

**DEVELOPMENT OF LOW-COST GREEN
ABSORBENTS FOR CARBON DIOXIDE
ABSORPTION FROM A POST-COMBUSTION
SYSTEM**

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ABSORPTION FROM A POST-COMBUSTION
SYSTEM**

by

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Submitted

in fulfillment of the requirements of the degree of Doctor of Philosophy

to the



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DEDICATED TO
MY PARENTS
&
MY IN-LAWS

CERTIFICATE

This is to certify that the thesis entitled “**Development of Low-Cost Green Absorbents for Carbon Dioxide Absorption From a Post-Combustion System**” being submitted by **Amita Chaudhary** to the Department of Chemical Engineering, Indian Institute of Technology, New Delhi, in fulfillment of the requirements for the award of the degree of **Doctor of Philosophy** in Chemical Engineering, is a record of bonafide work carried out by her. She has worked under my guidance and supervision and has fulfilled the requirements, which to my knowledge have reached the requisite standard for the submission of the thesis.

The research report and results presented in this thesis have not been submitted, in part or full, to any other university or institute for the award of any degree or diploma.

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Abstract

This research presents the development of a series of low-cost Protic Ionic Liquids (PILs) for CO₂ gas absorption from a post-combustion system. The PILs were synthesized by proton transfer from Bronsted acid to Bronsted base. The structures of the synthesized protic ionic liquids were elucidated using FT-IR, ¹H NMR, ¹³C NMR, and mass spectroscopy. Experimentally physico-chemical properties of pure Triethylenetetrammonium lactate ([TETA] [Lactate]) were evaluated at different temperatures ranging from 298K to 363K.

Studies of CO₂ -absorption capacity were carried at ambient conditions in 0.5 M aqueous solution of [TETA] [Lactate]. The experiment proved a very good efficiency of 1.92 mol mol⁻¹ of CO₂ when the CO₂ was bubbled discontinuously, whereas in continuous bubbling it showed only 1.57 mol of CO₂ absorbed per mol of [TETA] [Lactate].

The kinetics of CO₂-absorption in aqueous solutions of [TETA] [Lactate] was studied in a stirred-tank contactor with a plane interface. The operating variables considered in this study were the initial concentration of [TETA] [Lactate] and the temperature of the absorbing solution. Specific absorption rates were determined under different experimental conditions. Results indicate that the absorption process takes place in a fast reaction regime and the reaction exhibited pseudo first-order kinetics. The reaction rate constant was determined by performing the measurement of the kinetics at different temperatures and by making the Arrhenius plot for the CO₂-absorption in [TETA] [Lactate] solutions. The consequence of variance in lean-CO₂ gas flow-rate and [TETA] [Lactate] concentration in the liquid phase were also analyzed in detail for the CO₂-absorption.

The present work also examined the CO₂-absorption in aqueous solutions of [TETA] [Lactate] in a foam-bed reactor (FBR). Experimental results show that in foam-

bed reactor the synthesized PIL, i.e. [TETA] [Lactate], shows higher CO₂-absorption rate. The effect of surfactant used on the overall mass-transfer coefficient in absorption process was also determined experimentally. In addition, the effect of different operating variables like types of surfactant, surfactant concentration, lean gas flow-rate, CO₂ flow-rate, height of foam-bed, and initial concentration of [TETA] [Lactate] upon the volumetric mass-transfer coefficient and subsequently, on carbon-dioxide absorption rate were studied.

The carbon-dioxide absorption rate obtained in a bubble-column reactor has been compared with that of a foam-bed reactor. Up to 18% higher absorption rate are obtained in a foam-bed reactor.

Further, regeneration of CO₂-saturated [TETA] [Lactate] solutions was done thermally with continuous bubbling of N₂ gas in a semi-batch process. The regeneration rate was measured as a function of temperature and flow rate of N₂ gas through the solution in a semi-batch process. The studies reveal that regeneration rate increased with increase in temperature from 343 K to 383K and then it is leveled off. The increased flow-rate of N₂ gas further enhanced the regeneration rate at the given temperature. In the recycling studies, it was proved that [TETA] [Lactate] could be reused with simultaneous absorption and desorption for continuous three cycles with the same capacity and then the CO₂-absorption capacity slightly decreased from 0.65 to 0.59 mol mol⁻¹ in next five cycles. Later, in the ninth cycles, its capacity was coming to 0.46 mol mol⁻¹ which is comparable to first cycle CO₂-absorption of 30% MEA (0.55 mol mol⁻¹).

