Effect of Au addition on hydrogen permeation and the resistance to H$_2$S on Pd-Ag alloy membranes

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Abstract

In order to make a detailed comparison between Pd-Ag and Pd-Ag-Au membranes according to their H$_2$ permeation properties and sulfide resistance Au was deposited by the electroless plating (ELP) technique onto one half of Pd-Ag membranes. Permeation tests have been carried out from 400 to 600 °C under single gas conditions. The Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$ membrane has shown a H$_2$ permeance of $4.71 \cdot 10^{-3}$ mol s$^{-1}$ m$^{-2}$ Pa$^{0.5}$ at 600 °C, which is one of the highest values ever reported in the literature, where the Pd-Ag-Au membranes have exhibited higher hydrogen permeation rates compared to their respective Pd-Ag membranes above 550 °C. The correlation between the H$_2$ flux and the partial pressure differences between the retentate and permeate sides at different values of $n$, showed the effect of Au addition on the adsorption dissociation steps. The H$_2$ permeation properties have been determined in terms of the degree of H$_2$S inhibition, up to 17 ppm, and subsequent H$_2$ flux recovery rate. Pd-Ag membranes alloyed with gold resisted 12.5 hours of H$_2$S exposure showing recovery rates of 85 and 83% for Pd$_{91.5}$Ag$_{4.7}$Au$_{3.8}$ and Pd$_{90.5}$Ag$_{4.6}$Au$_{4.9}$ membranes, respectively, whereas the hydrogen flux of non-gold membranes decreased below detectable values. No evidence of the formation of a crystalline sulfide phase on the Pd-Ag-Au alloy membrane surfaces was found in the XRD patterns after H$_2$S exposure and also XPS characterization did not show important changes in the composition before and after the H$_2$S exposure tests. However, SEM images showed a decrease in the thickness of the Pd-Ag membrane and signs of corrosion and roughening on its surface, while gold-alloyed membranes did not show any damage.
Keywords: Palladium-silver-gold membrane; electroless plating; $\text{H}_2$ permeation; $\text{H}_2\text{S}$ poisoning; $\text{H}_2$ recovery.

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1. Introduction

In the last century, hydrogen has mainly been used as a chemical product and intermediate for different industrial applications (ammonia synthesis, methanol production, petroleum refining, etc.). However, the importance of high purity hydrogen has recently increased due to new and different applications such as micro/nano-electronics, fuel cells, transport and small stationary energy conversion devices (combined heat and power production), chemical and metallurgical industries, as well as in large stationary power installations [1]. Almost 50% of the global production of hydrogen is currently generated via steam methane reforming of natural gas [2]. Hydrogen selective membranes have frequently been used in separation steps or in reactors with the aim of obtaining high feedstock conversion and production of pure H\textsubscript{2}. Among those membranes, Pd based membranes have high H\textsubscript{2} permeation and very high perm-selectivity due to their solution/diffusion mechanism, where hydrogen is adsorbed on the surface and dissociated into hydrogen atoms which permeate through the membrane bulk. However, the presence of H\textsubscript{2}S impurities can irreversibly poison the Pd membranes. Sulfur is a very common impurity in fossil fuels, especially in coal, biogas and also in natural gas (depending on its origin). The adsorption of H\textsubscript{2}S molecules compete with hydrogen for active sites, and increases the energy barrier for hydrogen dissociative adsorption, resulting in a significant decrease in the hydrogen adsorption rate and thus the hydrogen permeance [3]. In particular H\textsubscript{2}S can react with the Pd surface to form a Pd\textsubscript{4}S phase depending on the exposure conditions, which is not as permeable as pure Pd and is also susceptible to mechanical failure [4] [5] [6]. In fact, the a large difference between the constant lattices of pure Pd and Pd\textsubscript{4}S causes structural stresses and leads to the formation of cracks or even the fracture of Pd membranes.

In order to improve stability, Pd membranes are generally alloyed with other metals. The addition of Ag or Cu to Pd can improve the resistance to hydrogen embrittlement below 298 °C and at H\textsubscript{2} pressures above 2MPa. Pd-Ag alloy membranes show higher H\textsubscript{2} permeation rates than pure Pd; when the amount of Ag increases, at 23 wt. %Ag (Pd\textsubscript{77}Ag\textsubscript{23}), the permeation rate increases up to 1.7 times higher than the H\textsubscript{2} permeation of pure Pd [7]. However, Pd-Ag alloys, as well as pure Pd, are prone to forming bulk sulfides in the presence of H\textsubscript{2}S throughout a wide range of exposure conditions [8] [9].

Considerable effort has also been spent on Pd–Cu membranes in order to improve their flux properties, since they do not show embrittlement even at low temperatures [10] [11]. The Pd–Cu
alloy presents some advantages over pure Pd. It gives a maximum hydrogen permeability at approximately Pd\textsubscript{60}Cu\textsubscript{40} and, although this does not show higher hydrogen permeability when compared to Pd–Ag alloys, it is mechanically more stable and exhibits resistance to H\textsubscript{2}S poisoning [12]. The response of Pd-Cu alloys exposed to H\textsubscript{2}S is a complex function of the alloy composition and the exposure conditions [13]. Pd-Cu alloys can form two different crystal structures: body-centered cubic (bcc) and face-centered cubic (fcc), depending on composition and temperature. In this regard, many different proportions of Cu (20-47 wt\%) in Pd-alloys were evaluated by Morreale et al. [14] at temperatures ranging from 330 to 750 °C in the presence of 1100 ppm H\textsubscript{2}S. A change in the crystal structure of the alloy due to the rearrangement of the Pd and Cu atoms can affect the permeability of the membrane [15].

Although many studies have been performed on Pd-Cu alloy membranes because of their sulfur resistance, Pd–Au alloy composite membranes have received increasing interest mainly due to two reasons: the presence of gold reduces the embrittlement problem resulting from the hydride phase transition and improves the resistance to poisoning and corrosive degradation by sulfur compounds. It has also been reported that the addition of Au also increases the hydrogen permeability compared to pure Pd [16]. Several authors have reported the performance of Pd-Au alloy membranes tested in gas mixtures of H\textsubscript{2}S in H\textsubscript{2} streams. Gade et al. [17] observed a 29% H\textsubscript{2} flux inhibition at 500 °C for a PdAu\textsubscript{23} membrane in a sour WGS mixture containing 20 ppm H\textsubscript{2}S. Chen et al. [6] reported resistance to bulk sulfidation of a PdAu\textsubscript{8} alloy composite membrane under exposure of 54.8 ppm H\textsubscript{2}S/H\textsubscript{2} mixture in the temperature range of 350–500 °C, also proving that the higher permeance recovery occurs at higher temperatures due to the exothermic nature of the dissociative adsorption of H\textsubscript{2}S on metals.

