



**Liqui-Cel™**  
Membrane Contactors

A large industrial power plant is shown at night, with its complex structure of pipes, towers, and scaffolding illuminated by numerous lights. The lights create a warm, golden glow that is reflected in the calm water in the foreground. The sky is a mix of deep blue and orange, suggesting a sunset or sunrise. A large white triangle is overlaid on the image, pointing downwards from the top center.

# Quality water. Powerful results.

**3M™ Liqui-Cel™**  
**Membrane Contactors**

Advanced membrane degasification  
technology for pure power plant water.



# Effective. Economical. Chemical-free.

## Advanced membrane technology for power plant water degasification

Power plants generating steam balance cost, efficiency and reliability with environmental considerations while supplying energy to the world. Degasified water plays a critical role in generating the energy used to heat and cool homes and businesses while protecting vital capital equipment.

3M™ Liqui-Cel™ Membrane Contactors remove dissolved  $O_2$ ,  $CO_2$ , and trace gases to industry-leading levels. With their chemical-free membrane technology, Liqui-Cel membrane contactors can help enhance the performance of water treatment systems and reduce the risk of downtime. They offer a cost-effective, easy-to-use and efficient degassing solution for power plants.



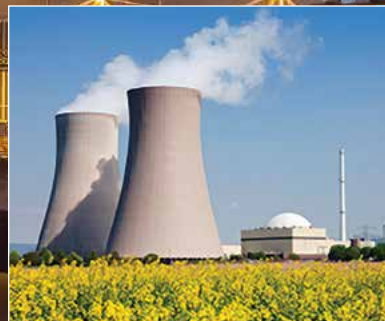
### 3M™ Liqui-Cel™ Membrane Contactors

Membrane contactors offer a reliable improvement over conventional degassing technologies such as steam deaerators, decarbonators, and chemical injection. With nearly 10x the effective surface area of conventional degassing towers, they produce virtually gas-free water at a wide range of flow rates—all without using chemicals or taking up vital square footage.



14-inch Industrial system

O<sub>2</sub> levels <1 ppb    CO<sub>2</sub> levels <1 ppm



#### Applications

- Steam-electric power stations
- Natural gas-fired power stations
- Heat recovery steam generators (HRSG)
- Nuclear power plants



# Clean, powerful water. Degasification for efficient

## Benefits of 3M™ Liqui-Cel™ Membrane Contactors

### Reduced corrosion and pitting



3M™ Liqui-Cel™ Membrane Contactors reduce  $O_2$  to levels below 1 ppb and  $CO_2$  levels below 1 ppm, helping prevent corrosion and pitting caused by oxidation and carbonic acid. In nuclear power plants, lower dissolved  $O_2$  and  $CO_2$  levels alleviate primary stress corrosion cracking. By minimizing long-term damage to pipes, heat exchangers, boilers and other equipment, Liqui-Cel membrane contactors help power plants reduce the high costs of capital equipment maintenance and replacement.

### Minimized environmental impact



Liqui-Cel membrane contactors degas water without using chemicals. By producing water with very low  $O_2$  and  $CO_2$  levels, steam-generating plants often eliminate the need for oxygen scavengers and reduce the use of ion exchange regeneration chemicals. Reduced chemical use may also decrease the boiler blowdown frequency, saving water and energy. In nuclear power plants, low levels of  $O_2$ ,  $CO_2$ , and  $N_2$  may reduce the formation of radionuclides such as  $^{14}C$  and oxides of  $^{60}Co$  along with reduced Corrosion Related Unidentified Deposit (CRUD).



### Case in point

*After installing a 3M™ Liqui-Cel™ Membrane Contactor system to replace a forced draft tower, a power plant in China saw pre-mixed bed regeneration drop from  $CO_2$  levels of 8 ppm to 1.5 ppm. As a result, the plant lowered its mixed bed chemical use nearly 20%.*

Operating expenses and savings provided by the customer.  
Actual savings and operating expenses will vary according to each project.

