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(54) **FLUID SEPARATION ASSEMBLY AND FLUID SEPARATION MODULE**

is a continuation-in-part of application No. 09/422,505, filed on Oct. 21, 1999, now Pat. No. 6,602,325.

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(52) **U.S. Cl.** ..... **95/55; 96/9**

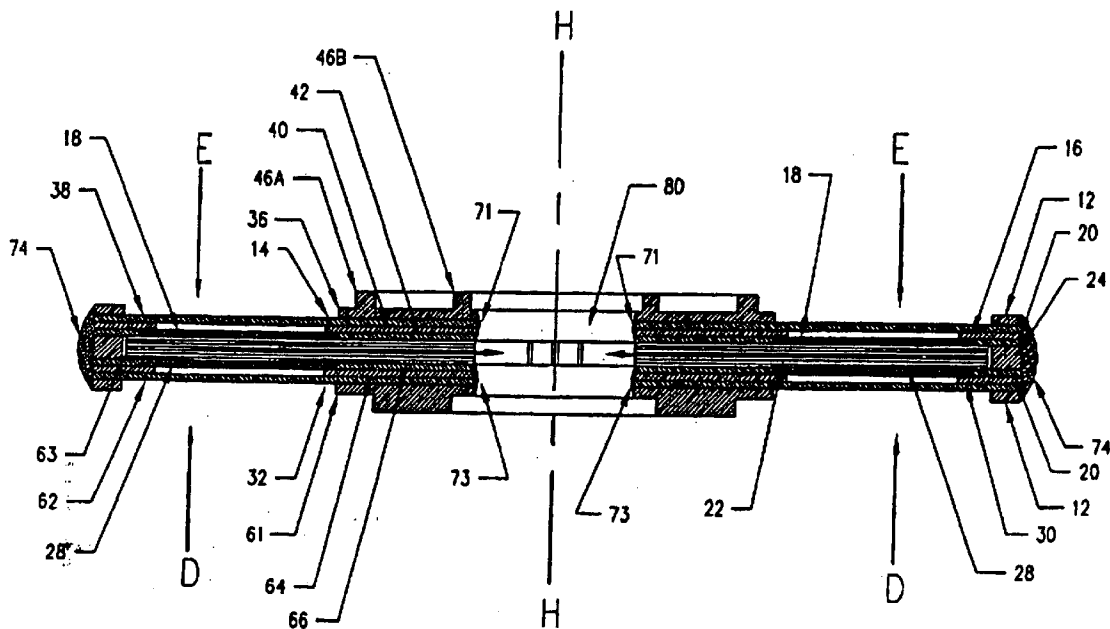
(57) **ABSTRACT**

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(86) PCT No.: **PCT/US01/12467**

A fluid separation assembly (10) having a fluid permeable membrane (38 and 62) and a wire mesh membrane (18 and 28) adjacent the fluid permeable membrane (38 and 62), wherein the wire mesh membrane (18 and 28) supports the fluid permeable membrane (38 and 62) and is coated with an intermetallic diffusion barrier. The barrier may be a thin film containing at least one of a nitride, oxide, boride, silicide, carbide and aluminide. Several groups of multiple fluid separation assemblies (104) can be used in a module (85) to separate hydrogen from a gas mixture containing hydrogen.

**Related U.S. Application Data**

(63) Continuation-in-part of application No. 09/560,314, filed on Apr. 27, 2000, now Pat. No. 6,419,726, which



