Carbon Dioxide Separation Technology: R & D Needs for the Chemical and Petrochemical Industries

A Chemical Industry Vision 2020 Initiative to Identity Future R & D Needs

Chemical Industry VISION2020 Technology Partnership

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FOREWORD

The Vision2020 Technology Partnership, an industry-led organization for accelerated innovation and technology development, formed a committee to identify research and development needs for separation technology to drive equilibrium processes for the Chemical and Petrochemical Industry. This committee was established in June 2004 and chartered with the responsibility to define the drivers and R&D requirements of the chemical and petrochemical industries for equilibrium separations. Several chemical production processes were selected for review and two topics, hydrogen and carbon dioxide separations, were developed into full studies. This report, the second of two, is directed to commercial, industrial CO_2 production.

EXECUTIVE SUMMARY

A Chemical Industry Vision 2020 sub-committee was established in June 2004 and chartered with the responsibility of identifying research and development needs for separation technology to drive equilibrium processes for the Chemical and Petrochemical Industry. This report, the second in a series, is designed to summarize and present recommendations for improved CO_2 separation technology for industrial processes. The first report on hydrogen manufacture and separation has been published as a review article and as a DOE report [1].

This report provides an overview of 1) the principal CO_2 producing processes, 2) the current commercial separation technologies and 3) emerging adsorption and membrane technologies for CO_2 separation, and makes recommendations for future research. Current industrial practices are summarized with the use of flow sheets. The overall goal of this review is to foster the development of new adsorption, absorption, and membrane technologies to improve manufacturing efficiency and reduce CO_2 emissions. This study focuses on the chemical and petrochemical industries.

The need for improving the energy intensive separation processes involving CO_2 are well recognized. The U.S. Department of Energy has shown that the separation of CO_2 represents 75% of the overall cost associated with its separation, storage, transport, and sequestration. The growing concern about global warming is placing greater demand on improving energy efficiency and reducing CO_2 emissions.

Energy efficient CO_2 separation technologies with improved economics are needed for industrial processing and for future options to capture and concentrate CO_2 for reuse or for sequestration. A very small portion (0.2%) of U.S. CO_2 emissions is separated for industrial or commercial use. Hence, other means besides CO_2 consumption must be considered to mitigate the CO_2 emissions. There are many programs outside the scope of this report addressing these issues (e.g. new power plant design, Kyoto protocol, carbon tax structure, sequestration).

Recommendations are set-forth for future R&D in CO_2 separation and recovery for both near-term (i.e., 0 – 5 years) and longer-range (i.e., 7 – 15 years) research. Flow sheets of existing CO_2 producing processes are provided for guidance and new conceptual flow sheets have also been designed.

The recommendations of this Vision 2020 Chemical Industry team are summarized below. In reviewing this section, please be patient as a summary of recommendations can, at times, appear rather apparent. Full details including scope of scientific space to be explored and justifications are provided in the report starting on page 31.

For near-term adsorbent development:

1) Develop high-capacity, 3-4 mol/kg, CO_2-selective adsorbents to operate at elevated temperatures and pressures in the presence of sulfur and steam.

For near-term membrane development:

1) Develop CO_2 permselective polymeric glassy or rubbery membranes with CO_2/H_2 selectivity of >15-20, with high flux and high temperature stability.
2) Specific Goal: Develop polymeric glassy or rubbery membranes for CO_2/CH_4 that have selectivity > 50, double the current commercial membrane CO_2 flux, resists plasticizing and is stable to heavy oil.
3) Develop CO_2 permselective facilitated transport membranes that can operate in the absence of water for long periods of time.
4) Develop CO_2 permselective inorganic membranes with selectivity of > 15-20.
5) Develop CO_2 permselective selective surface flow membranes with higher CO_2 selectivity with H_2, N_2, and CH_4.
6) Develop CO_2 permselective hybrid mixed-matrix membranes with improved selectivity, permeance, and stability.
7) Develop CO_2 permselective hollow fiber membrane contactors with improved permeance and stability.

For near-term adsorption process development:

1) Develop new pressure swing adsorption (PSA) cycle designs that take advantage of new or existing CO_2 selective adsorbents; possibly temperature swing adsorption (TSA) or PSA/TSA hybrid cycles. For example, develop new PSA cycles that take advantage of the heavy reflux concept, where a pure heavy product like CO_2 is more desirable than pure light product such as H_2.
2) Improve efficiency for thermal management in the design of TSA and PSA/TSA hybrid cycles. Rethink bed designs for rapid heating and cooling.

For near-term absorbent and absorption process development

1) Develop absorbents with improved capacity and greatly improved heat of absorption.
2) Develop new regeneration techniques, as opposed to thermal or vacuum regeneration, to be conducted at high pressure.
3) Develop absorbents that work on high temperature gases.
4) Develop absorbents that are stable to trace contaminants (e.g., amines).
5) Develop more selective absorbents, CO_2 over sulfur species, for processes with H_2S and COS species present (e.g., natural gas and coal bed methane).

For long-term flow sheet augmentation with adsorption and membrane processes:

1) Develop hybrid technology for H_2 production (e.g., for steam methane reforming by combining the reactor with a CO_2 selective adsorbent and an H_2 permeable membrane).
2) Develop new CO_2 adsorbent and membrane technologies that are amenable to integrated gasification combined cycle (IGCC) and related power and chemical production technologies with CO_2 sequestration as a potential long term objective.

3) Specific Goal: Develop hybrid technology, possibly coupled with adsorption or membranes processes, that removes CO_2 by chemical reaction in the chemical process.

For long-term advanced adsorbent materials and process development for CO_2 removal:

1) Develop advanced structured adsorbent materials for use in rapid-cycle PSA.
2) Develop improved designs for rapid-cycle PSA for CO_2 capture and concentration with both heavy and dual reflux cycles steps.
3) Reduce cycle time in rapid PSA to improve throughput - investigate the relationship between adsorbent particle size, surface properties, and accelerated cycle times (i.e., mass transfer limitations).
4) Develop TSA and or PSA/TSA hybrid cycles with improved materials - quantify the effect on cycle time and bed sizes for a forced temperature swing/PSA cycle.
5) Develop improved CO_2 separations with sorption enhanced reaction processes using PSA, TSA, and hybrid cycles.

For long-term advanced membrane materials for CO_2 removal:

1) Develop next generation membrane materials with high selectivity for CO_2 (> 100), operating at high temperatures and pressures and with resistance to fouling and cracking or embrittlement.

INTRODUCTION

The overall goal of this review is to foster the development of new adsorption, absorption, and membrane technologies for CO_2 separation. The underlying economic and environmental drivers are encouraging the development of more energy-efficient CO_2 separation technologies. This report provides an overview of 1) the principal CO_2 producing processes, 2) the current commercial separation technologies, and 3) the emerging adsorption, absorption, and membrane technologies for CO_2 separation, and makes recommendations for future separations research and development.

Carbon dioxide production is ubiquitous in combustion, energy generation and manufacturing processes. Some CO_2 is produced as a by product of chemical manufacturing, while most is produced in the generation of power through the combustion of fossil fuels. The growing concern about global warming is placing greater demands on improving the energy efficiency of processes and on reducing CO_2 emissions. The U.S. Department of Energy has shown that the separation of CO_2 represents 75% of the overall cost associated with its separation, storage, transport, and sequestration. Hence, more energy-efficient CO_2 separation processes are needed.

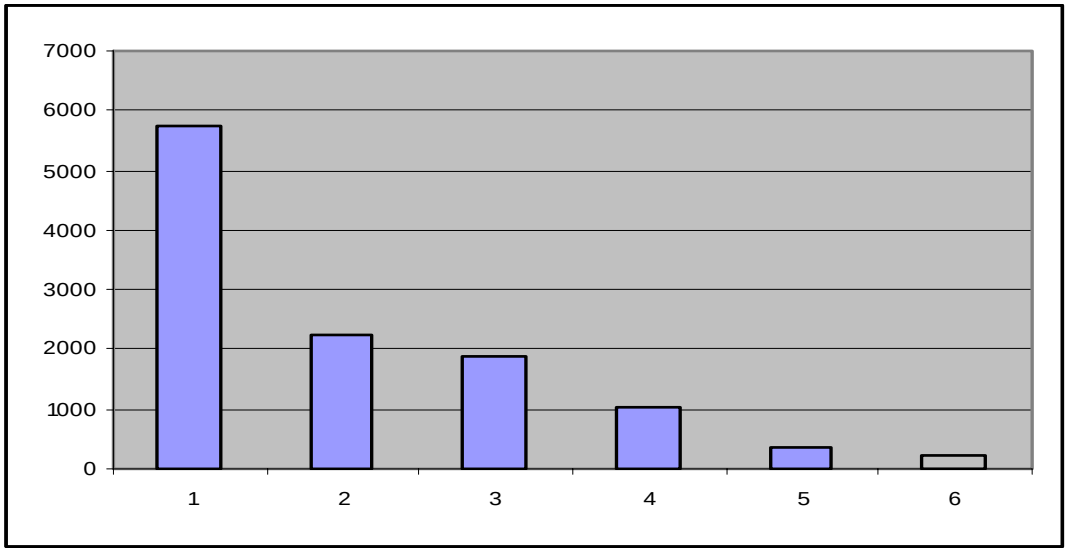
While reading this report, it is recommended that the following questions be kept in mind:

- What are the generic technologies with the most promise?
- What are the high-level technical issues to be overcome in commercializing a new CO_2 separation technology (e.g., costs, sulfur tolerance)?
- What is the estimated time of development for a new commercial application without additional action?
- What will it take to deliver a new commercial application in 3-5 years?
- What will it take to accelerate these developments?
- What breakthroughs, if any, are needed to accelerate these developments?

These questions constitute the overall focus and direction of this study. Direct answers are dependent on specific applications. This report provides specific recommendations for improving only adsorption, absorption, and membrane technologies for CO_2 separation. Furthermore, recommendations have been developed for certain technologies that might meet the CO_2 separation challenge.

CURRENT COMMERCIAL PRACTICES

This section provides an overview of the sources of CO_2 emissions and CO_2 production processes. Most of the CO_2 emissions originate from the generation of electricity, as shown in Figure 1.



1. Total US	5752	%
2. Electric Power	2250	39
3. Transportation	1868	32
4. Industrial Processes	1042	18
5. Residential Homes	365	6
6. Commercial Buildings	227	4

Figure 1. U.S. 2002 CO_2 emissions in MMt: Total, Electric Power, Transportation, Industrial, Residential and Commercial

While the focus of this report is on industrial separation technology associated with the purification of gas streams containing CO_2 or the production of CO_2, an overview of sources CO_2 and environmental emissions is provided in the supportive information section starting on page 38.

The four most widely used, commercial CO_2 removal processes are reviewed. These are absorption, adsorption, membrane, and cryogenic processing. All four processes are commercially important. Absorption is the most prevalent of CO_2 removal methods.

Overview of CO_2 Emissions and Production Processes

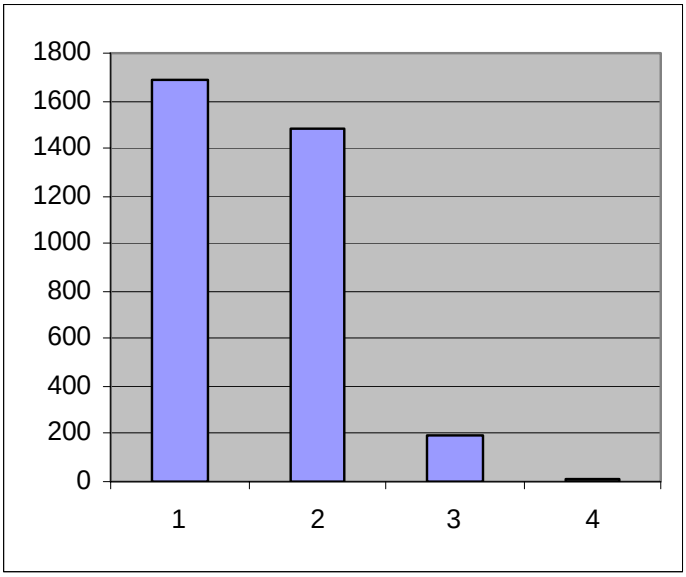
The literature on the production and emissions of CO_2 from the chemical and petrochemical industries is rapidly expanding, demonstrating that CO_2 separation and capture technologies are of growing importance. The general concern is that the continued production of CO_2 will

adversely impact global warming [2]. Hence, development efforts are underway to improve the efficiency of production and separation possesses and to mitigate CO_2 emissions.

Table 1 (tables begin on page 97) provides a summary of worldwide CO_2 emissions, which in 2004 were estimated at 27,043 million metric tons (MMt), a 26% increase over the 1990 emissions. By 2015 this number is expected to increase by 23% to 33,284 MMt, and by 2025 it is expected to increase by 43% to 38,790 MMt [3]. It is no surprise that CO_2 emissions track very well with population growth, and with the rise of developing countries.

Table 2 summarizes the CO_2 emissions from various U.S. sources in 2002 with a further breakdown for fuel type. In 2002 the U.S. was responsible for 5,752 MMt of CO_2 emissions or about 22% of the world's total. U.S. industrial activities accounted for 1,042 MMt of CO_2 emissions or about 18% of the total. When adding the CO_2 equivalence for the electricity consumed by industry, then industry was responsible for 1,685 MMt of CO_2 or about 29% of the U.S. total. Overall, electric power generation was responsible for 2,250 MMT, or 39% of the total. It is noteworthy that about 98% of the CO_2 emissions were from burning fossil fuels to produce energy. These numbers are shown in Figure 1.

As shown in Table 2 industrial production accounts for 29% of CO_2 emissions. Figure 2, however, reveals that 88% of these emissions are associated with energy generation, steam, etc. Only 11% of industrial emissions are associated with chemical or petrochemical processing.



1. Industrial Processes	1685	%
2. Energy, Steam, etc.	1486	88.2
3. Process Generated	192	11.4
4. Commercial Use	7	0.4

Figure 2. U.S. Industry 2002 CO_2 Emissions in MMt , processes including from electric or other power generation, compared to that produced solely by the process and that consumed by other processes.

The main sources of commercial CO_2 include synthetic ammonia and hydrogen plants, flue gas from fossil fuel combustion processes, fermentation, lime-kiln operations, sodium phosphate manufacture, and natural gas wells [4]. Table 2 provides a breakdown of the leading industries that produce the most (non-energy related) CO_2 emissions. These industries include iron and steel, cement, ammonia, natural gas, lime and aluminum production. The energy related CO_2 emissions are also given for comparison.

It appears that the CO_2 emissions from the energy generated to support the chemical and petrochemical

industries overwhelms the CO_2 emissions from the actual chemicals or petrochemical processes, 88% vs. 11% (see Figure 2). Table 3 illustrates average point-source (plant) CO_2 emissions for a number of industrial sectors.

A very small portion of the produced CO_2 is recovered for industrial or commercial use. Nevertheless, CO_2 production was nineteenth on the list of the top 50 highest volume chemicals produced in the U.S. in 2004 [5]. The main uses of CO_2 include 1) beverage carbonization, 2) chemical manufacture, 3) firefighting, 4) food freezing and processing, 5) foundry-mold preparation, 6) greenhouses, 7) mining operations, 8) oil well secondary recovery, 9) rubber tumbling, 10) therapeutical work, 11) welding, and 12) extraction processes [4]. Depending on the application, purification of this CO_2 may be required.

Most significantly, of the twelve uses listed above, only in the manufacture of chemicals (#2) is CO_2 consumed (i.e., reacted to form a different carbon-containing chemical). None of the other commercial uses of CO_2 actually consume CO_2. In fact, it is clear from the CO_2 production and emission numbers (Figure 2) that the industrial consumption of CO_2 constitutes only a negligible fraction of all the CO_2 produced by human activities and it is doubtful that this fact will change in the foreseeable future [6,7]. Hence, other means besides CO_2 consumption must be considered to mitigate the CO_2 emissions from industrial and energy-related sources. There are many programs outside the scope of this report addressing these issues (e.g., new power plant design, Kyoto protocol, carbon tax structure, sequestration).

CO_2 Removal Processes

There are three incentives to remove CO_2 from a process stream. First, and in most cases, CO_2 is being removed from a valuable product gas, such as H_2, where it is eventually emitted to the atmosphere as a waste by-product. Second, CO_2 is recovered from a process gas, such as in ethanol production, as a saleable product. However, as mentioned above, only a modest fraction of the CO_2 produced is marketed as a saleable product, and much of this CO_2 finds its way to the atmosphere because the end use does not consume the CO_2. Third, CO_2 is recovered simply to prevent it from being released into the atmosphere, but, this necessarily requires sequestration of the recovered CO_2. In spite of the Kyoto Protocol and potential penalties and taxes associated with CO_2 emissions, there is little if any use of commercially available CO_2 capture processes for this purpose. At the moment these processes are simply too expensive to use, and in most cases there is no place to put the CO_2 once it is captured.

Processes to remove CO_2 from gas streams vary from a simple once-through wash or treatment operations to complex multistep recycle systems. Most of these processes were developed for natural gas sweetening or H_2 recovery from syngas. Recently, interest has built on the capture of CO_2 from flue gas, and even landfill gas and coal bed methane gas. Natural gas, flue gas, landfill gas, and coal bed methane gas systems are more complex than the typical H_2 system. Along with CO_2, other contaminants generally must be removed or handled. Among these are particulates, H_2O, N_2, H_2S, and C_{2+} hydrocarbons and trace elements in various oxidation states. In addition, flue gas, coal bed methane and some landfill gases contain O_2 that can interfere with certain CO_2 separation systems. This complication is generally not present in natural gas, most landfill gas, or H_2 systems. For these reasons, commercial CO_2 gas treatment plants are usually

integrated gas processing systems; few are designed simply for CO_2 removal.

Four different CO_2 removal technologies are widely practiced in industry. These are 1) absorption, both chemical and physical, 2) adsorption, 3) membranes, and 4) cryogenic processes [8]. Tables 4 and 5 provide information on CO_2 removal technologies in terms of the number of patents and or peer-reviewed articles published by a company or research team since 1995 and since 2005. Table 6 lists the licensors of CO_2 separation processes as of 2004 [9].

Absorption Processes

The overwhelming majority of CO_2 removal processes in the chemical and petrochemical industries take place by absorption (see Table 6). The chemical process industries (CPI) removes CO_2 to meet process or product requirements (e.g., the production of natural gas requires the removal of CO_2 in order to be effectively utilized). Other examples include the removal of CO_2 from the circulating gas stream in ammonia manufacture or ethylene oxide manufacture.

A variety of liquid absorbents are being used to remove CO_2 from gas streams. Absorption processes generally can be divided into two categories. Processes where the solvent chemically reacts with the dissolved gas are referred to as chemical absorption processes. For these applications alkanolamines are commonly used as reactive absorbents.

Physical absorption processes are those where the solvent only interacts physically with the dissolved gas. Here a solvent is used as an absorbent with thermodynamic properties such that the relative absorption of CO_2 is favored over the other components of the gas mixture. Some commonly used physical solvents are methanol (Rectisol Process) and glycol ethers (Selexol Process).

In many industrial applications, combinations of physical solvents and reactive absorbents may be used in tandem. Table 7 lists the most widely used absorbents. These include monoethanolamine (MEA), diethanolamine (DEA), diisopropanolamine (DIPA), methyldiethanolamine (MDEA), and diglycolamine (DGA). Ammonia and alkaline salt solutions are also used as absorbents for CO_2. Water is used as a CO_2 absorbent, but only at high pressures where solubility becomes appreciable. However, in all cases solvent recycling is energy and capital intensive.

Tables 7 and 8 compare key properties of some of the important alkanolamines used in acid gas treating. Ethanolamine has the highest capacity and the lowest molecular weight. It offers the highest removal capacity on either a unit weight or a unit volume basis.

Table 8 also lists the major types of CO_2 and acid gas absorption processes that are commonly used in gas treating. Of the CO_2 producing processes listed above, natural gas, H_2, syngas, and NH_3 production, as well as coal gasification, utilize absorption processes for removing CO_2 and or acid gases. As far as the authors are aware, the use of CO_2 scrubbers for the production of CO_2 from the iron and steel, cement, lime, and aluminum industries and from combustion is virtually non-existent.

Natural gas is treated to remove the acid gas constituents (H_2S and CO_2) by contacting the natural gas with an alkaline liquid. The most commonly used treating solutions are aqueous solutions of the ethanolamines or alkali carbonates, although a considerable number of other treating agents have been developed in recent years, as illustrated in Tables 6 to 8. Most of the newer treating agents rely on a combination of physical absorption and chemical reaction. When only CO_2 is to be removed in large quantities, or when only partial removal is necessary, a hot carbonate solution or one of the physical solvents is economical preferred.

MEA has good thermal stability, but reacts irreversibly with COS and CS_2. In addition to the main desired, readily-reversible product, ammonium bicarbonate, MEA also reacts with CO_2 to give a series of products that lead to slow losses of this alkanolamine. More serious is the MEA loss by evaporation. Its vapor pressure is much higher that those of the other compounds in Table 7. Thus, using MEA to meet pipeline specifications for H_2S may be difficult.

DEA has a lower capacity than MEA and it reacts more slowly. Although its reactions with COS and CS_2 are slower, they lead to different products that cause fewer filtration and plugging problems. Triethanolamine has been almost completely replaced in sour gas treating because of its low reactivity toward H_2S. Diglycolamine has the same reactivity and capacity as DEA, with a lower vapor pressure and lower evaporation losses.

DIPA is used in the Sulfinol and Shell Adip processes to treat gas to pipeline specifications. DIPA can remove COS and is selective for H_2S removal over CO_2 removal. MDEA selectively removes H_2S in the presence of CO_2, has good capacity, good reactivity, and very low vapor pressure. As a result, MDEA is a preferred solvent for gas treating.

By-product CO_2 from H_2, syngas and NH_3 production via methane stream reforming is recovered using hot carbonate absorption or MEA absorption. The hot carbonate systems used in many ammonia plants typically afford 95-97 vol% CO_2 byproduct. MEA systems generally are capable of recovering a CO_2 stream that is 99.5+ vol% pure. Indeed, saleable CO_2 is being recovered from H_2, syngas and NH_3 production plants, where absorption processes are being used. Here the scrubber delivers a high-purity CO_2 product which requires little, if any, further purification.

Coal gasification to produce syngas (mostly $CO + H_2$) also yields some CO_2 that generally must be removed before using the syngas (e.g., for making methanol or acetic acid). If water gas shift is used to make more H_2, the by-product is additional CO_2. Also, for synthetic natural gas (SNG) production via coal gasification followed by methanation, some CO_2 is recovered. Recovery of the CO_2 requires treating a gas stream rich in CH_4 and H_2O. Absorption processes similar to those used in H_2, syngas and NH_3 production also are used in coal gasification.

Flue gas from combustion processes associated with burners, flaring, incineration, utility boilers, etc. contain significant amounts of CO_2. However, as discussed above, this CO_2 is generally of low quality because its concentration tends to be low, the flue gas is very hot, and it contains a variety of other gasous species and particulates that make CO_2 recovery difficult and expensive. Nevertheless, CO_2 is being recovered from flue gas for commercial use [9]. A train of separation and purification equipment is being used, with the CO_2 being removed via MEA absorption

technology, which was developed in the 1970s and 1980s for enhanced oil recovery [8].

Fluor Enterprises Inc. has 24 Econamine FG plants operating worldwide and producing a saleable CO_2 product for both the chemical and food industries. Randall Gas Technologies, ABB Lummus Global Inc. has four installations of similar technology operating on coal fired boilers. Two of these plants produce chemical grade CO_2 and the other two plants produce food grade CO_2. Mitsubishi Heavy Industries Ltd. also has commercialized a flue gas CO_2 recovery process, based on their newly developed and proprietary hindered amine solvents (KS-1, KS-2 and KS-3). As of April 2005, they have agreed to license two KD CDR Process[1] plants to a fertilizer company in India. Each plant can capture 450 metric tons per day of CO_2, making them the world's largest CO_2 recovery plants. It appears that these are the only examples of marketing flue gas CO_2 recovery technology.

With CO_2 emissions becoming more of a concern worldwide, and with absorption processes dominating CO_2 removal from industrial streams, the literature on the subject of CO_2 removal has grown substantially in the last few years. A review of the recent literature identified about 230 articles since 2000. Table 9 lists the number of papers and the corresponding absorbent that was studied. Although other reactive absorbents are represented, the family of amines is clearly dominant. It is noteworthy that a recent review article on this subject was not found during this search. Clearly, a review of the recent literature on absorption processes for the removal of CO_2 and other acid gases from process streams would be quite valuable.

Adsorption Processes

Only a few classes of adsorbents and adsorption processes are being used to remove CO_2 from gas streams. These adsorbents include aluminosilicate zeolite molecular sieves, titanosilicate molecular sieves, and activated carbons. CO_2 adsorption capacities of typical commercial adsorbents are given in Table 10. Other classic adsorbents are being used to remove contaminants from CO_2 streams destined for commercial use. In this case, the adsorbents include activated carbons for sulfur compounds and trace contaminant removal, silica gels for light hydrocarbon removal, and activated aluminas, bauxite, and silica gels for moisture removal. The adsorption processes include pressure swing adsorption (PSA), temperature swing adsorption (TSA), and hybrid PSA/TSA. Of the CO_2 producing processes listed above, only H_2, syngas, NH_3, fermentation ethanol, natural gas, and combustion are beginning to use adsorption processes for removing or purifying CO_2.

By-product CO_2 from H_2 production via methane stream reforming is recovered using PSA in lieu of absorption. In the early 1980s, new H_2 plants were being built with PSA units as the main H_2 purification process. This eliminated the CO_2 scrubber, the low temperature CO shift reactor and the methanation reactor. The PSA unit offers advantages of improved H_2 product purity (99-99.99 vol% H_2, 100 ppmv CH_4, 10-50 ppmv carbon oxides, and 0.1-1.0 vol% N_2) with capital and operating costs comparable to those of wet scrubbing.

Modern PSA plants for H_2 purification generally utilize layered beds containing 3 to 4 adsorbents (e.g., silica gel or alumina for water, activated carbon for CO_2, and 5A zeolite for

[1] Kansai-Mitsubishi proprietary Carbon Dioxide Recovery Process

CH_4, CO, and N_2 removal). Depending on the production volume requirements, from four to sixteen columns are used in tandem. The PSA unit is operated at ambient temperature with a feed pressure ranging between 20 and 60 atm. Hydrogen recovery depends on the desired purity, but ranges between 60 and 90%, with the tail gas (i.e., the desorbed gas containing H_2O, N_2, CO_2, CH_4, CO, and H_2) generally being used as fuel for the reformer.

Although PSA systems are increasingly used for H_2 recovery, they yield a by-product CO_2 stream that is only about 50 vol% pure. Low purity makes this tail gas stream less attractive as a commercial CO_2 source. PSA systems are under development to process this tail gas into H_2 and CO_2 rich streams, as discussed later in the *Emerging Literature Concepts* section (see page 12).

Fermentation to produce ethanol has recently emerged as a major source of CO_2 by-product for industrial use. The crude by-product is typically 99.8% pure CO_2 on a dry basis. But the product is wet (saturated with water at ambient temperature) and not odor-free. After recovery, the CO_2 is usually washed with a simple water scrubber to remove water soluble compounds. It is then treated with activated carbon to remove traces of H_2S, SO_2, and organics. The gas is finally dried with activated alumina, bauxite, or silica gel before compression and cooling to the liquid or solid form. When destined for large-scale industrial use (urea, enhanced oil recovery, industrial inerting, etc.), the purification is not as exacting as it is for food grade CO_2.

The composition of natural gas varies widely depending on the location of the well. Since landfill gas and coal bed methane gas are somewhat similar in composition to natural gas, they are included here for convenience. The CO_2 concentration in natural gas varies between 3 and 40 vol%; but it could be as high as 80 vol%. Because of the complexity and variability of the composition of natural gas, a train of separation processes, including adsorption, absorption, and cryogenic and membrane separation, may be used to process it into pipeline quality methane. CO_2 traditionally has been removed using an amine-based scrubbing process, as described in detail above. However, PSA technology is beginning to supplant some of the absorption technology in natural gas treatment, especially in the so called shut-in natural gas wells that previously contained too much N_2 to justify processing. The molecular gate adsorption technology commercialized by Engelhard Corporation uses a titanosilcate adsorbent combined with a PSA process in a vacuum swing adsorption mode to remove N_2 and/or CO_2 from natural gas streams. Two of these units were in operation as of 2004 [9].

To remove CO_2 from coal bed methane, Engelhard Corporation uses molecular gate adsorption technology with a more traditional PSA mode with compressed feeds ranging in pressure from 80 to 800 pounds per square inch gauge (psig) [10]. Ten of these units are being built and three are in operation for upgrading methane from abandoned coal mines [10]. Similarly, Axens has commercialized natural gas purification technology, based on alumina and zeolite molecular sieve adsorbents and a TSA regeneration mode. The alumina removes trace and bulk contaminants in the natural gas other than CO_2 through both chemisorption and physisorption mechanisms. The zeolite molecular sieve serves to remove CO_2 and other contaminants via physisorption. Axens has over 60 installations operating worldwide that treat a variety of natural gas and industrial process streams [9].

The recovery of CO_2 from flue gas by adsorption technology is not commonly practiced by

industry. The only example was obtained from a recent report in the literature that indicated CO_2 is being recovered from flue gas commercially using a layered PSA bed containing X and A type zeolites and activated carbon in Japan [11]. Neither the flow sheet nor the purity of the recovered CO_2 is known; but, the CO_2 appears not to be used for commercial applications.

Membrane Processes

In general, membrane technology for separating gas streams is attractive for many reasons [12-19]. First, it neither requires a separating agent nor involves phase changes. As a consequence, the elevated processing costs associated with regeneration and phase change are eliminated. In addition, membrane systems involve small footprints compared to other processes and require low maintenance. They are also compact and lightweight and can be positioned either horizontally or vertically, which is especially suitable for retrofitting applications. Finally, the modular aspect of membrane units allow for multi-stage operation and linear scale up costs.

Membranes are an appealing option for CO_2 separation, mainly because of the inherent permeating properties of this species. CO_2 is a very small gas molecule, with a smaller kinetic radius (i.e., 3.3 Angstrom units (Å)) than lighter gases, such as O_2 (3.46 Å), N_2 (3.64 Å) and CH_4 (3.8 Å). In fact, among permanent gases, only He (2.59 Å) and H_2 (2.89 Å) are smaller than CO_2. Hence, CO_2 is a fast diffusing gas in many membrane materials, such as glassy and rubbery polymers, molecular sieves, and several other inorganic materials. On the other hand, CO_2 also has a relatively high molecular weight and a large quadruple moment, enabling it naturally to adsorb more strongly to or dissolve at much higher concentrations in these membrane materials compared to many other gas species. These properties give rise to very high CO_2 permeation rates and selectivities over many other gas species, sometimes even higher than H_2 and He.

Membrane systems potentially or actually commercialized for gas separations are listed in Tables 4 and 5, with the number commercialized given in Table 6. Of the CO_2 producing processes listed above, only natural gas production, to a lesser extent landfill gas production, and H_2, syngas, and NH_3 production are beginning to use membrane processes for removing or purifying CO_2.

The first commercial cellulose acetate membrane units for CO_2 removal from natural gas were implemented only few years after the introduction in 1980 of the first commercial PRISM membrane air separation system developed by Monsanto [14,15]. By the end of the 1980s companies such as Natco (Cynara), UOP (Separex) and Kvaerner (Grace Membrane Systems) were producing membrane plants for this purpose. A few years later, more selective polyimides and only recently polyaramides were slowly introduced to displace the old cellulose acetate systems. Today, commercial membrane technology for CO_2 separation is largely based on glassy polymeric materials (cellulose acetate, polyimides, and polyaramides).

Currently, the membrane market devoted to CO_2 separation from natural gas is about 20%, which is only 2% of the total separations market for natural gas. Amine-based absorption processes dominate this market, as shown in Table 6. Membranes are used in situations where the produced gas contains high levels of CO_2. However, a key sensitivity with these current membranes is that they must be protected from the heavier C_{5+} hydrocarbons present in wet

natural gas streams. Exposure to these compounds immediately degrades performance and can cause irreversible damage to the membranes.

Membranes for large-scale recovery of CO_2 from, for example, natural gas for use as a salable product are a relatively recent development. As gleaned from above, current membranes have been designed generally to remove unwanted CO_2 from a desired product, rather than to recover CO_2 for its own value. The advent of enhanced oil recovery (EOR) projects using CO_2 has changed this situation. Natural gas fields in West Texas now recover CO_2 that is pipelined to areas where it is needed for EOR. A variety of membranes, including ones with separating layers made of cellulose acetate, polysulfone, and polyimide, are used for this purpose. Air Products and Chemicals and Ube are marketing membrane systems for EOR and landfill gas upgrading, respectively.

Membrane units have also been commercialized for H_2 purification in reforming processes (UOP, Air Products and Chemicals). For example, membrane processes, such as the Polysep membrane systems developed by UOP and the PRISM membrane systems developed by Monsanto and now sold by Air Products and Chemicals [9] recover H_2 from various refinery, petrochemical, and chemical process streams. Both are based on polymeric asymmetric membrane materials composed of a single polymer or layers of at least two different polymers, with the active polymer layer being a polyimide. The PRISM system is based on a hollow fiber design and Polysep is a spiral-wound, sheet-type contactor. Both are used to recover H_2 from refinery streams at purities ranging from 70 to 99 vol% and with recoveries ranging from 70 to 95%. Relatively pure H_2 containing a very low concentration of CO_2 leaves these units in the low pressure permeate stream. This stream can be sent to a methanator for CO_2 removal and further purification. The high-pressure retentate stream, consisting of H_2 and CO_2 with low concentrations of CO and CH_4, can be used as fuel.

Cryogenic Liquefaction Processes

Recovery of CO_2 by cold liquefaction has the advantage of enabling the direct production of very pure liquid CO_2, which can be readily transported. Liquefaction is achieved by the dual action of external refrigeration and the Joule-Thompson effect that results from the compression and adiabatic expansion of the stream. The disadvantages associated with the cryogenic separation of CO_2 are the amount of energy required in refrigeration, particularly in dilute gas streams, and the requirement to remove gases, such as water and heavy hydrocarbons, that tend to freeze and block the heat exchangers.

Liquefaction technology for CO_2 recovery is still incipient. Cryogenic CO_2 recovery is typically limited to streams that contain high concentrations of CO_2, with a lower limit of about 50 vol%, but with a preferred concentration of > 90 vol%. It is not considered to be a viable CO_2 capture technology for streams that contain low concentrations of CO_2, which includes most of the industrial sources of CO_2 emissions. Cryogenic separation of CO_2 is most applicable to high-pressure gas streams, like those available in precombustion and oxyfuel combustion processes [2]. One exception is for the production of ethanol through fermentation. In fact, liquefaction is generally practiced in this case to produce a highly pure liquid CO_2 product. Details about this cryogenic CO_2 process are not readily available, however.

Nevertheless, cryogenic CO_2 recovery is increasingly being used commercially for purification of CO_2 from streams that already have high CO_2 concentrations (typically > 90%). Of the CO_2 producing processes listed above, only ethanol production and H_2, syngas, and NH_3 production utilize (or are beginning to utilize) cryogenic processes for removing or purifying CO_2. Tables 4 and 6 provide some information on the cryogenic systems that are described in the literature.

Currently, Costain Oil, Gas & Process Ltd. has commercialized a CO_2 liquefaction process with around seven units installed worldwide. The process is assisted by membrane technology to treat streams with CO_2 fractions greater than 90 vol%. Recently, Fluor Enterprises Inc. also developed a CO_2 liquefaction process called CO_2LDSEP. This technology exploits liquefaction to separate CO_2 from H_2 and other gases in the tail gas of a H_2 purification PSA unit. However, no commercial operational units of this technology have been reported.

Summary of Current Commercial Practices

The four most widely used commercial CO_2 removal processes are: absorption, adsorption, membranes, and cryogenic processing. Absorption is by far the most prevalent CO_2 removal process. An overview of the sources of CO_2 emissions and CO_2 production processes is provided to exemplify that although most of the CO_2 emissions are from the generation of electricity, industrial point sources can be significant. For a more detailed review of CO_2 emissions and sources, see *Supportive Information on Environmental CO_2 Emissions* section on page 38.

This report is designed to promote the development of new adsorption, absorption, and membrane technologies for CO_2 recovery and capture from commercial processes. Special emphasis has been placed on fostering the development of separation technologies that are economically sound and effective under the operating conditions of CO_2-producing processes. The uses of adsorption, absorption, and membrane processes in CO_2 removal from industrial process streams are reviewed. Emerging concepts for new approaches in separation are highlighted in the next section of this report; some of the information dates back a few decades. That section is followed by recommendations for future R&D.

EMERGING LITERATURE CONCEPTS

The goal of this report is to achieve energy savings and to improve CO_2 separation process performance and economics. To set forth recommendations for future R&D on CO_2 removal processes, key factors must be considered: 1) the large scale and conditions of industrial production, 2) materials requirements, 3) economic goals and drivers, and 4) purity demands of gases involved. To this end, emerging literature concepts in adsorption and membrane technology for CO_2 removal are reviewed and recommendations are set forth for future R&D. Valuable guidance for this report has been provided by the Vision 2020 committee of industrial scientists active in the field and leading academic scientists referenced at the beginning and end of this report.

For this review, a focus has been placed on emerging concepts in the separation sciences to overcome the limitations of current CO_2 removal processes. The potential for novel adsorbents and membranes and associated processes are outlined. Many opportunities are identified, including hybrid systems that have the potential for significant improvement in separation technology.

Adsorption

The emerging literature concepts on the use of adsorbents and adsorption processes in the chemical and petrochemical industries that produce CO_2 have focused on a few processes. These include the H_2, syngas, and NH_3 production processes, and the natural gas production processes, which include landfill gas and coal bed methane gas. Emerging literature concepts on the use of adsorbents and adsorption processes to remove CO_2 from flue gas generated from fossil fuel combustion also have been identified. A survey of the recent literature in these areas is given below. The latest developments in PSA and TSA process refinements, sorption enhanced reaction processes (SERP) or periodic adsorptive separating reactors, and selective adsorbents for CO_2 are discussed. The concepts presented in these studies have the potential for both near-term and longer-term impact on adsorption technology for the removal of CO_2 from industrial process streams. Tables 10 and 11 respectively provide a list of adsorbents and PSA cycle configurations currently being investigated for CO_2 removal.

Adsorption Process Refinements

Adsorption-based CO_2 separation and capture technologies are based primarily on thermal and pressure swing regeneration processes (i.e., TSA and PSA technologies). These are well known cyclic adsorption processes with many commercialized gas separation and purification applications. The performance, cost, and reliability of the adsorbent used arekey to its successful commercial acceptance. Another key to success in both PSA and TSA processes is matching the adsorbent with the cycle configuration.

Major breakthroughs in PSA technology for large-scale H_2 purification and associated CO_2 removal were realized in the early 1970's with the development of a 4-bed, multi-layer PSA process. Modifications to improve separation efficiency have included additional beds, typically 7 to 10 beds [20] as many as 16 beds [21], and tanks for storing intermediate process streams

between cycle stages. Along with these additional beds and tanks came more complex cycle sequencing to achieve higher throughputs with the same or even less volume of adsorbent distributed in the additional beds.

Each bed in a PSA plant undergoes adsorption and regeneration cycle steps. These steps include 1) pressurization, 2) high pressure feed, 3) co-current depressurization, 4) counter-current depressurization, 5) counter-current purge (light reflux), and 6) several equalization (pressurization/depressurization) steps between two beds. Improvements, not only in H_2 purification PSA plants but also in CO_2 concentration and recovery PSA plants, can be realized by 1) further refinement of these cycle steps, 2) addition of new cycle steps, and 3) novel refinement of the cycle sequencing to create a more effective separation processes.

