

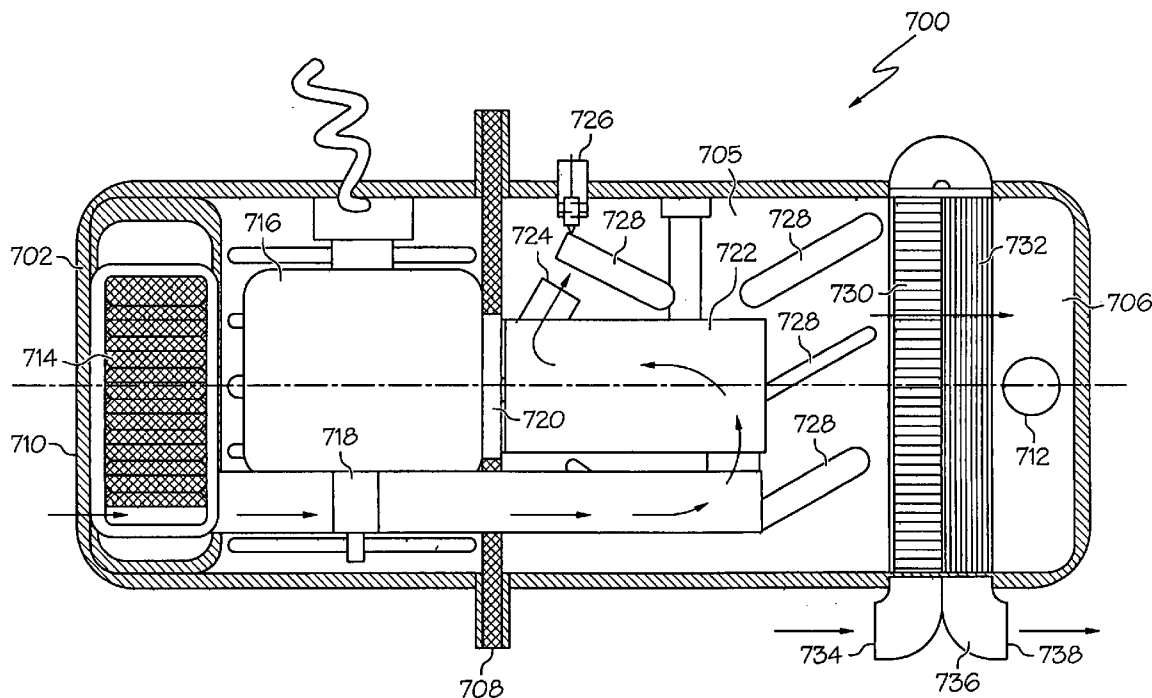


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(19) **United States**(12) **Patent Application Publication****Meltser et al.**(10) **Pub. No.: US 2007/0082242 A1**(43) **Pub. Date: Apr. 12, 2007**(54) **INTEGRATED AIR SUPPLY WITH  
HUMIDIFICATION CONTROL FOR FUEL  
CELL POWER SYSTEMS****Publication Classification**(51) **Int. Cl.**  
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429/25**(76) **Inventors:** **Mark A. Meltser**, Pittsford, NY (US);  
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(US); **Christian Konig**, Dreieich (DE);  
**John B. Ruhl**, Rochester, NY (US)(57) **ABSTRACT**

A fluid delivery device for an electrochemical conversion assembly. In one embodiment, the electrochemical conversion assembly is a fuel cell system. The device includes one or more fluid-manipulating components combined into a housing to minimize weight, size and complexity. In one form, the device may include a compressor, heat exchanger and a water vapor transfer unit, at least the latter two of which are located within a chamber defined by the housing. A controller can be used to monitor and selectively vary the extent to which at least one of these components modifies properties a fluid (such as air) that can be used as a reactant in the electrochemical conversion assembly. In a particular form, the heat exchanger and water vapor transfer unit can cooperate to promote the hydration of the reactant.

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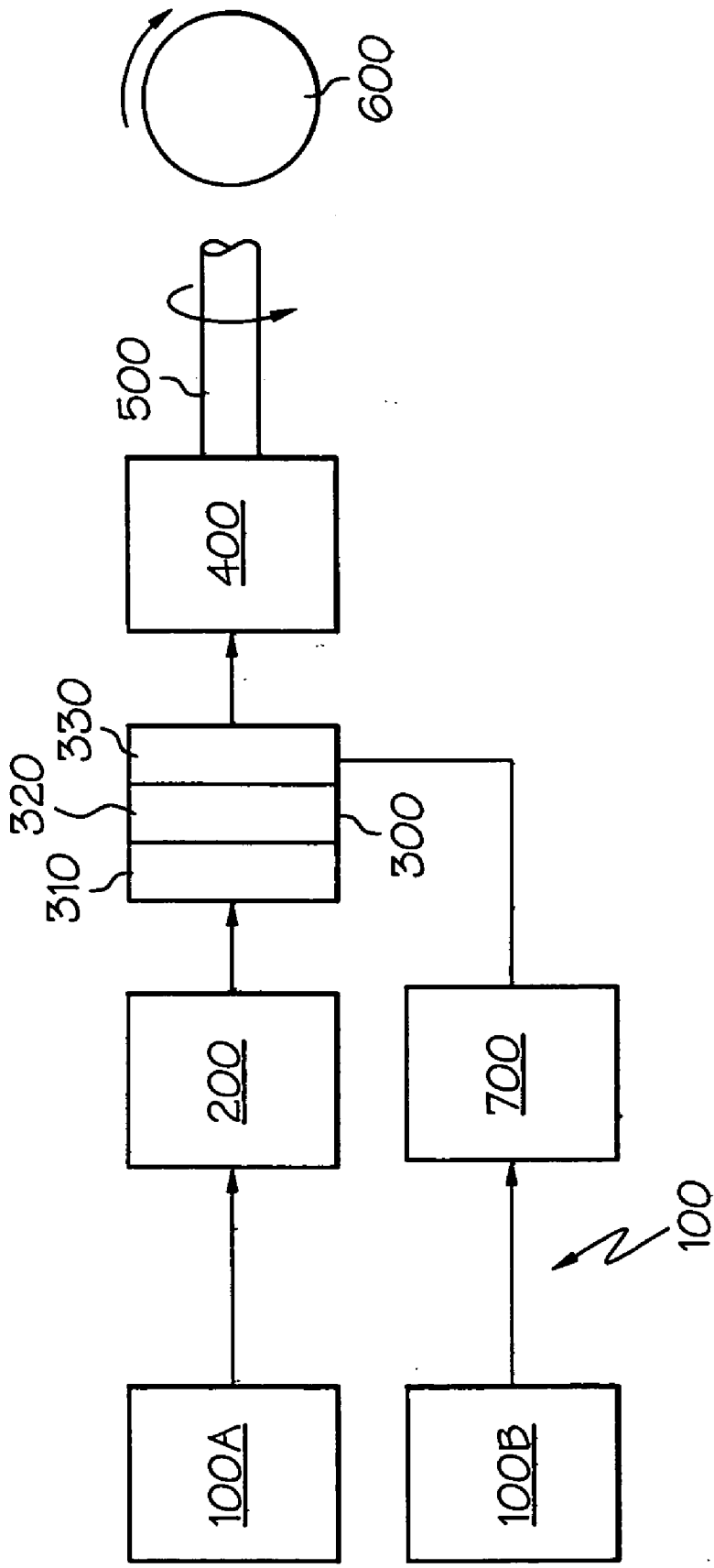