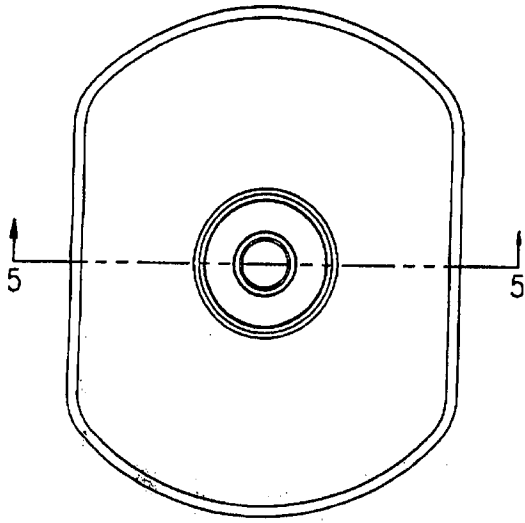


Fig. 1b

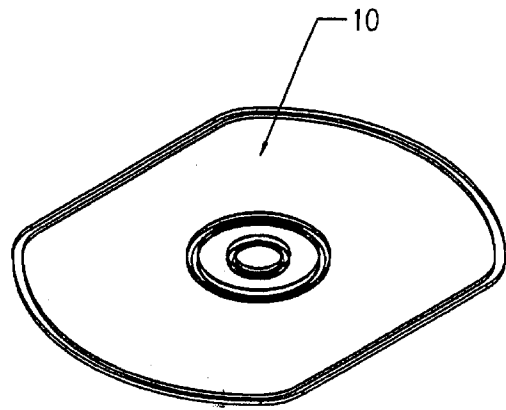


Fig. 1a



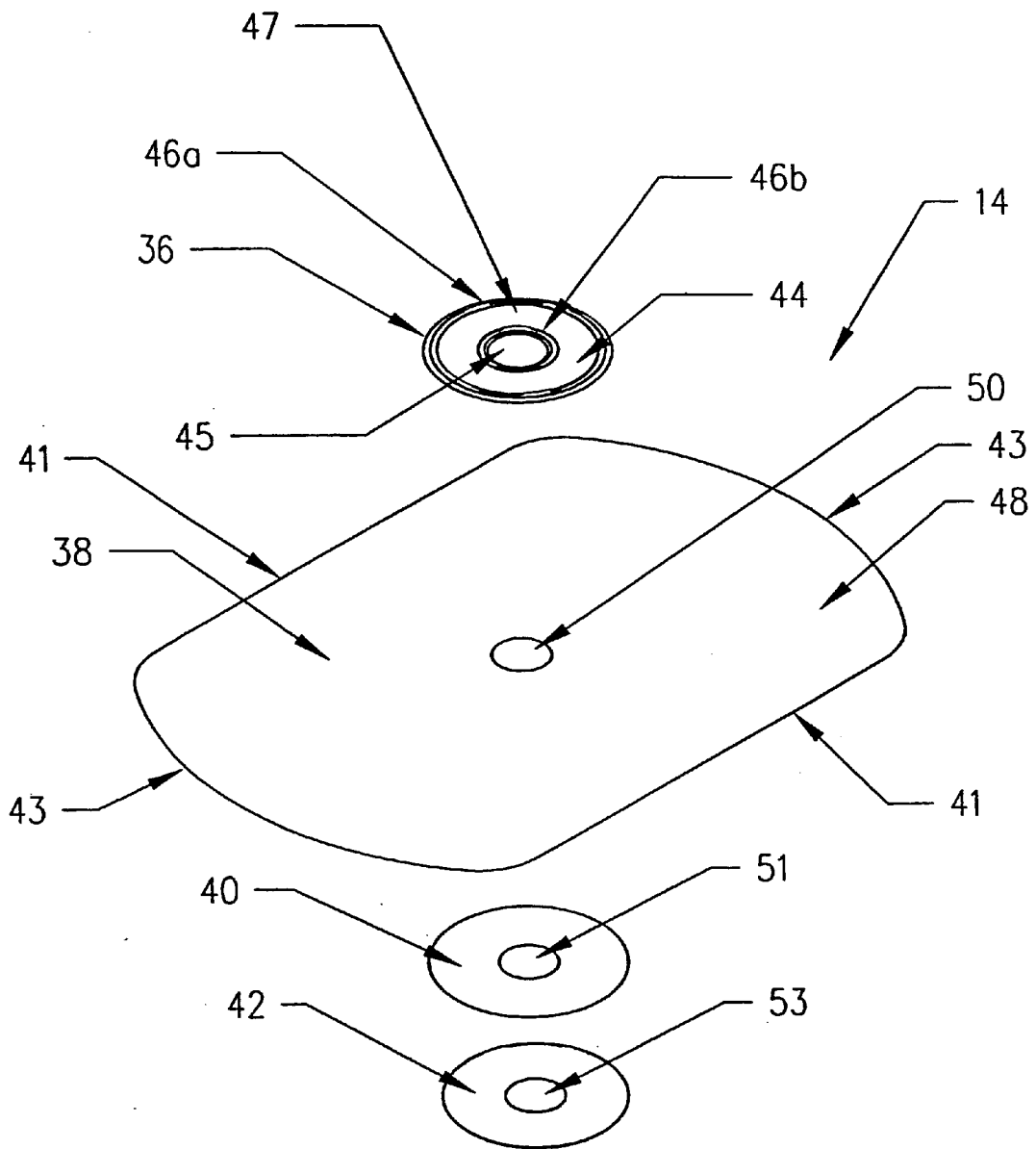


Figure 3

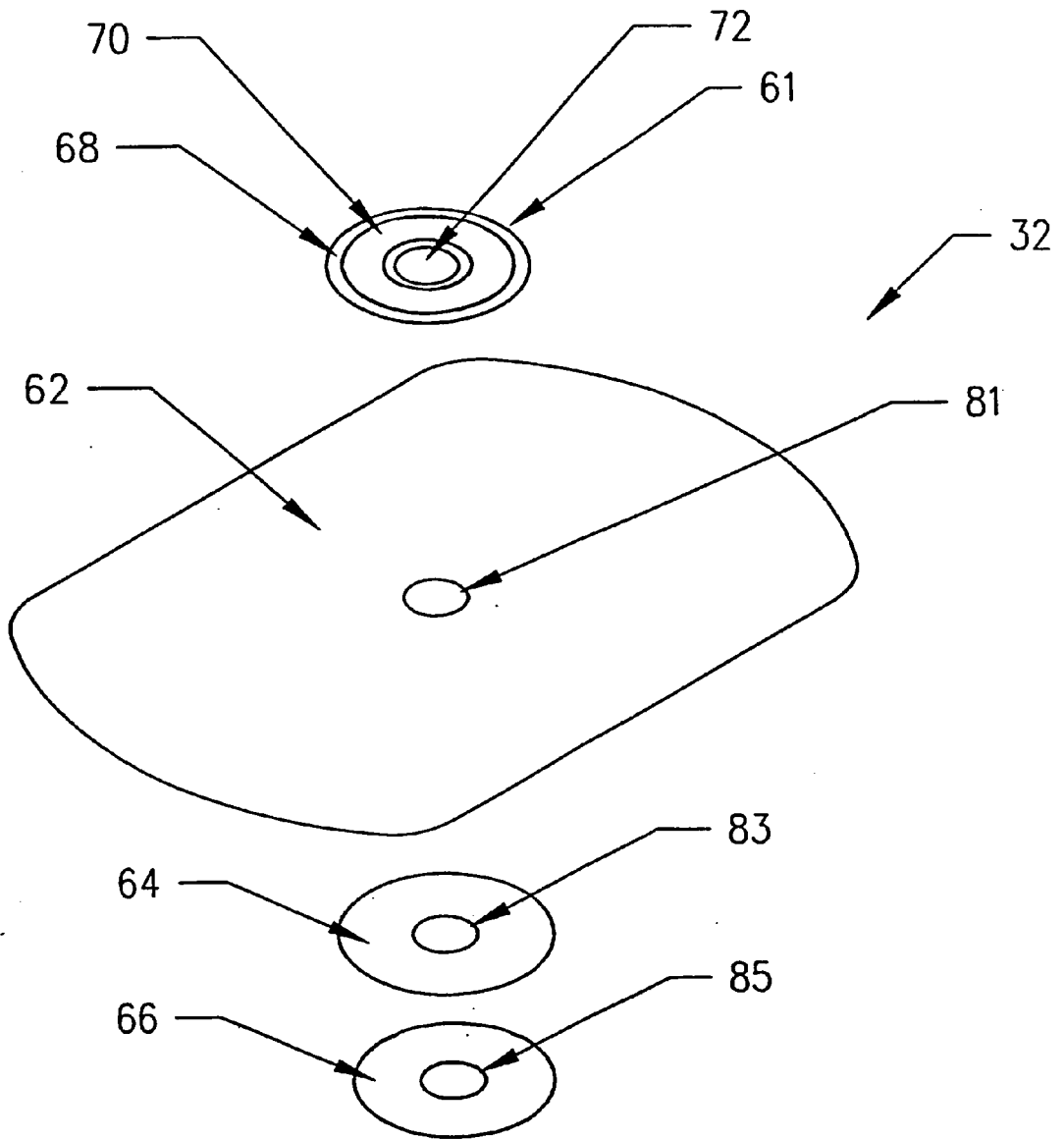
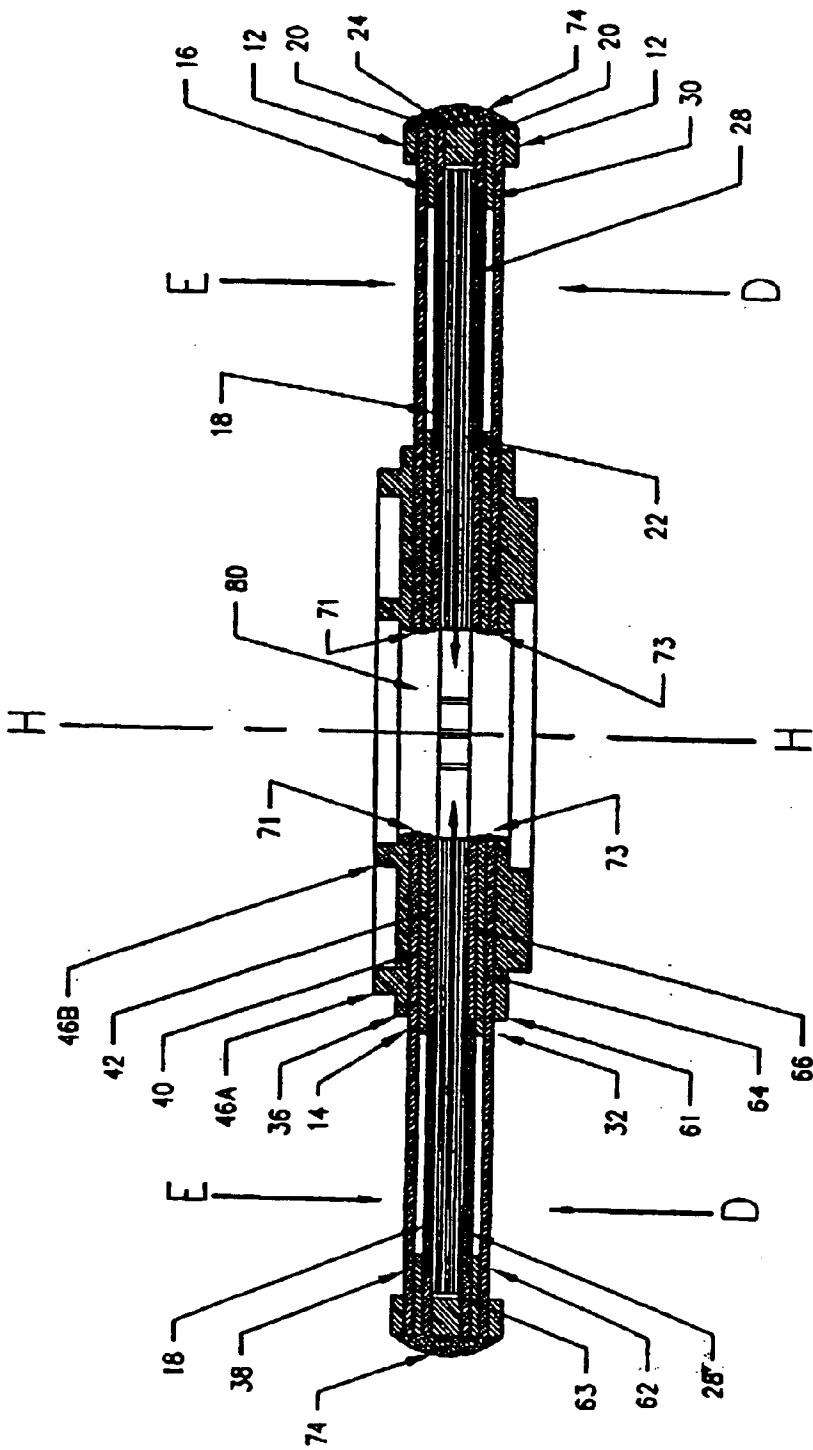