The corrosion studies were done on different metals using two standard methods, viz. Electrochemical and Weight-loss method. The results were interpreted using polarization curves, SEM, and EDX techniques. Linear polarization plots showed that an increasing the concentration of [TETA] [Lactate] from 0.1 to 0.5 kmol m⁻³ in 4. kmol m⁻³ MEA solutions the corrosion rate decreased from 3.98 mmpy to 0.086 mmpy which further supported by the

polarization resistance calculations. There was an increment in polarization resistance with an increase [TETA] [Lactate] concentration in CO₂-loaded solution. The anodic Tafel slope (β_a) and cathodic Tafel slope (β_b) of CO₂ loaded 4.0 kmol m⁻³ MEA decreased with increasing [TETA] [Lactate] concentration, indicating that the [TETA] [Lactate] inhibited the corrosion. At last, the experimental results were compared with the predictions of the theoretical model of a foam - bed reactor. The comparison of the experimental data with theory showed that the conversions obtained experimentally were higher than those predicted by the model. Due to the increase in viscosity of the solution of ionic liquid with reaction, the model failed to predict the experimental data beyond 5 minutes of the reactor operation, because the single stage model is valid only for absorbing liquids having constant low viscosities.

Lastly, the precursors cost of synthesized [TETA] [Lactate] was compared with the conventional ionic liquids precursors cost from Sigma Aldrich. [TETA] [Lactate] is comparably of low-cost and less toxic in terms of negligible vapor pressure and solvent lose.

सार

यह शोध दहन के बाद के सिस्टम से CO₂ गैस के अवशोषण के लिए कम लागत वाली प्रोटोनिक आयोनिक तरल पदार्थ (PIL) की एक श्रृंखला के विकास को प्रस्तुत करता है। जनहित याचिका को ब्रॉस्टेड एसिड से ब्रॉस्टेड बेस में प्रोटॉन ट्रांसफर द्वारा संश्लेषित किया गया था। संश्लेषित प्रोटी आयनिक तरल पदार्थों की संरचनाओं को एफटी-आईआर, 1 एच -एनएमआर, 13 सी- एनएमआर, और मास स्पेक्ट्रोस्कोपी का उपयोग करके अलग किया गया था। प्रायोगिक तौर पर शुद्ध ट्राइएथिलनेटेट्रामोनियम लैक्टेट (टेटा [लैक्टेट]) के भौतिक-रासायनिक गुणों का मूल्यांकन अलग-अलग तापमान पर किया गया था।

CO₂ के अभिसरण क्षमता के अध्ययनों को परिवेशीय परिस्थितियों में [TETA] [लैक्टेट] के 0.5 M जलीय घोल में किया गया। CO₂ को 1.92 mol mol⁻¹ की बहुत अच्छी दक्षता साबित हुई जब CO₂ को बंद कर दिया गया, जबकि लगातार बुदबुदाहट में यह केवल 1.57 mol CO₂ को अवशोषित करता है जो कि टेटा [लैक्टेट] के प्रति मोल को अवशोषित करता है।

टेटा [लैक्टेट] के जलीय घोल में CO₂-अवशोषण के कैनेटीक्स को एक जानने वाला इंटरफेस के साथ एक हलचल-टैंक संपर्ककर्ता में अध्ययन किया गया था। इस अध्ययन में विचार किए गए ऑपरेटिंग चर टेटा [लैक्टेट] की प्रारंभिक एकाग्रता और अवशोषित समाधान का तापमान थे। विशिष्ट प्रयोगात्मक दरों के तहत विशिष्ट अवशोषण दर निर्धारित की गई थी। परिणाम बताते हैं कि अवशोषण प्रक्रिया एक तेज प्रतिक्रिया शासन में होती है और प्रतिक्रिया ने छद्म प्रथम-क्रम कैनेटीक्स का प्रदर्शन किया। विभिन्न तापमानों पर कैनेटीक्स का मापन करके और टेटा [लैक्टेट] समाधानों में CO₂-अवशोषण के लिए ऐरहेनियस प्लॉट बनाकर प्रतिक्रिया दर स्थिर निर्धारित की गई थी। CO₂ गैस प्रवाह-दर और टेटा [लैक्टेट] में विचरण में तरल चरण में सांद्रता का भी CO₂-अवशोषण के लिए विस्तार से विश्लेषण किया गया।

