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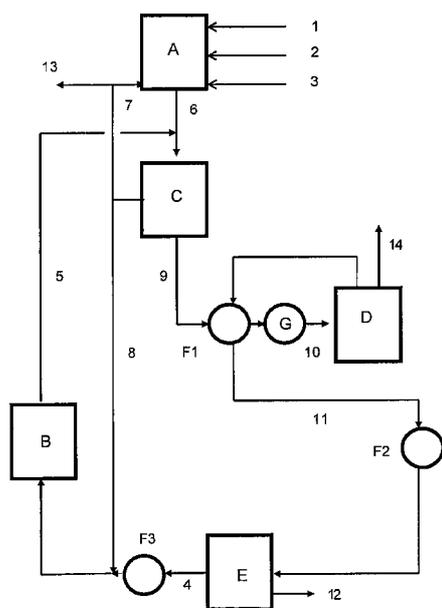
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(54) Title: INTEGRATED PROCESS FOR THE PRODUCTION OF BIO-OIL FROM MICRO-ORGANISMS

Fig. 1



(57) Abstract: The cultivation of heterotrophic and phototrophic micro-organisms is integrated for the production of bio-oil for biofuels, wherein the overall algal suspension produced is first thickened, with recirculation of the excess water to cultivation containers, and then thermally treated at a high temperature. After cooling, a bio-oil phase is recovered together with a suspension rich in soluble carbohydrates and proteins which forms a nutritional/energy source for heterotrophic micro-organisms.

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INTEGRATED PROCESS FOR THE PRODUCTION OF BIO-OIL FROM MICRO-ORGANISMS

The present invention relates to an integrated process for the production of bio-oil from micro-organisms, single or in a consortium.

More specifically, the present invention relates to a process for the production of bio-oil, for biofuels, from biomasses of a microbial origin obtained by integrating a cultivation of phototrophic microalgae with a cultivation of heterotrophic micro-organisms. The biomasses can also be obtained by means of cultivation schemes which include the cooperative use of various microbial forms, of the autotrophic or phototrophic type, for synthesizing the biomass with the use of CO₂ and solar light, and of the heterotrophic type, which grows in the absence of light, using carbohydrates as energy/nutrition source for producing the biomass.

Even more specifically, the present invention relates to a process integration based on a method for the cultivation of microalgae, phototrophs and heterotrophs, suitable for being used in the production of biomasses, preferably in a consortium with micro-organisms, using CO₂, coming from generic combustion plants and/or decarbonization plants of gaseous streams, and generic water, both fresh and salty, in addition to nutriment based on

phosphorous, nitrogen and oligo-elements .

Studies for the growth of microalgae are known, see for example W.J. Oswald, "Journal of Applied Phycology" 15, 99-106, 2003. The existence of different species of
5 microalgae capable of growing in high salinity environments, for example higher than that of the sea, is also known. Cultivations of microalgae generally use fresh or salt water to which nutrients and mineral salts and, when necessary, vitamins have been added, and are effected in
10 bioreactors and/or large-sized ponds, for example from 5 to 100 m long and from 1 to 100 m wide, with a depth ranging from 0.2 to 2 m, possibly under solar irradiation. Carbon dioxide, stored, in liquid or gaseous form, in specific ponds or recovered from exhausted gases of
15 industrial processing, for example from methane/coal electric power stations, decarbonization plants of natural gas or other fuel gases (for example, hydrogen) possibly diluted with air, can also be fed to the ponds together with water. In order to have the maximum avail-
20 ability of CO₂ for microalgae, the gaseous phase is bubbled through the liquid mass using perforated ducts immersed in the growth pond.

The cultivation of microalgae requires few essential components comprising, in addition to an en-
25 ergy/nutritional source, consisting of light and CO₂

and/or carbohydrates and proteins, also, as mentioned above, salts and substances based on nitrogen, phosphorous and oligo-elements .

The biomass obtained from microalgae, cultivated so
5 as to maximize their lipid content, suitably extracted, can be used as raw material for bio-oil to be fed to industrial plants for the production of biofuels. The bio-oil produced from microalgae, therefore offers the advantage of not being in competition with crops for nutri-
10 tional use.

Both phototrophic and heterotrophic microalgae, alone or in a consortium with other micro-organisms, are capable of growing in both fresh water and water having a high salinity, for example brackish water, with a concen-
15 tration of salts even higher than 5 g/l. In natural ecosystems, microalgae often coexist with other micro-organisms (other algae and bacteria, for example) with which they develop interactions which increase the stability and survival of the consortium.