Figure 4



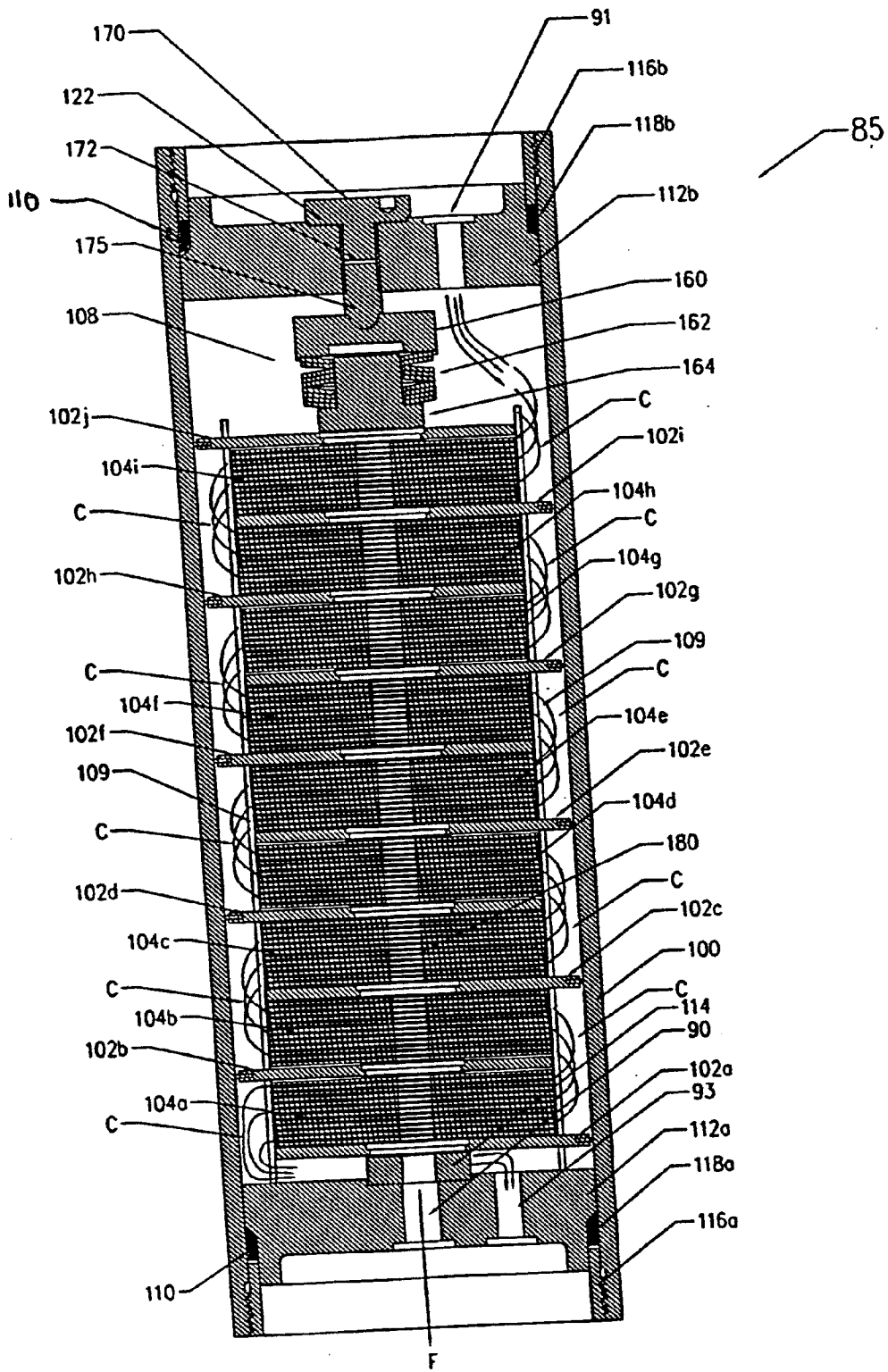


FIG. 6

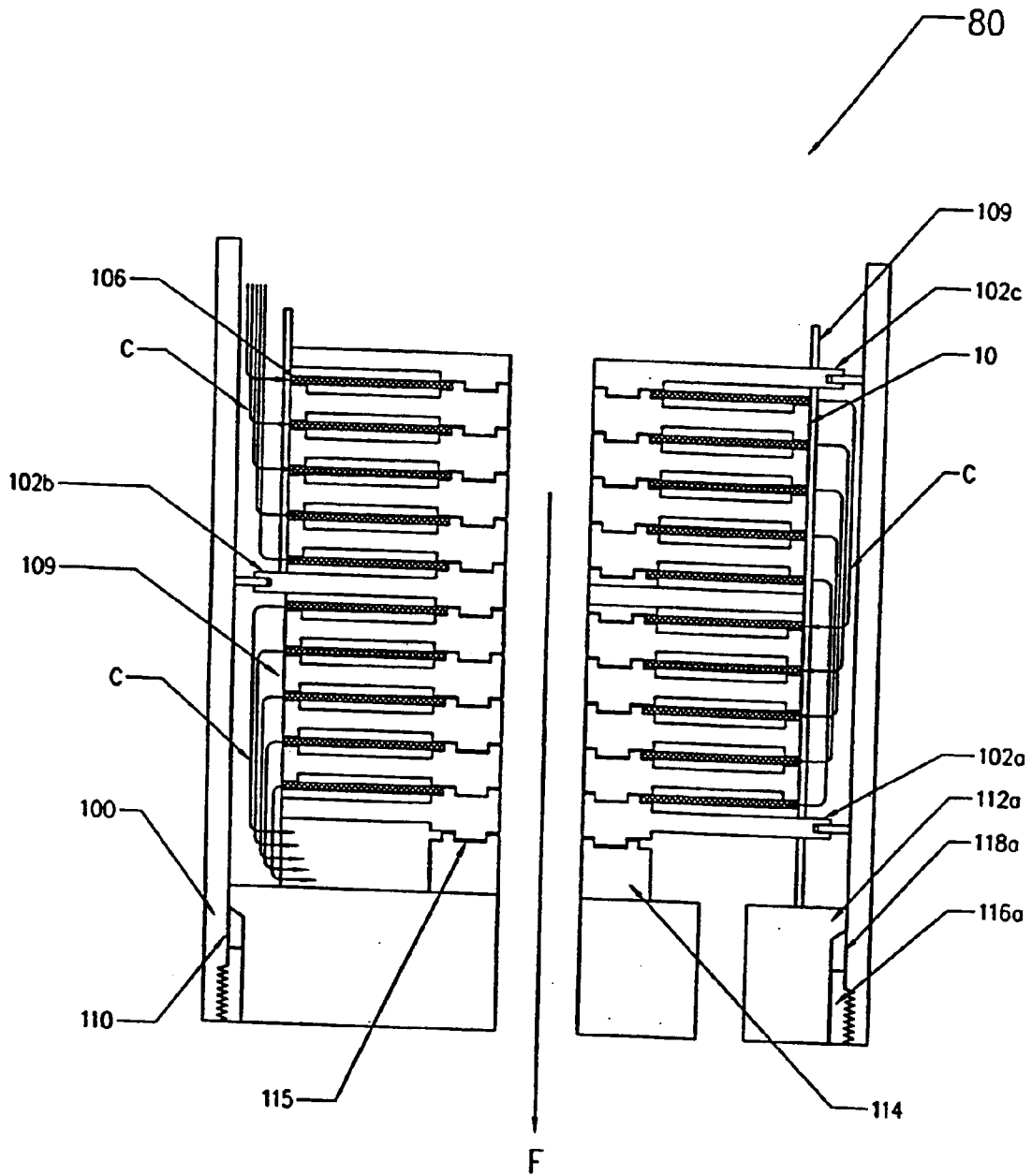


FIG. 7



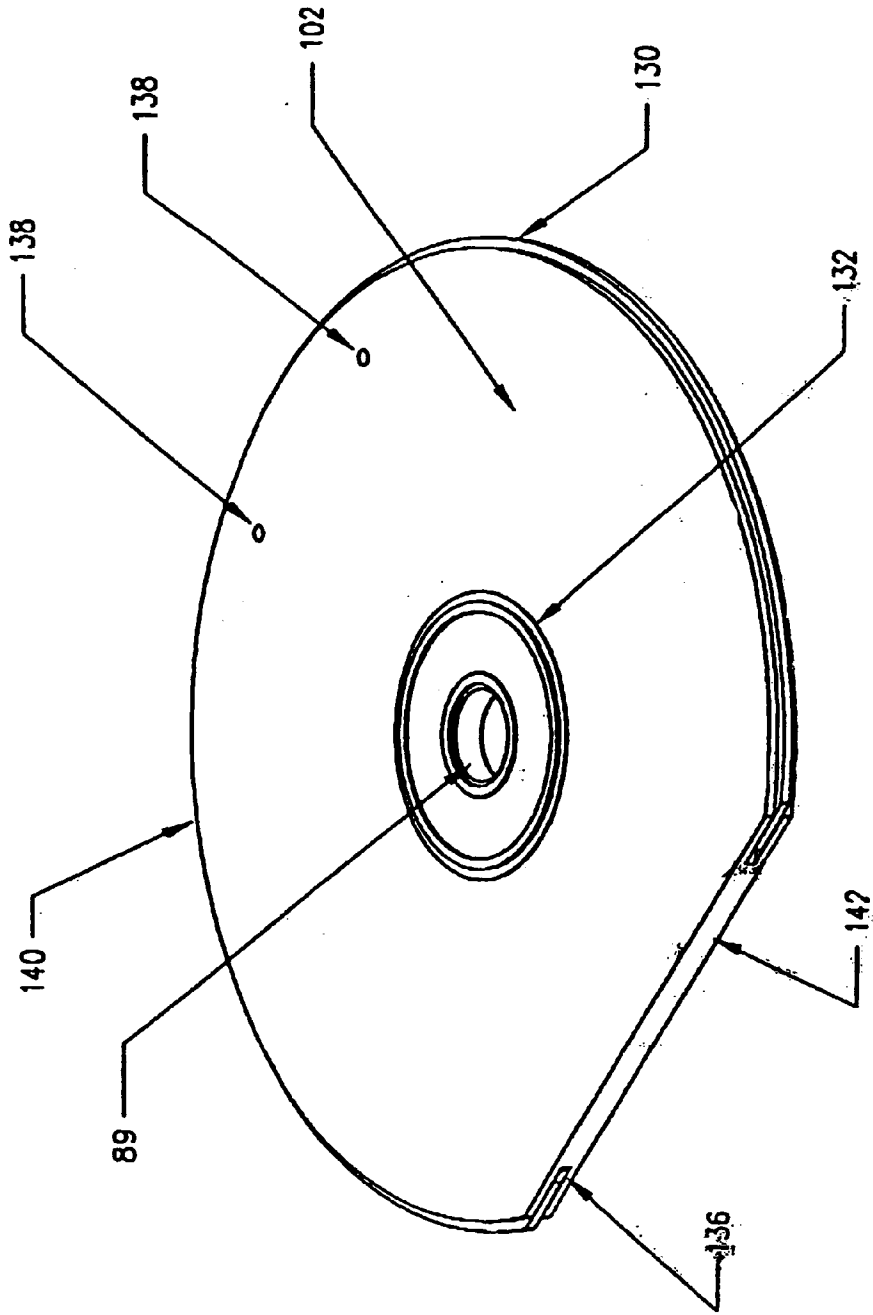


FIG. 8

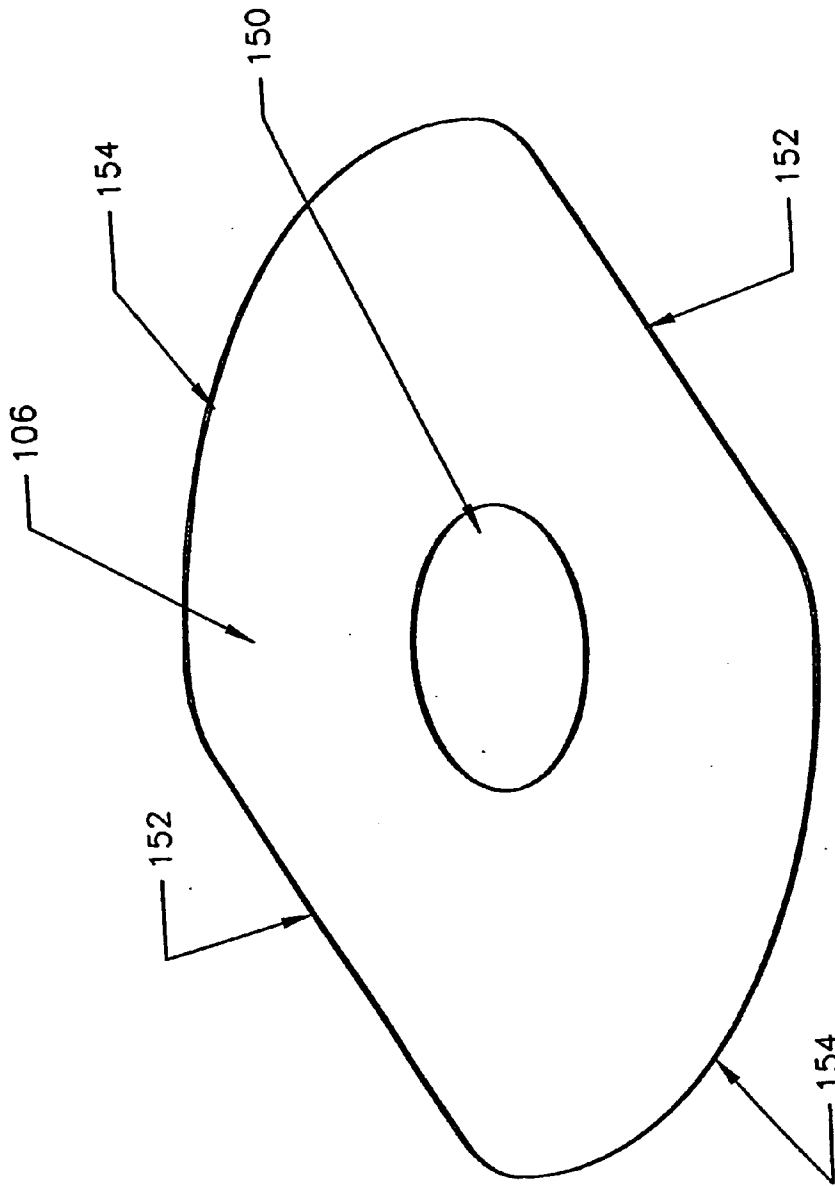


Fig. 9

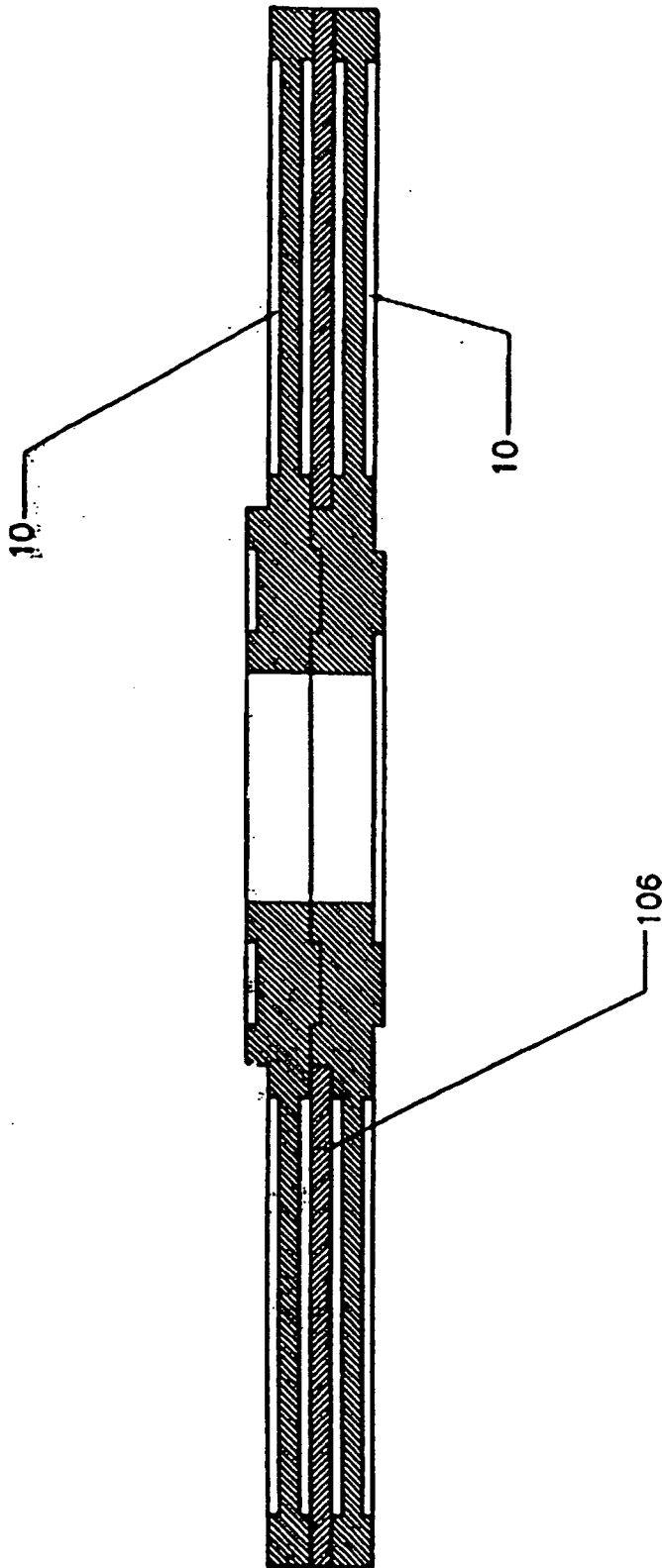


FIG. 10

## FLUID SEPARATION ASSEMBLY AND FLUID SEPARATION MODULE

### BACKGROUND OF THE INVENTION

#### [0001] 1. Field of the Invention

[0002] The present invention relates to apparatuses and methods for separation of a desired fluid from a fluid mixture. More particularly, the present invention is generally directed to a fluid separation module having several groups of multiple fluid separation assemblies separated by plate members that allows the fluid mixture to pass through the multiple fluid separation assemblies simultaneously.

#### [0003] 2. Description of the Invention Background

[0004] Generally, when separating a gas from a mixture of gases by diffusion, the gas mixture is typically brought into contact with a nonporous membrane which is selectively permeable to the gas that is desired to be separated from the gas mixture. The desired gas diffuses through the permeable membrane and is separated from the other gas mixture. A pressure differential between opposite sides of the permeable membrane is usually created such that the diffusion process proceeds more effectively, wherein a higher partial pressure of the gas to be separated is maintained on the gas mixture side of the permeable membrane. It is also desirable for the gas mixture and the selectively permeable membrane to be maintained at elevated temperatures to facilitate the separation of the desired gas from the gas mixture. This type of process can be used to separate hydrogen from a gas mixture containing hydrogen. Thus, in this application, the permeable membrane is permeable to hydrogen and is commonly constructed from palladium or a palladium alloy. The exposure to high temperatures and mechanical stresses created by the pressure differential dictates that the permeable membrane be robust. The palladium and palladium alloy of the permeable membrane is the single most expensive component of the fluid separation device, so it is desirable to minimize the amount used in the construction of the fluid separation assemblies while still providing fluid separation assemblies that are strong enough to withstand the mechanical stresses and elevated temperatures of typical operating conditions.