वर्तमान कार्य ने फोम-बेड रिएक्टर (FBR) में टेटा [लैक्टेट] के जलीय घोलों में CO₂ के अवशोषण की जांच की। प्रायोगिक परिणाम बताते हैं कि फोम-बेड रिएक्टर संश्लेषित जनहित याचिका, यानी टेटा [लैक्टेट], उच्च CO₂-अवशोषण दर को दर्शाता है। अवशोषण प्रक्रिया में समग्र द्रव्यमान-स्थानांतरण गुणांक पर प्रयुक्त सर्फैक्टेंट का प्रभाव भी प्रयोगात्मक रूप से निर्धारित किया गया था। इसके अलावा, अलग-अलग ऑपरेटिंग चर जैसे सर्फैक्टेंट, सर्फैक्टेंट एकाग्रता, लीन गैस प्रवाह-दर, CO₂ प्रवाह-दर, फोम-बिस्तर की ऊंचाई, और टेटा [लैक्टेट] की प्रारंभिक सांद्रता पर बड़े पैमाने पर-स्थानांतरण गुणांक और बाद में, कार्बन-डाइऑक्साइड अवशोषण दर का अध्ययन किया गया।

बबल-कॉलम रिएक्टर में प्राप्त कार्बन-डाइऑक्साइड अवशोषण दर की तुलना फोम-बेड रिएक्टर से की गई है। फोम-बेड रिएक्टर में 18% तक उच्च अवशोषण दर प्राप्त की जाती है।

इसके अलावा, CO₂-संतृप्त टेटा [लैक्टेट] के उत्थान को अर्ध-बैच प्रक्रिया में N₂ गैस के निरंतर बुदबुदाहट के साथ थर्मल रूप से किया गया था। पुनर्जनन दर को सेमी-बैच प्रक्रिया में समाधान के माध्यम से एन 2 गैस के तापमान और प्रवाह दर के एक फंक्शन के रूप में मापा गया था। अध्ययनों से पता चलता है कि पुनर्जनन दर 343 K से 383K तक तापमान में वृद्धि के साथ बढ़ी और फिर इसे बंद कर दिया गया। नाइट्रोजन गैस की बढ़ी हुई प्रवाह दर ने दिए गए तापमान पर पुनर्जनन दर को और बढ़ा दिया। पुनर्चक्रण अध्ययनों में, यह साबित हुआ कि टेटा [लैक्टेट] को एक ही क्षमता के साथ लगातार तीन चक्रों के लिए एक साथ अवशोषण और वियोजन के साथ पुनः उपयोग किया जा सकता है और फिर CO₂-अवशोषण की क्षमता अगले में 0.65 से 0.59 mol mol⁻¹ से थोड़ी कम हो गई पाँच चक्र। बाद में, नौवें चक्र में, इसकी क्षमता 0.46 mol mol⁻¹ थी जो कि पहले चक्र CO₂ अवशोषण 30% एम ई ए (0.55 mol mol⁻¹) के बराबर है।

संक्षारण अध्ययन दो मानक विधियों, अर्थात का उपयोग करके विभिन्न धातुओं पर किया गया था। विद्युत और वजन घटाने की विधि। परिणाम ध्रुवीकरण घटता, एस ई एम, और ई डी एक्स तकनीक का उपयोग कर व्याख्या की गई। रैखिक ध्रुवीकरण भ्रूखंडों से पता चला है कि बढ़ते हुए टेटा [लैक्टेट] की सघनता 0.1 से 0.5 kmol m⁻³ में 4. kmol m⁻³ एम ई ए घोल में संक्षारण दर 3.98 mmpy से घटकर 0.086 mmpy हो गई है - जो ध्रुवीकरण प्रतिरोध द्वारा समर्थित है। सीओ 2-लोड समाधान में वृद्धि टेटा [लैक्टेट] एकाग्रता के साथ ध्रुवीकरण प्रतिरोध में वृद्धि हुई थी। एनोडिक Tafel slope (β_a) और CO₂ का कैथोडिक Tafel ढलान (β_b) 4.0 kmol m⁻³ MEA लोड होने के साथ टेटा [लैक्टेट] एकाग्रता में वृद्धि के साथ कम हो गया, यह दर्शाता है कि टेटा [लैक्टेट] ने संक्षारण को रोक दिया है।

