

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization

International Bureau



(43) International Publication Date
4 February 2010 (04.02.2010)

(10) International Publication Number
WO 2010/012677 A1

(51) International Patent Classification:

B01D 53/94 (2006.01) *B01J 37/02* (2006.01)
B01J 23/63 (2006.01) *F01N 3/08* (2006.01)
B01J 35/04 (2006.01)

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PE, PG, PH, PL, PT, RO, RS, RU, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(21) International Application Number:

PCT/EP2009/059645

(22) International Filing Date:

27 July 2009 (27.07.2009)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

08161545.2 31 July 2008 (31.07.2008) EP

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(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

— with international search report (Art. 21(3))



WO 2010/012677 A1

(54) Title: NO_x STORAGE MATERIALS AND TRAPS RESISTANT TO THERMAL AGING

(57) Abstract: Nitrogen oxide storage catalysts comprising a substrate and at least two coating layers, where the second layer is substantially free of platinum, cerium and barium, and methods of manufacturing and using these nitrogen oxide storage catalysts are disclosed.

NO_x Storage Materials and Traps Resistant to Thermal Aging

TECHNICAL FIELD

5 Embodiments of the invention relate to nitrogen oxide storage materials and methods for their manufacture. More particularly, embodiments of the invention pertain to NO_x storage materials that are resistant to thermal aging and methods of making such materials. The nitrogen oxide storage materials may be part of a catalytic trap used to treat exhaust gas streams, especially those emanating from lean-burn gasoline or die-
10 sel engines.

BACKGROUND

15 Emission of nitrogen oxides ("NO_x") from lean-burn engines (described below) must be reduced in order to meet emission regulation standards. Conventional three-way conversion ("TWC") automotive catalysts are suitable for abating NO_x, carbon monoxide ("CO") and hydrocarbon ("HC") pollutants in the exhaust of engines operated at or near stoichiometric air/fuel conditions. The precise proportion of air to fuel which results in stoichiometric conditions varies with the relative proportions of carbon and hydrogen in
20 the fuel. An air-to-fuel ("A/F") ratio of 14.65:1 (weight of air to weight of fuel) is the stoichiometric ratio corresponding to the combustion of a hydrocarbon fuel, such as gasoline, with an average formula CH_{1.88}. The symbol λ is thus used to represent the result of dividing a particular A/F ratio by the stoichiometric A/F ratio for a given fuel, so that; $\lambda=1$ is a stoichiometric mixture, $\lambda>1$ is a fuel-lean mixture and $\lambda<1$ is a fuel-rich
25 mixture.

30 Engines, especially gasoline-fueled engines to be used for passenger automobiles and the like, are being designed to operate under lean conditions as a fuel economy measure. Such engines are referred to as "lean-burn engines". That is, the ratio of air to fuel in the combustion mixtures supplied to such engines is maintained considerably above the stoichiometric ratio (e.g., at an air-to-fuel weight ratio of 18:1) so that the resulting exhaust gases are "lean", i.e., the exhaust gases are relatively high in oxygen content.

35 Although lean-burn engines provide enhanced fuel economy, they have the disadvantage that conventional TWC catalysts are not effective for reducing NO_x emissions from such engines because of excessive oxygen in the exhaust. Attempts to overcome this problem have included operating lean-burn engines with brief periods of fuel-rich operation (engines which operate in this fashion are sometimes referred to as "partial
40 lean-burn engines"). The exhaust of such engines is treated with a catalyst/NO_x sorbent which stores NO_x during periods of lean (oxygen-rich) operation, and releases the

stored NO_x during the rich (fuel-rich) periods of operation. During periods of rich (or stoichiometric) operation, the catalyst component of the catalyst/NO_x sorbent promotes the reduction of NO_x to nitrogen by reaction of NO_x (including NO_x released from the NO_x sorbent) with HC, CO and/or hydrogen present in the exhaust.

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Diesel engines provide better fuel economy than gasoline engines and normally operate 100% of the time under lean conditions, where the reduction of NO_x is difficult due to the presence of excess oxygen. In this case, the catalyst/NO_x sorbent is effective for storing NO_x. As in the case of the gasoline partial lean burn application, after the NO_x storage mode, a transient rich condition must be utilized to release / reduce the stored NO_x to nitrogen. In the case of the diesel engine, this transient reducing condition will require unique engine calibration or injection of a diesel fuel into the exhaust to create the next reducing environment.

10 NO_x storage (sorbent) components including alkaline earth metal compounds, for example oxides, such as oxides of Mg, Ca, Sr and Ba, alkali metal oxides such as oxides of Li, Na, K, Rb and Cs, and rare earth metal compounds, for example, oxides such as oxides of Ce, La, Pr and Nd in combination with precious metal catalysts such as platinum dispersed on an alumina support have been used in the purification of exhaust gas from an internal combustion engine. It is known that in air, these materials are mostly present in the form of carbonates and hydroxides, and these compounds are suitable for storing NO_x. At high temperatures, the metal carbonates and hydroxides form metal oxides. Thus, as used in this specification, NO_x storage "oxides" are intended to include the corresponding carbonates and hydroxides. For NO_x storage, 15 barium oxide (baria) is usually preferred because it forms nitrates at lean engine operation and releases the nitrates relatively easily under rich conditions. However, catalysts that use baria for NO_x storage exhibit a problem in practical application, particularly when the catalysts are aged by exposure to high temperatures and lean operating conditions. After such exposure, such catalysts show a marked decrease in catalytic activity for NO_x reduction, particularly at low temperature (200 to 350°C) and high temperature (450°C to 600°C) operating conditions. In addition, NO_x absorbents that include baria suffer from the disadvantage that when exposed to temperatures above 450°C in the presence of CO₂, barium carbonate forms, which becomes more stable than barium nitrate. Furthermore, barium tends to sinter and to form composite compounds with 20 support materials, which leads to the loss of NO_x storage capacity.

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NO_x storage materials comprising barium fixed to ceria particles have been reported, and these NO_x materials have exhibited improved thermal aging properties compared to the catalyst materials described above. Despite these improvements, there is an ongoing need to improve the performance of NO_x storage materials, particularly the ability of these materials to operate over a wide temperature range and to operate ef- 40

fectively after exposure to high temperature. It is also desirable to improve the kinetics of NO_x oxidation (required in advance of NO_x storage) and the kinetics of NO_x reduction (required following NO_x release). Thus, there is a need to provide improved NO_x storage materials and methods for their manufacture.

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SUMMARY

Aspects of the invention include nitrogen oxide storage materials, catalysts in the form of catalytic traps for the abatement of nitrogen oxide, methods for manufacturing both the 10 nitrogen oxide storage materials and the catalytic traps for the abatement of nitrogen oxides, and methods of abating nitrogen oxide in an exhaust gas stream.

One or more embodiments of the invention are directed to a nitrogen oxide storage catalyst comprising a substrate and at least two layers, in particular washcoat layers.

15 According to one or more embodiments, a second washcoat layer containing rhodium or palladium does not contain platinum, cerium or barium to prevent detrimental interactions of rhodium or palladium with platinum, cerium or barium. In one embodiment, the first washcoat layer comprises a nitrogen oxide storage material comprising metal oxide support particles having a metal compound selected from an alkaline earth metal 20 compound, an alkali metal compound and a rare earth metal compound supported on the metal oxide support particles. The alkaline earth metal compound, the alkali metal compound and the rare earth metal compound may be present in the form of oxides, hydroxide or carbonates. The second washcoat layer comprises a single precious metal. The second washcoat layer may be substantially free of platinum, cerium and 25 barium.

The second washcoat layer of other embodiments comprises rhodium or palladium and is substantially free of platinum. In other embodiments, the second washcoat layer comprises substantially only rhodium supported on refractory metal oxide particles.

30 The refractory metal oxide of some embodiments comprises alumina doped with up to 30% zirconia.

The first washcoat layer of various embodiments may comprise at least one platinum group metals selected from the group consisting of platinum, palladium, rhodium, iridium and mixtures thereof supported on refractory oxide particles. Further embodiments 35 may have baria in the first washcoat layer.

