Zero-Gap Alkaline Water Electrolysis Using Ion-Solvating Polymer Electrolyte Membranes at Reduced KOH Concentrations

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Membranes based on poly(2,2′-(aminophenylene)-5,5-bibenzimidazole) (m-PBI) can dissolve large amounts of aqueous KOH to give electrolyte systems with ion conductivity in a practically useful range. The conductivity of the membrane strongly depends on the concentration of the aqueous KOH phase, reaching about 10⁻² S cm⁻¹ or higher in 15–25 wt% KOH. Herein, m-PBI membranes are systematically characterized with respect to performance and short-term stability as electrolyte in a zero-gap alkaline water electrolyzer at different KOH concentrations. Using plain uncatalyzed nickel foam electrodes, the cell based on m-PBI outperforms the cell based on the commercially available state-of-the-art diaphragm and reaches a current density of 1500 mA cm⁻² at 2.4 V in 20 wt% KOH at 80°C. The cell performance remained stable during two days of operation, though post analysis of the membrane using size exclusion chromatography and spectroscopy reveal evidence of oxidative degradation of the base polymer at KOH concentrations of 15 wt% and higher.

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Experimental

Materials.—The m-PBI membranes were prepared as reported elsewhere, using m-PBI from Danish Power Systems ApS with an inherent viscosity ηₘ₉₉ of 0.95 dL g⁻¹ as determined in 96 wt% H₂SO₄ (500 mg dL⁻¹ solid content) at 30.0°C using an Ubbelohde capillary viscosimeter. Based on the previously reported swelling data, the membranes were cast to different thicknesses so that membranes with a thickness of 50–60 μm were obtained after equilibration in aqueous KOH regardless of the KOH concentration. The aqueous KOH solutions were prepared by dissolving KOH pellets (Sigma-Aldrich, assay ≥ 85% KOH, ≤ 1% K₂CO₃) in deionized water and the concentrations were confirmed by density measurements and compared with literature data. Aqueous KCl conductance standard solutions (Sigma-Aldrich, 1.0 and 0.1 mol L⁻¹) were used for the calibration of the conductivity cell. The nickel foam (thickness 1100 μm) was purchased from American Elements. Zirfon Pearl 500 UTP was supplied by Agfa.
Membrane characterization.—The ion conductivity was measured in a tubular cell (inner diameter 0.9 cm) composed of two separate blocks made of poly(tetrafluoroethylene) (PTFE). One electrode made of nickel mesh was fixed in each block using PTFE gaskets. The cell was assembled using screws made of poly(ether ether ketone) (PEEK) and the interelectrode distance in the cell assembly was 4.6 mm. The cell was placed with the tubular void in a vertical orientation in a PTFE beaker filled with aqueous KOH, and placed in an oven for temperature control. The resistance between the electrodes, taken as $Z_{im}$ at $Z_{eq} = 0 \Omega$, was recorded by electrochemical impedance spectroscopy using a VersaStat 3 from Princeton Applied Research. The ion conductivity $\sigma$ of the $m$-PBI membranes was calculated according to Equation 1, where $t$ is the thickness taken as an average of 5 measurements, $R$ is the measured resistance taken as an average of 4 scans, $R_{\text{blank}}$ is the resistance recorded for the electrolyte without the membrane, and $A$ is the cross-sectional area of the cell. The thickness at 40, 60 and 80°C was taken as the initial membrane thickness before increasing the temperature.

$$\sigma = t/(R - R_{\text{blank}}) \times A$$

[1]

Scanning electron microscopy (SEM) was carried out on a Carl Zeiss EVO MA10. The cross-sections were prepared by ion-milling using a Hitachi E-3500. The Fourier transform infrared (FTIR) spectroscopy using a VersaStat 3 from Princeton Applied Research. The water electrolysis experiments were performed in a zero-gap laboratory cell mounted in the setup schematically represented in Figure 2a. Gear pumps circulated the electrolyte in separated compartments at flow rates of 100–120 mL min$^{-1}$. The electrolysis cell is visualized in Figure 2b, consisting of flow field plates with a linear pattern made from stainless steel coated with electroless nickel containing phosphorous (1), nickel foam electrodes with a diameter of 38.5 mm (area 11.6 cm$^2$) (2), $m$-PBI membrane or Zirfon diaphragm (diameter 44.5 mm) (3), and PTFE gaskets with an outer diameter of 70 mm and an inner diameter of 39 or 45 mm (4). Heating elements and a thermocouple were placed within the flow field plates to control the temperature. An Elektro Automatik EA-PS 3016-20 B unit controlled by a LabVIEW interface was used for the power supply. The cells were carefully assembled in a horizontal orientation. The cells were conditioned at 10–50 mA cm$^{-2}$ for 15–60 minutes before the first polarization curve was recorded, and thereafter operated in galvanostatic mode at 1.7 V or 2.0 V. Polarization curves were recorded after 0, 2, 25 and 48 hours of operation by scanning the potential from 1.225 V to 2.2 or 2.5 V with a scan rate of 2.5 mV s$^{-1}$. Since there were no autonomous water feed, or any balancing of concentration gradients and electrolyte level, water and electrolyte were added manually, usually after approximately 1 day.