अंत में, प्रयोगात्मक परिणामों की तुलना एक फोम-बेड रिएक्टर के सैद्धांतिक मॉडल की भविष्यवाणियों के साथ की गई थी। सिद्धांत के साथ प्रयोगात्मक डेटा की तुलना ने दिखाया कि प्रयोगात्मक रूप से प्राप्त रूपांतरण मॉडल द्वारा भविष्यवाणी की गई तुलना में अधिक थे। प्रतिक्रिया के साथ आयनिक तरल के समाधान की चिपचिपाहट में वृद्धि के कारण, मॉडल रिएक्टर ऑपरेशन के 5 मिनट से परे प्रयोगात्मक डेटा की भविष्यवाणी करने में विफल रहा, क्योंकि एकल चरण मॉडल केवल निरंतर कम चिपचिपाहट वाले तरल पदार्थों को अवशोषित करने के लिए मान्य है।

अन्त में, संश्लेषित टेटा [लैक्टेट] की पूर्ववर्ती लागत की तुलना सिग्मा एल्डरिच के पारंपरिक आयनिक तरल अग्रदूतों की लागत से की गई थी। टेटा [लैक्टेट] नगण्य वाष्प दबाव और विलायक खो के संदर्भ में तुलनात्मक रूप से कम लागत और कम विषाक्त है।

TABLE OF CONTENTS

Sections	Page Numbers(s)
CERTIFICATE	ii
ACKNOWLEDGEMENTS	iii
ABSTRACT	v
LIST OF FIGURES	xviii
LIST OF TABLES	xxiv
LIST OF ABBREVIATIONS	xxvii
<hr/>	
CHAPTER 1. INTRODUCTION	
<hr/>	
1.1 Motivation for Carbon Capture	2
1.2 CO ₂ Capture Systems	4
1.2.1 Post-combustion System	4
1.2.2 Pre-combustion System	5
1.2.3 Oxy-fuel Combustion System	6
1.3 Regeneration of Ionic Liquids	8
1.4 Corrosion Study of Ionic Liquids in Carbonated Solutions	8
1.5 Environmental Fates and Toxicity	9
1.6 Thesis Overview	10
<hr/>	
CHAPTER 2. LITERATURE SURVEY	
<hr/>	
2.1 Introduction of Ionic Liquids	12
2.1.1 History of Ionic Liquids	12

2.1.2	Generations of Ionic Liquids	13
2.1.3	Categorization of Ionic Liquids	14
2.1.4	Properties and Uses of Ionic Liquids	15
2.2	CO ₂ Solubility in PILs	15
2.2.1	CO ₂ -absorption in PILs with carboxylate anion	17
2.2.2	Mechanism and kinetics of CO ₂ -absorption	17
2.2.3	Theory	19
2.2.3.1	Equation and Reactions Involved in CO ₂ -absorption	20
2.2.3.2	Proposed Reaction Mechanisms of CO ₂ -absorption in [TETA] [Lactate]	23
2.3	Corrosion Studies of PILs	26
2.4	Regeneration Studies of PILs	30
2.5	Toxicity Studies of PILs	30
2.6	Foam-bed Reactor	33
2.6.1	Introduction to Foam-bed Reactor	33
2.6.2	Single-stage Mathematical Model for Foam-bed Reactor	42
	Operations	

CHAPTER 3. EXPERIMENTAL WORK

3.1	Synthesis and Characterization of Protic Ionic liquids (PILs)	47
3.1.1	Experimental Methods and Materials	48
3.1.2	Experimental Setup	48
3.1.3	Experimental Procedure	49
3.1.4	Characterization of PILs	49

3.1.4.1	Structure Elucidation by ^1H NMR, ^{13}C NMR, MS, and FT-IR	50
3.1.4.2	Moisture Determination by Karl Fisher Titrations	50
3.2	Measurements of Physico-Chemical Properties	50
3.2.1	Density Measurement	50
3.2.2	Viscosity Measurement	51
3.2.3	Surface Tension Measurement	51
3.2.4	Thermal Stability Measurement	51
3.2.5	Conductivity Measurement	51
3.2.6	pH Measurement	51
3.3	CO ₂ -absorption Studies	51
3.3.1	Experimental Setup	52
3.3.2	Experimental Procedure	52
3.3.2.1	Preliminary Absorption Experiments	53
3.3.2.2	Equilibrium CO ₂ -absorption Studies	53
3.3.2.3	Effect of Various Parameters and their Ranges	53
3.4	Studies of CO ₂ -absorption in a Semi-Batch Foam-bed Reactor	54
3.4.1	Material Used	54
3.4.2	Details of Foam-bed Reactor	55
3.4.3	Experimental Setup	56
3.4.3.1	Lean CO ₂ gas Absorption	56
3.4.3.2	Pure CO ₂ gas absorption	57
3.4.4	Experimental Procedure	58
3.4.5	Effect of Different Parameters and their Ranges	59
3.4.5.1	Effect of Surfactant	59