The substrate of one or more embodiments comprises a honeycomb substrate comprising a plurality of longitudinally extending passages formed by longitudinally extending 40 walls bounding and defining said passages, the passages comprising inlet pas-

sages having an open inlet end and closed outlet end, and outlet passages having a closed inlet end and an open outlet end.

5 The nitrogen oxide storage catalyst of some embodiments has a second washcoat layer with a total loading of from 0.05 to 5 g/in³ and is less than the loading of the first washcoat layer. In other embodiments, the first washcoat layer may comprise ceria and barium carbonate in a ratio of from 1:3 to 1:10.

10 Additional embodiments of the invention are directed to treatment systems for an automobile exhaust gas stream. The treatment system of some of these embodiments comprises a combustion engine which operates periodically between lean and rich conditions, an exhaust gas conduit in communication with the engine, and a nitrogen oxide storage catalyst as described above disposed within the exhaust gas conduit.

15 Further embodiments of the invention are directed to methods of making a nitrogen oxide storage catalyst. The methods include applying a bottom washcoat to a substrate, the bottom washcoat comprising ceria, baria and at least one precious metal. A top washcoat is applied over the bottom washcoat, the top washcoat comprising at least one, preferably exactly one, i.e. a single precious metal, wherein the top washcoat 20 is substantially free of cerium and barium.

25 The bottom washcoat of some embodiments is prepared by mixing a first solution of a barium compound with ceria particles to provide a first mixture. At least one precious metal is impregnated into alumina. A solution of a zirconium salt is added to the precious metal impregnated alumina, thereby providing a slurry and milling the slurry. The first mixture is added to the slurry and milled again. The substrate is washcoated with the slurry. A top washcoat is prepared by making a slurry comprising a precious metal impregnated alumina. Milling the slurry and washcoat layer the substrate with the milled slurry to create a top washcoat over the bottom washcoat.

30 In one embodiment, the alumina in the top washcoat slurry is doped with up to 30% zirconium oxide, preferably from 5 to 30%, more preferably from 5 to 25%, more preferably from 5 to 20%, and still more preferably from 5 to 15%. The loading of the top washcoat is up to 5 g/in³, preferably from 0.05 to 5 g/in³, more preferably from 0.05 to 4 g/in³, more preferably from 0.05 to 3 g/in³, more preferably from 0.05 to 2 g/in³, and still more preferably from 0.1 to 1 g/in³, and is less than the loading of the bottom washcoat. The bottom washcoat of various embodiments comprises ceria and barium carbonate in a ratio of from 1:3 to 1:10.

40 Still further embodiments are directed to a method of treating an automobile exhaust gas stream. These methods comprise passing the exhaust gas across a nitrogen ox-

ide storage catalyst having at least a bilayer structure, with at least a bottom layer and a top layer, wherein the bottom layer comprises ceria particles having an alkaline earth metal compound supported on the particles and the top layer comprises a single precious metal and is substantially free of cerium and barium.

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BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a graph comparing the percent NO_x conversion as a function of temperature for various catalysts; in Fig. 1, "E2" stands for "Example 2", "E3" stands for "Example 3", and "CE1" stands for "Comparative Example 1". "T" denotes the temperature in °C, and "NOxC" stands for "NOx Conversion" (in %).

Fig. 2 is a graph comparing the NO_x storage at 85% efficiency as a function of temperature for various catalysts; in Fig. 2, "E2" stands for "Example 2", "E3" stands for "Example 3", and "CE1" stands for "Comparative Example 1". "T" denotes the temperature in °C, and "NOxS" stands for "NOx Storage at 85% Efficiency" (in g/L).

Fig. 3 is a graph comparing the NO_x storage at 85% efficiency as a function of temperature for various catalysts; in Fig. 3, "E2" stands for "Example 2", and "CE1" stands for "Comparative Example 1". "T" denotes the temperature in °C, and "NOxS" stands for "NOx Storage at 85% Efficiency" (in g/L).

Fig. 4 is a graph comparing the percent NO_x conversion as a function of temperature for various catalysts; in Fig. 4, "E5" stands for "Example 5", "E2" stands for "Example 2", and "CE4" stands for "Comparative Example 4". "T" denotes the bed temperature in °C, and "NOxC" stands for "NOx Conversion" (in %).

Fig. 5 is a graph comparing the NO_x storage at 85% efficiency as a function of temperature for various catalysts; in Fig. 5, "E5" stands for "Example 5", "E2" stands for "Example 2", and "CE4" stands for "Comparative Example 4". "T" denotes the bed temperature in °C, and "NOxS" stands for "NOx Storage at 85% Efficiency" (in g/L).

35 DETAILED DESCRIPTION

Before describing several exemplary embodiments of the invention, it is to be understood that the invention is not limited to the details of construction or process steps set forth in the following description. The invention is capable of other embodiments and of 40 being practiced or being carried out in various ways.

As used in this specification and the appended claims, the singular forms "a", "an" and "the" include plural referents unless the context clearly indicates otherwise. Thus, for example, reference to "a precious metal" includes a combination of two or more precious metals, and the like.

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According to one or more embodiments of the present invention, a second coating layer applied over a first coating containing NO_x storage materials is provided. The second coating layer contains a single precious metal, and is free of platinum, cerium and barium to prevent detrimental interaction of rhodium or palladium precious metals with cerium, barium and platinum. In one specific embodiment of the invention, a NO_x storage material comprises a metal compound selected from an alkali metal compound, an alkaline earth metal compound, and a rare earth metal compound. The metal compound may be in an oxide, hydroxide, or carbonate form. In one embodiment, the metal compound is in carbonate form or a mixture of carbonates, for example, BaCO₃ or mixtures of BaCO₃ and MgCO₃ supported on a suitable support particle. Suitable metal oxide support particles include, but are not limited to alumina, ceria, ceria-alumina, zirconia, zirconia-alumina, ceria-zirconia-alumina, and mixtures thereof. These metal oxide support particles may also be doped with lanthanum or other suitable rare earth materials. According to one or more embodiments of the invention, Ba sintering and Ba composite compound formation is reduced under the conditions of thermal stress in an exhaust gas of a lean burn engine. The NO_x storage material according to embodiments of the present invention demonstrates improved NO_x storage capacity after thermal aging when used in a catalytic trap.

25 According to other embodiments of the invention, methods of manufacturing NO_x storage materials and catalytic traps including these storage materials are provided. Other embodiments of the invention pertain to catalysts in the form of a catalytic trap for abatement of NO_x in an exhaust gas stream generated by an internal combustion engine which is operated periodically between lean and stoichiometric or rich conditions.

30 According to one or more embodiments, the catalyst in the form of a catalytic trap has a first layer comprising a catalytic trap material including a catalytic component effective for promoting the reduction of NO_x under stoichiometric or rich conditions supported on a refractory metal oxide and a NO_x storage material effective for adsorbing the NO_x under lean conditions and desorbing and reducing the NO_x to nitrogen under stoichiometric or rich conditions, the NO_x storage material comprising particles of ceria having an alkaline earth compound, for example, barium carbonate, supported on the metal oxide support particles, the catalytic trap material being disposed on a refractory carrier member. An additional layer comprising a precious metal may be disposed over the first layer. The second layer may be substantially free of cerium or barium.

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As used in this specification and the appended claims, the term "substantially free of" means it contains less than 1% of the subject substance.

As used in this specification and the appended claims, the term "substantially only" means is contains greater than 99% of the subject substance.

Embodiments of the invention pertain to processes for abatement of NO_x in an exhaust gas stream generated by an internal combustion engine which periodically operates alternately between lean and stoichiometric or rich conditions, comprising locating the above-described catalytic trap in an exhaust passage of the engine and treating the exhaust gas stream with a catalytic trap whereby at least some of the NO_x in the exhaust gas stream is adsorbed by the catalytic trap during the periods of lean conditions and is desorbed from the catalytic trap and reduced to nitrogen during the periods of stoichiometric or rich conditions.