![Figure 1](image1.png)  
Figure 1. The chemical structure of $m$-PBI in the neutral pristine form (left) and in the potassium poly(benzimidazolide) form (right).

![Figure 2](image2.png)  
Figure 2. A schematic drawing of the system (a) and an exploded view of the cell hardware (b) where 1 denote the cell house, 2 denote the nickel foam electrodes, 3 denotes the $m$-PBI membrane and 4 denote PTFE gaskets.
The conductivity of the m-PBI membranes was measured after equilibration in aqueous KOH of different concentrations, as shown in Figure 3. The conductivity of the corresponding aqueous KOH solutions are shown for comparison and were in agreement with data in the literature. When the KOH concentration of the bulk solution was increased from 5 to 15 wt%, the ion conductivity of the m-PBI membrane was increased by two orders of magnitude from 0.7 to 72 mS cm$^{-1}$. By further increasing the concentration of the bulk solution to 20 and 25 wt%, the conductivity of the m-PBI membrane was further increased to 85 and 148 mS cm$^{-1}$, respectively.

The working temperature of an alkaline electrolyzer is, however, normally around 80 °C and it is therefore of interest to measure the conductivity as a function of temperature. The conductivity of the bulk solution as well as that of the m-PBI membrane increased with increasing temperature. The conductivity of the m-PBI membrane was found to peak in 25 wt% at 80 °C, reaching 260 mS cm$^{-1}$, but even in 15 wt% aqueous KOH the conductivity was as high as 155 mS cm$^{-1}$. It indicates that the KOH concentration can be significantly reduced from typically 30 wt% for conventional electrolyzers, resulting in a significant relief on the system and auxiliary units as recently discussed by Diaz et al. It should be remarked that the relative uncertainty of the conductivity data increases as the difference between $R$ and $R_{\text{blank}}$ is getting smaller, i.e. in the region where the conductivity peaks. Furthermore, the membranes tend to be mechanically soft in this KOH concentration range, and the precision of the thickness determination is therefore reduced.

Based on the four data points, the activation energy for ion conductivity $E_a$ was estimated by fitting the data to the Arrhenius equation (Eq. 2 in logarithmic form), where $\sigma$ is the ion conductivity, $\sigma_0$ is the pre-exponential factor, $T$ is the absolute temperature and $R$ is the universal gas constant.

$$\ln(\sigma) = \ln(\sigma_0) - \left(\frac{E_a}{RT}\right)$$ [2]

For aqueous the KOH solutions, the activation energy was found to be in the range of 8–15 kJ mol$^{-1}$ and tended to increase slightly with increasing KOH concentration, in good agreement with the data predicted by the model developed by Gilliam et al. Ion conductivity in aqueous basic solutions and polymeric materials represent fundamentally complex processes involving many interacting species. The observed activation energies fall in the range for the typical structure diffusion (Grotthuss) mechanism. Interestingly, the activation energy for ion conductivity of the m-PBI membrane equilibrated in aqueous KOH was only marginally higher than that of the bulk solutions in the intermediate concentration range (15–35 wt%), i.e. in the range where the ionic form of m-PBI predominates in the non-crystalline form and where remarkably high electrolyte uptake occurs, indicating a quasi-liquid like conduction.

