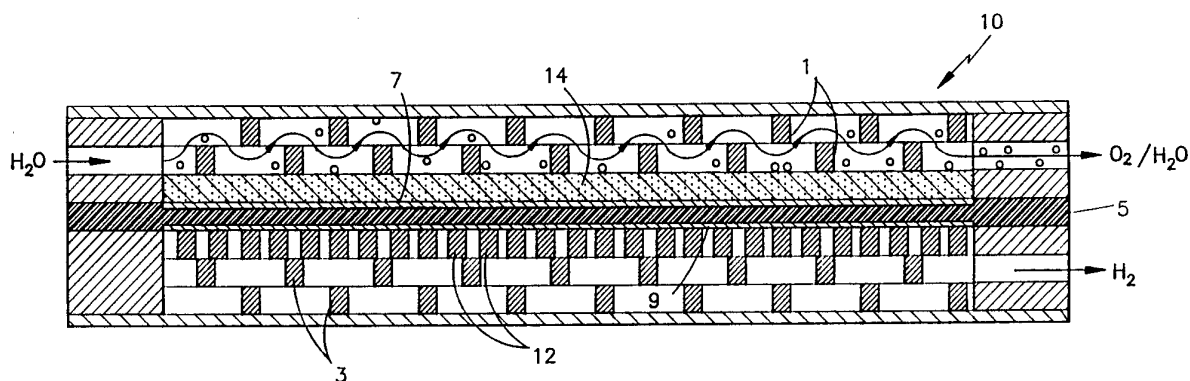


INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁵ : C25B 9/00, 1/10	A1	(11) International Publication Number: WO 93/24677 (43) International Publication Date: 9 December 1993 (09.12.93)
(21) International Application Number: PCT/US93/04969 (22) International Filing Date: 25 May 1993 (25.05.93) (30) Priority data: 892,152 2 June 1992 (02.06.92) US (71) Applicant: UNITED TECHNOLOGIES CORPORATION [US/US]; United Technologies Building, Hartford, CT 06101 (US). (72) Inventors: CARLSON, Hugh, A. ; 309 East Wakefield Blvd., Windsted, CT 06098 (US). LEONIDA, Andrei ; 2 Lincoln Avenue, West Hartford, CT 06117 (US). MCELROY, James, F. ; 278 Halladay Avenue, East Suffield, CT 06078 (US). SHANE, Eric, M. ; 27 Clifdon Drive, Simsbury, CT 06070 (US).		(74) Agent: KELLY, Robert, H.; Hamilton Standard, United Technologies Corporation, Patent Department, MS 1-1-BC19, One Hamilton Road, Windsor Locks, CT 06096 (US). (81) Designated States: JP, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report.</i>

(54) Title: DUAL-DIRECTIONAL FLOW MEMBRANE SUPPORT FOR WATER ELECTROLYZERS



(57) Abstract

Due to the limited structural integrity of the ion exchange membrane, operation at pressure gradients exceeding about 200 psi can cause electrolyzer failure due to the ion exchange membrane being physically forced into the holes of the screen set forming the chamber on the lower pressure side of the ion exchange membrane. Utilizing a porous sheet (14) between the anode electrode (7) and the screen set (1) provides additional structural integrity to the ion exchange membrane and allows simultaneous dual-directional flow of water to the anode electrode while oxygen flows from the anode electrode, thereby allowing high pressure gradient operation.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	FR	France	MR	Mauritania
AU	Australia	GA	Gabon	MW	Malawi
BB	Barbados	GB	United Kingdom	NL	Netherlands
BE	Belgium	GN	Guinea	NO	Norway
BF	Burkina Faso	GR	Greece	NZ	New Zealand
BG	Bulgaria	HU	Hungary	PL	Poland
BJ	Benin	IE	Ireland	PT	Portugal
BR	Brazil	IT	Italy	RO	Romania
CA	Canada	JP	Japan	RU	Russian Federation
CF	Central African Republic	KP	Democratic People's Republic of Korea	SD	Sudan
CG	Congo	KR	Republic of Korea	SE	Sweden
CH	Switzerland	KZ	Kazakhstan	SK	Slovak Republic
CI	Côte d'Ivoire	LJ	Liechtenstein	SN	Senegal
CM	Cameroon	LK	Sri Lanka	SU	Soviet Union
CS	Czechoslovakia	LU	Luxembourg	TD	Chad
CZ	Czech Republic	MC	Monaco	TG	Togo
DE	Germany	MG	Madagascar	UA	Ukraine
DK	Denmark	ML	Mali	US	United States of America
ES	Spain	MN	Mongolia	VN	Viet Nam
FI	Finland				

Description

Dual-Directional Flow Membrane Support for Water Electrolyzers

Technical Field

5 The present invention relates to water electrolyzers, and especially to water electrolyzers which can operate under high pressure gradients.

Background of the Invention

10 Ion exchange membrane water electrolyzers for producing hydrogen and oxygen from water have been known for more than 20 years. The electrolyzer's components typically include chambers for the introduction of water and the removal of hydrogen, oxygen, and water, an ion exchange membrane disposed between catalyst electrodes,
15 and metal screens which support the ion exchange membrane and form the chambers. Referring to Figure 1 which is illustrative of a common water electrolyzer component arrangement, a first metal screen set 1 which forms the anode chamber is located above the catalytic
20 anode electrode 7 which intimately contacts the ion exchange membrane 5. The opposite side of the ion exchange membrane 5 intimately contacts a catalytic cathode electrode 9, which lies above a second metal screen set 3 which forms the cathode chamber.

