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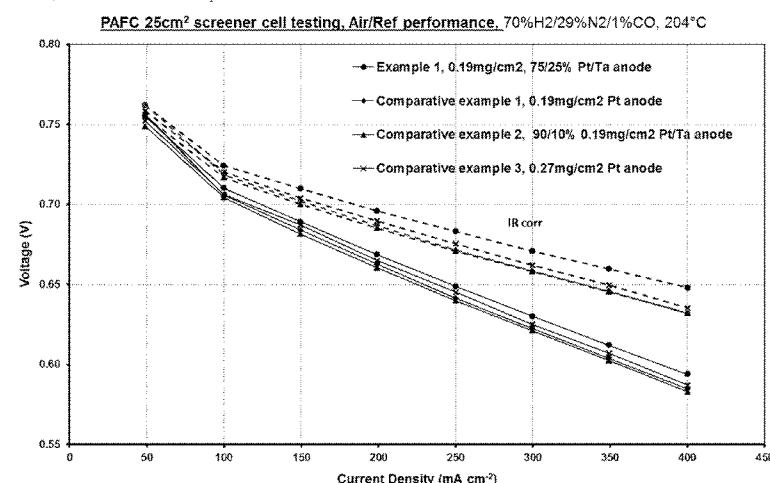
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Figure 1: Polarisation data for Example 1 and Comparative Examples 1, 2 and 3 generated at 204°C with air at the cathode and a 70% $\text{H}_2$ , 29% $\text{N}_2$ , 1%CO reformate mixture provided to the anode.



(57) Abstract: A binary alloy catalyst comprising platinum and tantalum, wherein the tantalum is present in the alloy at 15 to 50 atomic% and a phosphoric acid fuel cell comprising such a catalyst is disclosed. The catalyst provides a better CO tolerance.

WO 2014/122426 A1

## CO-TOLERANT CATALYST FOR PAFC

### Field of the Invention

The present invention relates to a novel catalyst, more specifically to a carbon monoxide tolerant catalyst for use in a gas diffusion electrode of a fuel cell using an acid electrolyte wherein proton conduction is carried out by materials such as phosphoric acid and/or polyphosphonic acid or materials comprising phosphonic acid functional groups.

### Background of the Invention

In a fuel cell a fuel, which is typically hydrogen or an alcohol, such as methanol or ethanol, is oxidised at a fuel electrode (anode) and oxygen, typically from air, is reduced at an oxygen electrode (cathode) to produce an electric current and form product water. An electrolyte is required which is in contact with both electrodes and which may be alkaline or acidic, liquid or solid. The liquid electrolyte phosphoric acid fuel cells operating at temperatures of 150°C-210°C, were the first fuel cells to be commercialised and find application in the multi-megawatt utility power generation market and also in combined heat and power i.e. cogeneration systems, in the 50 to several hundred kilowatt range. More recently, fuel cells in which a phosphoric acid-doped polybenzimidazole membrane is used as the electrolyte have been utilised for power generation, typically in the 1-5KW range, at temperatures in excess of 120°C.

To assist the oxidation and reduction reactions that take place at the anode and the cathode, catalysts are used. Precious metals, and in particular platinum, have been found to be the most efficient and stable electrocatalyst for fuel cells operating at temperatures below 300°C. The platinum electrocatalyst is typically provided as very small particles (~ 2-5nm) of high surface area, which are often, but not always, distributed on and supported by larger macroscopic electrically conductive particles to provide a desired catalyst loading. Conducting carbons are typically the preferred material to support the catalyst.

For use in a phosphoric acid fuel cell, hydrogen-rich fuel gas is obtained by external reforming of hydrocarbons, such as natural gas. Such a process produces, in addition to hydrogen, a mixture of gases including carbon monoxide at a level of 1 - 2%. Carbon monoxide is known to poison a pure platinum catalyst, even at relatively low levels and at the temperatures at which the phosphoric acid fuel cell is operated. Thus, researchers have been investigating ways of reducing the carbon monoxide content of hydrogen fuel before it enters

a fuel cell as a possible way to avoid poisoning the catalysts. However, extensive carbon monoxide reduction or clean-up processes invariably increase the size, complexity and cost of the fuel reformer system, often to prohibitive levels. An alternative simpler and more cost-effective solution is to provide a catalyst that is itself intrinsically more tolerant to carbon monoxide and achieving this has also been the subject matter of considerable research.

