



DEPARTMENT OF CHEMICAL ENGINEERING
FACULTY OF ENGINEERING
PRINCE OF SONGKLA UNIVERSITY

Final Examination: 2nd Semester

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Date: May 3rd, 2016

Time: 9:00 – 12:00

Subject: 230-520 Catalyst

Room: A200

ทจจริตในการสอบ โทษขั้นต่ำปรับตกรในรายวิชานั้น และ
พักการเรียน 1 ภาคการศึกษา

คำสั่ง

1. ห้ามนำข้อสอบชุดนี้ออกจากห้องสอบ
2. เป็นการสอบแบบนำเอกสารทุกชนิดเข้าห้องสอบได้
3. อนุญาตให้ใช้เครื่องคำนวณ และใช้ดินสอในการทำข้อสอบ
4. ห้ามพูดคุยหรือหยิบยืมเอกสาร เครื่องคำนวณ หรือเครื่องเขียน
5. หากท่านทำข้อสอบเสร็จก่อนหมดเวลา ให้นั่งอยู่กับที่แล้วยกมือแจ้งกรรมการคุมสอบ

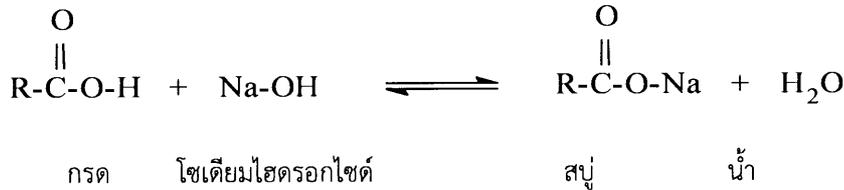
ข้อสอบมี 4 ข้อ 10 หน้า (รวมปก)

ข้อสอบ	1	2	3	4	รวม
คะแนนเต็ม	30	20	50	35	135
คะแนนที่ได้					

สุกฤทธิรา รัตนวิไล
เมษายน 2559

1. (30 คะแนน; 2 คะแนน / ข้อย่อย) เติมคำที่เหมาะสมลงในช่องว่าง
- 1.1กลุ่มสารประกอบอินทรีย์ที่ระเหยเป็นไอกระจายตัวไปในอากาศได้ในที่อุณหภูมิและความดันปกติ โมเลกุลส่วนใหญ่ประกอบด้วยอะตอมของคาร์บอนและไฮโดรเจน อาจมีออกซิเจนหรือ คลอรีนร่วมด้วย

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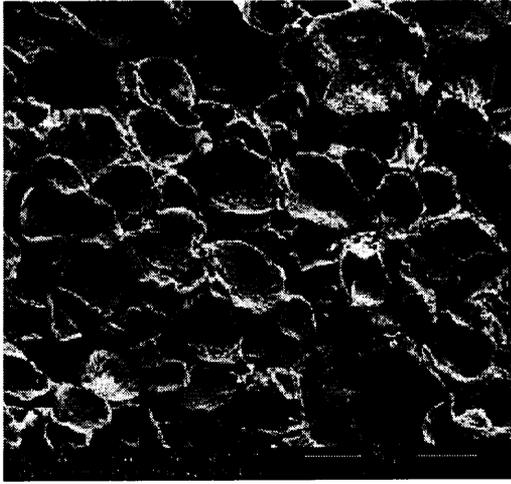


- 1.3 ความเป็นพิษที่เกิดขึ้นกับตัวเร่งปฏิกิริยาที่พบมากที่สุดคือความเป็นพิษที่เกิดจาก..... ซึ่งมีอยู่ทั่วไปในสารประกอบไฮโดรคาร์บอน
- 1.4การวิเคราะห์ทางเคมีที่ใช้หลักการ การเปลี่ยนสารตัวอย่างให้เป็นไอออน (Ionization) เมื่อสารตัวอย่างเปลี่ยนไปเป็นไอออนแล้วผ่านเข้าสู่ส่วนวิเคราะห์มวล (Mass analyzer) ที่ใช้ค่าศักย์ไฟฟ้าและคลื่นความถี่วิทยุในการจำแนก
- 1.5การสูญเสียพื้นที่ที่ว่องไวในการเกิดปฏิกิริยาเนื่องจากการที่อะตอมหรือโมเลกุลของตัวเร่งปฏิกิริยาเคลื่อนที่ไปรวมตัวกันเองหรือเคลื่อนที่ไปรวมกับผลึกที่มีอยู่เดิมกลายเป็นผลึกที่ใหญ่ขึ้น
- 1.6อุปกรณ์ที่ทำหน้าที่เปลี่ยนสารมลพิษในไอเสียรถยนต์ เช่น CO, PM, HC (Hydrocarbon) และ NO_x ให้เป็นสารที่ไม่มีอันตรายต่อมนุษย์ โดยทำปฏิกิริยาทางเคมีด้วยตัวเร่งปฏิกิริยา
- 1.7เป็นวิธีที่นิยมใช้ในอุตสาหกรรมพ่นสีและอุตสาหกรรมเฟอร์นิเจอร์ ซึ่งวิธีนี้ใช้น้ำดักจับสารประกอบอินทรีย์ระเหยง่ายที่อยู่ในอากาศขณะดำเนินงาน หลังจากนั้นก็นำน้ำไปทำการบำบัด
- 1.8การเสื่อมสภาพของตัวเร่งปฏิกิริยา ในกรณีที่สารตั้งต้นหรือสารผลิตภัณฑ์ในปฏิกิริยาที่ต้องการเกิดการยึดติดทางกายภาพของสารดังกล่าวบนพื้นผิวของตัวเร่งปฏิกิริยา (ไม่ได้เกิดจากสารที่ปนเปื้อนมา)
- 1.9เครื่องมือตรวจวัดอัตราการคายซึบของโมเลกุลของสารที่เป็นฟังก์ชันกับอุณหภูมิ โดยการให้ความร้อนกับสารตัวอย่างแล้วสังเกตการเปลี่ยนแปลงทางเคมีที่เกิดขึ้น
- 1.10แก๊สที่มีส่วนประกอบหลักคือไฮโดรเจนและคาร์บอนมอนอกไซด์ แก๊สนี้สามารถสังเคราะห์ได้จาก Biomass หรือถ่านหิน
- 1.11เป็นน้ำมันเชื้อเพลิงสำหรับใช้กับเครื่องยนต์สันดาปภายในได้มาจากการนำน้ำมันองค์ประกอบ ที่ได้จากจากกระบวนการกลั่นน้ำมันมีองค์ประกอบ C5-C10 นำมาผสมสารเพิ่มคุณภาพ และสารเติมแต่ง เช่น MTBE, เอทานอล และสีย้อม

