



High Density Hydrogen Storage System Demonstration Using NaAlH_4 Complex Compound Hydrides

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Project ID #ST4

Merit Review

Arlington, VA

May 23-26, 2005

United Technologies Research Center

This presentation does not contain proprietary or confidential information

Overview

- **Timeline**

- 4/1/02 Start
- 9/30/06 End
- 60% Complete

- **Budget**

- \$3.8M Total Program
 - \$2.7M DoE
 - \$1.1M (27%) UTC
- \$0.5M DoE FY'04
- \$0.8M DoE FY'05

- **Barriers**

- Gravimetric Density: 2KWh/kg
- Volumetric Density: 1.5 kWh/l
- Charging rate: 1.5 kgH₂/min.
- Discharging rate: 4 gH₂/sec.
- Safety: Meets or exceeds applicable standards
- Durability: 1000 cycles

- **Partners**

- UTC Fuel Cells
- U. Hawaii
- HCI
- Albemarle
- QuesTek LLC
- Spencer Comp.



Objective

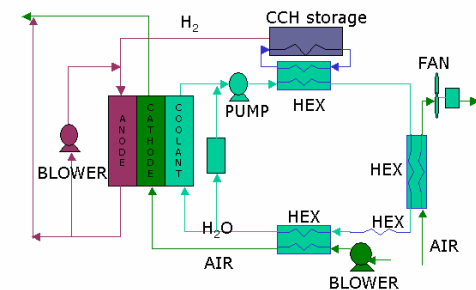
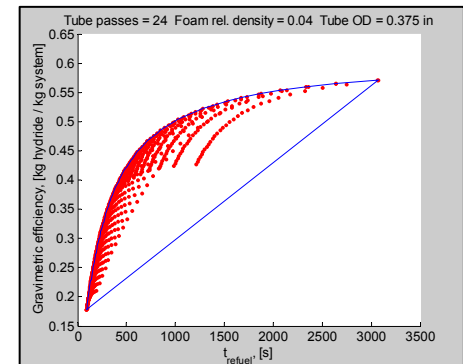
Design build and evaluate prototype low pressure hydrogen storage systems initially utilizing **catalyzed NaAlH₄**, but capable of being altered to use “**any**” reversible chemical hydride, having the higher gravimetric and/or volumetric hydrogen storage densities with minimal redesign.

- Assess the utility of combined **atomistic/thermodynamic modeling** in predicting the effectiveness of potential catalysts.
- **Characterize NaAlH₄** to obtain the highest performance composition and high volume media synthesis methods.
- Develop an understanding of the **safety testing** protocols and engineering design requirements for utilizing alanate materials.
- Develop, build & demonstrate an in-situ rechargeable **1 kg hydrogen storage system**.

