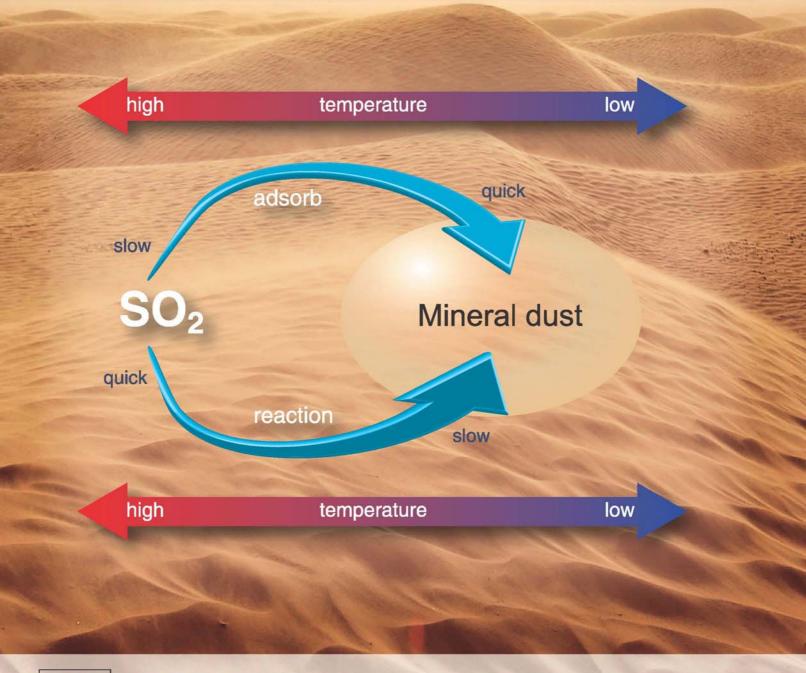


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2200	
2369	Effects of seasonal climatic variability on several toxic contaminants in urban lakes: Implications for the impacts of climate change Qiong Wu, Xinghui Xia, Xinli Mou, Baotong Zhu, Pujun Zhao, and Haiyang Dong
2379	Preparation of cross-linked magnetic chitosan with quaternary ammonium and its application for Cr(VI) and P(V) removal
	Wei Yao, Pinhua Rao, Irene M.C. Lo, Wenqi Zhang, and Wenrui Zheng
2387	Formation pathways of brominated products from benzophenone-4 chlorination in the presence of bromide ions Ming Xiao, Dongbin Wei, Liping Li, Qi Liu, Huimin Zhao, and Yuguo Du
2397	Influence of the inherent properties of drinking water treatment residuals on their phosphorus adsorption capacities
	Leilei Bai, Changhui Wang, Liansheng He, and Yuansheng Pei
2406	Radiation induced decomposition of a refractory cefathiamidine intermediate Qiburi Bao, Lujun Chen, and Jianlong Wang
2412	Characterization of aerosol optical properties, chemical composition and mixing states in the winter
	season in Shanghai, China Yong Tang, Yuanlong Huang, Ling Li, Hong Chen, Jianmin Chen, Xin Yang, Song Gao, and Deborah S. Gross
2423	Knudsen cell and smog chamber study of the heterogeneous uptake of sulfur dioxide on Chinese mineral dust
	Li Zhou, Weigang Wang, Yanbo Gai, and Maofa Ge
2434	Experimental study on filtration and continuous regeneration of a particulate filter system for heavy-duty diesel engines
	Tao Tang, Jun Zhang, Dongxiao Cao, Shijin Shuai, and Yanguang Zhao
2440	Combination of heterogeneous Fenton-like reaction and photocatalysis using $Co-TiO_2$ nanocatalyst for activation of KHSO ₅ with visible light irradiation at ambient conditions Qingkong Chen, Fangying Ji, Qian Guo, Jianping Fan, and Xuan Xu
2451	Atmospheric sulfur hexafluoride in-situ measurements at the Shangdianzi regional background station in China
2401	Bo Yao, Lingxi Zhou, Lingjun Xia, Gen Zhang, Lifeng Guo, Zhao Liu, and Shuangxi Fang
2459	Direct radiative forcing of urban aerosols over Pretoria (25.75°S, 28.28°E) using AERONET Sunphotometer data: First scientific results and environmental impact
	Ayodele Joseph Adesina, Kanike Raghavendra Kumar, Venkataraman Sivakumar, and Derek Griffith
2475	Chemical characteristics and source apportionment of atmospheric particles during heating period in Harbin, China
	Likun Huang and Guangzhi Wang
2484	Microbial community structures in an integrated two-phase anaerobic bioreactor fed by fruit vegetable wastes and wheat straw Chong Wang, Jiane Zuo, Xiaojie Chen, Wei Xing, Linan Xing, Peng Li, Xiangyang Lu, and Chao Li
2493	Persistent pollutants and the patchiness of urban green areas as drivers of genetic richness in the epiphytic moss Leptodon smithii