US 5,183,713 discloses a platinum-tantalum alloyed supported catalyst comprising 2 to 50 weight% platinum deposited on a support. The platinum-tantalum alloyed catalyst comprises about 2 to about 10 atomic% tantalum. The preferred range of tantalum in the catalyst is between about 5 and 8 atomic%. The tantalum, at percentages above about 8 atomic%, covers part of the platinum surface thereby interfering with fuel reaction sites, while at percentages below about 2 atomic% it causes a decrease in the carbon monoxide tolerance to unacceptable levels.

#### Summary of the Invention

It is the object of the present invention to provide a catalyst that demonstrates comparable or improved performance to state of the art catalysts in the presence of a fuel stream containing low levels of carbon monoxide, for example up to 4% carbon monoxide.

Accordingly, the present invention provides a binary alloy catalyst comprising platinum-tantalum, wherein the tantalum is present in the catalyst at 15 to 50 atomic%.

The invention further provides a method for the manufacture of the platinum-tantalum catalyst, and its use as the active component in an electrode of a fuel cell.

#### Brief Description of the Drawings

Figure 1 is a graph showing the polarisation data for Example 1 and Comparative Examples 1 to 3.

#### Detailed Description of the Invention

Preferred and/or optional features of the invention will now be set out. Any aspects of the invention may be combined with any other aspects of the invention, unless the context demands otherwise. Any of the preferred or optional features of any aspect may be combined, singly or in combination, with any aspect of the invention, unless the context demands otherwise.

The invention provides a binary alloy catalyst comprising platinum-tantalum, wherein the tantalum is present in the catalyst at 15 to 50 atomic%.

Suitably, the tantalum is present in the catalyst at 20 to 45 atomic%, suitably 20 to 40 atomic%, suitably 20 to 35 atomic %, suitably 20 to 30 atomic %, suitably 22 to 28 atomic %, suitably 24 to 26 atomic%.

In the present context, “atomic%” means atomic percentage, i.e. the percentage based on atoms or moles of the total of platinum and tantalum; any additional non-metallic components (e.g. carbon) are not taken into consideration. By the term ‘alloy’ we mean that there is at least some interaction and incorporation of the tantalum metal into the platinum lattice, but the incorporation is not necessarily complete or uniform throughout the whole alloy particle. The atomic percentage of the metal in the alloy catalyst may be determined by standard procedures known to those skilled in the art; for example by wet chemical analysis digestion of the sample followed by inductively coupled plasma (ICP) emission spectroscopy.

The catalyst of the invention can be used in a fuel cell as an unsupported catalyst (e.g. as a metal black) or as a supported catalyst (i.e. dispersed on a support material).

Preferably the catalyst of the invention is used as a supported catalyst. Suitably the amount of the platinum-tantalum alloy is 5-15wt% based on the weight of platinum versus the total weight of the supported catalyst, suitably 5-10wt%. In a supported catalyst according to the present invention the platinum-tantalum alloy is suitably dispersed on a conductive high surface area support material, for example a conductive carbon, such as an oil furnace black, extra-conductive black, acetylene black or heat-treated or graphitised versions thereof, or carbon nanofibres or nanotubes. It may also be possible to use a non-conducting support material, such as inorganic metal oxide particles if the catalyst is deposited sufficiently well over the surface to provide the required electronic conductivity. The catalyst of the invention preferably consists essentially of the platinum-tantalum alloy dispersed on a conductive carbon material. Exemplary carbons include Akzo Nobel Ketjen EC300J (or the heat-treated or graphitised versions thereof), Cabot Vulcan XC72R (or the heat-treated or graphitised versions thereof) and Denka Acetylene Black.

The invention further provides a method for the manufacture of the platinum-tantalum alloy catalyst of the invention. The catalyst of the invention is prepared by adding a mixed solution containing compounds of each of platinum and tantalum to a dispersion of carbon at elevated temperature. Once the metal depositions have completed, the catalyst is recovered, for example by filtration, washed free of soluble ionic species and dried. A heat treatment

process is carried out at a temperature of between 700°C and 1000°C in an inert atmosphere to form the catalyst. Alternatively, the platinum and tantalum solutions may be sequentially deposited onto the carbon support, followed by filtration, drying and heat treatment.