FIG. 1

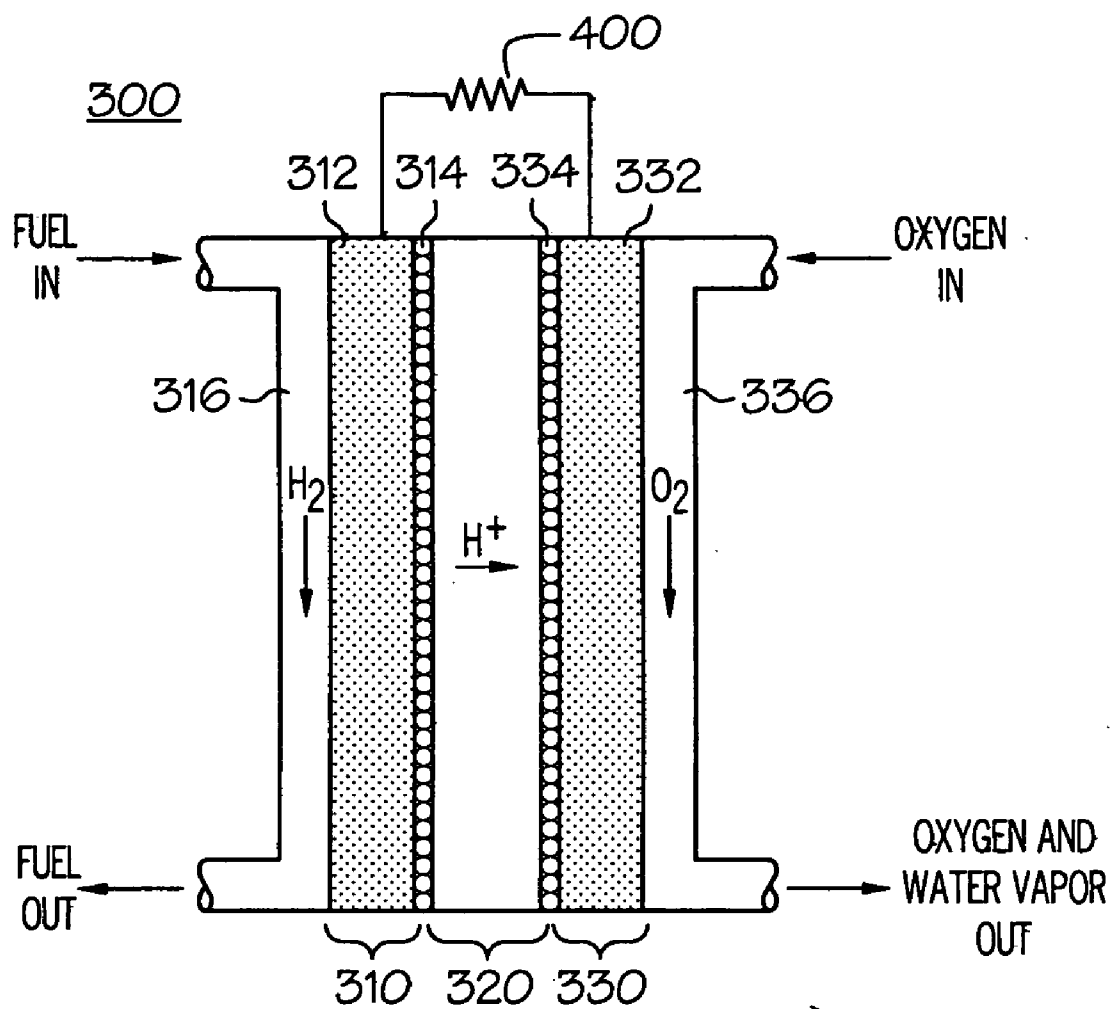


FIG. 2

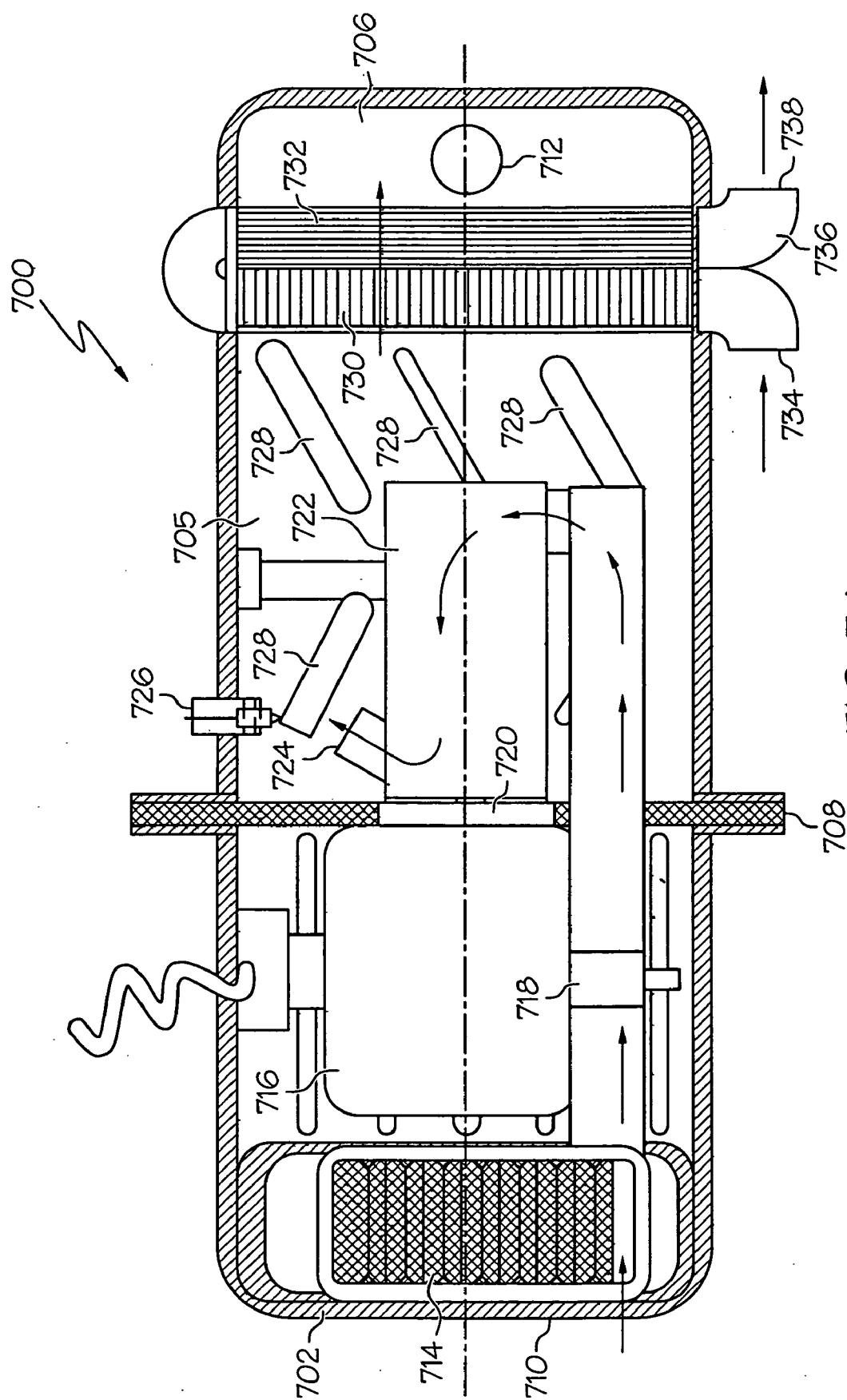


FIG. 3A

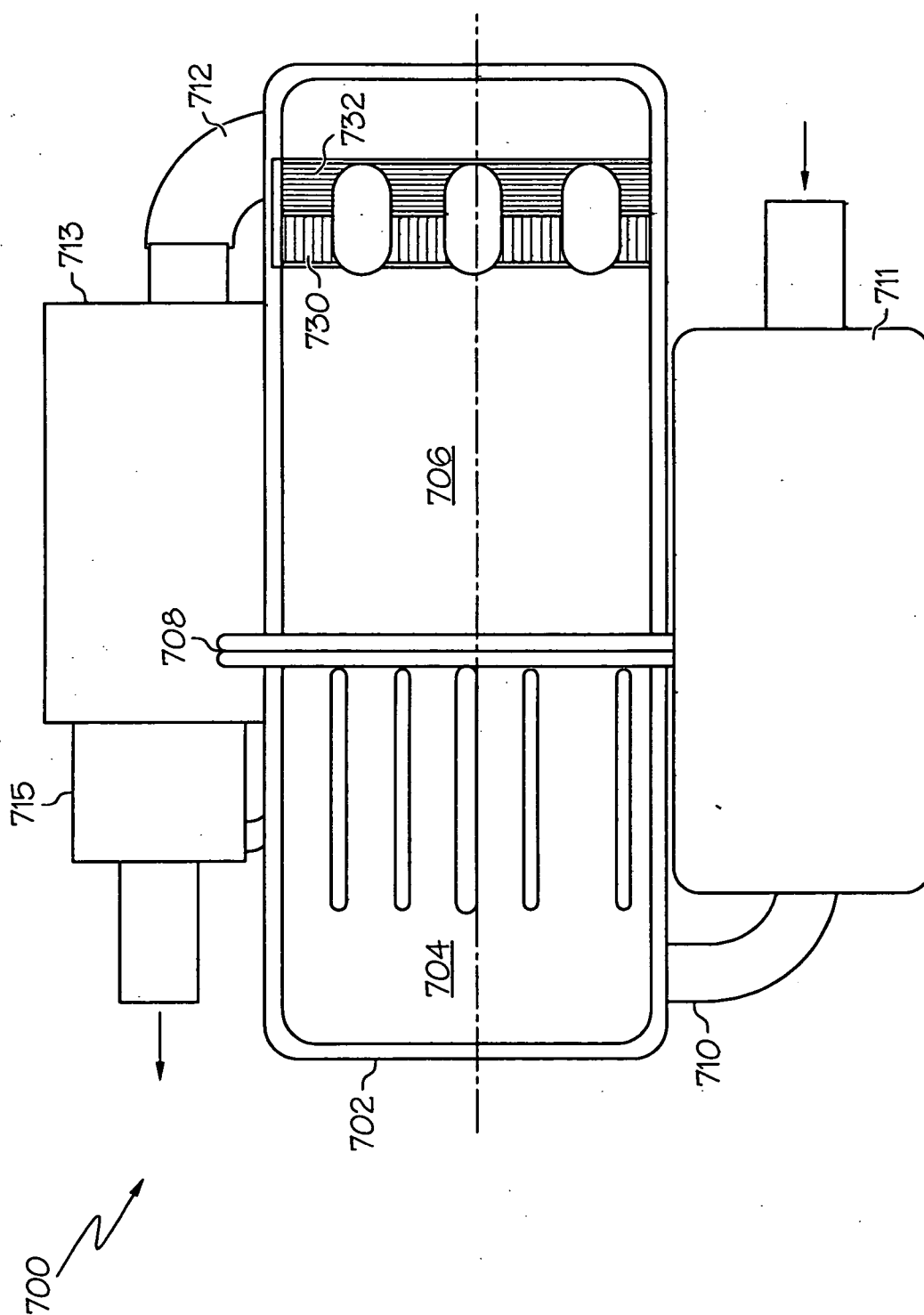


FIG. 3B

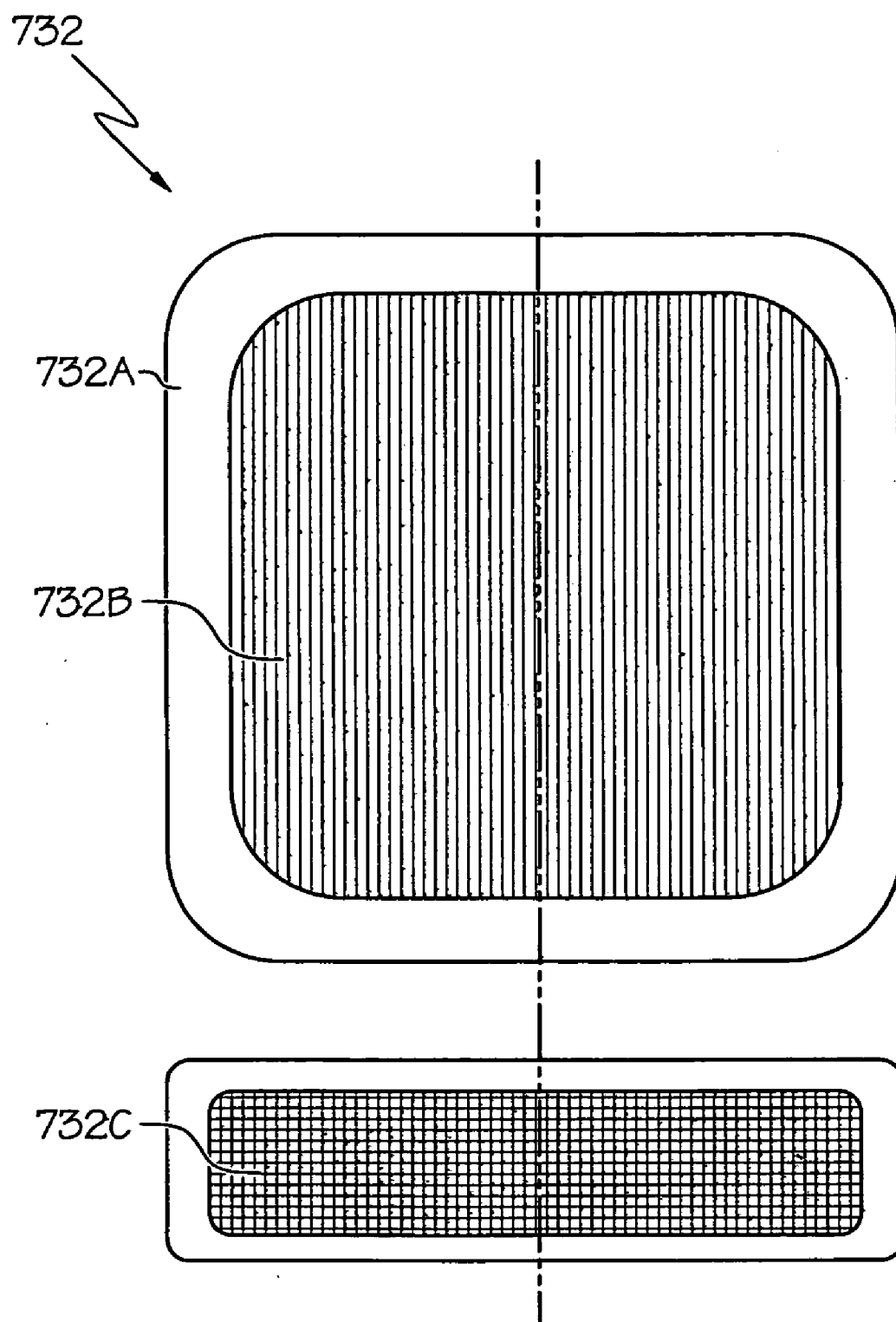


FIG. 3C

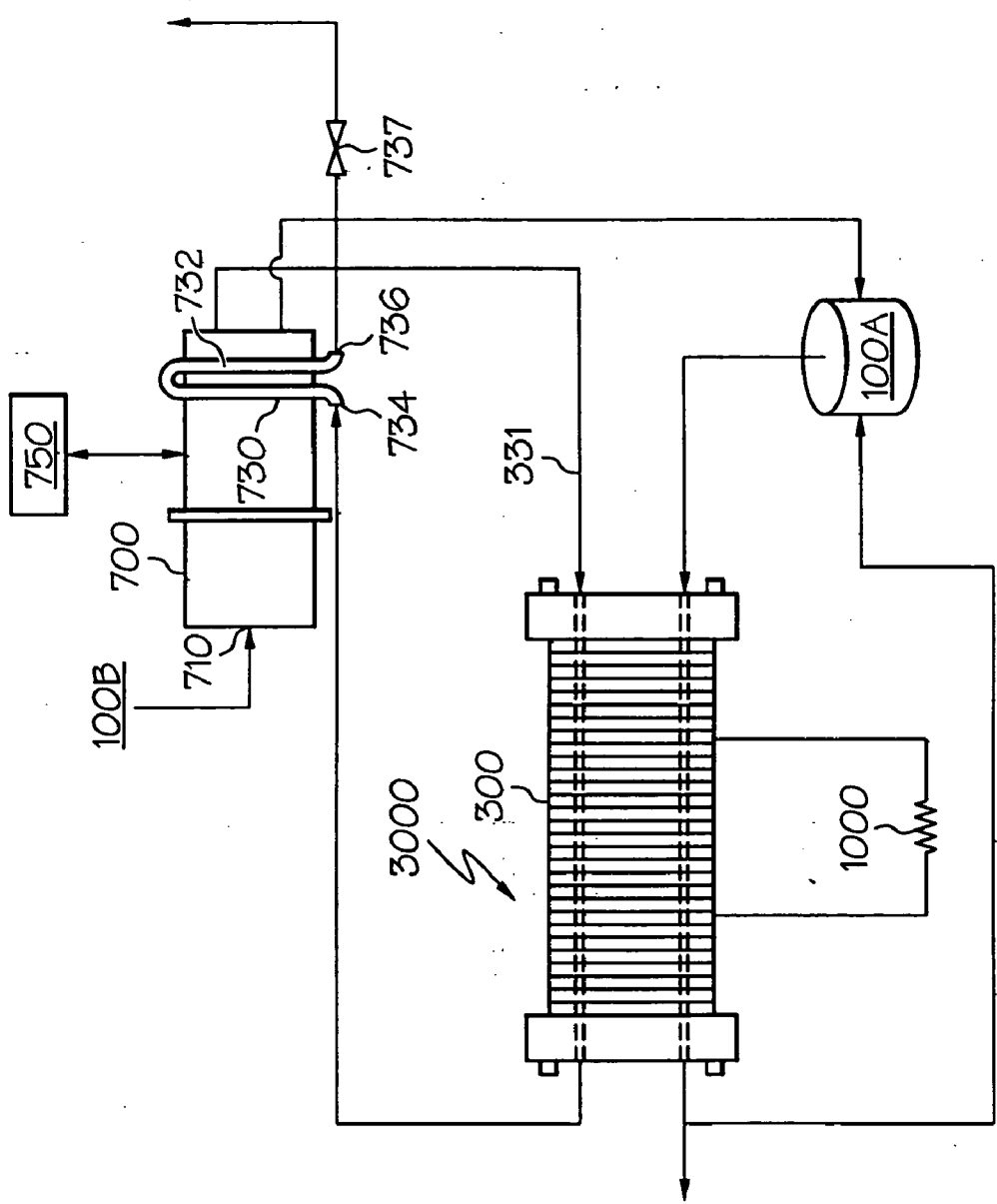


FIG. 3D

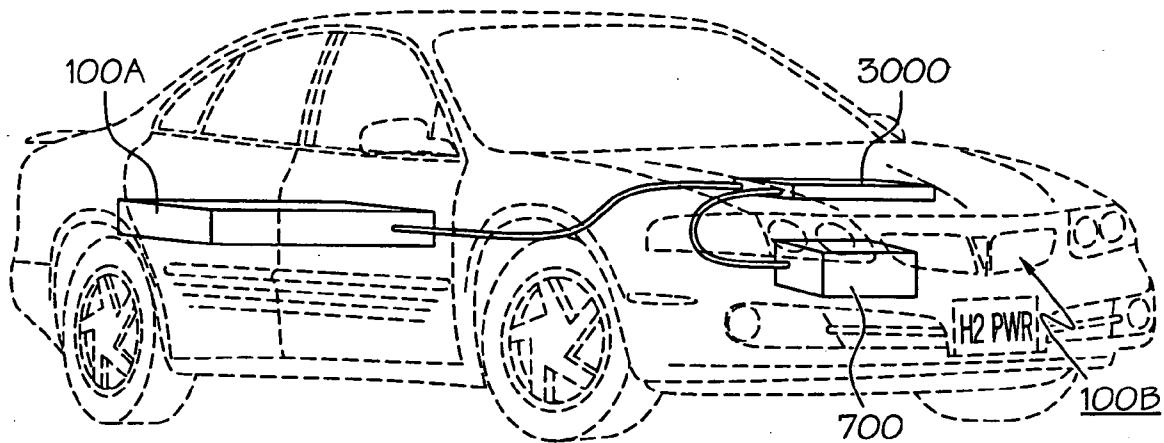


FIG. 4



## INTEGRATED AIR SUPPLY WITH HUMIDIFICATION CONTROL FOR FUEL CELL POWER SYSTEMS

### BACKGROUND OF THE INVENTION

[0001] The present invention relates generally to manipulating airflow for use as a reactant in a fuel cell system, and more particularly to integrating air supply system components in such a way as to reduce the size, weight and complexity associated with such airflow manipulation.

[0002] While conventional power source devices (such as internal combustion engines, including piston and gas turbine-based platforms) are well-known as ways to produce, among other things, motive, heat and electric power, recent concerns about the effects they and their fuel sources have on the environment have led to the development of alternative means of producing such power. The interest in fuel cells is in response to these and other concerns. One form of fuel cell, called the proton exchange membrane (PEM) fuel cell, has shown particular promise for vehicular and related mobile applications, using hydrogen and oxygen as the primary reactants to produce electricity with water vapor as a non-polluting reaction byproduct. A typical PEM construction includes a porous anode and cathode with a solid polymer electrolyte membrane spaced between them. Catalysts, typically in the form of a noble metal such as platinum, are placed at the anode and cathode. In PEM fuel cells, hydrogen or a hydrogen-rich gas is supplied to the anode, where a catalytic reaction between it and the platinum or related catalyst generates protons that can travel through the electrolyte to react with the ionized oxygen at the cathode. The ionization process produces electric current that can supply, among other things, a motor or related motive power device, while the hydrogen and oxygen reaction results in the formation of water at the cathode.

