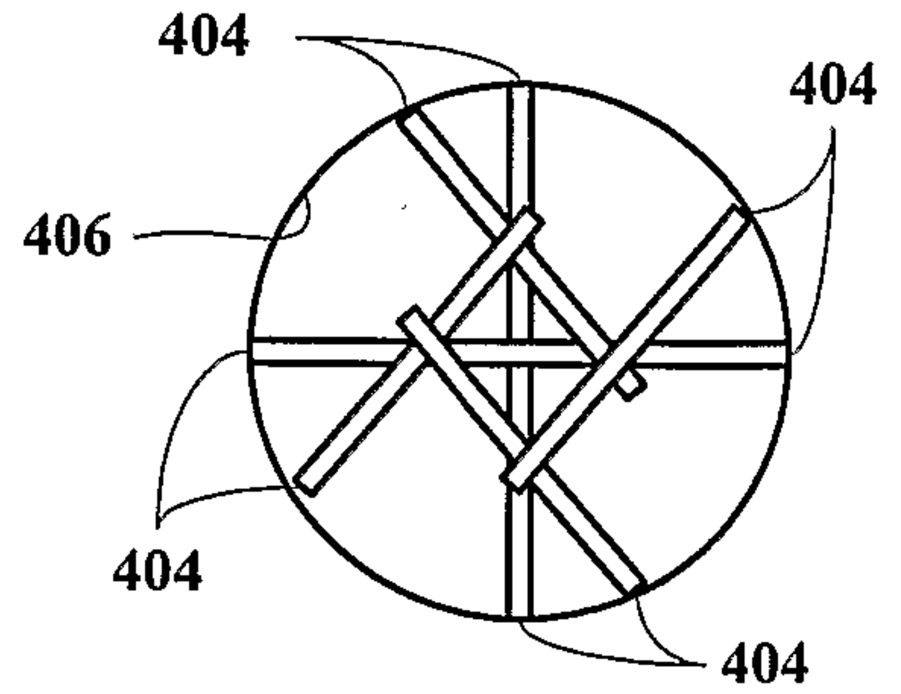


FIG. 4B

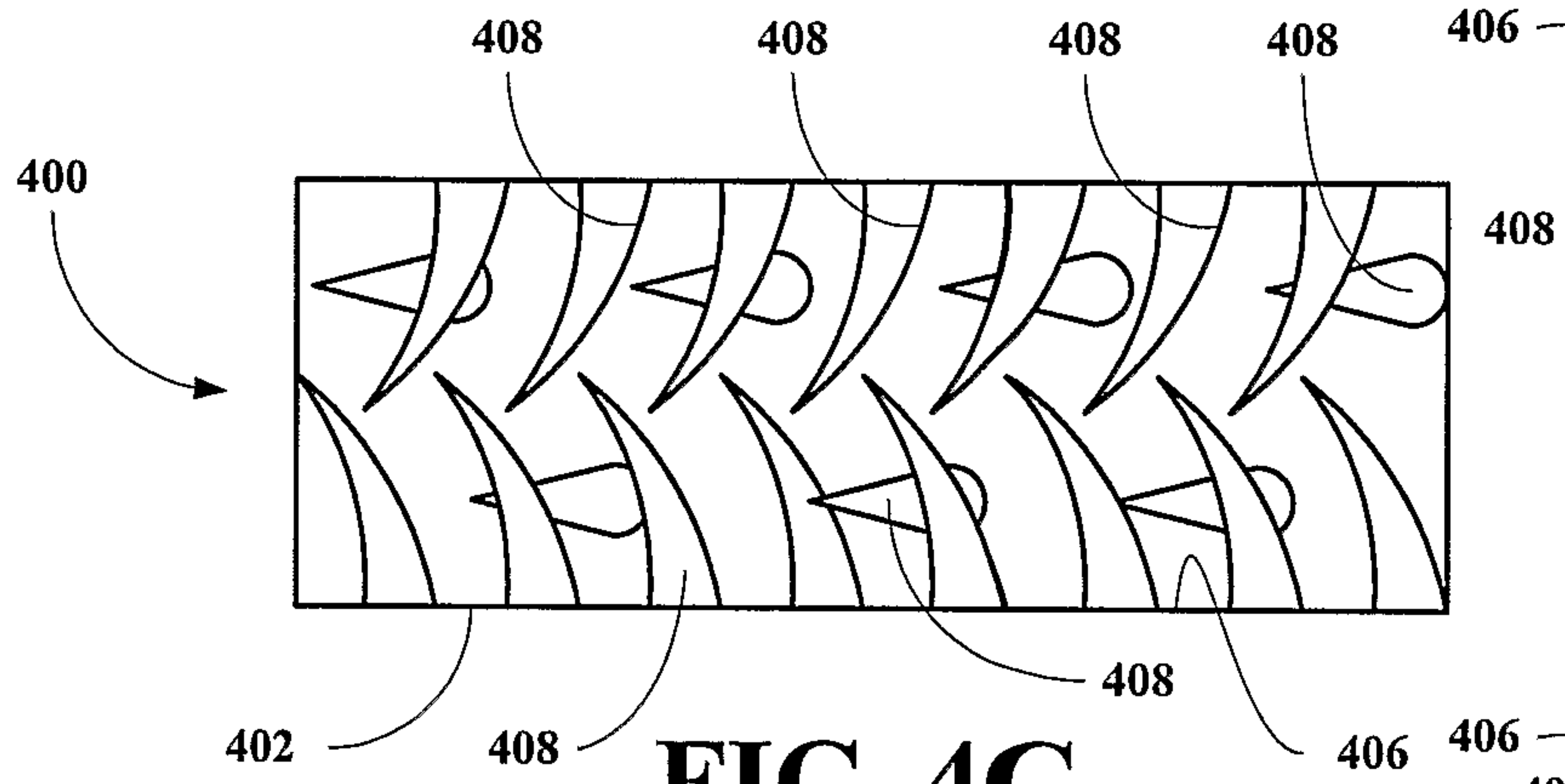