The catalyst of the invention has particular utility as the active component in an electrode of a fuel cell comprising an acid electrolyte wherein proton conduction is carried out by materials such as phosphoric acid and/or polyphosphonic acid or materials comprising phosphonic acid functional groups. Examples of such fuel cells include, but are not limited to: fuel cells, in which the electrolyte is liquid phosphoric acid held in a supporting matrix, for example a silicon carbide matrix; and fuel cells in which the electrolyte is a phosphoric acid-doped polybenzimidazole membrane. In the context of the present invention, all such fuel cells which comprise phosphoric acid materials as the electrolyte will be termed 'phosphoric acid fuel cells'. More specifically, the catalyst of the invention shows particular utility as the hydrogen oxidation catalyst when hydrogen contaminated with carbon monoxide (for example at a concentration of up to 4%) is used as the fuel.

Thus, a further aspect of the invention provides an electrode comprising a platinum-tantalum alloyed catalyst of the invention. In a preferred embodiment, the electrode is the anode. To form the electrode, a catalyst layer comprising the catalyst of the invention, mixed with a fluoropolymer binder such as polytetrafluoroethylene (PTFE), is applied to one side of a porous gas diffusion substrate using a range of well-established techniques, followed by drying and heating above the melting point of the polymer. Typical gas diffusion substrates include non-woven papers or webs comprising a network of carbon fibres and a thermoset resin binder (e.g. the TGP-H series of carbon fibre paper available from Toray Industries Inc., Japan or the H2315 series available from Freudenberg FCCT KG, Germany, or the Sigracet® series available from SGL Technologies GmbH, Germany or AvCarb® series from Ballard Power Systems Inc., or woven carbon cloths. The carbon paper, web or cloth may be provided with a further treatment prior to being used in an electrode either to make it more wettable (hydrophilic) or more wet-proofed (hydrophobic). The substrate can be made more wettable by incorporation of materials such as amorphous carbon blacks via impregnation from liquid suspensions, or can be made more hydrophobic by impregnating the pore structure of the substrate with a colloidal suspension of a polymer such as PTFE or polyfluoroethylenepropylene (FEP), followed by drying and heating above the melting point of the polymer.

In a further embodiment of the invention, the catalyst of the invention is applied to a decal transfer substrate. Accordingly, a further aspect of the present invention provides a decal transfer substrate comprising a platinum-tantalum catalyst of the invention applied to a surface thereof. The transfer substrate may be any suitable transfer substrate known to those skilled in the art but is preferably a polymeric material such as polytetrafluoroethylene (PTFE) or polypropylene (especially biaxially-oriented polypropylene, BOPP) or a polymer-coated paper such as polyurethane coated paper. The transfer substrate could also be a silicone release paper or a metal foil such as aluminium foil. The catalyst of the invention may then be transferred to a gas diffusion substrate by techniques known to those skilled in the art.

For phosphoric acid fuel cell electrodes, the catalyst is usually mixed with an aqueous suspension of a hydrophobic fluoropolymer such as PTFE, to act as a polymeric binder, and the resultant flocculated material applied to the gas diffusion substrate or decal transfer substrate by techniques such as direct filtration, filter transfer, screen printing (as described in e.g. US 4,185,131) or dry powder vacuum deposition (as described in US 4,175,055).

The catalyst of the invention is suitably applied to the gas diffusion substrate or decal transfer substrate at a loading on the anode of between 0.1mg/cm<sup>2</sup>Pt and 0.35mg/cm<sup>2</sup>Pt, suitably between 0.15mg/cm<sup>2</sup>Pt and 0.35mg/cm<sup>2</sup>Pt and preferably between 0.15mg/cm<sup>2</sup>Pt and 0.25mg/cm<sup>2</sup>Pt. The catalyst of the invention is suitably applied to the gas diffusion substrate or decal transfer substrate at a loading on the cathode of between 0.2mg/cm<sup>2</sup>Pt to 0.8mg/cm<sup>2</sup>Pt, suitably 0.3mg/cm<sup>2</sup>Pt to 0.6mg/cm<sup>2</sup>Pt.