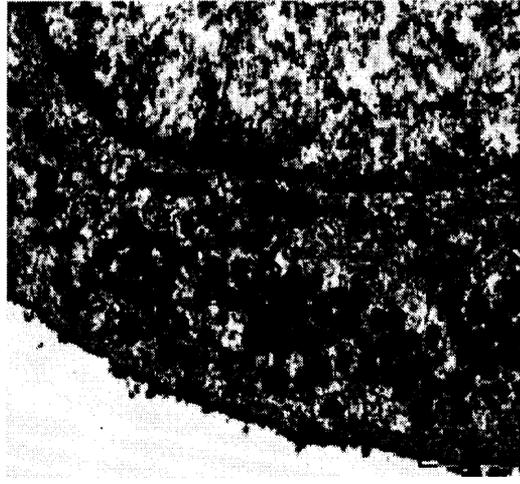
- 1.12 เครื่องมือที่สามารถใช้หาขนาดของอนุภาคเรียกว่า
เครื่องมือที่สามารถใช้หา crystal size เรียกว่า
- 1.13 คำกล่าวนี้ถูกหรือผิด หากสารตัวอย่างเป็น
ของเหลวไม่สามารถส่งวิเคราะห์ผลด้วยเครื่องมือ FTIR
- 1.14 คือการเพิ่มพื้นที่ผิวที่ว่องไวในการเกิดปฏิกิริยา
จากการกระจายตัวของผลึกหรืออะตอมของตัวเร่งปฏิกิริยา
- 1.15 คือการใช้รังสีแม่เหล็กไฟฟ้าที่มีความถี่อยู่ในช่วง
คลื่นวิทยุ เข้าไปกระตุ้น (Excite) อะตอมในสารตัวอย่างที่อยู่ในสนามแม่เหล็กทำให้พลังงานของ
nuclear spin ของอะตอมนั้นถูกกระตุ้นไปยังอีกระดับพลังงานหนึ่ง (Energy transition) ซึ่งความ
แตกต่างของระดับพลังงานนี้แสดงออกมาเป็นค่าของ chemical shifts ซึ่งค่านี้สามารถช่วย
วิเคราะห์ถึงสภาวะแวดล้อมต่าง ๆ ของอะตอมที่พิจารณาอยู่ได้

2. (20 คะแนน) จงอธิบายอย่างละเอียด

2.1 จากภาพที่ปรากฏ A และ B เป็นผลจากการใช้เครื่องมือใดในการวิเคราะห์ มีวิธีการเตรียมชิ้นงานอย่างไรและหากใช้อุปกรณ์ชนิดนี้วิเคราะห์ตัวอย่างปฏิกิริยา มีข้อดีหรือข้อด้อยอย่างไร (6 คะแนน)



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2.2 สมมุติว่าท่านได้รับการเสนอให้เป็นหัวหน้าฝ่ายวิจัยและพัฒนาของบริษัทแห่งหนึ่ง โดยงานชิ้นแรกคือให้พิจารณาการจัดซื้อเครื่องมือในการวิเคราะห์ตัวอย่างปฏิกิริยาที่ทางบริษัทผลิตขึ้นเพื่อยืนยันความถูกต้องของการผลิตตัวอย่างปฏิกิริยาดังกล่าว โดยได้รับเงินสนับสนุน 5 ล้านบาท ท่านจะนำเสนอการจัดซื้อเครื่องมือชนิดใดในการวิเคราะห์ภายใต้วงเงินที่กำหนด พร้อมเหตุผลอย่างละเอียดหากบริษัทให้ท่านวิเคราะห์ได้ด้วยเครื่องมือเพียง 2 ชนิดเท่านั้น (8 คะแนน)

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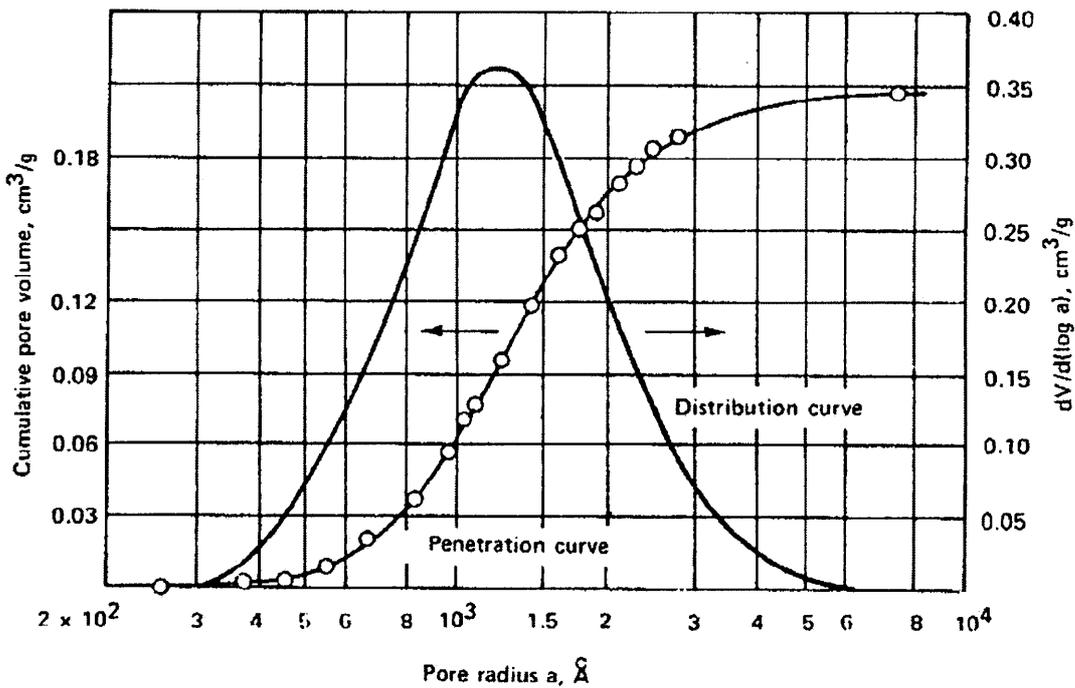
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2.3 จากรูปที่แสดงด้านล่าง ตอบคำถามต่อไปนี้ (6 คะแนน)



a) รูปที่แสดงเป็นผลจากการใช้เครื่องมือวิเคราะห์ชนิดใด

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b) รูพรุนที่มีรัศมีของรูพรุนในช่วง 1×10^3 ถึง $2 \times 10^3 \text{ \AA}$ มีปริมาตรของรูพรุนเท่าไรต่อกรัมของตัวเร่งปฏิกิริยา และคิดเป็นกี่เปอร์เซ็นต์ของปริมาตรรูพรุนทั้งหมด

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3. (50 คะแนน) จากเอกสารแนบ งานตีพิมพ์เรื่อง Characteristics and catalytic properties of Ni/CaAlO_x catalyst for hydrogen-enriched syngas production from pyrolysis-steam reforming of biomass sawdust จงตอบคำถามต่อไปนี้โดยใช้ภาษาไทย พร้อมเหตุผลอย่างละเอียด

3.1 งานตีพิมพ์นี้ทำเรื่องอะไร (5 คะแนน)