The evolution of H_2 PSA technology is a good example of how simple cycle modifications can have a significant impact on the process performance, and shows that intuition may not always be correct. Whysall and Wagemans of UOP [21] recently demonstrated that the duration of the purge step does not have to be equal to or less than the duration of the adsorption step and, by extending the purge step, the production capacity of a PSA H_2 plant for the first time could exceed 110 Nm^3/hr using 16 beds. Baksh et al. of Praxair Technology, Inc. [22,23] decreased the number of PSA beds with the judicious use of storage tanks to collect and reuse gas during cycle steps so as to increase H_2 production per unit adsorbent. [23] also shows that the PSA process performance can be improved significantly by first removing N_2 from the feed stream using modified (via cation exchange) X-type zeolite adsorbent, which also advantageously remove CO_2. Xu and Weist of Air Products and Chemicals [24] modified the pressure equalization steps by using four steps with just six beds, and decreasing the cycle time for pressure equalization between beds [25]. Most of these changes are not obvious but have provided a path way for improved separations.

Sircar and Golden [26] describe several other novel approaches to PSA cycle sequencing for both H_2 purification and simultaneous H_2 and CO_2 purification. The latter PSA cycle involves two interconnected cascades of PSA beds each operating with their own unique cycle sequence and number of beds. The complexity between the different cycle steps in a H_2 purification PSA unit has recently been reported by Waldron and Sircar [27]. Many improved and novel PSA cycle sequences are anticipated for use in CO_2 recovery plants, based on continued industrial and academic research.

Another way to improve the performance of a PSA process is to decrease the cycle time, which allows more gas to be processed using less adsorbent. This is referred to as rapid-cycle PSA. For example, QuestAir recently announced an improved H_2 purification technology employing a rapid-cycle PSA unit with a rotary valve. This technology is planned for installation in the largest liquid H_2 plant in Asia, which will be fabricated in Japan.

Rapid-cycle PSA is not a new concept; however, it required major innovations in process design for handling the gas streams before commercialization became feasible. This innovation has been reported in a series of patents by Keefer and Doman of QuestAir Technologies [28-30] which describe the rotary valve and multi-bed cycle sequencing approaches. The same rapid-cycle PSA concepts based on a rotary valve are now being applied by QuestAir to remove CO_2 from natural gas and landfill gas.

Adsorbent attrition and intraparticle mass transfer effects still limit how rapidly the cycle sequencing can be carried out. This problem partly has been alleviated with the recent development of novel structured adsorbents, incorporating very small commercially available adsorbent particles or crystals, like activated carbons and zeolites, in a support material like a sheet of paper. In this way, the effects of mass transfer and adsorbent attrition are minimized. Structured adsorbent materials are described in the recent patents by Golden et al. of Air Products and Chemicals [31-33], and by Keefer et al. [34].

With the development of a very thin, paper like, structured adsorbent material by QuestAir came the development of a second generation, ultra rapid-cycle PSA H_2 purification system. In this system, a rotary adsorbent bed concept has supplanted the rotary valve concept, with the rotary adsorbent bed being comprised of multiple beds within one cylindrical adsorber unit [35]. This unique configuration has resulted in a very compact PSA unit that can be operated at very short cycle times and thus very high H_2 production rates. ExxonMobil recently partnered with QuestAir Technologies to design and build a rotary bed PSA plant for the recovery of H_2 from the tail gas of a conventional H_2 PSA plant [36]. This rotary adsorbent bed concept is certainly applicable to CO_2 capture and concentration from a variety of process streams. However, further improvements in this technology are required for this application, including the continued development of new structured, multilayered adsorbents, with each layer containing an adsorbent that is selective to one or more of the gases to be separated.

A comprehensive review of relevant studies that deal with removing and concentrating CO_2 from simulated flue and stack gases by various PSA cycles has been given recently by Reynolds and co-workers [37]. Table 11 provides a summary of the performances of these various PSA cycles. All utilize a light, heavy, dual, or even a no reflux PSA cycle configuration, intermixed with various cocurrent and or countercurrent depressurization steps, feed, light product, and heavy product pressurization steps, and null (delay) and pressure equalization steps. Note the heavy and dual (light and heavy) reflux cycle steps have been included to concentrate the heavy component (e.g., CO_2). H_2 PSA plants, which have been designed specifically for producing a very pure light component (e.g., H_2,) only include a light reflux step. The heavy reflux step, or so called high pressure rinse step, has been introduced in several PSA patents with only limited commercialization. Not surprisingly, the fairly complicated two-cascade PSA system developed by Sircar and Golden [26] utilizes a heavy reflux step in the cascade that produces the concentrated CO_2; the other cascade uses only the light reflux purge step to produce the high purity H_2.

In addition, these PSA cycles being studied for removing and concentrating CO_2 from simulated flue and stack gases also utilize 1) a vacuum swing cycle with the high pressure set just above atmospheric pressure and the low pressure set at some vacuum level, or 2) a more conventional pressure swing cycle with the purge or low pressure set at or near atmospheric pressure and the feed set at a higher pressure. To concentrate and recover CO_2 from flue or stack gas, most PSA cycles utilize one or more commercially available adsorbents that exhibit a high capacity for CO_2 at ambient temperature and pressure (e.g., activated carbon, carbon molecular sieve, and X and Y type aluminosilicate zeolites). Some of these cycles also utilize a developmental adsorbent (i.e., a K-promoted hydrotalcite-like (HTlc) adsorbent that exhibits a high capacity for CO_2 at elevated

temperatures (e.g., 300 to 500°C) and ambient pressure).

It is clear from the summary in Table 11 that there are numerous designs for operating PSA processes. This also illuminates the challenge associated with choosing one PSA cycle over another one for a given application. After carefully examining the results summarized in Table 11, in most cases it is still not clear which PSA cycle would be more advantageous. For example, it could easily be reasoned by the expert that it would be inappropriate to use a no reflux cycle or just a light reflux cycle in an attempt to concentrate a heavy component by PSA. But even in this light reflux only case, a particular PSA cycle outperformed a PSA cycle with heavy reflux, depending on many factors like the process conditions, cycle times, bed sizes, adsorbent CO_2 capacity, or even the addition of a light end equalization step [38], all of which are interrelated. So, it appears that a PSA cycle with light reflux for concentrating a heavy component can be considered for separating CO_2, especially since a light reflux-only PSA cycle reduces the capital and operating costs by avoiding the use of an additional compressor for implementing a heavy reflux step.

Hence, PSA cycle configurations are difficult to predict, understand, and interpret, even for an expert. A better understanding of these heavy and dual reflux cycles through R&D clearly is warranted so that more efficient PSA processes can be developed for current commercial separations and for concentrating CO_2 from stack and flue gases. This is true in regard to both the more conventional multi-bed PSA process and to the new rotary bed process described above.

TSA is also being explored for CO_2 capture and concentration from stack and flue gases. For example, Ding and Alpay [39] used K-promoted HTlc as the adsorbent in a TSA process for CO_2 removal from high temperature streams. In a TSA mode, the adsorbent bed is usually regenerated by using a hot purge gas to effect desorption of CO_2. This purge gas (e.g., steam) can be any gas that does not adsorb appreciably on the adsorbent at the desorption temperature.

PSA processes are also being developed for CO_2 removal from natural gas [40-42], and even landfill gas [43,44] and coal bed methane [10, 45-48]. For example, Engelhard Corporation developed a PSA process to remove H_2O, CO_2, and heavier hydrocarbons from methane using their Molecular Gate adsorbent technology. These adsorbents are comprised of titanium silicate molecular sieves that were originally developed to remove only N_2 from natural gas by kinetic separation. This class of materials was subsequently found to provide uniquely higher kinetic and adsorption selectivities for CO_2 and H_2O, exceeding those of more traditional aluminosilicate molecular sieves. A typical PSA system using the Molecular Gate adsorbent to separate CO_2 from CH_4 rich gas streams at feed pressures between 100 and 800 psia produces a product stream containing CH_4 at concentrations of > 90 vol%. This commercial technology is able to process gas streams containing up to 30 vol% CO_2 with favorable economics [40,42].

Over the past decade, academic researchers also have focused on the development, understanding, and optimization of new PSA cycle configurations for gas separation and purification. For example, Jiang and co-workers [49] are developing important optimization tools for multi-bed PSA processes, especially for H_2 purification and CO_2 recovery. Process design and fine tuning offers opportunities for significant improvements in the PSA process

performance. However, this work needs to be extended to include the number of beds and all possible cycle steps for robust optimization.

Warmuzinski and Tanczyk [50,51], Lee and coworkers [52-54], Reynolds and co-workers [55], and others are studying the design of multi-layered adsorbent beds through mathematical simulation and bench scale experimentation. Multi-layed beds are the industrial standard; however, very little information has been published on the design and optimization of layered bed PSA processes. Most published work involving the purification of H_2 simply reports the performance of a given layered bed; they do not address optimizing the number of layers, types of adsorbents, or depth of each layer. More PSA R&D is needed in the area of recovering the heavy component, like CO_2, from a gas streams.

Some very novel PSA cycles were introduced to the literature by Diagne and co-workers in Japan [56-59] followed by the work of Mcintyre et al. and Reynolds et al. [60,61]. Both groups are studying PSA cycles to concentrate the heavy component in gas streams. The feed step is maintained at low pressure and the adsorbent bed enriches the gas phase with the heavy component due to desorption [61]. This kind of PSA cycle was first described by Wilson [62] and has recently appeared in two patents [63,64].

These uncommon enriching PSA cycles operate in stark contrast to common stripping PSA cycle configurations. The word "stripping" is used to denote that the feed step is carried out at the high pressure and that the adsorbent strips the heavy component from the gas phase due to selective adsorption, whereas the word "enriching" is used to denote that the feed step is carried out at the low pressure and that the adsorbent bed enriches the gas phase with the heavy component due to desorption [61]. Hence, an enriching PSA cycle functions in a reversed or inverted mode compared to a stripping PSA cycle. It appears that the vast majority (> 99%) of the PSA literature involves only the stripping PSA cycle concept. Hence, very little is known about the operation and performance of an enriching PSA cycle [56-59].

Another novel feature includes feeding a PSA column at intermediate position between the ends of the column. In this mode, the feed can be introduced at high (stripping) or low (enriching) pressure, and light and heavy reflux operations can be carried out simultaneously at the respective ends of the column. This type of PSA process mimics the behavior of a distillation column. Dong et al. [65] borrowed ideas from distillation and applied them to PSA by interconnecting two or more sets of twin columns through side, top, and or bottom ports for feeding, recycling, and or collecting gases. This concept was demonstrated by separating a ternary gas mixture (i.e., CO_2-CH_4-N_2) into three enriched products. In one case activated carbon was used in both sets of columns; in two other cases they used activated carbon in one set of columns and layered 13X zeolite and carbon molecular sieve in the other set of columns. The possibility of treating complex gas streams containing multiple components, such as natural gas, landfill gas, and coal bed methane gas streams, with multiple adsorbents appears feasible with these PSA cycles. Clearly, more research needs to be done with these PSA cycles that mimic multi-component distillation operations.

Sorption Enhanced Reaction (Periodic Adsorptive Separating Reactors)

Conducting reaction and adsorptive separation in a single fixed bed reactor configuration dates back to 1987, beginning with the work of Vaporciyan and coworkers [66-68]. The general idea is to use the adsorbent to selectively remove one or more of the products formed from an equilibrium limited reaction to shift the equilibrium in favor of increased conversion. The adsorbent is then regenerated with a pressure or temperature swing. Improved adsorbents with greater selectivity, larger working capacity, more rapid adsorption and desorption kinetics, and reduced sensitivity to moisture and other poisons are required for this approach to become of commercial interest. These separation characteristics are required at elevated process temperatures. Because performance of most commercial adsorbents like zeolites, activated carbons, activated aluminas or silica gels is lacking at the higher operating temperatures which is typical of the regeneration conditions, the development of new adsorbents is needed specifically for these high temperature applications.

A team at Air Products and Chemicals has developed adsorptive separating reactors using the SERP process. SERP is a fixed bed process with the reactor containing a mixture of a conventional catalyst and a selective, high-temperature adsorbent. For an equilibrium limited reaction, the adsorbent shifts the equilibrium in favor of higher conversion through Le Chatlier's principal. When the adsorbent becomes saturated with the product, a simple pressure swing in the bed can be used for regeneration.

In a series of patents [69-73] and three publications [74-76], this group discusses a redesign of the methane reforming operation. For this approach a high temperature CO_2 selective adsorbent is mixed with a typical reforming catalyst to conduct the steam methane reforming and water gas shift reactions in one unit and at lower temperatures. Reforming can be practiced at these lower temperatures because of the *in situ* removal of CO_2 [71,73]. Medium purity H_2 production (~ 95%) was achieved by conducting this SERP process in a water gas shift reactor containing the catalyst and a CO_2 selective adsorbent. The feed for this unit was obtained from a conventional steam methane reformer [77].

In a more general patent, three uses of the SERP concept are discussed [78]. In the first case steam methane reforming is driven using CO_2 and or CO selective adsorbents. In the second case, methane reforming with CO_2 can be revamped by using CO or H_2 selective adsorbents. In the third case, H_2O selective adsorbents are used in the production of CO using a reverse water gas shift reactor. An emphasis is placed on the judicious use of these different adsorptive reactors to optimize the production of H_2, CO, or syngas from the reforming of methane. There appears to be significant potential for the development of additional applications of and new adsorbents for the SERP concept, especially for CO_2 removal and concentration.

Some very recent work on the SERP concept by Hufton et al. [79] involves the development of precombustion decarbonization technology for CO_2 capture from to integrated gasification combined cycle (IGCC), natural gas combined cycle (NGCC), or related combined cycle processes. This process is referred to as sorption enhanced water gas shift. It involves a multi-bed PSA process operating at high temperature with the columns again packed with catalyst and K-promoted HTlc. CO is converted to CO_2 which is quickly removed by the CO_2 selective

adsorbent. This *in situ* removal of CO_2 facilitates more conversion of the CO to CO_2 through Le Chatlier's principal, as discussed above. A H_2 product free of CO_2 is produced at high pressure and temperature. This gas is burned in a high efficiency gas turbine. After a series of PSA cycle steps, including a heavy reflux step, a concentrated CO_2 product is produced at low pressure. This CO_2 product could be recovered, and either sold for industrial or commercial use or further processed for sequestration.

The success of the SERP relies on CO_2, H_2O and even H_2 selective adsorbents. The preferred CO_2 adsorbents include: K-promoted HTlc, modified double layer hydroxides, spinels, and modified spinels, with metal oxides and mixed metal oxides of Mg, Mn, La and Ca, and clay minerals such as sepiolite and dolomite [71-73,76,77]. The preferred H_2O adsorbents include commercially available A, X and Y zeolites, mordenites, aluminas, and silica gel [69,70,78]. The preferred H_2 adsorbents include metal hydrides such as Pd, PdAg, MgNi, FeTi, and LaNi [78]. The preferred CO adsorbents include Cu(I) or Ag(I) on silica-alumina [78]. Clearly, a wide range of commercially available and developmental adsorbent materials can be used in the SERP concept.

Han and Harrison [80], Harrison and Peng [81], and Ortiz and Harrison [82] have been researching SERP for the steam reforming of methane in a single unit using a TSA cycle to remove CO_2 reversibly from the reaction product gas with CaO. Zou and Rodrigues[83], Xiu et al. [84], Xiu and Rodrigues [85-88], and Ding and Alpay [89,90] have been studying the performance of the SERP for the steam reforming of methane in a single unit using a PSA cycle to remove CO_2 reversibly from the reaction product gas using a K-promoted HTlc. The continued experimental validation of modeling analyses, coupled with the study of various PSA cycle sequences, should contribute to the understanding of this type of adsorptive reactor system, and to optimizing its performance.

It is clear that these SERPs allow steam methane reforming, water gas shift, and/or reverse water gas shift reactors to operate at reduced temperatures or pressures. They can reduce or eliminate downstream separation and purification units currently associated with the production of high purity H_2, CO, or syngas when removing CO_2 for recovery or sequestration. Although the SERP concept seems to work well, industrial acceptance of this technology has been limited. Again, further implementation of SERP would be fostered with the development of improved adsorbents, especially high temperature adsorbents.

Selective Adsorbents

New selective adsorbents can play a key role in both H_2 and CO_2 production. A recent review of CO_2 absorbents by Yong et al. [91] covered activated carbons, aliminosilicate zeolites, metal oxides and HTlcs for reversible adsorption. The overall conclusion is that activated carbons and zeolites are superior to metal oxides and HTlcs for ambient temperature applications, but for high-temperature applications metal oxides and HTlcs are preferred. As shown in Table 10, typical activated carbons exhibit 1.5 to 2.0 mol/kg CO_2 adsorption at 25 ^oC and 500 torr, which decreases to 0.1 to 0.2 mol/kg at 250 to 300 ^oC and 500 torr. Similarly, 5A zeolite exhibits ~ 3.0 mol/kg at 25 ^oC and 500 torr, and 0.2 mol/kg at 250 ^oC and 500 torr. The capacities of these materials would be less than 0.1 mol/kg at the temperatures associated with the steam methane

reforming, water gas shift, and reverse water gas shift reactive adsorbers.

The recent work by Engelhard Corporation involves the development of novel adsorbent materials for CO_2 separation from natural gas streams. The Molecular Gate technology, which was originally targeted for kinetic separation of N_2 from natural gas, was also found to be uniquely attractive for CO_2 and H_2O separation from natural gas. Based on titanium silicate molecular sieves, the Molecular Gate process takes advantage of the unique ability to adjust pore size opening of the material within an accuracy of 0.1 angstrom. Despite the small differences of kinetic radius between nitrogen and methane, the material pore size of 3.7 angstroms is effective at excluding methane from its pores while accepting nitrogen and other smaller and far more adsorbing molecules such as CO_2 and H_2O into its pores [10]. The CO_2, N_2, CH_4 and H_2O capacities of theses various Molecular Gate adsorbents are proprietary.

For selective adsorbents, the K-promoted HTlc materials exhibit a high and pressure-reversible CO_2 capacity at temperatures compatible with steam methane reforming, and water gas shift and reverse water gas shift applications [92,93]. Mayorga et al. [93] at Air Products and Chemicals report synthesis procedures and operational capacities for both HTlcs and double layer hydroxides. Yong et al. [94] and Yong and Rodrigues [95] have characterized HTlcs for CO_2 adsorption at ambient and elevated temperatures, as have Ding and Alpay [89,90]. Overall, the reversible CO_2 capacities typically range between 0.4 and 0.7 mol/kg at 300 and 400 ^oC and 200 and 700 torr, even in the presence of steam. This performance is highly dependent on the synthesis and pretreatment conditions [96]. Double layer hydroxides exhibit even higher reversible capacities in the presence of steam, typically of around 1.5 mol/kg at 375 ^oC and 230 torr [93]. These adsorbents are attractive not only for SERPs, but also for high temperature PSA processes, as shown recently by Reynolds et al. [61,97]. Table 10 compares the capacities of these developmental CO_2 selective adsorbents to established commercial materials.

Several teams are also exploring alumina as a high temperature and pressure-reversible CO_2 adsorbent for use in a PSA cycle [91,98]. The CO_2 capacity of aluminas undoped and doped with metal oxides and carbonates ranges from 0.06 (undoped) to 0.52 (doped with 9 wt% Li_2O) mol/kg at 400 ^oC and 500 Torr [98], which is similar to that reported by Yong et al [91] for commercially available basic aluminas, ~ 0.3 mol/kg at 300 ^oC and 500 torr (see Table 10).

Lithium zirconate and CaO can function as high-temperature, selective CO_2 adsorbents with temperature-reversibility. Xiong et al. [99], Ida and Lin [100], and Ida et al. [101] are exploring the zirconates, as are Nair et al. [102] in Japan. Typical CO_2 adsorption capacities are high at 3.4 to 4.5 mol/kg at 500 ^oC and 760 torr, with reasonable regeneration rates exhibited at 780 ^oC that improve with CO_2 free purge gas [100] (see Table 10). The sensitivity of these materials to H_2O vapor has not been reported.

CaO adsorbents are being investigating by Iyer et al. [103[, Gupta and Fan [104], Gupta et al. [105], Han and Harrison [80], Harrison and Peng [81], Ortiz and Harrison [82], Kuramoto et al. [106] in Japan, and Abanades [107] in Spain. These materials are also showing high CO_2 capacities at high temperatures with reasonable regeneration rates. For example, typical reversible CO_2 capacities range between 4 and 8 mol/kg at 500 ^oC and 150 torr, with regeneration carried out at 900 ^oC in N_2 [106]. A similarly high CO_2 capacity of 7 mol/kg

resulted for a CaO exposed to 76 torr of CO_2 and cycled over 50 times at 700 ^oC using N_2 for purge. This is a large reversible CO_2 capacity (see Table 10). These CaO adsorbents are very sensitive to sulfur but the sensitivity to H_2O vapor has not been reported [103]. The operating temperature range of this material may be too high for most steam methane reforming (SMR), the water gas shift (WGS) and reverse water gas shift reactors, however.

United Technologies working with NASA in the mid to late 1990s developed novel low temperature solid amine-based CO_2 adsorbents that are pressure and or temperature regenerable [108,109]. One variant of this novel material consists of a liquid amine, such as polyethyleneimine (PEI) chemically bonded to polymethyl methacrylate with poly(ethylene glycol), a second liquid phase, used to enhance mass transfer [110]. This solid amine adsorbent has a reversible CO_2 capacity of around 0.9 mol/kg at 25 ^oC and 15.2 torr of CO_2, it can be regenerated using PSA at a moderate vacuum of 1 torr, and its capacity markedly improves in the presence of water vapor [110].

More recently, Xu et al. at Pennsylvania State University, in a series of works [111-113], have been developing a similar reversible solid amine-based adsorbent for CO_2 using MCM-41 as the support and PEI as the CO_2 active amine. Depending on the Si/Al ratio of the MCM-41 and the loading of PEI ranging from 30 to 75 wt%, typical CO_2 adsorption capacities range from 1.5 to 3.0 mol/kg at 75 ^oC and 1 atm of CO_2, with complete reversibility achieved simply by purging with pure N_2 at 75 ^oC [112]. However, the adsorption and desorption kinetics are generally quite slow with 150 minutes required in each case. Most recently they investigated its effectiveness for treating simulated flue gas comprised of 14.9, 4.25 and 80.85 vol% CO_2, O_2 and N_2, respectively [113]. The results at 75 ^oC were encouraging with CO_2/N_2 selectivites of over 1000 and CO_2/O_2 selectivites of over 180. This supported solid amine-based adsorbent has limited applications as it is unstable at 100 ^oC.

Membranes

A wide variety of membrane materials and membrane gas contactors are being developed for gas separation and purification applications involving CO_2. A survey of the recent literature is given below. The latest developments in polymeric, facilitated transport, inorganic, and hybrid organic/inorganic membranes are reviewed. This is followed by a brief assessment of hollow fiber gas-liquid contactors. Ideas presented in these studies have the potential for both near-term and longer-term impact of membrane applications on the removal of CO_2 from process streams, including flue gas or combustion gas streams. Tables 12 and 13, respectively, provide the permeability and permeance of membrane materials used for CO_2 separation, and the trans-membrane flux data for different capillary hollow-fiber membrane contactors reported in the literature.

Polymeric Membranes

Polymeric membranes are attractive because they can be manufactured into units with very high surface areas, either in the form of hollow fibers arranged in the tube-and-shell configuration (85% of the market) or in the form of flat sheets packaged as spiral-wound modules with less area but more resilience against adverse conditions [14,15,19]. There are two types of polymeric

membranes. Those that are referred to as glassy polymeric membranes have a glass transition temperature that is higher than room temperature. In contrast, those that have a glass transition temperature that is well below room temperature are referred to as rubbery polymeric membranes. Table 12 summarizes the permeability and permeance obtained with these kinds of membrane materials when used for CO_2 separation.

Most commercial membrane systems in gas separations are based on glassy polymeric materials as opposed to their rubbery counterparts because of their superior mechanical properties and overall permeability-selectivity tradeoffs [114-116]. Common glassy polymeric materials include polysulfones [117-127], polyimides [116,128-150], polyaramides and polycarbonates [151-154], polyphenylene oxides [155-163] and cellulose derivatives [164-168]. Although there are less than 10 commercial membrane processes available today [14,15], these glassy polymeric membranes are still receiving significant attention in the literature [169-176].

As indicated earlier, the selectivity of a large fraction of glassy polymeric membranes depends largely on their ability to discriminate gas species by size and diffusivities through the membrane structure. Such ability is for a large group of glassy polymeric membranes consistent with the solution-diffusion model [14-19,177-180]. In the solution-diffusion model, the transport of molecules is regulated mainly by thermal oscillations of the semi-rigid polymer structure that allows diffusion selectivities based upon subtle changes in size. However, there is a small fraction of stiff glassy polymeric materials (described below) where the diffusion selectivity is governed by a size selection mechanism similar to that found in inorganic molecular sieves [178-187].

Because the performance of most glassy polymers is structure dependent, physical or chemical attacks upon it can lead to a significant deterioration of performance. Glassy membranes that become overexposed for extended periods of time to large concentrations of CO_2 or even traces of vapors from organic solvents may lead to undesirable compaction, swelling, and plasticization that irreversibly change the morphology, and hence may lead to reduced membrane performance [13-19,128-130,135,142,144,145,188-204]. Plasma and thermal treatment (i.e., annealing) [135,188,190,200,202,204] and chemical cross-linking methods [128-130,142,144,145,193-199,201,203], which improve the membrane resistance by increasing the polymer rigidity, are the most frequently used strategies to improve durability.

Thermal treatments of polymeric material for membranes with cross linking agents improve resistance to plasticization and other attacks. Thermally induced densified structures are being investigated with charge transfer complexes [194-198,202], diols [128-130,193-198] and diamines [129,142,144,145,193,203]. The improved resistance against structural modification is realized via covalent bonding of neighboring polymeric strands. These approaches lead to reductions in permeability, sometimes with improvements in selectivity. Others have observed further success by attempting a mixed approach of both techniques [194-198]. Thermal annealing, for example, can further drive cross-linking reactions to stabilize the polymer properties.

The addition of inorganic materials can also lead to further stabilization of the membrane. In this regard, polymers crosslinked with inorganic monomers [205-209], typically alkoxy-silanes,

improve stability and also improve performance. These materials belong to a different class of materials normally regarded as organic-inorganic hybrid materials and are discussed later.

Glassy polymers, characterized by a very rigid ultramicroporus structure, posses pores sufficiently small for gas separation [178,179]. Molecule diffusion in these polymer molecular sieves is similar to that in inorganic molecular sieves. Examples of these materials are polypyrrolone copolymers [178-180,184-187] and the recently developed intrinsic microporous polymers [181-183,210]. In general, these polymeric membranes are very attractive because they display performances normally above the upper bound for conventional polymeric materials and enhanced stability [178,179].

Another type of glassy polymer is di-substituted acetylene-based polymers [116,211-231]. Disubstituted polyacetylenes are known for their unique gas transport properties, characterized mainly by enormous gas permeability, high fractional free volumes (typically > 20%), and unusually high vapor/gas selectivities [116,217,220,221,230,231]. Within polyacetylenes, poly(1-trimethylsilyl-1-propyne) (PTMSP) displays the largest gas permeability of all known polymers [116]. It is believed that the large permeability associated with these polymers is due mainly to a concerted action of the rigid double bonds of the polymeric backbone and the bulky side groups, hindering chain segmental motion and restraining polymer chains from packing efficiently [215]. The resulting effect is a polymeric matrix with large, possibly interconnected, free volume that provides a very efficient permeation pathway for transporting molecules.

Also, unlike the rest of the glassy polymers, polyacetylenes do not discriminate permeates based on diffusivity but rather on solubility, which provides them with the ability to permeate heavier and more soluble organic molecules and CO_2 over smaller gases. Due to this reason, polyacetylenes such as PTMSP [216,217,220-222,224,225,229,230] and Poly(1-methyl-1-pentyne) [217-219,230,231] have been investigated as potential materials for the separation of light hydrocarbon gases and vapors (C_{3+}) from natural gas and off-gas H_2-containing streams (e.g., from fluidized catalytic crackers) in refineries.

As result of their selectivity towards CO_2 over H_2, polyacetylenes also have found potential use in hydrogen/syngas production processes (e.g., reforming). However, the CO_2/H_2 selectivities so far displayed by these polymers (i.e., < 6) are still only moderate. This limitation, due mainly to the prohibitive losses of high-pressure H_2 in the low-pressure permeate, reduces the commercial potential for these polymer membranes.

Another major concern behind polyacetylenes is their lack of chemical resistance and performance loss over time [215,224,225]. Polyacetylenes tend to incur irreversible structural changes and degraded performance with long exposures to feed gases. Several approaches have been attempted to overcome these problems with some success and sometimes with loss of performance. These approaches include the addition of silica fillers [223,232-234] to manipulate the molecular polymer chain packing. They also include the addition, preparation, or use of other polyacetylenes more resistant to aggressive feeds, such as poly(4-methyl-2-pentyne) [230], poly(1-phenyl-1-propyne) [231], and diphenylacetylene [215]. Chemical treatments such as fluorination and desilylation [211-215] also have been explored.

The increasing demands for purer and cheaper H_2 has fostered the development of technologies that selectively remove CO_2 from H_2/syngas under high pressure from reforming, coal and waste gasification and partial oxidation, and other similar processes. In this regard, rubbery polymeric materials allow membrane technology to be a viable option for this industrial application. In general, rubbery polymers tend to display lower performance than their glassy counterparts, but they posses the unique ability to be selective towards CO_2 over H_2.

The transport of molecules in rubbery polymers also can be explained by the solution-diffusion model. However, in this case the selectivity of rubbery polymers relies upon the physical interactions (i.e., solubility) between gas penetrants and the polymeric phase. Thus, given relatively low temperatures, it is possible for rubbery polymeric materials to be more selective towards heavier gases such as CO_2 or H_2S over smaller molecules such as H_2 or He [13,175,235-255].

The fact that rubbery polymers do not rely on diffusion selectivity makes their performance much less likely to be affected by swelling, plasticization and other adverse attacks than their glassy counterparts [13,235-239]. In the past, semi-organic rubbery polymers such as silicone membranes (in particular poly(dimethylsiloxane) (PDMS)), have received considerable attention for their high intrinsic permeabilities [116,256-263]. However, because these materials have suffered from reduced selectivities, particularly for the CO_2/H_2 system, their further study as possible membrane materials is somewhat discouraged.

Today, polyphosphazenes [240,241,264,265] and polyethers [175,235-239,242-254] are the rubbery polymers receiving the greatest attention. These materials display the largest CO_2/H_2 selectivities (i.e., 6-10) and show significantly higher CO_2/N_2 or CO_2/CH_4 selectivities (40-60) than commercially available glassy membranes. It is believed that polar groups in the polymer backbone, particularly ether oxygen atoms, are largely responsible for the enhanced selectivity for CO_2.

Despite the large selectivities, rubbery polymers suffer from modest permeabilities, principally as a consequence of the large degree of crystallinity associated with them [235-238,240,241,264,265]. However, several approaches have been implemented to minimize the existence of crystalline phases within these polymers, including the addition of hydrophobic pendant groups [240,241,264,265], the preparation of block copolymers containing low molecular weight rubbery polymer segments and glassy polymers such as nylons [175,247,252,266,267,], polyimides [267-269] and others [158,159,245-247]. The utilization of cross linking agents that keep rubbery polymer segments small has also been investigated [242-243,235-238,253]. This cross linking improves the mechanical consistency that is normally lacking in rubbery polymers. Despite all these challenges, rubbery polymers seem to offer significant space for improvement with a great potential for future commercial use.

Facilitated Transport Membranes

Facilitated transport membranes (FTMs) have received considerable attention because of their extremely elevated selectivities and relatively high fluxes [17]. Table 12 summarizes the permeabilities and permeances obtained with these kinds of membrane materials when used for

CO_2 separation. The high selectivity in FTMs is achieved through the existence of carriers within the membrane that selectively interact with given molecules and facilitate their transport through the membranes. FTMs that are selective towards CO_2 can have a great impact on reducing processing costs or improving equilibrium driven processes such as natural gas sweetening, reforming and coal gasification, and flue gas treatment, where CO_2 is to be removed, even if present in low concentrations.

FTMs, however, are widely known for their stability problems, mainly as a result of the evaporation of the carrier medium – a problem that is particularly acute in immobilized liquid membranes (ILMs) [270]. Several approaches have been attempted with moderate success to control evaporation. In some FTMs, evaporation losses have been reduced by alternatively using non-volatile solvents such as carbonate-glycerol [271], glycine-Na-glycerol [272,273], dendrimers [274,275], and, more successfully, glycerol carbonate [270,274]. Similarly, in polyelectrolyte membranes (PEM) [276-281], which are also ILMs, the evaporation is reduced by using non-volatile polyelectrolytes as molten salts or salt hydrates as solvents.

Membranes where the carriers are tightly bound to the polymer also have been developed to counteract degradation. In ionic exchange membranes (IEMs) [282-287], the carrier is ionic and physically binds to the ion exchange membrane via attractive electrostatic forces. In water-swollen membranes [288-290], which are a particular type of IEM, where water serves as the carrier, the membrane physically interacts and retains water, causing swelling which improves the transport of the solute.

The most successful facilitated transport membranes are the so called fixed carrier membranes (FCMs) [291-293]. In FCMs the carrier consists of secondary amines or carbonates that are chemically bonded to the backbone of the membrane. Clearly, the chemically bound carrier alleviates the evaporation and migration problems associated with the free liquid FTMs.

Despite all this work on FTMs, and with the exception of some ILMs and FCMs, most FTMs still require feed preconditioning, particularly with water, to sustain their uniquely high selectivity. Otherwise, their selectivity severely deteriorates. However, FTMs may overcome these problems in applications where humidification preconditioning is not a requirement, such as in reforming, where H_2O actively participates.

Another problem, perhaps a minor one, of most FTMs is their characteristically strong decay of permeability as the partial pressure of the favored molecule increases [274-277,280-282,288,292,293]. This behavior limits their use to feeds with low partial pressures of this species. At partial pressures over 0.5 atm most carriers rapidly approach saturation and the permeation rates become severely limited.

A particularly novel approach to FTM technology is that associated with the “bulk flow liquid membrane” (BFLM) concept, which was introduced by the group of Teramoto [294-296]. In BLFMs, stability problems due to evaporation of the carrier solution, observed with traditional FTMs, are avoided. The carrier solution is forced to permeate through the membrane and then is continuously recycled to the feed side.

Briefly, with BFLMs the carrier solution is continuously mixed with the feed gas and the carrier selectively reacts with the solute. Once inside the membrane unit the carrier permeates the membrane with the dissolved solute from the feed side (high-pressure side) to the receiving side (low-pressure side). Upon leaving the unit the absorbed CO_2 is released and the regenerated carrier is recycled back to the feed for reuse. Any small amount of carrier solution that does not permeate the membrane is later separated from the treated gas and returned through the receiving side of the membrane to join the carrier that is permeating through the membrane.

Because the membrane is always wetted with carrier solution, the membrane remains highly selective while devoid of any open pores (i.e., pores unfilled with liquid through which the gas may flow unselectively). Also, BFLM units do not require the use of special membranes. The flexibility of this process is such that both microporous and capillary membranes can be successfully used. In addition, thick and porous membranes with sufficient mechanical strength and durability can be used as long as they do not severely restrict the transport of the carrier. Teramoto et al. [294,295] showed CO_2/N_2 selectivities over 500 and permeances and greater than 300 GPUs[2] for a wide variety of BFLMs containing capillary polyethersulfone membranes 250 microns thick.

Inorganic Membranes

Inorganic membranes are very attractive not only because they have significantly better performance in terms of permeability and selectivity over organic membranes, but also because they are more resistant to high temperatures and pressures, fouling, aggressive feeds, and regeneration treatments. Table 12 summarizes the permeabilities and permeances obtained with these kinds of membrane materials when used for CO_2 separation. Materials typically used as membrane materials include carbon molecular sieves from a wide variety of organic polymeric precursors [134,135,138,148,306-313,250,297-305,], zeolites [314-336], and silicas [337-341]. To improve their productivity, these membranes must be deposited as thin layers upon the surface of other, non-selective inorganic materials, such as aluminas, zirconias, or porous stainless steel that also provide structural consistency.

Most inorganic membranes exploit diffusion selectivity as the main factor for gas separation. An extreme case of diffusion-selective membranes is that of molecular sieves, where the molecular spacing within the pores of the membrane is so restricted that the transport of some larger molecules becomes severely impeded. Most of the literature regarding inorganic membranes that rely on diffusion selectivity for CO_2 separation has been focused on the CO_2/N_2 or CO_2/CH_4 systems.

In other materials adsorption and condensation play an additional role. For example, in so called selective surface flow (SSF) membranes, condensation is so important that even the smaller and faster diffusing species become the less permeable ones, sometimes to the point of becoming totally excluded. The first SSF membranes were developed by Air Products and Chemicals and have been extensively studied [71,342-350]. However, the CO_2/H_2 selectivities of these membranes (< 5 for most species - see Table 12) so far are too low to be of any economic value. Recently others [262,325,351-359] have reported new types of membranes with SSF

[2] GPU = 1 x 10^{-6} cm^3 (STP)/(cm^2-s-cm Hg)

characteristics.

Despite all their appealing properties, inorganic membranes are not commercially used for CO_2 separation. It is doubtful that this will change in the near future. Their inherent brittleness and the elevated manufacturing costs associated with making modules that are crack free and have large surface areas are still serious issues that limit their utility.

Hybrid Membranes

In the past two decades there has been much interest in the development of hybrid membranes consisting of mixtures of organic and inorganic phases. Table 12 summarizes the permeabilities and permeances obtained with these kinds of membrane materials when used for CO_2 separation. Polymeric membranes have shown little progress since Robeson set the permeability-selectivity trade-off upper limit in 1991 [360]. So-called hybrid organic–inorganic membranes seem to offer potential to overcome this limitation. In these membranes, the inorganic phase, which is normally in dispersed form, consists of diverse types of silicas [137,173,205-209,361-387], titanias [125,388], carbon materials [178,179,389-395], and zeolites [396-409]. The organic or polymeric phase serves as the host [390-392]. These membranes are attractive because they synergistically exploit the desired properties of both phases, improving the mechanical (e.g., by increasing bursting pressures) and thermal properties of the inorganic phase and providing the manufacturing flexibility and ductility associated with the organic phase [207,361-364,390-392].

In addition, there has been an abundance of literature reporting that organic-inorganic hybrid membranes can improve the performance of the organic phase, potentially addressing many of the current needs of the membrane industry [178,179,205-208,361-365,375,376,389,390-398,401,402]. Hybrid membranes have been shown to significantly increase the selectivity of the polymer while keeping, and sometimes also increasing, its permeability [178,179,389,390-395]. Further, it also has been reported that hybrid membranes exhibit higher stability against aggressive environments [390].

Organic-inorganic hybrid membranes generally can be classified into two types. In the first type the inorganic phase consists of either preformed submicron particles (fillers) [125,178,179,385-388,389,390-395,397-409,] or in the form sol-gel precursors that are subsequently incorporated into the organic phase [137,365,377-383,389]. In the second type both organic and inorganic phases become intermingled at the molecular level via chemical reactions between monomers of both phases [173,205-208,209,361-364,366,371,375,376]. In the first type the mixing is realized in a slurry that contains both phases dispersed in a solvent that is later removed. In the second type the membrane typically is formed via a sol-gel process whereby hydroxyls of the inorganic monomers (e.g., alkoxy silanes) become covalently bonded to the backbone of the organic monomer via organic functional groups.