Ternary Pd alloys have also been considered more extensively in the recent years for their potential to improve both the permeability and H\textsubscript{2}S response. Some researchers as Peters et al. [18], prepared a Pd\textsubscript{75}Ag\textsubscript{22}Au\textsubscript{3} membrane by magnetron sputtering improving the performance over Pd\textsubscript{85}Au\textsubscript{15} and Pd\textsubscript{70}Cu\textsubscript{30} membranes in the presence of H\textsubscript{2}S. Lewis et al. [19] reported a PdAu\textsubscript{20}Ag\textsubscript{13} membrane with a higher hydrogen permeability than a PdAu\textsubscript{23} alloy in single gas conditions at 400 and 500 °C and reduction of 52-75% under 20 ppm H\textsubscript{2}S conditions between 500 and 400 °C, pointing out the importance of the temperature on the H\textsubscript{2} flux inhibition. Furthermore, Braun et al. [13], [20] have proved the effectiveness of the addition of gold to high permeability PdAg binary membranes as inhibitor of the sulfur poisoning effect.
The purpose of this work is to investigate the effect of the addition of Au on the H\(_2\) permeation properties of Pd-Ag-Au alloy membranes as a function temperature and the influence of the Au concentration as a function of the H\(_2\)S content in the feed gas stream. Starting from Pd-Ag alloy membranes prepared by the electroless plating deposition technique (ELP), only one half of these membranes was used to deposit Au onto it, whereas the binary alloy membrane was kept to be tested at exactly the same conditions as the ternary alloy membranes. Both half membranes (the Pd-Ag alloy and the Pd-Ag-Au one) were placed together in the same reactor module to perform single gas tests which allowed to quantify their permeation properties and their response to different temperatures at the same time and under the same conditions of pressure and gas flow rates leading to a fairer comparison between these membranes. Different gold contents have been evaluated and a detailed characterization of the membranes before and after H\(_2\)S exposure has been carried out.

2. Experimental

2.1 Membrane preparation

Thin Pd-Ag layers were deposited on activated asymmetric ceramic tubes using the simultaneous deposition technique previously reported by Tanaka et al. [21], [22] and [23]. The Pd-Ag membranes were annealed at 550 °C for 4 h (3°C/min heating rate), using a 10% H\(_2\) / 90% N\(_2\) gas mixture.

Afterword, two of the Pd-Ag prepared membranes were half covered with teflon tape and a subsequent Au deposition process was carried out onto the uncovered parts for 5 hours; following the process conditions suggested by Okazaki et al. [24] while improving the chemical composition of the plating solution. The concentration of K[Au(CN)\(_4\)] was tuned to obtain different % Au compositions. Then, the resulting membranes were composed by a Pd-Ag alloy and a Pd-Ag-Au one (Figure 1).

Five membranes were prepared in total (Table 1). M1 - M1Au having the same Pd-Ag base layer, were tested in the range of 400-600 °C under single gas conditions and placed together in the same reactor, therefore, the permeation conditions were the same. On the other hand, the influence of H\(_2\)S in feed gas stream was studied for M2, M2Au (these two had the same Pd-Ag content) and M3Au membranes.
To determine the composition, from each membrane a sample was taken before any kind of permeation test was performed. The samples were dissolved at 130 ºC for 12 h in aqua regia using a Parr´s acid digestion vessel. Then a small amount of this solution was taken and diluted 20 times with deionized water and measured by ICP-OES (Inductively Coupled Plasma - Optical Emission Spectrometry) using a Varian Vista MPX.

**Figure 1.** Picture of two membranes (half Pd-Ag and half Pd-Ag-Au) prepared by ELP (picture taken before annealing treatment).

### 2.2 Annealing treatment study

Pd-Ag-Au ternary samples of the M1Au membrane were annealed at 550 ºC with different dwell times to monitor the alloy formation. Membrane samples were heated from room temperature to 550 ºC at 3 ºC/min in nitrogen. Then, the temperature was maintained for 8, 12, 16 and 24 hours. During the dwell time, the flow was changed to a 10% H$_2$ / 90% N$_2$ gas mixture with a total flow rate of 500 mL min$^{-1}$. The cooling step was again carried out only in nitrogen atmosphere. X-ray diffraction experiments were carried out to follow the formation of the alloy.

### 2.3 Membrane sealing

For the permeation tests, the membranes were cut and sealed using Swagelok® connectors and graphite ferrules, following the procedure reported before in [22], [23] and [25].
2.4 Permeation tests

Single gas permeation experiments were carried out using a reactor of 102 mm in diameter and 1000 mm in height and placed in a three zone oven used to keep the reactor at the desired temperature. The pressure throughout all the tests was measured at the top and the bottom of the reactor. The reactor was designed to have the possibility to test five membranes at the same time and under the same conditions. A complete description of the reactor module is provided in [23].

The influence of H\textsubscript{2}S on the H\textsubscript{2} permeance of Pd-Ag and Pd-Ag-Au membranes was studied in an in-house designed setup suitable for membrane tests with H\textsubscript{2}S (Figure 2). The membranes were sealed and placed in a reactor. A three zone oven was used to heat up the reactor to the desired operating temperature and was controlled with three independent thermocouples. An additional thermocouple was placed in the inside of the membrane and another thermocouple at the gas outlet of the oven. A gas feeding system with Bronkhorst mass flow controllers was used to produce the desired gas mixtures. 100 ppm of H\textsubscript{2}S in H\textsubscript{2} were supplied (Linde HIQ) and mixed with H\textsubscript{2} to get the desired composition of H\textsubscript{2}S in the feed gas stream. The pressure in the reactor was controlled by a Bronkhorst back pressure regulator. In addition, the pressure was controlled prior to the reactor in the feed gas line and in the permeate stream. The H\textsubscript{2} permeance was continuously monitored and logged using a Bronkhorst Mini Cori flow meter (up to 2 l/min). The setup is fully automated and controlled by a computer, enabling continuous operation and data acquisition. The N\textsubscript{2} leakage of the membranes was determined with a Horibastec liquid film flow meter.
2.5 Characterization

A FEI Quanta 250 FEG (Environmental Scanning Electron Microscope; ESEM) equipment was used to determine the thickness and morphology of the membranes. Pd-alloy membranes were characterized by X-ray electronspectrometry (XPS) with a monochromatic Thermo Scientific K-Alpha. Spectra were obtained using an aluminium anode (Al Kα = 1486.6 eV) operating at 72 W and a spot size of 400 µm and Sputtering was done with a beam energy of 1000 eV at low current. A MiniFlex 600 Benchtop XRD (X-Ray Diffractometer) was used both to follow the Pd-Ag-Au alloy formation at 550 °C and after permeation tests to detect the presence of any bulk sulfides that may have formed during testing. The scan speed was 1.00 °/min and the step width 0.02°, in the range 20 = 30-90° with a Kβ radiation at 40 kV and 15 mA.
3. Results and discussion

3.1 Physico-chemical and structure characterization

The studied membranes and their compositions, determined by ICP-OES, are listed in Table 1.

Table 1. ICP analysis of membranes prepared in this study.