[0003] Balanced water levels are required in the PEM fuel cell to ensure proper operation. For example, it is important to avoid having too much water in the fuel cell, which can result in the blockage of the porous anode and cathode, thereby preventing the flow of reactants. Contrarily, too little hydration limits electrical conductivity of the membrane. Exacerbating the difficulty in maintaining a balance in water level is that there are numerous conflicting reactions taking place in a fuel cell that are simultaneously increasing and decreasing its hydration levels. In addition to the formation of water or water vapor at the cathode as discussed above, water can be dragged from the anode and into the cathode by the ionized protons (i.e., hydrogen ions) moving from the anode. This phenomenon, known as electro-osmotic drag, significantly contributes to the removal of water molecules from the anode. Other mechanisms may also be prevalent, including diffusion of water molecules from the cathode to the anode across the membrane, the circulation of hydrogen adjacent the anode to function as an additional water removal source and the removal of water from an oxygen-depleted portion of the cathode. Furthermore, many of these effects are localized such that even if global levels of hydration are maintained in the fuel cell, there is no guarantee that local water balance is maintained. In addition, since typical PEM fuel cells operate at temperatures that are conducive for the evaporation of the resident water and a subsequent drying out of the solid polymer electrolyte

membrane, it would be desirable to maintain control over PEM fuel cell temperatures as a way to avoid membrane dehydration.

[0004] The manipulation of numerous air properties, including pressure, temperature, relative humidity and mass flow rates, can be used to maintain the desired hydration levels in the fuel cell. One potential method of ensuring adequate levels of hydration throughout the fuel cell includes humidifying one or both of the reactants before they enter the fuel cell. For example, the water produced at the cathode can be used, with appropriate humidification devices, to reduce the likelihood of anode or membrane dehydration. External sources of humidity control (either addition or removal, depending on the need) may also be used. Other approaches employing a combination of the above-mentioned multiple factors (for example, the simultaneous achievement of humidity, pressure, mass flow and temperature levels) to achieve appropriate air conditions may also be used. Of course, the use of humidification, temperature, pressure and mass flow control devices necessitates additional fuel cell system weight, size and complexity (in, for example, the form of pumps coupled to intricate valve networks tied together with precision control mechanisms), as well as reductions in fuel cell output or efficiency in situations where such componentry requires a source of power to operate. Such disadvantages are especially troublesome for vehicle-based fuel cell applications, as the often redundant componentry would take up precious vehicle space otherwise used for passenger, comfort or safety features.

[0005] Accordingly, there exists a need for a PEM fuel cell system design and mode of operation that facilitate manipulation of one or more airflow properties without having to resort to approaches that require significant increases in system weight, redundancy, volume or complexity.