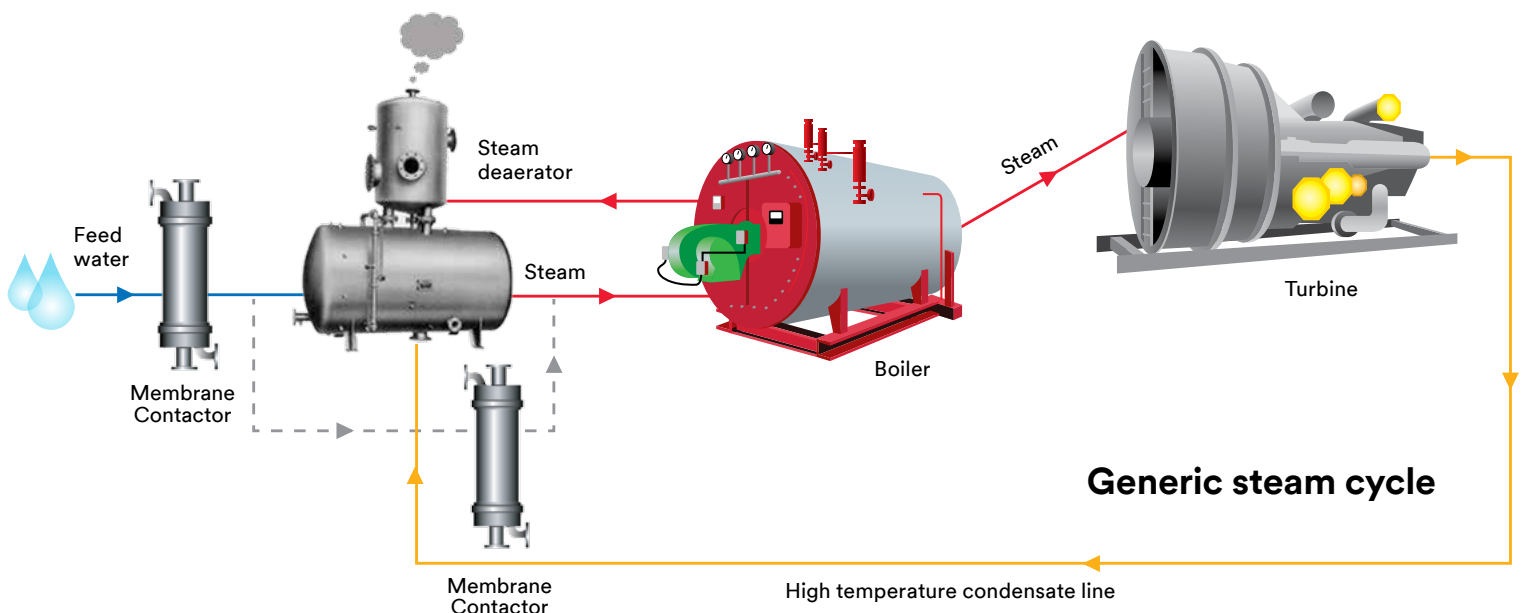
# power generation.

## Improved deionization

Lowering dissolved CO<sub>2</sub> levels with Liqui-Cel membrane contactors reduces the total ionic load in water, enhancing the effectiveness of IX, EDI, and CDI purification technologies. With more efficient deionization, power plants can reduce costly bed regeneration cycles and increase the service life of deionization equipment.

## Reduced blowdown frequency

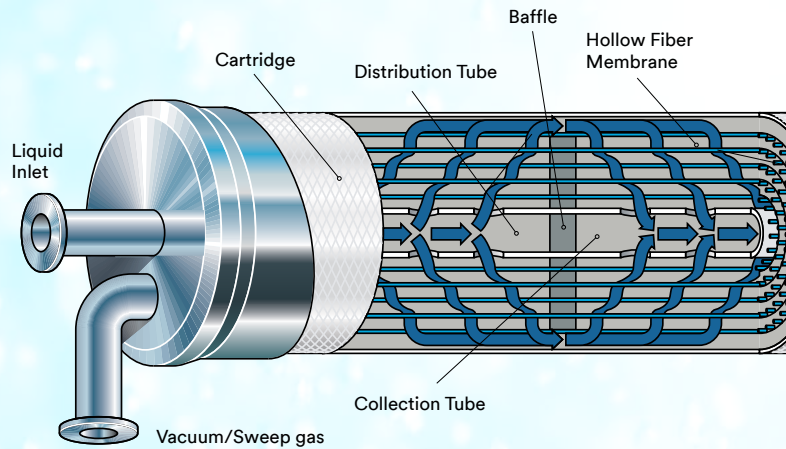
Blowdown cycles in steam generation plants can add significant costs due to extra water, energy and chemical use. By removing dissolved oxygen to low levels, Liqui-Cel membrane contactors can help reduce blowdown frequency and boiler operating costs.





# Inside the technology

Water flows around the outside of the hollow fiber membrane while a vacuum or sweep gas is applied to the inside of the fiber. The resulting difference in gas concentration levels between the inside (gas/vacuum phase) and outside (liquid phase) of the hydrophobic membrane drives highly efficient dissolved gas removal, producing water with very low gas concentrations.