FIG. 4C

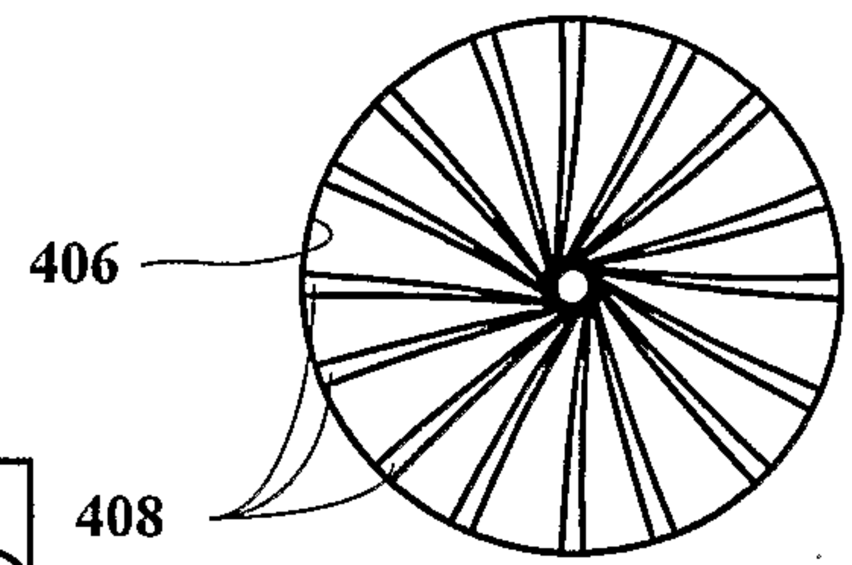


FIG. 4D