Valeria Spagnuolo, Flavia De Nicola, Stefano Terracciano, Roberto Bargagli, Daniela Baldantoni, Fabrizio Monaci, Anna Alfani, and Simonetta Giordano

- 2500 Enhanced removal of ethylbenzene from gas streams in biotrickling filters by Tween-20 and Zn(II)
 Lu Wang, Chunping Yang, Yan Cheng, Jian Huang, Haining Yang, Guangming Zeng, Li Lu, and
 Shanying He
- 2508 Enhanced efficiency of cadmium removal by Boehmeria nivea (L.) Gaud. in the presence of exogenous citric and oxalic acids
 Huaying Li, Yunguo Liu, Guangming Zeng, Lu Zhou, Xin Wang, Yaqin Wang, Chunlin Wang, Xinjiang Hu, and Weihua Xu
- 2517 Comparative sorption and desorption behaviors of PFHxS and PFOS on sequentially extracted humic substances
 Lixia Zhao, Yifeng Zhang, Shuhong Fang, Lingyan Zhu, and Zhengtao Liu
- 2526 Inhibitory effects of nisin-coated multi-walled carbon nanotube sheet on biofilm formation from Bacillus anthracis spores
 Xiuli Dong, Eric McCoy, Mei Zhang, and Liju Yang
- A comparative study and evaluation of sulfamethoxazole adsorption onto organo-montmorillonites Laifu Lu, Manglai Gao, Zheng Gu, Senfeng Yang, and Yuening Liu
- 2546 Removal of formaldehyde over Mn_xCe_{1 x}O₂ catalysts: Thermal catalytic oxidation *versus* ozone catalytic oxidation

 Jia Wei Li, Kuan Lun Pan, Sheng Jen Yu, Shaw Yi Yan, and Moo Been Chang
- 2554 Humic acid transport in saturated porous media: Influence of flow velocity and influent concentration Xiaorong Wei, Mingan Shao, Lina Du, and Robert Horton
- 2562 Salinity influence on soil microbial respiration rate of wetland in the Yangtze River estuary through changing microbial community
 Xue Fei Xi, Lei Wang, Jia Jun Hu, Yu Shu Tang, Yu Hu, Xiao Hua Fu, Ying Sun, Yiu Fai Tsang, Yan Nan Zhang, and Jin Hai Chen
- 2571 Comments on "Adsorption of 2-mercaptobenzothiazole from aqueous solution by organo-bentonite" by P. Jing, M.H. Hou, P. Zhao, X.Y. Tang, H.F. Wan Yuhshan Ho
- 2573 Reply to comments on "Adsorption of 2-mercaptobenzothiazole from aqueous solution by organobentonite" by Yuhshan Ho Ping Jing, Meifang Hou, Ping Zhao, Xiaoyan Tang, and Hongfu Wan



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Experimental study on filtration and continuous regeneration of a particulate filter system for heavy-duty diesel engines

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ABSTRACT

This study investigated the filtration and continuous regeneration of a particulate filter system on an engine test bench, consisting of a diesel oxidation catalyst (DOC) and a catalyzed diesel particulate filter (CDPF). Both the DOC and the CDPF led to a high conversion of NO to NO2 for continuous regeneration. The filtration efficiency on solid particle number (SPN) was close to 100%. The post-CDPF particles were mainly in accumulation mode. The downstream SPN was sensitively influenced by the variation of the soot loading. This phenomenon provides a method for determining the balance point temperature by measuring the trend of SPN concentration. © 2014 The Research Center for Eco-Environmental Sciences, Chinese Academy of Sciences. Published by Elsevier B.V.