3.4.5.2	Liquid-holdup	60
3.4.5.3	Bubble-size Analysis	61
3.4.5.4	Surfactant-film Mass-transfer Coefficient	61
3.5	Comparison of CO ₂ -absorption studies in a Foam-bed Reactor and the Bubble-column Reactor	61
3.6	Kinetic Studies of CO ₂ -absorption in [TETA] [Lactate] solutions	61
3.6.1	Chemical and Methods Used	62
3.6.2	Details of Stirred-cell Contactor	62
3.6.3	Procedure of CO ₂ -absorption	64
3.7	Corrosion and Corrosion Inhibitor Studies	66
3.7.1	Preparation of Specimens and Solutions	66
3.7.2	Experimental Setup	67
3.7.3	Experimental Procedure	67
3.7.4	Methods for Calculating Corrosion Rates	68
3.8	Regeneration Studies of CO ₂ rich [TETA] [Lactate] solution	69

CHAPTER 4. RESULTS AND DISCUSSION

4.1	Synthesis of PILs	71
4.2	Characterization of [TETA] [Lactate]	71
4.2.1	FT-IR data	71
4.2.2	¹ H NMR	73
4.2.3	¹³ C NMR	74
4.2.4	Mass Spectrographs	76
4.3	Physico-Chemical Properties	76

4.3.1	Density	76
4.3.2	Viscosity	77
4.3.3	Surface Tension	78
4.3.4	Conductivity	79
4.3.5	Thermal Stability	80
4.3.6	pH Value	80
4.3.7	Calculated Physical Properties	81
4.3.8	Moisture Determination	83
4.4	CO ₂ -absorption Studies in Semi-batch Reactor	83
4.4.1	CO ₂ -absorption in Synthesized PILs	83
4.4.2	Equilibrium Studies of CO ₂ -absorption	86
4.4.3	Effect of Various Parameters Range or Properties on CO ₂ - absorption in Semi-batch Process	87
	4.4.2.1 Effect of Temperature	87
	4.4.2.2 Effect of dilutions of [TETA] [Lactate]	88
	4.4.2.3 Effect of Initial Concentrations of [TETA] [Lactate]	89
4.5	CO ₂ -absorption in Foam-bed Reactor	89
4.5.1	Liquid Hold-up Profile	90
4.5.2	Bubble-size Analysis	91
4.5.3	Surfactant Film Mass-transfer Coefficients	92
4.6	Effect of Various Parameters on the CO ₂ -absorption Rate	93
4.6.1	Initial Surfactant Concentrations	93
4.6.2	Gas Flow -Rate	95
4.7	Comparative Studies in Bubble-column and Foam-bed Reactor	96
4.8	Kinetics of CO ₂ -absorption in an aqueous solutions of [TETA]	96

[Lactate] using a plane-interface Stirred-cell Contactor.

4.8.1	Effect of various parameters on the rate of CO ₂ -absorption	96
4.8.1.1	Influence of Agitation on Liquid-side Mass-transfer Coefficient	97
4.8.1.2	Effect of Initial Concentration of [TETA] [Lactate]	99
4.8.1.3	Effect of Partial Pressure of CO ₂	103
4.8.1.4	Effect of Temperature on Absorption	104
4.8.1.5	Reaction Regime for CO ₂ -absorption	105
4.9	Regeneration Studies of CO ₂ -rich [TETA] [Lactate]	107
4.9.1	Effect of Temperature	107
4.9.2	Effect of Continuous N ₂ Bubbling	108
4.10	Corrosion and Corrosion Inhibitor Studies	110
4.10.1	Effect of Temperature	110
4.10.2	Effect of Initial Concentration of [TETA] [Lactate]	111
4.10.3	EDX and SEM results of CS specimen used in Corrosion-Inhibitor Studies	115
4.11	Comparative Study of CO ₂ -absorption using lean CO ₂ gas in a Foam-bed Reactor with the predictions of theoretical Single-Stage Model	116

CHAPTER 5. CONCLUSION AND RECOMMENDATIONS FOR	119
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FUTURE WORK	
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REFERENCES	126
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APPENDICES	142
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Appendix	A.	Preparation and Standardization of Solutions Used	142
	B.	Sample Analysis Techniques	144
	C.	Calibration techniques for GC and Rotameters	148
	D.	Calculation of Foam Parameters	151
	E.	Data of Corrosion Studies	156
	F.	Details of Synthesized PILs	162
<hr/> BIODATA			165