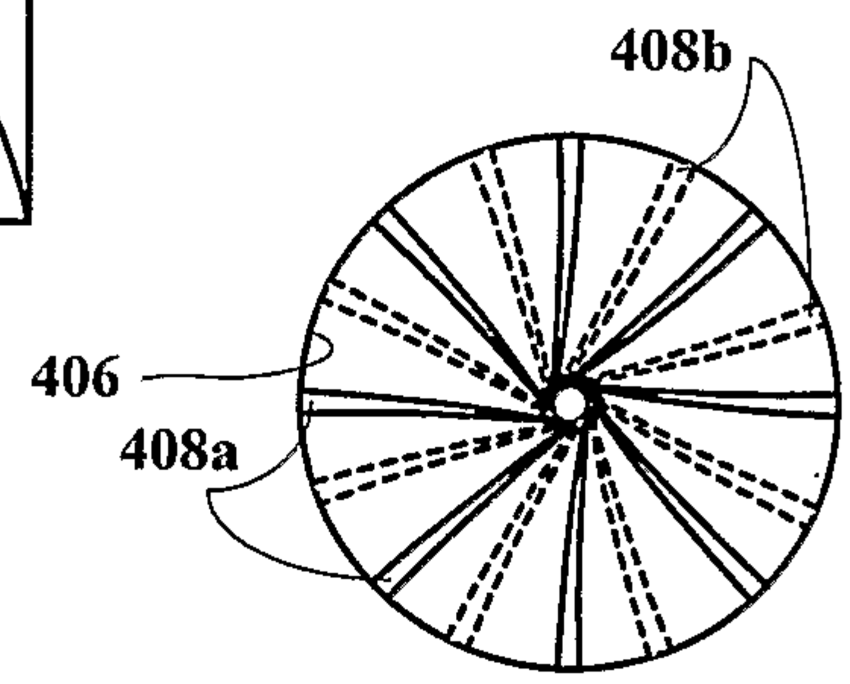


FIG. 4E

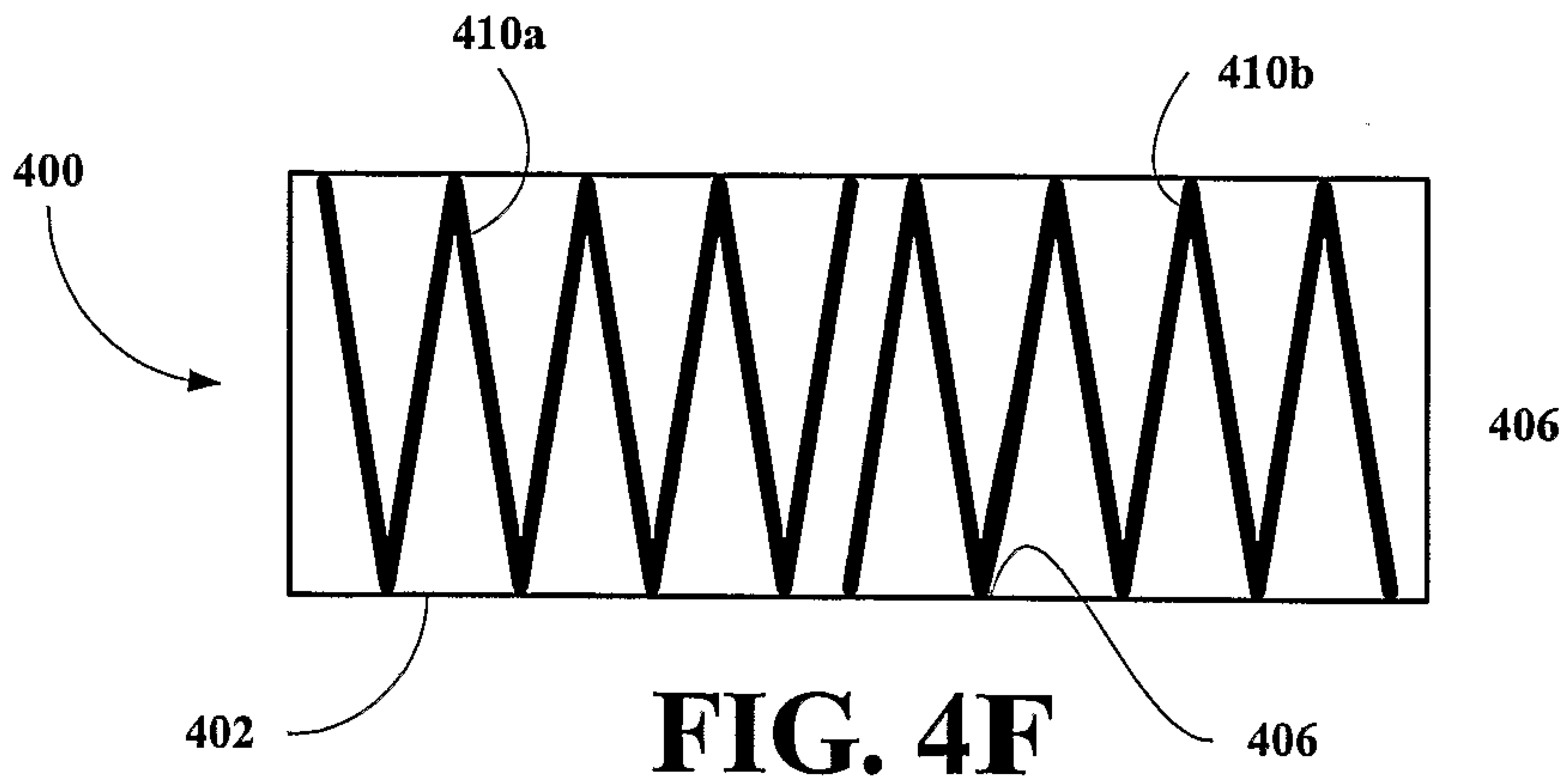