The catalyst of the invention is used in fuel cell comprising an acid electrolyte wherein proton conduction is carried out by materials such as phosphoric acid and/or polyphosphonic acid or materials comprising phosphonic acid functional groups; and in particular a phosphoric acid fuel cell. Accordingly, a further aspect of the invention provides a phosphoric acid fuel cell comprising an electrode, preferably an anode, of the invention. When in operation, a carbon-monoxide-containing hydrogen-fuel will be supplied to the anode (of the invention) and an oxidant to the cathode (a conventional cathode). More specifically, the invention provides a phosphoric acid fuel cell comprising an anode of the invention, a cathode and an electrolyte comprising phosphoric acid groups disposed between the anode and cathode, and wherein the anode of the fuel cell, when in operation, is supplied with a carbon monoxide-containing hydrogen fuel.

Also provided by the invention is a process for operating a phosphoric acid fuel cell, the process comprising: providing a phosphoric acid fuel cell, wherein the anode comprises a platinum-tantalum catalyst according to the invention; providing a fuel stream to the anode wherein the fuel stream comprises carbon monoxide; and operating the fuel cell at elevated temperature.

Typically, the fuel stream comprises up to 4% carbon monoxide, for example up to 2% carbon monoxide. Typically, the fuel stream comprises at least 0.5% carbon monoxide.

By elevated temperature is meant a temperature equal to or greater than about 120°C. The maximum temperature at which a phosphoric acid fuel cell is operated is about 220°C.

The invention will now be described in more detail with reference to the following examples, which are illustrative and not limiting of the invention.

Example 1: Preparation of Pt<sub>75</sub>Ta<sub>25</sub> catalyst

Carbon black (Cabot Vulcan XC72R) (180.4 g) was dispersed in water using a shear mixer and transferred to a reaction vessel. NaHCO<sub>3</sub> (143.8g) was added to the slurry and the mixture heated to reflux. TaCl<sub>5</sub> (9.2 g) dissolved in concentrated hydrochloric acid was added to a chloroplatinic acid solution containing 15.0g of Pt. The Pt/Ta solution was added to the refluxing carbon black suspension. When deposition of the metals was completed the catalyst was recovered by filtration and washed on the filter bed with demineralised water until free of soluble ions. The material was dried and then annealed at high temperature (e.g. 800°C) in an inert atmosphere. Final analysis was carried out by wet chemical digestion of samples and ICP-MS on the resultant metal solutions to determine the metal assay. The degree of sample uniformity and alloying was assessed using X-Ray Diffraction (XRD) analysis. A nominal Pt<sub>75</sub>Ta<sub>25</sub> catalyst (i.e. 75 atomic% Pt, 25 atomic% Ta) was obtained with a nominal loading of 7.5wt% Pt on carbon.

Comparative Example 1: Platinum Catalyst

Using an analogous process to that described for Example 1, a Pt catalyst was obtained with a nominal loading of 10wt% Pt on Cabot Vulcan XC72R carbon black.

Comparative Example 2: Preparation of Pt<sub>90</sub>Ta<sub>10</sub> Catalyst

Using an analogous process to that described for Example 1, a nominal Pt<sub>90</sub>Ta<sub>10</sub> catalyst (i.e. 90 atomic% Pt, 10 atomic% Ta) was obtained with a nominal loading of 7.4wt% Pt on Cabot Vulcan XC72R carbon black.

Comparative Example 3: Platinum Catalyst

Comparative Example 3 used the same catalyst as in Comparative Example 1.

Preparation of electrode and testing

Electrodes were prepared using Comparative Examples 1, 2 and 3 and Example 1 as anode catalysts. The same process was used for the preparation of the electrodes.

All catalysts were added to an aqueous dispersion of PTFE at a constant ratio of PTFE to the carbon support to create a floc before being mixed at high shear. The inks were then filtered and dried, before a dry powder deposition process was employed to deposit the anode catalyst onto a non-woven graphitised substrate which was subsequently heated above the PTFE melting temperature. Table 1 shows the loading of Pt in the anodes.