### BRIEF SUMMARY OF THE INVENTION

[0006] These needs are met by the present invention, wherein a fuel cell system and a method of operating the system that incorporates the features discussed below is disclosed. In accordance with a first aspect of the present invention, a device including an electrochemical conversion assembly, an oxidant delivery assembly and a controller is disclosed. The electrochemical conversion assembly is configured to combine an oxidant and a reductant, while the oxidant delivery assembly is fluidly coupled to the electrochemical conversion assembly. The controller is configured to operate the oxidant delivery assembly, which includes a compressor, heat exchanger, water vapor transfer unit and housing. The oxidant delivery assembly can be used to manipulate at least one property of the oxidant delivered from an oxidant source to make the oxidant more suitable for use in the electrochemical conversion assembly. The oxidant delivery assembly's housing defines a chamber therein. The compressor can be used to pressurize the chamber with oxidant from the oxidant source, while the heat exchanger is positioned within the chamber and can be used to transfer heat from oxidant within the chamber to an exhaust fluid produced by the electrochemical conversion assembly. The water vapor transfer unit is positioned within the chamber and can be used to transfer water vapor from the aforementioned exhaust fluid to the pressurized oxidant in the chamber. It will be appreciated that the one or more elements

positioned within the housing may share exterior surfaces with the housing, or even define exterior housing surfaces; the intent is to have a common housing that is able to provide simple packaging for the disparate components to minimize space, component redundancy and concomitant device complexity. In addition, by utilizing a common housing, pressure losses to the oxidant being conveyed to the electrochemical conversion assembly can be minimized, as losses associated with narrow, individual or similarly dedicated conduit can be reduced. In the present context, terms such as "oxidant source" and its variants are to be understood broadly, encompassing any device, container or environment (including the ambient environment) configured to provide an oxidant-bearing fluid, such as air, oxygen or related compound, mixture or the like.

[0007] In one optional form, the electrochemical conversion assembly is a fuel cell, where a particular form may be a PEM fuel cell. Specific fuel cell configurations may include an anode, cathode and membrane disposed between the anode and cathode. To convey reactants, the fuel cell may also include an anode flowpath configured to couple the anode to a fuel source, and a cathode flowpath fluidly coupled to the oxidant delivery assembly. The cathode flowpath, which defines conduit or related fluid-carrying means, includes a cathode inlet and a cathode outlet. The inlet of the cathode flowpath is used to convey oxidant (such as air) into the cathode for reaction with an appropriate reductant (such as hydrogen). The previously-discussed exhaust fluid (also called reactant byproduct) that forms upon completion of the reaction at the cathode is conveyed away from the cathode through the outlet of the cathode flowpath such that the reactant byproduct formed in the fuel cell can flow to the water vapor transfer unit or related humidity control device. There, the reactant byproduct may, with optional heat addition from the heat exchanger, be used to increase the humidity of the oxidant being fed to the fuel cell. While it has been mentioned that one type of fuel cell that can benefit from the present invention is the PEM fuel cell, it will be appreciated by those skilled in the art that the use of other fuel cell configurations is also within the purview of the present invention.

[0008] To minimize system redundancy, electricity generated during the operation of the electrochemical conversion assembly can be used to power the compressor or other electricity-consuming components. In another option, the device includes a filter disposed in fluid communication with the oxidant source. Preferably, the filter is disposed within the housing, and may further be placed upstream of the compressor. The chamber may include a low pressure section and a high pressure section. In a more particular option, at least one of the filter, compressor, heat exchanger and water vapor transfer unit is disposed within the low pressure section, while in another, at least one of the filter, compressor, heat exchanger and water vapor transfer unit is disposed within the high pressure section. In still another option, the filter is disposed in the low pressure section and the heat exchanger and water vapor transfer unit are disposed in the high pressure section. The controller may include one or more oxidant parameter measuring elements and a feedback loop in signal communication with the oxidant parameter measuring elements to react to a value sensed by the oxidant parameter measuring element. Examples of appropriate oxidant parameter measuring elements include temperature

measuring elements, pressure measuring elements, humidity measuring elements and mass flow measuring elements.

[0009] The water vapor transfer unit may include a porous medium made up of numerous microtubes through which water vapor or related humidity-increasing fluids may flow. The porous nature of the microtubes promotes diffusion of moisture from a moisture-bearing fluid (such as the exhaust fluid from a fuel cell cathode) into the oxidant in the chamber to increase the humidity of the supply oxidant being introduced into the electrochemical conversion assembly. Condensate from the saturated exhaust fluid can form on the inner wall of these microtubes, and can subsequently diffuse across the membrane walls of each tube. The heat exchanger is used to reduce the temperature of the oxidant exiting the compressor while increasing the temperature of the exhaust fluid flowing through the porous microtubes. This is beneficial in that the otherwise waste heat produced in the oxidant during its compression can be used to raise the temperature of the water-rich fluid that is passing through the microtubes; by raising the temperature of fluid flowing from the fuel cell exhaust (i.e., stack offgas), the likelihood of water being in a vapor form that can more readily be introduced into the oxidant flowing through the chamber is enhanced, which in turn can be used to increase hydration within parts of the fuel cell that may otherwise dry out during operation. Furthermore, decreased oxidant temperature relative to stack offgas temperature increases the water transfer driving force, and hence efficiency, across the water vapor transfer membrane. Accordingly, during system operation, the heat exchanger can be used to maintain the temperature of the exhaust fluid entering the porous microtubes closer to (although, preferably not in excess of) approximately one hundred degrees Celsius. As is common in heat exchangers, the present heat exchanger may define at least two flowpaths that are in thermal communication with one another. The flowpaths may include a first flowpath configured to be fluidly disposed between the oxidant source and a fuel cell cathode inlet; and a second flowpath configured to be fluidly coupled to a fuel cell cathode outlet. In a more particular embodiment, the water vapor transfer unit and the heat exchanger are fluidly adjacent one another. In addition, the water vapor transfer unit and the heat exchanger can be fluidly coupled to a fuel cell cathode outlet. This is advantageous in that it economizes on space in volume-limited applications, as the heat exchanger and water vapor transfer unit both utilize reactant byproducts from the cathode to manipulate the air yet to be introduced to the cathode as reactant. For example, they can both be fluidly coupled to a fuel cell cathode outlet. At least one baffle may be disposed in the chamber downstream of the compressor. The use of baffles helps to ensure more even distribution of air properties.

[0010] Even though the present invention reduces the amount of acoustic noise associated with the manipulation of oxidant to be used in a fuel cell or related electrochemical conversion assembly, there may be situations where additional acoustic attenuation becomes necessary. The device may further include one or more attenuators fluidly coupled to the device to effect noise reduction associated with a flow of oxidant into the oxidant delivery assembly. For example, the attenuators could be fluidly coupled both upstream and downstream of the oxidant delivery assembly to promote an

even further reduction in noise. In such a configuration, the attenuators may be mounted to or formed within the housing.

[0011] In more particular options, the oxidant delivery assembly and the electrochemical conversion assembly (the latter in the form of a fuel cell) is part of a vehicle such that the fuel cell is a source of motive power. Even more particularly, the vehicle may include a platform configured to carry the source of motive power, a drivetrain rotatably connected to the platform such that the drivetrain is responsive to output from the source of motive power, and numerous wheels connected to the drivetrain.

[0012] According to another aspect of the invention, a method of operating a fuel cell system is disclosed. The method includes configuring the fuel cell system to include an air delivery device used to condition the air introduced into a fuel cell, and a controller configured to monitor and selectively vary the extent to which at least one of the components making up the fluid delivery device modifies such air. The air delivery device includes features similar to that of the previously-described aspect. Additionally, the method includes introducing air into the air delivery device, modifying at least one property of the air introduced into the air delivery device and introducing air that has been modified by the air delivery device into the fuel cell.

[0013] Optionally, the properties that can be modified by the fuel delivery device include air pressure, air temperature, relative humidity, mass flow or particulate concentration. By way of example, when a compressor (such as previously described) operates on the air, both the temperature and pressure of the air that passes through the chamber defined inside the housing (both similar to that discussed in conjunction with the previous aspect) will be increased. The heat exchanger can be operated to increase the temperature of the exhaust fluid formed during the operation of the fuel cell by absorbing some of the excess heat in the compressed air. The simultaneous increase in exhaust fluid temperature and the decrease in microtube wall temperature (the latter enabled by contact with the lower temperature compressed air that has passed through the heat exchanger) promotes the condensation, subsequent migration and reevaporation of water into a fluid path coupling the air delivery device to the fuel cell, thereby increasing the humidity of supply air entering the fuel cell. Operating the heat exchanger ensures temperatures adequate to increase the amount of vapor present in the moisture-bearing exhaust fluid, thereby improving the humidity in the chamber. With water vapor, increasing the temperature of the exhaust fluid to closer to one hundred degrees Celsius is consistent with such objectives. In addition, a filter may be placed in a flowpath defined in the air delivery to reduce particulate contamination of the air. As with the previous aspect, at least one attenuator can be connected to the air delivery device to reduce the noise associated with the flowing of air into the fluid delivery device.