FIG. 4F

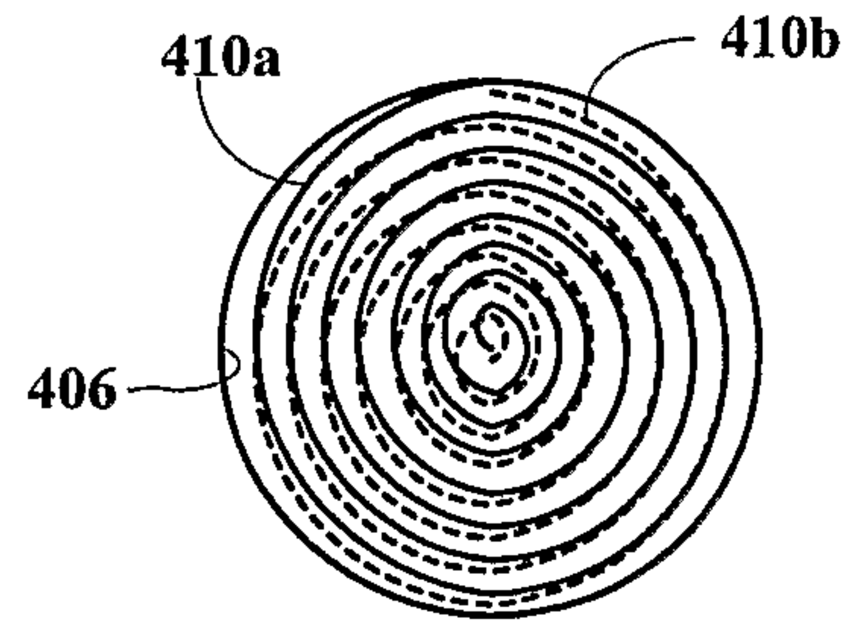


FIG. 4G