[0005] One type of conventional apparatus used for the separation of hydrogen from a gas mixture employs several fluid separation assemblies in a fluid separation module, wherein the fluid separation assemblies are planar disks that are coaxially aligned and stacked in a vertical direction. This type of configuration of the fluid separation assemblies is commonly referred to as being a "series operation." The module has a feed gas inlet, a permeate outlet and a discharge gas outlet. The path of the gas mixture containing hydrogen travels along the outer surface of each of the fluid separation assemblies one at a time, wherein some of the hydrogen of the gas mixture is free to enter the fluid separation assembly by the permeable membranes and is directed to the permeate outlet and the remaining gas mixture serpentine through the passageway contacting each of the remaining fluid separation assemblies one after the other. As the gas mixture travels through the passageway, it contacts the outer surfaces of several other fluid separation assemblies one at a time, wherein more of the hydrogen remaining in the gas mixture permeates the permeable membranes and follows the path resulting in this purified

hydrogen passing to the permeate outlet. The remainder of the hydrogen depleted gas mixture exits through the discharge gas outlet located at the opposite end of the module after flowing over the entire stack of fluid separation membrane assemblies. The disadvantage of this type of conventional fluid separation assembly is that the fluid membrane assemblies located at the bottom of the module are not fully utilized. The hydrogen content of the feed gas mixture is depleted to the point where the driving force (i.e., the partial pressure of hydrogen) required to diffuse hydrogen through the permeable membranes of the fluid separation assemblies in the lower portion of the module is very low.

[0006] Another conventional fluid separation configuration recycles the hydrogen depleted feed gas mixture. Recycling of the hydrogen depleted feed gas mixture back into the feed stream allows this type of fluid separation configuration to operate like a fully mixed reactor by exposing all of the fluid separation assemblies to a hydrogen feed gas mixture of identical composition. The disadvantage of this type of fluid separation configuration is that it is expensive to recompress the hydrogen feed gas mixture which is necessary to overcome the pressure losses as the hydrogen feed gas mixture moves through the module.