[0014] According to yet another aspect of the present invention, an integrated air delivery device is disclosed. The device, which can be used to modify air for use in a fuel cell system in a manner similar to that of the previously-described aspects, includes a housing that defines an air flowpath with a corresponding chamber, a filter, compressor, heat exchanger and water vapor transfer unit disposed in the

flowpath, and a controller configured to monitor and selectively vary the extent of air modification made possible by operation of one or more of the aforementioned components disposed in the air flowpath. The water vapor transfer unit is positioned within the chamber and is configured to transfer water vapor to the pressurized air within the chamber. The compressor is configured to pressurize the chamber with air. The heat exchanger is configured to transfer heat from the pressurized air within the chamber to the water vapor transfer unit.

[0015] Optionally, the chamber further can be made up of a first chamber defining a low pressure region and a second chamber defining a high pressure region. In one form, the filter is disposed in the first chamber. In a more particular form, it is disposed in the first chamber upstream of the compressor. The water vapor transfer unit and the heat exchanger are preferably disposed in the second chamber. In a preferred embodiment, the reactant byproduct (exhaust fluid) that comes in thermal contact with the heat exchanger are then passed through the inner portion of the microtubes. During operation of the system, the heat exchanger is used to increase the efficiency of the water vapor transfer unit. In a preferred embodiment, the temperature of the reactant byproduct after passing through the heat exchanger is enough to ensure a strong vapor presence, thereby promoting a significant vapor phase with concomitant increase in diffusion through the previously-discussed microtubes. For example, in the case of an exhaust fluid with a significant water content, this temperature would be close to one hundred degrees Celsius for a normal atmospheric pressure (possibly even higher in situations where the air pressure is elevated, as long as microtube durability is not compromised). In a particular option, electricity generated during the operation of the fuel cell can be used to provide power to run the compressor.

#### BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

[0016] The following detailed description of the present invention can be best understood when read in conjunction with the following drawings, where like structure is indicated with like reference numerals and in which:

[0017] FIG. 1 shows a block diagram of a fuel cell system configured for vehicular application;

[0018] FIG. 2 shows a notional fuel cell from the system of FIG. 1;

[0019] FIG. 3A shows an elevation cutaway view of an integrated air delivery system according to an aspect of the present invention;

[0020] FIG. 3B shows a top view of the system of FIG. 3A, and including optional attenuators; and

[0021] FIG. 3C shows a view of a water vapor transfer unit for the system of FIG. 3A;

[0022] FIG. 3D shows a simplified flow diagram of a fuel cell system employing the integrated air delivery system of FIG. 3A; and

[0023] FIG. 4 shows a vehicle employing the fuel cell system of FIG. 3A.

#### DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0024] Referring initially to FIGS. 1 and 4, a block diagram highlights the major components of a mobile fuel cell

system **1** according to the present invention, as well as a representative placement of a fuel cell system into an automotive application. Referring with particularity to FIG. **1**, the system **1** includes a fuel delivery system **100** (made up of fuel source **100A** and oxygen source **100B**), fuel processing system **200**, fuel cell **300**, one or more energy storage devices **400**, a drivetrain **500** and one or more motive devices **600**, shown notionally as a wheel. While the present system **1** is shown for mobile (such as vehicular) applications, it will be appreciated by those skilled in the art that the use of the fuel cell **300** and its ancillary equipment is equally applicable to stationary applications. It will also be appreciated by those skilled in the art that other fuel delivery and fuel processing systems are available. For example, there could be, in addition to a fuel source **100A** and oxygen source **100B**, a water source (not shown). Likewise, in some variants where substantially purified fuel is already available, the fuel processing system **200** may not be required. The energy storage devices **400** can be in the form of one or more batteries, capacitors, electricity converters, or even a motor to convert the electric current coming from the fuel cell **300** into mechanical power such as rotating shaft power that can be used to operate drivetrain **500** and one or more motive devices **600**. The fuel processing system **200** may be incorporated to convert a raw fuel, such as methanol into hydrogen or hydrogen-rich fuel for use in fuel cell **300**; otherwise, in configurations where the fuel source **100A** is already supplying substantially pure hydrogen, the fuel processing system **200** may not be required. Fuel cell **300** includes an anode **310**, cathode **330**, and an electrolyte layer **320** disposed between anode **310** and cathode **330**. Although only a single fuel cell **300** is shown in FIG. **1**, it will be appreciated by those skilled in the art that fuel cell system **1** (especially those for vehicular and related applications) may be made from a stack **3000** (shown in FIG. **4**) of such cells serially connected. An air delivery system **700** is shown between the oxygen source **100B** and the cathode **330** of fuel cell **300** and, as described below, is used to manipulate one or more properties of the incoming air from oxygen source **100B**.

[0025] Referring next to FIG. **2**, the anode **310** includes an electrode substrate **312** and catalyst layer **314** connected to a flow channel **316**. The cathode **330** includes an electrode substrate **332** and catalyst layer **334** connected to a flow channel **336**. Flow channels **316**, **336** form the part of an anode flowpath and cathode flowpath that act as conduit for delivering reactants to their respective anode and cathode. In a preferred (but not necessarily exclusive) embodiment, the reactant being routed through flow channel **316** is hydrogen, while that being routed through flow channel **336** is air or related oxygen-rich fluid. It is qualities of that air, including at least pressure, temperature, mass flow and relative humidity, that the present invention is configured to manipulate in order to optimize performance of fuel cell **300**. Preferably, the electrode substrates **312**, **332** are porous to allow diffusion of fuel and oxygen, as well as the flow of water that forms as a result of the fuel-oxygen reaction. The catalyst layer **314** is made up of a catalyst (not shown) dispersed on the surface of a support (not shown). The electrolyte layer **320**, shown presently in the form of a proton exchange membrane, is placed between each of the anode **310** and cathode **330** to allow the ionized hydrogen to flow from the anode **310** to the cathode **330** while inhibiting the passage of electrical current therethrough. Fuel (typically in the form of

gaseous hydrogen) passes through flow channel **316**, allowing the fuel to diffuse through electrode substrate **312** and come in contact with the catalyst, through which the electrochemical oxidation of the hydrogen fuel proceeds by what is believed to be a dissociate adsorption reaction. This reaction is facilitated by the catalyst, typically in the form of finely-divided particles of a noble metal (such as platinum) that are dispersed over the surface of the support, which is typically carbon-based. The positively-charged hydrogen ion (proton) produced at the anode **310** then passes through the electrolyte **320** to react with the negatively-charged oxygen ions generated at the cathode **330**. The flow of liberated electrons sets up a current through the load **400** such that a motor or related current-responsive device may be turned. Load **400**, shown in the form of the previously-discussed energy storage device, completes an electrical flowpath between the anode and cathode of fuel cell **300**. An additional pump (not shown) can be included to remove from the electrode substrates **312**, **332** water that would otherwise collect and possibly block the porous passageways.