25 During operation, water enters the anode chamber formed by the first metal screen set 1. The water passes through the first metal screen set 1 and intimately contacts the anode electrode 7. At the anode electrode 7, electrolysis converts the water to hydrogen
30 ions and oxygen. These hydrogen ions migrate across the ion exchange membrane 5 while the oxygen passes through the first metal screen set 1, enters the water stream, and exits the electrolyzer 10. Once across the ion

- 2 -

exchange membrane 5, the hydrogen ions form molecular hydrogen at the cathode electrode 9 and exit the electrolyzer 10 through the second metal screen set 3. This reaction mechanism is shown in Figure 1, mechanism A.

The metal screens of the water electrolyzer perform numerous functions. Generally, a low pressure gradient is permitted across the ion exchange membrane within the electrolyzer in order to simplify the system pressure controls. Often, up to about 200 pounds per square inch (psi) of pressure exists across the ion exchange membrane during electrolyzer operation. Since the ion exchange membrane possesses low structural integrity, the pressure gradient across the ion exchange membrane can cause failure thereof. Therefore, the metal screens are used to provide structural support to the ion exchange membrane during operation. These metal screens also form flow paths for the water, oxygen, and hydrogen, and they conduct electrons utilized during the water electrolysis to and from the electrodes, into adjacent cells, or to external circuits.

Although a water electrolyzer utilizing the configuration described above forms a performance stable base line cell at 1000 amperes per square foot (ASF) and 120°F, higher pressure differential operation is desired. Operation at higher pressure differentials will simplify the electrolysis process in many ways including simplification or elimination of pressure control equipment and lower pressure components (on one side). However, under increased pressure differentials, the metal screens fail to provide the necessary structural integrity to the ion exchange membrane. At pressure differentials exceeding about 400 psi, the ion exchange membrane can extrude into the metal screen located on the side of the ion exchange membrane having

- 3 -

the lower pressure, thereby causing electrolyzer failure. Referring to Figure 2, operation above about a 10 psi pressure gradient can deform the ion exchange membrane 5 and force it into the metal screen set 1 on the side of the ion exchange membrane 5 having the lower pressure.

What is needed in the art is a water electrolyzer which is capable of operation at high pressure differentials.

10 Disclosure of Invention

The present invention relates to a water electrolyzer. This water electrolyzer comprises an anode electrode, an anode chamber formed by a first screen set superimposed on said anode electrode, a cathode electrode, a cathode chamber formed by a second screen set superimposed on said cathode electrode, an ion exchange membrane disposed between and in intimate contact with said anode electrode and said cathode electrode, and a porous sheet interposed between and in intimate contact with the first screen set and the anode electrode.

The present invention further relates to a method for electrolyzing water using a water electrolyzer. This method includes introducing water to the anode chamber of the electrolyzer. The water passes through pores of the sheet to the anode electrode where it is electrolyzed to oxygen and hydrogen ions. The hydrogen ions migrate across the ion exchange membrane to the cathode electrode where they form molecular hydrogen. This molecular hydrogen exits the electrolyzer through the cathode chamber while the oxygen exits the electrolyzer by passing through the pores of the sheet and then out through the anode chamber.

- 4 -

The foregoing and other features and advantages of the present invention will become more apparent from the following description and accompanying drawings.

Brief Description of the Drawings

5 Figure 1 is an illustration of a basic prior art ion exchange membrane water electrolyzer.

 Figure 2 is an illustration of a basic prior art ion exchange membrane water electrolyzer and the flow path through this electrolyzer.

10 Figure 3 is a water electrolyzer which uses metal screen set to form the anode and the cathode chambers and further uses a fine mesh screen to provide additional support for the ion exchange membrane.

 Figure 4 is one embodiment of the water electrolyzer of the present invention using metal screen sets to form the anode and cathode chambers with a porous sheet located between the anode chamber and the anode electrode.

15 Figure 5 is a graph of the water electrolyzer performance which was realized using various supports including the prior art metal screen, the fine mesh screen, and finally the porous sheet of the present invention.

25 Best Mode for Carrying out the Invention

 The present invention relates to a water electrolyzer capable of operating at ion exchange membrane pressure gradients up to about 2000 psi and greater. The electrolyzer components include metal screens, a porous sheet, an anode electrode, an ion exchange membrane, and a cathode electrode. At pressure
30 gradients exceeding about 200 psi, the ion exchange membrane requires additional support to avoid extruding into the metal screens. The additional ion exchange

- 5 -

membrane support can be provided by employing fine mesh screens and/or porous sheets.

5 The fine mesh screens should be electrically conductive, and therefore are generally metal screens having a mesh size of about 5/0 to about 6/0. Additionally, these fine mesh screens are capable of providing structural integrity to the ion exchange membrane at pressure differentials exceeding about 200 psi, and typically up to about 1000 psi or greater.