20 The term "microalgae", as used in the present description and claims, refers, also when not specified, to vegetal micro-organisms and phototrophic prokaryotes alone or consortia of micro-organisms, natural or specifically cultivated, which contain the same microalgae.

25 The production of bio-oil from microalgae is advan-

tageous with respect to cultivation from agricultural crops as it allows a greater production of oil per hectare of surface per year. Microalgae which can be used for the production of bio-oil can be of the phototrophic
5 type which use solar light and CO₂ as energy source, or of the heterotrophic type which use a carbon source, such as carbohydrates and/or proteins, in the absence of light.

A disadvantage of phototrophic microalgae is that
10 they grow with a low density. As the aqueous suspension becomes more opaque and therefore less transparent to light, with an increase in the concentration of the algal mass, in fact, the growth diminishes until it stops above a certain concentration. The necessity of favouring the
15 penetration of light also limits the maximum depth of the ponds to a few tens of centimeters .

The low concentration of the algal mass, per litre of aqueous suspension, and the low depth of the ponds involve the use of large volumes of water and relatively
20 extensive surfaces and therefore high costs and energy consumptions for the separation and extraction of the bio-oil or, alternatively, relatively low productive yields to bio-oil.

Heterotrophic microalgae, also in consortium with
25 other micro-organisms, do not use light for the produc-

tion of algal biomass and consequently their concentration in the aqueous medium does not suffer from the light penetration limit in the growth medium. As they grow in the dark, on the other hand, they require an energy and
5 carbon source alternative to light and CO₂. This source is based on carbohydrates and possibly proteins, not always easily available at competitive costs.

The Applicant has now found a process for the production of bio-oil from algal masses, to be used for the
10 production of biofuels, which is able to combine the advantages of both phototrophic and heterotrophic microorganism production, overcoming the relative disadvantages. The present invention is based on the principle according to which phototrophic microalgae produce an algal biomass, using light and carbon dioxide, from which
15 bio-oil can be separated together with an aqueous suspension consisting of polysaccharides and protein aggregates. For the extraction of the bio-oil, the biomass is conveniently subjected to a hydrothermal treatment which
20 promotes the separation of the oil phase and the transformation of the polysaccharides and protein aggregates into carbohydrates and simple proteins, which can be more easily used for feeding and growing biomass from heterotrophic microalgae, which are also producers of bio-oil.

25 As heterotrophic microalgae can reach very high con-

centrations in the growth water, with the present invention, it is possible to produce bio-oil from microalgae using a much lower overall quantity of water than that which would be used with the cultivation of phototrophic
5 microalgae alone. A second advantage of the present invention is that it requires a lower cultivation surface with respect to the use of phototrophic microalgae alone with the same production of bio-oil.

An object of the present invention therefore relates
10 to an integrated process for the production of bio-oil from micro-organisms, both phototrophic and heterotrophic, which comprises:

- a. growing at least one phototrophic microalga, possibly in consortium with other micro-organisms, in
15 specific ponds/containers containing water and nutrients and a device suitable for distributing carbon dioxide in the form of micro-bubbles in the water mass;
- b. growing at least one heterotrophic microalga, possibly in consortium with other micro-organisms, in
20 specific ponds/containers containing water and nutrients in the presence of carbohydrates and/or proteins transported by a suspension coming from a hydrothermal treatment of a biomass;
- 25 c. recovering the biomass developed (at the end of the

growth) , obtained from phototrophic and heterotrophic cultures, with its growth water, and subjecting the overall suspension thus obtained to thickening, up to at least 5% by weight, in a specific section;

- d. subjecting the thickened suspension to thermal treatment, at a temperature ranging from 80 to 350⁰C and a pressure of 0.1 to 25 MPa, for a time greater than or equal to 1 minute ;
- 10 e. recovering, after cooling the thickened thermally treated suspension, an oil fraction sent to treatment suitable for producing biofuels, for example hydrogenation and/or transesterification treatment; and
- 15 f. feeding the remaining aqueous suspension, rich in hydrosoluble carbohydrates and proteins assimilable by heterotrophic microalgae, to step (b) .