<table>
<thead>
<tr>
<th>Membrane / Code</th>
<th>%Pd</th>
<th>%Ag</th>
<th>%Au</th>
</tr>
</thead>
<tbody>
<tr>
<td>Membrane 1 (Pd-Ag) / M1</td>
<td>94.9</td>
<td>5.1</td>
<td>-</td>
</tr>
<tr>
<td>Membrane 1 (Pd-Ag-Au) / M1Au</td>
<td>91.7</td>
<td>4.8</td>
<td>3.5</td>
</tr>
<tr>
<td>Membrane 2 (Pd-Ag) / M2</td>
<td>96.1</td>
<td>3.9</td>
<td>-</td>
</tr>
<tr>
<td>Membrane 2 (Pd-Ag-Au) / M2Au</td>
<td>91.5</td>
<td>4.7</td>
<td>3.8</td>
</tr>
<tr>
<td>Membrane 3 (Pd-Ag-Au) / M3Au</td>
<td>90.5</td>
<td>4.6</td>
<td>4.9</td>
</tr>
</tbody>
</table>

Once the deposition of Au by ELP over a Pd-Ag alloyed membrane was carried out, the membranes were exposed to a thermal treatment under nitrogen flow during the heating step at 550 °C and subsequently in a mixture of hydrogen and nitrogen (10/90 %vol.). Different dwell times at 550 °C (8, 12, 16 and 24 hours) were used to study the formation of a ternary alloy using XRD post-characterization. In Figure 3a the XRD spectra of Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$ (membrane M1Au) are shown in a range of 2Θ = 30° - 90° after Au deposition at 550 °C and various annealing times. Figure 3b displays the same XRD diffraction patterns as Figure 3a, but for 2Θ = 35° - 45° to show the evolution of the main peak of the alloy as a function of time in greater detail.

The red line shows the XRD diffraction of the Pd$_{94.9}$Ag$_{5.1}$ (M1) membrane after 4 hours of annealing at 550 °C and after gold deposition, but without thermal treatment. With this characterization the evolution of diffracted peaks can be monitored from the beginning. The spectra (red line) shows Pd-Ag alloyed peaks at 2Θ diffracted from the planes (1 1 1), (2 0 0), (2 2 0), (3 1 1) and (2 2 2) respectively and, four new peaks corresponding to Au are observed. After every annealing test, the membrane exhibits only the peaks for the Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$ (M1Au) alloy without the presence of the Pd-Ag and Au as separated peaks. During annealing, the Au peaks shifted to higher diffraction angles. The asymmetrical shapes of the Pd-Ag-Au alloy peaks
after 8 and 12 hours of thermal treatment (blue and green lines, respectively), indicate that ternary alloying is not complete yet; especially in the higher planes like (1 1 1) and (2 0 0) in the region of Pd-Ag. After 16 and 24 hours of annealing (yellow and black lines respectively), the main peak (1 1 1) of the Pd-Ag alloy is shifted to a lower 2Θ showing similar behavior as reported by Gade et al. [26] for annealing treatments above 400 °C and also by Peters et al. [18] when comparing the Pd-Ag-Au ternary alloy with the Pd-Ag layer. This symmetry of the (1 1 1) diffracted peak after 16 and 24 hours of thermal treatment can be better observed in Figure 3b. The calculated lattice parameter of the Pd-Ag-Au main peak was 3.924 Å.
Figure 3. XRD spectra at a) $2\Theta = 30^\circ - 90^\circ$ and b) $2\Theta = 35^\circ - 45^\circ$ of Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$ (M1Au) after Au deposition (represented with a red line) and after a subsequent annealing process at 550 $^\circ$C during 8 hours (blue line), 12 hours (green line), 16 hours (orange line) and 24 hours (black line).

SEM characterization of the cross-section of all the membranes before and after the addition of gold was performed in order to calculate their thicknesses (figures not reported here). Membranes M1 and M1Au, which will be used in single gas conditions to test the hydrogen
permeation at different temperatures showed 2.95 ± 0.25 µm and 2.71 ± 0.19 µm (thicknesses without and with Au, respectively. The M2, M2Au and M3Au membranes, which will be further tested under H₂S atmosphere with different concentrations, had a thickness of 2.53 ± 0.25, 3.13 ± 0.09 and 2.42 ± 0.15 µm, respectively. Only a small increase in the thickness was found after Au addition to M2, but when considering the standard deviation of the cross-section measurements with SEM, the differences can be considered negligible.

3.2 Permeation and characterization results of thin Pd-Ag and Pd-Ag-Au supported membranes

3.2.1 Single gas permeation test

The hydrogen and nitrogen fluxes through Pd₉₄.₉Ag₅.₁ (M1) and Pd₉₁.₇Ag₄.₆Au₃.₅ (M1Au) membranes were evaluated together in the multi-membrane reactor described in [23] at various pressures (ranging from 1 to 3 bar of total pressure) and temperatures (between 400 and 600 °C) in order to study the effect of Au addition onto the M1 membrane on the permeation properties. In the reactor, both membranes were tested at exactly the same conditions of temperature, pressure difference and time obtaining thus comparable results. The setup was heated up to 400 °C and the membranes were activated following the activation protocol in order to remove organic impurities on the membrane surface as reported in [23]. The H₂ flux of the activated membranes was measured at different temperatures and pressure differences across the membrane.

In order to determine the value of $n$, a fit through the H₂ flux data to pressure differences was evaluated for different values of $n$ and the linear regression factor $r^2$ was determined and this is shown in Figure 4. The highest value of $r^2$ is not obtained with $n = 0.5$ for Pd₉₁.₇Ag₄.₆Au₃.₅ (M1Au) (Figure 4b), showing that the permeation characteristics of the composite membrane follows a slightly different permeation mechanism than the Sieverts–Fick [7]. This behavior has also been found by Iulianelli et al. [27] for a PdAu₇ dense layer supported on a porous stainless steel (PSS) support at 420 °C. However, Pd₉₄.₉Ag₅.₁ (M1) as depicted in Figure 4a, showed its highest regression factor with $n = 0.5$ in the range 400-500 °C and with $n = 0.6$ at 550 °C and 600 °C, confirming that the addition of Au leads to an increasing importance of adsorption dissociation as rate limiting step instead of bulk transport in the solution-diffusion model for hydrogen permeation. Figure 5 shows the H₂ permeation flux as a function of the the difference
of the square root of the pressure between the retentate and permeate sides in the range 400-600 °C for the Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$ (M1Au) membrane.

Figure 4. Regression factor of H$_2$ flux versus different transmembrane pressures with various values of $n$ for a) M1 and b) M1Au in a range of temperatures from 400 °C to 600 °C.

Figure 5. Hydrogen flux through the Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$ (M1Au) membrane as a function of difference of square root of the hydrogen pressure on the retentate and permeate sides at different temperatures.