There are two main reasons for the enhanced performance observed in hybrid membranes [207]. The first one is due to the particular interactions that the inorganic phase establishes with the favored gas species. In this case, the inorganic phase may act as a molecular sieve, delaying the transport of the less selective species, or as a SSF material which, due to an improved condensation selectivity in favor of the heavier species, retards the flow of the smaller, more

diffusing species. The second reason for the improved performance is a consequence of morphological changes that take place in the polymer structure as a result of the strong interactions now existing between the two phases. A strongly interacting inorganic phase can inhibit chain or backbone mobility (i.e., increase stiffness) and open inter-chain packing (i.e., backbone inter-distance), simultaneously improving both the selectivity and permeability of the organic phase.

Perhaps, the most critical decision in making a hybrid membrane with improved performance lies in the correct selection of the membrane materials [207,391,392]. Both selected phases should facilitate the transport of the more selective gas species, while the transport of the less selective species is delayed. In this regard, matching the permeabilities of the favored gas species in both phases is an important consideration. A polymeric phase that is otherwise too permeable or too impermeable may lead to undesirable gas bypassing (i.e., low selectivity) or poor membrane productivity (i.e., low permeability), respectively.

It is also imperative that the phases display good adhesion at the interface. Defects at the interface and phase separation lead to gas bypassing, which reduces selectivity. The simplest approach to insure interfacial adhesion is to select phases that are physically and chemically compatible with each other and to assure that interfacial surface tension is minimized. For example, interacting mixtures containing zeolites and rubbery polymers [401-402], or carbon based materials with glassy polymers [178,179,389-395] have led to better performing membranes, in some cases significantly better. Limited or no success has been achieved where phase separation occurs (e.g., with mixtures of silicas or zeolites and glassy polymers) [390-392].

Alternative approaches have been attempted to improve adhesion of poorly interacting phases. The use of polymeric compatibilizers [173,209,379,410] to reduce surface tension has been demonstrated. Some success has been achieved by using coupling agents and sol-gel techniques with organic polymers functionalized with, for example, trialkoxysilane groups or alkoxysilane monomers containing functional groups [137,367,380,382,399-402,411]. The same bonding concept has been successfully exploited with *in situ* prepared hybrid membranes where bonding reactions result in the formation of nano-microcomposites [173,205-209,361-364,366,371,375,376].

At present, hybrid membranes are used only to improve the mechanical strength of membranes for liquid separations, such as those used in ultrafiltration, reverse osmosis, ion exchange, etc. [412,413]. In the gas separation industry, hybrid membranes currently are not being used.

Hollow Fiber Gas-Liquid Contactors

The concept of using a hollow fiber membrane unit to serve as a gas-liquid contactor for absorption was first introduced by Zhang and Cussler [414,415]. Currently, a handful of companies including Kvaerner Oil & Gas, W.L. Gore and Associates GmbH, and TNO Environment Energy and Process Innovation have successfully developed larger-scale units [416-418]. However, commercialization is looming. Nevertheless, because of the inherent high selectivity and relatively large flows, hollow fiber contactors may be very attractive for CO_2

separations in processes such as reforming and gas sweetening. Table 13 provides a summary of the trans-membrane flux being achieved for different capillary hollow fiber membrane contactors reported in the literature.

The process basically uses a non-selective membrane that serves only as a physical barrier between the gas and the liquid phase. The non-wetted pores in the membrane are such that the membrane does not offer any selectivity over the gas species; the liquid absorbent assumes this role [416-425]. Thus, the membrane must only allow the solute to diffuse through with little resistance before reaching the absorbent. The pores of the membrane must be kept completely gas filled. The presence of stagnant liquid within the pores (i.e., wetting) increases the overall mass transfer coefficient of the process.

Because of its advantages over conventional absorption towers, a great deal of research has been conducted on gas-liquid contactors in acid gas sweetening of natural gas and flue gas streams [416-418,421-424,426-445,]. Hollow fiber gas-liquid contactors are flexible and can be operated over a wider range of conditions, as they are not subject to the common limitations observed in packed beds such as flooding, foaming, channeling, and liquid entrainment [418]. Superficial velocities in these membrane processes easily can exceed 2 cm/s, which is a limit in their packed bed counterparts.

The larger surface area in these contactors is perhaps the most attractive advantage. Depending on the diameter and thickness of the hollow fibers, membrane contactors may display trans-membrane surface areas between 500-3000 m^2/m^3, which is significantly higher than the typical 100-500 m^2/m^3 observed in packed bed systems. The result of having a large surface area is that despite the typically lower mass transfer coefficients associated with the laminar regime of the liquid phase in these membrane contactors, the volumetric mass transfer coefficient (i.e., k_La) can still be larger than that attained in a packed bed [441-443]. Furthermore, unlike packed bed systems, the contacting area is fixed and does not vary with process conditions, and the particular modularity of the membrane contactors allows their design to be simple and scaled linearly. All these facts could lead to significant operational and capital cost savings.

These membrane contactors also offer advantages over selective membranes. The performance of hollow fiber membrane contactors depends almost exclusively on the liquid absorbent, and unlike dense or selective membranes it is not significantly affected by plasticization and other structural attacks. Also, the extremely high selectivity towards CO_2 that can be achieved with these membrane contactors limits their loss of primary gases such hydrogen, methane, or other hydrocarbons through the permeate, particularly in feeds with low CO_2 concentrations.

In spite of their positive attributes, hollow fiber gas-liquid contactors are unable to sustain processing conditions for prolonged periods of time. This problem has significantly limited commercial interest. The initial high resistance against liquid penetration into the membrane pores tends to break down with time as a result of combined mechanisms that include surface wetting, surface modification and reaction, clogging, and swelling of the polymer [316,418]. Membrane wetting largely depends on an adequate selection of membrane and liquid absorbent. The ability to stop a liquid from wetting or penetrating into the pores of the membrane depends directly on the surface tension of the liquid and inversely on the size of the membrane pores.

With higher surface tension and smaller pores it is less likely that the membrane can be wetted. In general, the use of hydrophobic membranes, such as inexpensive polyolefin membranes, in combination with aqueous based absorbents, such as suspensions of alkanolamines or carbonates, ensures large surface tensions. However, surface tension may also vary with the absorbent concentration and CO_2 loading. In alkanolamines, for example, the interfacial surface tension tends to decrease considerably with increasing alkanolamine concentration, but then recovers as the CO_2 loading increases [418].

In addition, the selected solvent must be compatible with long-term stability of the membrane. For example, alkanolamines tend physically to interact and breakdown the hydrophobicity of polyolefin membranes. More hydrophobic membranes, such as polytetrafluoroethylene (PTFE), have been developed to resolve this problem. However, PTFE is expensive and the PTFE membrane contactors exhibit only limited contacting areas. Amino acid salts made from glycine, alanine, diethyl or di-methyl glycine, which offer similar absorption characteristics to aqueous alkanolamines and do not degrade polyolefin membranes, can be used but are more expensive.

Recently, Yeon et al. [441,442] have shown that adding significant concentrations of triethanolamine (TEA) into the absorbent also can improve membrane stability against wetting. Membranes containing this alkanolamine displayed stable performances for over 3000 hours. TEA offers a lower absorption rate than the alkanolamines; but, it requires less energy consumption and does not react with CO_2. Korikov and Sirkar [433] showed that aqueous solutions containing polyamidoamine dendrimers as absorbents also may improve membrane stability.

Another way to restrict membrane wetting is by reducing the pore size. Pores, however, cannot be so small that they restrict the flow of solute across the membrane. Below the lowest limit, which corresponds to the mean free path and is equivalent to 70 nm for CO_2, the membrane becomes selective.

Another significant problem associated with these gas-liquid contactors is pore blocking, which is related to solvent stability. For example, alkanolamines, in particular monoethanolamine (MEA), and some amino acid salts tend to react with the CO_2 and form precipitates that eventually cause pore clogging and fouling.

Most recent efforts are directed towards developing cross-flow membrane contactors, which improve the lower mass transfer coefficients of the traditional contactors [416,417]. A summary of membrane contactors can be found in the reviews of Li and Chen [445], Drioli et al. [425], and Klaassen et al. [419,420].

Conclusions from Background Survey

This survey identified several areas where major improvements or breakthroughs may be achieved in CO_2 removal with the judicious use of adsorption and membrane processes. In several other areas the path forward is potentially blocked by fundamental material limitations. In the next section, recommendations are presented for future work on promising adsorption and membrane technologies. It is anticipated that breakthroughs in adsorption and membrane

technologies will lead to significant reductions in energy consumption, environmental impacts and feedstock requirements, and thereby provide considerable improvements in process economics.

RECOMMENDATIONS FOR FUTURE R&D

Recommendations are set-forth for future CO_2 separations R&D needs based on this technology and industrial assessment. These recommendations are set-forth for both the near-term time frame (i.e., 1 – 5 years) and longer- range research (i.e.,7 – 15 years).

The near-term developments in CO_2 separations technology are divided into four categories:

- Near-Term Adsorbent Development
- Near-Term Membrane Development
- Near-Term Adsorption Process Development
- Near-Term Absorbent and Absorption Process Development

The long-range developments in CO_2 separations technology are divided into three categories:

- Long-Term Flow Sheet Augmentation with Adsorption and Membrane Processes
- Long-Term Advanced Adsorbent Materials and Process Development for CO_2 Removal
- Long-Term Advanced Membrane Materials for CO_2 Removal

It must be emphasized that streams containing CO_2 tend to be dirty and contain many different contaminants, as mentioned throughout this report. This fact is very important and provides the basis for a crosscutting recommendation for adsorption and membrane materials and process development.

Crosscutting Recommendation: the development of pre-cleaning technologies to remove a wide variety of contaminants from CO_2 streams may be critical to the successful development and implementation of any or most membrane and some adsorption processes.

Near-Term Adsorbent Development

Overarching Goal: Develop high-capacity CO_2-selective adsorbents with rapid adsorption-desorption kinetics, improved selectivity, and operational stability.

As a guide, the classes of adsorbent materials being studied today include:

- Low-temperature activated carbons, carbon molecular sieves, and zeolites for CO_2
- High-temperature hydrotalcites, CaOs, and zirconates for CO_2
- structured adsorbents for rapid PSA, or PSA/TSA processes (e.g., carbon fiber molecular sieves)

In general, these materials have potential for commercial use in CO_2 capture. However, they all suffer from one or more of the following deficiencies:

- too expensive
- insufficient working capacity

- insufficient selectivity
- slow adsorption or desorption or mass transfer kinetics
- moisture sensitivity
- vulnerability to poisons like CO or S
- too rectangular of an adsorption isotherm shape making regeneration difficult with pressure
- too strong of a physiochemical interaction requiring regeneration with relatively high temperature instead of pressure
- limited rapid cycling capability because commercial pellet materials tend to crumble if the cycling is too fast

Table 10 provides some insight into the CO_2 capacities now being achieved. Any improvement in these capacities will be highly desirable.

Recommendations:

1) **Specific Goal: Develop high-capacity CO_2-selective adsorbents that can operate at elevated temperatures in the presence of sulfur-bearing compounds and possibly steam. Working capacities at elevated temperatures in the range of 3-4 mol/kg are desirable, which is similar to commercial low temperature adsorbents like 5A zeolite for CO_2. The operating pressures should be in the range that corresponds to this working capacity range (e.g., 1 to 40 atm).**

Near-Term Membrane Development

Overarching Goal: Develop low- and high-temperature membranes that are selective only to CO_2, that exhibit high permeability, are robust and resistant to fouling and degradation, and exhibit good mechanical stability under high differential pressures.

As a guide, the general classes of membrane materials being studied today include:

- polymeric membranes including glassy and rubbery membrane materials
- facilitated transport membranes including immobilized liquid membranes, ionic exchange membranes, fixed carrier membranes, water swollen membranes, and polyelectrolyte membranes
- inorganic membranes including molecular sieves and selective surface flow membranes
- hybrid mixed matrix membranes including inorganic-organic hybrid materials
- hollow fiber membrane contactors that operate with absorbents

In general, these types of membranes or membrane contactors show commercial potential with energy saving impact in CO_2 capture. However, they all suffer from one or more of the following deficiencies:

- polymeric glassy membranes generally suffer from chemical attack by CO_2, sulfur bearing compounds, and organic solvents
- polymeric rubbery membranes generally suffer from low permeabilities and low

selectivities towards CO_2 over H_2

- facilitated transport membranes suffer from being too dependent on the presence of moisture to maintain selectivity
- inorganic membranes tend to be brittle and have low surface areas
- selective surface flow membranes tend to have low selectivities
- hybrid mixed-matrix membranes suffer from phase separation
- hollow fiber membrane contactors suffer from plasticization and tend to lose their resistance to wettability with time

Table 12 and 13 provide some insight into the properties of these various membranes towards selective CO_2 separations. Any improvement in these properties will be highly desirable.

Recommendations:

1) **Specific Goal: Develop CO_2 permselective polymeric glassy or rubbery membranes with CO_2/H_2 selectivity of > 15-20, with at least 2 times higher CO_2 flux than current commercial membranes, and with higher stability to syngas production conditions of 200^oC or higher.**

2) **Specific Goal: Develop polymeric glassy or rubbery membranes for CO_2/CH_4 that have selectivity > 50, double the current commercial membrane CO_2 flux, resists plasticizing and is stable to heavy oil.**

3) **Specific Goal: Develop CO_2 permselective facilitated transport membranes that can operate in the absence of water for long periods of time, avoid vapor conditioning, control or eliminate carrier evaporation, and minimize the strong dependence between CO_2 permeance and partial pressure as often observed in these materials.**

4) **Specific Goal: Develop CO_2 permselective inorganic membranes with selectivity of > 15-20 or higher as these systems provide the desirable temperature stability.**

5) **Specific Goal: Develop CO_2 permselective selective surface flow membranes with a much higher CO_2 selectivity toward gases such as H_2, N_2, CH_4, etc.**

6) **Specific Goal: Develop CO_2 permselective hybrid mixed matrix membranes with improved selectivity and permeance, and stability against phase separation, bypassing, and plasticization for the case with matrices made of glassy polymer, etc.**

7) **Specific Goal: Develop CO_2 permselective hollow fiber membrane contactors with improved permeance and prolonged stability against solvent dissolution, wetting, and pore blocking.**

Near-Term Adsorption Process Development

Overarching Goal: Develop new or modify existing adsorption process technology that offers increased energy savings at lower capital and operating costs, affords higher reliability, and

reduces footprint and environmental impact.

As a guide, adsorption process technology being studied today includes:

- various pressure swing adsorption cycles at ambient and elevated temperatures
- temperature swing adsoprtion for some CO_2 separations
- sorption-enhanced reaction processes, mainly for H_2 production

In general, state-of-the-art cyclic adsoption processes suffer from the following:

- CO_2 is typically the heavy component discarded in the tail gas of a PSA unit
- poor enrichment of CO_2 in typical PSA units
- TSA is limited to long cycle times and hence low feed throughputs
- PSA generally is limited to ambient or near ambient temperature operation
- PSA feed pressures tend to be very high
- PSA and TSA beds tend to be very large

Table 11 provides some insight into the performances of PSA processes for the recovery of CO_2 from stack and flue gas. Any improvement in these performances will be highly desirable. No attempt has been made to recover CO_2 from the tail gas of H_2 PSA plants.

Recommendations:

1) **Specific Goal: Develop new PSA cycle designs that take advantage of new or even existing CO_2 selective adsorbents; possibly TSA or PSA/TSA hybrid cycle designs could be envisioned.**

Some ideas for improvement include:

- rethink the use of the tail gas or heavy product from PSA processes
- revamp existing PSA plants through cycle modification
- use lower or even higher purge gas pressure
- replace one or more of the adsorbents with more efficient ones
- decrease the number of adsorbent vessels
- add storage tanks to replace some of the adsorbent beds
- develop new PSA cycles that take advantage of the heavy reflux concept, where a pure heavy product like (CO_2) is more desirable than pure light product (like H_2)
- foster a clear understanding of the design of such a PSA cycle, which appears to be lacking compared to the commercial light reflux PSA processes; hence, the application of the heavy reflux PSA concept for H_2 production is a desirable near term target

Some existing adsorbents with potential include:

- molecular sieve zeolites
- molecular gate silicotitanates

- activated carbons

Some new adsorbents with potential include:

- hydrotalcites
- CaO
- zirconates

2) **Specific Goal: Need improved efficiency for thermal management in the design of TSA and PSA/TSA hybrid cycles. Some ideas include:**

   - rethink bed designs for rapid heating and cooling because the long times required to heat conventional beds for regeneration and then cool them to the feed temperature give rise to long cycle times and thus exceedingly large columns
   - take advantage of the many heat sources that are available throughout some of the CO_2 producing plants that may lend themselves to a TSA or a PSA/TSA hybrid cycle configuration for selective CO_2 removal from a process stream

Near-Term Absorbent and Absorption Process Development

Overarching Goal: Develop new or modify existing absorption process technology that offers increased energy savings with lower capital and operating costs, and affords higher reliability and reduces footprint and environmental impact.

Recommendations:

1) **Specific Goal: Develop absorbents with improved capacity and greatly improved heat of absorption.**

2) **Specific Goal: Develop new regeneration techniques, as opposed to thermal or vacuum regeneration; in particular develop regeneration techniques that can be done at high pressure to cut down on compression costs for sequestration or enhanced oil recovery uses.**

3) **Specific Goal: Develop absorbents that work on high temperature gases.**

4) **Specific Goal: Develop absorbents that are stable to trace contaminants (e.g., amines are more likely to develop problems than most physical solvents).**

5) **Specific Goal: Develop more selective absorbents (CO_2 over sulfur species) for processes with H_2S and COS species present (e.g., natural gas and coal bed methane); one approach might be to develop reactive solvents that can convert sulfur species directly to elemental sulfur, while simultaneously or later absorbing CO_2.**

Long-Term Flow Sheet Augmentation with Adsorption and Membrane Processes

Overarching Goal: Develop new adsorption and membrane process technology that offers lower capital and operating costs and affords higher reliability on stream with improved energy savings.

Recommendations:

1) **Specific Goal: Develop hybrid technology for H_2 production (e.g., develop a multi-functional hybrid reactor for steam methane reforming by combining the reactor with a CO_2 selective adsorbent and an H_2 permeable membrane).**

Driving equilibrium processes in this way can greatly improve manufacturing process efficiencies. This design would not only shift the equilibrium of the reforming reaction favorably, but it also would facilitate the WGS reaction. The recommended approach involves the development of new adsorbent and membrane separation materials.

It appears that highly selective and highly permeable membranes will always be very difficult to fabricate. However, with hybrid multi-reactive, multi-separation designs, the criteria for selectivity or permeability may be relaxed, so a less selective membrane with a high flux may suffice.

2) **Specific Goal: Develop new CO_2 adsorbent and membrane technologies that are amenable to IGCC and related power and chemical production technologies with CO_2 sequestration as a potential long term objective.**

3) **Specific Goal: Develop hybrid technology, possibly coupled with adsorption or membranes processes, that removes CO_2 by chemical reaction in the chemical process.**

Long-Term Advanced Adsorbent Materials and Process Development for CO_2 Removal

Overarching Goal: Develop new adsorbent materials and CO_2 process technology that offers increased energy savings with lower capital and operating costs, and affords higher reliability and reduces footprint and environmental impact.

Recommendations:

1) **Specific Goal: Develop advanced structured adsorbent materials for use in rapid-cycle PSA. These adsorbents should have comparable working capacity under operational conditions for the current and new non-structured adsorbents mentioned above.**

2) **Specific Goal: Further develop the design of rapid-cycle PSA for CO_2 capture and concentration. In particular, this includes exploring rapid-cycle PSA with the incorporation of both heavy and dual reflux cycles steps.**

3) **Specific Goal: Minimize the cycle time in rapid PSA to improve its throughput and**

hence efficiency by investigating the limiting relationship between adsorbent particle size, surface properties, and accelerated cycle times. In particular, the mass transfer limitations associated with ultra fast cycling need to be quantified.

4) **Specific Goal: Develop TSA and or PSA/TSA hybrid cycles with improved materials for use in CO_2 separation technologies. In particular, a deeper understanding of the PSA/TSA hybrid cycle is needed to quantify the effect on the cycle time and bed sizes when adding a forced temperature swing/PSA cycle.**

5) **Specific Goal: Develop improved CO_2 separations with sorption enhanced reaction processes using pressure swing, thermal swing, or even hybrid pressure and thermal swing regeneration methods.**

Long-Term Advanced Membrane Materials for CO_2 Removal

Overarching Goal: Develop new membrane materials that offer increased energy savings wiht lower capital and operating costs, and affords higher reliability and reduces footprint and environmental impact.

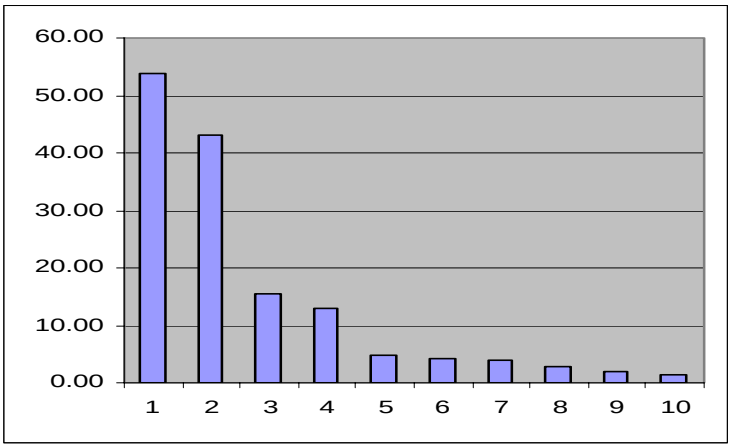
Recommendations:

1) **Specific Goal: Next generation membrane materials are needed that offer very high selectivity for CO_2 (> 100), while resisting fouling and cracking or embrittlement, and while withstanding high temperatures and pressures that could save substantial energy associated with operation by replacing existing CO_2 and acid gas removal equipment.**

SUPPORTIVE INFORMATION ON ENVIRONMENTAL CO_2 EMISSIONS

In this supportive section, the main sources of industrial CO_2 emissions are reviewed. Ten sources (see Figure 3) are reviewed in order of decreasing impact on CO_2 emissions. Process flowsheets are provided that illustrates where the CO_2 is produced, the process capacity, and the condition and composition of the various process streams addressed. These flow sheets, and corresponding stream compositions and conditions, should be helpful in defining performance and operating condition requirements for the near- and far-term development of new adsorption and membrane processes for CO_2 capture from industrial sources.

Also, in this supportive section, some of the approaches that have been proposed to combat these CO_2 emissions are summarized. These approaches include the worldwide Kyoto Protocol that is designed to cut CO_2 emissions to below 1990 levels, taxation in some parts of Europe on the release of CO_2 into the atmosphere, integrated gasification combined cycle power plants that are more efficient, and the use of CO_2-consuming algae that can be used to make biodiesel fuel.



1. Iron and Steel Production	53.76
2. Cement Manufacture	43.03
3. Ammonia Manufacture & Urea Application	15.56
4. Lime Manufacture	12.98
5. Limestone and Dolomite Use	4.72
6. Aluminum Production	4.22
7. Soda Ash Manufacture & Use	4.08
8. Petrochemical Production	2.78
9. Titanium Dioxide Production	2.01
10. Phosphoric Acid Production	1.38

Figure 3. U.S. Industry 2002 CO_2 emissions in MMt: non-energy related processes.

Main Sources of Industrial CO_2 Emissions

Brief descriptions of the processes most responsible for producing industrial CO_2 emissions are discussed below. Listed in order of decreasing CO_2 generation, these industrial processes include 1) combustion - including burners, flaring, incineration, and utility boilers; 2) coal gasification; 3) steel manufacture; 4) lime and cement production; 5) H_2, syngas, and NH_3 production; 6) natural gas production; 7) aluminum manufacture; 8) Claus/SCOT processes; 9) municipal solid waste landfills; and 10) fermentation to produce ethanol. The flowsheets associated with each of these industrial CO_2 producers is provided in Figures 4 through 14. The corresponding stream compositions and conditions for each of these flow sheets are given in Table 14. Typical process capacities and gas flow rates for these CO_2 producing industries are given in Table 15. Note that with the exception of some of the combustion and gasification processes, these flowsheets are

concerned only with CO_2 emissions resulting from chemical and petrochemical processes. Tables 2 and 3 and also Figure 3 present slightly different perspectives on non-energy related CO_2 production from various processes, six of which were mentioned above and are reviewed below.

Combustion Processes [446-449]

This section considers the carbon dioxide generated from all types of industrial combustion processes, including those that generate power from burning fossil fuels to simple burners, flares, incinerators, and boilers. Fossil fuel power plants, as well as many chemical and petrochemical plants, utilize burners, utility boilers, incinerators, and or flares to generate heat, energy, or steam or to get rid of a waste product. All of these processes produce CO_2 as a by-product of burning or combusting various fuel sources, such as coal, solid waste, natural gas, or some other type of fossil fuel. A typical flow sheet for a carbon-based combustion process that could be associated with a burner, flare, incinerator, or utility boiler is given in Figure 4.

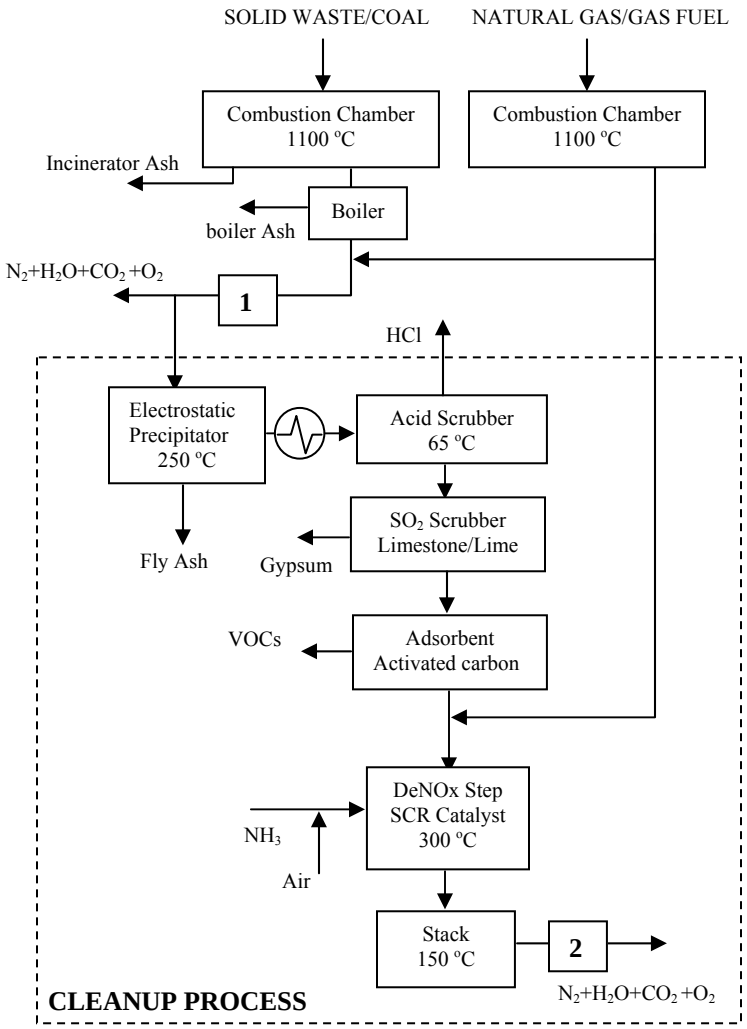


Figure 4. Flow sheet of a typical, state-of-the-art, combustion process that includes burners, incinerators, flaring, utility boilers, etc.. Flaring does not necessarily take place in a chamber. Combustion processes that use coal or waste as fuel may require an elaborate cleanup process to remove ash, HCl, SO_2, volatile organics, and NO_x. Combustion steps with gas fuels and natural gas may only require a NO_x removal step. The compositions of the numbered streams are shown in Table 14.

The corresponding stream compositions are given in Table 14, and capacity and flow rate information is given in Table 15.

Tables 1 and 2, and Figures 1 and 2 provide a breakdown of the energy and non-energy related CO_2 emissions from combustion processes. About 89% of the CO_2 emissions in the manufacturing industry are energy-related emissions. Almost all fossil fuel power plants for the generation of electricity fall into this group, including pulverized coal (PC) and IGCC or NGCC power plants.

The carbon-based fuel enters a chamber where it is combusted in the presence of air at a temperature of up to 1100°C. In power plants and utility boilers, the generated heat is used to generate electricity from steam turbines. In some plants, such as IGCC or NGCC power plants,

gas turbines are also used in addition to steam turbines. In the case of solid fuels, the chamber is designed to cope with the removal of ash from the bottom, and at the flue gas exit cyclones or other devices are used for gas phase particulate removal. Also, because of the ever increasing concerns over reducing the emissions of SO_2, volatile organic compopunds (VOCs), NO_X and other contaminants from the flue gas, more recent designs include a train of gas phase cleanup processes.

In general, the cleanup of the exiting flue gas starts with the electrostatic precipitation of particles (fly ash) that could not be removed by the particle separators. This process is carried out continuously at 250^oC and removes nearly 100% of the fly ash. The gas is then fed into an absorption process for the subsequent removal of HCl and SO_2. In the latter case, the gas is passed through an aqueous suspension of lime that leads to the formation of $CaSO_4$ (gypsum). Next, the gas is sent to an adsorption process where activated carbon removes the VOCs. The cleanup of the flue gas is finished after a deNOx step. In this step, the NO_x is catalytically converted into N_2 and H_2O using a mixture of air and ammonia at a temperature of about 300^oC. Currently, CO_2 generally is not recovered from flue gas; hence, it is released into the atmosphere in copious amounts that represent nearly 90% of all CO_2 emissions from industrial processing (Tables 1 and 2, and Figures 1 and 2).

Coal Gasification [446,450-452]

The increasing need to more efficiently and more cleanly utilize the energy contained within coal motivated the development of coal gasification processes to replace old coal-fired power plants. Typical flow sheets of coal gasification plants are given in Figures 5 and 6.

The corresponding stream compositions are given in Table 14, and capacity and flow rate information is given in Table 15. Coal gasification not only can be used for power generation, but also it can be used for H_2, syngas, NH_3, and even other chemical production. When it is used to generate only power, it falls under the category of combustion (Tables 1 and 2, and Figures 1 and 2). When it is designed to do produce both chemicals and power, it is referred to as an IGCC plant. In this dual mode, clearly it produces both energy and non-energy related CO_2 emissions (Tables 1 to 3 and Figure 3). In the act of producing power or chemicals, coal gasification processes unavoidably produce large amounts of CO_2 that, for the most part, are emitted to the atmosphere.

The coal or fuel in the gasification unit is exposed to a controlled atmosphere (> 20 atm and 1300^oC) of both steam and oxygen to produce syngas (i.e., $CO + H_2$), while minimizing the fraction of fully combusted carbon. The existence of these combustion and shift reactions leads to the formation of copious amounts of CO_2 that eventually make their way into the atmosphere. The fuel is normally a solid, such as coal, petroleum coke, biomass, or even organic solid waste. It can be fed to the gasifier dry or it can be injected in the form of a wet slurry. Heavy liquid oils can also be used in this process.

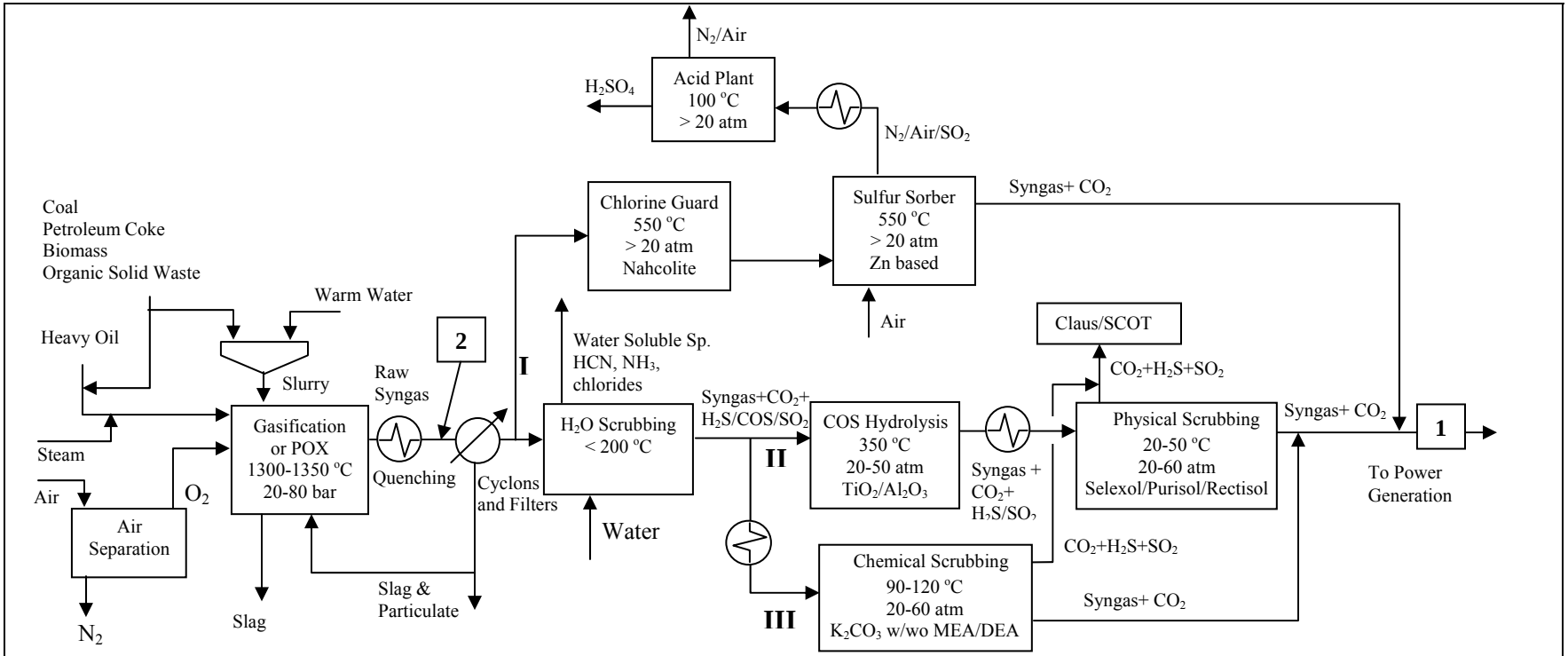


Figure 5. Flow sheet of typical, state-of-the-art coal gasification (also referred to as integrated gasification combined cycle, IGCC) plants for power generation/syngas production. After a fuel (mostly coal) gasification step that is similar to reforming of CH_4, cleanup of acid syngas takes place either through hot (I) or cold sweetening paths (II or III). In the hot path, sulfur compunds are converted into SO_2, which is then used to produce sulfuric acid. In the cold path, acid syngas may be treated via physical scrubbing following a COS hydrolysis step (II). Alturnatively, syngas may not need COS hydrolysis if the syngas is sweetened by chemical scrubbing with K_2CO_3 (Benfield) (III). Tail gas from the cold scrubbing steps is sent to a Claus/SCOT process for sulfur production. The compositions of the numbered streams are shown in Table 14.

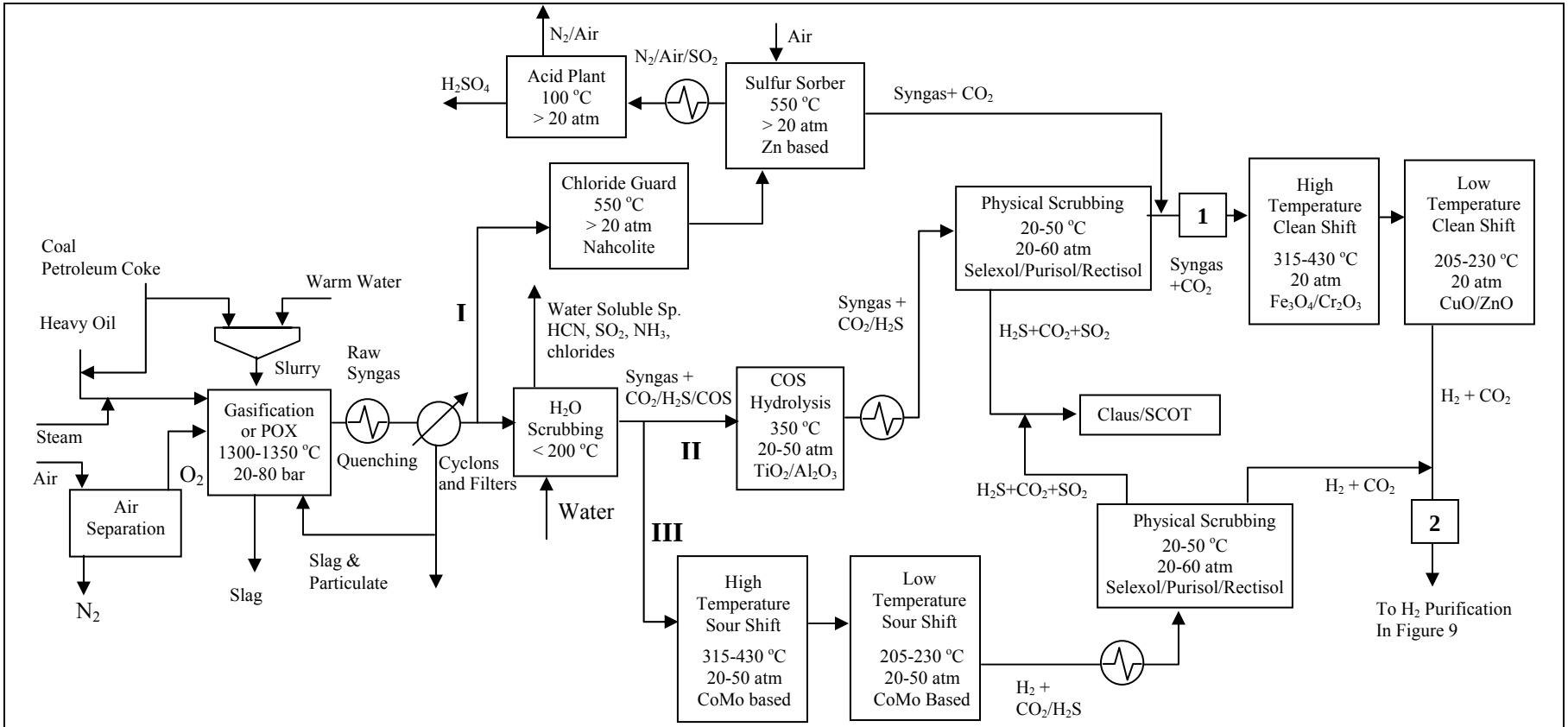


Figure 6. Flow sheet of typical, state-of-the-art coal gasification (also referred to as integrated gasification combined cycle, IGCC) plants for power generation/H_2 production. The process is similar to that shown in Figure 5 except that the syngas gas is further shifted for both H_2 production and pre-combustion capture of CO_2. In the case of the hot sweetening path (see Figure 5), syngas is shifted after sweetening through two water gas shift steps (i.e, sweet shift) identical to those in ammonia production (see Figure 9). In the case of the cold sweetening path (see Figure 5), the acid syngas may be sweetened before (II) or after (III) shift reactions. In the first case (i.e., path II), the sweetening step is just like those shown in paths II and III in Figure 5 (only that of path II is shown here) before going through two sweet shift steps. In the second case (i.e., path III), sweetening takes place via physical scrubbing after two sour shift reactions that are specially prepared to deal with sulfur bearing species while chemically converting them into H_2S. The compositions of the numbered streams are shown in Table 14.