LIST OF FIGURES

Figure Number	Title	Page Number
1.1	Plot of atmospheric CO ₂ concentration (ppm) vs. year as measured at Mauna Loa, Hawaii (In-situ CO ₂ data from 1980-present)	2
1.2	Global CO ₂ emission (%) by different sectors	3
1.3	Schematic representation of Post-combustion System	5
1.4	Schematic representation of Pre-Combustion System	5
1.5	Schematic representation of Oxy-fuel Combustion System	6
2.1	Schematic representations of (a) Stirred-cell contactor with a flat interface of known area, and (b) Partial-pressure and concentration profiles of CO ₂ in the gas phase and liquid phase, respectively, during the diffusion and chemical reaction of CO ₂ in [TETA] [Lactate] solution (fast-reaction regime).	19
2.2	Single-stage Model of a Foam-bed Reactor	42
2.3	Representation of a Foam-bubble with Cross-Sectional showing Liquid Film and associated Gas Pockets	44

2.4	Idealized Liquid Film associated with Gas Pockets and Surfactant Film	45
3.1	Experimental-setup for the synthesis of PILs	48
3.2	Experimental-setup used for CO ₂ -absorption Experiments	52
3.3	Details of the Semi-batch Foam-bed Reactor	55
3.4	Diagram of Sieve plate and Distributor plate of the Foam-bed Reactor	55
3.5	Photograph of a Foam-bed Reactor (a) Upper part of reactor (b) Lower part of reactor	56
3.6	Experimental setup for Lean CO ₂ Gas Absorption	57
3.7	Experimental setup for Pure CO ₂ Gas Absorption	58
3.8	Schematic Diagram for measuring Liquid-holdup	60
3.9	Schematic representation of Stirred-cell Contactor	63
3.10	Experimental setup for CO ₂ -absorption, by Pressure- Drop Method	66
3.11	Experimental Setup for Corrosion Studies	67
3.21	Experimental setup for the Regeneration Studies of CO ₂ -saturated [TETA] [Lactate] solutions	69
4.1	Photograph of Synthesized ILs of TETA	71

4.2	FT-IR of neat [TETA] [Lactate] (a) Before CO ₂ -absorption (b) after CO ₂ -absorption	72-73
4.3	¹ H NMR of pure [TETA] [Lactate]	74
4.4	¹³ C NMR of pure [TETA] [Lactate] (a) Before CO ₂ - absorption (b) After CO ₂ -absorption	75
4.5	Mass Spectrum of pure [TETA] [Lactate]	76
4.6	Behavior of the Density of [TETA] [Lactate] with temperature	77
4.7	Variation in Viscosity of [TETA] [Lactate] with temperature	78
4.8	Variation of surface tension with temperature	78
4.9	Effect of dilution on the conductivity of [TETA] [Lactate]	79
4.10	Thermo-gravimetric analysis of pure [TETA] [Lactate]	80
4.11	Variation in pH with dilution	80
4.12	CO ₂ -absorption in the Synthesized Ionic Liquids	84
4.13	Photograph (a) TETA acetate (b) TETA oxalate and TETA benzoate after CO ₂ -absorption	85
4.14	Comparative states of synthesized ionic liquids before and after CO ₂ -absorption for 1 hour	86
4.15	Equilibrium studies of CO ₂ -absorption in 0.5 M aqueous solution of [TETA] [Lactate]	86

4.16	Effect of Temperature on CO ₂ -absorption	88
4.17	Effect of Dilution on CO ₂ -absorption	88
4.18	Effect of Initial Concentration of [TETA] [Lactate]	89
4.19	Average Liquid hold-up with height using SLS and CTAB surfactant (a)in Lean gas, (b) in Pure gas, (c) with different flow-rate of Lean CO ₂ gas and (d) with different flow-rate of Pure CO ₂ gas	90
4.20	Variation of average bubble diameter with time at different foam heights for (a) Lean CO ₂ gas absorption and (b) Pure CO ₂ gas absorption	91
4.21	Change in viscosity of storage-section solution on CO ₂ absorption (a) in water and (b) in TETAL solution	92
4.22	Effect of Initial Concentration of SLS surfactant on CO ₂ absorption	93
4.23	Effect of Initial Concentration of SDS surfactant on the overall Mass-transfer Coefficient of CO ₂ -absorption	94
4.24	Effect of Lean CO ₂ Gas flow-rate on CO ₂ -absorption	95