From the permeation studies at different temperatures, the activation energies of H$_2$ permeation of the M1 and M1Au membranes were calculated using the Arrhenius equation as shown in Figure 6. For M1 (Pd$_{94.9}$Ag$_{5.1}$) an Ea of 9.5 kJ mol$^{-1}$ was obtained, which is within the range of
similar Pd-Ag alloy membranes reported by our group [28] (10 kJ mol$^{-1}$ for a 4µm thick Pd$_{86}$Ag$_{15}$ membrane). On the other hand, the Ea for Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$ membrane was 16.0 kJ mol$^{-1}$ which is exactly the same as found by Braun et al. for a PdAu$_{22}$Ag$_{8}$ membrane [13]. Since in this work the permeation experiments were carried out in the same reactor at the same conditions and the base PdAg membrane is the same, the previous results suggest that the addition of small amounts of Au influences the permeation mainly in the adsorption dissociation step, which is favored by the presence of Au on the surface as demonstrated in Figure 4.

![Figure 6](image.png)

**Figure 6.** Determination of the activation energy ($E_a$ in kJ mol$^{-1}$) of H$_2$ permeation of the M1 (Pd$_{94.9}$Ag$_{5.1}$) and M1Au (Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$) membranes

The differences in H$_2$ permeation between the membranes M1 and M1Au are depicted in Figure 7, which shows the H$_2$ flux at 100 kPa pressure difference from 400 °C to 600 °C. It can be observed that at temperatures lower than 500 °C the H$_2$ permeation of M1 is higher than M1Au. However, at 550 °C or higher, M1Au overtakes M1 in terms of hydrogen flux. This could be explained by the ability of Au to dissociate H$_2$ at high temperatures.
Figure 7. Comparison of hydrogen flux of $\text{Pd}_{94.9}\text{Ag}_{5.1}$ (M1) and $\text{Pd}_{91.7}\text{Ag}_{4.8}\text{Au}_{3.5}$ (M1Au) at 100 kPa pressure difference from 400 °C to 600 °C.

Only a few studies were found in the literature that correlate the hydrogen permeability, temperature and Au composition for Pd-Au membranes. These include the works reported by McKinley [8] at 350 °C, both theoretical calculations for 350 °C and 500 °C by Catalano et al. [29] and Gryaznov research [30] at 500 °C. The ratio between the hydrogen flux of Pd-Au and Pd membranes increases until around 10 wt% Au at 350 °C and 500 °C. After this point, the $H_2$ flux slowly decreases down to zero when the Au % overcomes 50 %.

The M1 ($\text{Pd}_{94.9}\text{Ag}_{5.1}$) and M1Au ($\text{Pd}_{91.7}\text{Ag}_{4.8}\text{Au}_{3.5}$) membranes were tested for 150 h at 600 °C and 1 bar pressure difference in order to assess its long-term performance. The $H_2$ and $N_2$ flow rates were monitored over time to determine the evolution of the $H_2$ permeance and the $H_2/N_2$ ideal perm-selectivity (see Figure 8). Both membranes showed a similar behavior with regard to the hydrogen flow rate over 150 h. A small drop in the hydrogen permeation was detected after the long term test; for the $\text{Pd}_{98}\text{Ag}_2$ membrane from $5.71 \times 10^{-6}$ mol s$^{-1}$ m$^{-2}$ Pa$^{-1}$ down to $4.15 \times 10^{-6}$ mol s$^{-1}$ m$^{-2}$ Pa$^{-1}$ (27%) and also for the $\text{Pd}_{91.7}\text{Ag}_{4.8}\text{Au}_{3.5}$ membrane the hydrogen permeation decreased from $6.24 \times 10^{-6}$ to $4.77 \times 10^{-6}$ mol s$^{-1}$ m$^{-2}$ Pa$^{-1}$ (24%). A similar decrease in the hydrogen permeance as a function of time at 600 °C has been observed by Abu El Hawa et al. [31] for a 4.9 µm thick Pd membrane during 250 h and for a 6.0 µm thick PdRu$_{0.3}$ membrane for almost 500 h. As described by Okazaki et al. [32], the hydrogen permeation flux through a 3.8 µm thick palladium membrane on an α-alumina support decreased markedly during the permeation tests conducted at temperatures above 600 °C due to the formation of a Pd-Al alloy (due to the
reduction of alumina to aluminum at high temperature in the presence of H$_2$ [32]). In this work, the zirconia layer on the outside of the support and in contact with the Pd alloy membrane, prevents the formation of any strong support interaction as reported by Okazaki et al. [32]. During the long-term test of the M1 and M1Au membranes the nitrogen permeation rate increased slowly leading to a decrease in the H$_2$/N$_2$ ideal perm-selectivity from 538 to 317 for Pd$_{94.9}$Ag$_{5.1}$ and from 378 to 244 for Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$ membranes with a rate of 1.67·10$^{-11}$ and 2·10$^{-11}$ mol s$^{-1}$ m$^{-2}$ Pa$^{-1}$ h$^{-1}$ respectively at 600 °C for the 150 h test. According to the findings by Abu El Hawa et al. [31], the nitrogen leakages show higher rates (and their leakage flow rates were higher than those in this work) for a pure Pd membrane at the same operating temperature, whereas the addition of Pt or Ru to Pd films improved the thermal stability by lowering the rate at which the nitrogen leak flow grows in time at 3·10$^{-12}$ mol s$^{-1}$ m$^{-2}$ Pa$^{-1}$ h$^{-1}$.

![Figure 8](image.png)

**Figure 8.** H$_2$ and N$_2$ permeances (mol m$^{-2}$ s$^{-1}$ Pa$^{-1}$) and H$_2$/N$_2$ ideal perm-selectivity of a) M1; and b) M1Au membranes for 150 h at 600 °C and 1 bar of pressure difference.

Three of the membranes prepared in this work, M2, M2Au and M3Au (see Table 1), were used to study their behavior under H$_2$S conditions at 550 °C. The effective length of the membranes after sealing was 14.67 mm, 30.65 mm and 11.16 mm respectively. Before being tested under atmospheres with a different H$_2$S content and for different times on stream, a comparison of the hydrogen fluxes of M2 (Pd$_{96.1}$Ag$_{3.9}$), M2Au (Pd$_{91.5}$Ag$_{4.7}$Au$_{3.8}$) and M3Au (Pd$_{90.5}$Ag$_{4.6}$Au$_{4.9}$) membranes was performed at 550 °C and transmembrane pressure differences up to 3 bar. The results of this characterization, prior to the H$_2$S exposure, are shown in Figure 9. Before testing the H$_2$ permeance, the membranes were activated following the same procedure used for the M1 and M1Au membranes. After the activation, the membranes were left in pure H$_2$ until a stable flux through the membrane was obtained. The obtained initial H$_2$ permeance for the
membranes M2 (Pd\textsubscript{96.1}Ag\textsubscript{3.9}), M2Au (Pd\textsubscript{91.5}Ag\textsubscript{4.7}Au\textsubscript{3.8}) and M3Au (Pd\textsubscript{90.5}Ag\textsubscript{4.6}Au\textsubscript{4.9}) are 1.7·10\textsuperscript{-3}, 2.3·10\textsuperscript{-3} and 3.9·10\textsuperscript{-3} mol s\textsuperscript{-1} m\textsuperscript{2} Pa\textsuperscript{0.5} respectively. The calculated H\textsubscript{2}/N\textsubscript{2} ideal perm-selectivity was above 1850 for all these membranes, since the measured N\textsubscript{2} leakage flow rate was below the detection limit of the flow meter (0.2 mL/min). As shown in the previous results at 550 °C, the Pd-Ag-Au membranes have higher permeances than the Pd-Ag membrane. The H\textsubscript{2} permeance obtained with the single gas tests is used as a reference for the H\textsubscript{2}S exposure and recovery results.