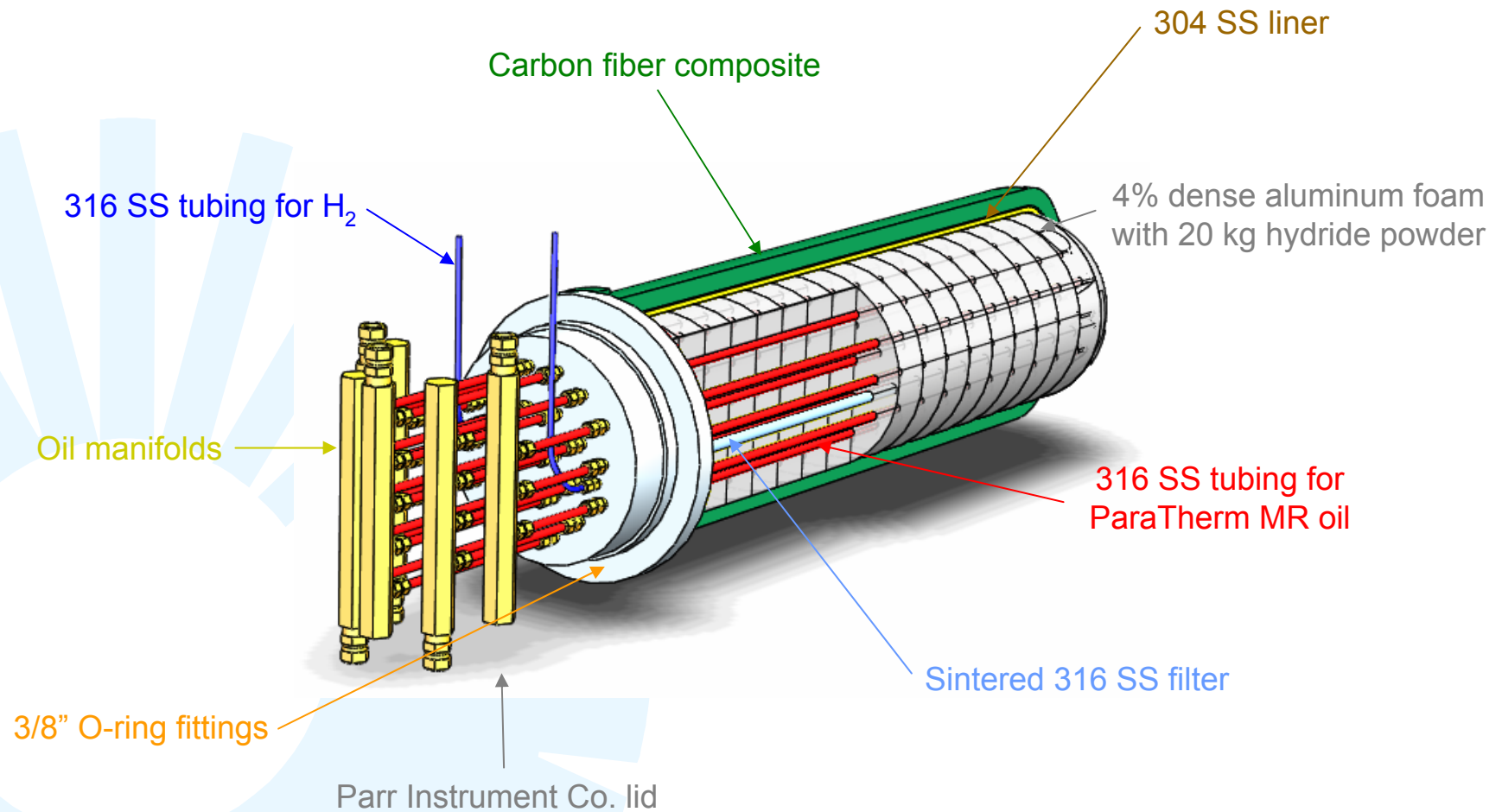
Approach

Concurrent System Design

- Identify **new technical challenges** including
 - Media packing
 - Media processing scale-up
 - Safety
 - Heat transfer specifics
- **Quantify system limits** for different system approaches. (ex. < 15 min refueling increasingly costly for in situ charging of NaAlH_4).
- Inform the materials community of system trade-offs to **guide selection of the best media** (effects of charging pressure, density, temperature span).
- **Time targets** – minimize the delay between materials and prototype development in the future.
- Examine fuel cell systems **integration issues**.



First Prototype Overview

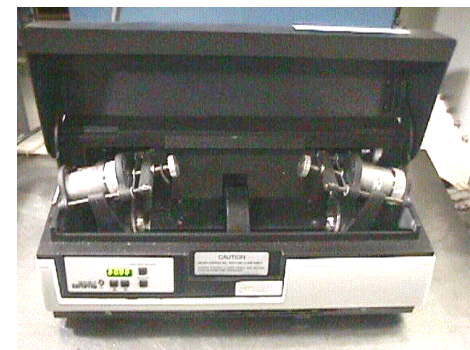


High Throughput Synthesis

Requirement: **30 kg** of catalyzed media

Process	Batch size	Frequency & g's	Time & temperature
SPEX Mill (SM)	0.005 kg	16 Hz 40 g	3 hrs 57 C
Tumble Mill (TM)	2 x 0.5 kg	1 Hz 1 g	24 hrs 23 C
Power Mill (PM)	0.5 kg	10 Hz 15 g	1 hr 40 C

SPEX Mill



Tumble Mill



30 kg Catalyzed NaAlH_4



- Initial tests showed similar kinetics for PM TiF_3 and SM TiCl_3 .
- Subsequent tests indicated batch-to-batch variation for PM processing with kinetics between 60% and 90% of small scale processing.
- Scale-up media processing is challenging to obtain both high throughput processing and high kinetics.

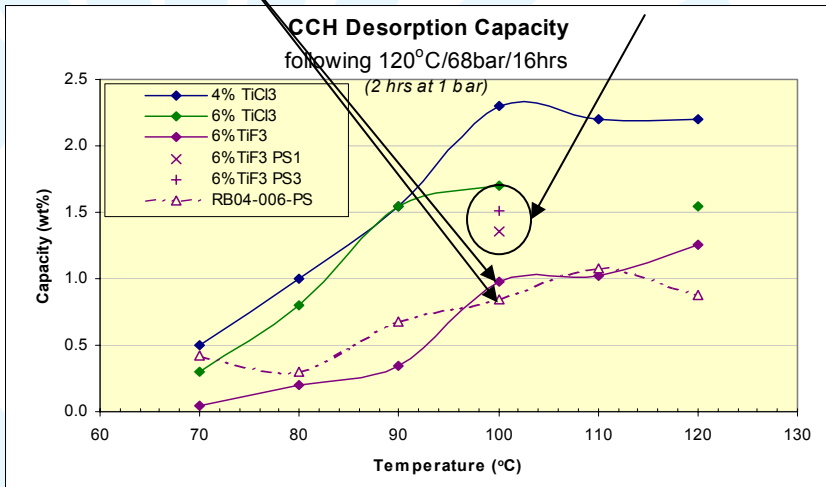
Media Quality Evaluations

- Media composition commercially pure NaAlH_4 supplied by Albemarle & catalyzed with 6m/o TiF_3
- Large batch processing results in significantly lowered kinetics due to lowered mechanico-chemical reaction as a result of lower kinetic energy pre mass input.
- Batch-to-batch variation in kinetics is significant and needs to be closely monitored and controlled.
- System performance will be base-lined with reference to known compound kinetics.**

Kinetic Analysis Quality Assurance

Subsequent Batch Analysis

Initial batch trials using high volume attrition unit.



Compositional Analysis Quality Assurance by XRD

Large Quantity Processing NaAlH_4 + 6m% TiF_3 Batch Check XRD Results

TM Tumble Mill 20 hrs
PSX Paint Shake X hrs.

Charged 120C/68bar/16hr
Discharged 120C/1bar/20hr

XRD Results (mol%)

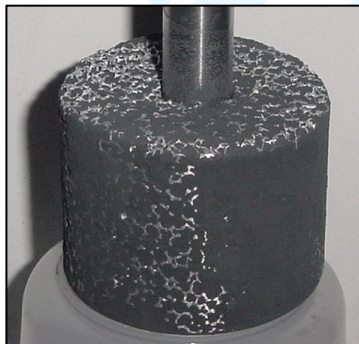
Batch ID	NaAlH_4	$\alpha\text{-Na}_3\text{AlH}_6$	$\beta\text{-Na}_3\text{AlH}_6$	NaH	Al	TiF_3	NaF	AlH_3	Condition
Tumble Milled									
RB04-006	63.4	0.0	1.9		34.6	0.2			TM
RB04-007	75.1	0.0	1.9		23.1	0.0			TM
RB04-008	70.7	0.0	23.0		26.9	0.2			TM
RB04-026	52.3	0.0	5.8		41.9	0.3			TM
RB04-030	71.9	1.0	2.0		25.1	1.0			TM
RB04-033	70.5	0.0	1.9		25.6	2.0			TM
RB04-049	72.3	1.4	0.9		22.8	2.7			TM
average	68.0	0.3	5.3		28.6	0.9			
Paint Shaken									
RB04-006	22.6	2.0	15.4		59.9	0.1			TM+Chg+DChg
RB04-007	28.1	1.5	13.7		57.6	0.1			TM+Chg+DChg
RB04-008	37.1	0.0	29.2		25.6	1.2		2.1	TM+Chg+DChg
RB04-026									
RB04-030	34.3	0.0	14.5		51.1	0.1			TM+Chg+DChg
RB04-033	45.0	0.0	8.3		46.7	0.04			TM+Chg+DChg
RB04-049									
average	33.4	0.7	16.2		48.2	0.3		0.4	