# Streamlining savings

Building long-term efficiency into power water treatment systems



## Flexible

- ▶ Small footprint
- ▶ Enables custom and mobile system designs
- ▶ Expandable for increased capacity
- ▶ Lower installation and construction costs

## Economical

- ▶ Reduce plant chemical use
- ▶ Low electrical cost
- ▶ Save ion exchange resin regeneration costs
- ▶ May reduce energy and water losses by reducing frequency of boiler blowdowns

## Performance and reliability

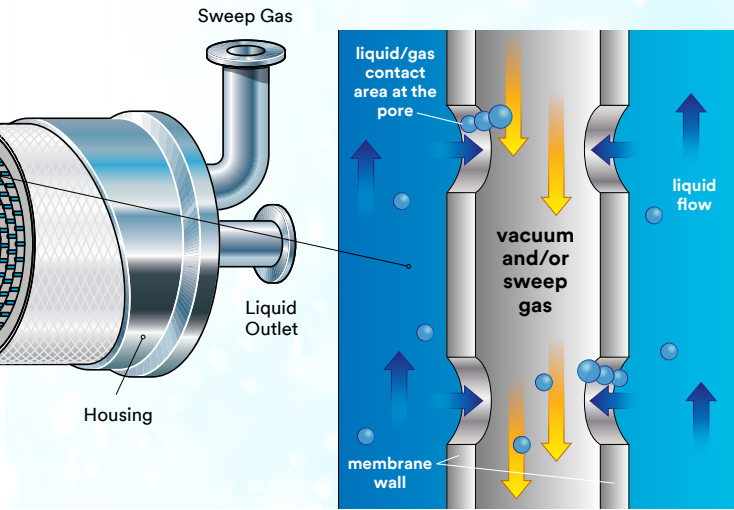
- ▶ Dissolved O<sub>2</sub> <1ppb and dissolved CO<sub>2</sub> <1ppm
- ▶ Improved EDI water quality
- ▶ Can be designed for redundancy
- ▶ Operation at a wide range of flow rates



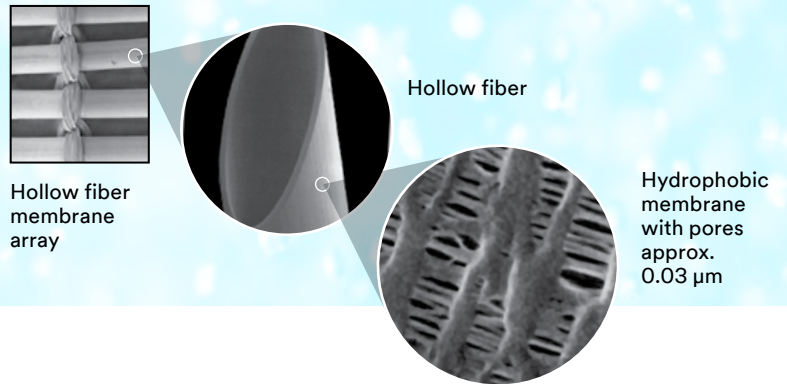
## Case in point

The Rokeby Generating Station in Lincoln, Nebraska installed 3M™ Liqui-Cel™ EXF-14×28 Series Membrane Contactors to remove CO<sub>2</sub> prior to mixed bed deionization. The Station expected its throughput to rise from 90,000 gallons (341 m<sup>3</sup>) to 160,000 gallons (636 m<sup>3</sup>). After installing the Liqui-Cel membrane contactor, the actual throughput was 191,000 gallons (725 m<sup>3</sup>), with full-scale capacity of 617,000 gallons (2,337 m<sup>3</sup>).

Operating expenses and savings provided by the customer.  
Actual savings and operating expenses will vary according to each project.

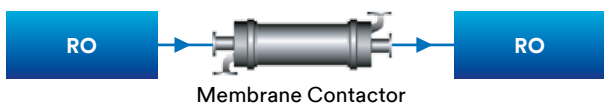


Scanning electron microscope images of Liqui-Cel membranes. Membrane arrays in a contactor have nearly 10x the effective surface area of a traditional vacuum tower.