The metal oxide support particles of the catalytic trap may be a porous refractory metal oxide and have a high surface area such as alumina, for example, gamma-alumina. Other suitable support materials include titania, titania-alumina, zirconia, zirconia-alumina, baria-alumina, lanthana-alumina, lanthana-zirconia-alumina titania-zirconia, and mixtures thereof. Desirably, the refractory metal oxide support will have a surface area of from 5 to 350 m^2/g , and more particularly of from 100 to 200 m^2/g . A suitable support material for the precious metal is alumina, which may be doped with one or more other materials. The refractory metal oxide support, preferably the alumina, in the top washcoat slurry is preferably doped with up to 30% zirconium oxide, preferably from 5 to 30%, more preferably from 5 to 25%, more preferably from 5 to 20%, and still more preferably from 5 to 15%. In particular, alumina having a BET surface area of from 175 to 225 m^2/g such as about 200 m^2/g and doped with up to 30% ZrO_2 and, even more preferably, up to 4% LaO provided good results.

In one or more detailed embodiment of the present invention the catalytic component comprises a precious metal component, i.e., a platinum group metal component. Suitable precious metal components include platinum, palladium, rhodium and mixtures thereof. The catalytic component will typically be present in an amount of up to 200 g/ft^3 , preferably from 50 to 200 g/ft^3 , more preferably from 55 to 150 g/ft^3 , and more specifically, of from 60 to 120 g/ft^3 .

The NO_x storage material employed in the catalytic trap according to embodiments of the present invention comprises a NO_x storage material comprising a metal compound selected from an alkaline earth metal compound, an alkali metal compound and rare earth metal compound in oxide or carbonate form, for example, BaCO_3 , supported on CeO_2 particles.

In one or more embodiments, the NO_x storage material is disposed on a refractory carrier member. Examples of such substrates include, for example, stainless steel, titanium, aluminum zirconate, aluminum titanate, aluminum phosphate, cordierite, mul-
5 lite and corundum. The carrier member may be employed as a monolithic honeycomb structure, spun fibers, corrugated foils, layered materials, etc.

In a gasoline vehicle application, a catalytic device employing a three-way conversion ("TWC") catalyst may be used in conjunction with the catalytic trap of the invention.
10 Such a device will be located in an exhaust passage of the internal combustion engine and will be disposed upstream and/or downstream of the catalytic trap. The TWC catalyst would typically include platinum, palladium and rhodium catalytic components dispersed on a high surface area refractory support and may also contain one or more base metal oxide catalytic components such as oxides of iron, manganese or nickel.
15 Such catalysts can be stabilized against thermal degradation by expedients such as impregnating an activated alumina support with one or more rare earth metal oxides, e.g., ceria. Such stabilized catalysts can sustain very high operating temperatures. For example, if a fuel cut technique is utilized, temperatures as high as 1050 °C may be sustained in the catalytic device.

20 If the catalytic device is employed and is located upstream of the catalytic trap of the invention, the catalytic device would be mounted close to the exhaust manifold of the engine. In such an arrangement, the TWC catalyst would warm up quickly and provide for efficient cold start emission control. Once the engine is warmed up, the TWC catalyst will remove HC, CO and NO_x from the exhaust gas stream during stoichiometric or rich operation and HC and CO during lean operation. In one embodiment, the catalyst in the form of a catalytic trap would be positioned downstream of the catalytic device where the exhaust gas temperature enables maximum NO_x trap efficiency. During periods of lean engine operation, when NO_x passes through the TWC catalyst, NO_x is stored on the catalytic trap. The catalytic trap is periodically desorbed and the NO_x is reduced to nitrogen under periods of stoichiometric or rich engine operation. If desired, a catalytic device containing a TWC catalyst may be employed downstream of the catalytic trap of the invention. Such catalytic device will serve to remove further amounts of HC and CO from the exhaust gas stream and, in particular, will provide for efficient reduction of the NO_x to nitrogen under periods of stoichiometric or rich engine operation.
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40 In a diesel vehicle application, the catalytic NO_x-trap according to embodiments of the invention may be used in conjunction with a diesel oxidation catalyst (DOC), and a catalyzed soot filter (CSF); where the DOC and CSF are placed either before or after

the catalytic device of this invention. In another embodiment of the invention, it is possible to place the NO_x-trap catalyst directly onto the filter media.

The several components of the catalytic trap material may be applied to the refractory 5 carrier member, i.e., the substrate, as a mixture of two or more components or as individual components in sequential steps in a manner which will be readily apparent to those skilled in the art of catalyst manufacture. A typical method of manufacturing the catalytic trap of the present invention is to provide the catalytic trap material as a coating 10 or layer of washcoat on the walls of the gas-flow passages of a suitable carrier member. This may be accomplished, by impregnating a fine particulate refractory metal oxide support material, e.g., gamma alumina, with one or more catalytic metal components such as a precious metal, i.e., platinum group, compound or other noble metals or base metals, drying and calcining the impregnated support particles and forming an aqueous slurry of these particles. Dried particles of the bulk NO_x sorbent 15 may be included in the slurry. Alternatively, the NO_x storage material or sorbent may be dispersed into the support, preferably in an impregnation operation, as described below. Activated alumina may be thermally stabilized before the catalytic components are dispersed thereon, as is well known in the art, by impregnating it with, e.g., a solution 20 of a soluble salt of barium, lanthanum, zirconium, rare earth metal or other suitable stabilizer precursor, and thereafter drying (e.g., at 110 °C for one hour) and calcining (e.g., at 550 °C for one hour) the impregnated activated alumina to form a stabilizing metal oxide dispersed onto the alumina. Base metal catalysts may optionally also have been impregnated into the activated alumina, for example, by impregnating a solution 25 of a base metal nitrate into the alumina particles and calcining to provide a base metal oxide dispersed in the alumina particles.

The carrier may then be immersed into the slurry of impregnated activated alumina and excess slurry removed to provide a thin coating of the slurry on the walls of the gas-flow passages of the carrier. The coated carrier is then dried and calcined to provide 30 an adherent coating of the catalytic component and, optionally, the catalytic trap material, to the walls of the passages thereof. The carrier may then be immersed into a slurry of fine particles of component of the NO_x storage material as a second or over-layer coating deposited over the layer of catalytic component. A magnesium component, e.g., a solution of a magnesium salt such as magnesium nitrate, acetate, sulfate, 35 hydroxide, etc., may be combined with the slurry of component of the NO_x storage material or it may be applied as a third or overlayer coating deposited over the second layer of the NO_x storage material. The carrier is then dried and calcined to provide a finished catalyst trap member in accordance with one embodiment of the present invention.

Alternatively, the alumina or other metal oxide support particles impregnated with the catalytic component may be mixed with bulk or supported particles of the NO_x storage material in an aqueous slurry, and this mixed slurry of catalytic component particles and NO_x storage material particles may be applied as a coating to the walls of the gas-
5 flow passages of the carrier. Preferably, however, for improved dispersion of the NO_x storage material, the washcoat of catalytic component material, after being dried and calcined, is immersed (post-dipped) into a solution of a component (NO_x storage material precursor compound (or complex) and a magnesium precursor compound (or complex) to impregnate the washcoat with the NO_x storage material precursor. The im-
10 pregnated washcoat is then dried and calcined to provide the NO_x storage material dispersed throughout the washcoat.

In use, the exhaust gas stream which is contacted with the catalytic trap of the present invention is alternately adjusted between lean and stoichiometric/rich operating conditions so as to provide alternating lean operating periods and stoichiometric/rich operating periods. It will be understood that the exhaust gas stream being treated may be selectively rendered lean or stoichiometric/rich either by adjusting the air-to-fuel ratio fed to the engine generating the exhaust or by periodically injecting a reductant into the gas stream upstream of the catalytic trap. For example, the composition of the present
15 invention is well suited to treat the exhaust of engines, including diesel engines, which continuously run lean. In such case, in order to establish a stoichiometric/rich operating period, a suitable reductant, such as fuel, may be periodically sprayed into the exhaust immediately upstream of the catalytic trap of the present invention to provide at least local (at the catalytic trap) stoichiometric/rich conditions at selected intervals.
20 Partial lean-burn engines, such as partial lean-burn gasoline engines, are designed with controls which cause them to operate lean with brief, intermittent rich or stoichiometric conditions.
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Accordingly, one or more embodiments of the invention are directed to a nitrogen oxide
30 storage catalyst comprising a substrate and at least two washcoat layers. The first washcoat layer comprises a nitrogen oxide storage material. The nitrogen oxide storage material comprises a metal compound in oxide or carbonate form, the metal selected from an alkaline earth metal, an alkali metal, and a rare earth metal supported on support particles. The second washcoat layer is applied on top of the first washcoat
35 layer and comprises a single precious metal. The second washcoat layer may be substantially free of cerium and barium.