Most gasifiers are provided with purified oxygen (> 95 vol%) to significantly reduce the size of the unit and its operational costs (e.g., heat exchanging). This also is done to minimize the generation of NO_x. However, due to the additional costs associated with the air separation unit, a considerable number of gasifiers operate with air.

Gasifiers produce both solids and gases as products. The solid slag is easily removed from the bottom of the gasifier. The resulting gas is very hot and contains particulate matter. It is cooled by quenching and heat exchanging. The particulates are removed using cyclones and filters. The cooled and particulate-free sour syngas is then sent through either a hot or cold sweetening process to be used either for power generation or H_2 (chemical) production.

In hot sweetening, the gas leaves the filters at about 550°C and more than 20 atm and enters a chloride guard reactor, followed by a hot gas cleanup unit (HGCU). In the chloride guard reactor, traces of HCl are removed from the gas by reacting with sodium bicarbonate (nahcolite) in the form of pellets. The following reaction takes place:

$$HCl + NaHCO_3 \rightarrow NaCl + H_2O + CO_2 \quad (1)$$

In the HGCU unit, the gas first goes through a column filled with a solid absorbent that contains ZnO. By simple chemical exchange, the ZnO reacts at about 550°C with all the sulfur containing compounds in the gas and converts them into ZnS. A fraction of the sweet gas produced in this step is recycled and mixed with hot air to regenerate the HGCU unit (or one that operates in parallel) once the ZnO is spent or saturated. This regeneration reaction takes place at a temperature above 750°C and the SO_2-rich gas leaving the unit is sent to an acid plant to produce sulfuric acid. The resulting syngas is sent to a series of shift reactors and purification units that are based on the same processes used in steam reforming, as described below in the *Hydrogen, Syngas, and NH_3 Production* section.

In cold sweetening, the gas leaves the filters at a much lower temperature (350°C) and enters an acid scrubber where water is used to remove most, if not all, of the HCl, HCN, and NH_3 present in the gas stream. At this point, two different processes have evolved for producing power or H_2 (chemicals) from cold-sweetened sour syngas. In the first process, the gas is first sent to a COS hydrolysis unit (350°C), whereby a TiO_2/Al_2O_3 catalyst converts most of the COS and even CS_2 into H_2S. Then it is sent to a cold gas cleanup unit (CGCU), such as a Selexol unit or some similar process, where H_2S, SO_2, and other traces of sulfur-containing gases are removed. Note that a COS-CS_2 hydrolysis unit is not always required; a chemical scrubbing unit operating as a CGCU at 90-120°C that contains K_2CO_3 has proven to be successful in hydrolyzing COS and CS_2, while simultaneously removing sulfur-containing species all in one step. The CGCU tail gas, which contains all the sulfur compounds and a large fraction of CO_2, is sent to a sulfur recovery process, such as the Claus/SCOT process, where elemental sulfur is produced. Finally, the resulting syngas is sent to a series of shift reactors and purification units that are based on the same processes used in steam reforming, as described below in the *H_2, Syngas, and NH_3 Production* section.

In the second process, the sour syngas is sent to so a called sour shift reactor located upstream of the CGCU. This unique shift reactor contains a sulfur resistant catalyst made of Co and Mo to

treat the sour syngas. It operates at high pressure (> 20 atm) and in two steps: one at an intermediate temperature (315-430°C) and the other one at a lower temperature (205-230°C). Because COS and CS_2 hydrolysis takes place inside this reactor, a separate hydrolysis unit is not needed in this case.

Iron and Steel Manufacture [446,453-456]

The manufacture of steel constitutes the largest industrial producer of non-energy related CO_2, being responsible for about 29% of those CO_2 emissions (Tables 2 and 3, and Figure 3). A typical flow sheet for the manufacture of steel is given in Figure 7.

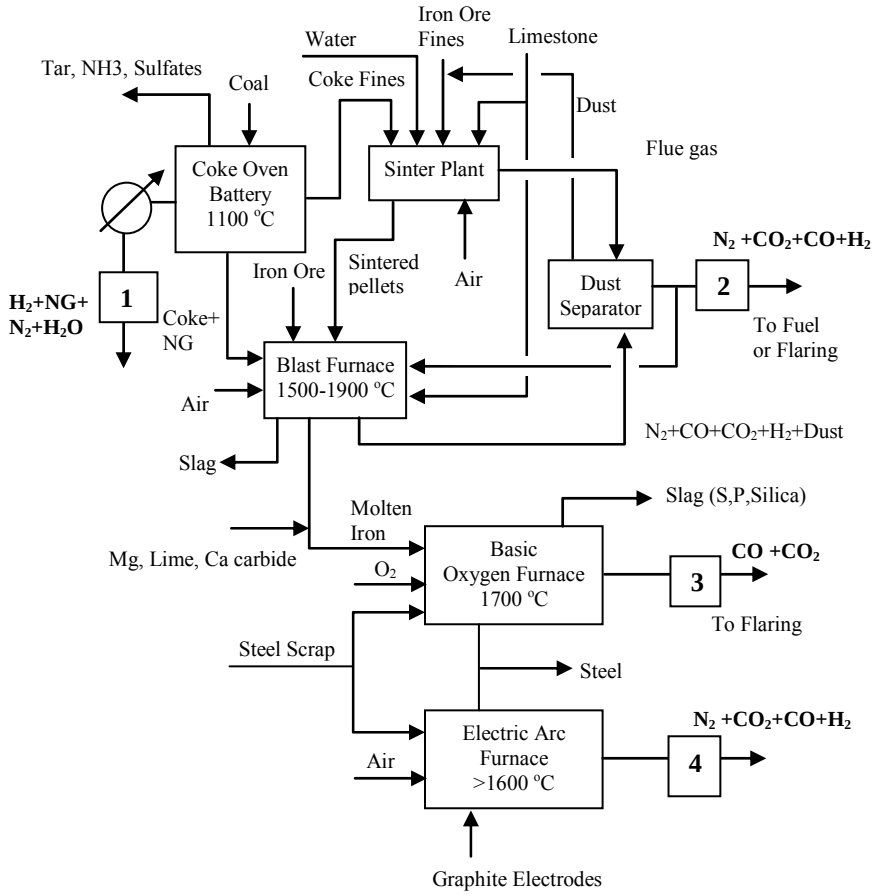


Figure 7. Flow sheet of a typical, state-of-the-art stainless steel production plant consisting of a coke oven, sinter plant, blast furnace, basic oxygen furnace (BOF), and electric arc furnace (EAF). CO_2 and CO are produced from burning methane, coal-coke conversion, and carbon removal from pig iron through all steps. The compositions of the numbered streams are shown in Table 14.

The corresponding stream compositions are given in Table 14, and capacity and flow rate information is given in Table 15. Steel manufacture starts with the coke making process, which involves the carbonization of coal at high temperature (1100°C) in an oxygen deficient atmosphere to produce coke, which is enriched in carbon relative to the raw coal. The gas leaving the coke oven is composed mainly of CH_4 and H_2 plus CO_2, CO, and heavier

hydrocarbons. This flue gas is used either as fuel or it is flared.

The next step, which is carried out in a sinter plant, is a pre-treatment step in the production of iron. Fine particles of iron ore, limestone, coke, and collected dust are agglomerated by combustion with air (1200^{o}C). These small agglomerates allow the passage of hot gases during the subsequent blast furnace operation. The result is a semi-molten mass called sinter that solidifies into porous pieces of appropriate size and strength for feeding into the blast furnace. Large quantities of CO_2, CO, VOCs, and NO_x emissions are produced during this step.

In the blast furnace, certain proportions of coke, iron ore, sinter, and limestone are mixed together and heated to temperatures of around 1500 to 1700^{o}C with a controlled supply of air to produce the so called pig iron. This step is where most of the CO_2 is generated that does not come from the burning of fuels. The coke as a reactant is essentially burned as a fuel to heat the furnace, and as it burns, it gives off CO, which ultimately reduces the iron oxide in both the iron ore and the sinter into metallic iron according to the following reaction:

$$Fe_2O_3 + 3CO \rightarrow 2Fe + 3CO_2 \quad (2)$$

The limestone is used to remove the silica present in the ore in the form of fusible calcium silicate, which floats to the top of the molten metal; as such, it is easy to separate. Without limestone, iron silicate is formed, resulting in a loss of metallic iron. The pig iron produced in this step contains about 92% iron, about 4% carbon, and a balance of silicon, manganese, phosphorus, and traces of sulfur.

This step is followed by a step that utilizes a basic oxygen furnace (BOF). About 75% of the hot metal from the blast furnace is poured into a pear-shaped basic oxygen furnace (BOF) that tilts sideways for charging and pouring. This hot metal is then mixed with 25% purchased scrap metal, along with desulfuring agents such as lime, calcium carbide, and magnesium. With a moving lance, pure oxygen is injected into the mix at various places in the BOF to combine with carbon and other unwanted elements such as silicon and phosphorus that are present in the pig iron. The heat released due to these reactions raises the furnace temperature (> 1600^{o}C) and facilitates melting of the mixture. CO is produced and leaves the reactor, while silica, calcium, and magnesium phosphates and sulfides become part of the slag that is separated from the molten steel.

Instead of a BOF, an electric arc furnace (EAF) is also used. In this furnace, energy is supplied electrically via graphite electrodes or chemically via mixing natural gas and oxygen through lances to melt the mixture. Whether the BOF or EAF are used, the steel forms in the same way, while producing CO and slag. Although it can process pig iron in the feed, the EAF process has been designed more specifically for the recuperation of steel from scrap. All CO produced in this and other steps in the steel industry is utilized as a reducing agent and in the generation of heat.

Lime and Cement Production [446,457]

The manufacture of cement and lime from limestone and dolomite constitute the second and fifth largest sources of CO_2 produced in non-energy related industrial processes (Tables 2 and 3, and

Figure 3), constituting together about 32 % of this total. A typical flow sheet for the manufacture of cement and lime is given in Figure 8. The corresponding stream compositions are given in Table 14, and capacity and flow rate information is given in Table 15. A review of the global cement industry and its associated CO_2 emissions has been given by Worrell et al. [458].

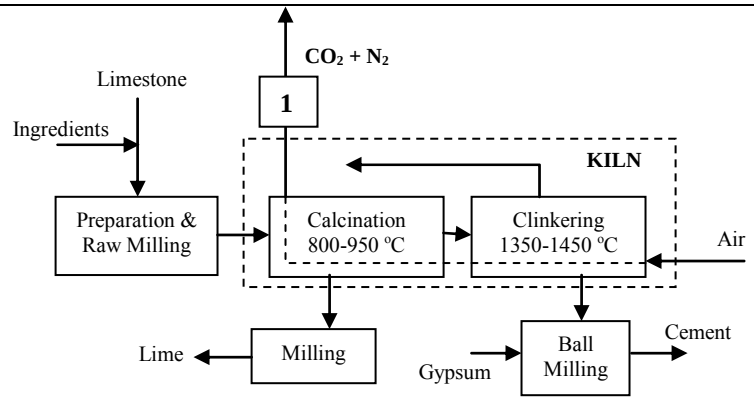


Figure 8. Flow sheet of a typical, state-of-the-art process for the manufacture of lime and cement. After a preparation and raw milling step, lime is produced through calcination within a kiln. Cement is produced in a further clinkering step and much more elevated temperatures. Most CO_2 is produced from the decomposition of carbonates and burning of kiln fuel. Final products are obtained following fine milling steps. The composition of the numbered stream is shown in Table 14.

Cement normally is produced in three steps. After an extraction and coarse milling process, the raw limestone is mixed with mineral additives and water in proportions that lead to the formation of pellets (i.e., clinker) of uniform quality. After a preheating step, the pellets are inserted into a rotary kiln where they undergo two steps. The first step consists of a calcination step at 800-900^{o}C where the calcium carbonate (i.e., limestone) in the pellets undergoes decomposition with the release of CO_2 according to:

$$CaCO_3 \rightarrow CaO + CO_2 \tag{3}$$

The CO_2 is produced at around 22 vol%, with it ranging from 14% to 33 vol%. This relatively high concentration of CO_2 makes it ideal for recovery as a saleable product.

Farther down in the kiln, at temperatures between 1350 and 1450^{o}C, additional clinkering completes the calcination stage and fuses the calcined raw mix into hard nodules (again referred to as clinker) that resemble small gray pebbles. The manufacture of cement is finished with a milling of the clinker to produce a fine grey powder. Gypsum ($CaSO_4$), which controls the rate of hydration of the cement in the cement-setting process, is blended with the ground clinker, along with other materials, to produce finished cement.

Lime is produced from limestone and dolomite in a very similar process. The major difference between them is that the rotary kiln is operated in one step to form the pellets during calcination at 800-900˚C. This calcination step again produces CO_2 according to the reaction depicted in Equation 3. The final product is then milled to produce a fine powder. This lime powder may be

sold as is or it may be mixed with water to produce a milky suspension and sold as lime slurry.

Hydrogen, Syngas, and NH_3 Production [446]

The manufacture of H_2, syngas, and NH_3 constitutes the third largest industrial producer of non-energy related CO_2, being responsible for about 10.4% of those CO_2 emissions (Tables 2 and 3 and Figure 3). A typical flow sheet for the manufacture of H_2, syngas (H_2 + CO), and NH_3 is given in Figure 9. The corresponding stream compositions are given in Table 14, and capacity and flow rate information is given in Table 15. A detailed report on hydrogen, syngas, and NH_3 production technologies by reforming, autothermal reforming, and partial oxidation processes has been published recently by the authors [1]. A brief overview is provided below, based on a typical reforming process.

CO_2 is produced as a by-product in the production of H_2, syngas, and NH_3. These important gases are all produced in a similar fashion through a chain of reforming and shift reactions. The source of the hydrogen and carbon in these gases, and hence the CO_2 that is formed, stems from the reforming of natural gas and other hydrocarbon feedstocks.

After leaving the reformer reactor at temperatures of over 1000^{o}C and pressures of up to 20 atm, the resulting syngas, which is relatively rich in CO_2, is cooled down and sent to either one or two water gas shift reactors. In these reactors, H_2O is utilized to convert most of the remaining CO into CO_2 while more H_2 is generated.

Before the advent of pressure swing adsorption (PSA) for H_2 purification in the early 1980s, older H_2 production plants (still in existence) required two steps for the water gas shift reaction to achieve maximum CO conversion into H_2 using H_2O and producing more CO_2 as the by-product. The first water gas shift reactor was a high-temperature shift reaction that converted most of the remaining CO into H_2 and CO_2 using a Fe-Cr catalyst at 315-430^{o}C. This step was then followed by the second water gas shift reactor, which was operated at a lower temperature of 203-230^{o}C. This reactor utilized a Cu-Zn catalyst to convert any remaining CO into H_2 and CO_2. The gas leaving this reactor, which contained less than 0.5 vol% CO, was sent to a high-pressure scrubbing process that removed nearly 100% of the CO_2 in the stream, typically at very high purity (> 98 vol%). It was then sent to a methanator, which reduced CO by converting it back to CH_4.

With the introduction of new NH_3 plants, with PSA units replacing the CO_2 scrubbing step for the purification of H_2, new avenues for CO_2 removal came into practice. Hydrogen purification with the PSA option became less expensive because it eliminated the need for the low temperature shift reactor and a methanation step to fully eliminate CO from the hydrogen stream. But the CO_2 was not enriched as much as it was before. The PSA tail gas does not contain more than 40 vol% CO_2 and is balanced with significantly high concentrations of H_2, CH_4, and even CO. At the present time the PSA tail gas is used as fuel, with the resulting CO_2 typically being released to the atmosphere.

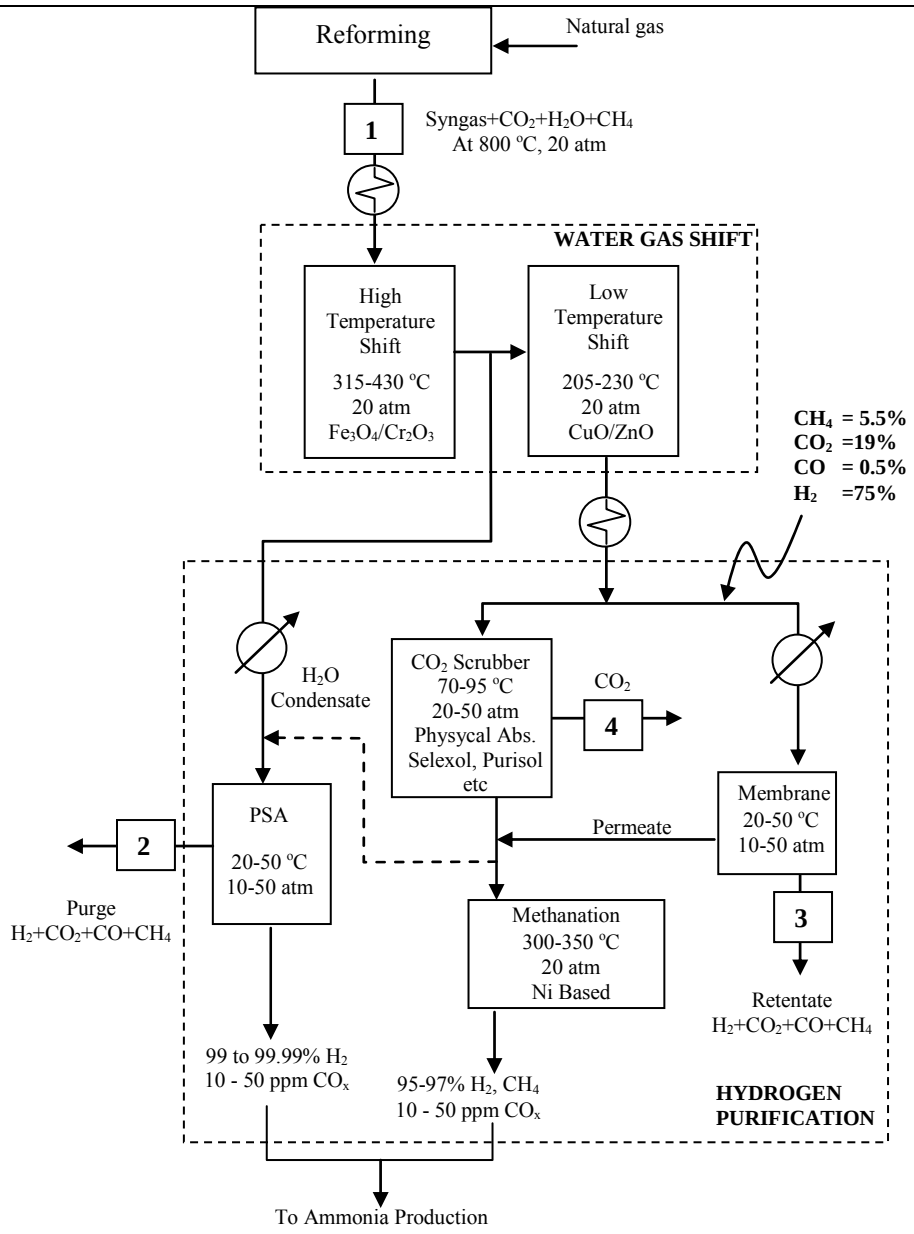


Figure 9. Flow sheet of a typical, state-of-the-art H_2 or NH_3 production plant. Shifted syngas, which is mostly H_2, CO_2, and CH_4 with traces of CO, is purified into H_2 using either CO_2 scrubbing with physical absorbents, PSA, or membranes. A methanation step may be required to convert the remaining CO into CH_4 when using scrubbing or membranes. The tail gas from the PSA or membrane unit (streams 2 and 3, respectively) are used as fuel. The compositions of the numbered streams are shown in Table 14.

H_2 selective membrane technology also is available commercially and is being used for H_2 production. This technology takes advantage of the relatively high H_2 concentration (> 75 vol%) produced from the low temperature shift reactor. However, the permeate, which is rich in H_2, requires recompression and may contain significant amounts of CO_2 that forces further H_2 purification. The high pressure-reject gas, which contains H_2, CO_2, CO, and CH_4 currently is

used for fuel, with the CO_2 again being released to the atmosphere.

Natural Gas Production [446,459]

A typical flow sheet for natural gas production is given in Figure 10. The corresponding stream compositions are given in Table 14, and capacity and flow rate information is given in Table 15. Natural gas production constitutes the fourth larger producer of CO_2 as a result of natural purification. This category accounts for around 10.1% of the non-energy related CO_2 emissions (Tables 2 and 3, and Figure 3).

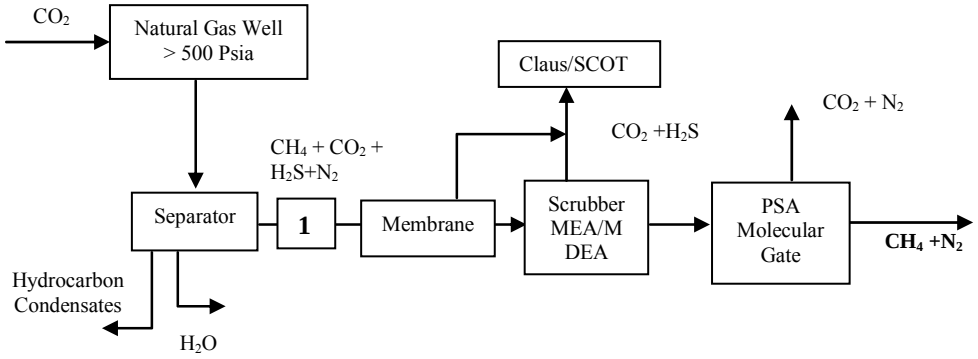


Figure 10. Flow sheet of a typical, state-of-the-art process for the production of natural gas. After extraction from a well at elevated pressures, a series of steps are carried out to remove water and C_{3+} vapors. Traditionally, the natural gas is then sweetened by scrubbing it with alkanolamines to remove the sulfur-bearing compounds and CO_2. Further steps may be required for the removal of excess N_2 or CO_2 in super sour streams. Membrane systems (with cellulose acetate, polyimide, or polyaramide) are used prior to scrubbing to reduce the large concentrations of both the CO_2 and sulfur-bearing compounds. Likewise, PSA systems with molecular sieves (titanosilicate molecular gates or zeolite molecular sieves) are located downstream of the scrubbing unit to remove the remaining CO_2 and excess N_2. Low-pressure wells may be assisted with CO_2 injection. The Claus/SCOT process (or similar processes), which is presented in Figure 7, are used to treat the tail gas from the scrubbing step to convert all the sulfur-bearing compounds into solid sulfur. The composition of the numbered stream is shown in Table 14.

Processed natural gas consists principally of methane, with a much smaller fraction (< 5 vol%) of ethane and propane. In a raw state, it is normally extracted as an associated gas, either free or dissolved, when extracted from oil wells, or as a non-associated gas when extracted from gas and condensate wells where there is little or no crude oil. Once separated from crude oil (if present), in addition to ethane and propane, natural gas in the raw state also contains some butanes and pentanes, and it may contain considerable amounts of water vapor, H_2S, CO_2, He, N_2, and other compounds such as Hg. The CO_2 emissions result from the so called natural gas sweetening steps that are associated with natural gas processing.

When natural gas contains H_2S, other sulfur bearing compounds, and CO_2, it normally is referred to as sour gas. After a series of dehydration steps, either with glycol absorption or adsorption with silica gel or activated alumina, and after removal of the C_2-C_5 fraction via absorption, the sour gas is sweetened through an absorption scrubbing process (typically, an ethanol-amine based process) that is followed by a desulfurization step (Claus/SCOT process), where all sulfur

compounds and CO_2 are removed. Natural gas sweetening is responsible for more than 15% of the total sulfur production in the US.

In the case of natural gas streams that are rich in N_2, only those streams containing more than 10 vol% N_2 can be economically blended with more dilute streams after the sweetening step. However, the concentration of CO_2, sulfur, and N_2 in some natural gas wells can be so high that traditional steps for gas sweetening may be insufficient. It is known, for example, that in 1 of every 10 wells the content of CO_2 is larger than 2 vol% and that in 1 of every 100 wells the CO_2 content is larger than 20 vol%. In the latter case, the CO_2 concentration can even exceed 50 vol%. The same is true with H_2S and N_2, where concentrations may vary between 2 and 98 vol% for the former and up to 20 vol% for the latter.

Aluminum Manufacture [446,454-456,459,460]

The manufacture of aluminum constitutes the sixth largest single source of non-energy related CO_2 emissions (Tables 2 and 3, and Figure 3) or about 2.6% of the total. A typical flow sheet for the manufacture of aluminum is given in Figure 11. The corresponding stream compositions are given in Table 14, and capacity and flow rate information is given in Table 15.

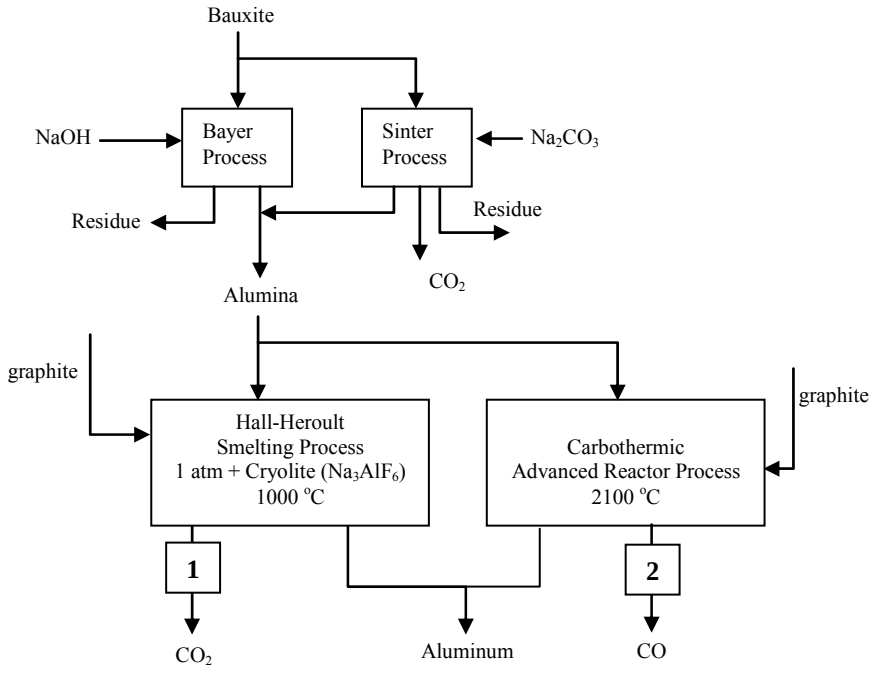


Figure 11. Flow sheet of typical, state-of-the-art processes for the manufacture of aluminum. In the first step, alumina is produced out of bauxite using either the Bayer process or the Sinter process. Alumina is then electrochemically converted into aluminum either by the Hall-Heroult process or the more recently developed carbothermic process. CO_2 is produced during the electrochemical decomposition of carbon made cathodes. The compositions of the numbered streams are shown in Table 14.

The manufacture of aluminum starts with the production of alumina from bauxite. Bauxite is a mineral rich in gibbsite ($Al_2O_3 \bullet 3H_2O$) and boehmite ($Al_2O_3 \bullet 3H_2O$). It also contains significant concentrations of oxides and hydroxides of Fe, Ti, and Si. Alumina is manufactured via the Bayer process, the Sinter process, or a combination of the two processes.

In the Bayer process, which is considered economically suitable for bauxites containing 30-60% Al_2O_3 as aluminum hydroxides and less than 7% SiO_2 as clay (kaolin) minerals, the bauxite is reacted with a hot aqueous solution of NaOH (~ 200 g/L) to extract the aluminum in the form of an oxide (such as $Na_2O \bullet Al_2O_3$). The temperature of the digestion process varies between 150 and 250^{o}C depending on whether the bauxite is richer in gibbsite or boehmite. Boehmite cannot be economically extracted below about 200^{o}C. This digestion process is followed by a sedimentation and filtration step, where oxides of Fe, Ti, and Si are removed. The caustic aluminate liquor is then sent to a crystallizer (60-70^{o}C) that forms precipitates of gibbsite. The precipitate is dried and filtered and finally undergoes a dry calcination step at 900-1100^{o}C that leads to the formation of 99.5% pure alumina.

The Sinter process starts with a rotary kiln, wherein pellets of the bauxite and minerals of sodium carbonate and sodium hydroxide are converted into $NaAlO_2$ at a relatively high temperature of 900-1100^{o}C. The sintered material is then converted into a very fine white alumina powder after realizing a series of steps that include water extraction, precipitation, and desilication. However, because of its complexity and high energy consumption, the Sinter process is of minor commercial significance compared to the Bayer process.

The purified alumina is then fed into a Hall-Heroult smelting process, consisting of one or more (typically three) potlines of several ovens, where aluminum is produced electrochemically at about 1000^{o}C. The process is based on the use of cryolite (Na_3AlF_3), which melts at temperatures a little under 1000^{o}C. It is able to dissolve alumina to the extent of 15 wt% at 1030^{o}C. Without cryolite, the temperature of the reactor would need to be over 2000^{o}C, which is when alumina starts to melt. The electrochemical energy is provided in the form of graphite anodes and carbon cathodes placed in the upper and lower parts of the reactor, respectively. CO_2 is evolved from the surface of the anodes and becomes the largest fraction of the off gas, while alumina reduces into aluminum when in contact with the cathode surface. The overall reaction is given by:

$$2Al_2O_3 + 3C \rightarrow 4Al + 3CO_2 \quad (4)$$

Besides CO_2, the major emissions are perflurocarbons that result from the decomposition of cryolite and SO_2 that derives from sulfur impurities in the graphite.

An alternative electrochemical process to the Hall-Heroult process, recently developed for the production of aluminum out of alumina, is the carbothermic advanced reactor process (CARP). CARP also uses graphite as the anode, but it eliminates the use of cryolite so that the reactor temperature must reach 2000^{o}C. This process has been shown to be more economically viable, and it eliminates all perflourocarbon and carbon anode baking furnace emissions. The major component of the off gas is CO instead of CO_2, which can be flared to produce CO_2 anyway.

Sulfur Recovery Processes [446,461,462]

Sulfur recovery in the petroleum refineries, coke production and natural gas sweetening is another important source of CO_2 emissions.Sulfur recovery constitutes around 25% of the CO_2 emissions produced in the natural gas industry, while at the same time it constitutes less than 2% of the total non-energy related CO_2 emissions. Hence, the CO_2 emissions due to sulfur recovery processes are not included here in tables or figures.

Today, the sulfur recovery industry produces about 9 millions tons of pure sulfur per year, 10% of which is in the form of sulfuric acid. Around 17 % of the total sulfur produced in the U.S. comes from natural gas sweetening, while the rest comes from oil refineries and a very minor fraction from coke manufacturing. Currently, the principal process that is used for sulfur recovery is based on the Claus and Shell-Claus offgas treating (SCOT) technologies, which constitute more than 80% of the total sulfur recovery plants in service in the U.S. A typical flow sheet for these technologies is given in Figure 12. The corresponding stream compositions are given in Table 14, and capacity and flow rate information is given in Table 15.

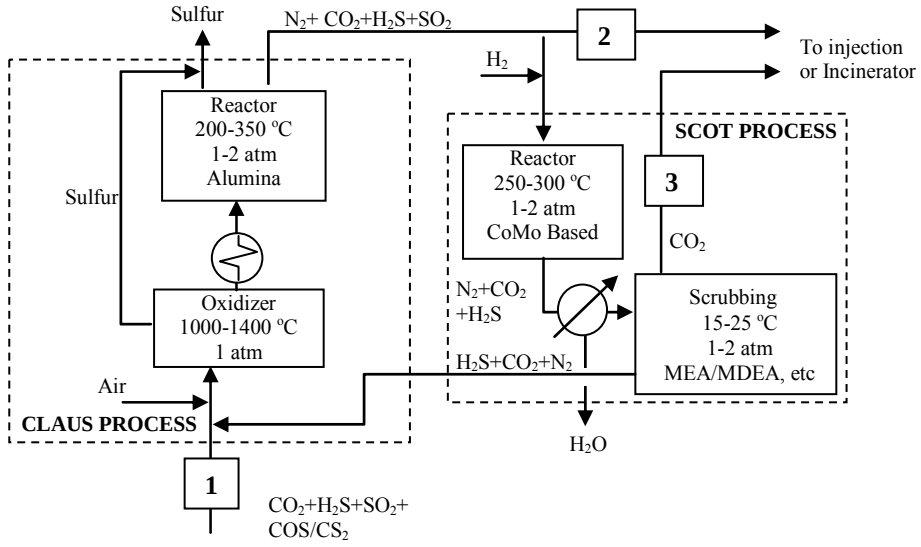


Figure 12. Flow sheet of a typical, state-of-the-art Claus-SCOT process for the production of sulfur from a stream rich in sulfur-bearing compounds. In the Claus step, the gross fraction of the sulfur is removed from the stream, while leaving only H_2S and SO_2 in the processed gas as sulfur-bearing species. In the SCOT step, the gas is further polished by removing the remaining sulfur by first converting SO_2 into H_2S and then using a MEA/MDEA scrubbing step, the tail of which is sent back to the Claus step. The compositions of the numbered streams are shown in Table 14.

The Claus/SCOT process removes species from sour streams that contain sulfur and converts them into elemental sulfur. The process is designed to treat gas streams containing more than 50 vol% H_2S, with CO_2 being the second largest species. The process starts with the Claus step, which produces elemental sulfur. This process is followed by the SCOT process, which converts all sulfur compounds in the gas leaving the Claus unit (e.g., SO_2, COS, CS_2 and elemental sulfur), into H_2S, which is then recycled back to the Claus step for further processing. The

remaining gas is sent to an incinerator prior to exhausting to the atmosphere.

The Claus process consists of two steps. The first step, which is referred to as the thermal step, is basically an incineration step. It is where the sour gas becomes combined with air at high temperatures (1000-1400^{o}C) to oxidize at least one third of the H_2S into SO_2 according to:

$$H_2S + 1.5O_2 \rightarrow SO_2 + H_2O \tag{5}$$

This reacted gas then goes to the second step that consists of a series of reactors and condensers, where H_2S and SO_2 react (200-350^{o}C) to produce elemental sulfur according to:

$$2H_2S + SO_2 \rightarrow S + 2H_2O \tag{6}$$

The elemental sulfur is removed in the liquid state through the condensers.

The reactors consist of packed beds containing alumina as the principal catalyst, but they may use as an option Co-Mo as the catalyst. At this step, all traces of NH_3 also react to form H_2 and N_2, and all traces of organic compounds combust into H_2O and CO_2. More than 95% of the sulfur compounds are removed in this step. Several improvements have been done to improve this process. For example, the superclaus process converts H_2S directly into elemental sulfur in one step. The gases produced during this step are mainly N_2, CO_2, and H_2O.

The SCOT process also consists of two steps. The first step consists of a reactor containing Co-Mo catalyst, where all the sulfur compounds react at about 250-300^{o}C with H_2 to form H_2S. Hydrogen may already be present in the Claus tail gas. Otherwise, it is added upstream. This reactor is then followed by an absorption process that removes more than 99% of the H_2S from the processed gas, where the H_2S-rich gas is sent back to the Claus step. Similar to the Cluas process, the gases produced during the SCOT process are mainly N_2, CO_2, and H_2O.

Landfill and Coal Bed Methane Gases [463,464]

Typical flow sheets for landfill and coal bed methane gas production are given in Figures 13a and 13b. The corresponding stream compositions are given in Table 14, and capacity and flow rate information is given in Table 15. These two gas streams are not included in any category in Table 2. Nevertheless, they are both sources of CO_2 emissions, albeit, relatively new sources.

Landfills are scattered all over the U.S. and the world. Each one covers anywhere from 10 to 1500 acres of land. They consist of layers 50 to 100 ft thick of solid human-generated wastes that are entombed beneath 5 ft of inert material that plays the role of reducing both gas permeation and rainfall water infiltration.

Landfill gas (LFG) is produced naturally from the anaerobic decomposition of the waste material. As a result, it contains relatively high concentrations of CH_4. This gas either slowly permeates the landfill cap into the environment, or it builds up pressure within the landfill

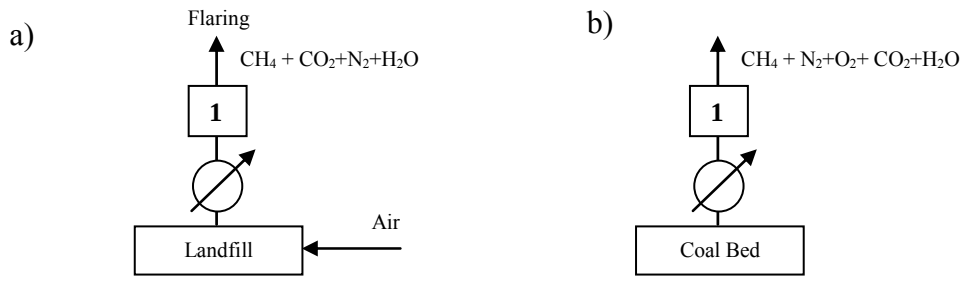


Figure 13. Flow sheet of a typical, state-of-the-art a) solid waste landfill gas recovery process and b) coal bed methane gas recovery process. Most of the permeating gas out of landfills consists of methane and carbon dioxide in an almost 1:1 split, which naturally vents to the atmosphere or is flared to convert methane into CO_2. In coal bed methane gas, methane splits 1:1 with N_2. Potential mechanical extraction of methane by vacuum may lead to diffusion of air into the landfill and may require separation steps similar to those of natural gas production. The same considerations are valid for coal bed methane gas, as oxygen and nitrogen may be present in considerable amounts. The compositions of the numbered streams for flow sheets (a) and (b) are shown in Table 14.

creating the potential for an explosion. Over the past few decades, pipes have been installed in most capped landfills to facilitate bringing the LFG to the surface for flaring or recovery as an energy source. For a typical LFG site, the flow rate is 2.5 million standard cubic feet of gas per day.

About 45 vol% of typical LFG is composed of CH_4. Another 45 vol% is composed of CO_2. The remaining 10 vol% is composed of a small amount of water vapor (saturated). N_2 and some toxic non-methane organic compounds, such as VOCs, and sulfur- and chlorine-bearing compounds are also present in typical LFG.

In the forced extraction of LFG for energy recovery, the extraction lines are subjected to vacuum. This causes the infiltration of significant amounts of air into the landfill. As a result, significant amounts of N_2 become incorporated into the extracted gas mixture, which dilutes both the CH_4 and CO_2 constituents. Some, but not necessarily all, of the oxygen is bioprocessed near the surface before reaching the suction lines.

Coal bed methane gas represents not only a virtually untapped source of energy, but also another source of CO_2 emissions if tapped for this energy. However, the coal mine itself is being considered as a viable place to sequestor CO_2. In such a situation, the CO_2 emissions are offset by the CO_2 storage, and the storage of CO_2 comes with energy benefits because the mine produces coal bed methane gas that can be recovered during the storage process. Coal bed methane gas, much like landfill gas, contains N_2, O_2, CH_4, CO_2 and H_2O, but the amounts of these gases in each case are quite different. Coal bed methane contains about the same amount of CH_4, but much more N_2 and O_2 and much less CO_2 than landfill gas (Table 14). The composition of coal bed methane gas can vary considerably, however, from coal mine to coal mine.

Fermentation to Produce Ethanol [465]

A typical flow sheet for the manufacture of ethanol through fermentation is given in Figure 14.