For the alkaline water electrolysis tests, the m-PBI membranes were sandwiched in between two electrodes made of nickel foam to form a membrane electrode assembly (MEA). The concept is illustrated in Figure 4, showing a cross-sectional SEM micrograph of a MEA using a dry pristine m-PBI membrane. The cell tests the m-PBI membranes were pre-equilibrated in aqueous KOH to give MEAs with inter-electrode distances in the range of 50–60 μm. The MEAs were tested in the alkaline electrolyzer at 80 °C and under ambient pressure. As shown in Figure 5, the cell operating with 5 wt% aqueous KOH as electrolyte reached only a modest current density of 22 mA cm$^{-2}$ at 2.4 V, apparently due to the low ion conductivity of m-PBI in this environment (Figure 3). As expected from the conductivity data, the current density at 2.4 V was significantly lower than that of an electrolyzer employing a commercial Zirfon diaphragm.
The viscosity decreases at lower concentrations,\textsuperscript{48} which promotes bubble dislocation and therefore reduces the gas bubble surface coverage and facilitates gas escape through the pores in the structure of the nickel foam electrode. Depending on electrode geometry and pore size distribution, the effects of changes in viscosity may be quite significant.

Chemically, m-PBI shows good stability in aqueous KOH in the lower concentration range (<10 wt%) for 6 months at temperatures above 80°C,\textsuperscript{37} but it gradually degrades by hydrolysis at higher concentrations. However, it can be expected that the membrane degradation rate is enhanced due to the electrode polarization and the formation of highly reactive species and reaction intermediates (e.g., radicals) at the membrane surfaces. For example, oxidation of the polymer may occur near the anode where oxygen is evolved. When doped with phosphoric acid, m-PBI appears stable for thousands of hours in fuel cells\textsuperscript{54} but severely degrades within a few hours when operated in steam electrolysis mode.\textsuperscript{35}

To assess the effect of polarization on a slightly longer time-scale, the cells operating with 5, 15 and 30 wt% KOH were kept at 1.7 or 2.0 V for 2 days and the current density was recorded as functions of time. The current density development for the cell operated in 15 wt% at 2.0 V is shown in Figure 6a. Polarization curves were recorded after certain durations of set-point operation as shown in Figure 6b. Due to electrode activation, perhaps from iron impurities as discussed above,\textsuperscript{55} the onset potential was observed to improve even when conductivity data alone suggest a different trend. Conversely, no apparent changes of the slope in the linear region of the polarization curve were evident, indicating no significant changes in ohmic resistance.

The cells were run potentiostatically for a total of 48 hours and several polarization curves reaching higher potentials for short durations were recorded. From the polarization data, no changes in cell performance could be ascribed to the membrane degradation and membrane integrity appeared good after disassembly for all cells except the cell operated in 30 wt% at 2.0 V. In the latter case, after the cell was disassembled a hole was observed in the membrane close to the electrolyte inlet, likely due to mechanical stress caused by liquid pressure fluctuations. A migration of the electrolyte from anode to cathode compartment was observed during operation, and the phenomenon seemed to increase with increasing current density. It was also observed that the membrane equilibrated in 30 wt% KOH was prone to short circuiting even during cell assembly, likely due to its

An improved performance at lower concentrations is not unexpected, even when conductivity data alone suggest a different trend. The viscosity decreases at lower concentrations,\textsuperscript{48} which promotes bubble dislocation and therefore reduces the gas bubble surface coverage and facilitates gas escape through the pores in the structure of the nickel foam electrode. Depending on electrode geometry and pore size distribution, the effects of changes in viscosity may be quite significant.

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low mechanical strength.\(^{31,47}\) To reduce the surface roughness of the electrodes they were therefore pressed with spacers before cell assembly to a thickness of 210 \(\mu\)m for the measurements with \(m\)-PBI and 420 \(\mu\)m for the measurements with Zirfon. It is worth noting that a gradually degrading membrane would not necessarily affect the electrochemical performance of the cell negatively, but could result in mechanical deterioration of the membrane ultimately leading to short-circuiting. Unlike cells based on ion exchange membranes, where the only conducting medium is the membrane, the liquid electrolyte could substitute the membrane locally in this system. An increased gas crossover is then expected, but it was not possible to monitor developed gasses with the experimental setup used.

The FTIR and \(^1\)H NMR spectra of the \(m\)-PBI membranes after operation at 2.0 V for 48 h in 5, 15 and 30 wt% KOH are shown in Figures 7a and 7b, respectively. The FTIR and \(^1\)H NMR spectra of the membrane that had been operated in 5 wt% KOH were practically identical with those of the starting material. The FTIR spectrum of the membrane that had been operated in 15 wt% KOH were practically identical with the FTIR spectrum of the reference material, indicating limited structural changes resulting from amino-groups. For comparison, the amino groups of the poly(methyl methacrylate) standards and summarized in Table I. Thus, a peak broadening toward higher retention times can be observed with increasing KOH concentration. Furthermore, the effect seems more pronounced after operation at higher cell voltage and therefore higher current densities. This clearly indicates increasing fraction of low molecular weight \(m\)-PBI, as previously observed for \(m\)-PBI membranes kept in aqueous KOH of high concentrations at close to 90°C for 6 months.\(^{47}\) It should be remarked that a minor fraction of the samples that had been operated in 15 and 30 wt% was insoluble in DMAc after electrolysis testing. The gel content was estimated to about 5%.