According to the present invention, the phototrophic and heterotrophic micro-organisms are cultivated in ponds/containers having large dimensions, for example 20 ponds/containers having large dimensions, for example from 5 to 100 m in length and from 1 to 100 m in width, with depths greater than 0.2 m and preferably ranging from 0.5 to 10 m , maintained under solar irradiation, necessary for phototrophic microalgae, or in the dark, by 25 means of appropriate covers, necessary for heterotrophic

microalgae. Alternatively, the heterotrophic microalgae are grown in closed containers.

In the case of phototrophic microalgae, photobioreactors can also be used.

5 The water necessary for the growth of the microalgae, of both species, can be fresh water or salt water coming from natural or artificial sources, for example from industrial processings .

Examples of phototrophic microalgae can be selected
10 from types such as *Tetraselmis*, *Nannochloropsis* ,
Scenedesmus, *Ankistrodesmus* , *Phaeodactylum*, *Chlorella*,
Amphipleura, *Amphora*, *Chaetoceros*, *Cyclotella*, *Cymbella*,
Fragilaria, *Navicula*, *Nitzschia*, *Achnantes*, *Dunaliella*,
Oscillatoria, *Porphyridium* or combinations thereof.

15 Examples of heterotrophic microalgae can be selected
from *Chlorella*, *Nannochloropsis*, *Nitzschia*, *Thraustochytrium* or combinations thereof, possibly in consortium
with bacteria such as, for example, strains belonging to
the species *alpha-Proteobacteria*, *beta-Protobacteria*, *Ac-*
20 *tinobacteria*, *Firmicutes* , *Flavobacteria-Cytophaga* .

The salt water can be seawater or of the brackish
type, either natural or artificial, also with a saline
concentration, for example ranging from 5 to 350 g/litre.
An example of brackish water, which can be used in the
25 process, object of the present invention, is water coming

from oil production fields.

In particular, the oil production fields in the North-African region are situated in a context with high solar irradiation, in desert areas which cannot be used
5 for food crops and have a high coproduction of water which generally has a volume several times higher than the corresponding oil production.

If necessary, it is possible to favour algal growth, or the growth of the algal consortium, by feeding nutrients based on carbohydrates, proteins, nitrogen, phosphorous, oligo-elements, etc., when these are not already
10 present in water. In general, solutions of various types of carbohydrates are fed such as, for example, acetate, glucose, glycine to favour growth in heterotrophy, in addition to organic and/or inorganic salts soluble in water,
15 such as for example, ammonium salts and phosphates of alkaline or alkaline earth metals, for example sodium, potassium, calcium, magnesium phosphates, or ammonium phosphates. Finally, in the case of phototrophic microalgae,
20 a stream of carbon dioxide, as carbon source, is fed to the water, in addition to the salts of N and P and oligo-elements, through specific distributors which are deposited on the bottom of the cultivation ponds or suitably inserted in the growth containers (photo-
25 bioreactors) .

When the micro-organisms, both phototrophic or heterotrophic, reach maturity, they are discharged from the growth ponds/containers together with the growth water and sent to a thickening phase. In this phase, the concentration of the algal suspension is brought to values ranging from 5 to 30% by weight, preferably from 18 to 25% by weight, by means of techniques such as sedimentation, decanting, flocculation, filtration, etc. The excess water is recycled to the ponds/containers of both the phototrophic microalgae and heterotrophic microalgae, whereas the concentrated suspension is fed to a hydrothermal treatment for the production of bio-oil and an aqueous solution of nutrients .

The thermal treatment (hydrothermal treatment) comprises heating the suspension of concentrated biomass in a container, under pressure, to a temperature ranging from 80 to 350 °C, preferably from 150 to 330 °C. The pressure is maintained at such values as to keep at least part of the water in the liquid state. The pressure can be maintained, for example, at between 0.1 and 25 MPa, preferably from 0.5 to 18 MPa.

Considering that the thermal energy necessary for the thermal treatment can derive from the combustion of traditional energy vectors, for example methane gas, LPG, mineral oil, coal, etc. it is not excluded that the ther-

mal energy can derive from solar energy and/or Solar Pond, above all in desert areas close to equatorial regions .