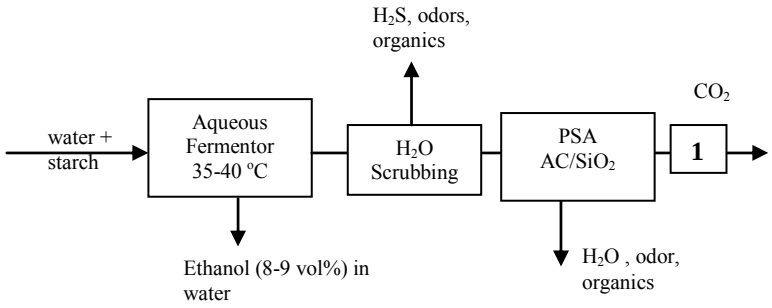


Figure 14. Flow sheet of a typical, state-of-the-art fermentation process for the production of ethanol typically out of corn-starch. The fermented juice produced contains about 8-9 wt% ethanol; this juice is ready for distillation. CO_2 is produced as result of a methabolic process by yeast. The composition of the numbered stream is shown in Table 14.

The corresponding stream compositions are given in Table 14, and capacity and flow rate information is given in Table 15. Ethanol manufacture is not included in any table or figure because it constitutes less than 2% of the non-energy related CO_2 emissions. Nevertheless, ethanol manufacture from the fermentation of either cornstarch or ground whole corn is increasingly becoming a significant source of CO_2 emissions. During 2004, 3.4 billion gallons of ethanol were produced in the US, a nearly 21% increase from the 2.81 billion gallons produced the previous year. It is highly likely that the non-fuel related CO_2 emissions in this area have already overcome those of the aluminum industry.

Nearly 4000 tons of CO_2 are produced along with each million gallons of ethanol. In countries that promote the use of ethanol as a motor fuel, a growth trend is apparent and likely to continue. The ethanol produced worldwide by fermentation constitutes more than 90% of the manufactured ethanol destined for use as a motor fuel. In recent years it has accounted for around 1% of the U.S. gasoline supply, which corresponds to the U.S. using nearly 2 billion gallons of fuel ethanol annually. This is changing rapidly in the US, with its use on the rise.

The ethanol fermentation process is carried out in a batch mode at a temperature of around 35°C. Water is mixed with baking yeast and milled corn that contains between 150 and 250 g/L of starch. The reactants are converted into a juice that contains between 7 and 9 vol% percent ethanol. The offgas is mostly CO_2, with H_2O and ethanol being very minor components. After a series of purification steps, including odor removal and drying, much (but not all) of the CO_2 produced during ethanol manufacture is being sold for commercial use. Adsoption processes for trace contaminant and moisture removal, followed by condensation and liquefaction are the principal methods for the purification of the CO_2 generated from ethanol production.

Mitigation Approaches to Combat CO_2 Emissions

One approach to address CO_2 emissions worldwide is known as the Kyoto Protocol, which was introduced in December 1997. So far 120 countries, responsible for 44% of the world's

greenhouse gas emissions have ratified this agreement; the U.S. has not signed on. In general, these countries have agreed to reduce their anthropogenic CO_2 equivalent emissions of greenhouse gases to levels that are at least 5% below their 1990 levels for the period of 2008 to 2012. As of early 2006, a number of countries had begun curbing emissions, including Germany, which has cut emissions to four-fifths of their 1990 levels. However, global CO_2 emissions are still rising. Emissions from Canada and Japan, two countries that ratified the Kyoto Protocol, are increasing [466], and Canada has admitted that the required Kyoto protocol emissions levels are unachievable [467]. It appears that the Kyoto Protocol will be challenged to meet its goals.

Another approach that has been quite effective outside the U.S. has been the institution of a tax associated with the release of CO_2 into the atmosphere. As an example, a 1996 Norwegian carbon tax of $50 U.S. per ton of CO_2 produced forced a natural gas producer to store CO_2 in an undersea aquifer rather than release it into the air [468]. A penalty or tax on CO_2 emissions in the U.S. will likely need to be considered, especially on fossil fuel power plant operations.

There has also been a drive to develop energy efficient and cost effective technologies to integrate the production of energy with the production of chemicals. The IGCC power plants that arose in the mid 1980s are designed to produce H_2, synthesis gas, Fisher-Tropsch liquids, ammonia, methanol, fuel and town gases, mid distillates, steam, and or electricity from various fossil fuel feedstocks. A summary of the 29 largest commercial IGCC or related processes (e.g., NGCC power plants) that are operating or under development as of January 2000 is provided in Table 16. Also, numerous demonstration projects are under way worldwide and in the US.

There are a number of reported benefits of IGCC technologies compared to traditional PC-fired power plants [469]. An IGCC is currently the most efficient means to convert coal into electricity, requiring around 10 to 35% less fuel compared to traditional coal fired power plants. They also require about 30% less water than their coal fired counterparts because the turbines do not require cooling. Their footprint is also considerably smaller, and an IGCC plant does not contribute nearly as much waste to landfills because many of the wastes are saleable items. Finally, an IGCC plant is more amenable to CO_2 capture and sequestration as the CO_2 can be removed before entering the turbine, whereas in traditional coal fired power plants it can only be removed after combustion. However, the capitol and operating costs of an IGCC plant are not as favorable as initially anticipated [470], and operational problems have plagued some units [471].

A recent MIT report [470] presented a study on the impact of a CO_2 emission tax on the cost of retrofitting existing PC or building new (e.g., IGCC) fossil fuel power plants based on old and new technologies with the tax ranging from $1 to $35/t CO_2. When a CO_2 tax was not considered, the PC type power plant was found to be more economical than the IGCC type power plant, but only by a small margin [470]. However, when a tax of $10 to $30/t CO_2 was factored into the analysis, the IGCC type plant became marginally more economical than a PC type power plant. Since it is anticipated that CO_2 capture and storage technology may be considered as an essential part of any future power plant, IGCC technology should become the standard for the industry. Because IGCC technology is more amenable to CO_2 capture, it should also foster the continued development of CO_2 recovery, capture, storage, and sequestration technologies.

The U.S. DOE has also shown that the separation of CO_2 represents 75% of the overall cost associated with its separation, storage, transport, and sequestration operations. This would have a significant impact on the cost of electricity. For example, a typical 500 MW PC fired power plant produces 11,000 t CO_2/day [2]. The U.S. DOE has estimated the cost of capturing CO_2 from power plants and the impact on the cost of electricity [3]. The cost to recovery CO_2 from fossil fuel power plant combustion processes is estimated to be \$40/t of CO_2 produced using currently available technology (e.g., amine scrubbers and cryogenic coolers). This cost could raise the price of electricity by \$0.025 to \$0.04/kWh. With electricity costs varying from around \$0.08 to \$0.11/kWh, this would represent up to a 50% increase in the cost of electricity – thus, the need for improved technology, like IGCC and other technologies, is clear.

It is worth putting the above numbers on the CO_2 emissions from a typical 500 MW coal fired power plant into perspective. There are around five hundred 500 MW coal fired power plants in the U.S. today that produce 11,000 t CO_2/day. With the density of cryogenic or compressed liquid CO_2 (1.03 g/cm^3) being essentially that of water (1.00 g/cm^3), the volume of liquid CO_2 that must be processed per year from each one of these power plants fills two 100 story buildings the size of the twin towers. This is a daunting volume of gas or liquid CO_2 that must be stored underground at each power plant (improbable) or transported via a gas or liquid pipeline to a yet to be determined centralized CO_2 sequestration site (probable, but costly as noted above).

To address the complex issues of CO_2 emissions, a "CO_2 Capture Project" was initiated in 2000 by eight of the world's leading energy companies, including BP, ChevronTexaco, Eni, Norsk Hydro, Suncor, Shell, EnCana, and Statoil. This substantial, international effort addresses the issues to achieve an environmentally acceptable reduction of CO_2 emissions with competitive pricing that is compatible with our global energy supply. Under the leadership of Linda Curran of BP, this team aims to develop new, breakthrough technologies to reduce the cost of CO_2 separation, capture, and geologic storage from combustion sources. This R&D is being conducted together with governments and other stakeholders to deliver technology that is cost-effective and meets the needs of society. Hopefully these technologies will be widely used by many different industries. More information can be found at http://www.co2captureproject.org .

In recent years, a group of scientists from Harvard, Columbia, and MIT, led by Isaac Berzin through GreenFuel Technologies Corp., have been developing a technology that uses algae to reduce CO_2 emissions from power plants. The approach is quite attractive as algae not only have the ability and capacity to effectively separate CO_2 from gas streams, but its biomass can also be used for biodiesel production. In fact, algae growth can be so prolific that biodiesel generated from algae can yield about 15,000 gallons of biodiesel per acre per year compared to only 60 gallons of biodiesel per acre per year from soybean. Putting this into perspective, a 1,000 MW power plant using the GreenFuel system could produce 40 million gallons of biodiesel and 50 million gallons of ethanol per year on a 2,000 acre farm near the power plant. The fuel produced from this one farm in a year corresponds with about 20% of the amount consumed daily in the U.S. by transportation. Moreover, with a 3 MW cogeneration demonstration plant at MIT having 50 to 80% of its CO_2 emissions removed by the algae-based system, the potential to remove 100% of the CO_2 emissions from power plants certainly exists. GreenFuel has launched small projects in Arizona, Massachusetts, and New York. A large U.S. utility company and a major U.S. power generator are also poised to begin partnerships with them to build full-scale power

plants. More information can be found in two patent applications by Berzin [472,473] and at the GreenFuel website: http://www.greenfuelonline.com.

Expanding the Definition of CO_2 Capture Approaches used in Power Plants

In this section, post-combustion, pre-combustion, and oxyfuel combustion approaches that traditionally have been considered for the capture of CO_2 from fossil fuel power plants are described in such a way as to make them general approaches that can be adopted for use with any CO_2 producing process. The post-combustion approach consists of the removal of CO_2 from flue gas. Flue gas typically is low in both pressure and CO_2 concentration (1 atm, and 3 to 20 vol%, respectively). The post-combustion approach is the only economical approach to existing air-fueled power plants based on pulverized carbon or natural gas fuel sources.

In the pre-combustion approach, CO_2 is separated from the gas stream prior to its conversion into flue gas. This approach is applied to produce gases other than CO_2, such as CO and H_2, from a potentially CO_2-producing source. The pre-combustion approach is unique to the IGCC and NGCC power plant technologies. Nevertheless, the gas to be treated consists typically of synthesis or shifted gas at relatively high partial pressures of CO_2 (15 and 40 vol% at total pressures of over 20 atm).

In the oxyfuel combustion approach, N_2 is excluded from the combustion process to produce flue gas with elevated CO_2 concentrations. This methodology also eliminates the need for post combustion NO_x removal. Also, in IGCC and NGCC power plant technologies controlled amounts of pure oxygen are added to achieve partial oxidation of the fuel during the initial gasification step. The oxyfuel combustion approach also could be applied to existing fossil fuel power plants, but the design and materials of construction may not be compatible with the use of higher concentrations of oxygen.

More broadly defined post-combustion, pre-combustion, and oxyfuel combustion concepts that can be applied to CO_2 separations in non-energy related processes are presented conceptually in Figure 15. The post combustion approach involves the use of any CO_2 capture step where the gas stream has no energetic value. A typical gas may consist primarily of flue gas produced during a combustion or flaring step. Examples of these kinds of gas streams include those resulting from metabolic combustion (i.e., fermentation) or reactions facilitated by the direct contact of a combustion step, such as autothermal reforming, or those in cement kilns and lime production.

The pre-combustion approach consists of the use of any CO_2 capture step in a process where the gas stream has some value, energetic or otherwise. Examples of these kinds of gas streams are found during steel industry blast furnace operations that typically are rich in CO, the tail gas from a pressure swing adsorption unit of an ammonia production plant that are typically rich in H_2, or even natural gas before sweetening.

The oxyfuel combustion approach consists of using pure O_2 or O_2 enriched air as oxidants in reaction processes that produce CO_2 as a by-product. This approach offers the possibility for improving the economics of CO_2 production. Examples of where this approach can be used

include in combustion processes and in the production of iron and steel, lime and cement, and NH_3.

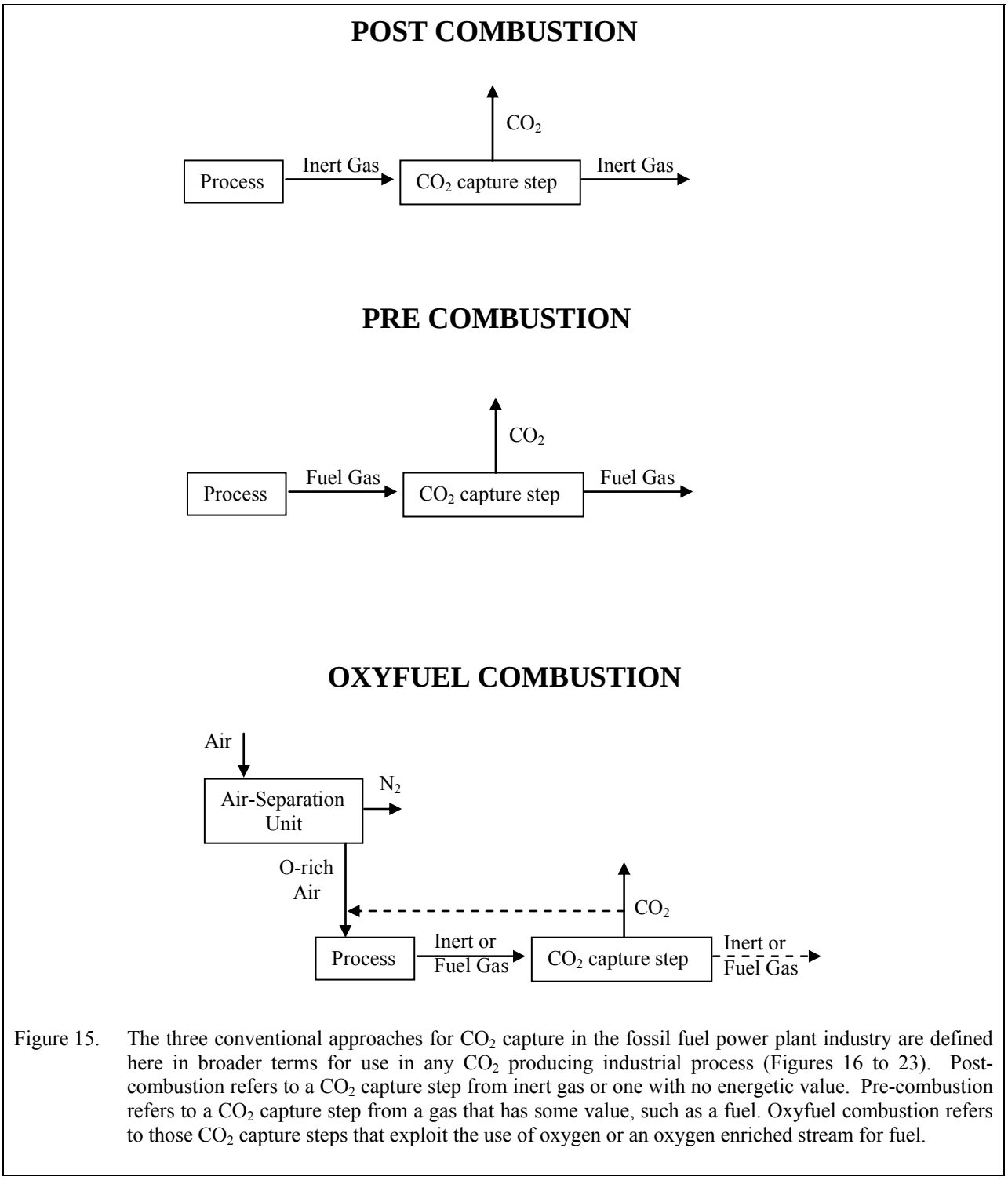


Figure 15. The three conventional approaches for CO_2 capture in the fossil fuel power plant industry are defined here in broader terms for use in any CO_2 producing industrial process (Figures 16 to 23). Post-combustion refers to a CO_2 capture step from inert gas or one with no energetic value. Pre-combustion refers to a CO_2 capture step from a gas that has some value, such as a fuel. Oxyfuel combustion refers to those CO_2 capture steps that exploit the use of oxygen or an oxygen enriched stream for fuel.

Conceptual Flow Sheets for Additional Guidance

The flow sheets given in Figures 4 to 14 for the most intense CO_2- producing processes were discussed at length in a preceeding section. They should be used for guidance to foster ideas for near- and long-term CO_2 production plant modifications with adsorption and membrane technologies. To further assist in this goal, new conceptual flow sheets have also been devised that are based on the post-combustion, pre-combustion and oxyfuel combustion approaches that have evolved over the years for the capture of CO_2 from fossil fuel power plants [468], and that were just introduced in the last section. They are given in Figures 16 to 23. For each of the CO_2 producing processes discussed in this report, a new flow sheet has been drawn that includes the incorporation of post-combustion, pre-combustion and/or oxyfuel combustion approaches.

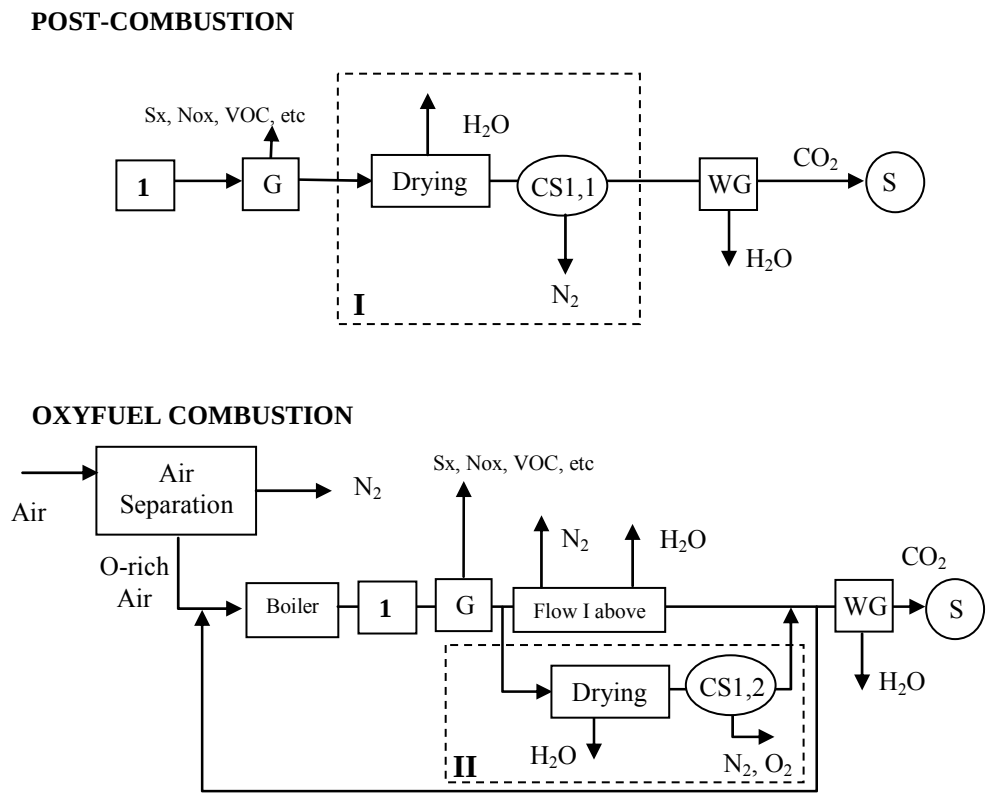


Figure 16. Post-combustion and oxyfuel-combustion approaches for the capture and concentration of CO_2 in combustion processes for stream 1 in Figure 4. The shorthand notation used here appears as CS#,# or CS#-#,#. CS stands for a CO_2 separation step. The first number (#) corresponds to a figure in the report (or figures in the report as indicated by #-#). This number (or numbers) corresponds to one (or more) of the CO_2 producing flowsheets depicted in Figures 4 to 14. The second number (#) after the comma represents the proposed CO_2 separation step that is indicated within the boxed region labeled with the corresponding Roman numeral. WG refers to a guard step particular for water, WGS refers to a water gas shift step, CS1,1 and CS1,2 refer to CO_2 separation steps appropriate to boxed flow sheets I and II, respectively, and S refers to the final CO_2 sequestration step. This final CO_2 stream is H_2O free but may contain small amounts CH_4, CO, O_2 and H_2. At the CO_2 separation steps, boxed flow sheets I and II contain CO_2 and N_2 as main gas components. Boxed flow sheet I is rich in N_2, while boxed flow sheet II is lean in this gas species. Depending on the CO_2 concentration, Figure 24 provides alternative processes for the CO_2 separation steps CS1,1 and CS1,2.

Within each of these new flow sheets, potential locations have been proposed where a CO_2 separations unit may be able to augment the performance of the current CO_2 producing plant.

At this point, the differentiation between these locations is not based on the type of separation process that may be applicable (e.g., adsorption, membrane); rather, it is based on the quality of the stream (i.e., the composition and CO_2 concentration in the stream). Hence, the proposed CO_2 separation processes for each of the indicated locations shown in Figures 16 to 23 are identified in Figures 24 to 26, where streams have been classified according to three main categories: 1) streams free of H_2 and sulfur bearing compounds, 2) streams containing significant H_2 and no sulfur bearing compounds, and 3) streams containing significant concentrations of sulfur bearing compounds. Within each classification and according to the quality of the stream, one or more separation units (e.g., liquefaction, absorption, adsorption, or membrane) is suggested where they may be most advantageous.

Also, stream compositions and conditions differ widely, depending on the process. For example, the removal of CO_2 from coal-fired power plants is very different from natural gas sweetening. In the former, the CO_2 is dilute, at low pressure, and dirty. In the latter, the CO_2 can be concentrated, at high pressure, and potentially may have a high sulfur content. The conditions of all the process streams are given in this report to ensure that these important design and development criteria are not overlooked.

These conceptual flowsheets, and corresponding stream differentiations, should be especially helpful to guide the near- and far-term developments of new adsorption and membrane processes for CO_2 separation or capture from industrial sources.

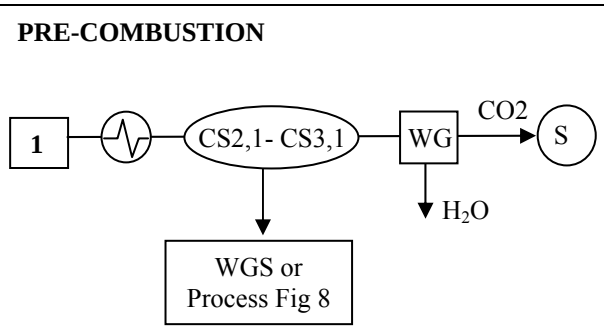


Figure 17. Pre-combustion approaches for the capture and concentration of CO_2 in the coal gasification industry for stream 1 in Figures 5 and 6. The shorthand notation used here appears as CS#,# or CS#-#,#. CS stands for a CO_2 separation step. The first number (#) corresponds to a figure in the report (or figures in the report as indicated by #-#). This number (or numbers) corresponds to one (or more) of the CO_2 producing flowsheets depicted in Figures 4 to 14. The second number (#) after the comma represents the proposed CO_2 separation step that is indicated within the boxed region labeled with the corresponding Roman numeral. WG refers to a guard step particular for water, WGS refers to a water gas shift step, CS2,1 and CS3,1 refer to a CO_2 separation step appropriate for the process in Figures 5 and 6, respectively, and S refers to the final CO_2 sequestration step. This final CO_2 stream is H_2O free but may contain small amounts CH_4, CO and H_2. At the CO_2 separation steps, boxed flow sheets I and II contain CO_2, CO, H_2, and CH_4 as main gas components. Depending on the CO_2 concentration, Figure 22 provides detailed alternative processes for the CO_2 separation steps CS2,1 and CS3,1.

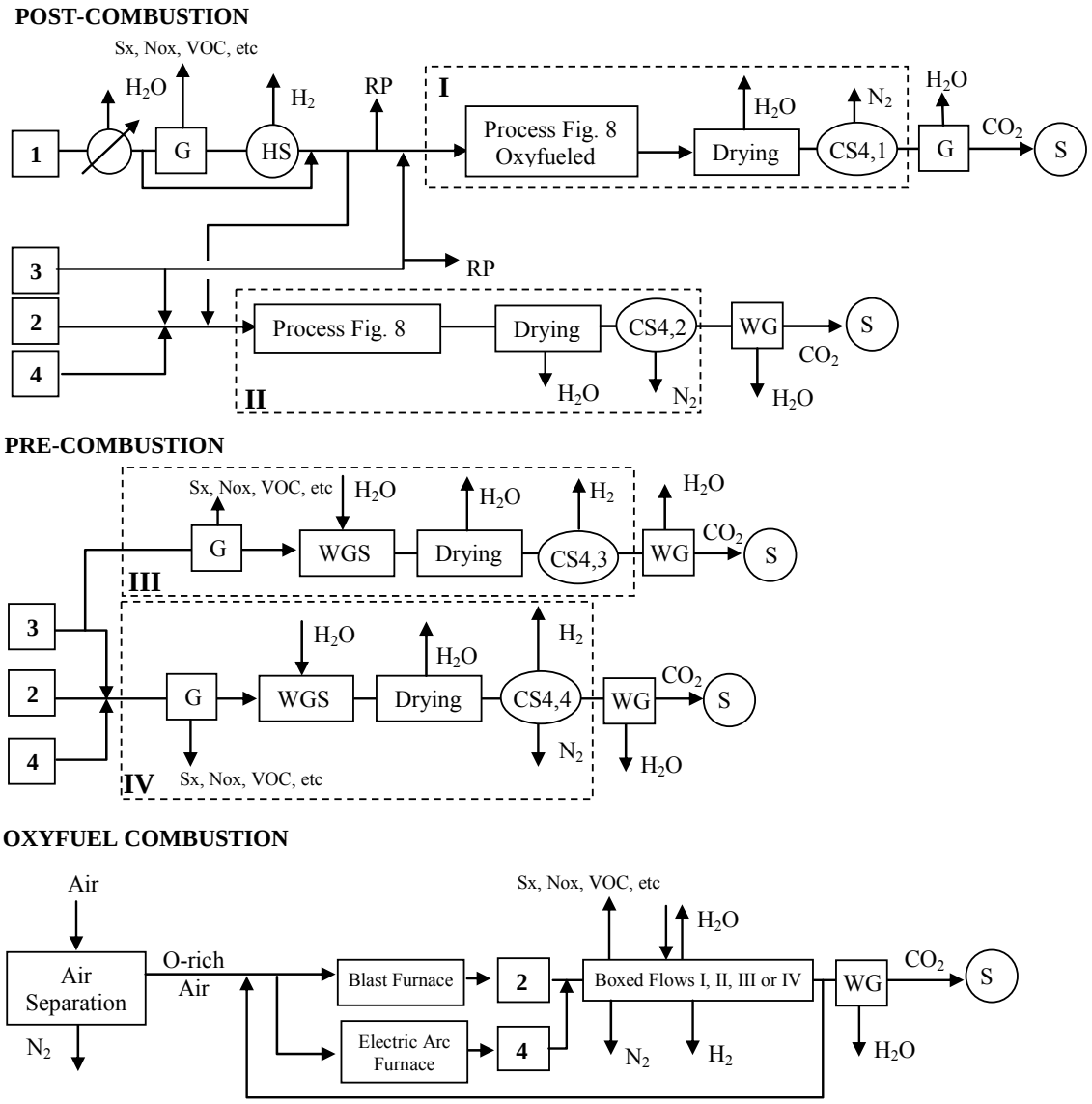


Figure 18. Post-combustion, pre-combustion, and oxyfuel combustion approaches for capture and concentration of CO_2 in the stainless steel industry for the streams 1 through 4 defined in Figure 7. The shorthand notation used here appears as CS#,# or CS#-#,#. CS stands for a CO_2 separation step. The first number (#) corresponds to a figure in the report (or figures in the report as indicated by #-#). This number (or numbers) corresponds to one (or more) of the CO_2 producing flowsheets depicted in Figures 4 to 14. The second number (#) after the comma represents the proposed CO_2 separation step that is indicated within the boxed region labeled with the corresponding Roman numeral. G refers to a guard step, WG refers to a guard step particular for water, HS refers to a hydrogen separation step, WGS refers to a water gas shift step, CS4,1 through CS4,4 refer to CO_2 separation steps appropriate to boxed flow sheets I through IV, respectively, and S refers to the final CO_2 sequestration step. A stream labelled with CO_2 indicates that stream is ready for injection (i.e., sequestration). This stream is H_2O free but may contain small amounts of N_2, CH_4, O_2 and H_2. At the CO_2 separation steps, boxed flows I and II contain CO_2 and N_2 as main gas components, while boxed flows III and IV contain CO_2, N_2 and H_2 as the main gas components. Boxed flow sheets I and III are lean in N_2, while boxed flow sheets II and IV are rich in this gas species. Depending on the CO_2 concentration, Figures 21 and 22 provide alternative processes for the CO_2 separation steps CS4,1 through CS4,4.

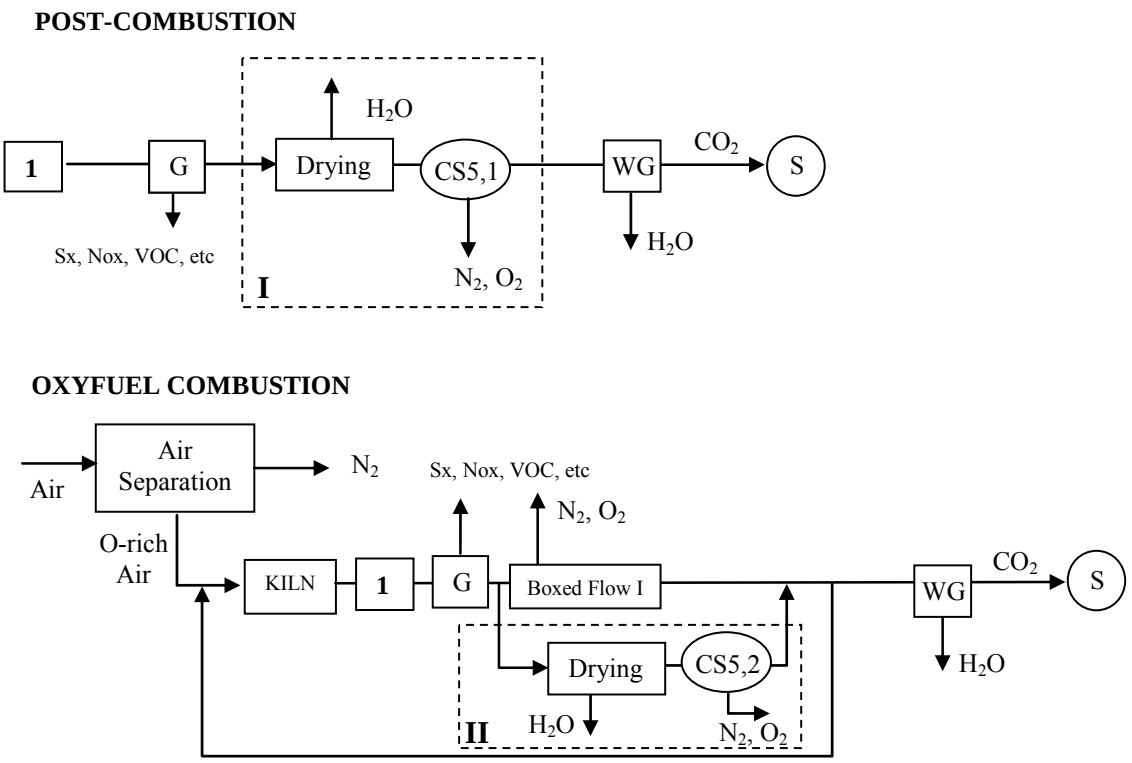


Figure 19. Post-combustion and oxyfuel-combustion approaches for capture and concentration of CO_2 in the cement and lime industry for stream 1 defined in Figure 8. The shorthand notation used here appears as CS#,# or CS#-#,#. CS stands for a CO_2 separation step. The first number (#) corresponds to a figure in the report (or figures in the report as indicated by #-#). This number (or numbers) corresponds to one (or more) of the CO_2 producing flowsheets depicted in Figures 4 to 14. The second number (#) after the comma represents the proposed CO_2 separation step that is indicated within the boxed region labeled with the corresponding Roman numeral. G refers to a guard step, WG refers to a guard step particular for water, CS5,1 and CS5,2 refer to CO_2 separation steps appropriate to boxed flow sheets I and II, respectively, and S refers to the final CO_2 sequestration step. This final CO_2 stream is H_2O free but may contain small amounts of N_2, CH_4, H_2S, O_2, and SO_2. At the CO_2 separation steps, boxed flow sheets I and II contain CO_2 and N_2 as main gas components. Boxed flow sheet I is rich in N_2, while boxed flow sheet II is lean in this gas species. Depending on the CO_2 concentration, Figure 24 provides alternative processes for the CO_2 separation steps CS5,1 and CS5,2.

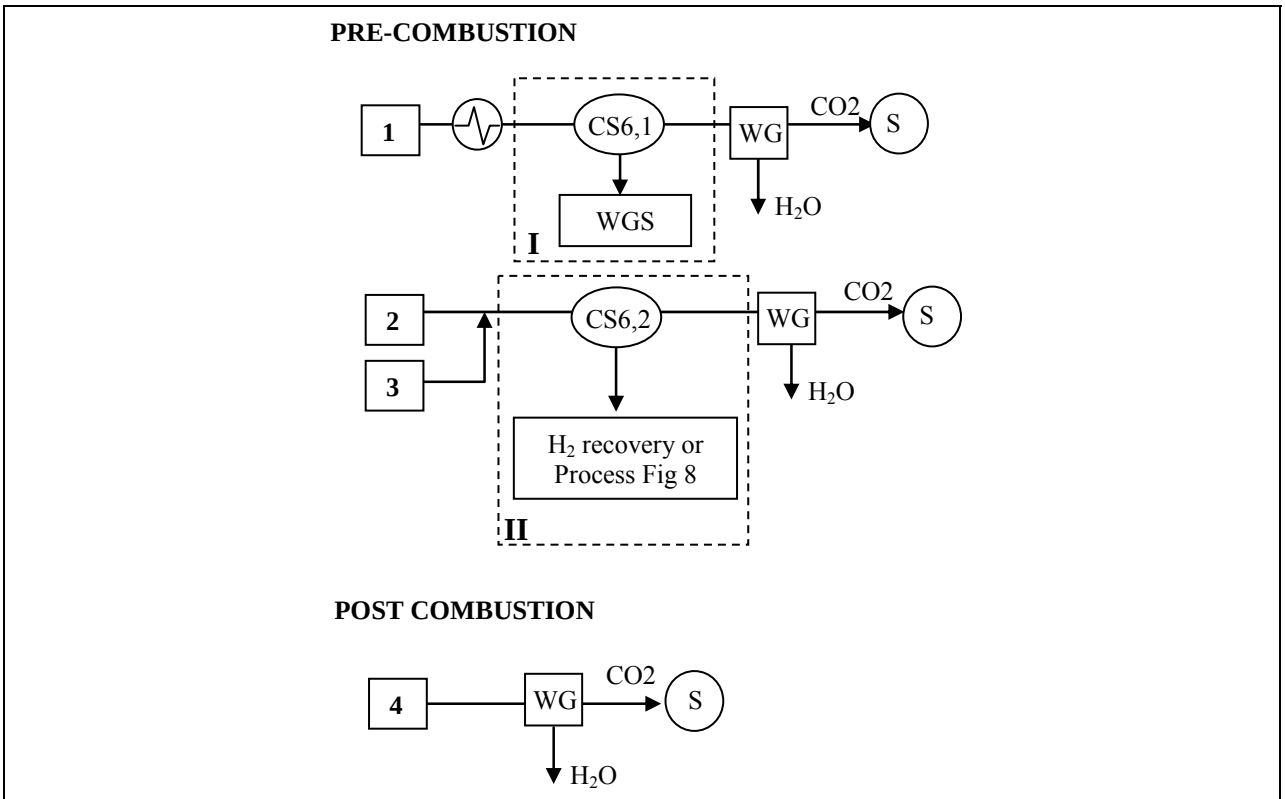


Figure 20. Pre-combustion and post-combustion approaches for capture and concentration of CO_2 in the ammonia manufacture industry for streams 1 through 4 in Figure 9. The shorthand notation used here appears as CS#,# or CS#-#,#. CS stands for a CO_2 separation step. The first number (#) corresponds to a figure in the report (or figures in the report as indicated by #-#). This number (or numbers) corresponds to one (or more) of the CO_2 producing flowsheets depicted in Figures 4 to 14. The second number (#) after the comma represents the proposed CO_2 separation step that is indicated within the boxed region labeled with the corresponding Roman numeral. WG refers to a guard step particular for water, WGS refers to a water gas shift step, CS6,1 and CS6,2 refer to CO_2 separation steps appropriate to boxed flow sheets I and II, respectively, and S refers to the final CO_2 sequestration step. This final CO_2 stream is H_2O free but may contain small amounts CH_4, CO and H_2. At the CO_2 separation steps, boxed flow sheets I and II contain CO_2, CO, H_2, and CH_4 as main gas components. Boxed flow sheet I is rich in CO and CH_4, while boxed flow sheet II is very lean in these gas species. Depending on the CO_2 concentration, Figure 22 provides detailed alternative processes for the CO_2 separation steps CS6,1 and CS6,2. No particular action is taken over stream 4 other than a drying step.

PRE-COMBUSTION

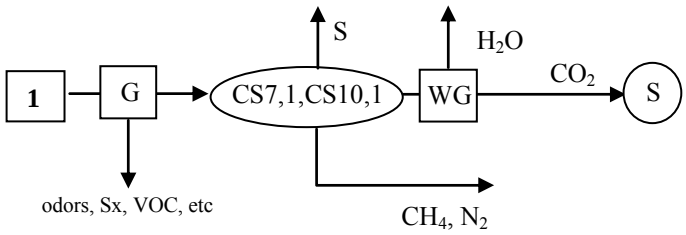


Figure 21. Pre-combustion approach for capture and concentration of CO_2 in the natural, coal, and landfill gas industries for stream 1 defined in Figures 10 and 13. The shorthand notation used here appears as CS#,# or CS#-#,#. CS stands for a CO_2 separation step. The first number (#) corresponds to a figure in the report (or figures in the report as indicated by #-#). This number (or numbers) corresponds to one (or more) of the CO_2 producing flowsheets depicted in Figures 4 to 14. The second number (#) after the comma represents the proposed CO_2 separation step that is indicated within the boxed region labeled with the corresponding Roman numeral. G refers to a guard step, WG refers to a guard step particular for water, CS7,1 and CS10,1 refer to a CO_2 separation step appropriate for the processes in Figures 10 and 13, respectively, and S refers to the final CO_2 sequestration step. This final CO_2 stream is H_2O free but may contain small amounts of N_2, CH_4, and H_2S. At the CO_2 separation step, the stream contains CO_2, N_2 and H_2S as main gas components. Depending on the CO_2 and H_2S concentrations, Figure 26 provides alternative processes for the CO_2 separation step CS7,1 and CS10,1.