Media Densification Screening Tests

Initial estimate

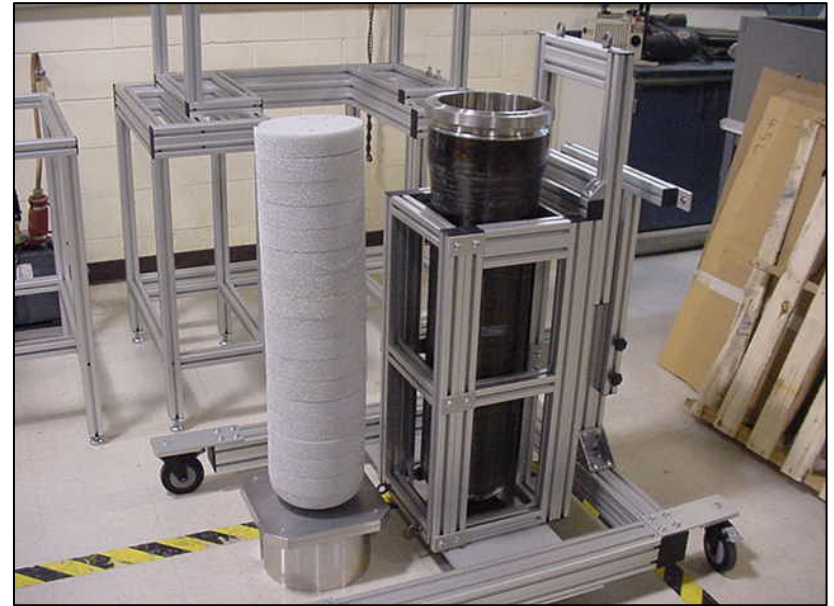
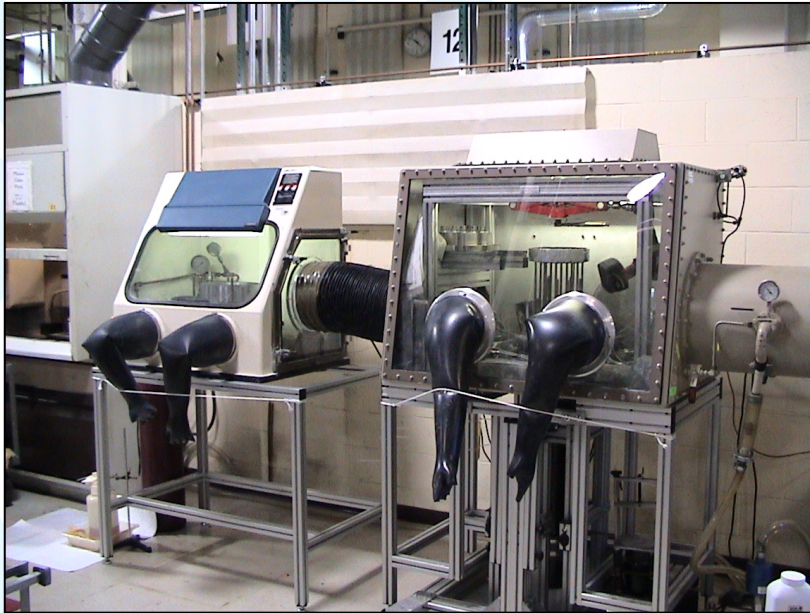
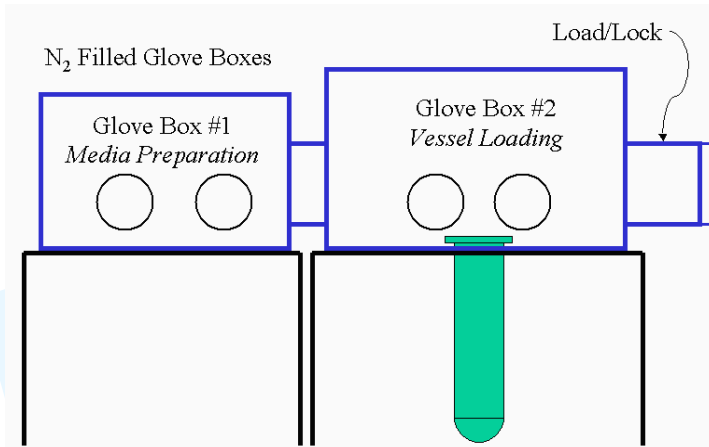
Method	g/cc	Scale up	Kinetics
M1	0.44 to 0.80	Moderate	Good
M2	0.97 to 1.07	Poor	Good
M3	0.44	Poor	Moderate to Good
M4	0.92	Good	Poor
M5	0.6 to 0.75	Good	Good

All experiments with aluminum foam



- Densification method M5 was initially chosen to be scaled up for construction of the first prototype.
- Method of densification changed to M1 after scale up issues of M5 posed significant schedule delay.