[0007] Thus, the need exists for a method and apparatus for inexpensively and effectively separating a desired fluid from a fluid mixture that can reliably withstand high operating pressures and temperatures.

### SUMMARY OF THE PRESENT INVENTION

[0008] The present invention provides a fluid separation module having groups of multiple fluid separation assemblies that operate in parallel, creating a large permeable membrane surface area for the fluid mixture to pass through. These groups of multiple fluid separation assemblies can then be assembled in a module in varying configurations or numbers depending on the specific application.

[0009] The present invention further provides a fluid separation assembly having a thin design that reduces the weight and volume of the fluid separation assembly. This thin design allows the subassemblies to be positioned in close proximity to each other in the module, which increases the packing density of the permeable membrane material (i.e., increases the permeable membrane surface area per unit of total volume of the fluid separation module).

[0010] The present invention provides the incorporation of turbulence inducing mechanisms in the feed channel to further increase the turbulence and mixing of the feed stream. These mechanisms may also be used as a support structure, for catalytic material. Having a specialized catalytic surface in close proximity to the permeable membrane surface aids the kinetics of secondary chemical reactions to completion as the hydrogen is removed from the feed stream through the permeable membrane.

[0011] The present invention provides several feed redistribution plates that direct the feed flow through each group of multiple fluid separation assemblies that operate in parallel thus, reducing the number of components of the fluid separation module.

[0012] The present invention provides a mechanical seal on each of the feed redistribution plates to ensure that feed gases pass across the fluid separation assemblies.

[0013] The present invention provides a fluid separation assembly having a fluid permeable membrane and a wire mesh membrane support adjacent the fluid permeable membrane, wherein the wire mesh membrane support has an intermetallic diffusion bonding barrier.

[0014] The present invention further provides a method for separating a desired fluid from a fluid mixture comprising providing a housing having a wall; providing a first plurality of fluid separation assemblies positioned adjacent one another; providing a second plurality of fluid separation assemblies positioned adjacent one another; positioning a plurality of plates adjacent and between the first and second plurality of fluid separation assemblies; forming a passageway defined by the plates and the housing wall; passing fluid through the passageway and through the first plurality of fluid separation assemblies and through the second plurality of fluid separation assemblies.

[0015] Other details, objects and advantages of the present invention will become more apparent with the following description of the present invention.

#### BRIEF DESCRIPTION OF THE DRAWINGS

[0016] For the present invention to be readily understood and practiced, preferred embodiments will be described in conjunction with the following figures wherein:

[0017] FIG. 1a is an isometric view of the fluid separation assembly of the present invention as assembled;

[0018] FIG. 1b is a top plan view of the fluid separation assembly shown in FIG. 1a;

[0019] FIG. 2 is an exploded isometric view of the fluid separation assembly of the present invention shown in FIG. 1a;

[0020] FIG. 3 is an exploded isometric view of the female permeable membrane subassembly of the present invention shown in FIG. 1a;

[0021] FIG. 4 is an exploded isometric view of the male permeable membrane subassembly of the present invention shown in FIG. 1a;

[0022] FIG. 5 is a sectional view of the fluid separation assemblies of the present invention shown in FIG. 1b and taken along line 5-5;

[0023] FIG. 6 is a sectional schematic view of a fluid separation module of the present invention having several groups of multiple fluid separation assemblies;

[0024] FIG. 7 is an enlarged schematic view of section A of the module shown in FIG. 6;

[0025] FIG. 8 is an isometric view of a feed redistribution plate of the present invention;

[0026] FIG. 9 is an isometric view of a turbulence screen of the present invention; and

[0027] FIG. 10 is a sectional view of multiple fluid separation assemblies and a turbulence screen of the present invention.

#### DETAILED DESCRIPTION OF THE INVENTION

[0028] The present invention will be described below in terms of apparatuses and methods for separation of hydro-

gen from a mixture of gases. It should be noted that describing the present invention in terms of a hydrogen separation assembly is for illustrative purposes and the advantages of the present invention may be realized using other structures and technologies that have a need for such apparatuses and methods for separation of a desired fluid from a fluid mixture containing the desired fluid.

[0029] It is to be further understood that the figures and descriptions of the present invention have been simplified to illustrate elements that are relevant for a clear understanding of the present invention, while eliminating, for purposes of clarity, other elements and/or descriptions thereof found in a hydrogen separation assembly. Those of ordinary skill in the art will recognize that other elements may be desirable in order to implement the present invention. However, because such elements are well known in the art, and because they do not facilitate a better understanding of the present invention, a discussion of such elements is not provided herein.

[0030] FIGS. 1a, 1b and 2 illustrate one embodiment of the fluid separation assembly 10 of the present invention, wherein FIG. 2 is an exploded view of the fluid separation assembly 10 shown in FIG. 1a. The fluid separation assembly 10 comprises first membrane retainers 12, a female membrane subassembly 14, a first membrane gasket 16, a first wire mesh membrane support 18, second membrane retainers 20, a slotted permeate plate 22, a permeate rim 24, a second wire mesh membrane support 28, a second membrane gasket 30 and a male membrane subassembly 32. In one embodiment, the first retainers 12 may be substantially flat members having four sides wherein two opposing sides are linear and the other two opposing sides are curvilinear such that the periphery corresponds to the peripheries of the female and male membrane subassemblies 14 and 32 and the thickness of the first retainers 12 is lo between approximately 0.001 inches and 0.060 inches. The first membrane retainers 12 have centrally disposed openings 13 and 35. The first membrane retainers 12 may be made from Monel 400 (UNS N 04400); however, other materials that are compatible with the welding process, discussed below, may also be used. It will also be appreciated that the first retainers 12 may have other desired shapes and other thicknesses than those illustrated without departing from the spirit and scope of the present invention.

[0031] FIG. 3 is an exploded view of the female permeable membrane subassembly 14. In this embodiment, female membrane subassembly 14, comprises a female gasket seat 36, a hydrogen permeable membrane 38, an inner diameter membrane gasket 40 and a center support washer 42. In this embodiment, the female gasket seat 36 is a substantially flat ring member 44 having raised faces 46a and 46b extending around the ring member 44 and a centrally disposed opening 45. The raised faces 46a and 46b are sized and proportioned to form a channel 47 which may accept a gasket 115, discussed below in connection with FIGS. 6-9, such that when the gasket 115 is compressed, it will not extrude and thus, it will be contained within the channel 47. It will be appreciated that there may be other geometries of gasket seats specific to other gasket configurations or materials that may be used without departing from the spirit and the scope of the present invention. The female gasket seat 36 may be made from Monel 400; however, other materials such as nickel, copper, nickel alloys, copper alloys, or other alloys

that provide for compatible fusion with the chosen permeable membrane material during welding may be used.

[0032] In this embodiment, the hydrogen permeable membrane 38 is a substantially planar member having two opposing sides 41 which are substantially linear, two other opposing sides 43 that are curvilinear, opposing surfaces 48 and a centrally disposed circular opening 50. The inner diameter membrane gasket 40 is a flat ring member having a centrally disposed opening 51. The center support washer 42 is a flat ring member having a centrally disposed opening 53. The inner diameter membrane gasket 40 and the center support washer 42 may be made of Monel 400 (UNS N 04400); however, other materials such as nickel, copper, nickel alloys, copper alloys, or other alloys that provide for compatible fusion with the chosen permeable membrane material or alloy during welding may be used.

[0033] Referring back to FIG. 2, in this embodiment, the first and second membrane gaskets 16 and 30 are each a substantially flat member having centrally-disposed openings 55 and 57, respectively. Similar to the first retainers 12 and the hydrogen permeable membrane 38, the first and second membrane gaskets 16 and 30 have four sides, wherein two opposing sides are substantially linear and two other opposing sides are curvilinear. In this embodiment, the first and second membrane gaskets 16 and 30 may be made from Monel 400 alloy (UNS N 004400), nickel, copper, nickel alloys, copper alloys or other precious alloys or other alloys compatible with the weld that is used to join the components of the fluid separation assembly 10 and which is discussed below. The first and second membrane gaskets 16 and 30 may have a thickness of between approximately 0.0005 inches to 0.005 inches. However, other gasket thicknesses could be employed.

[0034] Also in this embodiment, the first and second wire mesh membrane supports 18 and 28 are planar members having centrally disposed openings 52 and 54, respectively. The wire mesh membrane supports 18 and 28 each have four sides, wherein two opposing sides are linear and the other two opposing sides are curvilinear. The wire mesh membrane supports 18 and 28 may be made from 316L stainless steel alloy with a mesh count of between approximately 19 to 1,000 mesh per inch, wherein the mesh count is chosen to be adequate to support the hydrogen permeable membranes 38 and 62 (FIGS. 3 and 4). The style of woven mesh may include a standard plain square weave, twill square weave, rectangular plain or twill weave, or triangular plain or twill weave. One example of a mesh count that may be used is 49 mesh per inch. The wire mesh membrane supports 18 and 28 may be made of steel alloys, stainless steel alloys, nickel alloys or copper alloys. The wire mesh may be coated with a thin film that prevents intermetallic diffusion bonding (i.e., an intermetallic diffusion bonding barrier). The intermetallic diffusion bonding barrier may be a thin film containing at least one of an oxide, a nitride, a boride, a silicide, a carbide, or an aluminide and may be applied using a number of conventional methods, including but not limited to, physical vapor deposition (PVD), chemical vapor disposition, and plasma enhanced vapor deposition. For example, the method of reactive sputtering, a form of PVD, can be used to apply a thin oxide film to the wire mesh membrane supports 18 and 28. A variety of oxides, nitrides, borides, suicides, carbides and aluminides may also be used for the thin film as well as any thin films that will be apparent to those of ordinary skill

in the art. Using this form of PVD results in a dense amorphous thin film having approximately the same mechanical strength as the bulk thin film material.