[0026] Referring next to FIGS. **3A** through **3D**, details of the air delivery system **700** according to an embodiment of the invention are shown. Referring with particularity to FIG. **3A**, a block diagram of the primary components within the present system **700** shows the system including housing **702** with a chamber **705**, an inlet air filter **714**, compressor **722**, heat exchanger **730** and water vapor transfer unit **732**. Compressor **722**, which is preferably in the form of a screw compressor to reduce the pulsing associated with other positive-displacement compressors, can be powered by a compressor motor **716**. As shown by the figures, the substantial enclosure of many of the system's components evidences a compact design configured to minimize its contribution to overall fuel cell system size, weight and complexity. In addition, system reliability is enhanced as functions are combined, resulting in fewer interfaces, parts and the like. The chamber **705** of system **700** is divided into a low pressure chamber **704** and a high pressure chamber **706**. The low pressure chamber **704** contains the inlet air filter **714**, compressor motor **716** and air mass flow meter **718**. An air flowpath through the system **700** is designated by arrows, where the air enters through an inlet **710** and exits through an outlet **712**. The chamber **705** offers improved pressure difference reduction by employing a hollow chamber rather than numerous separate conduits. In addition, the design of the chamber **705** is such that it attenuates acoustical noise generated by the incoming and compressed air. In situations where noise minimization requirements are particularly stringent, the optional attenuators **711** and **713** shown in FIG. **3B** can be used to further reduce noise. They are coupled to the respective inlet **710** and outlet **712**. An optional discharge air cooler can be placed downstream of outlet attenuator **713** for additional cooling of the air being delivered to the fuel cell **300**. The separator has the effect of providing significant pressure isolation between the two portions of chamber **705**. As such, filtered air traverses the flowpath and enters the compressor **722** that is sealed from the motor **716** and the low pressure chamber **704** by the separator **708**. In addition, a seal **720** is used to separate the motor **716** from the compressor **722**.

[0027] Compressor **722**, heat exchanger **730** and water vapor transfer unit **732** are disposed within the high pressure chamber **706**. The air exhaust port **724** of compressor **722**

opens directly into the high pressure chamber **706** where baffles **728** can be used to promote air swirling. In addition to promoting the formation of a more homogeneous mixture through swirling, baffles **728** can also reduce noise. Air generated by compressor **722** enters the high pressure chamber **706** at elevated temperature (between, for example 120 and 140 degrees Celsius) as a result of the compression. The system **700** humidifies and cools the air to levels required by the fuel cell **300** by passing the compressed, swirled and hot air through the heat exchanger **730** and water vapor transfer unit **732**, the latter functioning as a humidity control device. Significant factors that effect the water transfer driving force include the humidity difference between the cathode exhaust fluid that enters the cathode recuperator inlet **734** (which may be, for example, approximately 80 percent relative humidity) and the compressed air passing through high pressure chamber **706** (which may be, for example, approximately 55 percent after humidification), and the temperature difference between the cathode exhaust fluid (which may be, for example, approximately 70 to 80 degrees Celsius) and the compressed air (which may be, for example, approximately seventy degrees Celsius). Regarding the first factor, the higher the difference, the more water that can be transferred by the membranes of the microtubes **732B**. Regarding the second factor, the higher the difference, the more water that can be condensed on the walls of the microtubes **732B** and consequently transferred to the compressed air. As such, the higher the compressed air temperature is going into the water vapor transfer **732** unit, the lower the amount of humidification possible.

[0028] Moist air from the cathode exhaust of the fuel cell **300** enters the heat exchanger **730** via cathode recuperator inlet **734**, exiting through a water vapor transfer unit manifold **736** and cathode recuperator outlet **738**. The cathode recuperator inlet **734** contains significant amount of water at fuel cell stack exhaust temperature (approximately 80 to 85 degrees Celsius). The cathode heat exchanger **730** accomplishes dual functions by raising the temperature of the exhaust fluid flowing through cathode recuperator inlet **734** by transferring to the fluid energy from the compressed air flowing through the high pressure chamber **706** using heat exchanger **730**. This action allows more efficient water vapor transfer to the compressed air in the water vapor transfer unit **732**. An additional gain in transferring water from the exhaust fluid into the fuel stack inlet (i.e., reactant supply) air is achieved by exposing the exhaust fluid in the water vapor transfer unit **732** to elevated temperatures to promote a vapor phase (and concomitant higher humidity) within the exhaust fluid, as well as a temperature difference driving force between the exhaust fluid and the reactant supply air.

[0029] Referring with particularity to FIG. 3C, the mechanism of transferring water into the compressed air designated for the fuel cell **300** is shown in more detail. Water vapor transfer unit **732** includes a case **732A** that holds a plurality of porous microtubes **732B** (an example of which is manufactured by NOK Corp. of Japan) that can transfer liquid water through their walls into surrounding air. The cathode exhaust fluid that is routed through the cathode recuperator inlet **734** is saturated with water vapor. When the temperature of the exhaust fluid is considerably greater than the temperature of the air leaving the compressor **722** and passing through the high pressure chamber **706**, the water vapor present in the exhaust fluid tends to condense on the

wall of the microtube **732B**. The condensate then passes through inner diameter of the microtubes **732B** through sealing interface **732C** that forms a part of case **732A**. The humidification performance of the water vapor transfer unit **732** is improved by inducing condensation in the cathode exhaust fluid. This can occur under conditions where the temperature of the air exiting compressor **722** and before being routed to the fuel cell **300** is less than the temperature of the cathode exhaust fluid that is routed through the cathode recuperator inlet **734**. When such is true, the temperature of the microtubes **732B** is decreased to the point where liquid water present in the exhaust fluid will start to form on the surface of the tubes. The water is then transported through the porous membrane and is subsequently evaporated at the drier side of the membrane. As far as pressure differentials are concerned, the relatively high pressures inside the high pressure chamber **706** of housing **702** should not inhibit the passage of the water vapor from inside the microtubes **732B** to the air flowpath inside high pressure chamber **706**, as the ability to function in a reverse osmosis-like fashion depends from (among other things) the flow velocity. Similarly, the mix of water vapor and pressurized air passing through high pressure chamber **706** is made more homogeneous due to the swirling motions created by baffles **728**. An additional benefit of transferring the heat generated by the compression of the air to the water vapor transfer unit **732** is that the air temperature coming out of the heat exchanger **730** has potential to meet temperature requirements of fuel cell **300** as a result of energy consumption from the compressed air by cathode heat exchanger **730**. In other words, the cooperation of the heat exchanger **730** and water vapor transfer unit **732** (and an optional discharge air cooler **715**) lower the compressed air temperature from initial values of between 120 to 140 degrees Celsius before combination to between approximately 60 and 85 degrees Celsius thereafter.

[0030] Referring next with particularity to FIG. 3D, a block diagram showing the fluid connections between the integrated air delivery system **700** and a fuel cell stack **3000** is shown. As previously mentioned, the incoming air from air source **100B** can have one or more of its temperature, pressure, humidity and mass flow properties be manipulated. Traditionally, the biggest contributor to parasitic loss is the pressure loss associated with the incoming air. For example, the incoming air that passes through the filter **714** (shown in FIG. 3A) incurs a pressure drop. In situations where the fuel cell needs high pressure oxidants and reductants, the air pressure may need to be between 1.2 and 2.2 times the atmospheric pressure. To optimize system performance, it is desirable to reduce these parasitic losses. Cathode flowpath **331** promotes the flow of air from air source **100B** from the air delivery system **700**, through the fuel cell stack **3000** and back to the heat exchanger **730** and water vapor transfer unit **732** via inlet **734** and to a vent via outlet **736**. In addition, a back pressure valve **737** is included downstream of outlet **736** to maintain a high pressure on the fuel cell stack **3000**. This ensures that the pressure drop of the air between the air exhaust port **724** of compressor **722**, the individual fuel cells **300** and the remainder of the devices in the cathode flowpath **331** remains relatively small (on the order of 10 to 15 kPa, or about 1.5 to 2.2 pounds per square inch). Electricity generated in fuel cell stack **3000** can be used to power a load **1000**, such as an automobile or related vehicle drivetrain.

[0031] As shown, a comparable fuel flowpath is configured to route fuel from a fuel source 10A, through the anodes of the fuel cell stack 3000, and out, where a recycle line can be used to capture unused fuel. Controller 750 is used to determine which components of air delivery system 700 should be operating to manipulate the air coming from air source 100B. Numerous air parameter measuring elements (such as air mass flow meter 718 shown) can be used to provide signals to controller 750. The controller 750 includes a feedback loop in signal communication with the air parameter measuring elements to react to a value sensed thereby. In addition to the air mass flow measuring meter 718, previously discussed examples of appropriate air parameter measuring elements include temperature measuring elements, pressure measuring elements and humidity measuring elements.