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3.2 ตัวเร่งปฏิกิริยาที่ศึกษาคืออะไร จัดอยู่ในรูปตัวเร่งปฏิกิริยาชนิดใด และมีขั้นตอนในการเตรียมอย่างไร (5 คะแนน)

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3.3 จากผลการวิเคราะห์สมบัติทางของตัวเร่งปฏิกิริยา หากต้องการลดค่าใช้จ่ายในการวิเคราะห์ ท่านจะลดการวิเคราะห์ด้วยอุปกรณ์ตัวใดพร้อมเหตุผลประกอบ (5 คะแนน)

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3.4 จากผลการวิเคราะห์ตัวเร่งปฏิกิริยาด้วย XRD ได้ข้อมูลที่มีประโยชน์ต่อตัวเร่งปฏิกิริยาอย่างไร (10 คะแนน)

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3.5 WGSR คืออะไร ตัวเร่งปฏิกิริยาที่ใช้มีผลต่อ WGSR อย่างไร (5 คะแนน)

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3.6 ในกระบวนการ pyrolysis-steam reforming of biomass sawdust มี coke เกิดขึ้นและเป็นปัญหาหลัก คำถาม: ก. coke คืออะไร ข. เกิดขึ้นได้อย่างไร ค. เป็นการเสื่อมสภาพของตัวเร่งปฏิกิริยาแบบไหนและง. มีวิธีการแก้ไขอย่างไร (10 คะแนน)

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3.7 Coke ที่เกิดขึ้นในกระบวนการนี้มีกี่ชนิด ทราบได้จากเครื่องมือวิเคราะห์ใดอธิบายพร้อมเหตุผลประกอบ (5 คะแนน)

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3.8 สรุปจากงานชิ้นนี้ สมควรนำตัวเร่งปฏิกิริยาที่ใช้ในกระบวนการนี้ ขยายผลต่อเพื่อผลิต Syngas หรือไม่อย่างไร (5 คะแนน)

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Characteristics and catalytic properties of Ni/CaAlO_x catalyst for hydrogen-enriched syngas production from pyrolysis-steam reforming of biomass sawdust

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ABSTRACT

The production of hydrogen-enriched syngas from the thermo-chemical conversion of biomass was studied using Ni/CaAlO_x catalysts prepared by co-precipitation method. The effect of Ca addition with different molar ratios of Ca:Al (1:3, 1:2, 1:1, 2:1, 3:1) on the properties and catalytic behavior in relation to syngas production and the coke formation on the surface of the catalysts were investigated. Catalysts were characterized by BET, XRD, TPR, SEM, and TEM. The SEM and TEM results showed that rod-shaped nanoparticles were highly dispersed on the surface of the catalyst. The particle size of NiO was slightly affected with the increase of Ca content in the catalyst. It appeared that the selectivity of CO was increased and the selectivity of CO₂ was reduced with the increase of Ca addition to the catalyst. For example, CO₂ concentration was reduced from 20 to 12 vol.%, when the molar ratio of Ca/Al was increased from 1:3 to 3:1 for the Ni/CaAlO_x catalyst; it is suggested that the water gas shift reaction was inhibited and CO₂ reforming reactions were promoted in the presence of the catalyst with higher Ca content. The CO/H₂ molar ratio could be manipulated by changing the Ca content in the catalyst, while the H₂ concentration remained almost constant (around 45 vol.%). Thus, using the Ni/CaAlO_x catalyst developed in this work could provide a promising route to control the syngas composition, which is an important factor for syngas applications.

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1. Introduction

The consumption of fuels and chemicals continues to increase with the development of the world's economy [1,2]. As a versatile building block in the chemical industry and fuel synthesis, synthesis gas (syngas) plays an important role in industry [3–5]. Currently, syngas production largely depends on fossil sources through the reforming process [6]. For sustainable development, great attention has been focused on the production of syngas from renewable resource. Biomass, including agriculture and forest wastes is one of the most abundant renewable resources; it has been considered as a promising raw material to partially replace fossil resources in syngas production in the future [7–12].

Biomass gasification has been widely practiced for syngas production due to its high thermal efficiency [12]. However, this process has challenges towards large-scale development, i.e., low hydrogen production and high tar content in the syngas [13,14]. Catalysts are well-known for their capability for accelerating biomass conversion through lowering activation energy, and for enhancing catalytic reforming to produce syngas [12,15,16]. For example, reduction of tar and significant increase in production of syngas have been achieved by adding olivine and alumina catalysts to biomass gasification using a conical spouted bed reactor [15]. Cheah et al. [17] carried out biomass gasification using a nickel cerium olivine catalyst; they reported that the presence of catalyst resulted in a significant improvement of H₂-enriched syngas production. In addition, the improvement of hydrogen production was reported by adding Fe/CaO catalyst to a continuous-feed fluidized bed reactor [16]. Supported noble metal catalysts such as Rh, Ru and Pt have been reported to effectively increase syngas yield

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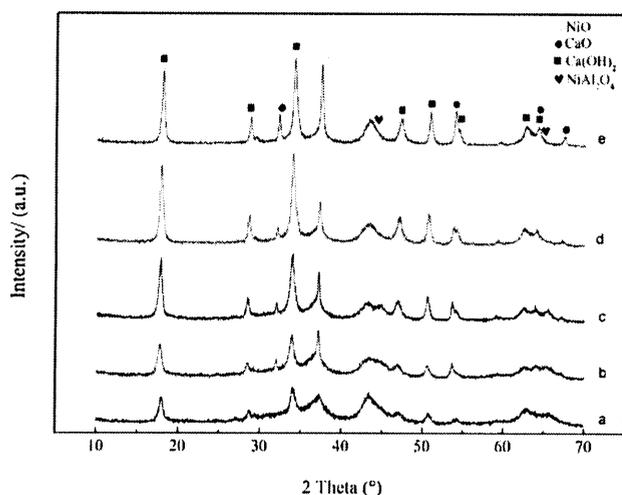


Fig. 1. XRD patterns of Ni/CaAlO_x catalysts: (a) Ni/CaAlO_x (1:3); (b) Ni/CaAlO_x (1:2); (c) Ni/CaAlO_x (1:1); (d) Ni/CaAlO_x (2:1); (e) Ni/CaAlO_x (3:1).

[18–21]. However, the high cost of these noble metals limits the wide applications of biomass gasification in industrial practice.

At present, low-cost transition metal catalysts such as Ni-based catalysts have been widely used as effective alternatives to noble metal-based catalysts in biomass gasification or steam reforming processes [14,22]. Ni based catalysts are generally prepared by impregnation method by loading Ni or NiO particles on catalyst supports such as alumina and silica for gasification or reforming. The physical structure and chemical composition of catalyst supports influence the characteristics of Ni catalysts e.g., Ni dispersion and consequently their catalytic performance for gas production from biomass gasification. For a better Ni dispersion, various nanoporous supports such as MCM-41 [23,24], zeolite [25], and SBA-15 [26,27] have been utilized to confine the size of Ni nano-particles inside the pores of the catalyst support. This type of confined reaction space with uniform Ni particles could enhance the production of H₂-enriched syngas. However, the nanopores of catalysts have diffusion limitations for large-molecular weight biomass compounds and thus reduce the catalytic performance for syngas production [13].