[0035] Also in this embodiment, the second membrane retainers 20 each are a substantially flat member. The second membrane retainers 20 have four sides, wherein two opposing sides are substantially linear and the other two opposing sides are curvilinear. One retainer 20 has a centrally disposed opening 59 and the other retainer 20 has a centrally disposed opening 60. See FIG. 2. These retainers 20 may be the same thickness as the first and second wire mesh membrane supports 18 and 28. The second membrane retainers 20 may be made from a material that is compatible with the weld, discussed below, such as Monel 400 (UNS N 004400) and nickel, copper, nickel alloys, copper alloys, precious metals or alloys, or other alloys that provide for compatible fusion with the chosen membrane material or alloy during welding may be used.

[0036] In this embodiment, the slotted permeate plate 22 is a steel plate having a plurality of slots 56 extending radially and outwardly from a centrally disposed opening 58 in the direction of the periphery of the slotted permeate plate 22. The number of slots 56 in a slotted permeate plate 22 may range from approximately 10 to 72. However, other suitable slot densities may be employed. The permeate plate rim 24 is a substantially flat member having a centrally disposed opening 63 that receives the slotted permeate plate 22, wherein the opening 63 of the inner periphery is larger than the outer periphery of the slotted permeate plate 22 allowing for a gap at 63 between the slotted permeate plate 22 and the permeate plate rim 24. See FIG. 5. The shape of the slotted permeate plate 22 is similar to the other components of the fluid separation assembly in that it has four sides, wherein two opposing sides are substantially linear and the other two opposing sides are curvilinear. The permeate plate rim 24 is made from Monel 400 (UNS N 04400); however, other materials can also be used such as nickel, copper, nickel alloys, copper alloys, precious metals or alloys or other alloys that provide for compatible fusion with the chosen membrane material or alloy during welding.

[0037] FIG. 4 is an exploded view of the male permeable membrane subassembly 32. The male membrane subassembly 32 comprises a male gasket seat 61, a hydrogen permeable membrane 62, an inner diameter membrane gasket 64, and a center support washer 66. The hydrogen permeable membranes 38 and 62 may be made from at least one hydrogen permeable metal or an alloy containing at least one hydrogen permeable metal, preferably selected from the transition metals of groups VIIIA or IB of the periodic table. The hydrogen permeable membrane 62, the inner diameter membrane gasket 64, and the center support washer 66 are similar in structure to the hydrogen permeable membrane 38, the inner diameter membrane gasket 40 and the center support washer 42, respectively, discussed above in connection with FIG. 3. The hydrogen permeable membrane 62 has a centrally disposed opening 81. The male gasket seat 61 is a substantially planar ring member 68 having a circular protuberance 70 extending around a centrally disposed opening 72. In this embodiment, the female gasket seat 36 and the male gasket seat 61 are made of a high strength alloy material that is compatible with the weld such as Monel 400. The inner diameter membrane gaskets 40 and 64 are made

from the same materials as the first and second outer diameter membrane gaskets **16** and **30**, discussed above.

[0038] FIG. 5 is a cross-sectional view of the assembled fluid separation assembly **10** of the present invention. When assembling the components of the fluid separation assembly **10** shown in FIGS. 24, the female membrane subassembly **14** and the male membrane subassembly **32** are initially assembled. The female gasket seat **36** (FIG. 3), the permeable membrane **38**, the inner diameter membrane gasket **40** and the center support washer **42** are placed adjacent one another such that their central disposed openings **45**, **50**, **51** and **53**, respectively, are coaxially aligned and form a portion of a conduit **80**. A first weld **71** (FIG. 5) is placed at the openings thereof. The first weld **71** takes the form of a weld bead creating a hermetic seal between the female gasket seat **36**, the permeable membrane **38**, the inner diameter membrane gasket **40** and the center support washer **42**. The weld **71** can be effected by a number of commercially available technologies, including but not limited to, laser, electron beam, and tungsten inert gas (TIG) welding. Alternative joining technologies such as brazing or soldering may also be employed with the desired result being a gas tight bond between the gasket seat **36** and the permeable membrane **38**. Likewise, the components of the male membrane subassembly **32** (FIG. 4), which include the male gasket seat **61**, the permeable membrane **62**, the inner diameter membrane gasket **64** and the center support washer **66** are also placed adjacent one another such that their centrally disposed openings **72**, **81**, **83** and **85** are coaxially aligned with each other forming another portion of conduit **80** and a second weld bead **73** (FIG. 5) is placed around the circumference of the openings **72**, **81**, **83** and **85** thereof. As stated above, the weld **73** can be effected by a number of commercially available joining technologies, including but not limited to, laser, electron beam, and tungsten inert gas (TIG) welding.

[0039] After the components of the female membrane subassembly **14** and the components of the male membrane subassembly **32** have each been connected by the two welds **71** and **73**, respectively, they are assembled with the other components described above to form the fluid separation assembly **10**. As shown in FIG. 2, the first and second retainer members **12** and **20**, the female and male membrane subassemblies **14** and **32**, the first and second outer diameter gaskets **16** and **30**, the first and second wire mesh membrane supports **18** and **28**, the slotted permeate plate **22** and the permeate rim **24** are aligned such that their centrally disposed openings are coaxially aligned and form conduit **80**. As shown in FIG. 5, these components are retained in that configuration by placing a weld **74** at the outer periphery of the first and second retainer members **12** and **20**, the female and male membrane subassemblies **14** and **32**, the first and second outer diameter membrane gaskets **16** and **30**, and the permeate rim **24**. Alternatively, these parts could be assembled such that their centrally disposed openings are coaxially aligned, as shown in FIG. 5, and connected to one another by performing a brazing or soldering operation at the outer periphery of the first and second retainer members **12** and **20**, the female and male membrane subassemblies **14** and **32**, the first and second outer diameter membrane gaskets **16** and **30** and the permeate rim **24**. A space at **63** (FIG. 5) between the slotted permeate plate **22** and the permeate rim **24** permits expansion and contraction of the components of the fluid separation assembly **10** resulting

from the change in temperature. Assembled, the fluid separation assembly **10** may have a thickness ranging from 0.010 inches to 0.125 inches, depending upon the thicknesses of the components employed.

[0040] FIGS. 6 and 7 illustrate a fluid separation module **85** of the present invention employing several groups of multiple fluid separation assemblies **10**, wherein FIG. 7 is an enlarged section A of the module **85**. For clarity, the number of fluid separation assemblies **10** shown in FIG. 7 has been reduced from ten to four between each successive redistribution plate **102a**, **102b**, and **102c**. To more clearly represent the assembly of the module **85**, the fluid separation assemblies **10** are shown in FIG. 7 without the details shown in FIG. 5. The fluid separation module **85** substantially comprises a housing **100**, a plurality of feed redistribution plates **102a-102j**, several groups of multiple fluid separation assemblies **104a-104i**, a plurality of turbulence screens **106**, a plurality of guide rods **109**, and a compression mechanism **108**. The compression mechanism **108** comprises a compression cap **160**, high temperature belleville type springs **162** and a spring guide **164**. These components of the compression mechanism **108** are standard in the industry. The housing **100** substantially comprises a cylindrical body, a permeate end plug **112a**, a feed end plug **112b**, compressible gaskets **118a** and **118b**, a lock ring **116a**, a lock ring **116b**, a feed gas inlet **91**, a permeate outlet **90** and a discharge gas outlet **93**. The housing **100** may be made of carbon, alloy, heat and corrosion resistant steels, such as stainless steel or other alloys; however, a variety of metals may also be used, as will be apparent to one of ordinary skill in the art. A variety of conventional module housings can also be employed with the present invention.

[0041] FIG. 8 is an isometric view of a feed redistribution plate **102** of the present invention. The feed redistribution plates **102** each have a curvilinear portion **140**, a substantially linear portion **142**, a feed redistribution sealing ring **130**, and a female gasket member **132** and a male gasket **134** (not shown) which are welded to redistribution plate **102**. The feed redistribution sealing ring **130** fits inside the slot **136** and around the curvilinear portion **140** of the feed redistribution plate **102**. The male and female gasket members **134** and **132** may take the same form as the male and female gasket members **61** and **36**, shown in FIGS. 4 and 3, respectively. The feed redistribution plate **102** also has holes **138** which serve as alignment holes for the guide rods **109** such that the guide rods **109** are received therein to maintain the radial orientation of the redistribution plates **102**, and the fluid separation assemblies **10** in the housing **100**. The guide rods **109** may be sized and proportioned such that they are received by recesses in the end plug **112a** (FIG. 8). The feed redistribution plate **102** may be made from stainless alloy or other suitable high temperature material.