Assembly Approach & Hardware

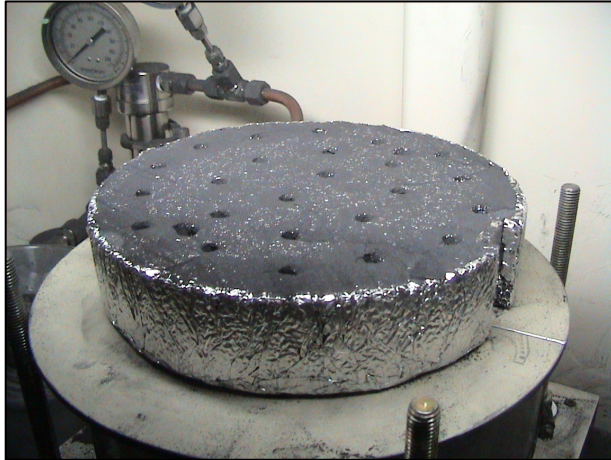


Significant resources were invested in assuring a safe & clean environment for system loading

Powder Loading & Disk Installation

Foam disks filled with hydride

1



Move to assembly glove box

2



Alignment of disk with tubes

3



Press fit disk into vessel

4



System Loading Results

Bottom two sections

- installed empty
- filled by shaking the entire vessel.

$$\rho \approx 0.35 \text{ g/cc}$$

Nominal 1" gap present due to disk binding

Scaled-up M5 approach

$$\rho \approx 0.4 \text{ g/cc}$$

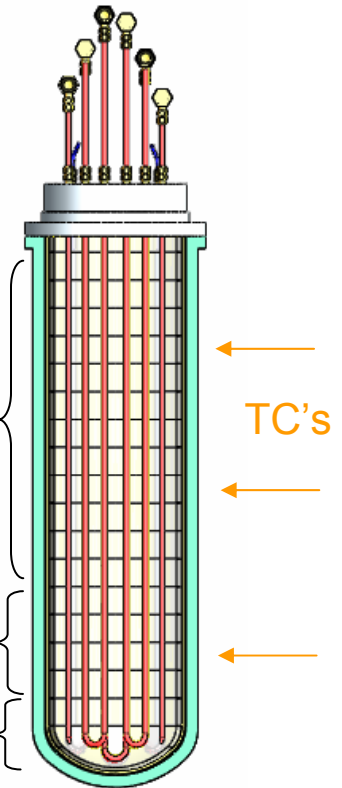
Modified M1 method developed

$$0.4 \text{ g/cc} > \rho > 0.6 \text{ g/cc}$$

Entire vessel

- 19 kg of hydride
- Average hydride density = 0.44 g/cc

12 internal thermocouples installed in **three disks**



Powder loading in an inert environment is challenging with overall density of 0.44g/cc (35% ρ_{th}) achieved.

Densification will be examined at full scale for 2nd prototype.

Component Masses

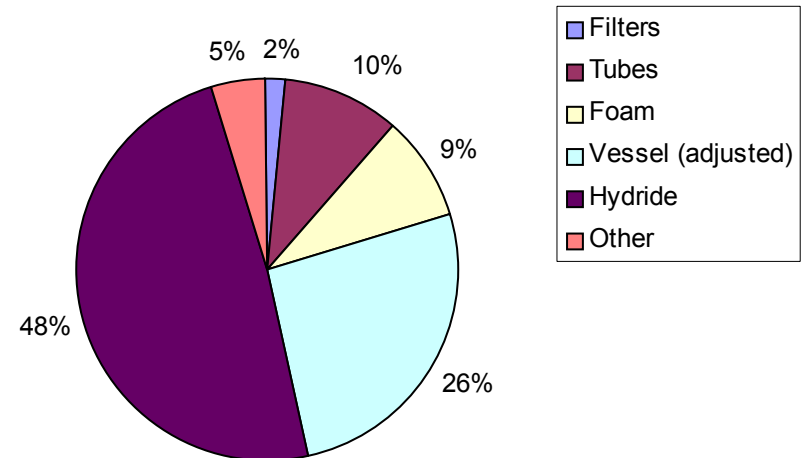
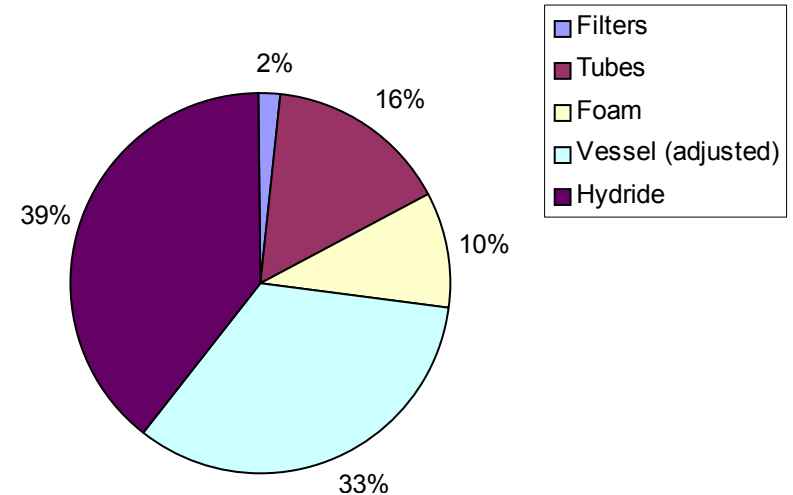
Actual & Projected

Actual storage tank

- 19 kg hydride in system
- 0.44 g/cc average hydride density
- 0.60 g/cc peak hydride density for disk
- 100 atm vessel
- Assumes hemispherical domed end