![Figure 9. H\textsubscript{2} flux of membranes Pd\textsubscript{96.1}Ag\textsubscript{3.9} (M2), Pd\textsubscript{91.5}Ag\textsubscript{4.7}Au\textsubscript{3.8} (M2Au) and M3 Pd\textsubscript{90.5}Ag\textsubscript{4.6}Au\textsubscript{4.9} (M3Au) as a function of H\textsubscript{2} difference of square root of the pressure at 550 °C](image)

Table 2 compares the Pd-Ag-Au membranes prepared in this work with the permeation properties of some of the best membranes reported in the literature. The membranes prepared in this work showed the highest hydrogen permeance ever reported among those fabricated by ELP. Only those reported by Peters et al. (a Pd\textsubscript{75}Ag\textsubscript{22}Au\textsubscript{3} membrane of 1.9 µm thickness [18] and a Pd\textsubscript{95}Au\textsubscript{5} membrane of 2.5 µm [33]) prepared by sputtering showed an even higher hydrogen permeance at 400 °C and 450 °C. There is not a clear trend regarding the comparison between a Pd or Pd-Ag membrane and another one alloyed with gold. The hydrogen permeance differs by almost a factor 2 when comparing the M1Au with M2Au membranes, despite the fact the membranes have a similar composition. The observed difference cannot be justified only by a difference in the thicknesses of the membranes, which is only 0.4 µm, and the observed discrepancy needs to be a consequence of other factors that have not yet been determined. A strict comparative analysis regarding the hydrogen recovery after H\textsubscript{2}S exposure
of the different membranes tested in the literature is more difficult because of the large variety in 
$\text{H}_2\text{S}$ concentrations and times of exposure studied in each work.
Table 2. Summary of the H₂ permeance of different Pd-based membranes alloyed with Au and their exposure conditions to H₂S reported in the literature and the ones presented in this work.

<table>
<thead>
<tr>
<th>Membrane /support</th>
<th>Thickness (µm)</th>
<th>Preparation method</th>
<th>Temperature (°C)</th>
<th>H₂ permeance ([10^{-3} \text{ mol s}^{-1} \text{ m}^{-2} \text{ Pa}^{0.5}])</th>
<th>H₂ permeance over pure Pd (%) *</th>
<th>H₂S treatment / Recovery</th>
<th>Reference</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pd₇₅Ag₂₂Au₃ / micro-channel</td>
<td>1.9</td>
<td>Sputtering</td>
<td>400</td>
<td>4.47</td>
<td>82 (over Pd₇₇Ag₂₃)</td>
<td></td>
<td>[18]</td>
</tr>
<tr>
<td>Pd₇₅Ag₂₂Au₃ / micro-channel</td>
<td>1.9</td>
<td>Sputtering</td>
<td>450</td>
<td>4.89</td>
<td>83 (over Pd₇₇Ag₂₃)</td>
<td>20 ppm / 1 hour / 90% H₂–N₂. ~80% flux recovery</td>
<td>[18]</td>
</tr>
<tr>
<td>Pd₇₅Ag₁₆Au₉ / ZrO₂-modified porous stainless steel (PSS) disk</td>
<td>~ 14</td>
<td>ELP</td>
<td>400</td>
<td>0.84</td>
<td>98</td>
<td>100 ppm / 24 hours. 65% flux recovery</td>
<td>[13]</td>
</tr>
<tr>
<td>Pd₇₅Ag₁₆Au₉ / ZrO₂-PSS disk</td>
<td>~ 14</td>
<td>ELP</td>
<td>450</td>
<td>0.97</td>
<td>90</td>
<td></td>
<td>[13]</td>
</tr>
<tr>
<td>Pd₇₈Ag₉Au₁₃ / ZrO₂-PSS disk</td>
<td>~ 14</td>
<td>ELP</td>
<td>400</td>
<td>0.96</td>
<td>111</td>
<td>100 ppm / 24 hours. 80% flux recovery</td>
<td>[13]</td>
</tr>
<tr>
<td>Pd₇₈Ag₉Au₁₃ / ZrO₂-PSS disk</td>
<td>~ 14</td>
<td>ELP</td>
<td>450</td>
<td>1.16</td>
<td>107</td>
<td></td>
<td>[13]</td>
</tr>
<tr>
<td>Pd₉₅Au₅ / micro-channel</td>
<td>2.5</td>
<td>Sputtering</td>
<td>400</td>
<td>4.40</td>
<td>113</td>
<td></td>
<td>[33]</td>
</tr>
<tr>
<td>Pd₇₂Cu₂₅Au₃ / micro-channel</td>
<td>2.1</td>
<td>Sputtering</td>
<td>400</td>
<td>1.81</td>
<td>38</td>
<td></td>
<td>[33]</td>
</tr>
<tr>
<td>Pd₉₁Au₉-ZrO₂ / PSS disk</td>
<td>12</td>
<td>ELP</td>
<td>400</td>
<td>0.92</td>
<td>-</td>
<td></td>
<td>[34]</td>
</tr>
<tr>
<td>Pd₉₁Au₉-ZrO₂ / PSS disk</td>
<td>12</td>
<td>ELP</td>
<td>450</td>
<td>1.25</td>
<td>-</td>
<td></td>
<td>[34]</td>
</tr>
<tr>
<td>Pd₉₂Au₈ / PSS plates</td>
<td>18.1</td>
<td>ELP &amp; Galvanic displacement plating</td>
<td>500</td>
<td>0.26</td>
<td>13</td>
<td>54.8 ppm / 4 hours. 65% flux recovery</td>
<td>[6]</td>
</tr>
<tr>
<td>PdAu₂₀</td>
<td>25</td>
<td>Cold worked</td>
<td>400</td>
<td>0.40</td>
<td>-</td>
<td>20 ppm / 100 hours in 51% H₂; 29% CO₂; 19% H₂O; 1%</td>
<td>[17]</td>
</tr>
<tr>
<td>Membrane Type</td>
<td>Hydrogen Permeance</td>
<td>ELP</td>
<td>Temperature (°C)</td>
<td>Permeance</td>
<td>Recovery (%)</td>
<td>Source</td>
<td></td>
</tr>
<tr>
<td>---------------</td>
<td>--------------------</td>
<td>-----</td>
<td>------------------</td>
<td>------------</td>
<td>--------------</td>
<td>--------</td>
<td></td>
</tr>
<tr>
<td>PdAgAu / ZrO₂-PSS disk</td>
<td>14.0</td>
<td>ELP</td>
<td>400</td>
<td>0.93</td>
<td>108</td>
<td>CO stream 100 ppm / 24 hours. 32% flux recovery [20]</td>
<td></td>
</tr>
<tr>
<td>PdAuAg / ZrO₂-PSS tubes</td>
<td>9.3</td>
<td>ELP</td>
<td>400</td>
<td>~ 0.95</td>
<td>-</td>
<td>20 ppm / 24 hours. 70% flux recovery [19]</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>450</td>
<td>~ 1.1</td>
<td>-</td>
<td>20 ppm / 24 hours. 93% flux recovery [19]</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>500</td>
<td>~ 1.45</td>
<td>-</td>
<td>20 ppm / 24 hours. 85-90% flux recovery [19]</td>
<td></td>
</tr>
<tr>
<td>M1Au. PdAgAu / ZrO₂ ceramic porous tubes</td>
<td>2.71</td>
<td>ELP</td>
<td>400</td>
<td>2.52</td>
<td>81 (over PdAg)</td>
<td>9 ppm / 12.5 hours. 85% recovery [this wok]</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>450</td>
<td>3.21</td>
<td>91 (over PdAg)</td>
<td>- [this wok]</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>500</td>
<td>3.69</td>
<td>96 (over PdAg)</td>
<td>- [this wok]</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>550</td>
<td>4.27</td>
<td>102 (over PdAg)</td>
<td>- [this wok]</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>600</td>
<td>4.71</td>
<td>104 (over PdAg)</td>
<td>- [this wok]</td>
<td></td>
</tr>
<tr>
<td>M2Au. PdAgAu / ZrO₂ ceramic porous tubes</td>
<td>3.13</td>
<td>ELP</td>
<td>550</td>
<td>2.32</td>
<td>135 (over PdAg)</td>
<td>9 ppm / 12.5 hours. 85% recovery [this wok]</td>
<td></td>
</tr>
<tr>
<td>M3Au. PdAgAu / ZrO₂ ceramic porous tubes</td>
<td>2.31</td>
<td>ELP</td>
<td>550</td>
<td>3.91</td>
<td>-</td>
<td>17 ppm / 12.5 hours. 83% recovery [this wok]</td>
<td></td>
</tr>
</tbody>
</table>