[0042] FIG. 9 is an isometric view of a turbulence screen **106** of the fluid separation module **85** of the present invention; and FIG. 10 is a sectional view of multiple fluid separation assemblies **10** and a turbulence screen **106** of the present invention. The turbulence screen **106** has a centrally disposed opening **150** and four sides, wherein two opposing sides **152** are substantially linear and the other two opposing sides **154** are curvilinear. The turbulence screen **106** is a plain woven screen with a thickness substantially the same as the opening of the flow channel between fluid separation assemblies is utilized. Conventional woven mesh may be

used for the economic manufacture of the turbulence screens **106**, but other materials that promote turbulence could also be selected, such as refractory or high temperature cloths, fibers, mats, felts, or papers. Reticulated ceramics and other types of woven or mat type metal materials (i.e., steel wool) would also serve as a suitable material for the turbulence screen **106**. These turbulence screens **106** also may be coated with catalytic material to drive secondary chemical reactions to completion in close proximity to the hydrogen permeable membrane surfaces, without actually contacting the permeable membrane surfaces **48** and **62** and causing damage. The selection of the material and construction should be compatible with the type of catalytic material employed. Catalytic materials may be chosen from a variety of commercially available catalysts. The choice of catalytic material is dependent upon the required operating parameters of the reaction (i.e., pressure, temperature, type and concentration of the constituents in the feed stream) as well as the desired reaction. The catalytic materials could be applied directly to the turbulence screen **106**, or indirectly using an intermediate coating material to improve adhesion and prevent spalling of the catalytic material during operation of the module **85**. The main criteria for the selection of the material of the turbulence screen **106** is that the material be thermally stable and rigid enough so that it will not deform and possibly damage the permeable membranes **48** and **62**.

[0043] Referring back to FIGS. 6 and 7, when assembling the fluid separation module **85**, the end plug **112a** may be welded to the female gasket seat **114**. Suitable plumbing fittings (not shown), such as a compression or face seal type, may be welded to the permeate port outlet **90** and discharge outlet port **93**. A pliable high-temperature gasket **118a** is then installed onto the end plug **112a**. The gasket **118a** may be a molded or pressed unitary flat wound material, a rectangular or square cross-sectional woven or non-woven packing material, or a multiple cut ring of sheet-type gasket material that is fitted onto the shoulder of the end plug **112a** to create a compression-type seal. Other types of mechanical seals, such as metal o-rings, metal c-section seals, or soft metal seals, may also be used.

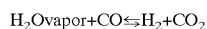
[0044] After the gasket **118a** is in place, the end plug **112a** is inserted into the module body **110** and a threaded lock ring **116a** is screwed into the end of the module housing **100**. The module **85** is then placed into a press (not shown) and a mechanical force is applied to the end plug **112a** forcing it down against the lock ring **116a** thus, compressing the gasket **118a** and forcing the gasket **118a** in an outward radial direction against the wall **110** of the module **85**, creating a seal.

[0045] One feed redistribution plate **102a** is inserted into the housing **100** adjacent the female seat **114**. The sealing ring **130** of the feed redistribution plate **102a** is compressed and forms a fluid tight seal with the housing **100**. The grooves **136** cut into the outer periphery of the redistribution plates **102** allow the sealing rings **130** to be compressed. Once the redistribution plates **102** are lowered into the housing **100**, the compression on the sealing rings **130** are released, allowing them to contact the wall **110** of the housing **100**. The male gasket seat **134** on the underneath sides of the redistribution plates **102** are in contact with a fibrous gasket **115** (FIG. 7) that is received within the female gasket seat **114**. It will be appreciated that other

mechanical seals employing different geometries and different materials may be used to effect a fluid-tight seal.

[0046] After the redistribution plate **102a** is in place, a plurality of the fluid separation assemblies **104a** and turbulence screens **106** positioned between each of the fluid separation assemblies **104a** may then be assembled into the module **85**. The guide rods **109** are inserted into the holes **138** of the redistribution plate **102a**. The centrally disposed openings of each of the turbulence screens **106**, the fluid separation assemblies **10** and the feed redistribution plates **102** are coaxially aligned. The turbulence screens **106** are added between each pair of fluid separation assemblies **10** to promote turbulent flow of the feed gases and insure that hydrogen rich feed gas is continuously fed to the membrane surface. The turbulence screens **106**, shown in FIGS. 6, 7 and 9, contact the planar surfaces of the female gasket seat **44** (FIG. 5) and the male gasket seat **68** when the module **85** (FIG. 6) is constructed. The turbulence screens **106** are held in place by the first membrane retainers **12** of the fluid separation assemblies **10** that are adjacent to each turbulence screens **106**. A turbulence screen **106** is positioned between fluid separation assemblies **10**, as shown in FIG. 10, when the fluid separation assemblies **10** are stacked adjacent to one another to create groups of multiple fluid separation assemblies **104a-104i** (FIGS. 6 and 7).

[0047] The turbulence screens **106** also serve as a substrate for the application of reaction catalysts that will prompt a secondary reaction adjacent to the permeable membrane surfaces **48** and **62**. One example of a catalytic material that may be used for methanol steam reforming or water-gas shift reactions is a material comprised of Cu/ZnO/Al<sub>2</sub>O<sub>3</sub>, wherein the desired reaction to take place would be dependent upon the operating parameters employed. When a hydrogen producing reaction is carried out in this manner, the reaction kinetics are driven to completion by the continuous removal of hydrogen from the feed stream by the hydrogen permeable membranes **48** and **62**. An example of this type of reaction is the water-gas shift reaction, which is denoted as:



[0048] As the water vapor and carbon monoxide react to form hydrogen and carbon dioxide in the presence of a suitable catalyst, hydrogen is continually being removed by the hydrogen permeable membranes **48** and **62** thus, allowing a substantially complete reaction. This type of reaction is common in hydrogen rich reformat streams, where both water vapor and carbon monoxide are present. Catalytic materials may be chosen from a variety of commercially developed catalysts, wherein the selection of the catalytic material would be dependent upon the required operating parameters of the reaction (i.e., pressure, temperature, type and concentration of the constituents in the feed stream) as well as the desired reaction to take place. The catalytic materials may be applied directly to the turbulence screen **106**, or indirectly using an intermediate coating material to improve adhesion and prevent spalling of the catalytic material during operation.

[0049] The redistribution plates **102** are positioned on the female and male gasket seats **36** and **61** in such a manner that they are positioned equidistant from the planar surface of the permeable membrane assemblies **14** and **32** in successive fluid separation assemblies **10**. The redistribution plates **102**



are not fixedly connected to the gasket seats **36** and **61**, but rather are received by the channel **47** of the female gasket seat **36** and the raised face **70** of the male gasket seat **61**. There is sufficient clearance between slot **136** and the sealing ring **130** of the redistribution plate **102** such that the redistribution plate **102** and the fluid separation assemblies **10** are positioned inside the wall **110** of the housing **100** independently of the position of the fluid separation assemblies **10**. Each redistribution plate **102** has opening **89** therein.

[0050] Several groups of multiple fluid separation assemblies **104b-104i** (FIG. 6) are stacked within the module **85**, wherein the feed redistribution plates **102b-102j** separate the groups of fluid separation assemblies **104b-104i** and turbulence screens **106** separate successive fluid separation assemblies **10**. The fluid separation assemblies **10** are aligned one with the other such that each of the conduits **80** (FIG. 5) of the fluid separation assemblies **10** form a portion of channel **180**. The assembly of the module **85** continues by alternatively stacking a gasket **115**, multiple fluid separation assemblies **104** having turbulence screens **106** positioned between successive fluid separation assemblies **10**, and feed redistribution plates **102** until the desired number of groups of multiple fluid separation assemblies **104** have been stacked in the module **85**. Please note that the redistribution plate **102b** is assembled in the same way as the redistribution plate **102a**, with the exception that it is rotated 180 degrees relative to the first redistribution plate **102a**. This alternating orientation of the redistribution plates **102** along the stack of fluid separation assemblies **104a-104i** creates a fluid passageway C (FIG. 7) that directs the feed gas over each group of fluid separation assemblies **10**. It should also be noted that the number of fluid separation assemblies **10** in the multiple fluid separation assemblies **104a-104i** may be assembled in different quantities. In this embodiment, equal numbers of fluid separation assemblies **10** comprising the multiple fluid separation assemblies **104** have been placed between each successive redistribution plate **102** for purposes of illustration only. The number of fluid separation assemblies **10** between each successive redistribution plate **102** may be reduced or increased to optimize the performance of the fluid separation assemblies **10** at each successive stage in the module **85**. Altering the number of fluid separation assemblies **10**, and thus the total permeable membrane area between each successive redistribution plate **102**, allows the overall performance of the hydrogen separation module **85** to be maximized with respect to the total permeable membrane area required for a given fluid separation application. For example, a larger number of fluid separation assemblies **10** may be positioned together at the feed end of the module **85**, where the feed stock gas is highest in hydrogen content and a reduced number of fluid separation assemblies **10** may be positioned at the raffinate end of the module **85**, where the hydrogen depleted feed gas exits.

[0051] When the last redistribution plate **102j** is assembled in the module **85**, the compression mechanism **108** is placed on the redistribution plate **102j**. The belleville springs **162** are sized such that at full compression, supplies a compressive load sufficient to maintain a positive sealing force on the gaskets **115** positioned between the fluid separation assemblies **104a-104i** in the module **85**. When the gaskets **115** are compressed, they also provide a small amount of give to compensate for the different coefficients of thermal expansion inherent to the different materials used in the module **85**. As the module **85** thermally cycles between

ambient and operating temperatures, the components within the module **85** are able to expand and contract. This small amount of give also helps compensate for any additional compression of the gaskets **118a** and **118b** that may occur over time.