4.25	Comparison of a Bubble-column Reactor and a Foam-bed Reactor for CO ₂ -absorption	96
4.26	Effect of agitation speed on CO ₂ -absorption rate in 0.1 kmol m ³ [TETA] [Lactate] solution at 299K and 101.325 kPa	98
4.27	Volumetric Mass-transfer Coefficient of CO ₂ at different Agitation Speeds in 0.1 kmol m ⁻³ [TETA] [Lactate] solution at 299K and 101.325 kPa	99
4.28	Effect of initial concentration of [TETA] [Lactate] on the initial rate of CO ₂ -absorption at T = 299 K and P = 101.325 kPa; the Stirring rate in liquid phase, NL = 1.33 rps (80 rpm); the Stirring rate in gas-phase, NG = 2 rps (120 rpm).	102
4.29	Rate of decrease of CO ₂ Pressure in High Pressure Vessel	103
4.30	Initial rate of CO ₂ -absorption vs. Partial pressure of CO ₂	104
4.31	(a) The rate of CO ₂ -absorption at different temperature in 0.1 kmol m ⁻³ of [TETA] [Lactate] solution (b) Arrhenius plot for CO ₂ -absorption reaction in [TETA] [Lactate] solution	105
4.32	Effect of Temperature on Regeneration Rate of [TETA] [Lactate] solutions	108
4.33	Effect of Flow-rates of N ₂ gas at Regeneration Rate of [TETA] [Lactate] solutions	108
4.34	Recycling Studies of [TETA] [Lactate] solutions	109

4.35	SEM images of Al, CS, and SS specimens at 5.0 K Magnification after Corrosion Studies	111
4.36	Effect of Initial Concentration of [TETA] [Lactate] on the Polarization Curve in 4.0 kmol m ⁻³ MEA Solution at 303 K and 101.325 kPa	112
4.37	Effect of addition of [TETA] [Lactate] on Corrosion Rate	113
4.38	Plots of Protection Efficiency of the CO ₂ loaded solution vs. Initial Concentration of [TETA] [Lactate] loaded in the solution	114
4.39	EDX images for carbon steel sample (a) Before (b) After corrosion studies in 0.5 molar CO ₂ loaded solution	115
4.40	SEM analyses for carbon steel (1) Before (2) After corrosion studies in 0.5 molar CO ₂ loaded solution	116
4.41	Comparison of experimental data with Single-stage Model data on the CO ₂ -absorption in a Foam-bed Reactor	117

LIST OF TABLES

Table Number	Title	Page Number
1.1	Comparative Cost-estimation studies of the three Carbon Capture Systems	7
2.1	Corrosion inhibitor studies on 1018 CS in CO ₂ Loaded [TETA] [Lactate] solutions	26
2.2	Solubility of CO ₂ in Hydroxyl Ammonium Ionic Liquids at Elevated Pressures	31
2.3	Experimental data for CO ₂ -absorption Conducted at 100kPa CO ₂ Partial Pressure and 293.15 K	33
2.4	Lists of Gas Absorption Studies reported in the Foam-bed Reactor	37
3.1	Physico-Chemical Properties and their Measuring Instruments	50
3.2	Parameters influencing the CO ₂ -absorption rate	54
3.3	Dimensions of a Foam-bed Reactor and a Bubble-column Reactor	56
3.4	Dimensions of the Stirred-cell Contactor and its elements	63

4.1	FT-IR data of pure [TETA] [Lactate] (a) Before and (b) After CO ₂ -absorption	72
4.2	Henry's constant and Diffusivity constants for the aqueous solutions of [TETA] [Lactate]	82
4.3	CO ₂ -absorption data in the Synthesized PILs	84
4.4	CO ₂ - absorption capacity of pure TETAL at different temperatures	87
4.5	Calculated value of Hatta number and Enhancement factor with different concentrations of [TETA] [Lactate] at 299.15 K and 101.325 kPa	106
4.6	Calculated values of Second order Rate constant by Arrhenius plot	106
4.7	Kinetic parameters for CO ₂ -absorption at different temperatures in 0.1 kmol m ⁻³ [TETA] [Lactate] solution and at 101.325 kPa	106
4.8	Conditions for Reaction Regimes	107
4.9	Corrosion rates in different metal alloys at ambient condition calculated using the Electrochemical Linear Polarization Method	110
4.10	Corrosion rates in different metal alloys at ambient condition calculated using Weight Loss Method	111