10 Some possible fine mesh screens include titanium, zirconium, tantalum, and niobium expanded metal screens produced by X-MET Corporation, Bridgeport, Connecticut, among others. These fine mesh screens typically have a thickness of about 0.05 millimeters (mm) to about 0.3

15 mm. Although thicker fine mesh screens are feasible, they are impractical due to decreased mass transfer rates in these thicker screens.

Even though these fine mesh screens provide structural integrity to the ion exchange membrane, they

20 inhibit the water flow and therefore decrease the electrolyzer efficiency. Figure 3, which is meant to be exemplary, not limiting, explains this phenomenon. At start-up of the electrolyzer 10, water passes through the holes of the metal screen set 1 and the holes of the

25 fine mesh screen 12 to the anode electrode 7 where electrolysis converts the water to hydrogen ions and oxygen. This oxygen then occupies the holes of the fine mesh screen 12, thereby inhibiting the access of additional water to the anode electrode 7. The fine

30 mesh screen 12 allows uni-directional flow, thereby only allowing the flow of the oxygen from the anode electrode 7 through the fine mesh screen 12 to the metal screen set 1 while inhibiting water flow to the anode electrode 7. As a result, water only gains access to the anode

35 electrode 7 after the oxygen has passed through the fine

- 6 -

mesh screen 12 to the metal screen set 1. This inability of the water to reach the anode electrode 7 causes the electrolysis rates and therefore the electrolyzer efficiency to decrease.

5 With the porous sheets, as shown in Figure 4, which is meant to be exemplary, not limiting, oxygen produced at the anode electrode 7 escapes through the pores of the porous sheet 14 while additional water flows to the anode electrode 7 for electrolysis. The porous sheet 14
10 is perforated having multiple-pore sizes. Water wicks from the metal screen set 1, through the porous sheet 14, to the anode electrode 7. On the anode electrode 7, electrolysis converts the water to oxygen and hydrogen ions. This oxygen then passes from the anode electrode
15 7, through the larger pores of the porous sheet 14, to the metal screen set 1. Meanwhile, additional water is wicked through some of the smaller pores of the porous sheet 14 to the anode electrode 7 for additional electrolysis.

20 The porous sheet 14 establishes a simultaneous, dual-directional flow since the smaller pores allow water to be wicked to the anode electrode 7 while the larger pores simultaneously allow oxygen to pass from the anode electrode 7 to the metal screen set 1. As a
25 result, the porous sheet can provide the necessary support for the ion exchange membrane during high pressure gradient operation without compromising the efficiency of the electrolyzer 10.

30 The porous sheet should be composed of an electrically conductive compound capable of being formed into a thin sheet having multiple pore sizes, of allowing simultaneous, dual-directional flow such that the passage of oxygen or hydrogen (depending upon the side of the ion exchange membrane) occurs simultaneously
35 with the passage of water, and of supporting the ion

- 7 -

exchange membrane under high pressure gradient conditions. Additionally, compatibility of the porous sheet with an oxygen and water or hydrogen and water environment is important. Typically, this porous sheet is a metal such as carbon, niobium, tantalum, titanium, zirconium, mixtures thereof, and others. The sheet thickness can range from about 0.127 mm to about 0.635 mm with a thickness of about 0.293 mm to about 0.305 mm preferred. Although thicker membranes provide additional support, they possess lower mass transfer rates and therefore decreased water transport rates and electrolyzer efficiency. The pore size of the porous sheet is dependent upon the size of the molecules which must pass through these pores. Pore sizes ranging from about 10 microns to about 14 microns have proven useful. Since porosities exceeding 60% tend to decrease the strength of the porous sheet and therefore its ability to provide structural integrity to the ion exchange membrane, and since porosities below about 40% inhibit the flow of the water and oxygen or hydrogen to and from the respective electrode, the porosity of the porous sheet typically ranges from about 40% to about 60%.

Since water electrolysis requires the conversion of water to hydrogen ions and oxygen using electricity, the electrical conductivity of the porous sheet is also important. Therefore, the porous sheet electrical conductivity can be improved by electroplating it with a conductive metal. Typically a metal conventionally used to form the anode and cathode electrodes can be utilized for electroplating purposes. A few of the possible electroplating metals include gold, iridium, palladium, platinum, rhodium, ruthenium, and mixtures thereof, among others, with platinum preferred. Generally, the porous sheets are fine spotted using conventional electroplating techniques with about 0.05 milligrams per

- 8 -

square centimeter (mg/cm^2) to about $0.2 \text{ mg}/\text{cm}^2$ of the electroplating metal, with about $0.07 \text{ mg}/\text{cm}^2$ to about $0.12 \text{ mg}/\text{cm}^2$ preferred.

5 These porous sheets can be interposed between the anode electrode, cathode electrode, or both, and the metal screen sets, depending upon where dual-directional flow is needed and the amount of support necessary. For example, submarine electrolyzers preferably utilize the porous sheets interposed between the anode electrode and
10 the metal screen set forming the anode chamber, while aircraft electrolyzers preferably utilize the porous sheets interposed between the cathode electrode and the metal screen set forming the cathode chamber.