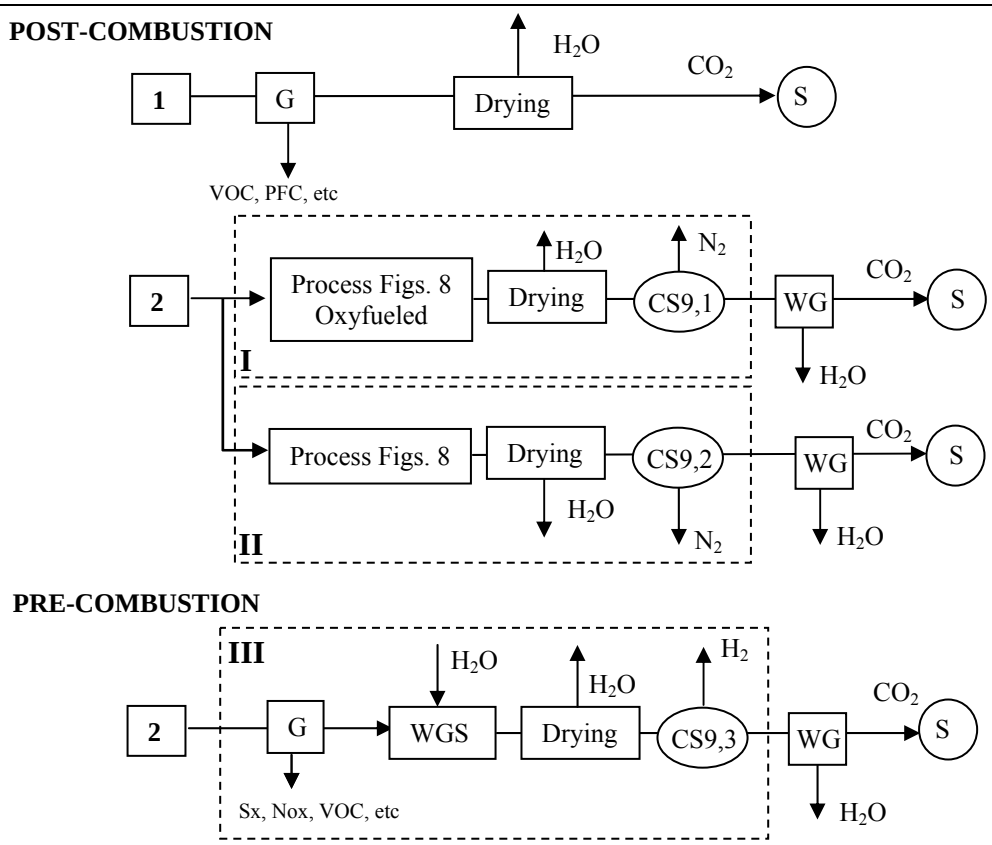


Figure 22. Post-combustion and pre-combustion approaches for capture and concentration of CO_2 in the aluminum industry for the streams 1 and 2 defined in Figure 12. The shorthand notation used here appears as CS#,# or CS#-#,#. CS stands for a CO_2 separation step. The first number (#) corresponds to a figure in the report (or figures in the report as indicated by #-#). This number (or numbers) corresponds to one (or more) of the CO_2 producing flowsheets depicted in Figures 4 to 14. The second number (#) after the comma represents the proposed CO_2 separation step that is indicated within the boxed region labeled with the corresponding Roman numeral. G refers to a guard step, WGS refers to a water gas shift step, WG refers to a guard step particular for water, CS9,1 through CS9,3 refer to CO_2 separation steps appropriate to boxed flow sheets I through III, respectively, and S refers to the final CO_2 seqestration step. This final CO_2 stream is H_2O free but may contain small amounts of N_2. At the CO_2 separation steps, boxed flow sheets I and II contain CO_2 and N_2 as main gas components, while boxed flow sheets III and IV contain CO_2, N_2 and H_2 as the main gas components. Boxed flow sheets I and III are lean in N_2, while boxed flow sheet II is rich in this gas species. Depending on the CO_2 concentration, Figures 24 and 25 provide alternative processes for the CO_2 separation steps CS9,1 through CS9,3. No particular action is taken over stream 1 other than a drying step.

POST-COMBUSTION

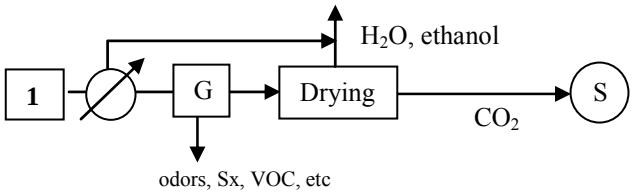
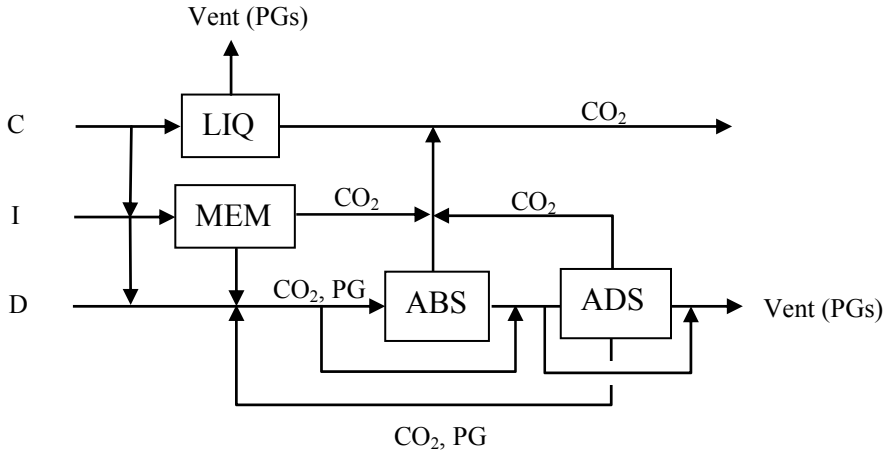


Figure 23. Post-combustion approach for capture and concentration of CO_2 in the ethanol production industry for stream 1 defined in Figure 14. G refers to a guard step and S refers to the final CO_2 sequestration step. This final CO_2 stream is H_2O free but may contain small amounts of N_2. No particular action is taken over stream 1 other than a drying step.

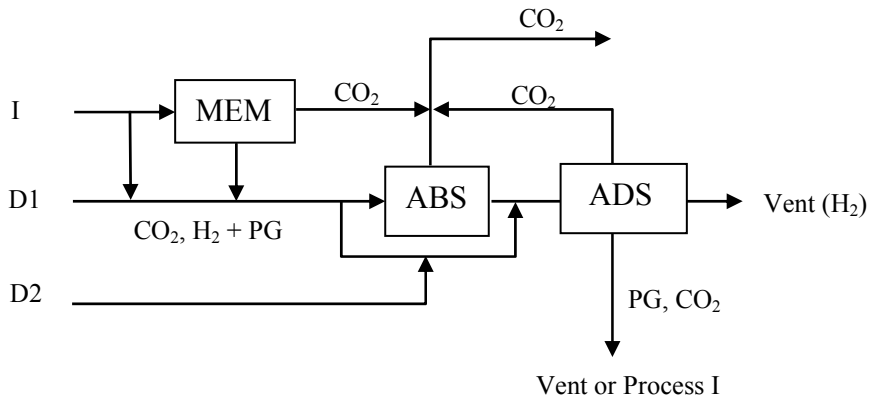
Process I: CO_2 and gases such as N_2, O_2, CO and CH_4



C: (>90% CO_2) CS1,2; CS4,1; CS5,2; CS9,1
I: (20-90% CO_2) CS1,1; CS4,1; CS4,2; CS5,1; CS9,1; CS9,2
D: (5-20% CO_2) CS4,2; CS9,2

Figure 24. Flow diagram representing a CO_2 separation and concentration step for streams in Figures 16, 18, 19 and 22 that contain N_2, O_2, CO or CH_4 as permanent gases (PG) in addition to CO_2. The separation step may consist of one or more separation processes that include liquefaction (LIQ), membrane (MEM), absorption (ABS), and adsorption (ADS). The step flow diagram allows different accesses depending on whether the CO_2 content in the stream is concentrated (C), intermediate (I), or dilute (D).

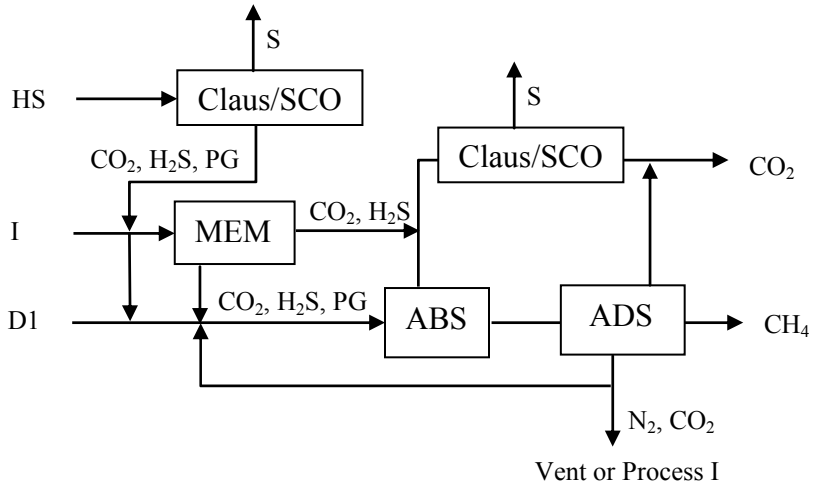
Process II: CO_2, gases such as N_2, O_2, CH_4 and significant H_2



I: (20-90% CO_2) CS4,3; CS4,4; CS6,2; CS9,3
D1: (5-20% CO_2) CS4,4; CS6,2; CS9,2
D2: (5-20% CO_2, HOT) CS2,1; CS3,1; CS6,1

Figure 25. Flow diagram representing a CO_2 separation and concentration step for streams in Figures 17, 18, 20 and 22 that contain N_2, O_2, CO or CH_4 as permanent gases (PG) as well as significant concentrations of H_2 in addition to CO_2. The separation step may consist of one or more separation processes that include membranes (MEM), absorption (ABS), and adsorption (ADS). The step flow diagram allows different accesses for the stream depending on whether its CO_2 content is intermediate (I), or dilute at room temperature (D1) or dilute at high temperatre (D2)

Process III: CO_2, gases such as N_2, CH_4 and H_2S



HS: (> **20% H_2S)** CS7,1; CS10,1
I: (20-90% CO_2) CS7,1; CS10,1
D: (5-20% CO_2) CS7,1; CS10,1

Figure 26. Flow diagram representing a CO_2 separation and concentration step for streams in Figure 21 that contain N_2, O_2, CO or CH_4 as permanent gases (PG) as well as sulfur bearing compounds (e.g, H_2S, COS, etc.) in addition to CO_2. The separation step may consist of one or more separation processes that include a Claus/SCOT step for sulfur removal, membranes (MEM), absorption (ABS), and adsorption (ADS). The step flow diagram allows different accesses for the stream depending on whether its CO_2 content is intermediate (I) or dilute (D), or on whether its content of sulfur bearing compounds is elevated (HS).

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Table 1. 1990 and 2004 Worldwide and U.S. CO_2 emissions (MMt).

	1990	**2004**
Worldwide Emissions [474]	21,426.12	27,043.57
U.S. CO_2 Emissions [474]	5,013.45	5,912.20
U.S. CO_2 Emissions [475][a]	4,984.80	5,923.20
1. Residential	953.00	1,213.90
2. Comercial	780.70	1,034.10
3. Transportation	1,566.80	1,939.20
4. Industrial	1,683.60	1,736.00
5. Electric[b]	1,803.10	2,309.40
6. Non-fuel use of fossil fuels[c]	98.10	111.70
7. Other sources[d]	88.30	105.70

[a] Sum of rows 1 to 4, and includes total emissions from energy and non-energy related sources.

[b] Total emissions from electricity needed to power activities in rows 1 to 4.

[c] Emissions in row 6 included in emissions in rows 1 to 4.

[d] Emissions in row 7 not included in emissions in rows 1 to 4, and includes natural gas flaring, CO_2 in natural gas, cement production, other industries, and waste combustion.

Table 2. Summary of 2002 U.S. CO_2 emissions (MMt).

	Total	Electricity	Natural gas	Petroleum	Coal	Other			
CO_2 Emissions [475,476][a]	**5,752.20**								
1. Residential	**1,186.40**	821.40	263.70	100.20	1.10	0.00			
2. Comercial	**1,009.40**	782.30	170.20	48.70	8.30	0.00			
3. Transportation	**1,871.70**	3.60	37.10	1,831.00	0.00	0.00			
4. Industrial	**1,684.70**	642.70	450.70	400.40	190.90	0.00			
5. Electric[b]	**2,250.00**	-----	305.90	77.40	1,853.70	12.60			
		Energy Related Fossil Fuels [476][c]					**Non-Energy Related Sources**		
	Total	**Electricity**	**Natural Gas**	**Petroleum**	**Coal**	**Other**	**Total [477][d]**	**Fossil[e]**	**Non-Fossil [475]**
Manufacturing Industry [476][c]									
6. Total manufacturing	**1,401.20**	540.70	325.90	257.60	202.80	74.20	**177.10**[f]	89.80	87.30[g]
7. Iron and steel industry	**126.00**	35.00	22.00	1.10	66.70	1.20	**51.30**	49.90	1.40
8. Cement manufacture	**39.00**	8.20	1.10	6.40	23.00	0.30	**43.00**	0.00	43.00
9. Ammonia	-----	-----	-----	-----	-----	-----	**18.50**	18.50	0.00
10. Natural gas	-----	-----	-----	-----	-----	-----	**17.90**	0.00	17.90
11. Lime	**10.30**	1.00	0.40	2.80	6.20	0.00	**14.10**	0.00	14.10
12. Aluminum production	**48.00**	36.70	7.10	0.10	0.00	4.00	**4.60**	0.60	4.00
13. Other manufacturing	**1,177.90**	459.80	295.30	247.20	106.90	68.70	**27.70**	20.80	6.90
Other industries and sources [475]									
14. Municipal combustion	**12.60**	0.00	0.00	0.00	0.00	12.60	**6.20**	0.00	6.20
15. Natural gas flaring	**0.00**	0.00	0.00	0.00	0.00	0.00	**6.00**	6.00	0.00
CO_2 Consumption [475]	**11.31**								

[a] Sum of rows 1 to 4, and and includes total emissions from energy and non-energy related sources.

[b] Total emissions from electricity needed to power activities in rows 1 to 4.

[c] Ammonia and natural gas production not mentioned in this report, but emissions expected to be negligible.

[d] Data for municipal combustion and natural gas flaring and production obtained from [475].

[e] Difference between total non-energy related sources and non-fossil sources.

[f] This value includes all values reported in Tables 2 and 3 of [477], including natural gas production reported in row 10 of this table, but excluding those for combustion and natural gas flaring.

[g] This value includes natural gas production reported in row 10 of this table.

Table 3. Average U.S. CO_2 emissions per plant within several industries (MMt).[a]

Industry	Year	Number of Plants	Emissions	Average Plant Emissions
Fossil fuel power plants:				
Coal	1998	1198	1801.1	1.50
Gas	1998	3321	249.1	0.08
Petroleum	1998	2148	104.1	0.05
Iron and steel industry	2004	95	51.3	0.54
Cement manufacture	2004	116	45.6	0.39
Ammonia	2004	32	16.9	0.53
Natural gas (absorption)	1991	460	16.2	0.04
Aluminum production	2006	400	4.3	0.01
Ethanol industry	2006	101	3.5	0.03

[a] Except for fossil fuel plants, emissions are non-energy related.

Table 4. Number of patents (P) and peer review manuscripts (M) per researcher or research group on CO_2 related separation processes since 1995 and 2002 (in parentheses).

Main Investigator	Company or Institution	Membrane		Membrane Process		Adsorption		Absorption		Other	
		P	M	P	M	P	M	P	M	P	M
Katsuki Kusakabe, Shigeharu Morooka	Kyushu Sangyo University, Japan	0(0)	35(9)								
Tai S. Chung and Rong Wang	National U. of Singapore, Nanyang Technological U., Singapore	1(1)	37(29)								
William J. Koros	Georgia Institute of Technology, USA	8(8)	42(22)	2(1)	0(0)						
Ken-ichi Okamoto, Hidetoshi Kita	Yamaguchi University, Japan	1(0)	31(25)								
Richard D. Noble and John L. Falconer	University of Colorado, USA	3(0)	29(13)								
Kenji Haraya	National Institute of Advanced Industrial Science and Technology, Japan	1(0)	15(6)								
Hiroyoshi Kawakami	Tokyo Metropolitan University, Japan	1(0)	26(6)								
Akira Miyamoto, Momoji Kubo	Tohoku University, Japan	0(0)	8(1)								
Matthias Wessling	U. of Twente, the Netherlands	1(1)	23(16)								
Richard W. Baker, Ingo Pinnau	Membrane Tech. & Research, Inc., USA	7(4)	14(4)	12(5)	3(1)						
Stephen J. Miller, Curtis L. Munson, De Q. Vu	Chevron USA Inc., USA	9(9)	6(6)	2(2)	1(1)	2(2)	3(3)	3(3)	0(0)		
Benny D. Freeman	U. of Texas, USA	0(0)	43(11)								
William D. Dolan	Engelhard Corporation , USA	5(5)	2(2)								
Raymond Clarke	Landec Corporation, USA	4(2)	2(1)								
John W. Simmons	L'air Liquide, France	5(5)	0(0)								
Santi Kulprathipanja	UOP LLC, USA	2(2)	1(1)								
David J. Hasse, Sudhir S. Kulkarni	L'air Liquide, France	4(4)	2(0)								
Harry W. Deckman, Donald J. Victory, Eugene R. Thomas	ExxonMobil, USA	3(3)	0(0)			1(1)	0(0)				
Benjamin Bikson, Joice K. Nelson, Yong Ding	Praxair Technology, Inc., USA	6(2)	0(0)								
Gilles P. Robertson, Michael D. Guiver	Institute for Chemical Process and Environmental Technology, Canada	1(1)	10(8)								
Hisao Hachisuka, Tomomi Ohara, Ken-Ichi Ikeda	Nitto Denko Corporation, Japan	0(0)	5(0)								
Nikunj P. Patel, Richard J. Spontak	North Carolina State University, USA	0(0)	8(6)								
Liang Hu	Hampton University, USA	1(1)	6(4)								
Eva Marand	Virginia Polytechnic I. and State U., USA	1(1)	9(6)								
Yong S. Kang	Korea I. of Science and Tech., South Korea	3(2)	2(1)								
Shigeo T. Oyama	Virginia Polytechnic I. and State U., USA	1(1)	12(7)								
Anthony M. Sammels	Eltron Research Inc. USA	2(1)	2(2)	1(0)	2(1)						

S. Alexander Stern	Gas Research Institute, USA	0(0)	8(0)								
Shivaji Sircar, Jeffrey R. Hufton, Madhukar B. Rao	Air Products and Chemicals, Inc., USA	2(0)	0(0)	3(0)	2(0)	7(0)	5(0)				
Charles L. Anderson	L'Air Liquide, France	2(2)	0(0)								
W. H. Winston Ho	ExxonMobil, USA	4(0)	0(0)					9(0)	5(0)		
Ravi Prasad, Frank Notaro	Praxair Technology, Inc., USA	1(1)	0(0)			4(1)	0(0)				
George P. Sakellaropoulos	Aristotle Univ Thessaloniki, Greece	1(0)	1(1)	0(0)	3(2)	0(0)	8(2)				
Kang Li, Wah K. Teo, Dongliang Wang	National University of Singapore, Singapore	1(0)	10(1)								
Takeshi Matsuura	U. of Ottawa, Canada	1(0)	19(6)								
Gilbert M. Rios, Stephane Sarrade	I. Europeen des Membranes-UM2, France	0(0)	12(6)								
Tsutomu Nakagawa	Meiji University, Japan	0(0)	21(3)								
Theodore T.. Tsotsis	U. of Southern California, USA	0(0)	13(5)	0(0)	3(1)						
Antonio B. Fuertes, Teresa A. Centeno	Instituto Nacional del Carbon, Spain	0(0)	11(2)								
A. F. Ismail	U. Teknologi of Malaysia, Malaysia	0(0)	9(4)								
Ho Bum Park, Young Moo Lee	Hanyang University, South Korea	0(0)	19(16)								
S. Ted Oyama	Virginia Polytechnic Institute and State University, USA	2(1)	9(5)								
Zhi Kang Xu	Zhejiang University, China	0(0)	10(4)							0(0)	2(2)[a]
Enrico Drioli,	U. of Calabria, Italy	0(0)	20(12)								
Yong Soo Kang	Korea I. of Science and Tech., South Korea	5(4)	15(6)								
Ricardo A. F. Machado	U. Federal de Santa Catarina, Brazil	0(0)	6(5)								
Henk Verweij	U. of Twente, the Netherlands	0(0)	5(2)								
Daniele Fiaschi	U. degli Studi di Firenze, Italy	0(0)	5(4)								
Jose Sanchez	Institut Europeen des Membranes, France	0(0)	15(6)							0(0)	1(1)[a]
Kamalesh K. Sirkar	New Jersey Institute of Technology, USA			0(0)	3(1)					3(1)	14(3)[b]
Tomonori Takahashi, Hitoshi Sakai, Toshihiro Tomita	NGK insulators, Japan			4(0)	2(2)						
Paul A. Daus, Charles R. Pauley	Messer Griesheim Industries, Inc., Germany			3(0)	0(0)						
Sawas Vasileiadis	Ivatech Corporation, USA			2(1)	2(0)						
Ralph T. Yang	U. of Michigan, USA					1(0)	19(6)				
Tsutomu Hirose, Monotobu Goto	Kumamoto University, Japan					0(0)	18(4)				
Chang Ha Lee	Yonsei University, South Korea					0(0)	19(8)				
Angel Linares, Diego Cazorla	U. de Alicante, Spain					0(0)	29(14)				
Isao Mochida	Kyushu University, Japan					0(0)	12(2)				
Alirio E. Rodrigues	U. de Oporto, Portugal					0(0)	16(9)				
James A. Ritter	U. of South Carolina, USA					0(0)	5(1)				
Jia Guo, Aik C. Lua	Fudan University, China					0(0)	12(6)				
Juan M. D. Tascon, Amelia Martinez, Silvia Villar Rodil	Instituto Nacional del Carbon, Spain					0(0)	30(21)				

Jose Ortiga, Cristina Volzone	Centro de Tecnologia de Recursos Minerales y Ceramica, Argentina					0(0)	5(2)				
F. Handan Tezel	U. of Ottawa, Canada					0(0)	10(4)				
Kenzi Suzuki	Agency of Industrial Sci.& Tech, Japan					0(2)	7(0)				
Martin Bulow	The BOC Group, Inc., USA					3(12)	7(5)				
Ravi Kumar	The BOC Group, Inc., USA					4(13)	2(1)				
Akhilesh Kapoor	The BOC Group, Inc., USA					0(8)	0(0)	1(0)	0(0)		
Ravi Jain	The BOC Group, Inc., USA					0(7)	0(0)				
Mohamed S. A. Baksh	Praxair Technology, Inc., USA					2(4)	0(0)				
Roger D. Whitley, Robert L. Chiang	Air Products and Chemicals, Inc., USA					4(4)	0(0)				
Norberto O. Lemcoff, Divyanshu R. Acharya	The BOC Group, Inc., Canada					2(5)	3(1)				
Bowie G. Keefer	Questair Technologies, Inc., Canada					6(9)	0(0)				
Amitabh Gupta, Shrikar Chakravarti	Praxair Technology, Inc., USA					1(1)	0(0)	6(1)	0(0)		
Timothy C. Golden	Air Products and Chemicals, Inc, USA					11(28)	1(0)				
Hans H. Funkel, Dan Fraenkel	Matheson Tri-Gas, Inc., USA					6(7)	1(1)				
Richard K. Lyon	General Electric Co., USA					5(5)	4(0)				
Omar M. Yaghi	U. of Michigan, USA					4(5)	15(8)				
Robert S. Wegeng	Battelle Memorial Institute, USA					2(2)	0(0)				
Alan Mather	U. of Alberta, Canada							0(0)	18(2)		
Sang Wook Park	Korean Inst. of Chemical Engineers, Korea							0(0)	16(16)		
Gary T. Rochelle	U. of Texas, USA							2(2)	15(10)		
Syamalendu S. Bandyopadhyay	Indian I. of Technology, India							0(0)	14(13)		
Menghui Li	Chung Yuan Christian University, Taiwan							0(0)	13(6)		
Helmuth Sigel	U of Basel, Switzerland							0(0)	13(6)		
Fumio Kiyono	Agency of Industrial Sci.& Tech, Japan							1(0)	5(5)		
Arturo Trejo	Instituto Mexicano de Petroleo, Mexico							1(0)	9(5)		
Mohamed K Aroua	U. of Malaya, Malaysia							0(0)	7(4)		
Gerd Maurer	U. of Kaiserslautern, Germany							0(0)	8(5)		
Orville C. Sandall	U. of California Santa Barbara,USA							0(0)	8(0)		
Hallvard F. Svendsen	Norwegian Inst. of Science and Tech., Norway							0(0)	8(7)		
Takayuki Saito	Nat. Institute for Res. & Environ., Japan							2(0)	8(1)		
Masaki Iijima, Kazuto Kobayashi, Kazuhiro Morita, Shigeaki Mitsuoka	Mitsubishi Heavy Industries, Japan							19(10)	8(1)		
Paul L. Wallace	Texaco Development Corp., USA							3(1)	0(0)		
Tofik K. Khanmamedov	TKK Company,USA							3(1)	1(1)		
Guido Sartori	ExxonMobil,USA							23(0)	1(0)		
Bernt H. Torkildsen, Martin Sigmundstad, Harald Linga, Patrick Finn	Den Norske Stats Oljieselskap A.S., Norway							7(0)	0(0)		
James E. Critchfield	Hunstmann Petrochemical Corp., USA							2(0)	1(0)		

Jerry D. Blue	Alliance, USA							3(1)	0(0)		
Fabrice Lecomte	Institut Francais du Petrole, France							3(3)	3(2)		
Gary Palmer	Alberta Limited, Canada							2(2)	0(0)		
John Mak	Fluor Corporation, USA							7(7)	2(2)		
Paolo Chiesa	Politecnico di Milano, Italy							0(0)	5(1)		
Masahiro Kato	Toshiba Corporation, Japan							0(0)	12(4)		
Paitoon Tontiwachwuthikul, Amornvadee Veawab, Raphael Idem	U. of Regina, Canada							0(0)	30(18)		
Syamalendus S. Bandyopadhyay	Indian Institute of Technology, India							0(0)	5(2)		
Cheng Fang Zhang	Shanghai Jiaotong University, China							0(0)	8(4)		
Dwain F. Spencer	Electric Power Research Institute, USA							7(1)	5(2)		
Frederic Dutil	CO2 Solution, Inc., Canada							7(7)	0(0)		
Joan F. Brennecke	U. of Notre Dame, USA							0(0)	37(14)	1(1)	0(0)[b]
Satish Reddy	Fluor Corporation, USA							0(0)	1(1)	4(2)	0(0)[c]
Geert F. Versteeg, Vishwas Y. Dindore	Institutt for Kjemisk Prosessteknologi, Norway							1(1)	11(7)	0(0)	8(8)[a]
Robert Quinn	Air Products and Chemicals, Inc., USA							0(1)	6(1)	0(0)	6(1)[b]
Hideto Matsuyama, Masaaki Teramoto	Kyoto Institute of Technology, Japan									0(0)	17(4)[a,b]
Kew-Ho Lee, You-In park	Korea Research Inst. of Chemical Tech., South Korea									0(0)	18(11)[a,b]
Zhi Wang	Tianjin University, China									0(0)	15(9)[b]
Paul H. M. Feron	TNO Institute of Environmental Sciences, The Netherlands									2(1)	16(10)[a]
Zoher M. Meratla	CDS Research Ltd., USA									1(0)	2(0)[d]
Olav Falk-Pedersen	Kvaerner ASA, Norway									2(0)	8(4)[a]
Fawzy T. Abdelmalek	Abdelmalek & Associates, Inc., USA									4(0)	1(0)[c]

[a] Membrane contactors
[b] Immobilized liquid and facilitated transport membranes
[c] Autorefrigeration and liquefaction
[d] Cryogenic separation

Table 5. Number of patents per company on CO_2 related separation processes since 1995 and 2002 (in parentheses).

Company	Membrane	Adsorption	Absorption
Air Products and Chemicals, Inc., USA	11(3)	51(18)	5(2)
The BOC Group, Inc., USA	3(1)	49(15)	5(2)
Praxair Technology, Inc., USA	23(7)	24(9)	10(2)
ExxonMobil, USA	10(4)	2(2)	28(1)
UOP LLC, USA	7(3)	17(5)	2(0)
Membrane Technology and Research, Inc., USA	23(9)		
Mitsubishi Heavy Industries, Japan	1(1)	2(1)	19(10)
L'Air Liquide, France	11(5)	7(3)	2(0)
Chevron USA Inc., USA	9(9)	3(3)	5(5)
Shell Internationale Research, The Netherlands	4(2)	3(2)	8(7)
Battelle Memorial Institute, USA	4(3)	4(3)	4(3)
DSM N V, The Netherlands			13(8)
Fluor Corporation, USA		4(3)	8(7)
E.I. Du Pont de Nemours and Company, USA	5(0)	1(0)	5(1)
Engelhard Corporation , USA	6(6)	4(4)	
General Electric Co., USA	2(2)	5(5)	3(2)
Norsk Hydro ASA, Norway	6(1)		3(0)
Questair Technologies, Inc., Canada		9(6)	
Den Norske Stats Oljieselskap A.S., Norway	2(0)		7(0)
Hamilton Sundstrand Corporation, USA	2(2)	4(4)	2(2)
Texaco Development Corp., USA	3(0)		4(1)
Kvaerner ASA, Norway	4(1)		3(0)
Matheson Tri-Gas, Inc., USA		7(6)	
DOW/Corning Corp, USA		3(0)	4(0)
Messer Griesheim Industries, Inc.	3(0)	1(0)	2(0)
Agency of Industrial Sci.& Tech, Japan	1(0)	3(0)	2(0)
Korea Institute of Science and Technology, South Korea	4(3)	2(1)	
Conoco/Phillips, USA	2(2)	2(1)	1(1)
Honeywell International Inc, USA	1(0)	3(2)	
Hunstmann Petrochemical Corporation, USA		1(2)	0(2)
BP-Amoco, UK-USA	4(2)		4(3)
Union Carbide,USA			4(1)
Institut Francais du Petrole, France		1(1)	3(3)
Landec Corporation, USA	3(2)		

Table 6. Licensors of CO_2 separation processes, type of process, production rate, and number of plants worldwide [478].

Licensor	System	Primary Goal		CO_2 in Tailgas	Capacity/unit	Plants Worldwide
Linde AG	PSA-H_2	$_2$	(P)	30-60%	1-100 MMscfd	250
Technip	PSA-H_2	H_2	(P)	30-60%	-	240
Uhde	PSA-H_2	H_2	(P)	30-60%	-110 MMscfd	60
Haldor Topsøe A/S	PSA-H_2	H_2	(P)	30-60%	-20 MMscfd	31
UOP LLC (Polybed)	PSA-H_2	H_2	(P)	30-60%	-200 MMscfd	700
CB&I Howe-Baker	PSA-H_2	H_2	(P)	30-60%	1- 280 MMscfd	170
Foster Wheeler	PSA-H_2	H_2	(P)	30-60%	1- 95 MMscfd	100
Lurgi Oel-Gas-Chemie GmbH	PSA-H_2	H_2	(P)	30-60%	1-200 MMscfd	105
Air Products (PRISM)	PSA H_2	$_2$	(P)	30-60%	15-120 MMscfd	50
Linde AG	PSA-NH_3	H_2	(P)	30-60%	230-1350 mtpd	3
Uhde Gmbh	PSA-NH_3	$_2$	(P)	30-60%	500-1800 mtpd	14
Haldor Topsøe	PSA-NH_3	H_2	(P)	30-60%	650-2050 mtpd	60
Kellogg Brown & Root, Inc	PSA-NH_3	$_2$	(P)	30-60%	-1850 mtpd	200
Engelhard Corp. (Molecular Gate)	Adsorption	CO_2, H_2O	(R)	1-98%	2-10 MMscfd	2
Axens	Adsorption	GC+CO_2	(R)	1-98%	-	60
ProPure As (CAP-compact)	Scrub (MDEA)	H_2S	(R)	-	-	2
Shell Global Solutions International B.V (ADIP)	Scrub (MDEA, DIPA)	AG	(R)	1-98%	-	400
Shell Global Solutions International B.V (ADIP-X)	Scrub (MDEA)	AG	(R)	1-98%	-	1
Prosernat-IFP Group Tech. (Advanced Amines)	Scrub (DEA, MDEA)	AG	(R)	1-98%	0.3-25.2 Nm^3/d	120
BASF AG (aMDEA)	Scrub (MDEA)	AG	(R)	1-98%	3.5-700 MMscfd	230
UOP LLC (Amine Guard FS)	Scrub (amine)	AG	(R)	1-98%	-500 MMscfd	500
Prosernat IFP & Titan SNC Lavalin (ifpex-2)	Scrub (Methanol)	AG	(R)	1-98%	-350 MMscfd	-
UOP LLC (Benfield)	Scrub (DEA-K_2CO_3)	AG	(R)	1-98%	-500 MMscfd	700
Randall Gas Tech, ABB Lummus Global Inc.	Scrub (MEA)	AG	(R)	1-98%	2700 mtpd	8
Exxon Mobil Research & Eng. Co. (FlEXSORB)	Scrub (amine)	AG	(R)	1-98%	-	49
Fluor Enterprises, Inc. (Econamine)	Scrub (DGA)	CO_2	(R)	+99%	3-400 MMscfd	55
Fluor Enterprises, Inc. (Econamine FG Plus)	Scrub (MEA)	CO_2	(R)	+99%	-300 mtpd	24
Fluor Enterprises, Inc. (Improved Econamine)	Scrub (DGA)	CO_2	(R)	+99%	547 MMscfd	7
Fluor Enterprises, Inc. (Fluor Solvent)	Scrub (fluor solvent+PC)	CO_2	(R)	+99%	-220 MMscfd	13
Advantica Ltd. (LRS-10)	Scrub (LRS10-K_2CO_3)	CO_2	(R)	+99%	-	30
Uhde Gmbh (Morphysorb)	Scrub (Morphysorb)	AG	(R)	1-98%	300 MMscfd	2
Lurgi Oel-Gas-Chemie GmbH (Omnisulf)	Scrub (Morphysorb)	AG	(R)	1-98%	-	1
Lurgi Oel-Gas-Chemie GmbH (Purisol)	Scrub (NMP)	AG	(R)	1-98%	-	7
Lurgi Oel-Gas-Chemie GmbH (Rectisol)	Scrub (Methanol)	AG	(R)	1-98%	-	100
UOP LLC (Selexol)	Scrub (DME, PEG)	AG	(R)	1-98%	-	55
Shell Global Solutions International B.V (Sulfinol)	Scrub (sulfolane, amine)	AG	(R)	1-98%	-	200
Fluor (CO_2LDSEP)	Liquifaction	CO_2, H_2	(R, P)	+99%	-15 MMscfd	-
Costain Oil, Gas & Process ltd.	Liquifaction	CO_2	(P)	100%	5-1200 mtpd	7
Air Liquide (Medal)	Membrane	CO_2, H_2O	(R)	2-70%	1-1000 MMscfd	several
NATCO Group Inc. (CYNARA)	Membrane	CO_2	(R)	-95%	5-750 MMscfd	30
UOP LLC (Separex)	Membrane	AG	(R)	-	1-1000 MMscfd	50
Merichem Chem & Refineries Services (AMINEX)	HFMC	AG	(R)	1-98%	-	10

PSA = Pressure Swing Adsorption; Mem = membrane; CEL = compression-expansion liquefaction; L = Liquefaction; HFMC = hollow fiber membrane contactor; AG = All acid gases (i.e., H_2S, COS and CO_2); P = purification; R = removal; PC = propylene carbonate; GC= Gas contaminants (Hg, As, H_2O, TBC, NH and Sx)

Table 7. Characteristics of key alkanolamines used in gas treating [479].

Name		Chemical Formula	Molecular Weight	Vapor Pressure (mm Hg)	Relative Acid Gas Capacity (%)
Ethanolamine (Monoethanolamine)	MEA	$HO\text{-}CH_2CH_2\text{-}NH_2$	61	1.05	100
Diethanolamine	DEA	$(HO\text{-}CH_2CH_2)_2\text{-}NH$	105	0.058	58
Triethanolamine	TEA	$(HO\text{-}CH_2CH_2)_3\text{-}N$	148	0.0063	41
Hydroxyethanolamine (Diglycolamine)	DGA	$H\text{-}(OCH_2CH_2)_2\text{-}NH_2$	105	0.0160	58
Diisopropanolamine	DIPA	$(CH_3CH(OH)CH_2)_2\text{-}NH$	133	0.010	46
Methyldiethanolamine	MDEA	$(HO\text{-}CH_2CH_2)_2\text{-}N\text{-}CH_3$	119	0.0061	51

Table 8. Major types of acid gas absorbent processes [479-481].

	Chemical Absorption		**Physical Solvent Absorption**
	Alkanolamine	Inorganic Carbonate	
Adsorbents	MEA, DEA, DGA, MDEA, DIPA	K_2CO_3, K_2CO_3-MEA, K_2CO_3-DEA	Purisol, Selexol, Rectisol,
CO_2 & H_2S absorption mechanism	Chemical reaction CO_2: $2RNH_2+CO_2+H_2O\leftrightarrow(RNH_3)_2CO_3$ $(RNH_3)_2CO_3+CO_2+H_2O\leftrightarrow2RNH_3HCO_3$ H_2S: $2RNH_2+H_2S\leftrightarrow(RNH_3)_2S$ $(RNH_3)_2S+H_2S\leftrightarrow2RNH_3HS$	Chemical reaction CO_2: $Na_2CO_3+CO_2+H_2O\leftrightarrow2NaHCO_3$ H_2S: $Na_2CO_3+H_2S\leftrightarrow NaHS+NaHCO_3$	Physical dissolution
Operating Pressure, psig	Insensitive to pressure	> 200	250-1000
Operating Temp., ^oF	100-400	200-250	Ambient temperature
Stripper Gas	Steam	Steam or air*	Steam or air*
Absorbent Recovery	Reboiled stripper	Stripper	Flash, reboiler, or steam stripper
Swing variables (Temp. or Pressure)	Temperature principally	Both, but pressure principally	Pressure principally
Selectivity CO_2 vs. H_2S	Only MDEA selective for H_2S	May be selective for H_2S	Some selectivity for H_2S
Meets ppmv H_2S	Yes	Yes	Yes
Effect of O2 in Feed	Amine degradation products	None	Sulfur (S_8) precipitates at low temperatures
COS and CS2 Removal and degradation	MEA – no removal and strong degradation; DEA – slight removal and some degradation; DGA – removes both, strong degradation; DIPA, MDEA – Removes both, no degradation	Converts both into CO_2 and H_2S, then removes both, no degradation	Removes both, no degradation
Solvent: solute concentration, wt%	H_2O: MEA, 13-25; DEA,10-30; DGA,40-60; MDEA,33-55	H_2O: K_2CO_3 < 30	N-methyl-2-pyrrolidone (purisol); dimethyl ether of polypropylene glycol (selexol); methanol (rectisol);
Operating Problems	Solution degradation, foaming, corrosion, evaporation (MEA)	Column instability, corrosion, erosion	Absorption of heavy hydrocarbons
Utility Cost	High	Medium	Low to medium
Other comments	MEA limited to COS, CS_2 free streams with low CO_2 and H_2S concentrations; inhibitors used to control corrosive character of loaded alkanolamines; performance improves: MEA< DEA< DIPA< MDEA	Rate enhancers are used to improve low adsorption rates; good for high pressure gases	Best for high pressure gases.

* For streams free of sulfur compounds.

Table 9. Number of papers since 2000 containing in the title the indicated alkanolamine and other absorbents for CO_2 removal.

Absorbent	#
Methyldiethanolamine (MDEA)	73
Monoethanolamine (MEA)	55
Diethanolamine (DEA)	38
Piperazine (PZ)	33
Potassium Carbonate	7
Aminomethylpropano (AMP)	6
Triethanolamine (TEA)	5
Diglycolamine (DGA)	4
Sodium Glycinate	4
Dyethylene triamine (DETA)	3
Diisopropanolamine (DIPA)	2

Table 10. Typical capacities of commercial and developmental CO_2 and CO selective adsorbents.