Introduction

Diesel engines are widely used as movers for vehicles, marines and engineering machines due to its high power, high efficiency, long durability and low fuel consumption. One of the challenges for diesel engines is to reduce particulate matter (PM) and nitrogen oxidizes (NOx) simultaneously with simple and lowcost technologies. PM emissions are believed to have a series of adverse effects on human health, environment and global climate (Prasad and Bella, 2010). Many investigations indicate that ultrafine particles are airborne and penetrate deep into the lungs when breathed in, which makes them more hazardous to human health than larger particles (Peters et al., 1997; Alessandrini et al., 2006). Given the research and evidence on the adverse effects of particulates, both PM mass and particle number (PN) are limited strictly in emission regulations.

The wall-flow diesel particulate filter (DPF) is effective in removing the PM by forcing the exhaust to flow through the thin walls in the ceramic filter. To meet the Euro VI legislation for heavy-duty diesel engines, the filtration behavior for both PM mass and solid particle number (SPN) should be examined. Because of sufficient sensitivity to measure the exhaust from DPF, the SPN is used to evaluate DPF in place of mass-based method gradually (Giechaskiel et al., 2014).

In Euro VI stage, the aftertreatment of a heavy-duty diesel engine commonly consists of a diesel oxidation catalyst (DOC), a catalyzed DPF (CDPF) followed with a selective reduction catalyst (SCR) system (Cloudt and Willems, 2011; Charlton et al., 2010). The DPF system could reduce PN emission significantly (Liu et al., 2012). The trapped soot in the filter can be oxidized by NO2 to make the DPF regenerate continuously (Copper and Thoss, 1989). A high conversion rate of NO to NO₂ can be supplied by DOC and CDPF, which helps continuous regeneration achieve a high efficiency level. The NO₂ slip at the outlet of the CDPF can be reduced by the downstream SCR system. Most (or all) of the soot trapped



in the filter for HD diesel engines is burned passively by NO_2 (Johnson, 2013).

The engine-out PM is continuously trapped in the CDPF, while the trapped soot is oxidized by the continuous regeneration. At the equilibrium, the PM deposited in the filter is equal to the oxidized mass, and the soot loading of the filter remains constant (Widdershoven et al., 1986). The balance point temperature (BPT) at this equilibrium is a key parameter to evaluate the continuous regeneration performance, and usually defined as the temperature at which the pressure drop of the filter is not changed (Oi-Uchisawa et al., 2003). A DPF system with continuous regeneration should try to decrease BPT, thus the soot can be oxidized catalytically without frequent active regeneration.

In this study a DOC-CDPF integrated aftertreatment system for heavy-duty diesel engines was tested on an engine dynamometer. The effect of DOC and CDPF on NO₂ concentration was investigated and the filtration behavior for PM mass and PN was evaluated. The experiment results showed that the SPN downstream the CDPF was influenced by the soot loading in the filter, which could be used to determine the BPT.

1. Experiment and method

1.1. Engine test bench

The engine test bench with the DOC–CDPF aftertreatment system is presented in Fig. 1. The specifications of the engine are shown in Table 1. The diesel fuel used in the experiment was purchased in Beijing market with the sulfur content below 10 mg/kg.

The gaseous emissions were sampled from the raw exhaust by AVL FTIR (AVL List GmbH, Graz, Austria),

measuring hydrocarbons (HC), CO, NO, NO₂ and N₂O simultaneously. The PM mass and SPN were measured using AVL SPC472 and AVL CPC489 (AVL List GmbH, Graz, Austria), and the number-size spectrum of the particles was obtained by DMS500 (Cambustion Ltd., Cambridge, Britain). The pressure drop of the aftertreatment was monitored by differential pressure sensor, and the temperatures upstream and downstream were measured with thermocouples. The engine was connected to an AC electrical dynamometer FC2005 (Xiangyi Power, Changsha, China). The engine operation parameters and gaseous emissions were recorded by the dynamometer control system.

1.2. DOC and CDPF specifications

The specifications of the DOC and the CDPF are listed in Table 2. The DOC used a cordierite monolithic substrate coated with a catalyst containing platinum (Pt) and palladium (Pd), converting NO to NO_2 for continuous regeneration. The CDPF utilized a wall-flow cordierite substrate, coated with Pt–Pd catalyst to lower the soot oxidation temperature.

1.3. Test method

The DOC, the CDPF and the coupled DOC–CDPF were tested individually on the bench to investigate their effects and performance. The effects of the DOC and CDPF on gaseous emissions were tested under different temperatures and space velocities (SVs) by adjusting the engine operating conditions.