*H₂ permeance of each membrane over the Pd membrane developed in each study.
3.2.2 H$_2$S exposure tests

At the end of the pure hydrogen permeation experiments with M2 (Pd$_{96.1}$Ag$_{3.9}$), M2Au (Pd$_{91.6}$Ag$_{4.7}$Au$_{3.8}$) and M3Au (Pd$_{90.5}$Ag$_{4.6}$Au$_{4.9}$) membranes, a sequence of different H$_2$S contents (in ppm) were added to the hydrogen feed gas to investigate the effect of H$_2$S on the hydrogen permeation rate at 550 °C and 1 bar of pressure difference. In Table 3, the concentration of H$_2$S and time of exposure to H$_2$S are shown. M2 (Pd$_{96.1}$Ag$_{3.9}$) was exposed for 15.25 h in total at 1 H$_2$S ppm (10 h and 15 min) and 3 H$_2$S ppm (5 h), whereas the Pd$_{91.5}$Ag$_{4.7}$Au$_{3.8}$ and Pd$_{90.5}$Ag$_{4.6}$Au$_{4.9}$ membranes were exposed for 2.5 h to H$_2$S at each concentration. The H$_2$ permeation rate was measured before and after each H$_2$S inhibition test and the determined relative H$_2$ permeance before and after exposure at the different H$_2$S concentrations is shown in Figure 10a. Subsequently, the feed gas was changed back to pure H$_2$ and the temperature was increased to 600 °C to desorb the sulfur that was reversibly bonded [6]. The recovery step was carried out for 1 h, which allowed reaching a stable H$_2$ permeance through the membranes. The relation between the H$_2$ permeance before the H$_2$S exposure and after recovery is shown in Figure 10b. Post-characterization based on XRD, XPS and SEM analysis was used to investigate the effect of the H$_2$S exposure on the membrane after all the tests were completed.

### Table 3. Concentration of H$_2$S on exposure and total time of exposure for each membrane.

<table>
<thead>
<tr>
<th>Membrane</th>
<th>1 ppm</th>
<th>3 ppm</th>
<th>5 ppm</th>
<th>7 ppm</th>
<th>9 ppm</th>
<th>13 ppm</th>
<th>17 ppm</th>
<th>Total time of exposure [h]</th>
<th>H2/N2 ideal perm-selectivity after H$_2$S tests</th>
</tr>
</thead>
<tbody>
<tr>
<td>M2 (Pd$<em>{96.1}$Ag$</em>{3.9}$)</td>
<td>X</td>
<td>X</td>
<td>X*</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>15.25</td>
<td>18</td>
</tr>
<tr>
<td>M2Au (Pd$<em>{91.5}$Ag$</em>{4.7}$Au$_{3.8}$)</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td></td>
<td></td>
<td></td>
<td>12.5</td>
<td>793</td>
</tr>
<tr>
<td>M3Au (Pd$<em>{90.5}$Ag$</em>{4.6}$Au$_{4.9}$)</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td></td>
<td></td>
<td>12.5</td>
<td>121</td>
</tr>
</tbody>
</table>

* At 9 ppm, H$_2$ flux was entirely inhibited, so the permeation test under H$_2$S exposure was suspended.

For the M2 (Pd$_{96.1}$Ag$_{3.9}$) membrane exposed to 1 ppm of H$_2$S, a decrease of 38% in the H$_2$ permeation rate was observed, caused by the interaction of H$_2$S with active sites on the membrane surface blocking the H$_2$ dissociation sites [18], [35], [36], [37]. After the initial decrease, no further significant decrease in the flux was measured during the exposure. A permanent decrease in the flux during the exposure is expected when bulk sulfides are formed, which have a lower H$_2$ permeability than the Pd-Ag alloy membrane [4], [9]. The H$_2$ permeance
obtained after a 1 h of recovery under pure H\textsubscript{2} at 600 °C was only 52% of the initial permeance before the exposure to 1 ppm H\textsubscript{2}S leading to an incomplete recovery from sulfur poisoning. This could be explained by the formation of irreversible bulk sulfides in some areas of the membrane. During the exposure to 3 ppm H\textsubscript{2}S a reduction in the permeance of 39% of the initial permeance was observed. The recovery after the exposure of 3 ppm of H\textsubscript{2}S resulted in 55% of the initial permeance. During the exposure of 9 ppm the flux decreased below detectable values for the permeate flow rate measurement, which indicates that a full poisoning of the Pd-Ag layer occurred and that there are not large defects in the membrane. However, the thermodynamic equilibrium for Pd\textsubscript{4}S formation at 550 °C and 100% H\textsubscript{2} takes place at 28.5 ppm of H\textsubscript{2}S as reported by Mundschau et al. [9]. After the recovery, the hydrogen flux was twice the initial flux with a H\textsubscript{2}/N\textsubscript{2} ideal perm-selectivity of 18. The very large increase in the hydrogen permeance may suggest that some kind of corrosion has occurred during the hydrogen recovery step. As can be seen in Figure 11, when the M2 membrane (A) was removed from the setup, its surface had lost its initially shiny grey look and had turned into an “unpolished” appearance, whereas membranes the gold alloyed membranes (B and C) remained shiny.