Adsorbent	Adsorbate	T (^oC)	P (torr)	Loading (mol/kg)	Mode
act. carbon	CO_2	25	500	1.5-2.0	PSA
act. carbon	CO_2	250-300	500	0.1-0.2	PSA
5A zeolite	CO_2	25	500	~ 3.0	PSA
5A zeolite	CO_2	250	500	0.2	PSA
titanosilicates	CO_2	25-200	760-6x10^5	proprietary[1]	PSA
titanosilicates	N_2	25-200	760-6x10^5	proprietary[1]	PSA
titanosilicates	CH_4	25-200	760-6x10^5	proprietary[1]	PSA
solid amine (supported PEI)		75	760	1.5 – 3.0	PSA
HTlc (K-promoted)	CO_2	300-400	200-700	0.4-0.7	PSA
double-layer hydroxides	CO_2	375	230	1.5	PSA
alumina (un-doped)	CO_2	400	500	0.06	PSA
alumina (doped w/Li_2O)	CO_2	400	500	0.52	PSA
alumina (basic)	CO_2	300	500	0.3	PSA
Li zirconate	CO_2	500	760	3.4-4.5	TSA
CaO	CO_2	500	150	4-8	TSA
CaO	CO_2	700	76	7	TSA
Cu(I) (alumina)	CO	25-30	760	0.8-1.2	PSA
Cu(I) (alumina)	CO	30	760	0.8	PSA

[1]Molecular Gate titanosilicates molecular sieves patented by Engelhard Coproration [10].

Table 11. Performances of various PSA cycle configurations investigated for CO_2 concentration from flue gas, with the process performance judged primarily in terms of the CO_2 purity in the heavy product ($y_{CO2,F}$), with the CO_2 recovery (R_{CO2}) and the feed throughput (θ) being secondary but also important process performance indicators.

Cycle Configuration	Cycle Step Sequence*	Ads**	P_H (atm)	P_H/P_L	$y_{CO2,F}$ (%)	$y_{CO2,HP}$ (%)	R_{CO2} (%)	θ (LSTP/hr/kg)	Reference
2-bed 2-step	FP, CnD	Y	2.0	2.0	15	18	90	12,600	[482]
2-bed 4-step	FP, F, CnD, LR	13X	3.0	3.0	8.3	--	--	15	[483]
1-bed 4-step	LPP, F, CnD, LR	13X	1.7	1.9	15	24.4	9	17	[484]
2-bed 4-step	FP, F, CnD, LR	13X	1.1	17.2	10	68	50	507	[38]
1-bed 4-step	FP, F, CnD, LR	13X	14.0	15.9	15	56.4	98	908	[485]
3-bed 8-step	FP, F, CoD, LEE, HPP or HR-IP, N, CnD, LEE	AC	1.5	15	17	99.8	34	331	[486]
3-bed 7-step	FP, F, LEE, HR-IP, N, CnD, LEE	AC	2.0	20	13	99	55	156	[487]
3-bed 8-step	FP, F, LEE, HPP, HR-IP, N, CnD, LEE	13X	1.5	30	13	99.5	69	228	[488]
3-bed 8-step	FP, F, CoD, FR, N, HR-IP, CnD, N	AC	1.1	16.6	16	99	50	610	[489]
4-bed 4-step	LPP, F+ReC, HR, CnD	AC	1.2	12	17	99.9+	68	33	[490]
4-bed 8-step	LPP, N, F, HR, LEE, CnD, LR, LEE	13X	1.1	11	13	64	80	120	[491]
3-bed 5-step	FP, F, HR, CnD, LR	13X	1.1	17.2	10	83	54	338	[38]
2-bed 6-step	LEE, FP, F, LEE, CnD, LR	13X	1.1	17.2	10	82	57	477	[38]
2-bed 4-step	HPP, FP, CoD, CnD	13X	5.5	110	20	48	94	426	[491]
2-bed 5-step	LPP, FP, F, CoD, CnD	13X	5.5	110	20	43	88	426	[491]
3-bed 4-step	LPP, F, CnD, LR	13X	1.5	30	20	58	75	273	[491]
3-bed 6-step	LPP, FP, F, HR, CoD, CnD	13X	1.5	30	20	63	70	273	[491]
4-bed 4-step	LPP, F, CnD, LR	HTlc	1.4	12	15	63	75	22	[37]
4-bed 5-step	LPP, F, CoD, CnD, LR	HTlc	1.4	12	15	84	68	15	[37]
5-bed 5-step	LPP, F, CoD, CnD, LR	HTlc	1.4	12	15	65	87	12	[37]
5-bed 5-step	LPP, F, HR (from CnD), CnD, LR	HTlc	1.4	12	15	72	82	12	[37]
5-bed 5-step	LPP, F, HR (from LR), CnD, LR	HTlc	1.4	12	15	76	49	23	[37]
4-bed 4-step	LPP, F, HR (from CnD), CnD	HTlc	1.4	12	15	83	17	14	[37]
5-bed 5-step	LPP, F, HR (from LR), CnD, LR	HTlc	1.4	12	15	89	72	58	[61]
4-bed 4-step	LPP, F, HR (from CnD), CnD	HTlc	1.4	12	15	98	5	202	[61]

* CnD = countercurrent depressurization; CoD = cocurrent depressurization; FP = feed pressurization; F = high pressure feed; HPP = heavy product pressurization; HR = heavy reflux; IP = intermediate pressure; LEE = light end equalization; LPP = light product pressurization; LR = light reflux; N = null or delay; ReC = recycle.

** All processes operated at ambient temperature except for HTlc (hydrotalcite like compound), which was done at 575 °K.

Table 12. Permeabilities and permeances of membrane materials used for CO_2 separations.

	*	T (°C)	UNITS	PERMEANCES AND PERMEABILITIES He	H_2	N_2	O_2	CH_4	CO_2	SELECTIVITIES CO_2/He	CO_2/H2	CO_2/N_2	CO_2/CH_4	REFERENCE
ORGANIC MEMBRANES														
Polyacetylenes R groups														
R = H; R' = $C(CH_3)_4$	S	25	Barrer	180	300	43	130	85	560	3.11	1.87	13.02	6.59	[230]
R = CH_3; R' = $CH(CH_3)_2$ (PMP)	S	25	Barrer	2630	5800	1330	2700	2900	10700	4.07	1.84	8.05	3.69	[230]
R = CH_3; R' = $CH(CH_3)_2$ (PMP)	S	35	Barrer	2650	5640	1250	2460	2690	9090	3.43	1.61	7.27	3.38	[219]
R = CH_3; R' = $CH_2CH(CH_3)_2$ (P5M2H)	S	35	Barrer	460	750	93	245	190	900	1.96	1.20	9.68	4.74	[219]
R = CH_3; R' = $CH_2CH_2CH(CH_3)_2$ (P6M2H)	S	35	Barrer	240	370	51	130	112	390	1.63	1.05	7.65	3.48	[219]
R = CH_3; R' = $SiMe_3$ (PTMSP)	S	25	Barrer		18000	7000	11000		41000		2.28	5.86		[231]
R = CH_3; R' = $SiMe_3$ (PTMSP)	M	23	Barrer		11800	5700			18200		1.54	3.19		[222]
R = CH_3; R' = $SiMe_3$ (PTMSP)	S	35	Barrer	5080		4970	7730	13000	28000	5.51		5.63	2.15	[116]
R = CH_3; R' = $SiMe_3$ (PTMSP)	S	25	Barrer	2200	5200	1800	3000	4300	19000	8.64	3.65	10.56	4.42	[116]
R = H; R' = t-Bu	S	25	Barrer	180	300	43	130	85	560	3.11	1.87	13.02	6.59	[116]
R = H; R' = CH_3; 'Poly(cis-isoprene)	S	35	Barrer	100		35.9	91	150	520	5.20		14.48	3.47	[116]
R = CH_3; R' = $Si(CH_3)_2CH_2Si(CH_3)_3$	S	25	Barrer	180	270	21	75	45	310	1.72	1.15	14.76	6.89	[116]
R = H; R' = o-$C_6H_4Si(CH_3)_3$	S	25	Barrer	170	290	24	78	38	290	1.71	1.00	12.08	7.63	[116]
R = CH_3; R' = n-C_5H_{11}	S	35	Barrer		150	21	57	51	200		1.33	9.52	3.92	[218]
R = CH_3; R' = n-C_6H_{13}	S	35	Barrer		140	23	60	64	230		1.64	10.00	3.59	[218]
R = CH_3; R' = n-C_7H_{15}	S	35	Barrer		150	29	74	84	290		1.93	10.00	3.45	[218]
R = CH_3; R' = n-C_8H_{17}	S	35	Barrer		140	29	71	83	290		2.07	10.00	3.49	[218]
R = CH_3; R' = n-C_7H_{15}	S	25	Barrer	48	76	14	35	40	130	2.71	1.71	9.29	3.25	[116]
R = Cl; R' = n-C_6H_{13}	S	25	Barrer	43	76	16	47	46	170	3.95	2.24	10.63	3.70	[116]
R = Cl; R' = n-C_4H_9	S	25	Barrer	41	66	11	32	33	130	3.17	1.97	11.82	3.94	[116]
R = Cl; R' = n-C_8H_{19}	S	25	Barrer	59	100	10	35	30	180	3.05	1.80	18.00	6.00	[116]
R = H; R' = $CH(n\text{-}C_5H_{11})Si(CH_3)_3$	S	25	Barrer	60	84	8	27	21	120	2.00	1.43	15.00	5.71	[116]
R = H; R' = $CH(n\text{-}C_3H_7)Si(CH_3)_2$-n-$C_6H_{13}$	S	25	Barrer	58	42	6.3	19	17	70	1.21	1.67	11.11	4.12	[116]
R = Ph; R' = n-C_6H_{13}	S	25	Barrer	30	45	5.5	14	14	48	1.60	1.07	8.73	3.43	[116]
R = H; R' = $CH(n\text{-}C_3H_7)Si(CH_3)_2Ph$	S	25	Barrer	25	29	2.5	9.5	7	54	2.16	1.86	21.60	7.71	[116]

	*	T (°C)	UNITS	PERMEANCES AND PERMEABILITIES						SELECTIVITIES				REFERENCE
				He	H_2	N_2	O_2	CH_4	CO_2	CO_2/He	$CO_2/H2$	CO_2/N_2	CO_2/CH_4	
Polyacetylenes (Cont'd.)														
R = CH_3; R' = $Si(CH_3)_2CH_2CH_2Si(CH_3)_3$		25	Barrer	130	180	14	50	28	150	1.15	0.83	10.71	5.36	[116]
R = CH_3; R' = n-C_3H_7	S	35	Barrer		160	12	39	21	120		0.75	10.00	5.71	[218]
R = H; R' = o-$C_6H_4CF_3$	S	25	Barrer	130	140	7.3	25	6.6	130	1.00	0.93	17.81	19.70	[116]
R = Ph; R' = $(CH_3)_3$ (PPP)	S	25	Barrer	30	43	2.2	6.3	2.8	25	0.83	0.58	11.36	8.93	[116
R = Ph; R' = Et	S	25	Barrer	40	57	4.5	12	4.4	40	1.00	0.70	8.89	9.09	[116
R = Ph; R' = Cl	S	25	Barrer	23	29	1	5.1	1.3	23	1.00	0.79	23.00	17.69	[116
R = H; R' = o-$C_6H_4(CH_3)$	S	25	Barrer	29	39	3	8.1	3	15	0.52	0.38	5.00	5.00	[116
R = $(CH_3)_3$; R' = Ph (PPP)	S	25	Barrer		280	20	58		260		0.93	13.00		[231]
Polyolefins														
Polystyrene	S	35	Barrer	22.4		0.52	2.9	0.78	12.4	0.55		23.85	15.90	[116]
Polytetrafluoroethylene (PTFE)	M	25	Barrer		9.8				11.7		1.19			[492]
Polyethylene	S	30	Barrer		17.3	4.2	6.3	7.7	17.9		1.03	4.26	2.32	[249]
Polystyrene	S	30	Barrer		23.8	0.6	2.4	0.8	10.4		0.44	17.33	13.00	[249]
Polybenzylmethacrylate	S	30	Barrer		11			1.4	7.9		0.72		5.64	[249]
Polymethylmethacrylate	S	30	Barrer		2.4	1.2	3.3	0.6	0.6		0.25	0.50	1.00	[249]
Polyvinylacetate	S	30	Barrer		15.1	1.3	2.3	0.9	13.1		0.87	10.08	14.56	[249]
Polyethylene:Polyvinylalcohol	S	30	Barrer		0.5	0.3	0.2	0.2	0.2		0.40	0.67	1.00	[249]
Polyvinylidenefluoride	S	30	Barrer		2.4	0.7	1.4	1.3	1.2		0.50	1.71	0.92	[249]
Polyvinyltrimethylsilane (PVTMS)	S	25	Barrer		200	11	44	14	200		1.00	18.18	14.29	[116]
Polyvinylacetate	S	35	Barrer	15.1		0.089	0.53		3.1	0.21		34.83		[359]
Poly(ethyl methacrylate)	S	35	Barrer	23.8		0.33	1.9	0.35	7.01	0.29		21.24	20.03	[116]
Poly(methyl methacrylate)	S	35	Barrer	8.4		0.02	0.14	0.0052	0.62	0.07		31.00	119.23	[116]
PVTMS	S	20-25	GPU	762		138		156	746	0.98		5.41	4.78	[493]
PVTMS (silicone coated)	S	20-25	GPU	473		52		90	450	0.95		8.65	5.00	[493]
PVTMS (silicone coated & fluorinated)	S	20-25	GPU	120		3.4		1	110	0.92		32.35	110.00	[493]
Poly(2-hydroxyethyl methacrylate)/alumina	S	room	Barrer	15	23	7.9	7.2	10.6	7	0.47	0.30	0.89	0.66	[248]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES						SELECTIVITIES			REFERENCE
				He	H_2	N_2	O_2	CH_4	CO_2	CO_2/He	$CO_2/H2$	CO_2/N_2	CO_2/CH_4	
Polydienes													
Polychloroprene	M	25	Barrer		13.6				25.8		1.90			[492]
Polybutadiene	M	25	Barrer		42				138		3.29			[492]
Silicones													
Poly(dimethylsiloxane)	M	23	Barrer		950	380		850	3200		3.37	8.42	3.76	[222]
Poly(dimethylsiloxane)	S	30	Barrer		375	299	540	600	1300		3.47	4.35	2.17	[249]
PDMS	S	23	Barrer		890	400	800	1200	3800		4.27	9.50	3.17	[364]
Poly(dimethylsiloxane) (PDMS)	S	35	Barrer	590		351	781	1430	4550	7.71		12.96	3.18	[116]
Poly(methylpropylsiloxane)	S	35	Barrer					531	1520				2.86	[116]
Poly(methyloctylsiloxane)	S	35	Barrer					314	917				2.92	[116]
Poly(trifluoropropylmethylsiloxane)	S	35	Barrer					201	1210				6.02	[116]
Poly(benzilmethylsiloxane)	S	35	Barrer					36.3	226				6.23	[116]
$[(CH_3)_2Si(CH_2)_6Si(CH_3)_2O]_x$	S	35	Barrer					395	1310				3.32	[116]
$[(CH_3)_2SiCH_2]_x$	S	35	Barrer					130	542				4.17	[116]
$[(CH_3)_2Si\text{-}p\text{-}C_6H_4Si(CH_3)_2O]_x$	S	35	Barrer					10.4	52.3				5.03	[116]
Polyethers													
Pol(ethylene oxide) PEO	S	25	Barrer		0.81	0.07	0.26	0.19	9.5		11.73	135.71	50.00	[177]
Pol(ethylene oxide) PEO	S	35	Barrer		1.8	0.24	0.68	0.7	17		9.44	70.83	24.29	[177]
PEO	S	35	Barrer		10	2			100		10.00	50.00		[254]
Poly (phenylene oxide) (PPO)	S	room	Barrer			3.52	16.71	4.59	80.1			22.76	17.45	[255]
PPO 20% brominated	S	room	Barrer			3.62	18.24	3.98	88.69			24.50	22.28	[255]
PPO 40% brominated	S	room	Barrer			5.03	23.13	5.33	118.42			23.54	22.22	[255]
PPO 60% brominated	S	room	Barrer			4.88	24.57	5.7	139.3			28.55	24.44	[255]
sulfonated PPO	S	room	Barrer				4.1		33.6					[255]
sulfonated PPO 20% brominated	S	room	Barrer			1.53	9.09	0.67	39.8			26.01	59.40	[255]
sulfonated PPO 40% brominated	S	room	Barrer			0.79	5.17	0.53	27.22			34.46	51.36	[255]
sulfonated PPO 60% brominated	S	room	Barrer			2.92	15.96	3.83	112.5			38.53	29.37	[255]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES							SELECTIVITIES			REFERENCE
				He	H_2	$_2$	$_2$	CH_4	CO_2	CO_2/He	CO_2/H2	CO_2/N_2	CO_2/CH_4	
Polysulfones					N	O								
Bisphenol-A polysulfone (PSf)	S	35	Barrer		14	1.4			5.6		0.40	4.00		[254]
PSf	S	30	Barrer		12.1	0.8	1.7	0.4	6.1		0.50	7.63	15.25	[249]
PSf	S	35	Barrer	10.8		0.19	1.2	0.18	4.6	0.43		24.21	25.56	[116]
PSf	S	25	Barrer					5.3-8.8	23.7-68.7				5.00-8.00	[121]
PSf	S	25	Barrer					0.95-1.4	38.1-58.1				40.00	[121]
PSf	S	25	Barrer					0.36-1.06	13.7-35.7				35.00	[121]
PSf	S	25	Barrer					0.38-0.81	20.8-43.4				55.00	[121]
PSf	S	22	Barrer		5.8-23.8				3.6-8.5		0.65			[127]
PSf aldehyde (PSFCHO)	S	22	Barrer		6.7-8.2				3.8-4.3		0.55			[127]
PSFCHO/3A zeolite	S	22	Barrer		14.2-136				5.0-10.7		0.35			[127]
PSFCHO/5A zeolite	S	22	Barrer		32.6				11.9		0.37			[127]
Polyvinylacetate/diverse inorg. supports	S	35	Barrer	10.6-20.9			0.53-0.77	0.08-0.1	2.4-5.1	0.23			30.0-51.0	[359]
Polyaryleneethers														
6FPT-6FBPA	S	35	Barrer		41.9	2.18	6.96	1.58	25.29		0.60	11.60	16.01	[172]
6FPT-BPA	S	35	Barrer		28.8	1.37	4.76	1.41	18.53		0.64	13.53	13.14	[172]
6FPPy-6FBPA	S	35	Barrer		50.1	2.39	7.9	1.92	29.46		0.59	12.33	15.34	[172]
6FPPy-BPA	S	35	Barrer		41.2	1.7	5.6	1.78	21.44		0.52	12.61	12.04	[172]
Polyesters														
BisA w/High KOH conc.	M	room	GPU	5.5				0.545	12.00	2.18			22.00	[494]
DHBP w/High KOH conc.	M	room	GPU	2				0.075	2.40	1.20			32.00	[494]
DHDPE w/High KOH conc.	M	room	GPU	4.3				0.390	8.20	1.91			21.00	[494]
TBBA w/High KOH conc.	M	room	GPU	3				0.480	12.00	4.00			25.00	[494]
TCHFBA w/High KOH conc.	M	room	GPU	69				10.952	230.00	3.33			21.00	[494]
TDP w/High KOH conc.	M	room	GPU	4.3				0.319	8.60	2.00			27.00	[494]
TMBA w/High KOH conc.	M	room	GPU	6.8				0.486	17.00	2.50			35.00	[494]
BisF w/Low KOH conc.	M	room	GPU	32				31.667	38.00	1.19			1.20	[494]
BisA w/Low KOH conc.	M	room	GPU	2.8				0.061	2.00	0.71			33.00	[494]
DHBP w/Low KOH conc.	M	room	GPU	2				0.034	1.80	0.90			53.00	[494]
DHDPE w/Low KOH conc.	M	room	GPU	22				17.500	21.00	0.95			1.20	[494]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES He	H_2	N_2	O_2	CH_4	CO_2	CO_2/He	SELECTIVITIES CO_2/H2	CO_2/N_2	CO_2/CH_4	REFERENCE
Polyesters (Cont'd.)														
BHPF w/High KOH conc.	M	room	GPU	1.9				0.072	1.80	0.95			25.00	[494]
TBBA w/Low KOH conc.	M	room	GPU	1.9				0.038	1.80	0.95			48.00	[494]
TDP w/Low KOH conc.	M	room	GPU	4.2				0.065	2.00	0.48			31.00	[494]
TMBA w/Low KOH conc.	M	room	GPU	2.2				0.067	1.00	0.45			15.00	[494]
SDP w/Low KOH conc.	M	room	GPU	11				3.296	8.9	0.81			2.70	[494]
Polycarbonates														
Bisphenol-A polycarbonate	S	35	Barrer	13		0.38	1.6	0.36	6.8	0.52		17.89	18.89	[116]
Polysilmethylenes														
Poly(dimethyl silmethylene)	S	35	Barrer	43.4		14.5	37.5	47.4	191	4.40		13.17	4.03	[116]
Cellulose based														
Ethyl cellulose	S	35	Barrer	39.8		3.4	12.4	6.8	75	1.88		22.06	11.03	[116]
Cellulose acetate	M	25	Barrer		3.5				22.7		6.49			[492]
Cellulose acetate	M	-20	Barrer		3.5				22.6		6.46			[492]
Cellulose acetate	S	35	Barrer	16		0.15	0.82	0.15	4.75	0.30		31.67	31.67	[116]
Polyimides														
PI-1/PTMSP	S	25	GPU		30.1	4.2	11.9		60.9		2.02	14.50		[495]
PI-1/PTMSP	S	25	GPU		7.2	0.64	2.27		12.3		1.71	19.22		[495]
PI-2/PTMSP	S	25	GPU		2.76	0.28	0.91		5.02		1.82	17.93		[495]
PI-3/PTMSP	S	25	GPU		2.39	0.25	0.84		4.35		1.82	17.40		[495]
BDCDA-MPD	S	30	Barrer		15.4	0.13	1	0.1	3.7		0.24	28.46	37.00	[143]
BDCDA-DDSO	S	30	Barrer		12.9	0.14	0.93	0.12	4.2		0.33	30.00	35.00	[143]
HDCDA-6F	S	30	Barrer		23.1	0.12	1.06	0.1	4.1		0.18	34.17	41.00	[143]
PDCDA-6F	S	30	Barrer		25	0.18	1.2	0.16	5		0.20	27.78	31.25	[143]
BDCDA-6F	S	30	Barrer		41.5	0.64	3.8	0.4	15.6		0.38	24.38	39.00	[143]
PMDA-ODA	S	35	Barrer	8		0.1	0.61	0.059	2.71	0.34		27.10	45.93	[116]
PMDA-MDA	S	35	Barrer	9.4			0.98	0.1	4.03	0.43			40.30	[116]
PMDA-IPDA	S	35	Barrer	37.1			7.1	0.9	26.8	0.72			29.78	[116]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES							SELECTIVITIES			REFERENCE
				He	H_2	$_2$	$_2$	CH_4	CO_2	CO_2/He	CO_2/H2	CO_2/N_2	CO_2/CH_4	
Polyimides (Cont'd.)														
6FDA-ODA	S	35	Barrer	51.5	**N**	**O**	4.34	0.38	23	0.45			60.53	[116]
6FDA-MDA	S	35	Barrer	50			4.6	0.43	24.2	0.48			56.28	[116]
6FDA-IPDA	S	35	Barrer	71.2			7.53	0.7	30	0.42			42.86	[116]
6FDA-DAF	S	35	Barrer	98.5			7.85		32.2	0.33				[116]
PMDA-m'pODA	S	35	Barrer		5.92	0.045	0.31	0.0258	1.18		0.20	25.99	45.74	[116]
PMDA-p 'pODA	S	35	Barrer		10.6	0.145	0.825	0.0937	3.55		0.33	24.48	37.89	[116]
PMDA-BAPHF	S	35	Barrer		34.3	0.943	4.98	0.638	17.6		0.51	18.66	27.59	[116]
PMDA-BATPHF	S	35	Barrer		50.4	1.5	7.06	0.937	24.6		0.49	16.40	26.25	[116]
BPDA-p 'pODA	S	35	Barrer		3.68			0.0099	0.642		0.17		64.85	[116]
BPDA-BAPHF	S	35	Barrer		17.3	0.245	1.54	0.145	4.96		0.29	20.24	34.21	[116]
BPDA-BATPHF	S	35	Barrer		30.6	0.563	3.11	0.279	9.15		0.30	16.25	32.80	[116]
BPDA-BAHF	S	35	Barrer		59.1	1.39	7.1	0.78	27.7		0.47	19.93	35.51	[116]
BTDA-p 'pODA	S	35	Barrer		4.79	0.024	0.191	0.0109	0.625		0.13	26.48	57.34	[116]
BTDA-BAPHF	S	35	Barrer		16.1	0.195	1.14	0.105	4.37		0.27	22.41	41.62	[116]
BTDA-BATPHF	S	35	Barrer		24.6	0.37	2.17	0.189	6.94		0.28	18.76	36.72	[116]
BTDA-BAHF	S	35	Barrer		30.8	0.45	2.5	0.226	10.1		0.33	22.44	44.69	[116]
6FDA-m'pODA	S	35	Barrer		23.7	0.259	1.57	0.125	6.11		0.26	23.59	48.88	[116]
6FDA-APAP	S	35	Barrer		38.2	0.473	2.89	0.217	10.7		0.28	22.62	49.31	[116]
6FDA-p'pODA	S	35	Barrer		40.7	0.733	3.88	0.341	16.7		0.41	22.78	48.97	[116]
6FDA-BAPHF	S	35	Barrer		47.4	0.981	5.13	0.52	19.1		0.40	19.47	36.73	[116]
6FDA-BATPHF	S	35	Barrer		55.4	1.3	6.5	0.703	22.8		0.41	17.54	32.43	[116]
6FDA-BAHF	S	35	Barrer		108	3.11	14.2	1.34	51.2		0.47	16.46	38.21	[116]
6FDA-TADPO (polypyrrolone)	S	35	Barrer	89			4.34		23	0.26				
6FDA-HAB	S	35	Barrer					0.071	7.83				110.28	[149]
6FDA-durene	S	35	Barrer	490	786	55.4	186	45.1	612	1.25	0.78	11.05	13.57	[132]
6FDA-6FpDA-8%-DABA	S	30	Barrer	178		10	36	6	84	0.47		8.40	14.00	[132]
6FDA-6FpDA-8%-DABA:Aluminophoshate(95:5)	S	30	Barrer	148		6.2	24	3.6	66	0.45		10.65	18.33	[132]
6FDA-6FpDA-8%-DABA:Aluminophoshate(90:10),1	S	30	Barrer	94.4		2.1	18.5	1.3	51	0.54		24.29	39.23	[132]
6FDA-6FpDA-8%-DABA:Aluminophoshate(90:10),2	S	30	Barrer	67.5		1.2	9.3	0.7	28.3	0.42		23.58	40.43	[132]
Matrimid 5218	S	35	Barrer			0.32	2.12	0.28	10			31.25	35.71	[311]
Matrimid 5218	M	20-25	GPU	83.2				0.57	28.5	0.34			50.00	[493]
Matrimid 5218 (Fluorinated)	M	20-25	GPU	77				0.2	18.7	0.24			93.50	[493]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES He	H_2	N_2	O_2	CH_4	CO_2	SELECTIVITIES CO_2/He	CO_2/H2	CO_2/N_2	CO_2/CH_4	REFERENCE
Polyphosphazenes Pendant groups: 2-(2-methoxyethoxy)ethanol : 4Methoxyphenol : 2-Allylphenol														
6:75:19	S	30	Barrer	4.7	4.2	0.3	1.7	1.4	9.3	1.98	2.21	31.00	6.64	[264]
23:72:5	S	30	Barrer	9.7	13.4	1.8	4.8	3.6	38.9	4.01	2.90	21.61	10.81	[264]
25:59:16	S	30	Barrer	15.1	19.4	2.8	7.7	7.1	81.9	5.42	4.22	29.25	11.54	[264]
38:46:16	S	30	Barrer	16.8	25.6	3.9	10.2	13.9	107.7	6.41	4.21	27.62	7.75	[264]
48:48:4	S	30	Barrer	16.6	23.7	8.3	14.8	16	115.9	6.98	4.89	13.96	7.24	[264]
74:24:2	S	30	Barrer	21.9	28.8	10.2	18	19.2	226.7	10.35	7.87	22.23	11.81	[264]
100:0:0	S	30	Barrer	17	25	4	7	11	250	14.71	10.00	62.50	22.73	[264]
R Group														
PPOP	S	30	Barrer		7.5	1.3	2.1	1.2	4.8		0.64	3.69	4.00	[241]
PTBP	S	30	Barrer		23	2.4	8.2	1.7	17		0.74	7.08	10.00	[241]
PBTBP:Cl (20:80)	S	30	Barrer		75	3	11	5	27		0.36	9.00	5.40	[241]
Other Polymers														
Cytop	S	35	Barrer	1270	620	34	130	11	300	0.24	0.48	8.82	27.27	[150]
Poly(3-(2-acetoxyethyl)thiophene) (P3AcET)	S	20	Barrer			22	111	36	668			30.36	18.56	[150]
Poly(3-(2-hydroxyethyl)thiophene) (P3AcET),1	S	20	Barrer			5	63	14	281			56.20	20.07	[150]
Poly(3-(2-hydroxyethyl)thiophene) (P3AcET),2	S	20	Barrer			5	60	8	336			67.20	42.00	[150]
Copolymers														
Ether-Olefin														
Poly(propylene glycol) diacrylate (PPGDA) 540	S	23	Barrer		15	2	5		30		2.00	15.00		[242]
PPGDA900	S	23	Barrer		33	7	15		110		3.33	15.71		[242]
Poly(ethylene glycol) diacrylate (PEGDA) 575	S	23	Barrer		7.2		1.8	0.73	39		5.42		53.42	[242]
PEGDA575 + 10 wt% fumed silica	S	23	Barrer		5.3		1.4	0.6	32		6.04		53.33	[242]
PEGDA700	S	23	Barrer		8.5		3	1	72		8.47		72.00	[242]
PEGDA700 + 10 wt% fumed silica	S	23	Barrer		7.2		3.1	0.9	68		9.44		75.56	[242]
PEGDMA/alumina	S	room	Barrer	6.7	7.5	1	1.5	1.1	19	2.84	2.53	19.00	17.27	[248]
poly(tetramethylene oxide) (PTMEO):nylon (PEA)12 (80:20)	S	35	Barrer		59.73	9.44			221		3.70	23.40		[252]
PTMEO:PEA12(53:47)	S	35	Barrer		32.29	5.54			113		3.50	20.40		[252]
PEO:PA6(55:45)	S	35	Barrer		12.24	2.33			120		9.80	51.40		[252]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES						SELECTIVITIES			REFERENCE
				He	H_2	N_2	O_2	CH_4	CO_2	CO_2/He	$CO_2/H2$	CO_2/N_2	CO_2/CH_4	
Copolymers (Cont'd.)													
PEO:PA12(57:43)	S	35	Barrer		8.46	1.17			66		7.80	56.40		[252]
Methoxy PEG acrylate (MePEGA)0/Polyacrylonitrile (PAN)	S	30	GPU			0.658			6.45			9.80		[251]
MePEGA2/PAN	S	30	GPU			0.186			6.14			33.00		[251]
MePEGA4/PAN	S	30	GPU			0.159			5.4			34.00		[251]
MePEGA6/PAN	S	30	GPU			0.174			5.65			32.40		[251]
MePEGA8/PAN	S	30	GPU			0.180			5.87			32.60		[251]
MePEGA10/PAN	S	30	GPU			0.206			6.36			30.90		[251]
MePEGA12/PAN	S	30	GPU			0.239			7.06			29.50		[251]
MePEGA14/PAN	S	30	GPU			0.684			7.52			11.00		[251]
MePEGA16/PAN	S	30	GPU			1.532			9.04			5.90		[251]
MePEGA18/PAN	S	30	GPU			3.570			9.64			2.70		[251]
PEGDA/Poly(ethylene glycol) methyl ether acrylate (PEGMEA) (100:0)	S	35	Barrer			2.15			112			52.00		[237]
PEGDA/PEGMEA(80:20)	S	35	Barrer			2.59			150			58.00		[237]
PEGDA/PEGMEA(50:50)	S	35	Barrer			6.10			250			41.00		[237]
PEGDA/PEGMEA(30:70)	S	35	Barrer			6.81			320			47.00		[237]
PEGDA/PEGMEA(9:91)	S	35	Barrer			12.68			520			41.00		[237]
PEGDA/PEGMEA(1:99)	S	35	Barrer			13.90			570			41.00		[237]
PEG dimethacrylate(DM)14:PEG methyl ether methacrylate (MM)9 (100:0)	S	35	Barrer			1.23			65			53.00		[253]
DM14:MM9 (90:10)	S	35	Barrer			1.57			85			54.00		[253]
DM14:MM9 (70:30)	S	35	Barrer			2.53			129			51.00		[253]
DM14:MM9 (50:50)	S	35	Barrer			3.70			185			50.00		[253]
DM14:MM9 (30:70)	S	35	Barrer			5.42			260			48.00		[253]
DM9:MM9 (90:10)	S	35	Barrer			0.53			28			53.00		[253]
DM23:MM9 (90:10)	S	35	Barrer			3.73			194			52.00		[253]
2,2-bis(4-methacryloxy polyethoxy phenyl)propane (DB)30:MM9 (100:0)	S	35	Barrer			2.61			128			49.00		[253]
DB30:MM9 (90:10)	S	35	Barrer			2.80			140			50.00		[253]
DB30:MM9 (70:30)	S	35	Barrer			3.63			185			51.00		[253]
DB30:MM9 (50:50)	S	35	Barrer			4.81			231			48.00		[253]
DB30:MM9 (30:70)	S	35	Barrer			6.55			308			47.00		[253]
DB10:MM9 (90:10)	S	35	Barrer			0.25			12			48.00		[253]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES						SELECTIVITIES				REFERENCE
				He	H_2	$_2$	$_2$	CH_4	CO_2	CO_2/He	CO_2/H2	CO_2/N_2	CO_2/CH_4	
Copolymers (Cont'd.)														
					N	O								
Ether-Ether														
EO:2-(2-methoxyethoxy)ethyl glycidyl ether(EM-2):allyl glycidyl ether (AGE) (94:4:2)	S	35	Barrer		20	4			250		12.50	62.50		[254]
Ethylene oxide (EO):propylene oxide(PO):AGE (83:16:1)	S	35	Barrer		30	5			220		7.33	44.00		[254]
EO:epichlorohydrin(EP):AGE (56:39:5)	S	35	Barrer		30	6			260		8.67	43.33		[254]
PO:EP:3-glycidoxypropyltrimethoxysilane (GPTMS) (35:63:2)	S	35	Barrer		30	6			270		9.00	45.00		[254]
EO:AGE (92:8)	S	35	Barrer		30	5			350		11.67	70.00		[254]
EP:AGE (94:6)	S	35	Barrer		20	6			250		12.50	41.67		[254]
EO:GPTMS (95:5)	S	35	Barrer		40	6			380		9.50	63.33		[254]
EO:PO (90:10)	S	35	Barrer		45	6			400		8.89	66.67		[254]
EO:EM-2 (78:22)	S	35	Barrer		38	7			610		16.05	87.14		[254]
Ester-Ether														
PEG-1500:1,4-butanediol:DMT	S	35	Barrer		28.2				262		9.29			[176]
PEG-1500:1,4-butanediol:2,6 DMN	S	33	Barrer		30.6				333		10.88			[176]
PEG-1500:1,3-propanediol:DMCH	S	33.5	Barrer		35.8				353		9.86			[176]
PEG-1500:1,3-propanediol:SBMB	S	36	Barrer		23.1				237		10.26			[176]
PEG-1500:1,3-propanediol:DMBPD	S	33	Barrer		45.3				322		7.11			[176]
PEG-2000:1,2-ethyleneglycol:2,6-DMN	S	33	Barrer		5.6				59.3		10.59			[176]
Diene-Olefin														
Poly(butadiene-styrene)	S	35	Barrer	32.9		10.3	32.9	34.2	171	5.20		16.60	5.00	[116]
Polyvinyl-butadiene	S	30	Barrer		7.9	1.8	0.6	2.5	15.3		1.94	8.50	6.12	[249]
Poly(acrylonitrile-butadiene)	M	25	Barrer		25.2				63.1		2.50			[492]
Ether-Urethane														
PU1	M	35	Barrer					8.1-11.2	77.5-55.8				5.0-9.	[175]
PU3	M	35	Barrer					4.7-5.1	58.8-62.2				12.2-12.5	[175]
Ether-Urethane urea														
PU2	M	35	Barrer					32.5-34.7	195-197				5.6-6.0	[175]
PU4	M	35	Barrer					2.7-3.4	44.7-50.8				15.0-16.6	[175]
Copolyimides														
Teflon AF2400 (Hyflon AD87)	S	25	Barrer	3600	3400	780	1600	600	3900	1.08	1.15	5.00	6.50	[496]
BTDA-TDI/MDI (80:20) (P84)	S	25	Barrer	7.2		0.024	0.24	0.0246	0.99	0.14		41.25	40.24	[134]