The second washcoat layer of other embodiments comprises rhodium or palladium and is substantially free of platinum. In other embodiments, the second washcoat layer
40 comprises substantially only rhodium supported on refractory metal oxide particles. By separating the rhodium from platinum, palladium barium and cerium, this prevents the

rhodium from forming composites with barium and alloys with other precious metals. If the precious metal in the second layer forms an alloy with platinum, the NO oxidation activity of platinum will be reduced, and the NO_x reduction properties of the catalyst will be diminished. The refractory metal oxide of some embodiments comprises alumina 5 doped with up to 30% zirconia.

The first washcoat layer of various embodiments may comprise at least one platinum group metals selected from the group consisting of platinum, palladium, rhodium, iridium and mixtures thereof supported on refractory oxide particles. Further embodiments 10 may have baria in the first washcoat layer.

The nitrogen oxide storage catalyst of some embodiments has a second washcoat layer with a total loading of from 0.05 to 5 g/in³ and is less than the loading of the first washcoat layer. In other embodiments, the first washcoat layer may comprise ceria 15 and barium carbonate in a ratio of from 1:3 to 1:10.

Additional embodiments of the invention are directed to treatment systems for an automobile exhaust gas stream. The treatment system of some of these embodiments comprises a combustion engine which operates periodically between lean and rich 20 conditions, an exhaust gas conduit in communication with the engine, and a nitrogen oxide storage catalyst as described herein disposed within the exhaust gas conduit.

Further embodiments of the invention are directed to methods of making a nitrogen oxide storage catalyst. The methods include applying a bottom washcoat to a substrate, the bottom washcoat comprising at least one precious metal, metal oxide support particles and an alkaline earth metal compound, an alkali metal compound and a rare earth metal compound. A top washcoat is applied over the bottom washcoat, the top washcoat comprising a single precious metal, wherein the top washcoat is substantially free of platinum, cerium and barium. 30

The bottom washcoat of specific embodiments is prepared by mixing a first solution of a barium compound with ceria particles to provide a first mixture. At least one precious metal is impregnated into alumina. A solution of a zirconium salt is added to the precious metal impregnated alumina, thereby providing a slurry and milling the slurry. The 35 first mixture is added to the slurry and milled again. The substrate is washcoated with the slurry. A top washcoat is prepared by making a slurry comprising a precious metal impregnated alumina. Milling the slurry and coating the substrate with the milled slurry to create a top washcoat over the bottom washcoat.

40 In one embodiment, the alumina in the top washcoat slurry is doped with up to 30% zirconium oxide. The loading of the top washcoat is up to 5 g/in³, and is less than the

loading of the bottom washcoat. The bottom washcoat of various embodiments comprises ceria and barium carbonate in a ratio of from 1:3 to 1:10.

Still further embodiments are directed to a method of treating an automobile exhaust gas stream. These methods comprise passing the exhaust gas across a nitrogen oxide storage catalyst having at least a bilayer structure, with at least a bottom layer and a top layer, wherein the bottom layer comprises ceria particles having an alkaline earth metal compound supported on the particles and the top layer comprises a precious metal and is substantially free of cerium and barium.

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The catalyst compositions are disposed on a substrate. The substrate may be any of those materials typically used for preparing catalysts, and will usually comprise a ceramic or metal honeycomb structure. Any suitable substrate may be employed, such as a monolithic substrate of the type having fine, parallel gas flow passages extending therethrough from an inlet or an outlet face of the substrate, such that passages are open to fluid flow therethrough (referred to as honeycomb flow through substrates). The passages, which are essentially straight paths from their fluid inlet to their fluid outlet, are defined by walls on which the catalytic material is disposed as a washcoat so that the gases flowing through the passages contact the catalytic material. The flow passages of the monolithic substrate are thin-walled channels, which can be of any suitable cross-sectional shape and size such as trapezoidal, rectangular, square, sinusoidal, hexagonal, oval, circular, etc. Such structures may contain from 60 to 400 or more gas inlet openings (i.e., cells) per square inch of cross section.

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The substrate can also be a wall-flow filter substrate, where the channels are alternately blocked, allowing a gaseous stream entering the channels from one direction (inlet direction), to flow through the channel walls and exit from the channels from the other direction (outlet direction). AMOX and/or SCR catalyst composition can be coated on the flow through or wall-flow filter. If a wall flow substrate is utilized, the resulting system will be able to remove particulate matter along with gaseous pollutants. The wall-flow filter substrate can be made from materials commonly known in the art, such as cordierite, aluminum titanate or silicon carbide. It will be understood that the loading of the catalytic composition on a wall flow substrate will depend on substrate properties such as porosity and wall thickness, and typically will be lower than loading on a flow through substrate.

The ceramic substrate may be made of any suitable refractory material, e.g., cordierite, cordierite-alumina, silicon nitride, zircon mullite, spodumene, alumina-silica magnesia, zircon silicate, sillimanite, a magnesium silicate, zircon, petalite, alpha-alumina, an aluminosilicate and the like.

40

The substrates useful for the catalysts of embodiments of the present invention may also be metallic in nature and be composed of one or more metals or metal alloys. The metallic substrates may be employed in various shapes such as corrugated sheet or monolithic form. Suitable metallic supports include the heat resistant metals and metal alloys such as titanium and stainless steel as well as other alloys in which iron is a substantial or major component. Such alloys may contain one or more of nickel, chromium and/or aluminum, and the total amount of these metals may advantageously comprise at least 15 wt. % of the alloy, e.g., 10-25 wt. % of chromium, 3-8 wt. % of aluminum and up to 20 wt. % of nickel. The alloys may also contain small or trace amounts of one or more other metals such as manganese, copper, vanadium, titanium and the like. The surface or the metal substrates may be oxidized at high temperatures, e.g., 1000°C and higher, to improve the resistance to corrosion of the alloys by forming an oxide layer on the surfaces the substrates. Such high temperature-induced oxidation may enhance the adherence of the refractory metal oxide support and catalytically promoting metal components to the substrate.

Without intending to limit the invention in any manner, embodiments of the present invention will be more fully described by the following examples.

20 COMPARATIVE EXAMPLE 1

Preparation of First Layer

25 BaCO₃ and CeO₂ were intimately mixed and finely dispersed in a weight ratio of from 1:3 to 1:10. Cerium oxide having a BET surface area of from 50 to 150 m²/g was mixed with a solution of barium acetate such that the BaCO₃/CeO₂ composite had a BaCO₃ content of from 10 to 30 wt%. After mixing, the suspension of soluble barium acetate and CeO₂ was then dried at a temperature of from 90 °C to 120 °C to obtain a solid mixture of barium acetate and ceria.

30 After drying, the mixture was then heated at 550 °C to 800 °C for 2 hours to form particles of ceria having barium carbonate supported on the ceria particles. The resulting BaCO₃ had a crystallite size of from about 20 to about 30 nm and the ceria had a crystallite size of from about 6.5 to about 10 nm. The BaCO₃ and CeO₂ crystallites formed particles with a size of from about 6 to about 15 microns. The BET surface area of the particulate mixture is from 30 to 80 m²/g.

Preparation of Catalytic Component

40 To provide a fully formulated NO_x storage catalyst or catalytic trap as described above, in addition to the manufacture of barium carbonate supported on ceria, a precious

metal can be supported on a refractory oxide according to the following description. Pt and Rh are impregnated onto Al_2O_3 by an incipient wetness procedure to yield 1.8 weight percent Pt and 0.1 weight percent Rh. Pd is impregnated separately onto alumina to a Pd loading of 1.4 weight percent.