![Figure 10](image-url) Figure 10. a) H\textsubscript{2} permeance normalized with initial permeance during exposure for different concentrations of H\textsubscript{2}S at 550 °C, and b) H\textsubscript{2} permeance after recovery normalized with initial permeance after recovery for different concentrations of H\textsubscript{2}S at 550 °C.
The M2Au was first exposed to 1 ppm of H$_2$S, resulting in 51% of the initial permeance. The lower decrease in the flux compared to the M2 membrane was expected due to the presence of gold. According to Hyman et al. [38] the lower poisoning effect by Au addition is due to the higher energy barrier for H$_2$S to dissociate on gold. This was also demonstrated by Peters et al. [18] for ternary Pd membranes with gold [18]. After the recovery, the permeance obtained is even higher than the initial, exactly 107%. The following tests under 3, 5, 7 and 9 ppm H$_2$S showed a slight increase after each exposure. The increasing trend was, however, not observed after the recovery, so that hydrogen permeance ends at 85% of its initial flux after the 9 ppm test. The M3Au membrane exhibited an almost similar behavior as the M2Au membrane, regarding its hydrogen permeance after recovery, but with a lower poisoning effect under H$_2$S exposure, probably due to its higher Au content. For both M2Au and M3Au membranes, the decrease after recovery can be explained by either irreversibly adsorbed sulfur or the formation of bulk sulfides. The effect of irreversibly adsorbed sulfur or bulk sulfides is more pronounced for exposures at higher H$_2$S concentrations, which leads to the decrease in permeance.

Although the extent of recovery after the H$_2$S exposition is almost similar for the M3Au and M2Au membranes, the decrease in the H$_2$ permeance during the H$_2$S exposure under the same conditions is lower for the M3Au membrane, probably due to its higher Au content. The selectivity was only determined after the last exposure and was not measured during the experiment. As mentioned before, the M2 membrane (Pd$_{96.1}$Ag$_{3.9}$) had a perm-selectivity of 18 after exposure to 9 ppm H$_2$S for 15.25 h. The selectivity obtained for the M2Au (Pd$_{91.5}$Ag$_{4.7}$Au$_{3.8}$) and M3Au (Pd$_{90.5}$Ag$_{4.6}$Au$_{4.9}$) membranes are respectively 793 after 9 ppm and 12.5 h and 121
after 17 ppm and 12.5 h. The results show that the decrease in selectivity is less pronounced when gold is present in the membrane.

3.2.3 Characterization of the membranes after the $\text{H}_2\text{S}$ test

Post characterization based on XRD, XPS and SEM analysis was carried out to investigate the effect of sulfur on the $\text{H}_2$ permeance once all the permeation tests were finalized. The outer surfaces of the membranes were analyzed using SEM (Figure 12). Figures 12a, 12c and 12e are the SEM images of membrane surfaces after the annealing treatment (but before any permeation test), whereas Figures 12b, 12d and 12f show the corresponding results after the $\text{H}_2/\text{H}_2\text{S}$ testing. The SEM micrographs of the M2Au sample (Figure 12c) show that the Au cluster structure of the surface has already merged with the previous Pd-Ag structure. After the $\text{H}_2/\text{H}_2\text{S}$ tests, the Pd-Ag-Au samples in Figure 12f show that full fusion of Au particles with the underlying layer has taken place as a result of the long-term testing at 550 °C and subsequent alloying has occurred. The complete alloying of both Pd-Ag-Au layers was also verified by XRD, shown in Figure 14. The appearance of the Pd-Ag-Au membrane surface after testing is similar to the one reported by [3] for Pd-Au layers after 96 h at 550 °C.

After the $\text{H}_2\text{S}$ tests, for all the samples, the formation of polyhedral structures is observed which is more pronounced for the Pd-Ag membrane when Au is not present (Figure 12b), where spaces are formed between the structures indicating loss of material. An increase in the gold content decreases the tendency to form these structures (see Figure 12d and Figure 12f). The formation of these structures was also reported by Peters et al. [39] for a PdAg$_4$ sample indicating that surface roughening and grain growth also occurred during $\text{H}_2\text{S}$ exposure to 20 ppm for 265 h at 450 °C. A high sulfur concentration was observed (15 at% according to EDS analysis) confirming severe sulfide formation. Similar results were obtained by Braun et al. [20] where a Pd foil revealed the appearance of discrete surface aggregates after 3 h under 1000 ppm $\text{H}_2\text{S}$ exposure at 400 °C. These aggregates grew until they covered the entire surface after 30 h under the same conditions and X-ray characterization confirmed the presence of S in the aggregates of this Pd foil. Nevertheless, no sulfur compounds were detected for the M2 membrane by characterization techniques such as EDS, XRD and XPS. The absence of sulfur compounds completely covering the surface can be attributed to the recovery step, where hydrogen removed the absorbed sulfur, thereby damaging the Pd-Ag layer and leading to a
corrosion effect. The cross-section of the M1 membrane in Figure 13 shows that material was lost and that the membrane became thinner after H$_2$S exposure (Figure 13b), which could be responsible of the significant increase in the hydrogen flux, which was almost double after sulfur tests (Figure 10b). Braun et al. [13] reported defect formation for different Pd-Ag-Au alloys and after 24 h under 100 ppm H$_2$S exposure at 400 °C. Moreover, Gade et al. [17] analyzed two Pd-Au membranes (PdAu$_{7.0}$ and PdAu$_{10.1}$) fabricated by sputtering, and they observed a reduction of their thicknesses from 11 µm to 3.3 µm and from 31 µm to 26 µm respectively after water-gas-shift (WGS) tests at 400 °C with 20 ppm of H$_2$S.
Figure 12. SEM surface images of a) Pd$_{96.1}$Ag$_{3.9}$ (M2) before testing; b) Pd$_{96.1}$Ag$_{3.9}$ (M2) after testing under H$_2$S conditions; c) Pd$_{91.5}$Ag$_{4.7}$Au$_{3.8}$ (M2Au) before testing; d) Pd$_{91.5}$Ag$_{4.7}$Au$_{3.8}$ (M2Au) after testing under H$_2$S conditions; e) Pd$_{90.5}$Ag$_{4.6}$Au$_{4.9}$ (M3Au) before testing; f) Pd$_{90.5}$Ag$_{4.6}$Au$_{4.9}$ (M3Au) after testing under H$_2$S conditions.