	*	T (°C)	UNITS	PERMEANCES AND PERMEABILITIES						SELECTIVITIES				REFERENCE
				He	H_2	N_2	O_2	CH_4	CO_2	CO_2/He	$CO_2/H2$	CO_2/N_2	CO_2/CH_4	
Copolymers (Cont'd.)														
Hyflon AD60	S	35	Barrer	1360	790	52	180	17.6	433	0.32	0.55	8.33	24.60	[153]
Hyflon AD60	S	22	Barrer					27	460				17.04	[153]
Hyflon AD80	S	22	Barrer					125	1620				12.96	[153]
Polysulfone:poly(4-vnylpyridine):Silcon Rubber (25:0.1:3)	S	25	GPU		140	1.3	8.1	0.77	40		0.29	30.77	51.95	[126]
Polysulfone:poly(4-vnylpyridine):Silcon Rubber (25:0.2:3)	S	25	GPU		90	0.92	6.7	0.48	40		0.44	43.48	83.33	[126]
Polysulfone:poly(4-vnylpyridine):Silcon Rubber (25:0.5:3)	S	25	GPU		74	0.65	4.9	0.44	24		0.32	36.92	54.55	[126]
Polysulfone:poly(4-vnylpyridine):Silcon Rubber (25:1.0:3)	S	25	GPU		54	0.59	3.4	0.36	16		0.30	27.12	44.44	[126]
Polysulfone:poly(4-vnylpyridine):Silcon Rubber (23:0.2:3)	S	25	GPU		132	1.3	8.6	0.87	51		0.39	39.23	58.62	[126]
Polysulfone:poly(4-vnylpyridine):Silcon Rubber (21:0.5:3)	S	25	GPU		96	1.6	7.5	1.8	40		0.42	25.00	22.22	[126]
Polysulfone:poly(4-vnylpyridine):Silcon Rubber (21:1.0:3)	S	25	GPU		81	1.1	5.3	0.99	28		0.35	25.45	28.28	[126]
Polysulfone:poly(4-vnylpyridine):Silcon Rubber (21:2.0:3)	S	25	GPU		20	0.4	2.1	0.26	8.8		0.44	22.00	33.85	[126]
Polysulfone:poly(4-vnylpyridine):Silcon Rubber (17:2.0:3)	S	25	GPU		54	3	5.2	1.9	16		0.30	5.33	8.42	[126]
FACILITATED TRANSPORT														
Solid-Polyelectrolyte														
Polyvinylpyrrolidone (hydrolyzed)/polysulfone	S	26	GPU					0.3-3.5	25-800					[292,293]
PVBTAF:poly(diallyldimethylammonium fluoride)	M	23	Barrer		0.276			0.0417	7.51		27.21		180.10	[281]
Poly(vinylbenzyltrimethylammonium fluoride) (PVBTAF)	M	23	GPU		0.0751			0.0128	3.57		47.54		278.91	[281]
PVBTAF/poly(diallyldimethylammonium fluoride)	M	23	GPU		0.0443			0.00636	4.83		109.03		759.43	[281]
PVBTAF-nCesiumFluoride,n=4	M	23	GPU		0.20-0.3			0.035-0.044	13-25.7		43-126		371-587	[277]
PVBTAF-nCesiumFluoride-1cholineFluoride,n=3	M	23	GPU					0.109-0.061	19.31-24.39				178-400	[277]
PDMS/poly(diallyl-dimethylammoniumfluoride) (PDADMAF)/PDMS	M	23	GPU		0.016-0.023			0.007	0.87-1.83		53-81		120-239	[279]
PTMSP/PDADMAF/PTMSP	M	23	GPU		0.065			0.007	1.1-2.84		17-44		150-380	[279]
PTMSP/PDADMAF/microporous polymer	M	23	GPU		0.112-0.163			0.023-0.025	1.96-2.69		12-24		78-118	[279]
PTMSP/PVBTAF/microporous polymer	M	23	GPU		0.006			0.068	2.88-6.02		490-10000		43-87	[279]
Poly(vyvilbenzyltrimethylammonium fluoride) PVBTAF,#1	M	23	GPU		0.07-0.10			0.00586	2.88-6.02		42-64		4910-10270	[280]
Poly(vyvilbenzyltrimethylammonium fluoride) PVBTAF,#2	M	23	GPU			0.011	0.026-0.022		7.17-9.02			629-835		[280]
Polyvinylamine (PVAm)/poly(ether sulfone)	S	25	GPU					0.221	1.437				6.50	[288]
Polyvinylamine (PVAm)/polyacrylonitrile	S	25	GPU					2.375	12.111				5.10	[288]
Polyvinylamine (PVAm)/celullose acetate	S	25	GPU					2.119	36.67				17.31	[288]
Polyvinylamine (PVAm)/polysulfone	S	25	GPU					0.003-0.087	2.33-3.1				36-778	[288]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES						SELECTIVITIES			REFERENCE
				He	H_2	N_2	O_2	CH_4	CO_2	CO_2/He	CO_2/H2	CO_2/N_2	CO_2/CH_4	
FACILITATED TRANSPORT (Cont'd.)													
Inmobilized liquid													
Glycerol-Na_2CO_3 in poly(vinylidine fluoride) (PVDF) (dry)	M	23	Barrer					1.24	2.79				2.25	[272]
Glycerol-Na_2CO_3 in PVDF (100 RH)	M	23	Barrer					1.56	1770				1135	[272]
Glycerol carbonate in PVDF (dry)	M	23	Barrer					1.1	100				90.91	[274]
Glycerol carbonate in PVDF (humid)	M	23	Barrer					3.7	320				86.49	[274]
Glycerol carbonate in Celgard 2500 (dry)	M	23	Barrer					4.4	260				59.09	[274]
Glycerol carbonate in Celgard 2500 (humid)	M	23	Barrer					3.5	160				45.71	[274]
44% dendrimer (generation 0) in glycerol in PVDF (dry)	M	23	Barrer					7.54	17				2.25	[275]
44% dendrimer (generation 0) in glycerol in PVDF (humid)	M	23	Barrer					0.94	900				957	[275]
75% dendrimer (generation 0) in glycerol in PVDF (dry)	M	23	Barrer					860	5800				6.74	[275]
75% dendrimer (generation 0) in glycerol in PVDF (humid)	M	23	Barrer					0.19	3200				16842	[275]
Pure dendrimer in PVDF by impregnation (dry)	M	23	Barrer					930	4700				5.05	[275]
Pure dendrimer in PVDF by impregnation (humid)	M	23	Barrer					0.17	3600				21176	[275]
INORGANIC MEMBRANES														
Zeolites														
Fau-type,1	S	50	GPU		717.44				567.97		0.79			[320]
Fau-type,2	S	50	GPU		777.23				627.76		0.81			[320]
Fau-type,3	S	50	GPU		161.42				388.61		2.41			[320]
Fau-type,4	S	50	GPU		47.83				358.72		7.50			[320]
Fau-type,5	S	50	GPU		14.65				233.17		15.92			[320]
Fau-type,6	S	50	GPU		5.98				116.58		19.50			[320]
Fau-type,7	S	50	GPU		38.86				275.02		7.08			[320]
Fau-type,8	S	50	GPU		23.62				230.18		9.75			[320]
ZSM-5	S	25	GPU		2.27				104.63		46.00			[314]
ZSM-5	S	25	GPU		30.45				1644.13		54.00			[314]
Na-Y	M	30	GPU		4.48				448.40		100.00			[329]
K-Y	M	40	GPU		177.58				5380.80		30.30			[327]
Silicalite	M	180	GPU		2.54				50.82		20.00			[334]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES						SELECTIVITIES				REFERENCE
				He	H_2	N_2	O_2	CH_4	CO_2	CO_2/He	CO_2/H2	CO_2/N_2	CO_2/CH_4	
Zeolites (Cont'd.)														
Silicalite	M	30	GPU			38.05			209.25			5.50		[330]
K-ZSM-5	M	50	GPU			67.26			134.52			2.00		[333]
B-ZSM-5	M	27	GPU			45.08			567.97			12.60		[322]
Na-ZSM-5	M	27	GPU			567.32			7772.27			13.70		[322]
Sapo-34,1	S	24	GPU					12.26	328.83				26.83	[315]
Sapo-34,2	S	24	GPU					7.47	418.51				56.00	[315]
Sapo-34,3	S	24	GPU					4.78	418.51				87.50	[315]
Sapo-34	M	22	GPU					15.51	573.95				37.00	[316]
Sapo-34	M	22	GPU					17.58	298.93				17.00	[316]
Carbon-Silicalite composite	S	27	GPU	22.12		0.54	1.91		32.88	1.49		61.11		[321]
Sapo-34,1	S	25	GPU		203.27	37.37		110.61	179.36		0.88	4.80	1.62	[325]
Sapo-34,2	S	25	GPU		179.36	32.88		50.82	158.43		0.88	4.82	3.12	[325]
Silicas														
Silica,1	S	20	GPU			0.38			6.40			17		[317]
Silica,2	S	20	GPU			0.54			3.89			7.2		[317]
Aminosilicate,1	S	22	GPU			5.83			304.82			52.3		[318]
Aminosilicate,2	S	22	GPU			1.16			72.37			62.6		[318]
Aminosilicate,3	S	22	GPU			3.76			225.88			60.1		[318]
Aminosilicate,4	S	22	GPU			0.64			63.60			100		[318]
Aminosilicate,5	S	22	GPU			2.75			212.72			77.3		[318]
Aminosilicate,6	S	22	GPU			1.23			50.44			41		[318]
Aminosilicate,7	S	22	GPU			2.33			116.23			49.9		[318]
Aminosilicate,8	S	22	GPU			1.19			83.33			70.2		[318]
Aminosilicate,9	S	22	GPU			0.40			30.70			76.8		[318]
Aminosilicate,10	S	22	GPU			1.33			70.18			52.9		[318]
Microporous Silica	S	50	GPU	8968	14049	2989	419		10164	1.13	0.72	3.40		[318]
Microporous Silica	S	50	GPU	5381	5380	1494	50.8		2391	0.44	0.44	1.60		[497]
Carbon Molecular Sieves (precursors)														[497]
BTDA-TDI/MDI	S	25	GPU	400	1250	120	400	80	2000	5.00	1.60	16.67	25.00	[308]
BTDA-TDI/MDI (80:20) (P84)	S	25	Barrer	58.5		2.8	3		3.3	0.06		1.18		[306]
BTDA-TDI/MDI (80:20) (P84):AgSPEEK (95:5)	S	25	Barrer	161		4.6	27.5		83.3	0.52		18.11		[306]
BTDA-TDI/MDI (80:20) (P84):AgSPEEK (90.9:9.1)	S	25	Barrer	465		10.3	91.8		366	0.79		35.53		[306]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES						SELECTIVITIES				REFERENCE
				He	H_2	$_2$	$_2$	CH_4	CO_2	CO_2/He	CO_2/H2	CO_2/N_2	CO_2/CH_4	
Carbon Molecular Sieves (precursors) (Cont'd.)						N	O							
BTDA-TDI/MDI (80:20) (P84):AgSPEEK (83.3:16.7)	S	25	Barrer	361		3.9	52.7		191	0.53		48.97		[306]
BTDA-TDI/MDI (80:20) (P84):AgNO3 (94:6)	S	25	Barrer	169		0.19	3		12.4	0.07		65.26		[306]
Matrimid 5218	S	35	Barrer			1.65	22	0.22	44			26.67	200.00	[390]
Matrimid 5218,1	S	25	Barrer	18		0.8	4.5	0.37	12	0.67		15.00	32.43	[148]
Matrimid 5218,2	S	25	Barrer	70		2.5	7.5	2	10	0.14		4.00	5.00	[148]
Matrimid 5218,3	S	25	Barrer	22		0.72	3.1	0.72	8.5	0.39		11.81	11.81	[148]
Kapton	S	25	Barrer	9		0.15	1.15	0.15	2	0.22		13.33	13.33	[148]
PMDA-ODA-PDM (Poly(imide-siloxane:PIS),1		25	Barrer	315		0.3	8		21	0.07		70.00		[304]
PMDA-ODA-PDM (Poly(imide-siloxane:PIS),2		25	Barrer	3416	8216	27	326		1068	0.31	0.13	39.56		[304]
PMDA-ODA-PDM (Poly(imide-siloxane:PIS),3		25	Barrer	610		1.4	30		84	0.14		60.00		[304]
PMDA-ODA-PDM (Poly(imide-siloxane:PIS),4		25	Barrer	4245	9518	40	399		1509	0.36	0.16	37.73		[304]
PMDA-ODA-PDM (Poly(imide-siloxane:PIS),5	S	25	Barrer	1258		8.5	111		386	0.31		45.41		[304]
PMDA-ODA-PDM (Poly(imide-siloxane:PIS),6	S	25	Barrer	7319	12598	69	595		2526	0.35	0.20	36.61		[304]
BTDA-ODA (PI)-(PVP) blend (10:10:0),1	S	S	25	Barrer	1700		47	500		1500	0.88		31.91		[302]
BTDA-ODA (PI)-(PVP) blend (10:10:0),2	S	S	25	Barrer	1100		9	140		350	0.32		38.89		[302]
BTDA-ODA (PI)-(PVP) blend (10:10:5),1	S	S	25	Barrer	2000		57	550		1800	0.90		31.58		[302]
BTDA-ODA (PI)-(PVP) blend (10:10:5),2	S	S	25	Barrer	1250		13	160		400	0.32		30.77		[302]
BTDA-ODA (PI)-(PVP) blend (10:10:10),1		S	25	Barrer	2200		66	640		1950	0.89		29.55		[302]
BTDA-ODA (PI)-(PVP) blend (10:10:10),2		S	25	Barrer	1700		17	230		550	0.32		32.35		[302]
Matrimid 5218		S	35	Barrer			30.3	227	10	611			20.17	200.00	[309]
Matrimid 5218, MeOH pretreat		S	35	Barrer			15.8	138	4.8	423			26.77	88.13	[309]
Matrimid 5218, EtOH pretreat		S	35	Barrer			6.3	75.4	1.1	191			30.32	173.64	[309]
Matrimid 5218, PrOH pretreat		S	35	Barrer			24.1	204	6.7	565			23.44	84.33	[309]
Matrimid 5218, BuOH pretreat		S	35	Barrer			21	186	7	547			26.05	78.14	[309]
P84		S	35	Barrer			17.8	158	5.6	499			28.03	201.00	[309]
P84, MeOH pretreat		S	35	Barrer			13.6	132	3.7	402			29.56	108.65	[309]
P84, EtOH pretreat		S	35	Barrer			9	101	2	278			30.89	139.00	[309]
P84, PrOH pretreat		S	35	Barrer			14.6	144	3.9	428			29.32	109.74	[309]
BTDA-ODA-mPDA-DBA (10:8:2:0)		S	25	Barrer	2763		24	256		829	0.30		34.54		[250]
BTDA-ODA-mPDA-DBA (10:8:0:2)		S	25	Barrer	3208		49	501		1674	0.52		34.16		[250]
BTDA-ODA-mPDA-DBA (10:8:0:5)		S	25	Barrer	4193		83	707		2863	0.68		34.49		[250]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES						SELECTIVITIES				REFERENCE
				He	H_2	N_2	O_2	CH_4	CO_2	CO_2/He	CO_2/H2	CO_2/N_2	CO_2/CH_4	
Carbon Molecular Sieves (precursors) (Cont'd.)														
CMSM,1	S	20	GPU		2160.00	10.40	86.27		486.67		0.23	46.79		[297,298]
CMSM,2	S	20	GPU		1680.00	7.47	63.33		288.00		0.17	38.57		[297,298]
CMSM,3	S	20	GPU		2093.33	13.33	141.33		792.00		0.38	59.40		[297,298]
CMSM,4	S	20	GPU		1893.33	8.13	97.33		530.67		0.28	65.25		[297,298]
CMSM,5	S	20	GPU		1130.67	4.40	58.53		317.33		0.28	72.12		[297,298]
Surface Flow (adsorption Selective membranes)														
Carbonized latex-graphite, MI	M	25	Barrer					350	1130				3.23	[492]
Carbonized latex-graphite, MI	M	-20	Barrer					240	1080				4.50	[492]
Carbonized latex-graphite, MII	M	25	Barrer					250	1800				7.20	[492]
Carbonized latex-graphite, MII	M	-15	Barrer					58	1500				25.86	[492]
Carbonized latex-graphite, MIIIA	S	22	Barrer	22	150			335	631	28.68	4.21		1.88	[492]
Carbonized latex-graphite, MIIIB	S	22	Barrer	31	129			663	1054	34.00	8.17		1.59	[492]
Carbonized latex-graphite, MIIIC	S	22	Barrer	28	145			551	973	34.75	6.71		1.77	[492]
Carbonized phenolic resin	S	25	GPU	239		329	448	836	1195	5.00		3.64	1.43	[356]
HDFS in Vycor	S	20	GPU	1.01	0.52	0.34		0.56	2.1	2.07	4.03	6.12	3.74	[351]
ODS in g-Alumina	S	20	GPU		38	11		17	60		1.58	5.45	3.53	[358]
$C_nH_{2n+1}(CH_3)_2SiCl$ in porous glass, n = 18	S	25	GPU	0.051		0.028			0.284	5.59		10.00		[262]
$C_nH_{2n+1}(CH_3)_2SiCl$ in porous glass, n = 8	S	25	GPU	0.358		0.299			0.538	1.50		1.80		[262]
$C_nH_{2n+1}(CH_3)_2SiCl$ in porous glass, n = 3	S	25	GPU	3.58		2.09			2.69	0.75		1.29		[262]
$C_nH_{2n+1}(CH_3)_2SiCl$ in porous glass, n = 1	S	25	GPU	5.38		2.99			3.88	0.72		1.30		[262]
Novolak-phenolic resin-N-methyl-2-pyrrolidone,1	S	25	GPU		151.86	39.04		68.51	335.70		2.21	8.60	4.90	[356]
Novolak-phenolic resin-N-methyl-2-pyrrolidone,1	S	25	GPU		216.73	311.05		677.00	1150.89		5.31	3.70	1.70	[356]
Novolak-phenolic resin-N-methyl-2-pyrrolidone,1	S	25	GPU		70.25	47.10		150.02	405.05		5.77	8.60	2.70	[356]
Novolak-phenolic resin-N-methyl-2-pyrrolidone,1	S	25	GPU		248.11	83.93		134.64	646.29		2.60	7.70	4.80	[356]
Novolak-phenolic resin-N-methyl-2-pyrrolidone,1	S	25	GPU		322.55	55.98		48.87	615.80		1.91	11	12.6	[356]
Zeolite-T	S	35	GPU	10.46	23.91	5.38		0.42	89.68	8.57	3.75	16.67	214.29	[352,353]
DDR-zeolite	S	18	GPU	29.89	119.57	14.95	26.90	0.34	239.15	8.00	2.00	16.00	703.37	[355]
Sapo-34,3	S	25	GPU	119.57	248.11	65.77		20.93	448.40	3.75	1.81	6.82	21.43	[325]
SSZ-13 Zeolite,1	S	25	GPU		403.56	89.68		44.84	478.29		1.19	5.33	10.67	[357]
SSZ-13 Zeolite,2	S	25	GPU		388.61	134.52		80.71	627.76		1.62	4.67	7.78	[357]
SSZ-13 Zeolite,3	S	25	GPU		553.03	107.62		113.59	702.49		1.27	6.53	6.18	[357]

	*	T (^{O}C)	UNITS	PERMEANCES AND PERMEABILITIES He	H_2	N_2	O_2	CH_4	CO_2	CO_2/He	SELECTIVITIES CO_2/H2	CO_2/N_2	CO_2/CH_4	REFERENCE
Surface Flow (adsorption Selective membranes) (Cont'd.)														
SSZ-13 Zeolite,4	S	25	GPU		463.35	134.52		89.68	553.03		1.19	4.11	6.17	[357]
SSZ-13 Zeolite,5	S	25	GPU		463.35	134.52		74.73	702.49		1.52	5.22	9.40	[357]
HYBRID ORGANIC-INORGANIC MEMBRANES														
Poly(amide-6-b ethylene oxide)(PEBAX)-Silica														[207]
PEBAX:Silica(100:0)	S	25	Barrer	18.6		1.71	5.84		122	6.56		71.35		[207]
PEBAX:Silica(90:10)	S	25	Barrer	21.4		2.13	6.82		154	7.20		72.30		[207]
PEBAX:Silica(81:19)	S	25	Barrer	25.5		1.73	8.74		205	8.04		118.50		[207]
PEBAX:Silica(73:27)	S	25	Barrer	32.2		3.52	11.3		277	8.60		78.69		[207]
PDMS-pentaerythrithol triacrylate (PETA)-Silica														[364]
PDMS:PETA:Silica (11:89:0)	S	23	Barrer		479	206	441	648	1154		2.41	5.60	1.78	[364]
PDMS:PETA:Silica (10:85:5)	S	23	Barrer		647	381	665	1246	4511		6.97	11.84	3.62	[364]
PDMS:PETA:Silica (10:80:10)	S	23	Barrer		285	156	341	466	1422		4.99	9.12	3.05	[364]
Poly(ethylene glycol)(PEG)-Silica														[363]
PEG600:Silica	S	30	Barrer			0.52	1.51	1.48	23.92			46.00	16.16	[363]
PEG1000:Silica	S	30	Barrer			1.16	2.68	3.12	49.3			42.50	15.80	[363]
PEG2000:Silica	S	30	Barrer			2.46	5.56	6.01	94.2			38.29	15.67	[363]
Poly(propylene glycol)(PPG)-Silica														[363]
PPG600:Silica	S	30	Barrer			1.69	5	4.99	33.91			20.07	6.80	[363]
PPG1000:Silica	S	30	Barrer			2.54	6.73	7.3	48.37			19.04	6.63	[363]
PPG2000:Silica	S	30	Barrer			3.81	9.24	10.95	72.26			18.97	6.60	[363]
(PEG-PPG-PEG) (PEPG)-Silica														[363]
PEPG2000:Silica	S	30	Barrer			3.2	8.1	10.1	83.64			26.14	8.28	[363]
PEPG2700:Silica	S	30	Barrer			4.39	10.6	13.6	110			25.06	8.09	[363]
PEPG3300:Silica	S	30	Barrer			6.59	15.76	20.18	132.3			20.08	6.56	[363]
Acrylonitrile-butadiene-sturene (ABS)/Activated carbon 1(AC1)	S	20	Barrer					0.162-0.315	4.31-10.81				26.6-34.3	[393]
ABS/AC2	S	20	Barrer					0.264-0.406	7.49-20.50				28.4-50.5	[393]
6FDA-TAPOB hyperbranched polyimide (HBPI)-Silica														[206]
HBPI-Silica(100:0)	S	25	Barrer			0.22	1.5	0.098	7.4			26.67	75.51	[206]
HBPI-Silica(90:10)	S	25	Barrer			0.31	2	0.092	10			32.26	108.70	[206]
HBPI-Silica(80:20)	S	25	Barrer			0.32	2.1	0.08	12			37.50	150.00	[206]
HBPI-Silica(100:30)	S	25	Barrer			0.46	3	0.08	19			41.30	237.50	[206]

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				He	H_2	N_2	O_2	CH_4	CO_2	CO_2/He	CO_2/H2	CO_2/N_2	CO_2/CH_4	
HYBRID ORGANIC-INORGANIC MEMBRANES (Cont')													
Polysulfone (PSF)-Carbon Black(CB)													
PSF:CB (100:0)	S	25	GPU			2.05	12.21	2.1	86.12			26.67	41.01	[125]
PSF:CB (98:2)	S	25	GPU			1.94	12.65	2.16	76.25			39.30	35.30	[125]
PSF:CB (95:5)	S	25	GPU			2.81	12.78	4.77	68.72			24.46	14.41	[125]
PSF:CB (90:10)	S	25	GPU			2.25	11.89	2.44	75.13			33.39	30.79	[125]
PSF-Vapor grown carbon fibers (VGVF)	S	25	GPU			3.95	12.63	5.52	57.12			26.67	10.35	[125]
PSF-Titania	S	25	GPU			3.17	14.7	3.67	89.56			28.25	24.40	[125]
Matrimid® 5218-Carbon molecular sieve (CMS)													
Matrimid® 5218:CMS (100:0)	S	35	Barrer			0.32	2.12	0.28	10			26.67	35.71	[390,391]
Matrimid® 5218:CMS (83:17)	S	35	Barrer			0.29	2.08	0.23	10.3			35.52	44.78	[390,391]
Matrimid® 5218:CMS (81:19)	S	35	Barrer			0.35	2.41	0.23	10.6			30.29	46.09	[390,391]
Matrimid® 5218:CMS (67:33)	S	35	Barrer			0.38	2.7	0.24	11.5			30.26	47.92	[390,391]
Matrimid® 5218:CMS (64:36)	S	35	Barrer			0.38	3	0.24	12.6			33.16	52.50	[390,391]
Matrimid® 5218:CMS (0:100)	S	35	Barrer			1.65	22	0.22	44			26.67	200.00	[390,391]
Ultem® 1000-Carbon molecular sieve (CMS)													
Ultem® 1000:CMS (100:0)	S	35	Barrer			0.052	0.38	0.037	1.45			27.88	39.19	[390,391]
Ultem® 1000:CMS (84:16)	S	35	Barrer			0.071	0.56	0.058	2.51			35.35	43.28	[390,391]
Ultem® 1000:CMS (80:20)	S	35	Barrer			0.09	0.71	0.06	2.9			26.67	48.33	[390,391]
Ultem® 1000:CMS (65:35)	S	35	Barrer			0.136	1.09	0.083	4.48			32.94	53.98	[390,391]
Ultem® 1000:CMS (0:100)	S	35	Barrer			1.65	22	0.22	44			26.67	200.00	[390,391]

* S: Data based on single gas experiments; M: Data based on mix-gas experiments; Barrer: 10^{-10} cm^3 (STP) cm cm^{-2} s^{-1} $cmHg^{-1}$; GPU: 10^{-6} cm^3 (STP) cm^{-2} s^{-1} $cmHg^{-1}$. To convert values in GPU into mol m^{-2} s^{-1} Pa^{-1}, multiply the value by 5.95 10^{-4}. Cells in gray show materials with preference of CO_2 over H_2.

Table 13. Trans-membrane flux (mmol/m^{2}s) for different capillary hollow fiber membrane contactors reported in the literature. The parameters reported include number, internal diameter, length and surface area of the fibers (i.e., No, d_i, L, a), concentration of absorbent (wt%), and feed temperature, pressure, concentration and flow (i.e., T_F, P_F, y_{CO2}, F_{CO2}).

Authors	Membrane					Solvent (Conc., loading[a])	Conditions					CO_2		Stability[b]
	Mat.	No	d_i mm	L cm	a m^2/m^3		T_F (^oC)	P_F (kPa)	y_{CO2} (%)[e]	V_L (cm/s)	F_{CO2} (SLPM)	Flux (mmol/m^2 s)	Eff. (%)	
[418]	PTFE	28	3.00	43.0	416	MEA(30wt%)	40	NA	1.5*	1.68	NA[c]	1.910	NA	NA
							40	NA	7.5*	1.68	NA	3.360	NA	
						MEA(30wt%, 0.150)	40	NA	1.0*	1.68	NA	1.180	NA	
							40	NA	9.0*	1.68	NA	2.450	NA	
						MEA(30wt%, 0.068)	40	NA	5.0*	0.84	NA	2.270	NA	
							40	NA	5.0*	3.37	NA	2.910	NA	
						MEA(30wt%, 0.043)	25	NA	5.0*	1.68	NA	3.180	NA	
							55	NA	5.0*	1.68	NA	2.000	NA	
[444]	PVDF	2050	0.83	52.0	1542	MEA(5wt%)+TEA(5wt%)	40	NA	11.0	0.90	2.200	0.580	99	+80 h
							40	NA	11.0	0.90	3.300	0.760	86	
							40	NA	11.0	2.70	2.750	0.730	100	
							40	NA	11.0	2.70	4.400	1.120	95	
[442]	PVDF	130	0.83	23.0	1391	Piperazine (PZ) (5wt%)	40	NA	20.0	0.47	0.010	0.100	100	<2 h
							40	NA	20.0	0.47	0.070	0.230	35	
						TEA(5wt%)	40	NA	20.0	0.47	0.070	0.670	100	
							40	NA	20.0	0.47	0.090	0.750	88	
						PZ(5wt%)+TEA(5wt%)	40	NA	20.0	0.47	0.080	0.760	100	+50 h
							40	NA	20.0	0.47	0.120	1.090	95	
[429]	PP	4900	0.60	10.0	924	Pure water	22	137.8	30.0	1.20	4.212	0.044	1	NA
							22	137.8	30.0	8.30	4.212	0.212	6	
							22	115.5	70.0	1.20	14.190	0.313	3	
							22	115.5	70.0	8.30	14.190	0.765	7	
	PP	400	0.60	10.0	471	Pure water	20	116.5	2.5	6.60	0.017	0.030	17	NA
							20	116.5	2.5	9.60	0.017	0.034	19	
							22	119.6	30.0	1.00	0.125	0.086	7	
							22	119.6	30.0	10.00	0.125	0.255	20	
							22	144.9	87.5	0.50	0.417	0.354	8	
							22	144.9	87.5	8.50	0.417	1.133	27	

Authors	Membrane					Solvent (Conc., loading[a])	Conditions					CO_2		Stability[b]
	Mat.	No	d_i mm	L cm	a m^2/m^3		T_F (°C)	P_F (kPa)	y_{CO2} (%)[e]	V_L (cm/s)	F_{CO2} (SLPM)	Flux (mmol/m^2 s)	Eff. (%)	
[443]	PVDF	139	0.83	23.0	1488	MEA(5wt%)	40	NA	25.0	0.27	0.110	0.530	55	NA
							40	NA	25.0	0.55	0.110	0.950	100	
	PTFE	70	1.00	23.0	1340	MEA(5wt%)	40	NA	25.0	0.36	0.045	0.450	66	NA
							40	NA	25.0	0.76	0.045	0.680	100	
[422]	PP	1	0.60	15.0	-	Propylene Carbonate	20	172.3	100.0	2.50	NA	1.700	NA	Short
							20	172.3	100.0	9.00	NA	3.000	NA	
							20	202.7	100.0	4.00	NA	2.700	NA	
							20	202.7	100.0	14.50	NA	4.200	NA	
	PP	1	0.60	13.0	-	Propylene Carbonate	25	425.6	100.0	0.50	NA	2.200	NA	
							25	425.6	100.0	9.50	NA	9.300	NA	
							25	810.6	100.0	2.00	NA	9.200	NA	
							25	810.6	100.0	8.50	NA	17.000	NA	
	PP	1	0.60	11.5	-	Propylene Carbonate	25	1013.3	100.0	1.50	NA	11.000	NA	
							25	1013.3	100.0	9.00	NA	24.000	NA	
	PP	1	0.60	13.5	-	Propylene Carbonate	25	1519.9	100.0	3.00	NA	20.000	NA	
							25	1519.9	100.0	12.00	NA	38.000	NA	
							25	2026.5	100.0	3.00	NA	25.000	NA	
							25	2026.5	100.0	13.00	NA	56.000	NA	
	PP	1	0.60	13.0	-	Propylene Carbonate	25	405.6	10.3	2.00	NA	0.500	NA	
							25	405.6	10.3	10.00	NA	0.950	NA	
							25	405.6	22.5	2.00	NA	1.000	NA	
							25	405.6	22.5	8.00	NA	2.050	NA	
							25	810.6	8.6	2.00	NA	0.800	NA	
							25	810.6	8.6	10.00	NA	1.500	NA	
[422]	PP	400	0.60	10.0	471	K_2CO_3 (0.25M)	24	101.3	32.6	1.00	14.90	0.540	NA	NA
							24	101.3	32.6	10.00	14.90	0.760	NA	
						K_2CO_3 (0.50M)	24	101.3	32.6	1.00	19.50	0.640	NA	
							24	101.3	32.6	10.00	19.50	0.920	NA	

[a] Loading is shown in some results and is evaluated as mol of CO_2 absorbed per mol of active absorbent (water excluded).
[b] NA: not available or cannot be elucidated from data provided.

Table 14. Typical molar fraction concentrations in each of the streams listed in Figures 4 to 14.

Process[a]	Stream	N_2	$_2$	H_2	CH_4	CO_2	CO	H_2S	SO_2	C2+	H_2O	Other Emissions[*]	Temp (^oC)	Press (atm)
1	**1**	76	5	-	-	16	<0.05	-	<0.05	-	8	NOX,Hg,VOC, HCl	1000	1
1	**2**	76	5	-	-	16	-	-	-	-	-	-	<100	1
2	**1**	<0.5	-	38	<0.3	19	42	-	-	-	<10	-	<100	20-60
2	**2**	<0.5	-	38	<0.3	19	42	-	<0.05	-	20	COS,CS_2	1000	20-80
3	**1**	<0.5	-	38	<0.3	19	42	-	-	-	<10	-	<100	20-60
3	**2**	<0.5	-	58	<0.3	40	<1	-	-	-	<10	-	<100	20-60
4	**1**	4	-	50	30	2	8	<1	-	2	55	VOC, PAH	1000	1
4	**2**	51	<1	5	<1	20	22	-	~	-	7	NOX,VOC	1000	1
4	**3**	10	-	2	-	15	70	-	-	-	-	VOC	1000	1
4	**4**	55	-	4	-	12	28	-	~	-	<1	NOX,VOC	1000	1
5	**1**	70	9	-	-	22	-	-	<1	-	13	NOX,VOC	1000	1
6	**1**	-	-	72	6	12	8	-	-	-	>70	-	1000	20-30
6	**2**	-	-	42	15	37	7	-	-	-	-	-	20-50	20-30
6	**3**	-	-	39	12	48	<1	-	-	-	-	-	20-50	20-30
6	**4**	-	-	-	-	>99	-	-	-	-	-	-	<100	1
7	**1**	4	-	-	91	<1*	-	<1*	-	6	-	COS,CS_2,HCN		>30
8	**1**	-	-	-	-	99	-	-	<0.5	-	-	PFCs,VOC	1000	1
8	**2**	-	-	-	-	-	99	-	~	-	-	-	1000	1
9	**1**	<0.5	-	-	-	36	-	60	<1.0	<2	-	COS,CS_2	<100	<1
9	**2**	75	-	<3	-	23	<2	<1	<0.5	<2	10	COS,CS_2		1
9	**3**	75	-	<3	-	23	<2	<0.05	-	<2	10	-	<100	1
10a	**1**	<10	<1	-	45	40	-	-	-	-	<5	VOC, Sx, Clx	20-40	1
10b	**1**	40	7	-	50	3					<5	<100		
11	**1**	-	-	-	-	>99.9	-	-	-	-	>0.1	-	<100	30-40

[a] Figure number in the text. Estimations based on dry basis. NO_X: NO_2<1 NO; VOC: volatile organic compounds; PAH: Polycyclic aromatic hydrocarbons; PFC: perfluorocarbons; Sx, Clx,: S- and Cl-bearing compounds.

Table 15. Typical capacities and gas flows for processes in Figures 4 to 14.

Process[a]		Capacities	Gas Production
1	1. Pulverized Coal Power Plant	-7.84 t Coal/MW power -10-1000 MW plants	0.4-0.5 MMscf gas /t coal
2-3	1. IGCC	-7.52 t Coal/MW power -300-4000 MW plants	0.060-0.065 MMscf CO_2/t coal
4	1.Coke Oven Battery: 10-105 ovens, usually > 45 ovens	-10-45 t coal/charge/oven -0.8 t coke/t coal -Coking time: 18-22 h -Battery capacities: 0.18-0.90 MMtpa	-9,500-11,500 scf gas/t coal
	2. Blast Furnace	-2,000-8,000 Mtpd of pig iron prod. -0.5 t Coke/t of pig iron prod.	-70,000-80,000 scf gas/t pig iron prod.
	3. Basic Oxygen Furnace	-1.00 -5.50 MMtpa steel prod.	-3,200 scf gas/t steel prod.
	4. Electric Arc Furnace	-0.60 -0.85 MMtpa steel prod.	-3,800 scf gas/t steel prod.
5	1. Kiln	-0.5-2.0 MMtpa per kiln	-1.0-1.2 t CO_2/t cement or lime -75,000-85,000 scf gas/t cement or lime
6	1. Hydrogen/Ammonia Plants	1-270 MMscfd H_2 (7.5-2000 Mtpd NH3)	1.5 t CO_2/t NH_3
7	1. Natural Gas Wells		-.05-2.5 MMscfd
8	1. Hall Heroult Process 1-3 potlines of 50-200 pots each	-66,000-110,000 Mtpa per potline	-1.83 t CO_2/t Al -33500 scf gas/t Al
9	1.Claus Process	3-4000 t Sulphur/day	-5-50 mol% SBC in gas steam
	2. Scot Process	0.3-400 t Sulphur/day	<1 mol% SBC in gas steam
10	1. Coal Bed Wells		-0.1-2.0 MMscfd
	2. Landfills	Sizes 1.0t -100MMt (average 3.8 MMt; 50% 1-10 MMt)	-220 scfa gas/t landfill -0.7-1.0 t landfill/person/year
11	1. Fermenter	-14-15 Ga ethanol/gal of batch fermenter -20 MGa-140 MGa ethanol/plant	-2.8 kg CO_2/gal ethanol -50 scf/gal ethanol

[a] Figure number in the text. Acronyms: Mtpa: metric tons per annum; MMtpa: million Mtpa; Mtpd: metric tons per day; Ga: gallons per annum, MGa: megagallons per annum; scf: standard cubic feet; MMscf: Million scf; scfd: scf per day; scfa: scf per annum; MW: Megawatt; SBC: sulfur bearing compounds.

Table 16. Largest IGCC and NGCC plants in the world as of January 2000.

Owner	Location	Technology	Output (MW_{th})*	Year Online	Feedstock	Products
Sasol-II	South Africa	Lurgi Dry Ash	4,130	1977	Subbit. coal	FT liquids
Sasol-III	South Africa	Lurgi Dry Ash	4,130	1982	Subbit. coal	FT liquids
Repsol/Iberdrola	Spain	GE Energy	1,654	2004a	Vac. Res	Electricity
Dakota Gasification Co.	U.S.	Lurgi Dry Ash	1,545	1984	Lignite & ref res	Syngas
SARLUX srl	Italy	GE Energy	1,067	2000b	Visbreaker res	Electricity & H2
Shell MDS	Malaysia	Shell	1,032	1993	Natural gas	Mid-distallates
Linde AG	Germany	Shell	984	1997	Visbreaker res	H2 & methanol
ISAB Energy	Italy	GE Energy	982	1999b	Asphalt	Electricity & H2
Sasol-1	South Africa	Lurgi Dry Ash	911	1955	Subbit. coal	FT
Total France/edf/GE Energy	France	GE Energy	895	2003a	Fuel oil	Electricity & H2
Shell Nederland	Netherlands	Shell	637	1997	Visbreaker res	Electricity & H2
SUV/EGT	Czech Republic	Lurgi Dry Ash	636	1996	Coal	Elec. & steam
Chinese Pet Corp	Taiwan	GE Energy	621	1984	Bitumen	H2 & CO
Hydro Agri Brunsbutt	Germany	Shell	615	1978	Hvy vac res	Ammonia
Global Energy	U.S.	E-gas	591	1995	Bit. coal/pet coke	Electricity
VEBA Chemie AG	Germany	Shell	588	1973	Vac. Res	Ammonia & methanol
Elcogas SA	Spain	PRENFLO	588	1997	Coal & pet coke	Electricity
Motiva Enterprises	U.S.	GE Energy	558	1999b	Fluid petcoke	Electricity
API Raffineria	Italy	GE Energy	496	1999b	Visbreaker res	Electricity
Chemopetrol	Czech Republic	Shell	492	1971	Vac. Res	Methanol & Ammonia
NUON	Netherlands	Shell	466	1994	Bit coal	Electricity
Tampa Electric	U.S.	GE Energy	455	1996	Coal	Electricity
Ultrafertil	Brazil	Shell	451	1979	Asphalt res	Ammonia
Shanghai Pacific Chem. Corp.	China	GE Energy	439	1995	Anthracite coal	Methanol & Town gas
Exxon USA	U.S.	GE Energy	436	2000b	Petcoke	Electricity & Syngas
Shanghai Pacific Chem. Corp.	China	IGT U-Gas	410	1994	Bit coal	Fuel gas & Town gas
Gujarat National Fertilizer	India	GE Energy	405	1982	Ref residue	Methanol & Ammonia
Esso Singapore	Singapore	GE Energy	364	2000	Residual oil	Electricity & H2
Quimigal Adubos	Portugal	Shell	328	1984	Vac. Res	Ammonia

[a] Plant was in advanced engineering at time of survey.
[b] Plant was under construction at time of survey.
* MW_{th} is a measure of syngas thermal energy.
Source: NETL/Gasification Technology Council, "Gasification: Worldwide Use and Acceptance," Jan. 2000, p. 7.

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Glossary

Å	Angstrom unit
BFLM	Bulk flow liquid membrane
BOF	Basic oxygen furnace
CARP	Carbothermic advanced reactor process
DEA	Diethanolamine
DGA	Diglycolamine
DIPA	Diisopropanolamine
EAF	Electric arc furnace
EOR	Enhanced oil recovery
FCM	Fixed carrier membrane
FTM	Facilitated transport membrane
HGCU	Hot gas cleanup unit
HTlc	Hydrotalcite
IEM	Ionic exchange membrane
IGCC	Integrated gasification combined cycle
ILM	Immobilized liquid membrane
MDEA	Methyldiethanolamine
MEA	Monoethanolamine
MMt	Million metric tons
NGCC	Natural gas combined cycle
PC	Pulverized coal
PDMS	Poly(dimethylsiloxane)
PEI	Polyethyleneimine
PSA	Pressure swing adsorption
Psig	Pounds per Square Inch Gauge
PTFE	Polytetrafluoroethylene
PTMSP	Poly(1-trimethylsilyl-1-propyne)
SCOT	Shell-Claus offgas treating
SERP	Sorption enhanced reaction processes
SMR	Steam methane reforming
SSF	Selective surface flow
TEA	Triethanolamine
TSA	Temperature swing adsorption
VOC	Volatile organic compound
WGS	Water gas shift reaction