Projected storage tank

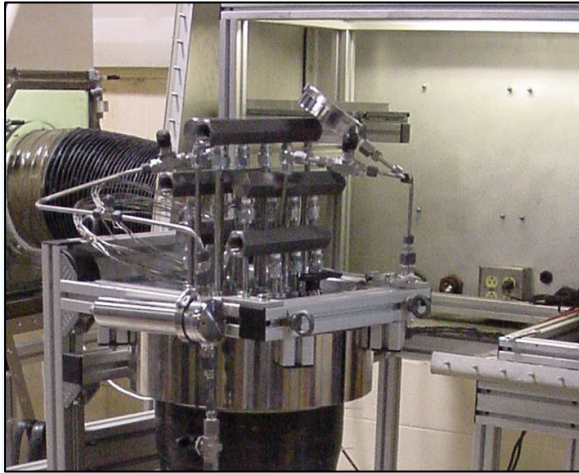
- Eliminate tubing excess Factor of Safety
- Eliminate vessel excess Factor of Safety
- Apply best settled density of 0.6 g/cc for entire vessel resulting in 26 kg hydride
- Add oil, insulation, supports, ...
- Gravimetric efficiency of 48%



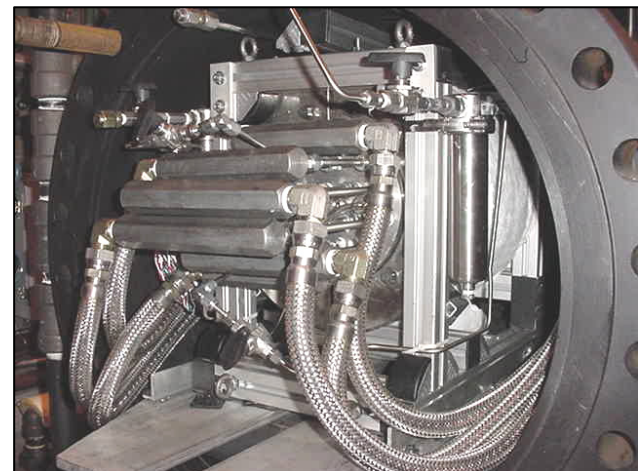
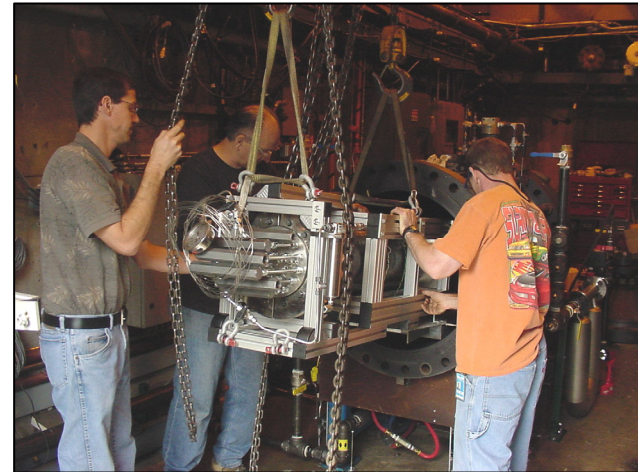
Gravimetric engineering efficiency, E_g of ~50% achieved.

Final Assembly and Installation

Final assembly of manifold
Transport to test cell



Application of external insulation
Installation into containment

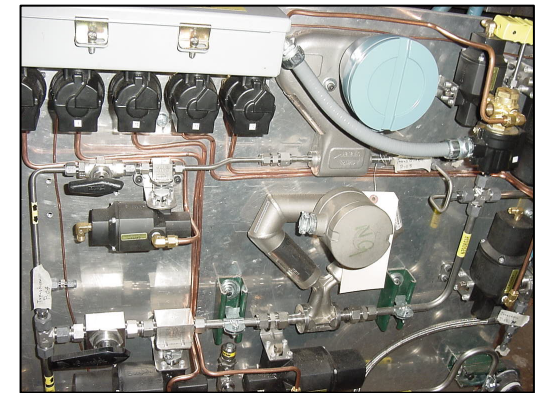
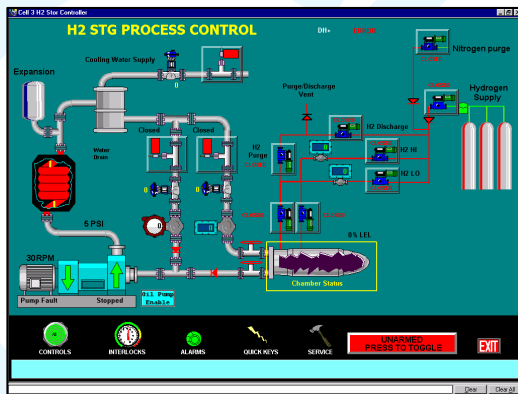


Evaluation System Development

Features

- 12kW electric oil heater
- Oil/water HX oil cooler
- 100gpm max variable speed, 650F, 350 psi oil pump & sealed reticulating system
- Secondary containment with inert gas blanket and H₂ monitor.
- Two range H₂ mass flow measurement
- 12 vessel & 15 system type K TC's
- 2 vessel and 4 system 2000psi pressure transducers.
- 6 strain gages
- Data acquisition at 1-100 Hz
- Automated control software with fail safe shut down.

Significant resources were invested in system evaluation facilities assuring: accurate, controlled, safe and cost effective evaluation.



CCHSS#1 Evaluation Results

Charging

- Std. discharge: 150°C/vac./24hrs.
- 70 and 100 bar charging (24 hrs):
 - 80 °C ✓
 - 100 °C ✓
 - 120 °C