[0052] With the compression mechanism **108** in place, the end plug **112b** is fitted with a gasket **118b** identical to the gasket **118a**, and is lowered into the module **85**. A suitable plumbing fitting (not shown), such as a compression or face seal type fitting is welded into the inlet port **91**. The lock ring **116b** is then screwed into the module **85** to a point where it is flush with the end of the housing **100**. A setscrew **175** is inserted into the threaded compression screw hole **172**. As this setscrew **175** is tightened, it contacts the compression cap **160** and forces the end plug **112b** upwards against the lock ring **116b**. This results in the gasket **118b** being forced outwardly in a radial direction against the wall **110**, thus creating a fluid-tight seal. At the same time that the end plug **112b** is being forced upwards, the setscrew **175** is compressing the belleville springs **162** and thus, maintaining a compressive force on the gaskets **115** within the module **85**. After the setscrew **175** has been tightened to the required torque necessary for fully compressing the belleville springs **162**, a sealing gasket (not shown) is placed in the recess surrounding the threaded screw hole **172**. The cap **170** is then screwed into the hole **172** and tightened to create a positive seal with the sealing gasket positioned in the recess surrounding the hole **172** and the end plug **112b**.

[0053] During operation, the hydrogen rich feed gas is admitted into the inlet port **91** and travels in a serpentine fashion through passageway C in the module **85** where the feed gas encounters multiple fluid separation assemblies **104a-104i**. Specifically, pure hydrogen is first diffused through the permeable membrane of each fluid separation assembly **10** comprising multiple fluid separation assemblies **104i** and is collected in a central permeate channel **180**. The permeate hydrogen exits the module **85** through the permeate outlet **90**, while the hydrogen depleted mixture exits through the discharge outlet **93**. Referring to FIG. 5, when separating the hydrogen from the feed gas that includes hydrogen, the feed gas is directed towards the permeable membranes **38** and **62** of the female membrane subassembly **14** and the male membrane subassembly **32**, respectively, in the directions D and E. When the feed gas containing hydrogen contacts the hydrogen permeable membranes **38** and **62**, the hydrogen permeates through the permeable membranes **38** and **62**, passes through the first and second wire mesh membrane supports **18** and **28** and enters the slotted permeate plate **22** where the hydrogen enters slots **56** and is directed toward the central axis H by the passageways formed by the slots **56**. The central openings of the components of the fluid separation assembly **10** form the conduit **80**, which forms a portion of the channel **180** such that the purified hydrogen is collected and transported to the permeate outlet **90**. The conduit **80** may have a diameter of between approximately 0.25 inches and 1 inch. The diameter is determined by the components of the fluid separation assembly **10** and by the desire that the hydrogen flow be substantially unimpeded. The non-hydrogen gases in the gas mixture are prevented from entering the fluid separation assembly **10** by the fluid permeable membranes **38** and **62**. The remainder of the hydrogen depleted feed gas is directed around the exterior of the fluid separation assembly

10 and continues along the passageway C to the next set of multiple fluid separation assemblies 104h, 104g, 104f, 104e, 104d, 104c, 104b and 104a.

[0054] Although the present invention has been described in conjunction with the above described embodiment thereof, it is expected that many modifications and variations will be developed. This disclosure and the following claims are intended to cover all such modifications and variations.

What is claimed is:

1. A fluid separation module, comprising:
  - a housing having a wall;
  - a first plurality of fluid separation assemblies within said housing, each of said first plurality of fluid separation assemblies are adjacent one another;
  - a second plurality of fluid separation assemblies within said housing, each of said second plurality of fluid separation assemblies are adjacent one another;
  - a plurality of plates within said housing, said plurality of plates positioned between and separating said adjacent first plurality of fluid separation assemblies members from said adjacent second plurality of fluid separation assemblies; and
  - a fluid passageway defined by said plurality of plates and said housing wall.
2. The fluid separation module according to claim 1, wherein each of said first and second plurality of fluid separation assemblies comprises:
  - a slotted permeate body having opposing faces;
  - first and second wire mesh membranes, each of said wire mesh membranes having a first surface and a second surface, wherein each of said wire mesh membranes first surfaces is adjacent said slotted permeate;
  - first and second membranes permeable to a desired fluid, each of said permeable membranes adjacent one of said wire mesh membranes second surfaces;
  - a permeate rim surrounding said slotted permeate body;
  - first retainers adjacent each of said permeable membranes;
  - second retainers between said slotted permeate and each of said wire mesh membranes; and
  - gaskets between each of said wire mesh membranes and said permeable membranes, wherein said permeate rim, said first retainers, said second retainers and said gaskets are joined together at their peripheries.
3. The fluid separation module of claim 1, further comprising a plurality of screens, wherein said plurality of screens are positioned between said first plurality of fluid separation assemblies and said plurality of screens are positioned between said second plurality of fluid separation assemblies.
4. The fluid separation module of claim 1, wherein each of said first and second plurality of fluid separation assemblies comprises:

a fluid permeable membrane; and

a wire mesh membrane adjacent said fluid permeable membrane, said wire mesh membrane having an inter-metallic diffusion barrier.

5. The fluid separation module according to claim 4, wherein said barrier is a thin film containing at least one of the group consisting of nitrides, oxides, borides, suicides, carbides and aluminides.

6. The fluid separation module according to claim 5, wherein said barrier is a thin film containing one of an oxide and a nitride.

7. The fluid separation module according to claim 4, wherein said fluid permeable membrane is a substantially planar member having a centrally disposed opening.

8. The fluid separation module according to claim 7, wherein said wire mesh membrane is a substantially planar membrane having a centrally disposed opening which is in alignment with said fluid permeable membrane opening.

9. The fluid separation module according to claim 4, wherein said wire mesh membrane has a mesh count ranging between approximately 19 to 1000 mesh per inch.

10. The fluid separation module according to claim 4, further comprising a slotted permeate plate adjacent to said wire mesh membrane.

11. The fluid separation module according to claim 10, further comprising a second fluid permeable membrane and a second wire mesh membrane, wherein said slotted permeate plate has a first side and a second side and said first permeable membrane is adjacent said first side of said slotted permeate plate and said first wire mesh membrane is adjacent said first permeable membrane, and wherein said second wire mesh membrane is adjacent said slotted permeate plate second side and said second fluid permeable membrane is adjacent said second wire mesh membrane.

12. The fluid separation module according to claim 11, wherein said slotted permeate plate, said second wire mesh membrane and said second fluid permeable membrane each also have a centrally disposed opening and each of said centrally disposed openings are coaxially aligned and form a central conduit.

13. The fluid separation module according to claim 4, wherein said wire mesh membrane is made from stainless steel.

14. The fluid separation module according to claim 11, wherein each of said fluid permeable membranes further comprises a gasket seat, a membrane gasket, and a washer to form first and second membrane subassembly, wherein said gasket seats, said membrane gaskets and said washers are connected to said fluid permeable membranes.

15. The fluid separation module according to claim 14, further comprising a weld bead connected to each of said first and second membrane subassemblies.

16. The fluid separation module according to claim 15, further comprising first retainers, one of said first retainers connected to each of said fluid permeable membranes.

17. The fluid separation module according to claim 16, further comprising second retainers adjacent said slotted permeate plate.

18. The fluid separation module according to claim 15, further comprising first retainers and second retainers, wherein said first retainers and said second retainers are adjacent each of said fluid permeable membranes.

19. The fluid separation module according to claim 15, further comprising gaskets, one of said gaskets adjacent each of said wire mesh membranes.

20. The fluid separation module according to claim 10, wherein said permeable membrane and said slotted permeate each have a centrally disposed opening that form a conduit.

21. The fluid separation module according to claim 1, wherein said plurality of plates are a substantially planar member having a gasket connected at the periphery of said plate.

22. The fluid separation module according to claim 1, wherein said plurality of plates have a curved portion and a linear portion.

23. The fluid separation module according to claim 1, wherein the said housing is substantially cylindrical and said plurality of plates has a surface area that is less than said cross-sectional area of said housing.

24. The fluid separation module according to claim 1, wherein each of said plurality of plates defines a plurality of holes therethrough.

25. The fluid separation module according to claim 24, further comprising a plurality of guide rods that are received by said holes.

26. The fluid separation module according to claim 1, wherein each of said plurality of plates has first and second gaskets connected thereto.

27. The fluid separation module according to claim 26, wherein said first and second gaskets have male and female connectors, respectively.

28. The fluid separation module of claim 1, wherein each of said plurality of plates has a centrally disposed opening, and wherein each of said first and second plurality of fluid separation assemblies also has a centrally disposed opening and said openings of said plurality of plates and said openings of said first and second plurality of fluid separation assemblies are in coaxial alignment with each other.

29. The fluid separation module according to claim 21, wherein each of said plurality of plates has a groove extending around a portion of the periphery of each of said plurality of plates, each of said plurality of plates has a gasket that is received within said grooves.

30. The fluid separation module of claim 1, wherein each of said first and second plurality of fluid separation assemblies has a centrally disposed opening, each of said centrally disposed openings are in coaxial alignment with each other and form a conduit.

31. The fluid separation module according to claim 1, further comprising several pluralities of fluid separation assemblies within said housing, said fluid separation assemblies of each of said several plurality of fluid separation assemblies being adjacent each other.

32. A method for separating a desired fluid from a fluid mixture, comprising:

providing a housing having a wall;

providing a first plurality of fluid separation assemblies positioned adjacent one another;

providing a second plurality of fluid separation assemblies positioned adjacent one another;

positioning a plurality of plates adjacent and between said first and second plurality of fluid separation assemblies;

forming a passageway defined by said plates and said housing wall;

passing fluid through said passageway and through said first plurality of fluid separation assemblies and through said second plurality of fluid separation assemblies.

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