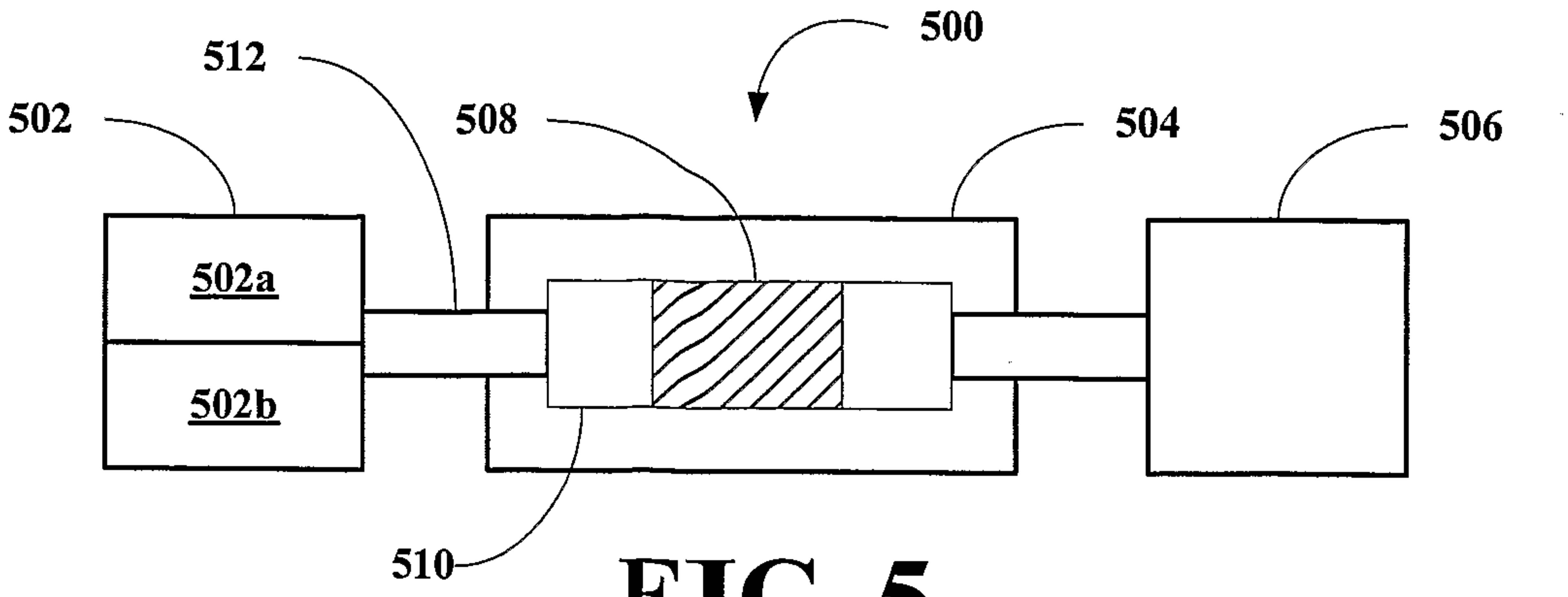


FIG. 5

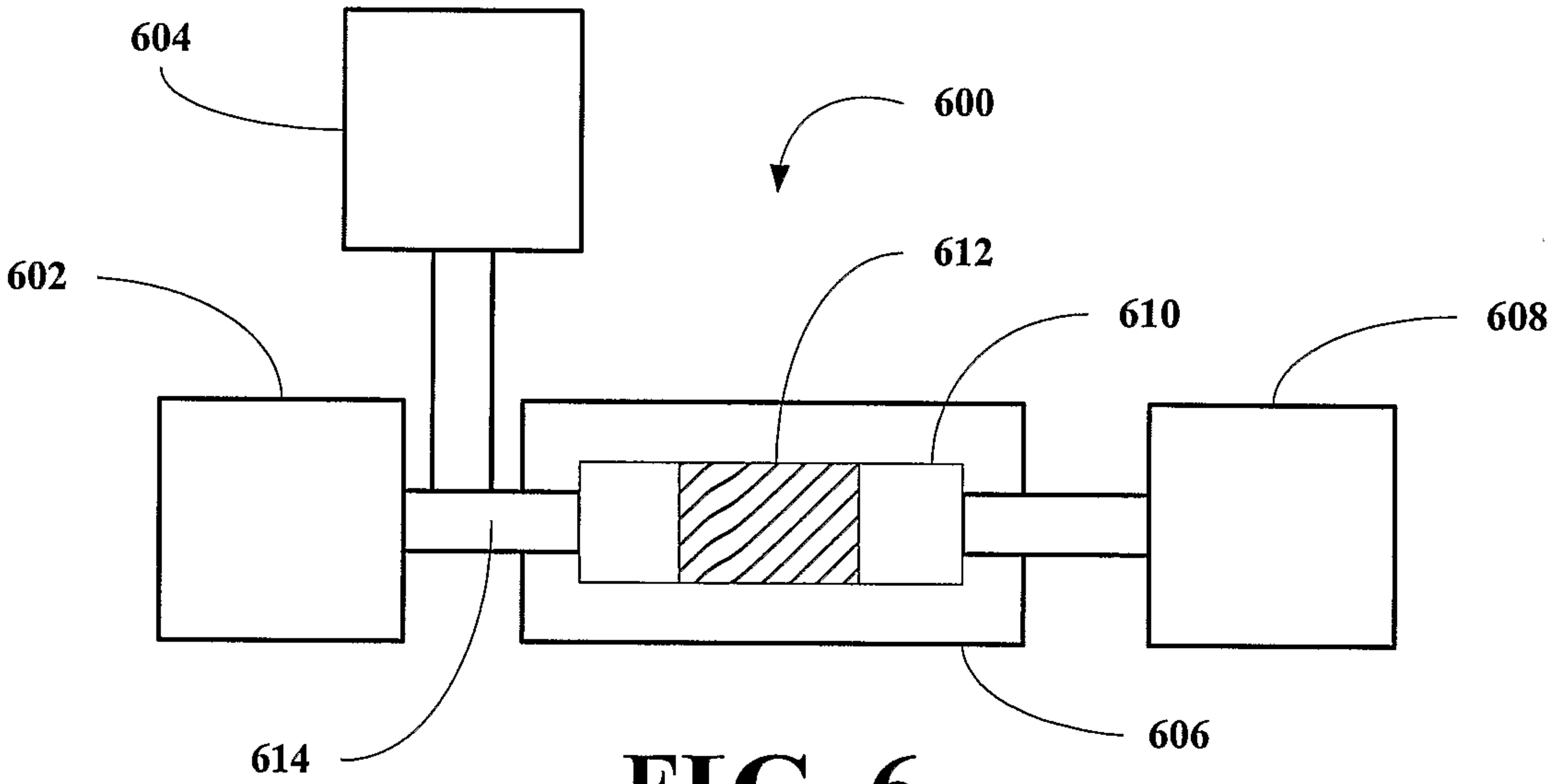


FIG. 6