Another efficient method to enhance Ni dispersion is to induce a strong metal-support interaction by incorporating rare-earth or alkaline metals in the catalyst system. It has been reported that introducing Zr, Ce, and Mg into a silica support markedly promoted Ni dispersion [28–31]. Based on these previous contributions, it is desirable to prepare a highly dispersed Ni catalyst using non-porous supports without diffusion limitation. However, using rare-earth metals as promoters to Ni-based catalysts is costly. In this study, we introduced Ca, a low cost and highly abundant metal, into alumina supports for preparing uniform and fine Ni nano-particles with high dispersion for H₂-enriched syngas production from biomass through a pyrolysis-reforming process, using a two-stage reaction system.

2. Experimental

2.1. Biomass sample and catalyst synthesis

Wood sawdust with a size less than 0.2 mm was used as raw biomass material in this work. The biomass sample contained 6.4 wt.% moisture, 74.8 wt.% volatiles, 18.3 wt.% fixed carbon and 1.2 wt.% of ash, as reported in our previous work [24]. In addition, the biomass contents of C, H, O and N were 47.1, 5.9, 46.9 and 0.1 wt.%, respectively.

The catalysts were prepared by a co-precipitation method with an initial Ni-loading mole ratio of 20 mol%. Ni(NO₃)₂·6H₂O (≥99%), Ca(NO₃)₂·4H₂O (≥99%), Al₂(NO₃)₃·9H₂O (≥99%) were purchased from Sigma–Aldrich. Precursors with the desired Ni–Ca–Al ratios were prepared by dissolving a certain amount of metal salts in deionized water. After the precipitation, the suspension was aged under agitation for an hour and then filtered under vacuum. The filter cake obtained was rinsed with deionized water several times followed by drying at a temperature of 80 °C overnight. The solid products were calcined at 800 °C for 4 h with a heating rate of 1 min⁻¹ in static air. The catalysts obtained were labeled as Ni/CaAlO_x(A:B), where A:B represented the mole ratio of Ca to Al.

2.2. Catalyst characterization

BET surface area of the fresh catalysts was analyzed by N₂ adsorption and desorption isotherms on a Quanta chrome Autosorb-1. X-ray diffraction (XRD) analysis was carried out by using a SIEMENS D5000 in the range of 10–70° with a scanning step of 0.02° using Cu Kα radiation (0.1542 nm wavelength). A scanning electron microscope (SEM) (LEO 1530) coupled to an energy dispersive X-ray spectroscopy (EDXs) system was used to investigate the surface morphology and the element distributions of the catalysts. Temperature programmed reduction (TPR) using H₂ was employed to analyze the reduction behavior of the fresh catalysts by using a modified thermogravimetric analyzer (SDT Q600); during the TPR experiment, fresh catalysts were loaded in an alumina pan and placed in the thermogravimetric analyzer furnace which was purged by a gas flow containing 15% H₂ and 85% N₂ with a flow rate of 100 ml min⁻¹, and heated from room temperature to 900 °C at a heating rate of 10 °C min⁻¹.

Temperature-programmed oxidation (TPO) of the reacted catalysts was carried out using a Stanton–Redcroft thermogravimetric analyzer (TGA and DTG) to determine the properties of the reacted catalysts. About 10 mg of the reacted catalyst was heated in an atmosphere of air at 15 °C min⁻¹ to a final temperature of 800 °C, with a dwell time of 10 min.

2.3. Experimental process

Pyrolysis-reforming of biomass was carried out with a fixed bed, two-stage reaction system. The first stage involved pyrolysis of the biomass and the pyrolysis gases were passed directly to the second stage where catalytic reforming took place as reported in our previous work [32]. During the experiment, N₂ (80 ml min⁻¹) was used as carrier gas. 0.5 g of biomass was placed inside a crucible and held in the first pyrolysis reactor. 0.25 g of sand or catalyst was placed in the second reactor. The temperature of the second reactor was initially heated to the set point (800 °C). Then the first reactor was heated to the pyrolysis temperature (500 °C) at a heating rate of 40 °C min⁻¹ and kept at that temperature for 30 min. Water for steam reforming was injected into a location between the two reactors with an injection rate of 0.05 g min⁻¹ when the temperature of the pyrolysis reactor reached 150 °C.

The products from pyrolysis/catalytic reforming were cooled using air and dry ice to collect the condensed liquid. Non-condensed gases were collected using a Tedlar™ gas sample bag. Around 20 min more time was allowed to collect the non-condensed gases to ensure complete reaction. The amounts of injected water and the condensed liquid were calculated by weighing the syringe and condensers before and after the experiment, respectively. Experiments were repeated to ensure the reliability of the results.

Non-condensed gases collected in the Tedlar™ gas sample bag were analysed off-line by gas chromatography (GC). H₂, CO and N₂ were analyzed with a Varian 3380 GC on a 60–80 mesh molecular sieve column with argon carrier gas, whilst CO₂ was analyzed by