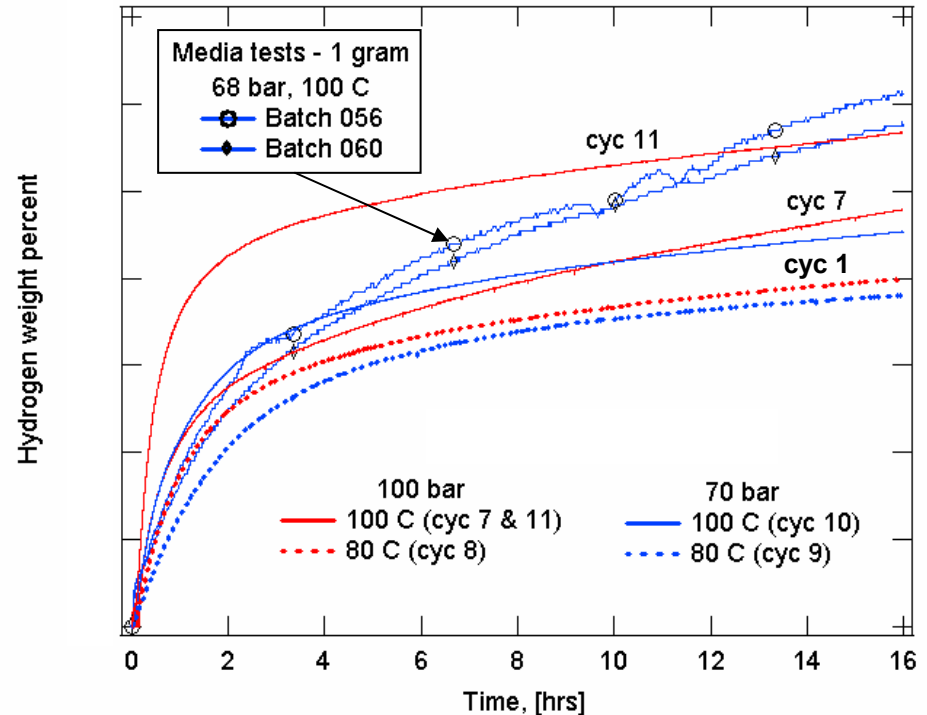
Discharging

- Std. charge: 100°C/100bar/24hr
- 2 bar discharging (24 hrs)
 - 80 °C
 - 90 °C ✓
 - 100 °C ✓
 - 110 °C

Control Dynamics

- Optimum charging

CCHSS#1 Charging Tests



- Initial absorption data are consistent with 1 gram tests for scaled up media processing.
- Prototype fabrication & testing have had little effect on kinetics.
- Kinetics and capacity are improving with cycling probably due to increased homogenization of Ti^{+3} catalyst

Future Work

Second Prototype

Address challenges for realizing a prototype system with low weight hemi-spherical end closure having small boss port and improved gravimetrics:

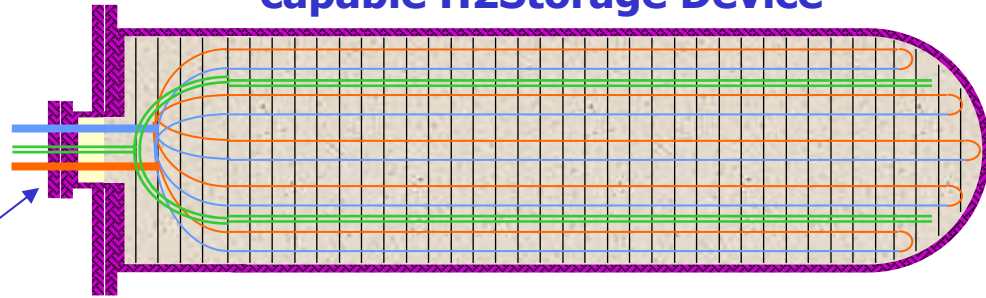
- Improved media composition, 4wt. %
- Improved media synthesis method
- New media filling method to obtain $\rho > .6 \text{ g/cc}$
- Advanced tube/fin HX
- Internal manifold

Modify new lid to mimic opening of boss port composite vessel domed end

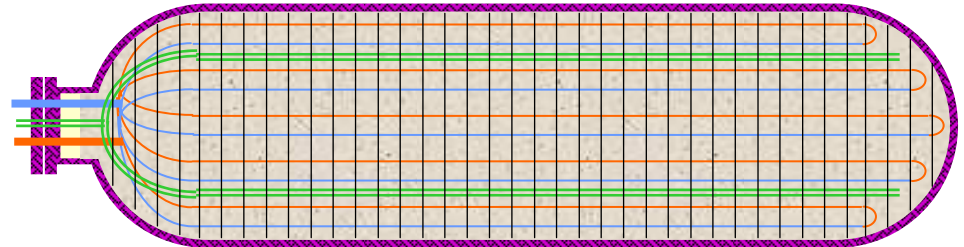
Methods and design will allow media to be loaded into system with **prefabricated HX** through **reduced diameter opening** and be applicable to **other media**.

Approach will simplify fabrication logistics allowing emphasis on critical technologies.

Intermediate 100 bar capable H2Storage Device



Ultimate 100 bar capable H2Storage Device

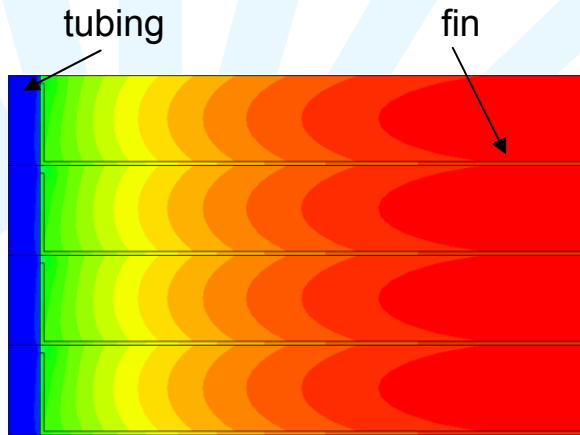


Second Prototype Finned HX

Advantages of finned HX over aluminum foam

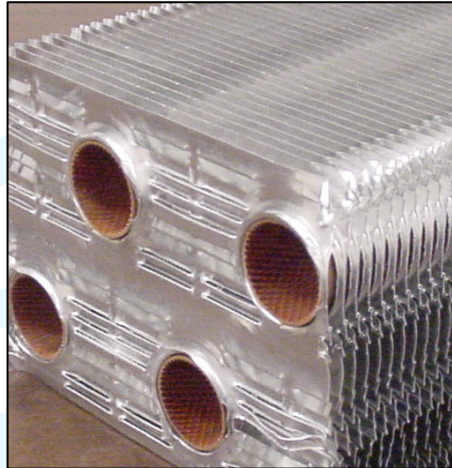
- Improved long range heat transport (up to 3X better)
- Lower cost for mass production
- More adaptable to a variety of powder loading methods