Table 1

Electrode Number	Catalyst	Loading of Pt in the anode
Example 1	75/25at% Pt/Ta/C	0.19mg/cm <sup>2</sup>
Comparative Example 1	Pt/C	0.19mg/cm <sup>2</sup>
Comparative Example 2	90/10at% Pt/Ta/C	0.19mg/cm <sup>2</sup>
Comparative Example 3	Pt/C	0.27mg/cm <sup>2</sup>

The electrodes were then paired with a state of the art cathode comprising a Pt/Co/Cr ternary alloy catalyst in between a SiC matrix and doped with the same known amount of phosphoric acid to form an integrated single phosphoric acid fuel cell electrode assembly. The assembly was placed either side of metal flow field plates to build a complete single fuel cell. Each cell was then conditioned for 15hrs at 100mA/cm<sup>2</sup> and a polarisation curve was generated at 204°C with air at the cathode and a reformatte fuel stream containing 70%H<sub>2</sub>, 29%N<sub>2</sub>, 1%CO fed to the anode. The cell polarisation results are shown in Figure 1.

Comparative Examples 1 and 2 and Example 1 each have the same platinum loading in the anode. Comparative Examples 1 and 2 demonstrate very similar performance but Example 1 using the Pt/Ta alloy of the invention clearly demonstrates an improvement across the current density range realising a 10mV improvement in fuel cell output at the 300mA/cm<sup>2</sup> operational current density. Once corrected for ohmic resistance the kinetic improvement is in the 15mV range.

Comparative Example 3 has a higher platinum loading in the anode than Example 1; however, Example 1 again demonstrates an improvement across the current density range.

The higher cell voltage achieved by Example 1 of the invention provides for a significantly higher electrical efficiency output from the fuel cell.