The number-size spectrum of the particles was measured under separate steady state conditions of a 13-mode European steady state cycle (ESC). The engine speeds at A, B and C points

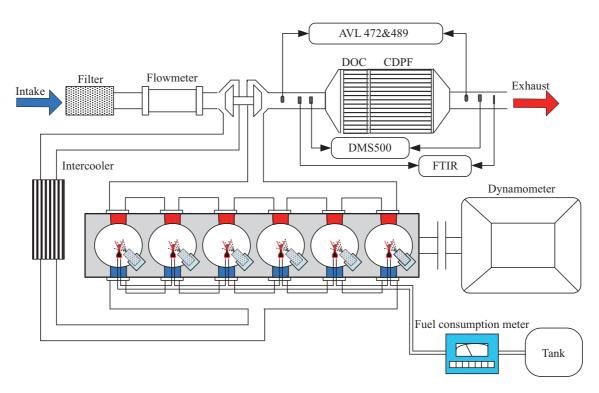


Fig. 1 - Schematic diagram of the engine test bench.

Table 1 – Engine specifications.					
Parameter	Feature/value				
Engine type	4-stroke, intercooling, turbocharging, 6-cylinders in line				
Bore (mm)	108				
Stroke (mm)	130				
Displacement (L)	7.14				
Compression ratio	18:1				
Fuel injection system	High pressure common rail				
Rated power	199 kW at 2300 r/min				
Maximum torque	1000 Nm at 1400 r/min				

Table 2 – Specifications of the DOC and CDPF.					
Parameter	DOC	DPF			
Substrate Cell density (cells/in.²) Diameter × length (mm × mm) Wall thickness (mm) Volume (L)	Cordierite 400 Φ266.7 × 152.4 0.18 8.5	Cordierite 200 Φ266.7 × 304.8 0.30 17			
1 in. = 2.54 cm. DOC: diesel oxidation catalyst, DPF: diesel particulate filter.					

in the ESC test cycle were 1435, 1750, 2050 r/min, respectively. The engine operation conditions of these steady states are represented by the engine modes in the following text. For instance, the engine mode A25 means that the engine ran under the A speed (1435 r/min) at 25% of full load.

The PM mass and SPN at the upstream and downstream of the DOC–CDPF system were measured in both ESC and European transient cycle (ETC) and the filtration efficiency was calculated based on the measurement. To examine the filtration and continuous regeneration behavior, the PM emissions and pressure drop of the filter were tested under different steady engine operation conditions.

2. Results and discussion

2.1. Gaseous emissions

Fig. 2 shows the effect of the aftertreatment on gaseous emissions with a constant SV equaling 30,000 $\rm hr^{-1}$ for the CDPF. Both the DOC and the CDPF could convert NO to NO₂ and remove the HC and CO emissions. The NO₂/NOx ratio in the engine-out

exhaust was less than 10%. As the exhaust flowed through the DOC, the NO₂/NOx ratio was above 40% in the temperature range of 300–350°C. In the CDPF, NO₂ was consumed to oxidize the trapped soot. Meanwhile, some part of NO was converted to NO₂ due to the Pt–Pd catalyst on the CDPF. Because the engine-out NOx/PM ratio was high, the NO₂ consumption by oxidizing the trapped soot had little effect on NO₂/NOx ratio. In the experiment, the NO₂/NOx ratio was increased in the temperature range of 200–400°C as the exhaust flowed through the CDPF. When the temperature was above 400°C, the NO₂/NOx ratios at the outlet of the DOC, the CDPF and the DOC–CDPF were similar, since the conversion was limited by the chemical equilibrium (Olsson et al., 1999).

The soot trapped in the filter can be oxidized by NO_2 and can produce CO or CO_2 (Copper and Thoss, 1989; Majewski et al., 1995). The test results showed that little CO existed at the downstream of the CDPF (Fig. 2c), which was in agreement with a previous study (Liu et al., 2011), indicating that CO_2 was the final product when the trapped soot was oxidized.

It is worth noting that at 160°C the NO_2/NOx ratio decreased across the DOC and the CDPF. Previous studies show that NO_2 is preferentially consumed relative to O_2 for the oxidation of HC over Pt–Pd/Al $_2O_3$ catalyst (Irani et al., 2009). At low temperatures the DOC can be a net consumer of NO_2 for oxidizing CO and HC, and the loss of NO_2 increases with DOC aging (Katare et al., 2007).