Automated ABAQUS
2D simulation



Simulated temperature contours
during charging

Conventional Tube/Fin
Heat Exchanger



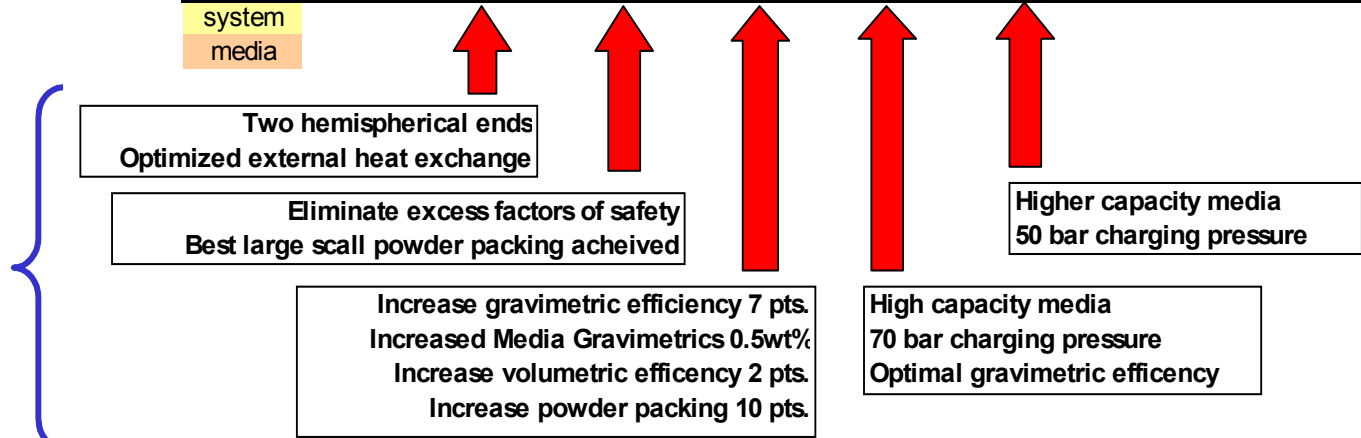
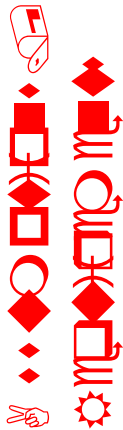
Perform initial development on
subscale 4" diameter fins



Replace with fin stack

System Projections

	Symbol	units	system #1	system #1.1	system #2	system #2P	system #2PP	DoE		
			CCHSS#1 6%TIF3	CCHSS#1.1 6%TIF3	CCHSS#2			2007 Goal	2010 Goal	2015 Goal
Media Density	ρ^m	g/cm^3	1.51	1.51	1.51	1.51	1.51			
Media Gravimetric Density	ρ_g^m	wt%	0.035	0.035	0.04	0.065	0.075			
Media Volumetric Density	ρ_v^m	kgH_2/m^3	52.9	52.9	60.4	98.2	113.3			
System Gravimetric Density	ρ_g^s	wt%	1.4%	1.7%	2.2%	4.5%	6.0%	4.5%	6.0%	9.0%
	ρ_g^s	kWh/kg	0.5	0.6	0.7	1.5	2.0	1.5	2.0	3.0
System Volumetric Density	ρ_v^s	kgH_2/m^3	11.7	17.2	24.3	46	53	36	45	81
	ρ_v^s	kWh/l	0.39	0.57	0.81	1.53	1.77	1.2	1.5	2.7
Gravimetric Engineering Efficiency	E_f^g		0.39	0.48	0.55	0.69	0.80			
Volumetric Engineering Efficiency	E_f^v		0.65	0.65	0.67	0.67	0.67			
Powder Packing density	ρ_p^m		0.34	0.5	0.6	0.7	0.7			



Previous Year's Comments

- **Comment**

“How to design a system such that it can be used with other metal hydrides?”

With input of the heats of formation and chemical kinetics, maximum thermal loads are established which, through FEM and convex hull system optimization methods, guide heat exchanger design.

- **Comment**

“Why are the results of the system level modeling sensitive IP?”

The system level modeling utilized actual weights, volumes and performance metrics from the UTFuelCells Mercury Program, all of which are company owned and proprietary. Additionally, UTC is paying 27% cost share of the effort and a commercial rights agreement to all findings is in place with DoE.

- **Comment**

“Alanes probably have limits and may never make DoE goals.”

NaAlH₄ alone will certainly never be able to meet the DoE 2010 and 2015 gravimetric goals, but it is anticipated that other systems, similar in chemistry and kinetics, will be discovered to meet these challenging requirements. By designing and fabricating a working system early in the technology development cycle, other less transparent technical barriers such as high volume media synthesis, media densification and long range heat transfer issues can be addressed. This should considerably shorten the design cycle allowing introduction of these new materials with minimal re-engineering.

A light blue sunburst graphic is positioned on the left side of the slide. It features a central white circle with several light blue rays extending outwards, creating a semi-circular fan shape.

Supplemental Slides

Publications

Articles

- C. Qiu, S. M. Opalka, G. B. Olson, and D. L. Anton, "The Na-H System: from First Principles Calculations to Thermodynamic Modeling," to be submitted to Phys. Rev. B.
- O. M. Lovvik and S. M. Opalka, "First-principles calculations of Ti-enhanced NaAlH₄," Phys. Rev. B 71 054103-1-10 (2005).
- C. Qiu, G. B. Olson, S. M. Opalka and D. L. Anton, "A Thermodynamic Evaluation of the Al-H System," J. of Phase Equilibria and Diffusion 25(6) 520-527 (2004).
- D.L. Anton, "Hydrogen Desorption Kinetics in Transition Metal Modified NaAlH₄," J. Alloys and Compounds, 356-357, pp.400-4 (2003).
- S. M. Opalka and D. L. Anton, "First Principles Study of Sodium-Aluminum-Hydrogen Phases," J. of Alloys and Compounds 356-357 486-489 (2003).