15 In the submarine electrolyzer, the ship directly receives low pressure metabolic oxygen from the electrolyzer while the hydrogen is delivered to discharge at sea depth pressure. Therefore, the ion exchange membrane cathode side pressure exceeds the anode side pressure, resulting in a pressure gradient up
20 to about 1,000 psi. If the ion exchange membrane is not supported by the porous sheet, it potentially can be extruded into the metal screen set on the anode side causing ion exchange membrane and electrolyzer failure. On the other hand, in an aircraft 200 psi oxygen
25 recharge system, hydrogen at about 20 psi, reacts with ambient air at altitude pressure (i.e. cabin pressure). Therefore, the ion exchange membrane anode side pressure exceeds the cathode side pressure, resulting in a pressure gradient up to about 2,000 psi. Again, the
30 potential for ion exchange membrane failure is created without porous sheet support of the ion exchange membrane on the cathode side.

35 Beside the fine mesh screens and the porous sheets, the other components of the electrolyzer can be conventional. Conventional anode and cathode electrodes

- 9 -

include metal and metal alloys of noble metals, such as iridium based, palladium based, platinum based, rhodium based, and ruthenium based metals, mixtures thereof, and other catalytic metals known in the art. Conventional electrolyzer ion exchange membranes allow hydrogen ion migration from the anode electrode to the cathode electrode. Typical long life ion exchange membranes are of the perfluorocarbon sulfonic acid type due to their electrochemical stability. One such perfluorocarbon sulfonic acid membrane is Nafion® produced by E.I. duPont de Nemours & Co. (Inc.), Wilmington, Delaware. Similar perfluorocarbon sulfonic acid membranes are produced by Dow Chemical and others.

Conventional metal screens include screens having a thickness and a mesh size determined on the basis of mass flow rates, pressure, and temperature conditions. Typically, these metal screens have a mesh size of about 2/0 to about 6/0, with about 2/0 to about 4/0 preferred. The metal screen thickness typically ranges from about 0.05 mm to about 0.5 mm, with about 0.05 mm to about 0.3 mm preferred.

Operation of one embodiment of the water electrolyzer of the present invention comprises introduction of water to the anode chamber. The water passes through the metal screen set, through the porous sheet, and intimately contacts the anode electrode. On the anode electrode, electrolysis converts the water to hydrogen ions and oxygen. The hydrogen ions migrate across the ion exchange membrane to the cathode electrode, form molecular hydrogen at the cathode electrode, and exit the electrolyzer through the cathode chamber as molecular hydrogen. Meanwhile the oxygen passes from the anode electrode through the larger pores in the porous sheet, through the metal screen set, and exits the electrolyzer as additional water

- 10 -

simultaneously passes through the metal screen set and through the porous sheet to the anode electrode.

It should be noted that one or a plurality of porous sheets can be utilized on one or both sides of the ion exchange membrane depending upon where and the amount of support required. Furthermore, where additional support is needed on both sides of the ion exchange membrane yet only one side of the ion exchange membrane requires dual directional flow, one or a plurality of fine screens can be used with one or a plurality of porous sheets on the respective sides of the ion exchange membrane. Therefore, the arrangement of the electrolyzer could be (referring to Figure 4) metal screen set 1, porous sheet 14, anode electrode 7, ion exchange membrane 5, cathode electrode 9, fine mesh screen 12, second metal screen set 3. This arrangement would allow the dual-directional flow necessary for the passage of water and oxygen and also allow uni-directional flow of the hydrogen while increasing the structural integrity of both sides of the ion exchange membrane.

The advantages of the present invention range from improved structural integrity and the ability to successfully operate under high pressure gradient conditions to improved cell performance under all practical pressure gradient conditions. These pressure gradients include gradients up to about 6000 psi and possibly greater.

Referring to the experimental data in Figure 5, which is meant to be exemplary, not limiting, the difference in performance between an electrolyzer using a metal screen set (Line 3), a fine mesh screen (Line 1), and a porous sheet (Line 2) can be seen. The fine mesh screen electrolyzer performance was significantly poorer than that of the metal screen set electrolyzer.

- 11 -

The fine mesh screen electrolyzer only maintained a cell potential below 2 volts (DC) at a current density below about 250 ASF (Line 1) while the metal screen set electrolyzer maintained a cell potential below 2 volts up to a current density of about 730 ASF to about 830 ASF (Line 3). In contrast, the porous sheet electrolyzer maintained a current density below 2 volts at a higher current density and higher pressure gradient (ΔP) than the metal screen set electrolyzer; a ΔP of 750 psi and a current density of about 1000 ASF at 2 volts (Line 2) versus a ΔP below 200 psi and a current density below about 830 ASF (Line 3), respectively. Note, the fine mesh screen and the porous sheet electrolyzers operated at ΔP of about 750 pounds per square inch (psi) while the metal screen set electrolyzer operated below about 200 psi ΔP .

Successful operation of prior art ion exchange membrane electrolyzers at pressure gradients between about 25 psi and about 200 psi required the use of significant additional pressure control equipment and typically sacrificed electrolyzer performance. The ion exchange membrane electrolyzer of the present invention is capable of operating at pressure gradients up to about 6,000 psi without the use of additional equipment, and without sacrificing electrolyzer performance. Furthermore, the electrolyzer performance of the present invention is superior to that of the prior art over a wide range of pressures and current densities; from about 100 psi to about 3,000 psi and greater, and from about 100 ASF to about 2,000 ASF.