2.2. Particle emissions and filtration behavior

To understand the filtration behavior on the particles with different sizes, particle number-size distributions were tested under each of the steady-state engine modes according to ESC test cycle. The typical test results at the engine mode C25 and C100 are represented in Fig. 3. The number-size distributions of the engine-out PM had a bimodal character, with the corresponding particle types referred to as the nucleation mode and the accumulation mode. The particles in accumulation mode are carbonaceous agglomerates and associated adsorbed materials, while the nucleation mode consists of volatile organic and inorganic components like sulfates, and maybe also some soot and metal compounds (Kittelson, 1998). After the filter, both the nucleation and accumulation mode particles were reduced significantly.

By fitting each log-normally distributed mode from the number-size spectrum, the nucleation and accumulation mode particles were discriminated automatically by the DMS500 software (Symonds et al., 2007). The break specific PN of these

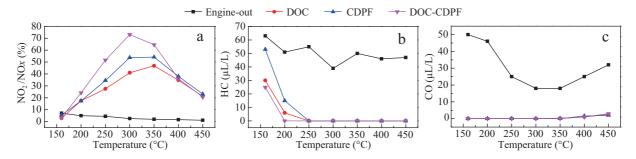


Fig. 2 – Impact of DOC and CDPF on NO_2/NOx (a), HC (b) and CO (c) at SV = 30,000 hr⁻¹ for CDPF. SV: space velocity.

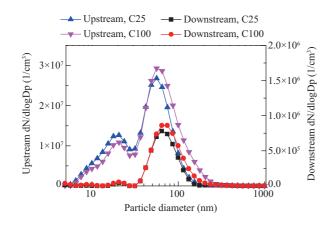


Fig. 3 - Number-size distributions of diesel particles.

two modes upstream and downstream are shown in Fig. 4. After the DOC–CDPF, the brake specific particle number (BSPC) of nucleation mode was much lower than that of accumulation mode at each engine steady state. Most of the volatile components of the nucleation particles were oxidized with the DOC and CDPF. The smaller solid particles, including the nucleation mode particles, were efficiently removed by diffusional deposition in the filter due to their faster Brownian movement (Filippo and Maricq, 2008).

The brake specific PM mass (BSPM) and BSPN of solid particles were measured in ESC and ETC (Table 3). The filtration efficiency of the CDPF on SPN was higher than 99%, while the efficiency on PM mass was relatively low. The PM emissions from the engine contained large part of soluble organic fraction (SOF) and inorganic oxides. The SOF filtration of the CDPF was not as effective as the soot filtration, because the volatile fractions of PM could be vaporized and could flow through the filter as gases, and because they condensed when the PM was collected for weighting (Giechaskiel et al., 2012).

The relationship between the PM mass and the SPN emissions at each steady state of ESC are represented in Fig. 5. In the raw exhaust from the engine, the BSPM and BSPN emissions had a positive correlation. At the outlet of the CDPF, the BSPM showed no correlation with BSPN, as the BSPM was mainly determined by the SOF and inorganic components instead of the number of solid particles.

Table 3 – Filtration of PM mass and SPN in ESC and ETC.				
Parameter	ESC test	ETC test		
Engine-out BSPM (g/kW/h)	0.019	0.021		
Post-CDPF BSPM (g/kW/h)	0.008	0.005		
PM mass filtration efficiency (%)	58	76		
Engine-out BSPN (#/kW/h)	1.63×10^{13}	1.9×10^{13}		
Post-CDPF BSPN (#/kW/h)	1.17×10^{11}	4.6×10^{9}		
SPN filtration efficiency (%)	99.3	99.98		

2.3. Equilibrium regeneration process

The experimental results indicated that the pressure drop increment of the CDPF was less than 0.1 kPa when the engine was operated at each of steady states with low temperatures for 1 hr, which was caused by the low engine-out PM emission and slow soot accumulation in the large-sized CDPF. However, the SPN at the downstream of the CDPF changed obviously and the trend of SPN change was dependent on engine operating conditions (Fig. 6). The SPN decreased at the engine modes B25 and B50 and increased at B75 and B100. The variation of the SPN downstream at steady engine conditions was in response to the change of filtration efficiency, which could be improved with an increase of soot loading (Giechaskiel et al., 2007).