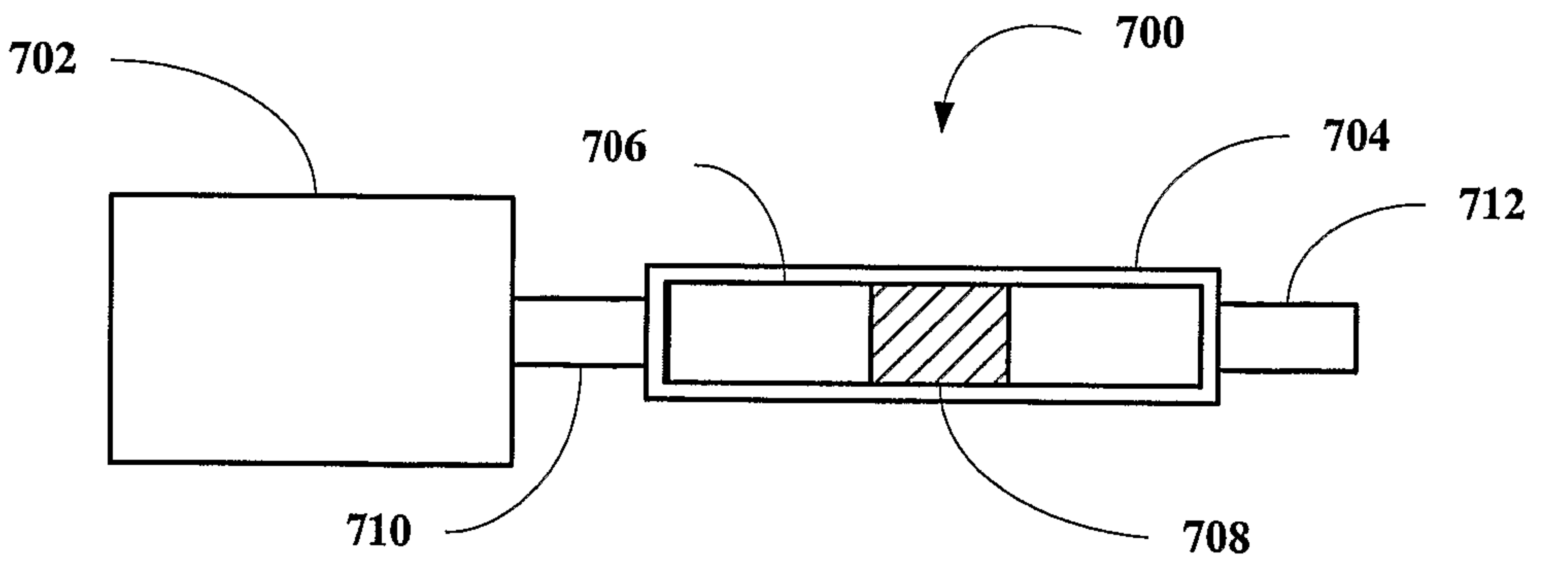


FIG. 7

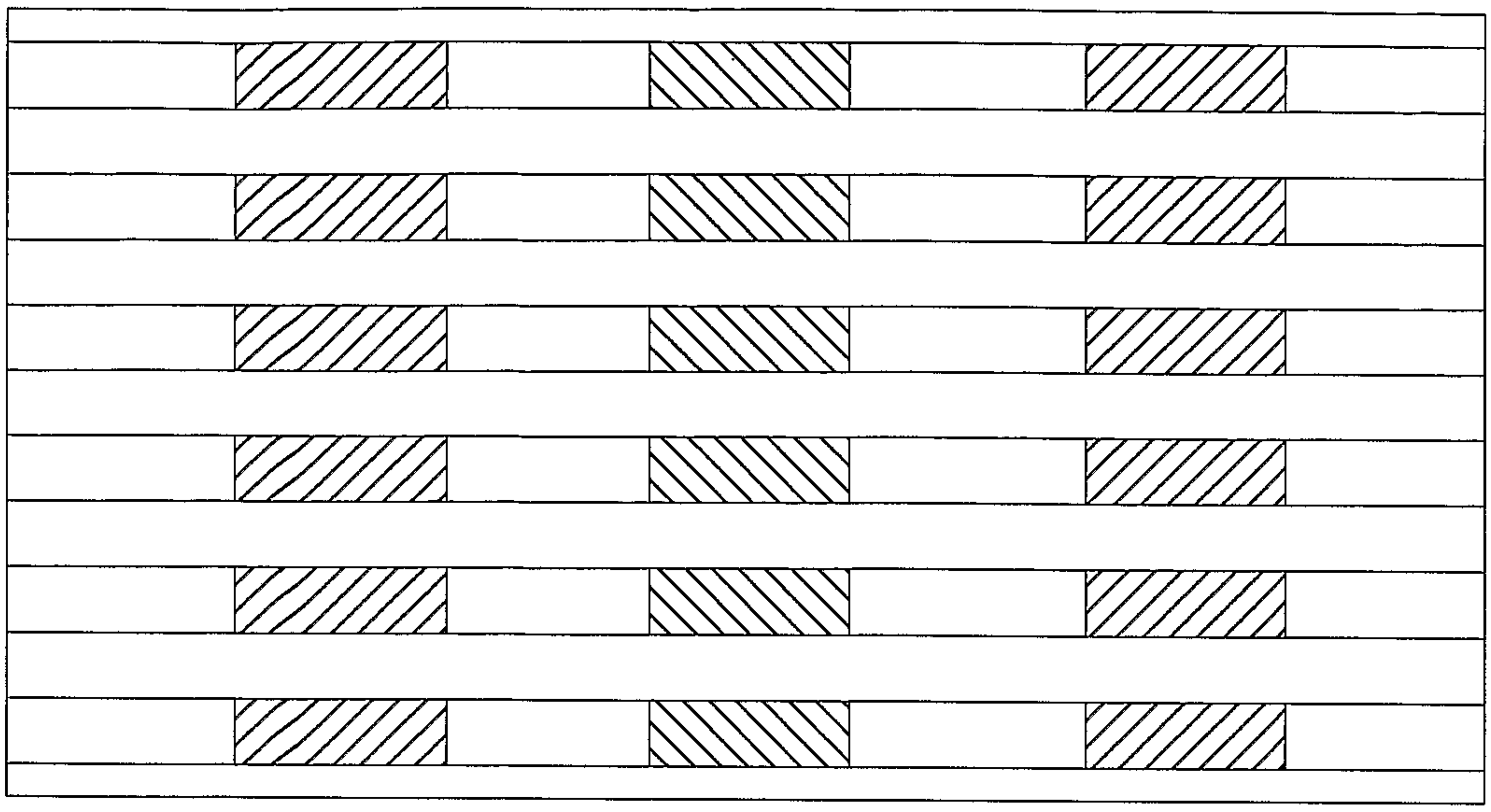