During the thermal or hydrothermal treatment phase,
5 the breakage of the cell membranes and separation of the oil phase are effected. Furthermore, the polysaccharides and protein material are partially converted to bio-oil whereas the remaining part is hydrolyzed producing gluco-
10 side and protein fractions soluble in water and easily assimilable as nutrition by both heterotrophic microalgae and micro-organisms which live with them in consortium. Consequently, at the end of the thermal treatment, which has a duration equal to or higher than 1 minute, for example from 0.5 to 2 hours, the residual biomass is cooled
15 to a temperature ranging from 45 to 80°C and fed to a separation/recovery section of the bio-oil, by means of known techniques and devices such as, for example, a static separator.

The aqueous suspension separated is possibly further
20 cooled to a temperature ranging from room temperature to 50°C and sent to the cultivation section of the heterotrophic micro-organisms.

During the thermal treatment, a gaseous phase is also formed equal to about 10-25% by weight of the bio-
25 mass (referring to the dry product) subjected to thermal

treatment and essentially consisting of carbon dioxide, for example about 80-90% by volume, and C₁-C₃ hydrocarbons, for the remaining 10-20%. This gaseous phase is preferably separated, during the recovery phase of the
5 bio-oil, and used as supplementary source of carbon dioxide for the growth of the phototrophic microalgae and upgraded in its hydrocarbon component as fuel gas.

At the end of the growth of the heterotrophic microalgae, possibly in a consortium, the latter are discharged from the cultivation ponds/containers, with the
10 growth water, and the whole mixture is combined with the flow coming from the cultivation of phototrophic microalgae to be thickened.

For a better understanding of the present invention, reference can be made to the scheme of the enclosed Figure and quantification sheet of the process which are introduced into the description for purely illustrative and
15 non-limiting purposes.

According to the enclosed scheme, A represents the cultivation ponds/containers of the phototrophic microalgae and B the cultivation ponds/containers of the heterotrophic microalgae. C represents a thickening section of the suspension comprising the algal mass, produced both
20 in A and B, and the recycled aqueous suspension.

25 D is a pressurized container, E is a separator, F1,

F2 and F3 are heat exchange sections and **G (in bold)** is a heat generator.

The cultivation ponds A produce a phototrophic microalga, which grows for example in seawater. Make-up water, CO₂ and nutrients, for example soluble ammonium and phosphorous salts, reach these ponds, through lines (1), (2) and (3) respectively.

In the same way, the containers B produce a heterotrophic microalga, which also grows in seawater. An aqueous suspension, rich in carbohydrates and/or proteins soluble in water, a residue of the hydrothermal treatment in D, reach the containers B, through line 4.

When the microalgae, both phototrophic and heterotrophic, reach maturity, they are collected by completely or partially emptying the respective cultivation containers and sent, through lines (5) and (6), to a thickening area C where they are concentrated to give a suspension, for example 20% by weight. The excess water is recycled to the containers A and B through lines (7) and (8) respectively.

The thickened suspension (9) is preheated in F1, possibly brought to temperature in G, then fed to the pressurized container D, through (10). In D, the suspension is brought to the temperature and pressure conditions and residence times which allow a bio-oil to be ob-

tained, which is suitable for being transformed into bio-fuel, and producing an optimum aqueous phase for its subsequent use as a source of nutrients/energy for the growth of heterotrophic micro-organisms. During the thermal treatment, a gaseous phase (14), essentially consisting of CO₂ and C₁-C₃ gaseous hydrocarbons, is produced, which can be recycled to the system or sent to treatment sections .

For this reason, the residual degraded algal mass is discharged from the container D, through (11), and the whole mixture (residual mass + suspension water) is cooled in F1 and subsequently in F2. The bio-oil is then recovered in the separator E, which can be sent, by means of (12), to the subsequent processing phases to transform it into biofuel by means of treatment, for example hydrogenation and/or esterification (not illustrated in the Figure), whereas the residual aqueous suspension, rich in hydrosoluble carbohydrates and proteins, is fed, after possible further cooling in F3 and through (4), to the cultivation containers B of the heterotrophic microalgae.

As the production cycle is subject to the possible accumulation of salts and organic substances, a purging (13) can be envisaged, which allows the levels of these products to be kept within the management limits of the production plant.

Again for illustrative and non-limiting purposes, an applicative example is provided hereunder.

EXAMPLE

Cultivation ponds with seawater are used, with a total surface, for phototrophic microalgae, of about 377 hectares, 30 cm deep.

The phototrophic microalga is *Nannochloropsis*.

Cultivation ponds with seawater with a total surface area, for heterotrophic microalgae, of about 8 hectares, 1 m deep, are used.