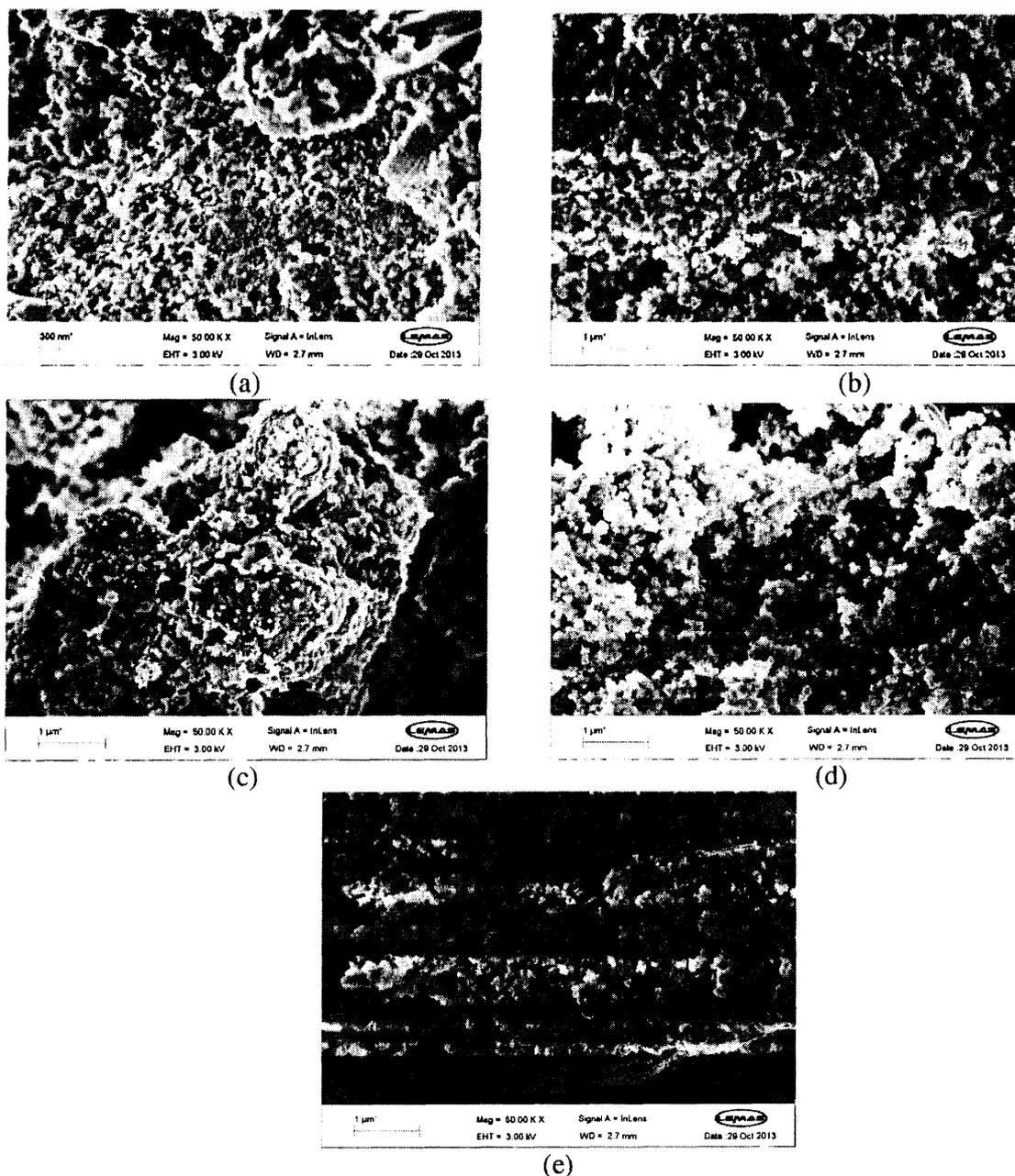


Fig. 2. SEM images of the fresh Ni/CaAlO_x catalysts. (a) Ni/CaAlO_x (1:3); (b) Ni/CaAlO_x (1:2); (c) Ni/CaAlO_x (1:1); (d) Ni/CaAlO_x (2:1); (e) Ni/CaAlO_x (3:1).

another Varian 3380 GC on a HayeSep 80–100 mesh column with argon carrier gas. C₁–C₄ hydrocarbons were analyzed using a Varian 3380 gas chromatograph with a flame ionization detector, with an 80–100 mesh HyeSep column with nitrogen carrier gas.

3. Results and discussion

3.1. Textural properties of Ni/CaAlO_x catalysts

The BET surface areas of the Ni/CaAlO_x catalysts were between 46 and 83 m² g⁻¹ and are reported in Table 1. It seems that the BET surface area did not change proportionally with the increase of Ca content in the catalyst support.

XRD patterns of the Ni/CaAlO_x catalysts shown in Fig. 1 may be used to identify the crystal species present in the catalysts. It can be

seen that the main phases on the catalysts were CaO, Ca(OH)₂, NiO, and NiAl₂O₄. NiO was present as separated metal particles and there were no detectable alloyed or inter-metallic Ca–Ni nanoparticles present. It should be noted that the catalysts were not pre-reduced prior to the experiments, and the NiO particles will be converted into active Ni particles by the produced H₂ and CO during the process of pyrolysis-reforming of biomass [33]. The diffraction peaks at 2 theta values of 32.2°, 53.9°, 64.2° and 67.5° were identified as CaO, and the diffraction peaks at 2 theta positions of 18.1°, 28.7°, 34.2°, 47.2° and 50.9° were identified as Ca(OH)₂. Ca(OH)₂ present on the catalysts may be derived from the hydrolysis of CaO by ambient moisture in the environment [34]. It was noted that CaCO₃ was not observed from XRD analysis of all the fresh catalysts. It has been reported that carbonation of CaO is slower compared with rapid hydration and the generated Ca(OH)₂ layer may act as a protective

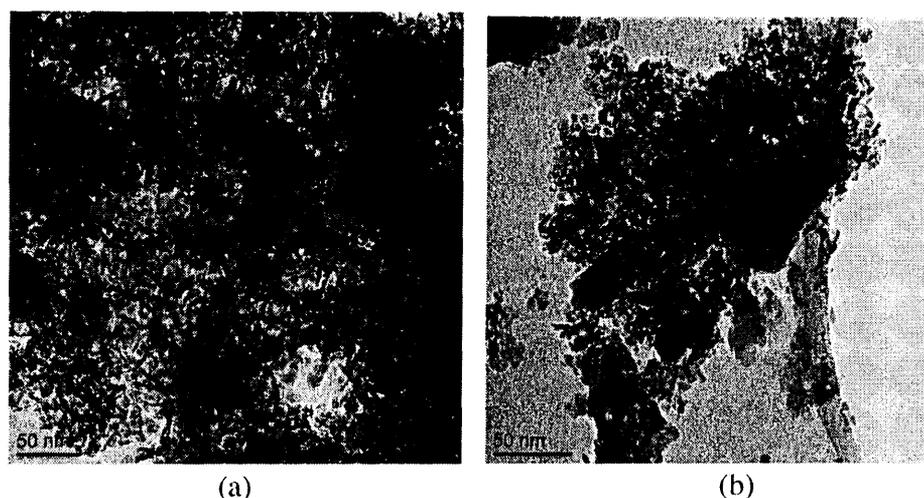


Fig. 3. TEM images of the fresh Ni/CaAlO_x catalysts. (a) Ni/CaAlO_x (3:1); (b) Ni/CaAlO_x (1:1).

layer to prevent carbonation of CaO [34]. The diffraction peaks at 2 theta values of 37.3°, 43.3°, and 62.9° are assigned to NiO. The broad characteristics of the NiO peaks demonstrated a low crystallinity and high distribution of metal phases. In addition, the diffraction peaks at 2 theta values of 37.0°, 45.0°, 59.6° and 65.5° were assigned to NiAl₂O₄.

With the increase of Ca content changing from the Ni/CaAlO_x (1:3) to Ni/CaAlO_x (3:1), the peak intensity of CaO and Ca(OH)₂ increased. In contrast, the peak intensity and position of NiO barely changed when the Ca/Al ratio was increased from 1:3 to 3:1, indicating that there were only slight differences of size and distribution of NiO for the catalysts with different Ca contents. This corresponds with the calculated sizes of NiO particles (around 10 nm) from XRD analysis (Table 1). However, it was reported that the size of NiO can range widely over many nanometers depending on the composition of the catalysts [35,36]. Wu et al. [37] have reported that when using Ni/La₂O₃ prepared by impregnation methods for glycerol steam reforming, the partial substitution of La by Ca caused gradual increase of Ni particle size and significantly affected catalyst metal dispersion. Elias et al. [38] reported that Ni–Ca/Al₂O₃ catalyst prepared by impregnation method has an increased size of Ni with the increasing of Ca content. It is demonstrated that the addition of Ca in the Ni/CaAlO_x prepared by co-precipitation method in this work may favor size uniformity and dispersion of Ni, which are beneficial for catalytic reactions for syngas production from thermo-chemical conversion of biomass, as more active catalytic sites are available. High metal dispersion in the Ca-added catalysts prepared by co-precipitation makes Ca a promising candidate as a catalyst promoter. In addition, maintaining the size of active sites in the Ni/CaAlO_x catalyst enables a controlled investigation into the influence of different amounts of

Ca addition to the catalyst in relation to syngas production with little interference from the particle size of the active metal sites.