FIG. 8A

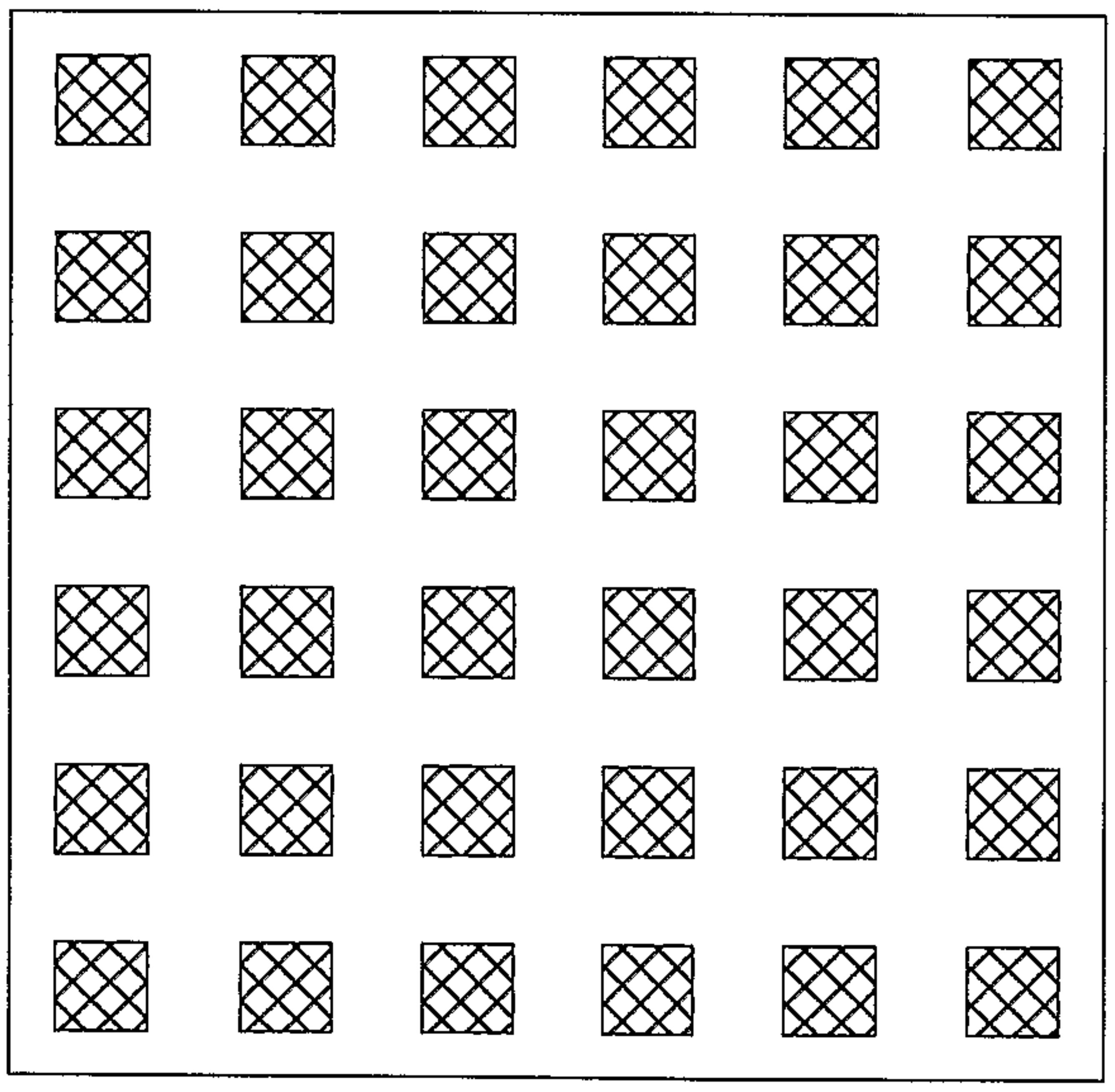