Presentations

- Xia Tang, D. A. Mosher and D. L. Anton, "Practical Sorption Kinetics of TiCl₃ Doped NaAlH₄" Materials Research Society Spring Meeting, San Francisco, California, March 28 to April 1, 2005.
- D. A. Mosher and D. L. Anton, "Beyond Weight Percent – The Influence of Material Characteristics on Hydrogen Storage System Performance," Materials Research Society Spring Meeting, San Francisco, California, March 28 to April 1, 2005.
- C. Qiu, S. M. Opalka, D. L. Anton, G. B. Olson, "Thermodynamic Modeling of Sodium Alanates," Materials Science & Technology 2005 to be held in Pittsburgh, PA, on September 25-28, 2005.
- O. M. Løvvik and S. M. Opalka, "First-principles calculations of Ti-enhanced NaAlH₄," Presentation at the International Symposium of Metal Hydrogen Systems (MH2004), Krakow, Poland, September 10, 2004.
- S. M. Opalka and O. M. Lovvik, "Bulk Hydrogen Diffusion within Undoped and Titanium-Doped Sodium Alanate," and O. M. Lovvik and S.M. Opalka, "Calculation of hydrogen mobility near the surface of doped and undoped NaAlH₄,"
- S. M. Opalka and D. L. Anton, "First principles study of sodium-aluminum-hydrogen," International Symposium On Metal Hydrogen Systems MH2002, Annecy, France, September 2-6, 2002.

Safety

Risk Identification

Burn Rate Test

Partially Discharged CCH#0-33

13.11
0

16.08
2.97

20.01
6.90

24.20
11.09

United Technologies

Water Immersion Test

Partially Discharged CCH#0-33

4.12
0

4.23
.11

4.24
.12

4.27

United Technologies

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Water Injection

Partially Discharged CCH#0-33

31.06
0

31.20
0.14

31.23
0.17

1:01.09
30.03

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Fire risk
quantitatively
assessed

Dust Explosion Testing

Dust explosion: class St-3, Highly Explosive when finely divided and dispersed.

	Test Materials		Reference Materials	
	NaAlH ₄	NaH+Al	Pitt. Seam Coal Dust	Lycopodium Spores
P _{max} bar-g	11.9	8.9	7.3	7.4
R _{max} bar/s	3202	1200	426	511
K _{st} bar-m/s	869	326	124	139
Dust Class	St-3	St-3	St-1	St-1
MEC g/m ³	140	90	65	30
MIE mJ	<7	<7	110	17
T _c °C	137.5	137.5	584	430

P_{max} = maximum explosion pressure, R_{max} = pressure rise maximum, K_{st} = maximum scaled rate of pressure rise, MEC = minimum explosive concentration, MIE = minimum spark ignition energy, T_c = maximum dust cloud ignition temperature

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17

Explosion risks
quantitatively
assessed

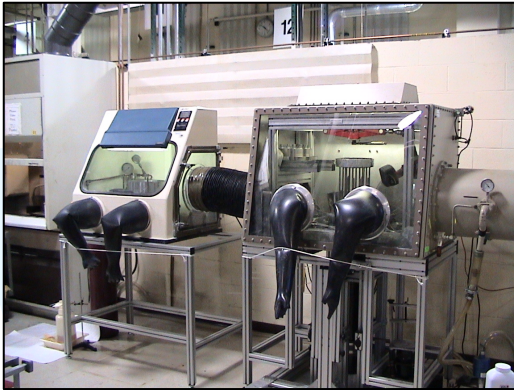
Appendix V- UTRC Risk Assessment Form

Date	Room Number	Participants					
5/4/04	S145H	Tom Ververis, Xia Fang, Ron Brown, Jodi Vecchiarelli					
No	Process, Task or Step	Potential hazard	Controls in Place	Likelihood Occurrence	Potential Impact	Risk Rank	Controls Required To reduce risk further/Name/Date
1	Mixing Powder Media Preparation	Fire, Explosion	All work is done in glovebox filled with Nitrogen Containers inside glove box sealed Gloves inspected every day Nitrogen pressure checked every day Moisture and O2 sensor in glovebox Positive pressure maintained in glove box	2	3	6 Med	
2	Hydrogen Storage Running Test	Failure of High Pressure Systems Fire, Explosion	Risk assessments Local rules and procedures Pressure rated components Pressure relief valves Automatic controllers; Redundant valves Detailed Procedures; Employee training Critical valve Maintenance Remote gas line shutoff and purge if loss of power or ventilation All test stands in hoods All equipment leak tested (H2 sniffer) Flash arrestor Moisture filters	2	3	6 Med	Lower Pressure
3	Hydrogen Storage, Running Test	High Temp. Oil Bath Burns, Oil spill	Warning sign "Hot Oil" Secondary containment Redesignated Jack stand guard in place Located in hood.	2	2	4 Low	
4	Vacuum System (Hydrogen), Running Test	Explosion	Special Hydrogen Vac. Pumps Sparkless	2	3	6 Med	
5	Working in glovebox	Ergonomic pain	Limited time in glovebox to 45 minutes max. Set up to avoid awkward reaching	2	2	4 Low	
6	Lifting, transporting samples	Ergonomics	Training, procedures Weight kept to < 30 pounds	2	2	4 Low	

Comprehensive risk
assessment performed on all
major operations

Safety

Risk Mitigation



System loaded in inert gas



Media handled & stored under inert gas



System tested remotely

All risks reduced to low impact or negligible probability



Incoming material stored in fire cabinet



System housed and tested in secondary containment under inert gas