Although this invention has been shown and described with respect to detailed embodiments thereof, it would be understood by those skilled in the art that various changes in form and detail thereof maybe made

- 12 -

without departing from the spirit and scope of the
claimed invention.

We claim:

- 13 -

Claims

1. A water electrolyzer, comprising:
 - a. an anode electrode;
 - b. an anode chamber formed by a first screen set superimposed on said anode electrode;
 - 5 c. a cathode electrode;
 - d. a cathode chamber formed by a second screen set superimposed on said cathode electrode;
 - e. an ion exchange membrane disposed between and in intimate contact with said anode electrode and said cathode electrode; and
 - 10 f. a porous sheet constructed and arranged for dual directional flow and for supporting said ion exchange membrane, said porous sheet interposed between said first screen set and
 - 15 said anode electrode.
2. A water electrolyzer as in Claim 1 further comprising a second porous sheet for supporting said ion exchange membrane interposed between said second screen set and said cathode electrode.
3. A water electrolyzer as in Claim 1 further comprising a fine mesh screen for supporting said ion exchange membrane interposed between said second screen set and said cathode electrode.
4. A water electrolyzer as in Claim 1 wherein said porous sheet is carbon, niobium, tantalum, titanium, zirconium, or mixtures thereof.

- 14 -

5. A water electrolyzer as in Claim 1 wherein said porous sheet has a mean pore size between about 10 microns and about 14 microns and has a porosity between about 40% and about 60%.

6. A water electrolyzer as in Claim 1 wherein said porous sheet is electroplated with platinum.

7. A water electrolyzer, comprising:

- a. an anode electrode;
- b. an anode chamber formed by a first screen set superimposed on said anode electrode;
- 5 c. a cathode electrode;
- d. a cathode chamber formed by a second screen set superimposed on said cathode electrode;
- e. an ion exchange membrane disposed between and in intimate contact with said anode electrode and said cathode electrode;
- 10 f. a porous sheet constructed and arranged for dual directional flow and for supporting said ion exchange membrane, said porous sheet interposed between said second screen set and
- 15 said cathode electrode.

8. A water electrolyzer as in Claim 7 wherein said porous sheet is carbon, niobium, tantalum, titanium, zirconium, or mixtures thereof.

9. A water electrolyzer as in Claim 7 wherein said porous sheet has a mean pore size between about 10 microns and about 14 microns and has a porosity between about 40% and about 60%.

10. A water electrolyzer as in Claim 7 wherein said porous sheet is electroplated with platinum.

- 15 -

11. A water electrolyzer as in Claim 7 further comprising a fine mesh screen for supporting said ion exchange membrane interposed between said anode electrode and said first screen set.

12. A method for electrolyzing water using a water electrolyzer, said electrolyzer having an anode chamber, a cathode chamber, an anode electrode, a cathode electrode, and an ion exchange membrane disposed between the anode electrode and the cathode electrode,
5 comprising the steps of:

- a. introducing water to the anode chamber;
- b. passing said water through pores in a porous sheet interposed between and in intimate
10 contact with the anode chamber and the anode electrode, wherein said porous sheet is constructed and arranged for dual directional flow;
- c. electrolyzing said water to oxygen and
15 hydrogen ions on the anode electrode;
- d. allowing said hydrogen ions to migrate across the ion exchange membrane to the cathode electrode;
- e. forming said hydrogen ions into molecular
20 hydrogen at the cathode electrode;
- f. removing said molecular hydrogen from the electrolyzer through the cathode chamber; and
- g. removing said oxygen from the electrolyzer by
25 passing said oxygen through the pores of said porous sheet and through the anode chamber.

13. A method for electrolyzing water as in Claim 12, further comprising the step of passing said molecular hydrogen through a second porous sheet interposed between the cathode electrode and the cathode chamber.

- 16 -

14. A method for electrolyzing water as in Claim 12, further comprising the step of passing said molecular hydrogen through a fine mesh screen interposed between the cathode electrode and the cathode chamber.