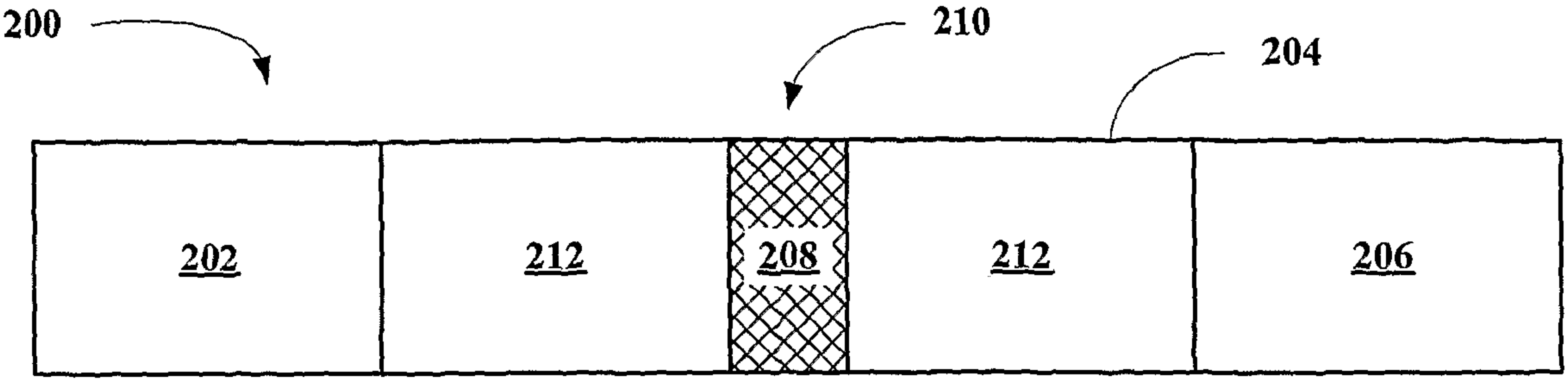


FIG. 8B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