Fig. 2 shows SEM images of the fresh Ni/CaAlO_x catalysts. The surfaces of the catalysts were covered with fine spherical particles. The size of the spheres was around 100 nm. Limmanee et al. [34] have reported that substitution of Mg²⁺ and Zn²⁺ with Ca²⁺ resulted in highly dispersed metal oxide crystallites at a calcination temperature of 800 °C. The spheres are assumed to be a mixture of NiO, Ca(OH)₂, CaO and Ni-spinels. Furthermore, holes with different sizes were found on the surface of the catalysts, which could be attributed to the release of CO₂ during catalyst calcination [39]. In order to observe the catalyst structure, TEM images of selected catalysts with the ratio of Ca/Al of 1:1 and 3:1 are shown in Fig. 3. For the Ni/CaAlO_x (3:1) catalyst, it can be clearly seen that the surface was dominantly covered by rod-shaped Ca(OH)₂ with a size of around 15 nm, and NiO with a size of 10 nm which were sparsely embedded. This is in accordance with the crystal size calculated by XRD analysis (Fig. 1), which shows a particle size of about 18.1 nm for Ca(OH)₂ and 9.3 nm for NiO, respectively. For the Ni/CaAlO_x (1:1) catalyst, Ca(OH)₂ exhibited a spherical shape with a size of around 15 nm. NiO particles on the surface of the Ni/CaAlO_x (1:1) catalyst have a similar size with that on the surface of the Ni/CaAlO_x (3:1) catalyst, i.e., around 10 nm. The sizes of particles on the surface of the Ni/CaAlO_x (1:1) catalyst observed by TEM are also consistent with the XRD analysis, i.e., 15.3 nm for Ca(OH)₂ and 9.0 nm for NiO, respectively. It is further suggested that the increasing content of Ca in the catalysts increased the size of Ca(OH)₂, however it has little influence on the size of the active nickel-based phase in the Ni/CaAlO_x catalysts.

The reducibility of Ni/CaAlO_x catalysts with various Ca/Al molar ratios was investigated by H₂-TPR, and the reduction profiles are shown in Fig. 4. All the fresh catalysts are characterized by three

Table 1
Composition, particle size and surface areas of the Ni/CaAlO_x catalysts.

Catalyst	Molar ratio (Ca/Al)	Metal molar composition (wt.%) ^a				Particle size (nm) ^b			BET surface area (m ² g ⁻¹)
		NiO	CaO	Al ₂ O ₃	Ca(OH) ₂	CaO	NiAl ₂ O ₄	NiO	
Ni/CaAlO _x	1:3	26.4	19.7	53.9	14.0	15.6	19.5	9.7	64.6
	1:2	26.3	26.1	47.6	15.0	17.1	11.9	11.3	83.0
	1:1	25.9	38.8	35.3	15.3	16.2	13.2	9.0	46.8
	2:1	25.6	51.1	23.2	16.6	13.3	–	10.8	61.0
	3:1	25.5	57.1	17.3	18.1	19.4	–	9.3	46.3

^a Molar ratio was obtained from calculation of catalyst preparation.

^b Particle size was calculated from XRD analysis using the Scherrer equation.

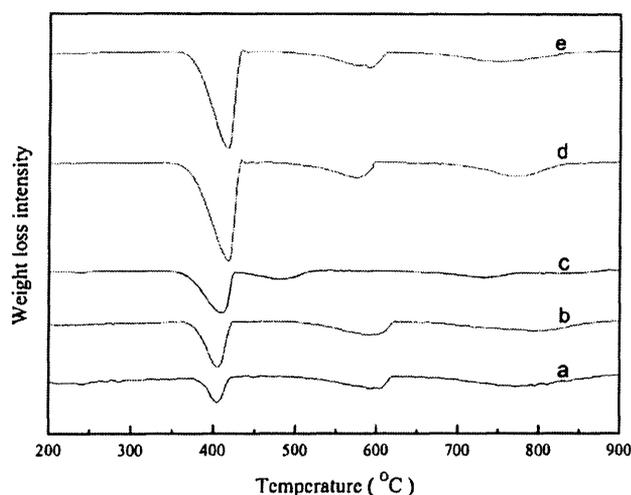


Fig. 4. TPR results of the Ni/CaAlO_x catalysts: (a) Ni/CaAlO_x (1:3); (b) Ni/CaAlO_x (1:2); (c) Ni/CaAlO_x (1:1); (d) Ni/CaAlO_x (2:1); (e) Ni/CaAlO_x (3:1).

main reduction peaks: the first peak is centered at around 400 °C which might be assigned to the reduction of bulk NiO oxides [40]. The second reduction peak between 450 and 600 °C might be attributed to complex NiO species which have stronger interaction with the CaO modified Al₂O₃ support [41]. The third reduction peak around 800 °C could result from the reduction of NiAl₂O₄ spinel phases [42–44]. For the Ni/CaAlO_x (1:3) catalyst with 19.7% CaO content, the intensities of the three peaks were similar, indicating that the three fractions of NiO species were evenly distributed. However, with the stepwise increase of CaO content to around 50%, the relative intensity of reduction peaks for bulk NiO showed an obvious increase. It indicates that the increase of Ca content in the Ni/CaAlO_x catalysts contributes to the increase of the fraction of bulk NiO species. Wu et al. [40] reported that the presence of an excess amount of Ca (Ca/Ni ≥ 0.2) in a Ni–Ca/Al₂O₃ catalyst prepared by impregnation method covered the surface of the Al₂O₃ support and hindered the interaction between Ni and support [41]. In this work, the increase of Ca content might occupy more surface area of the alumina support and reduce the interactions between Ni and the catalyst support; thus resulting in an increase in the fraction of bulk Ni-species with the increase of Ca content. In addition, the reducibility of a Ni–Al catalyst was reported to be increased by adding La metal [45].

3.2. Pyrolysis/steam reforming of sawdust over Ni/CaAlO_x catalysts

Catalytic steam reforming of pyrolysis product gases derived from biomass sawdust pyrolysis was carried out at 800 °C to evaluate the performance of the developed catalysts with different Ca/Al molar ratios. The mass balance calculated for each experiment is shown in Table 2. Char residue was obtained in the pyrolysis stage. The yield of char residue in terms of the amount of biomass sam-

Table 2
Mass balance for pyrolysis catalytic steam reforming of biomass using Ni/CaAlO_x catalyst.