When the exhaust temperature was lower than BPT, the soot oxidation rate was slower than the soot accumulation and the soot loading in the filter increased, resulting in an increase of filtration efficiency and a decrease of SPN downstream. Similarly at higher temperatures the SPN downstream increased. At B50 and B75, SPN changed more slowly than those at B25 and B100, indicating that the exhaust temperature was closer to the BPT. It can be proposed that the slope of the SPN downstream is zero at the equilibrium process, which could be used to define the BPT. To assess BPT of the CDPF for this HD diesel engine, the time consumption was much less by measuring the SPN downstream than by testing pressure drop of the filter.

Actually, the BPT of a continuously regenerating DPF system is a function of many operation parameters, including soot loading, inlet gas composition, SV and test procedure (Schejbala et al., 2010). The BPT of the CDPF, defined as the temperature at which the SPN downstream remained constant, was measured at different SVs with or without DOC (Fig. 7). It was demonstrated that the DOC could help reduce the BPT of CDPF for nearly 50°C, as

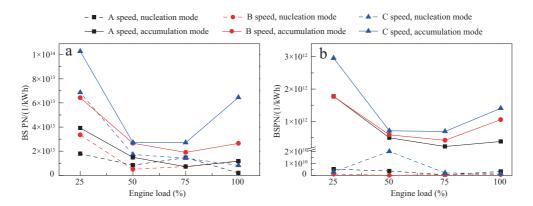


Fig. 4 – Particle number emissions in nucleation and accumulation mode. (a) upstream; (b) downstream. BSPN: brake specific particle number. A, B, C speeds: 1435, 1750, and 2050 r/min of engine speeds at points A, B, and C.

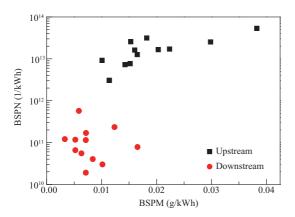


Fig. 5 – Relationship between PM mass and solid particle number. BSPM: brake specific particle mass. BSPN: brake specific SPN particle number.

the DOC increased NO_2 concentration through the CDPF (Fig. 2). The BPT of the CDPF without DOC increased at a higher SV because the residual time for the oxidation of NO to NO_2 was shorter, and the NO_2 concentration was not sufficient to oxidize the soot loaded in the upstream part of the CDPF. For the DOC–CDPF system, the NO_2 concentration at the inlet of the CDPF was already high, so the influence of SV on BPT was not obvious.

3. Conclusions

A DOG–CDPF system was investigated to examine its filtration behavior and passive regeneration process by NO_2 . Both the DOC and the CDPF helped to increase the NO_2/NOx ratio. The CDPF located downstream of the DOC led to more oxidation of NO to NO_2 at lower temperature, while the conversion was limited by the chemical equilibrium when exhaust temperature was higher than 350°C. The DOC–CDPF system almost completely oxidized the pollutants CO and HC. When the temperature was below 200°C, NO_2 across DOC and CDPF was consumed for the oxidation of CO and HC.

When the DOC–CDPF was tested on a HD diesel engine, most of the particles downstream were in accumulation mode. The filtration efficiency for the particle number was close to 100% in both steady and transient test cycles, while the filtration efficiency for PM mass was relatively low. A positive correlation was found between PM mass and SPN in the raw exhaust, but at

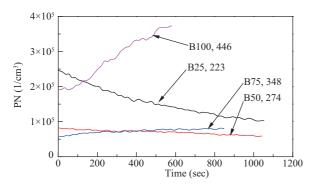


Fig. 6 – Solid particle number profiles downstream of the DOC-CDPF. PN: particle number.

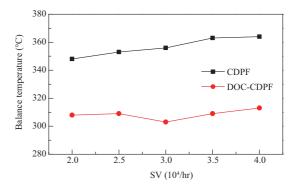


Fig. 7 – Balance point temperature of CDPF with and without DOC at different SVs. SV: space velocity.

the downstream of the CDPF the correlation was not obvious, because most of the PM was SOF and inorganic components.

The SPN at the downstream of the CDPF changed as the soot loading varied. Because the downstream SPN was sensitively influenced by the soot loading, the BPT can be identified by monitoring the trend of SPN. The BPT for the DOG–CDPF system is 303° C at $30,000~hr^{-1}$, and increased to 356° C for the CDPF without DOC. The BPT of the CDPF without DOC increased slightly with higher SV.

Acknowledgments

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