5

The alumina had a BET surface area of 200 m^2/g and contained 10% zirconia. A mixture of 2.2 g/in^3 of the Pt/Rh alumina with 0.6 g/in^3 Pd on alumina was prepared. A solution of zirconium acetate with a content of 0.2 g/in^3 was added, giving a slurry with a solid content of 45%. This slurry was milled with a ball mill until a particle size of 12 10 micron (d_{90}) was obtained. Magnesium acetate was added to the slurry and stirred to dissolve, yielding 0.6 g/in^3 magnesium oxide. To this mixture, 2.9 g/in^3 $\text{BaCO}_3/\text{CeO}_2$ dried powder is added and the slurry is eventually milled at pH 5-6 until a particle size of 11 micron (d_{90}) is obtained.

15 Coating of a Substrate

Ceramic or metallic honeycomb substrates were coated with the slurry in a dip coating manner and then dried in a dryer and subsequently calcined in a furnace under air at 450 °C to 550 °C. The coating procedure is then repeated until a loading of from 4 to 20 6.5 g/in^3 is achieved.

EXAMPLE 2

25 Samples were prepared in accordance with Example 1 above, with the addition of a second layer, as described below. A slurry with a metal loading of 5 g/ft^3 rhodium on an alumina support was prepared and used to create a second layer having a wash-coat layer loading of 0.5 g/in^3 rhodium, as described below in greater detail.

30 Preparation of a Second Layer

A precious metal is impregnated onto alumina with a BET surface area greater than 100 m^2/g . The alumina may be doped with zirconia up to 30%. After impregnation, the alumina slurry is diluted to 35% solids with water. The pH is adjusted to 3.5 to 4 using tartaric acid and/or monoethanolamine (MEA). The slurry is then milled to about 12 35 micron with a continuous mill. Subsequently, the pH is adjusted to 6.5 using MEA.

To create a second, or subsequent layer, a coated substrate is coated again with the slurry in a dip coating manner and then dried in a dryer. The substrate is then calcined in a furnace under air at 450 °C to 550 °C. The coating procedure is repeated until a 40 loading of from 0.1 to 1 g/in^3 is achieved.

EXAMPLE 3

Samples were prepared in accordance with Example 1 above, with the addition of a second layer comprising palladium, as previously described. A slurry was prepared to 5 obtain a metal loading of the coated substrate of 10 g/ft³ palladium and a washcoat layer loading of the second layer of 0.5 g/in³ alumina.

COMPARATIVE EXAMPLE 4

10 Samples were prepared in accordance with Example 1 above. The total metal loading was 3.6 g/ft³ Rh, 72 g/ft³ Pt and 14.4 g/ft³ Pd.

EXAMPLE 5

15 Samples were prepared in accordance with Example 1 above, with the addition of a second layer comprising rhodium, as previously described. A slurry was prepared to obtain a metal loading of the coated substrate of 5 g/ft³ rhodium and used to create a second layer having a washcoat layer loading of 0.5 g/in³ alumina.

20 NO_x Storage Capacity Testing

Catalytic traps were evaluated after aging for 8 hours at 850°C, as follows. An engine was set to an air/fuel ratio of 11.6 for 2 minutes at the desired temperature to remove all stored NO_x and oxygen from the catalyst. This mode represents rich engine operation. 25 Subsequently, the engine was adjusted to an air/fuel ratio of 29.6 under constant NO_x mass flow. This mode represents lean engine operation. During the whole test, the NO_x concentration was measured before and after the NO_x trap using a NO_x analyzer.

$$U = \frac{NO_x^{massoutlet}}{NO_x^{massinlet}} \bullet 100 \quad (1)$$

30 After the 2 minute rich operation followed by a 60 second lean operation, the engine was set to a 3 second rich operation to remove stored NO_x without having hydrocarbon and carbon monoxide tailpipe emissions. This 60 sec lean / 3 sec rich cycle was 35 repeated 10 times to establish constant catalyst conditions. For the time period of the 10 lean/rich cycles the NO_x efficiency (U) is calculated from the NO_x inlet and NO_x outlet concentrations via equation (1): NO_x storage mass in g is calculated via equation (2):

$$NO_x^{mass}(g) = \int NO_x * \dot{V} / V_{ideal} * M_S * 1/(3.6 * 10^6) dt \quad (2)$$

NO_x = NO_x concentration (ppm)

V = volume flow (m³/h)

V_{ideal} = ideal molar volume (l/mol) at STP
Ms = Molar weight of NO_2 (g/mol)
dt = time interval (s)

5 After the 10 lean/rich cycles, the engine is operated for 1 min rich to remove the stored NO_x completely. Subsequently, the engine is operated under lean condition until no more NO_x is stored in the trap. Under these conditions, the overall NO_x storage capacity is evaluated. However, to achieve a NO_x conversion of greater than 80%, the NO_x storage capacity at high NO_x efficiency is decisive.

10

Figures 1 and 2 demonstrate that the inventive nitrogen oxide storage catalysts (Example 2 and Example 3) have greater NO_x conversion and storage than Comparative Example 1. These samples were aged in an oven for 4 hours at 800 °C.

15 Figure 3 shows that the inventive nitrogen oxide storage catalyst has a greater NO_x storage at 85% efficiency than Comparative Example 1.

Figures 4 and 5 show the effect of the thickness of the rhodium/alumina topcoat. The samples were aged for 25 hours at a temperature of 800 °C. The λ for these measurements was 1.02. The thickness of the topcoat, 0.5 g/in³ vs. 1 g/in³, does not have a significant effect on the NO_x conversion. However, the catalyst with the topcoat with 0.5 g/in³ resulted in better NO_x storage at 85% efficiency, over the testing range.

25 Although the invention has been described with reference to several exemplary embodiments, it should be understood that the invention is not limited to the details of construction or process steps set forth in the examples. The invention is capable of other embodiments and of being practiced or being carried out in various ways.

30 The present application also refers to the following embodiments, including the specific combinations of embodiments as defined by the specific back-references indicated in the embodiments:

1. (First embodiment) A nitrogen oxide storage catalyst comprising:
a substrate;
- 35 a first washcoat layer on the substrate, the first washcoat layer comprising a nitrogen oxide storage material comprising metal oxide support particles having a metal compound selected from alkaline earth metal compound, alkali metal compound and a rare earth metal compound supported on the metal oxide support particles; and
a second washcoat layer over the first washcoat layer comprising a single precious metal, the second washcoat layer being substantially free of platinum, cerium and barium.
- 40

2. The nitrogen oxide storage catalyst of embodiment 1, wherein the single precious metal is selected from rhodium and palladium.
- 5 3. The nitrogen oxide storage catalyst of embodiment 2, wherein the second washcoat layer comprises substantially only rhodium supported on refractory metal oxide particles.
4. The nitrogen oxide storage catalyst of embodiment 3, wherein the refractory metal oxide comprises alumina doped with about 5% to about 30% zirconia.
- 10 5. The nitrogen oxide storage catalyst of embodiment 1, wherein the first washcoat layer further comprises at least one member of platinum group metals selected from the group consisting of platinum, palladium, rhodium, iridium and mixtures thereof supported on refractory oxide particles.
- 15 6. The nitrogen oxide storage catalyst of embodiment 3, wherein the first washcoat layer further comprises a barium compound.
- 20 7. The nitrogen oxide storage catalyst of embodiment 1, wherein the substrate comprises a honeycomb substrate comprising a plurality of longitudinally extending passages formed by longitudinally extending walls bounding and defining said passages, the passages comprising inlet passages having an open inlet end and closed outlet end, and outlet passages having a closed inlet end and an open outlet end.
- 25 8. The nitrogen oxide storage catalyst of embodiment 1, wherein the total loading of the second washcoat layer is between about 0.05 to about 5 g/in³ and is less than the loading of the first washcoat layer.
- 30 9. The nitrogen oxide storage catalyst of embodiment 6, wherein the first washcoat layer comprises ceria and barium carbonate in a ratio between about 1:3 to about 1:10.
- 35 10. A treatment system for an automobile exhaust gas stream, comprising:
a combustion engine which operates periodically between lean and rich conditions;
an exhaust gas conduit in communication with the engine; and
a nitrogen oxide storage catalyst in accordance with any of embodiments 1 to 9, disposed within the exhaust gas conduit.