Catalyst Bed	Sand	Catalyst with different Ca/Al ratios				
		1:3	1:2	1:1	2:1	3:1
Gas/biomass (wt.%)	32.99	55.42	65.2	55.87	63.45	57.57
Residue char/biomass (wt.%)	38.75	36.25	37.5	37.5	37.5	37.5
Mass balance (wt.%)	103.25	104.29	97.03	95.69	98.67	95.95
H ₂ Yield (mmol H ₂ g ⁻¹ biomass)	2.36	12.97	15.57	15.3	15.37	14.32
H ₂ /CO molar ratio	0.38	1.51	1.08	1.63	1.25	1.01

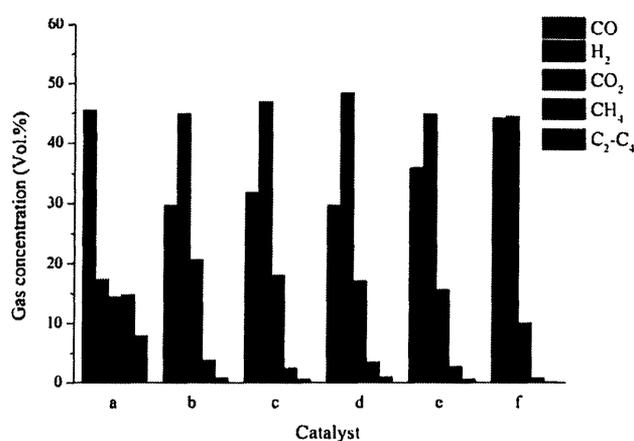
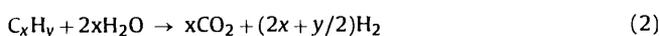


Fig. 5. Gas compositions and fractions from biomass gasification on the sand and Ni/CaAlO_x catalysts. (a) sand; (b) Ni/CaAlO_x (1:3); (c) Ni/CaAlO_x (1:2); (d) Ni/CaAlO_x (1:1); (e) Ni/CaAlO_x (2:1); (f) Ni/CaAlO_x (3:1).

ple is around 38 wt.% for all the experiments, as the pyrolysis stage was not affected by the type of catalyst downstream. Compared with pyrolysis-reforming of biomass without catalyst (using sand), it was found that with the addition of catalyst, the yields of total gas and hydrogen greatly increased, from around 30 to 50 wt.% and from 2 to >10 mmol g⁻¹ biomass, respectively. It is difficult to determine a clear influence of Ca content on total gas yield from Table 2. Quincoces et al. [46] has also reported that there were no important influences of Ca addition on methane reforming; It was suggested that small modifications of crystal size were obtained for Ni–Al catalyst containing different amounts of Ca, which is consistent with our results in relation to the changes of crystal size as presented in Table 1. However, the highest gas yield (65.2 wt.%) was obtained using the Ni/CaAlO_x (1:2) catalyst, which might be related to the catalyst with the highest BET surface area (Table 1), which promoted more contact between reactants and catalytic sites. In addition, the Ni/CaAlO_x (1:1) catalyst showed a lower gas yield (55.87 wt.%) compared with the Ni/CaAlO_x (1:2) and the Ni/CaAlO_x (2:1) catalysts, which might also be due to the Ni/CaAlO_x (1:1) catalyst which had a lower BET surface area (Table 1).

From Table 2, it seems that hydrogen production was increased slightly from 12.97 to 15.57 mmol g⁻¹ biomass, when the catalyst was changed from the Ni/CaAlO_x (1:3) to the Ni/CaAlO_x (1:2); with the further increase of Ca content, the hydrogen production was reduced slightly to 14.32 mmol g⁻¹ biomass using the Ni/CaAlO_x (3:1) catalyst.

The performance of the catalyst during biomass pyrolysis-reforming was also compared using the product gas concentrations (N₂ carrier gas free), as shown in Fig. 5. In the absence of catalyst, CO concentration was about 45 vol.% and H₂ concentration was about 18 vol.%. In the presence of Ni/CaAlO_x catalyst, the concentration of H₂ increased markedly to about 45 vol.%, and the concentration of CO reduced to about 30 vol.% (except for the Ni/CaAlO_x (3:1) catalyst). It is suggested that the water gas shift reaction (Reaction (1)) was significantly enhanced by the introduction of the catalysts for the reforming of primary products from pyrolysis-reforming of wood sawdust [24,47]. In addition, the concentrations of hydrocarbon gases (CH₄ and C₂–C₄) were largely reduced as shown in Fig. 5 in the presence of catalyst, indicating steam reforming of hydrocarbons (Reaction (2)) was effectively promoted by adding the Ni-based catalyst prepared in this work.





Hydrogen concentration was slightly changed when the catalysts with different Ca/Al molar ratios were used for thermo-chemical conversion of biomass. From Fig. 5, CO concentration increased from about 30 to 45 vol.%, and CO₂ concentration reduced from 20 to 12 vol.%, when the molar ratio of Ca/Al was increased from 1:3 to 3:1 for the Ni/CaAlO_x catalyst; this might be ascribed to the inhibition of the water gas shift reaction (WGSR) (Reaction (1)). In addition, the reduction of CO₂ concentration with the increase of Ca content might be due to the promotion of CO₂ reforming reactions (e.g., Reaction (3)). It is known that the acidic sites of nickel-based alumina catalysts resulted in coke deposition during reforming reactions [48]. The addition of Ca into a Ni–Al catalyst has been reported to significantly increase the basicity of the catalyst [49]. In this work, it is suggested that the increase of basic sites promoted the methane dry reforming reaction (Reaction (3)) with the increase of Ca content in the Ni/CaAlO_x catalyst; this is consistent with the other report, where CO₂ conversion was enhanced during methane dry reforming by increasing the Ca content in a Ni–Ca-based catalyst [41].

Here, it is suggested that the addition of Ca promoted the metal dispersion and affected the equilibrium through adsorption on the enhanced basicity sites. NiO and NiAl₂O₄ (as identified in the XRD analysis of the fresh catalysts, Fig. 1) have been reported to provide active Ni sites for methane dry reforming [50]. From the TPR analysis of the fresh catalysts, it seems that the fraction of NiO species was increased with the increase of Ca addition. Therefore, it is proposed that in this work, NiO species play key roles to provide active sites for methane dry reforming (Reaction (3)) and possibly other hydrogen carbon reforming reactions for CO production. Ni has also been reported as active sites for the WGSR [51]; however, the increase of NiO fraction in the catalyst with the increase of Ca addition did not enhance the WGSR. Here we suggested that the water gas shift reaction has been significantly affected by the basicity of the catalyst introduced by the addition of Ca.