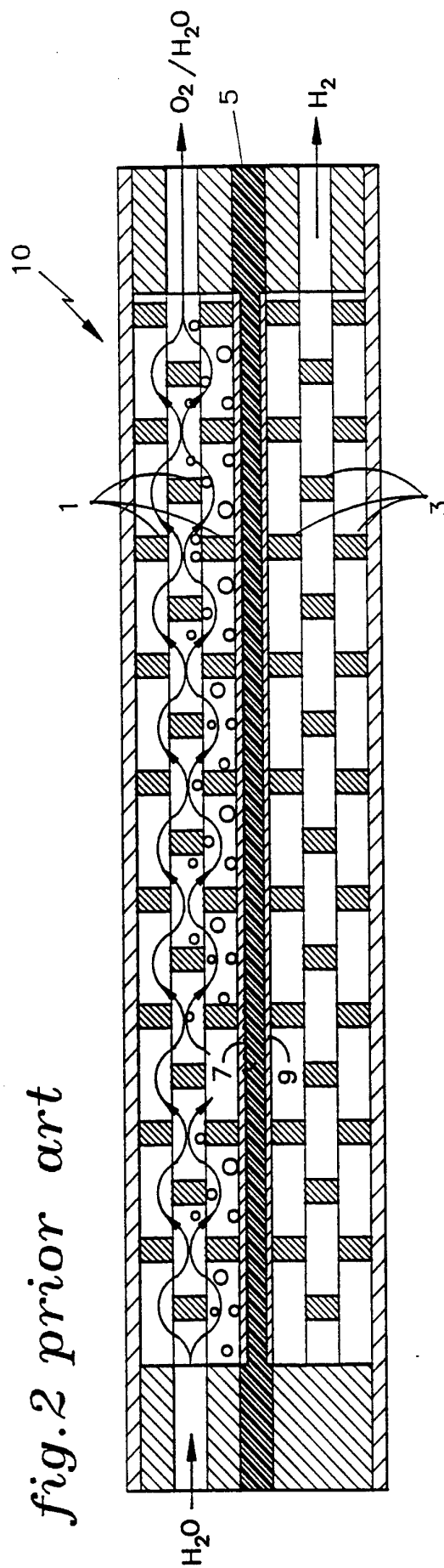
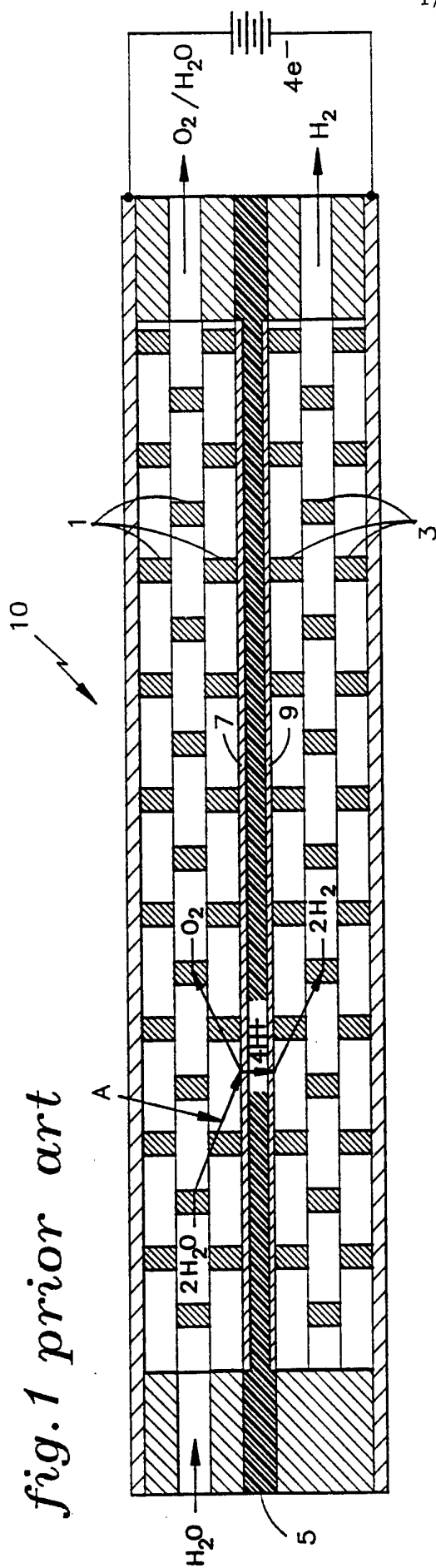
15. A method for electrolyzing water using a water electrolyzer, said electrolyzer having an anode chamber, a cathode chamber, an anode electrode, a cathode electrode, and an ion exchange membrane disposed between the anode electrode and the cathode electrode,
5 comprising the steps of:

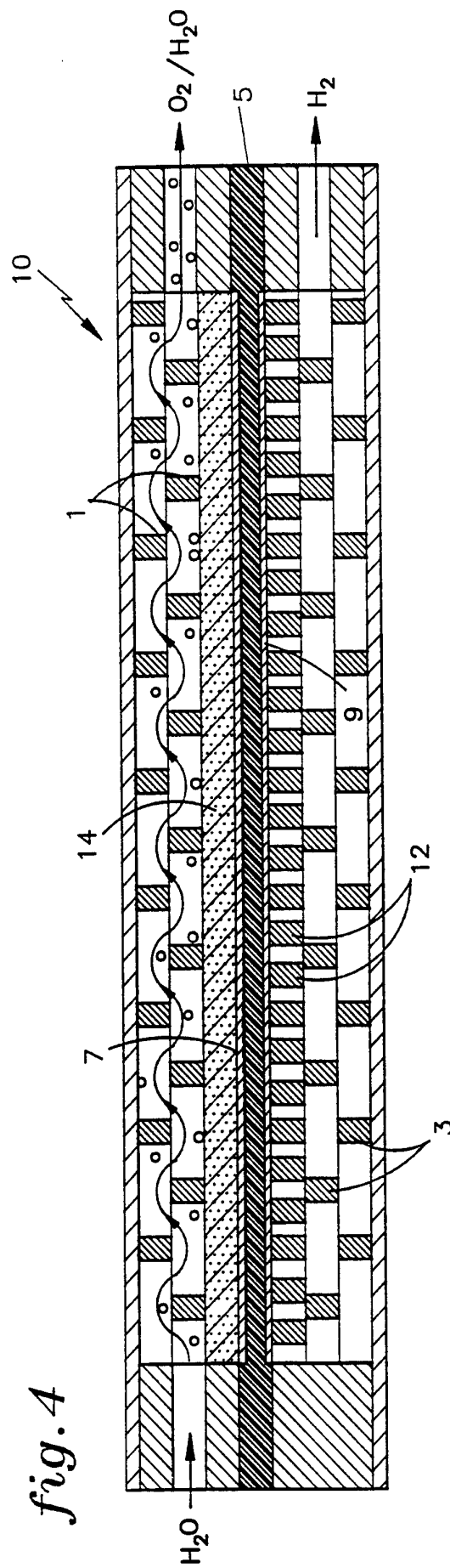
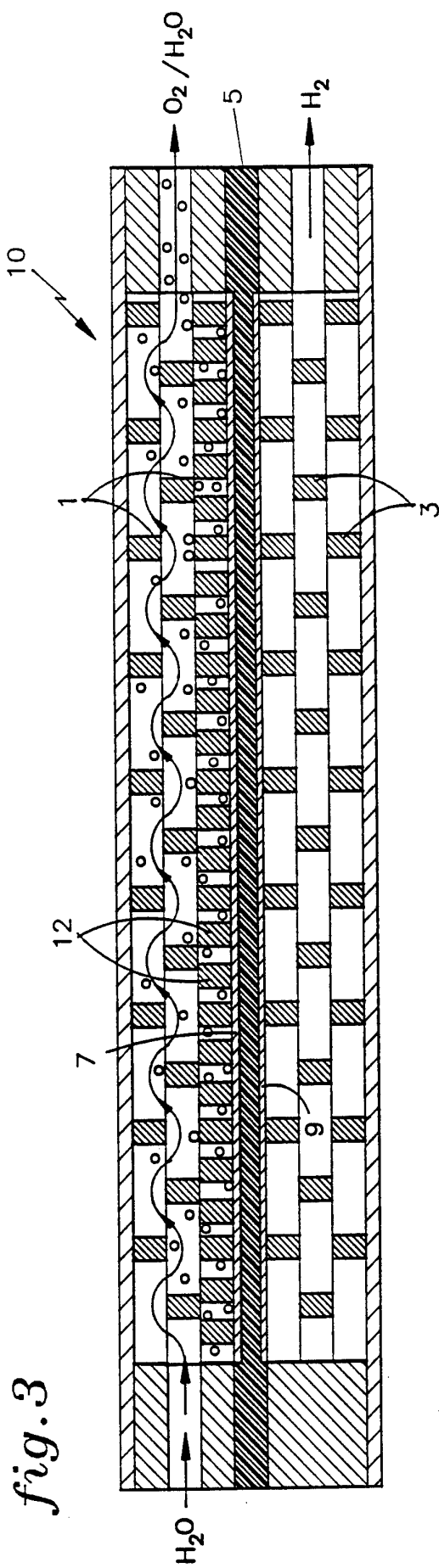
- a. introducing water to the cathode chamber;
- b. passing said water through pores in a porous sheet interposed between and in intimate
10 contact with the cathode chamber and the cathode electrode, wherein said porous sheet is constructed and arranged for dual directional flow;
- c. electrolyzing said water to oxygen ions and
15 hydrogen on the cathode electrode;
- d. allowing said oxygen ions to migrate across the ion exchange membrane to the anode electrode;
- e. forming said oxygen ions into molecular oxygen
20 at the anode electrode;
- f. removing said molecular oxygen from the electrolyzer through the anode chamber; and
- g. removing said hydrogen from the electrolyzer
25 by passing said hydrogen through the pores of said porous sheet and through said cathode chamber.