The heterotrophic microalga is a heterotrophic strain belonging to the genus *Nannochloropsis*.

The following products are fed to the pond A, under regime conditions:

- (1) make-up water: 1,500 t/h (to compensate the water lost in the purging and by evaporation) ;
- (2) CO₂: 8.5 t/h;
- (3) sodium nitrate and sodium phosphate, to maintain a concentration of 200 and 20 ppm, respectively;
- (7) recycled water.

When the phototrophic microalga has matured, approximately 9,450 t/h (6) of a suspension at 0.05% by weight of microalgae in water fed to the thickening area (decanting) c, are discharged from the ponds A. The stream (5), coming from the cultivation containers B of

the heterotrophic microalga, consisting of 500 t/h of a suspension at 0.5% by weight of heterotrophic micro-organisms, reaches the same thickening area.

Approximately 20% by weight is thickened in c. 36
5 t/h of aqueous suspension at 20% approximately by weight, are continuously removed (9) from this area, preheated in F1 to 150⁰c, brought to 300⁰C and 12 MPa in G, fed to D and maintained under these conditions for 1 hour.

The water discharged from the thickening is respec-
10 tively recycled to A, 9170 t/h by means of (7), after purging equal to 260 t/h to keep the salinity constant, and in B, 470 t/h through (8).

The biomass thermally treated in D is cooled in F1 and F2 and transported to the separator E. 2.5 t/h of
15 bio-oil (12) are recovered from this, together with 1.5 t/h of gas and 32 t/h of an aqueous suspension (4) fed to the closed containers B of the heterotrophic microalgae, after dilution with the stream (8).

The use of the scheme, object of the present inven-
20 tion, allowed the specific productivity of about 20,000 ton/year of bio-oil to be reached, using an overall surface of 385 hectares and with a volume of make-up water equal to about 12,000,000 ton/year.

For the same production of bio-oil, using the tech-
25 nology based on phototrophic micro-organisms alone, cul-

tivation ponds for 755 hectares and 24,000,000 ton/year of make-up water would have been necessary.

CLAIMS

1. Integrated process for producing bio-oil from micro-organisms, both phototrophic and heterotrophic, comprising:
- 5 a. growing at least one phototrophic microalga, in dedicated ponds/containers containing water and nutrients and a device adapted to distribute carbon dioxide in the water mass;
- b. growing at least one heterotrophic microalga, possibly
10 in consortium with other microorganisms, in dedicated ponds/containers containing water and nutrients in presence of carbohydrates and/or proteins transported by a suspension coming from a hydrothermal treatment of a biomass;
- 15 c. recovering the developed biomass, both phototrophic and heterotrophic, with its growth water, and subjecting the global suspension thus obtained to thickening, at least up to 5% by weight, in a dedicated section;
- d. subjecting to thermal treatment, at a temperature in
20 the range of 80 to 350⁰C and pressure in the range of 0.1 to 25 MPa, the thickened suspension for a period of time greater than or equivalent to 1 minute;
- e. recovering, after cooling the thermally treated thickened suspension, an oil fraction adapted to be trans-
25 formed into bio-fuel; and

f. supplying the resulting aqueous suspension, rich in carbohydrates and proteins, assimilable by the heterotrophic microalgae, to stage (b) .

2. Process according to claim 1, wherein the growth water
5 of the phototrophic and heterotrophic microalgae is fresh or salty water, of natural or artificial origin.

3. Process according to claim 2, wherein the growth water is brackish water with concentration of salts in the range of 5 to 350 g/l.

10 4. Process according to claim 3, wherein the growth water is sea water or brackish water associated to the wells for producing natural gas/oil.

5. Process according to any one of the preceding claims, wherein the algae suspension is thickened to values in
15 the range 5 to 30 % by weight, preferably in the range of 18 to 25% by weight.

6. Process according to any one of the preceding claims, wherein the excess water coming from the thickening section is recycled both to the ponds/containers of the photo-
20 totrophic and heterotrophic microalgae.

7. Process according to any one of the preceding claims, wherein the thermal treatment is performed at a temperature in the range of 150 to 330⁰c, at a pressure in the range of 0.5 to 18 MPa and for periods of time in the
25 range of 0.5 to 2 hours.

8. Process according to any one of the preceding claims, wherein the thermal energy required for the thermal treatment derives from solar energy and/or from "solar pond" .

5

Fig. 1