From Fig. 5, it is demonstrated that the concentration of syngas (H₂ and CO) was about 80 vol.% using the Ni/CaAlO_x (1:3) catalyst, and increased to about 90 vol.% when the Ca/Al molar ratio was increased to 3:1 (the Ni/CaAlO_x(3:1) catalyst), while the concentration of H₂ was almost constant. In addition, with the addition of the catalyst, the H₂/CO molar ratio increased significantly to about 1.63 from 0.38. A range of H₂/CO molar ratio between 1.01 and 1.63 was obtained using different Ni/CaAlO_x catalysts (Table 2). It is therefore suggested that using the Ni/CaAlO_x catalyst prepared in this work the H₂/CO molar ratio in syngas can be manipulated, by controlling the content of Ca in the catalyst system; since it appears that the selectivity to CO or CO₂ was related to the Ca content in the Ni/CaAlO_x catalyst.

3.3. Coke formation analysis using temperature programmed oxidation

Coke deposition is one of the most problematic factors causing catalyst deactivation during catalytic thermo-chemical conversion of biomass [52,53]. The characteristics of coke formation on the reacted Ni/CaAlO_x catalysts were investigated using temperature programmed oxidation (TPO). Fig. 6 shows TGA results of TPO analysis for the reacted catalysts. It can be seen that two types of carbon were formed on the surface of the majority of the reacted catalysts corresponding to a two-stage weight loss. For all the catalysts except the Ni/CaAlO_x (1:3), the weight loss which occurred at around 410 °C might be assigned to the oxidation of amorphous carbons. The weight loss at higher oxidation temperature (around 600 °C) might be assigned to filamentous carbon [54]. However the reacted Ni/CaAlO_x (1:3) catalyst showed a three-stage weight

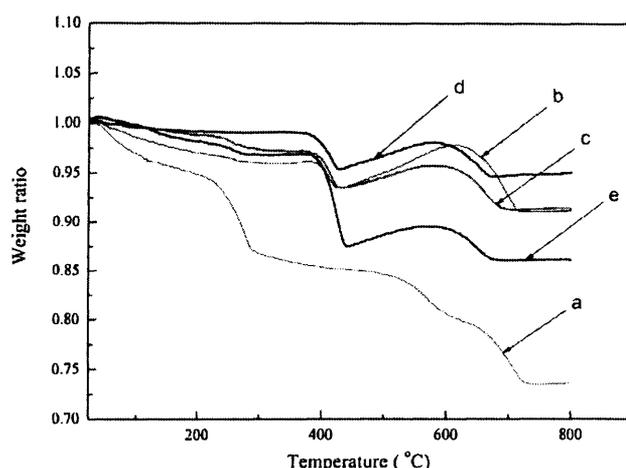


Fig. 6. TPO analyses of reacted Ni/CaAlO_x catalysts: (a) Ni/CaAlO_x (1:3); (b) Ni/CaAlO_x (1:2); (c) Ni/CaAlO_x (1:1); (d) Ni/CaAlO_x (2:1); (e) Ni/CaAlO_x (3:1).

loss in the TPO analysis, which occurred at around 270, 560 and 710 °C, respectively. The weight loss around 400 °C was normally deemed as heavy hydrocarbon depositions, and the one at 560 °C may be attributed to the oxidation of amorphous carbons [47,55]; the weight loss at around 710 °C for the reacted Ni/CaAlO_x (1:3) catalyst can be assigned to filamentous carbons for the reacted Ni/CaAlO_x (1:3) catalyst [53,56]. It is noted that weight increase was observed at around 550 °C from Fig. 6 in particular for the catalysts with high Ca content, demonstrating that oxidation of Ni might have occurred during the TPO analysis. It is known that Ni could be produced from the reduction of NiO during the pyrolysis-reforming reactions.

It was reported that high dispersion of nickel metal particles and the basicity of the support surface benefited the resistance to coke deposition, since water splitting into hydroxyl (OH⁻) groups could be enhanced during reforming reactions due to the high nickel dispersion and support basicity, which thus promoted carbon elimination reaction with hydroxyl groups [14]. The use of Ni/Al₂O₃ catalysts in the thermo-chemical conversion process is known to have problems of coke deposition on the surface of the catalyst due to the presence of acid sites [48]. In this work, Ca was added to the catalyst system to improve the catalyst basicity in order to reduce coke formation during pyrolysis-reforming of biomass. It is reported that the increase of basicity of a catalyst by adding Ca could promote steam-coke reactions, which resulted in a decrease of coke deposition on the surface of the catalyst during the steam reforming of biomass [49]. The reacted Ni/CaAlO_x (1:3) catalyst showed the highest coke formation (about 20 wt.%); this might be because the Ni/CaAlO_x (1:3) catalyst has the lowest alkaline metal (Ca) addition which corresponded to the lowest catalyst basicity compared with the other Ni/CaAlO_x catalysts. The amount of coke deposition on the surface of the reacted catalyst was estimated from the weight loss of reacted catalysts from the TPO analysis, with the assumption that the weight increase from Ni oxidation was insignificant.

For the other reacted Ni/CaAlO_x catalysts, coke formation was less than 10 wt.% of the weight of the reacted catalyst. It seems that the coke deposition on the surface of the reacted catalyst was reduced when the Ca/Al molar ratio was increased from 1:3 to 3:1. However, as shown in Fig. 6, amorphous carbon was largely formed on the reacted Ni/CaAlO_x (3:1) catalyst (weight loss around 400 °C), indicating that there might be an optimal content of Ca addition to the catalyst in order to minimize coke formation. Amorphous carbons are known to easily deactivate catalyst by encapsulating catalytic active sites.

4. Conclusions

As an alkaline metal, Ca is attractive to promote catalytic activity in thermo-chemical conversion of biomass due to its low cost and high abundance in nature. In this study, a series of Ni/CaAlO_x catalysts promoted by different contents of Ca were prepared by co-precipitation method, and were investigated for H₂-enriched syngas production from the pyrolysis-reforming of sawdust biomass. The following conclusions were proposed:

- (1) High dispersion of NiO particles was obtained within the Ni/CaAlO_x catalysts. With the increase of Ca/Al molar ratio from 1:3 to 3:1, the particle size of NiO remained constant at around 10 nm, while the reducibility of the Ni/CaAlO_x catalysts increased according to TPR analysis.
- (2) The catalytic performance in terms of total gas yield and hydrogen production was not closely related to the content of Ca in the catalyst. The total gas yield might depend on the surface area of the catalyst. The Ni/CaAlO_x (1:3) catalyst showed the lowest gas production; this might be due to the severe catalyst deactivation which resulted from coke deposition which was supported from TPO analysis.
- (3) It was clearly demonstrated that the increase of Ca content resulted in the increase of CO selectivity and the decrease of CO₂ selectivity.
- (4) A total concentration of 90 vol.% syngas (H₂ + CO) could be obtained using the Ni/CaAlO_x (3:1) catalyst. In addition, the H₂/CO ratio could be controlled between 1.01 and 1.63 by varying Ca content while H₂ concentration in the syngas remained almost constant. This is particularly important in relation to the manipulation of syngas composition for downstream applications

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