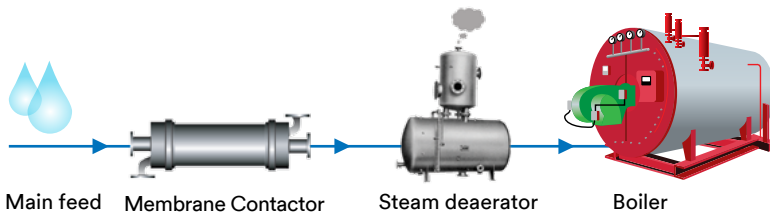


## Common installation scenarios

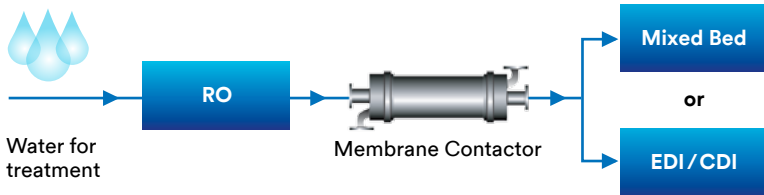
### Traditional steam generation plants



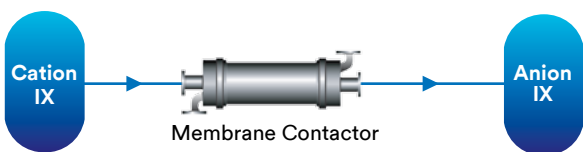
CO<sub>2</sub> removal between RO passes to reduce caustic use



Dissolved oxygen removal from boiler make-up water

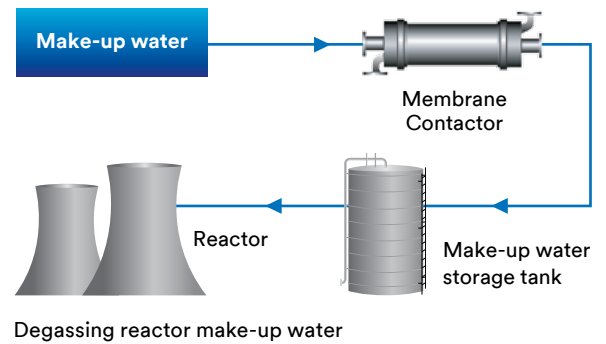


CO<sub>2</sub> removal with Liqui-Cel membrane contactor between RO and IX

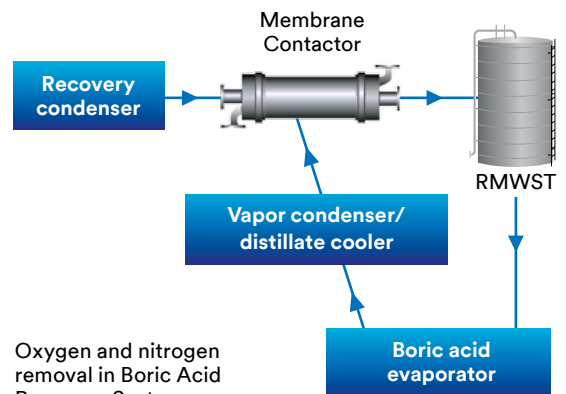


CO<sub>2</sub> removal with Liqui-Cel membrane contactor between IX resin beds

### Nuclear power plants



Degassing reactor make-up water



Oxygen and nitrogen removal in Boric Acid Recovery System

## Support at every step

Systems utilizing 3M™ Liqui-Cel™ Membrane Contactor technology are operating around the world in many applications. Whether you need help assessing the application of membrane contactor technology or discussing design details, 3M has the knowledge and experience to support your next project.

## Maintenance

Liqui-Cel membrane contactors typically require little maintenance. With proper system design, this technology can be operated with limited support from operators and maintenance personnel.

Visit our website to download technical bulletins, mechanical drawings, case studies and more!

[3M.com/Liqui-Cel](http://3M.com/Liqui-Cel)



## Expansion and Reconfiguration

The variety of compact Liqui-Cel membrane contactors means that membrane contactors can be easily added and/or reconfigured as power plant water demands change.

**Technical Information:** The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

**Product Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

**Warranty, Limited Remedy, and Disclaimer:** Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

**Limitation of Liability:** Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

3M and Liqui-Cel are trademarks of 3M Company. © 2017 3M Company. All rights reserved.



ISO 9001



**Separation and Purification Sciences Division**  
13840 South Lakes Drive  
Charlotte, North Carolina  
28273 USA  
Phone: +1 980 859 5400

**3M Deutschland GmbH**  
**Separation and Purification Sciences Division**  
Öhder Straße 28  
42289 Wuppertal Germany  
Phone: +49 202 6099 - 0  
Fax: +49 202 6099 - 241

LC-1208  
Rev. 3/17

[3M.com/Liqui-Cel](http://3M.com/Liqui-Cel)