11. The treatment system of embodiment 10, the catalytic component comprising at least one member of platinum group metals selected from the group consisting of platinum, palladium, rhodium, iridium and mixtures thereof.

5 12. The treatment system of embodiment 10, wherein the top layer is substantially free of platinum and palladium.

13. The system of embodiment 10, wherein the top layer is comprised of essentially only rhodium supported on alumina particles.

10 14. The system of embodiment 10, wherein the substrate comprises a honeycomb substrate comprising a plurality of longitudinally extending passages formed by longitudinally extending walls bounding and defining said passages, the passages comprising inlet passages having an open inlet end and closed outlet end, and outlet passages 15 having a closed inlet end and an open outlet end.

15. A method of making a nitrogen oxide storage catalyst comprising: applying a bottom washcoat to a substrate, the bottom washcoat comprising ceria, a barium compound and at least one precious metal;

20 applying a top washcoat over the bottom washcoat, the top washcoat comprising at least one precious metal, wherein the top washcoat is substantially free of cerium and barium.

25 16. The method of embodiment 15, wherein the top washcoat is substantially free of platinum.

17. The method of embodiment 15, wherein the precious metal in the top washcoat comprises substantially only rhodium.

30 18. The method of embodiment 15, wherein the bottom washcoat is prepared by mixing a first solution of barium with ceria particles to provide a first mixture, impregnating alumina with at least one precious metal, adding a solution of a zirconium salt to the precious metal impregnated alumina to providing a slurry, milling the slurry, adding first mixture to the slurry to provide a mixed slurry, milling the mixed slurry, and coating the 35 substrate with the mixed slurry; and the top washcoat is prepared by making a top washcoat slurry comprising a precious metal impregnated alumina, milling the slurry, and coating the substrate with the milled top washcoat slurry over the bottom washcoat

40 19. The method of embodiment 15, wherein the alumina in the top washcoat slurry is doped with about 5% to about 30% zirconium oxide.

20. The method of embodiment 15, wherein the top washcoat has a loading of about 0.05 to about 5 g/in³ and is less than the loading of the bottom washcoat.

21. The method of embodiment 15, wherein the bottom washcoat comprises ceria 5 and barium carbonate in a ratio of about 1:3 to about 1:10.

22. A method of treating an automobile exhaust gas stream comprising passing exhaust gas across a nitrogen oxide storage catalyst having at least a bilayer structure, with at least a bottom layer and a top layer, wherein the bottom layer comprises metal 10 oxide support particles having a metal compound selected from alkali earth metal compounds, alkaline earth metal compounds and rare earth metal compounds supported on the metal oxide support particles and the top layer comprises a single precious metal selected from rhodium and palladium and is substantially free of cerium and barium.

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23. The method of embodiment 22, wherein the top layer is substantially free of platinum.

24. The method of embodiment 22, wherein the precious metal component of the 20 top layer is substantially only rhodium.

25. The method of embodiment 22, where in the top layer has a loading of about 0.05 to about 5 g/in³ and is less than the loading of the bottom layer.

Claims

1. A nitrogen oxide storage catalyst comprising:
a substrate;
5 a first washcoat layer on the substrate, the first washcoat layer comprising a nitrogen oxide storage material comprising metal oxide support particles having a metal compound selected from an alkaline earth metal compound, an alkali metal compound and a rare earth metal compound supported on the metal oxide support particles; and
10 a second washcoat layer over the first washcoat layer comprising a single precious metal, the second washcoat layer being substantially free of platinum, cerium and barium.
2. The nitrogen oxide storage catalyst of claim 1, wherein the single precious metal is selected from rhodium and palladium.
15
3. The nitrogen oxide storage catalyst of claim 1 or 2, wherein the second washcoat layer comprises substantially only rhodium as precious metal supported on refractory metal oxide particles.
20
4. The nitrogen oxide storage catalyst of claim 3, wherein the refractory metal oxide comprises alumina doped with from 5% to 30% zirconia.
5. The nitrogen oxide storage catalyst of any of claims 1 to 4, wherein the first washcoat layer further comprises at least one member of platinum group metals selected from the group consisting of platinum, palladium, rhodium, iridium and mixtures thereof supported on refractory oxide particles.
25
6. The nitrogen oxide storage catalyst of any of claims 1 to 5, wherein the first washcoat layer comprises a barium compound.
30
7. The nitrogen oxide storage catalyst of any of claims 1 to 6, wherein the substrate comprises a honeycomb substrate comprising a plurality of longitudinally extending passages formed by longitudinally extending walls bounding and defining said passages, the passages comprising inlet passages having an open inlet end and closed outlet end, and outlet passages having a closed inlet end and an open outlet end.
35
8. The nitrogen oxide storage catalyst of any of claims 1 to 7, wherein the total loading of the second washcoat layer is from 0.05 to 5 g/in³ (0.05 to 5 g/(2.54 cm)³) and is less than the loading of the first washcoat layer.
40

9. The nitrogen oxide storage catalyst of any of claims 1 to 8, wherein the first washcoat layer comprises ceria and barium carbonate in a ceria : barium carbonate ratio from 1:3 to 1:10.
- 5
10. The nitrogen oxide catalyst of any of claims 1 to 9, wherein barium carbonate as alkaline earth metal compound is supported on ceria support particles.
- 10
11. A treatment system for an automobile exhaust gas stream, comprising:
 - a combustion engine which operates periodically between lean and rich conditions;
 - an exhaust gas conduit in communication with the engine; and
 - a nitrogen oxide storage catalyst in accordance with any of claims 1 to 10 disposed within the exhaust gas conduit.
- 15
12. A method of making a nitrogen oxide storage catalyst comprising:
 - applying a bottom washcoat to a substrate, the bottom washcoat comprising a nitrogen oxide storage material comprising metal oxide support particles having a metal compound selected from an alkaline earth metal compound, an alkali metal compound and a rare earth metal compound supported on the metal oxide support particles; said bottom washcoat preferably comprising ceria, a barium compound, preferably barium carbonate, and at least one precious metal;
 - applying a top washcoat over the bottom washcoat, the top washcoat comprising a single precious metal, wherein the top washcoat is substantially free of platinum, cerium and barium.
- 20
13. The method of claim 12, wherein the precious metal in the top washcoat comprises substantially only rhodium.
- 25
14. The method of claim 12 or 13,
 - wherein the bottom washcoat is prepared by mixing a first solution of a barium compound, preferably barium carbonate, with ceria particles to provide a first mixture, impregnating alumina with at least one precious metal, adding a solution of a zirconium salt to the precious metal impregnated alumina to provide a slurry, milling the slurry, adding the first mixture to the slurry to provide a mixed slurry, milling the mixed slurry; and coating the substrate with the milled slurry;
 - 30
 - 35
 - wherein the top washcoat is prepared by making a top washcoat slurry comprising a precious metal impregnated alumina, milling the slurry;
 - 40
 - and wherein the milled top washcoat slurry is coated over the bottom washcoat of the substrate.

15. The method of claim 14, wherein the alumina in the top washcoat slurry is doped with from 5% to 30% zirconia.
- 5 16. The method of any of claims 12 to 15, wherein the top washcoat has a loading of from 0.05 to 5 g/in³ (0.05 to 5 g/(2.54 cm)³) and is less than the loading of the bottom washcoat.
- 10 17. The method of any of claims 12 to 16, wherein the bottom washcoat comprises ceria and barium carbonate in a ceria : barium carbonate ratio of from 1:3 to 1:10.
- 15 18. A method of treating an automobile exhaust gas stream comprising passing exhaust gas across a nitrogen oxide storage catalyst having at least a bilayer structure, with at least a bottom layer and a top layer, wherein the bottom layer comprises metal oxide support particles having a metal compound selected from alkali earth metal compounds, alkaline earth metal compounds and rare earth metal compounds supported on the metal oxide support particles and the top layer comprises a single precious metal selected from rhodium and palladium and is substantially free of cerium and barium.
- 20 19. The method of claim 18, wherein the nitrogen oxide storage catalyst is a catalyst according to any of claims 1 to 10 or a catalyst, obtainable or obtained by a method according to any of claims 12 to 17.