4.11	Chemical composition of carbon steel specimen with surface area (1 cm ²)	112
4.12	Parameters extracted from the polarization curve of 4.0 kmol m ⁻³ MEA and 4.0 kmol m ⁻³ MEA with [TETA] [Lactate] with 0.5 molar CO ₂ loading and at temperature 303 K	113
4.13	Elemental analysis of 1018 CS (a) Before (b) After Corrosion Study in 0.5 molar CO ₂ loaded solution	115

LIST OF ABBREVIATIONS

A	Arrhenius Pre-exponential factor, $\text{m}^3\text{mol}^{-1} \text{s}^{-1}$
a	Volumetric Gas-Liquid Interfacial Area, m^{-1}
2a	Thickness of liquid film, m
B	Base (water)
C_A	Concentration of species A in the liquid phase in the foam film, kmol m^{-3}
C_{Ag}	Concentration of A in the gas pockets surrounding the liquid films, kmol m^{-3}
C_B	Concentration of reactant B in the liquid phase in the storage section at time t, kmol m^{-3}
C_{B0}	Initial concentration of reactant B in the liquid stream entering the storage section, kmol m^{-3}
C_{B1}	Concentration of liquid phase reactant B in the liquid draining into the foam section, kmol m^{-3}
C_{TETAL}	Initial Concentration of [TETA] [Lactate], kmol m^{-3}
CO_2	Carbon-dioxide gas
$C_{2,i}$	CO_2 concentration at G-L interface, kmol m^{-3}

CTAB	Cetyltrimethylammonium bromide ($[(C_{16}H_{33})N(CH_3)_3]Br$)
CS	Carbon Steel
CMC	Critical Micelle Concentration, mM
D_A	Diffusion coefficient of reactant A in the liquid phase, m^2s^{-1}
D_{CO_2}	Diffusion coefficient of carbon dioxide in the [TETA] [Lactate] solution, m^2s^{-1}
$D_{CO_2}^{H_2O}$	Diffusivity of CO_2 in water, m^2s^{-1}
D_S	Diameter of impeller blades in the liquid-phase, m
$D_{Stirred-cel}$	Inner diameter of stirred tank reactor, m
E_a	Activation energy, $kJ\ mol^{-1}$
E_A	Enhancement Factor
E_i	Instantaneous enhancement factor
EDX	Energy-dispersive X-ray spectroscopy
FT-IR	Fourier Transform Infrared Spectroscopy
G-L	Gas-Liquid Interface
H_{CO_2}	Henry's constant for carbon-dioxide in [TETA] [Lactate] solution
Ha	Hatta Number
ILs	Ionic Liquids

k_{la}	Volumetric mass-transfer coefficient, ms^{-1}
k_{-1}	Backward first-order reaction rate constant, s
k_2	Forward second-order reaction rate constant for the formation of the zwitterion, $\text{m}^3\text{mol}^{-1} \text{s}^{-1}$
k_{ov}	Overall pseudo-first order reaction rate constant, s^{-1}
k_B	Rate constant for the de-protonation of the zwitterion by a base, $\text{m}^3\text{mol}^{-1} \text{s}^{-1}$
k_n^2	Equals $[-(p_n + \lambda)/D_A]$, m^{-1}
K_e	Equilibrium distribution factor, dimensionless
l	Representative length of an idealized gas pocket for absorption, equals $\frac{V_B}{12K_eS}$, m
M	Total amount of reactant A, both free to diffuse and immobilized, in half the liquid film of surface area S at contact time t_c^* , k mol
M_∞	Total amount of reactant A, both free to diffuse and immobilized, in half the liquid film of surface area S after infinite time t_c^* , k mol
n	Number of moles, k mol
p_n	Equals $D_A k_n [\tan(k_n a)]/l$, s^{-1}

P_1	Equals $\frac{Q_1}{V}$, s^{-1}
P_2	Equals $\frac{Q_1 C_{B1}}{V}$, $k \text{ mol m}^{-3} s^{-1}$
Q_1	Flow rate of liquid entering the foam section, $m^3 s$
S	Surface area of a liquid film, m^2
t	Time of operation of the foam-bed reactor, s
t_c	Time of contact between the liquid film and gas pockets in the foam section, s
t_c^*	Total time of contact in the foam section, s
t_i	Time node corresponding to the i th interval, s
V	Volume of the liquid in the storage section, m^3
V_i	Volume of the liquid film in the foam section, m^3
V_B	Volume of a foam bubble, m^3
x	Spatial coordinate of a system with origin placed at the centre of the foam film, m
Y	Stoichiometric factor for B (moles of aqueous phase reactant B consumed per mole of A), dimensionless