Figure 13. SEM cross-section images of a) M2 (Pd$_{96.1}$Ag$_{3.9}$) prior to permeation tests and b) M2 (Pd$_{96.1}$Ag$_{3.9}$) after testing under H$_2$S conditions

In order to determine whether bulk sulfides were formed on the membrane surface during the tests, the metal films were removed from the ceramic support before the XRD analysis. Figure 14 shows the X-ray diffraction patterns obtained for the Pd$_{96.1}$Ag$_{3.9}$ and Pd$_{91.5}$Ag$_{4.7}$Au$_{3.8}$ membranes before and after H$_2$ exposure tests. The M2 (Pd$_{96.1}$Ag$_{3.9}$) peaks are symmetric indicating that complete annealing was achieved before any H$_2$S test. After H$_2$S exposure, these
diffracted peaks suffered a small deformation, indicating the start of dealloying, as reported by Lewis et al. [19] for PdAu23 and PdAu20Ag13 membranes after 24 h exposure of 20 ppm of H2S in H2 as feed gas and subsequent tests under WGS feed conditions. However, there are no signs of clear sulfide peaks. As was reported for the M2(Pd96.1Ag3.9) membrane after H2S exposure, only a starting depletion of the Pd-Ag main diffraction peaks is described by Lewis et al. [19] due to the sulfide effect, compared to the Pd-Ag peak before any permeation tests. Regarding the M2Au (Pd91.5Ag4.7Au3.8) membrane, the peaks before testing are not symmetric, which indicates that alloying was not yet complete. The M2Au (Pd91.5Ag4.7Au3.8) membrane after the 12.5 h test under H2S exposure shows sharp diffracted peaks, from which it is concluded that after all the tests complete annealing was reached. Moreover, no sulfur and bulk sulfide phases were detected.

Figure 14. X-ray diffraction patterns of M2 and M2Au membranes before and after H2S exposure. H2S treatment conditions listed in Table 3.

Figure 15a–e shows the XPS depth profiles, where the atomic compositions as a function of the XPS etching time is obtained for Pd-Ag based membranes exposed to different H2S concentrations. The XPS analysis is performed on the membrane prior to exposure and after the H2S tests. The composition of the Pd96.1Ag3.9 membrane did not change significantly after its exposure to H2S. The amount of sulfur found on the surface in the beginning of the
characterization were 1.71 at% in M2, 2.8 at% in M2Au and 8.7 at% in M3Au but these values were rapidly reduced to almost 0 at% in all the samples indicating that there was not any remaining sulfur. These values are very small compared to those found by Peters et al. [18], but the total time of exposure was much longer in that study. The undetectably low hydrogen permeation rate found for the Pd-Ag membrane under 9 ppm of H₂S (Figure 11a), but lack of sulfur presence throughout the XPS test, suggests that the recovery step carried out under a H₂ stream at 600 °C during 1 h removed the Pd-S structure. The remainder of sulfur detected is expected to be either bulk sulfides or irreversible adsorbed sulfur [40].

Regarding the M2Au and M3Au membranes, in both samples the palladium content increases on the surface compared to their values prior to exposure. The migration of Pd to the surface of the membrane after testing could be explained by the lack of total annealing (in terms of time and/or temperature). It also explains the increase in the permeance found for Pd₉₁₅Ag₄₇Au₃₈, since it needed a longer activation time to reach a stable permeance prior to exposure. The gold content on the surface of the M3Au is higher than in the M2Au membrane, as expected due to the higher Au amount added in the ELP deposition process. For both gold containing samples, with an increase in the etching time, there is a slight decrease in the palladium concentration and an increase in the gold concentration, while the silver concentration remained constant.

In other studies, the increase in the Pd content on the feed-side surface after H₂S exposure, corroborates Au surface depletion on the feed side after H₂S testing reported by Lewis et al. [19] for two Pd-Ag-Au membranes fabricated by ELP. Gade et al. [17] also described lower contents of Au on their surfaces after testing. However, these values are still higher than the ones calculated as the theoretical ones added during the Au electroless plating. This observation can be explained by incomplete annealing or by Au surface segregation, as reported by Gade et al. [26] for Pd-Au membranes prepared by sequential electroless plating, where an unalloyed layer of pure Pd remained below the gold. In addition, Au was the last metal to be deposited during the electroless plating process. It is possible that due to a too low annealing temperature and/or too short annealing time, complete homogenization may not have been accomplished throughout this process, and this would explain why the surface was Au enriched [19].
Figure 15. XPS depth profiles; a) M2 (Pd$_{96.1}$Ag$_{3.9}$) prior to exposure; b) M2 (Pd$_{96.1}$Ag$_{3.9}$) after exposure; c) M2Au (Pd$_{91.5}$Ag$_{4.7}$Au$_{3.8}$) prior to exposure, d) M2Au (Pd$_{91.5}$Ag$_{4.7}$Au$_{3.8}$) after exposure; e) M3Au (Pd$_{90.5}$Ag$_{4.6}$Au$_{4.9}$) prior to exposure and f) M3Au (Pd$_{90.5}$Ag$_{4.6}$Au$_{4.9}$) after exposure.

4. Conclusions

Pd-Ag-Au membranes were prepared by Au deposition by electroless plating on PdAg membranes. In order to study the effect of the addition of Au, half of the membrane was plated with Au leaving the other half with only PdAg. Hydrogen permeation properties were studied providing a fair comparison of the effect of gold. The Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$ membrane showed a higher hydrogen permeation rate than the Pd$_{94.9}$Ag$_{5.1}$ membrane above 550 °C. The Pd-Ag and Pd-Ag-Au membranes exhibited a slight decrease in their hydrogen flux and a small increase in the nitrogen fluxes over the 150 h test at 600 °C. A H$_2$ permeance of 4.71·10$^{-3}$ mol s$^{-1}$ m$^{-2}$ Pa$^{0.5}$ at 600 °C was obtained for the Pd$_{91.7}$Ag$_{4.8}$Au$_{3.5}$ membrane that had a thickness of 2.71 µm. The activation energy for the H$_2$ flux through the Pd$_{94.9}$Ag$_{5.1}$ membrane was determined at
9.5 kJ·mol\(^{-1}\). However, after the addition of Au, the activation energy was found to increase up to 16.0 kJ·mole\(^{-1}\), showing that the addition of Au has an effect on the adsorption and dissociation steps in the solution-diffusion model of the H\(_2\) transport through Pd-based membranes. This was also corroborated with the regression factor values obtained for different values for \(n\) in Sieverts’ equation, where \(n\) is very close to 0.5 for Pd-Ag and increases to 0.7-0.8 after the addition of Au. The H\(_2\) permeance of Pd-Ag and Pd-Ag-Au membranes with different gold compositions was measured under exposure to H\(_2\)S for different H2S concentrations and exposure times and after recovery. The addition of Au to the Pd-Ag membranes increases the resistance to H\(_2\)S poisoning. The H\(_2\)/N\(_2\) ideal perm-selectivity of Pd-Ag-Au membranes was maintained better after H\(_2\)S exposure compared to the Pd-Ag membranes. However, the decrease in the selectivity after exposure is still substantial. The membranes exposed to H\(_2\)S, showed that sulfur has an effect on the surface of the membranes by the formation of polyhedral crystals after testing and removing H\(_2\)S. The formation these of polyhedral structures produce corrosion in the Pd-Ag membrane, increasing the hydrogen permeation. This phenomenon is less pronounced when Au is added.

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