Fig. 1

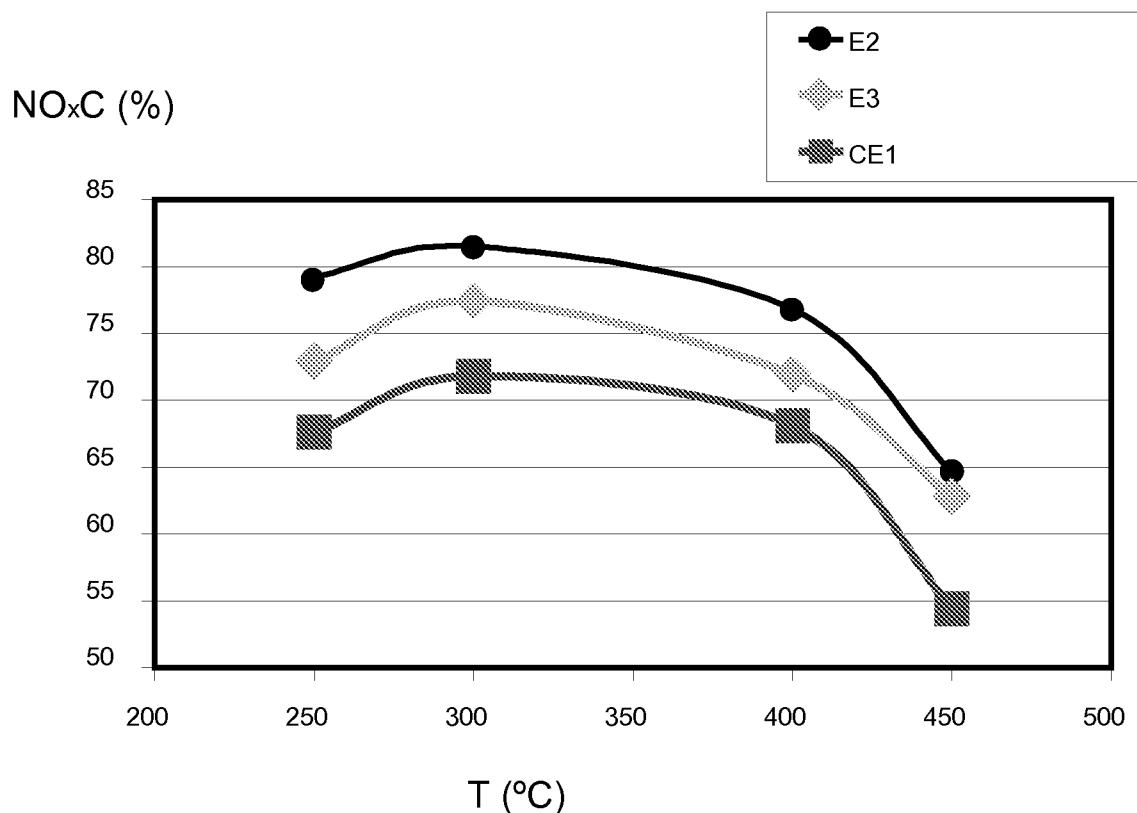


Fig. 2

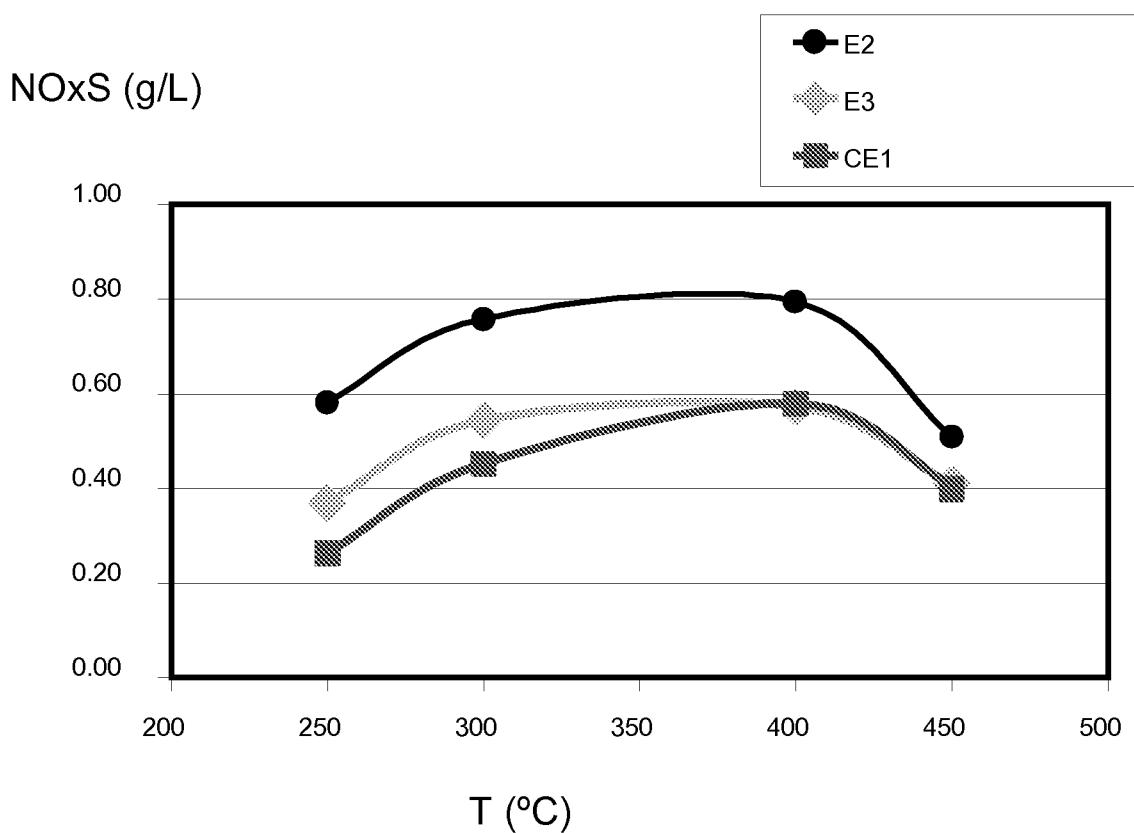


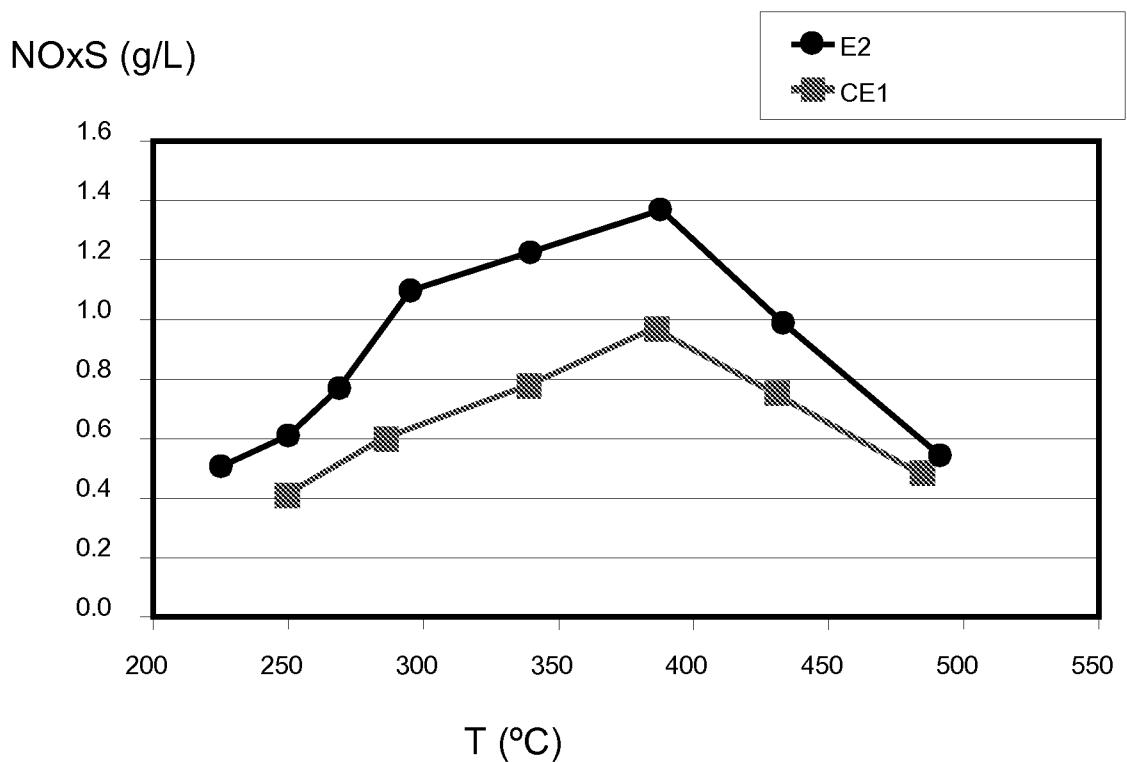
Fig. 3

Fig. 4

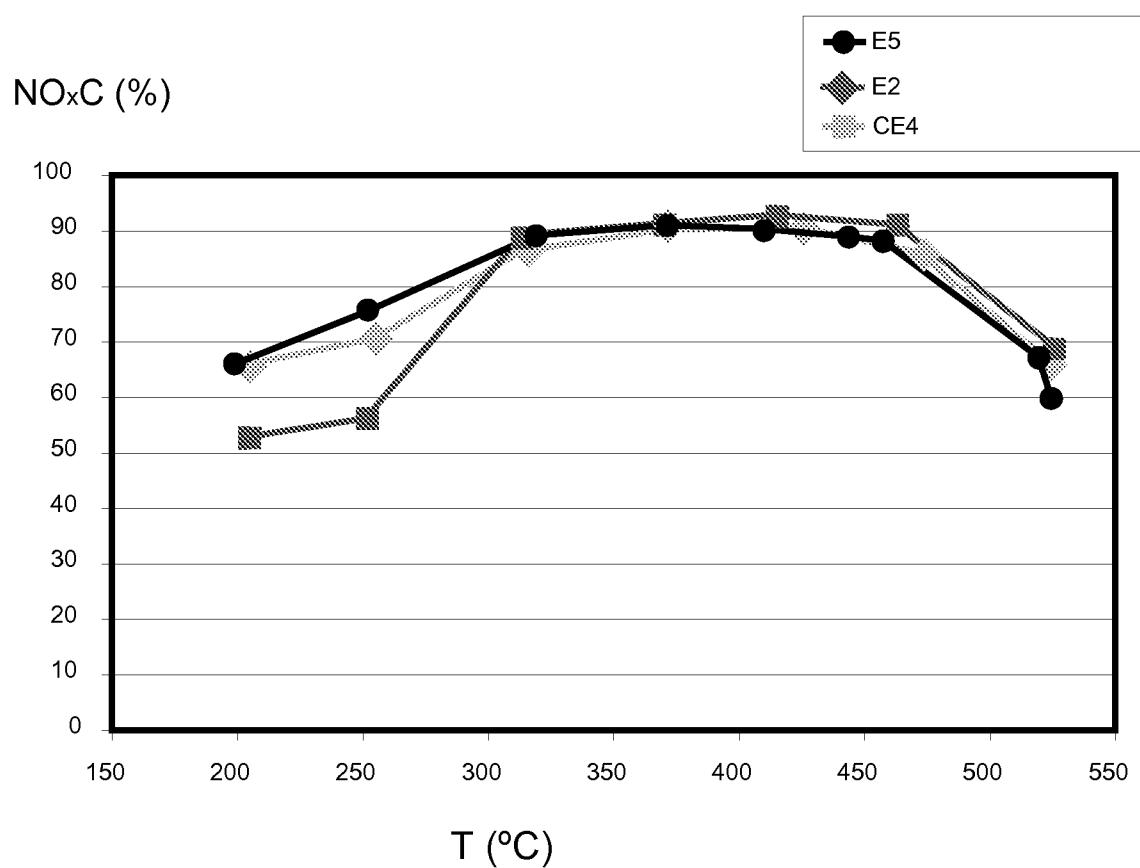
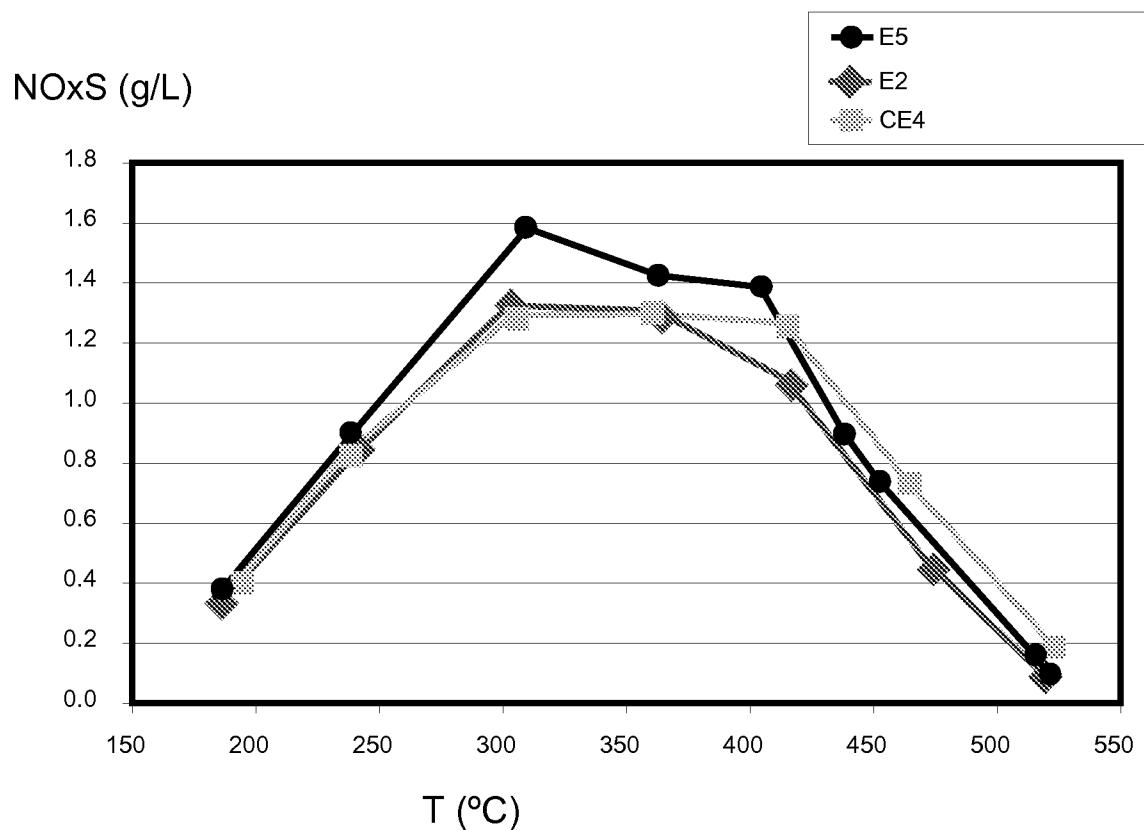


Fig. 5



INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2009/059645

A. CLASSIFICATION OF SUBJECT MATTER	INV.	B01D53/94	B01J23/63	B01J35/04	B01J37/02	F01N3/08
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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)
B01D B01J F01N

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 practical, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 95/00235 A (ENGELHARD CORP [US]) 5 January 1995 (1995-01-05) claims; examples -----	1-19
X	US 5 248 650 A (SEKIBA TORU [JP] ET AL) 28 September 1993 (1993-09-28) claims; examples -----	1-19
A	WO 2008/067375 A (BASF CATALYSTS LLC [US]; HILGENDORFF MARCUS [DE]; ROTH STANLEY A [US];) 5 June 2008 (2008-06-05) the whole document -----	1-19
A	WO 2005/047663 A (ENGELHARD CORP [US]) 26 May 2005 (2005-05-26) the whole document -----	1-19

Further documents are listed in the continuation of Box C.

See patent family annex.

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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.

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Date of the actual completion of the international search

Date of mailing of the international search report

24 September 2009

14/10/2009

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Authorized officer

Schoofs, Bart

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No
PCT/EP2009/059645

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