The molecular weight data were obtained from calibrations with poly(methyl methacrylate) standards and summarized in Table I. The peak molecular weights \(M_p\) shifted from 195000 g mol\(^{-1}\) for the reference material to 191000, 185000 and 159000 g mol\(^{-1}\) after operation at 2.0 V in 5, 15 and 30 wt% aqueous KOH, respectively. At the temperature of the second decomposition step was lowered to 637°C. After operation in 30% the second onset appeared as a diffuse shoulder at around 600°C. A similar shift of the second onset of decomposition to lower temperatures has previously been observed for \(m\)-PBI membranes after aging in 25–30 wt% aqueous KOH for about 6 months.\(^{47}\)

The size exclusion chromatograms of \(m\)-PBI after water electrolysis operation in 5, 15 and 30 wt% KOH for 2 days at 1.7 or 2.0 V are shown in Figure 9. In general, a peak broadening toward higher retention times can be observed with increasing KOH concentration. Furthermore, the effect seems more pronounced after operation at higher cell voltage and therefore higher current densities. This clearly indicates increasing fraction of low molecular weight \(m\)-PBI, as previously observed for \(m\)-PBI membranes kept in aqueous KOH of high concentrations at close to 90°C for 6 months.\(^{47}\) It should be remarked that a minor fraction of the samples that had been operated in 15 and 30 wt% was insoluble in DMAc after electrolysis testing. The gel content was estimated to about 5%.

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same time the polydispersity index was increased from 2.61 for the reference material to 2.95, 6.86 and 7.37, indicating a broadening of the molecular weight distribution. This effect was further strengthened by the increased weight average molecular weight $M_w$, likely due to agglomeration or partial oxidative crosslinking of the polymer as also supported by the existence of a small insoluble fraction. This phenomenon is different from the effect observed under simulated degradation conditions in aqueous KOH or in the Fenton solution, indicating a different degradation mode during in situ operation.

In brief, operation at 2.0 V in 5 wt% KOH resulted in very limited degradation of the polymer. Higher rates of the electrochemical reactions were obtained at the same cell voltage when the KOH concentration was increased to 15 and 30 wt%, which resulted in enhanced membrane degradation. Generally, the rate of hydrolysis of m-PBI in aqueous KOH increases with increasing KOH concentration, but whether the effect observed here is due to the increased KOH concentration or due to the higher rates of the electrochemical processes remain to be investigated. It is, however, anticipated that further exploration of the degradation modes under cell operation will provide information for the rational design of new polybenzimidazole derivatives with improved long-term stability.

Conclusions

Membranes based on m-PBI can be used as electrolytes in an alkaline water electrolyzer with zero-gap design, showing considerable better performance than traditional porous separators even at lower concentrations of the aqueous KOH electrolyte. The best performance was achieved in 20–25 wt% aqueous KOH, which is also the concentration range where the ion conductivity reached a maximum at 20–80 °C. Stable water electrolysis operation was demonstrated for 2 days in 5, 15 and 30 wt% KOH. Post analysis of the membrane revealed evidence of oxidative degradation of m-PBI after operation in 15 and 30 wt% KOH, likely with a different degradation mode than observed ex-situ. In 5 wt% KOH the membrane degradation was very limited even after 2 days at 2.0 V. Higher KOH concentration and/or higher cell voltage resulted in enhanced degradation. As a result, the membrane stability on one hand must be balanced against cell performance on the other. Further exploration of the degradation modes under cell operation will provide information for the rational design of new polybenzimidazole derivatives with improved long-term stability for advanced alkaline water electrolyzers.

Acknowledgments

This work was financially supported by DTU Energy. Danish Power Systems ApS is gratefully acknowledged for supplying the m-PBI used in this work.

Table 1. Summary of molecular weight data calculated on basis of calibration with a poly(methyl methacrylate) standard.

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<th>$M_w \times 10^{-3}$ g mol$^{-1}$</th>
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References