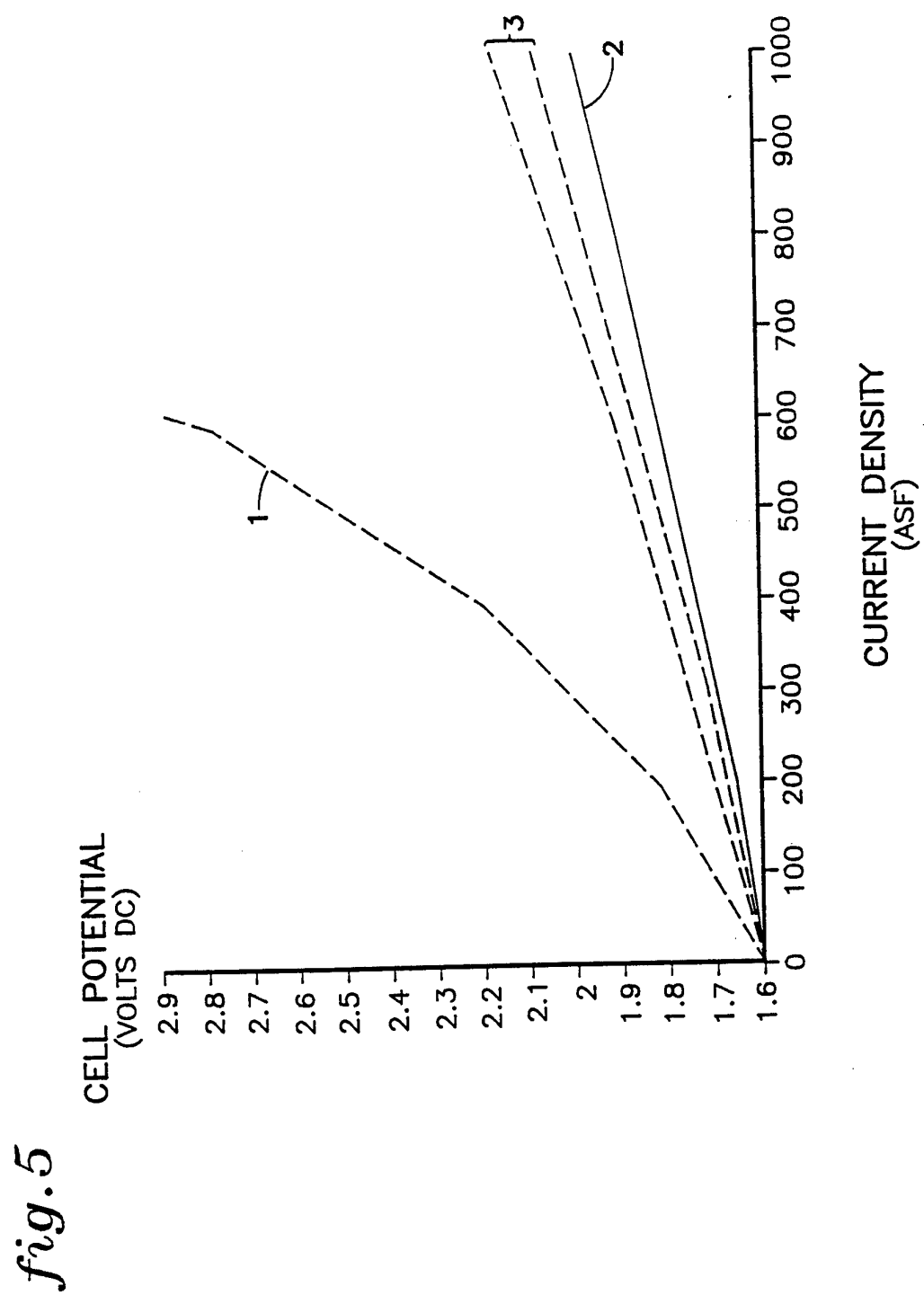
- 17 -

16. A method for electrolyzing water as in Claim 15, further comprising the step of passing said molecular oxygen through a second porous sheet interposed between the anode electrode and the anode chamber.

17. A method for electrolyzing water as in Claim 15, further comprising the step of passing said molecular oxygen through a fine mesh screen interposed between the anode electrode and the anode chamber.







INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 93/04969

I. CLASSIFICATION OF SUBJECT MATTER (If several classification symbols apply, indicate all) ⁶		
According to International Patent Classification (IPC) or to both National Classification and IPC		
Int.Cl. 5 C25B9/00; C25B1/10		
II. FIELDS SEARCHED		
Minimum Documentation Searched ⁷		
Classification System	Classification Symbols	
Int.Cl. 5	C25B	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched ⁸		
III. DOCUMENTS CONSIDERED TO BE RELEVANT⁹		
Category ¹⁰	Citation of Document, ¹¹ with indication, where appropriate, of the relevant passages ¹²	Relevant to Claim No. ¹³
X	FR,A,2 446 868 (BBC) 14 August 1980 see page 1, line 6 - line 12 see page 2, line 1 - line 10 see page 2, line 19 - page 3, line 28 see figure 1 ---	1,2,4,7, 8
X	EP,A,0 031 660 (PERMELEC ELECTRODE) 8 July 1981 see page 4, line 25 - line 34 see page 9, line 6 - line 23 see page 14 - page 16; example 1 see figures 3,4 ---	1-4,7,8, 11
A	EP,A,0 081 251 (ELTECH) 15 June 1983 see page 19, line 12 see page 21, line 2 - line 6 see figure 1 -----	1
¹⁰ Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier document but published on or after the international filing date "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) "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 "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 "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step "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. "&" document member of the same patent family		
IV. CERTIFICATION		
Date of the Actual Completion of the International Search		Date of Mailing of this International Search Report
02 SEPTEMBER 1993		22. 09. 93
International Searching Authority EUROPEAN PATENT OFFICE		Signature of Authorized Officer GROSEILLER P.A.

**ANNEX TO THE INTERNATIONAL SEARCH REPORT
ON INTERNATIONAL PATENT APPLICATION NO.**

US 9304969
SA 75021

This annex lists the patent family members relating to the patent documents cited in the above-mentioned international search report.
The members are as contained in the European Patent Office EDP file on
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information. 02/09/93

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
FR-A-2446868	14-08-80	CH-A- 640005	15-12-83
		CA-A- 1131169	07-09-82
		DE-A, C 2905754	24-07-80
		US-A- 4312736	26-01-82

EP-A-0031660	08-07-81	JP-C- 1375076	22-04-87
		JP-A- 56093883	29-07-81
		JP-B- 61043436	27-09-86
		AU-B- 537960	19-07-84
		AU-A- 6582680	02-07-81
		CA-A- 1282733	09-04-91
		US-A- 4457822	03-07-84
		US-A- 4498942	12-02-85

EP-A-0081251	15-06-83	CA-A- 1207276	08-07-86
		WO-A- 8301630	11-05-83
		US-A- 4545886	08-10-85