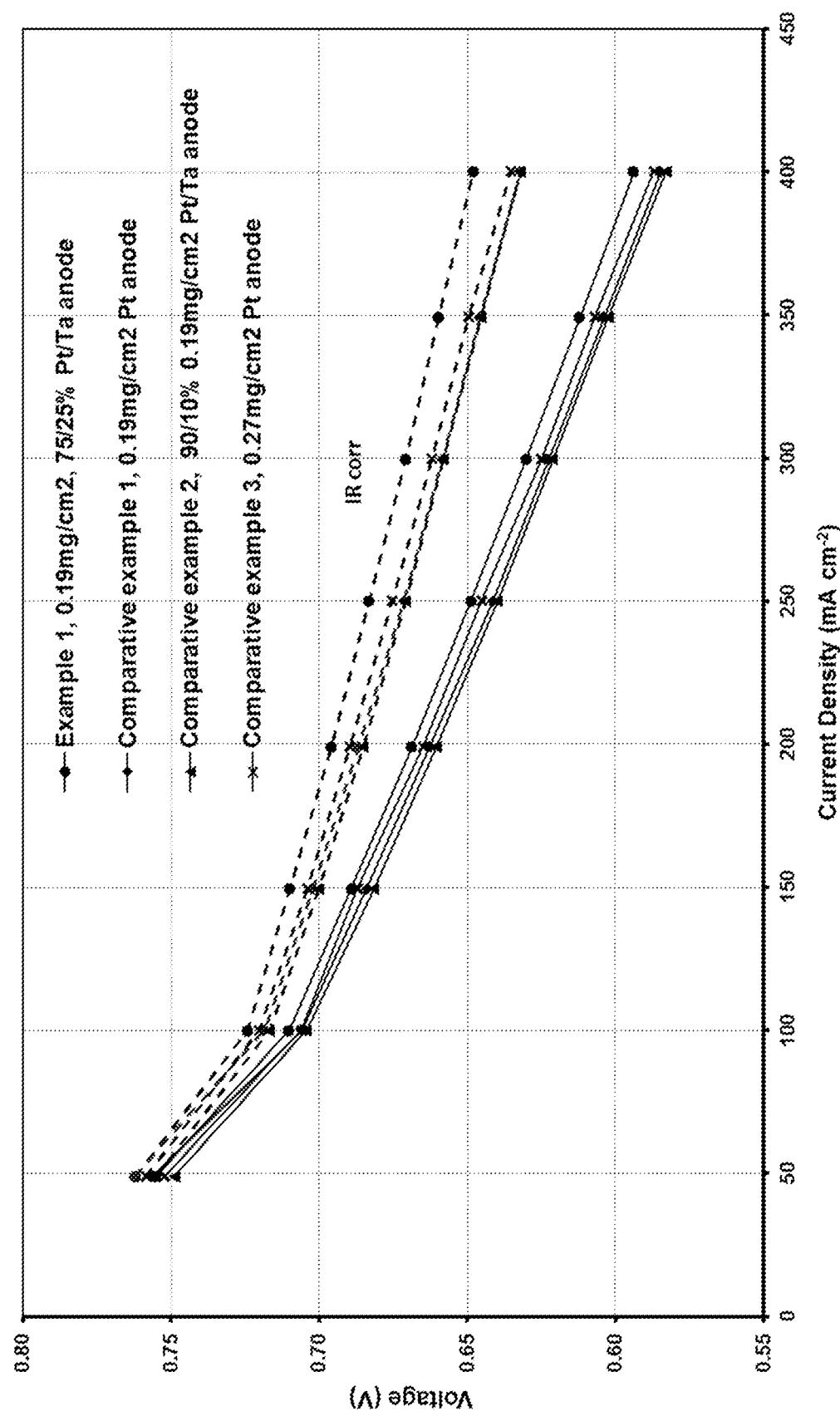
**Claims**

1. A binary alloy catalyst comprising platinum and tantalum, wherein the tantalum is present in the alloy at 15 to 50 atomic%.
2. A binary alloy catalyst according to claim 1, wherein the catalyst further comprises a support material on which the alloy is dispersed.
3. A binary alloy catalyst according to claim 2, wherein the alloy is dispersed on the support material at a loading of 5-15wt% based on the weight of platinum versus the total weight of the catalyst.
4. An electrode comprising the binary alloy catalyst according to any one of claims 1 to 3.
5. An electrode according to claim 4, wherein the electrode is the anode.
6. A phosphoric acid fuel cell comprising an electrode according to claim 4.
7. A phosphoric acid fuel cell comprising an anode according to claim 5, a cathode and a phosphoric acid electrolyte disposed between the anode and cathode, and wherein the anode of the fuel cell, when in operation, is supplied with a carbon monoxide-containing hydrogen fuel.
8. A phosphoric acid fuel cell according to claim 7, in which the electrolyte is liquid phosphoric acid held in a supporting matrix.
9. A phosphoric acid fuel cell according to claim 7, in which the electrolyte is a phosphoric acid-doped polybenzimidazole membrane.
10. A process for operating a phosphoric acid fuel cell, the process comprising: providing a phosphoric acid fuel cell, wherein the anode comprises a platinum-tantalum catalyst

according to the invention; providing a fuel stream to the anode wherein the fuel stream comprises carbon monoxide; and operating the fuel cell at elevated temperature.

Figure 1: Polarisation data for Example 1 and Comparative Examples 1, 2 and 3 generated at 204°C with air at the cathode and a 70%H<sub>2</sub>, 29%N<sub>2</sub>, 1%CO reformate mixture provided to the anode.

**PATC 25cm<sup>2</sup> screener cell testing, Air/Ref performance, 70%H<sub>2</sub>/29%N<sub>2</sub>/1%CO, 204°C**



# INTERNATIONAL SEARCH REPORT

International application No

PCT/GB2014/050226

**A. CLASSIFICATION OF SUBJECT MATTER**  
 INV. H01M4/92 B01J23/648 H01M8/08  
 ADD.

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)  
 H01M B01J

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

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

EP0-Internal

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2012/189943 A1 (CAMPBELL STEPHEN A [CA] ET AL) 26 July 2012 (2012-07-26) paragraphs [0007], [0023], [0024], [0029], [0033] - [0035] ----- X US 2009/137388 A1 (YOSHIDA TAKASHI [JP] ET AL) 28 May 2009 (2009-05-28) paragraphs [0006], [0015], [0019], [0026] claim 1 ----- A US 5 183 713 A (KUNZ HAROLD R [US]) 2 February 1993 (1993-02-02) cited in the application column 3, lines 1-31 column 4, lines 59-64 column 5, lines 39-45 ----- -/-	1-10 1,4,5 1-10

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  
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 "P" document published prior to the international filing date but later than the priority date claimed

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Date of the actual completion of the international search

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**INTERNATIONAL SEARCH REPORT**

International application No  
PCT/GB2014/050226

**C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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**INTERNATIONAL SEARCH REPORT**

Information on patent family members

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