[0032] Benefits realized by using the present invention include minimum presence of liquid water in the air exiting the air delivery system, since the vaporization process effected by the combined operation of the water vapor transfer unit and the heat exchanger promotes the formation of vapor. In addition, the baffles help to promote a homogeneous mixture of compressed air and water vapor due to the swirling actions generated. Moreover, the microtubes 732B of the water vapor transfer unit 732 function as a filter device (similar to inlet air filter 714), thereby removing the need for an output air filter. In addition to reducing system complexity, the elimination of an extra pressure-reduction device promotes the higher reactant pressures sometimes needed in fuel cell applications. In addition, the present design can accommodate different types of compressors with minimum adjustments.

[0033] While certain representative embodiments and details have been shown for purposes of illustrating the invention, it will be apparent to those skilled in the art that various changes may be made without departing from the scope of the invention, which is defined in the appended claims.

What is claimed is:

1. A device comprising:

an electrochemical conversion assembly configured to combine an oxidant and a reductant;

an oxidant delivery assembly fluidly coupled to said electrochemical conversion assembly, said oxidant delivery assembly configured to manipulate at least one property of oxidant delivered from an oxidant source and prior to use thereof in said electrochemical conversion assembly, said oxidant delivery assembly comprising:

a compressor;

a heat exchanger;

a water vapor transfer unit; and

a housing defining a chamber therein, wherein said compressor is configured to pressurize said chamber with oxidant from said oxidant source, said heat exchanger is positioned within said chamber and is configured to transfer heat from oxidant within said chamber to an exhaust fluid produced by said electrochemical conversion assembly, and said water vapor transfer unit is positioned within said chamber

and is configured to transfer water vapor from said exhaust fluid to said oxidant in said chamber; and

a controller configured to monitor and selectively vary the extent to which said oxidant delivery assembly modifies the oxidant.

2. The device of claim 1, further comprising a filter disposed in fluid communication with said compressor.

3. The device of claim 2, wherein said filter is fluidly disposed between said oxidant source and said compressor.

4. The device of claim 2, wherein said filter is disposed within said housing.

5. The device of claim 4, wherein said chamber comprises a low pressure section and a high pressure section.

6. The device of claim 5, wherein at least one of said filter, compressor, heat exchanger and water vapor transfer unit is disposed within said low pressure section.

7. The device of claim 5, wherein at least one of said filter, compressor, heat exchanger and water vapor transfer unit is disposed within said high pressure section.

8. The device of claim 5, wherein said filter is disposed in said low pressure section and said heat exchanger and water vapor transfer unit are disposed in said high pressure section.

9. The device of claim 1, wherein said controller comprises at least one oxidant parameter measuring element and a feedback loop disposed in signal communication with a value sensed by said oxidant parameter measuring element.

10. The device of claim 9, wherein said oxidant parameter measuring element is selected from the group consisting of temperature measuring elements, pressure measuring elements, humidity measuring elements and mass flow measuring elements.

11. The device of claim 1, wherein said water vapor transfer unit comprises a plurality of porous microtubes configured to be disposed in fluid communication with said electrochemical conversion assembly such that at least a portion of an exhaust fluid flowing from said electrochemical conversion assembly and through said porous microtubes can diffuse through the latter and into said oxidant in said chamber to increase the humidity of said oxidant.

12. The system of claim 11, wherein said heat exchanger is configured to reduce the temperature of said oxidant exiting said compressor while increasing the temperature of said exhaust fluid entering said porous microtubes.

13. The device of claim 12, wherein during operation of said system, said heat exchanger maintains said exhaust fluid entering said porous microtubes at a temperature of at least one hundred degrees Celsius.

14. The device of claim 12, wherein said oxidant delivery assembly and said fuel cell is part of a vehicle such that said fuel cell is a source of motive power.

15. The device of claim 14, wherein said vehicle comprises:

a platform configured to carry said source of motive power;

a drivetrain rotatably responsive to output from said source of motive power, said drivetrain connected to said platform; and

a plurality of wheels connected to said drivetrain.

16. The device of claim 1, wherein said heat exchanger comprises a plurality of flowpaths disposed therein that are in thermal communication with one another, said plurality of flowpaths comprising:

a first flowpath configured to be fluidly disposed between said oxidant source and a fuel cell cathode inlet; and

a second flowpath configured to be fluidly coupled to a fuel cell cathode outlet.

17. The device of claim 1, wherein said water vapor transfer unit and said heat exchanger are fluidly adjacent one another.

18. The device of claim 17, wherein said water vapor transfer unit and said heat exchanger are configured to be fluidly coupled to a fuel cell cathode outlet.

19. The device of claim 1, further comprising at least one baffle disposed in said chamber downstream of said compressor.

20. The device of claim 1, further comprising an attenuator fluidly coupled to said device to effect noise reduction associated with a flow of fluid from said fluid source.

21. The device of claim 1, wherein said electrochemical conversion assembly is a fuel cell.

22. The device of claim 21, wherein said fuel cell is a proton exchange membrane fuel cell.

23. The system of claim 1, wherein electricity generated during the operation of said electrochemical conversion assembly can power said compressor.

24. A method of operating a fuel cell system, said method comprising:

configuring at least one fuel cell system to comprise:

a fuel cell;

an air delivery device to condition air prior to its introduction into said fuel cell, said air delivery device comprising:

a compressor;

a heat exchanger;

a water vapor transfer unit; and

a housing defining a chamber therein, wherein said compressor is configured to pressurize said chamber with air, said heat exchanger is positioned within said chamber and is configured to transfer heat from air within said chamber to an exhaust fluid produced by said fuel cell, and said water vapor transfer unit is positioned within said chamber and is configured to transfer water vapor from said exhaust fluid to air in said chamber; and

a controller configured to monitor and selectively vary the extent to which said air delivery device modifies air introduced therein;

introducing air into said air delivery device;

modifying at least one property of air introduced into said air delivery device; and

introducing air that has been modified by said air delivery device into said fuel cell.

25. The method of claim 24, wherein said at least one property is air pressure.

26. The method of claim 25, wherein said modified air pressure is increased by the operation of said compressor element.

27. The method of claim 24, wherein said at least one property is air temperature.

28. The method of claim 24, wherein said at least one property is air relative humidity.

29. The method of claim 24, wherein said at least one property is air mass flow.

30. The method of claim 26, further comprising:

operating said heat exchanger to increase the temperature of said exhaust fluid formed during the operation of said fuel cell; and

operating said water vapor transfer unit such that said exhaust fluid that has had its temperature increased by said operation of said heat exchanger can migrate into a fluid path coupling said air delivery device to said fuel cell, thereby increasing the humidity of air entering said fuel cell.

31. The method of claim 30, wherein the temperature of said exhaust fluid passing through said water vapor transfer unit is greater than the temperature of the portion of said air in said chamber that has passed through said heat exchanger.

32. The method of claim 30, wherein said water vapor transfer unit comprises a porous medium through which water that has condensed from said exhaust fluid migrates into said fluid path coupling said air delivery device to said fuel cell.

33. The method of claim 32, wherein said porous medium comprises a plurality of porous microtubes.

34. The method of claim 24, further comprising configuring a filter to reduce particulate contamination introduced into said fluid delivery device.

35. The method of claim 24, further comprising:

fluidly coupling at least one attenuator to said fluid delivery device; and

reducing the noise associated with the flowing of said at least one fluid introduced into said fluid delivery device.

36. An integrated air delivery device comprising:

a housing defining an air flowpath therein, said flowpath including a chamber;

a filter disposed in said air flowpath;

a compressor disposed in said flowpath, wherein said compressor is configured to pressurize said chamber with air;

a heat exchanger disposed in said flowpath, wherein said heat exchanger is configured to transfer heat from said pressurized air within said chamber;

a water vapor transfer unit disposed in said flowpath, wherein said water vapor transfer unit is positioned within said chamber and is configured to transfer water vapor to said pressurized air within said chamber; and

a controller configured to monitor and selectively vary the extent of said modification of air.

**37.** The device of claim 36, wherein said chamber further comprises a first chamber defining a low pressure region and a second chamber defining a high pressure region.

**38.** The device of claim 36, wherein said filter is disposed in said first chamber.

**39.** The device of claim 36, wherein said water vapor transfer unit and said heat exchanger are disposed in said second chamber.

**40.** The device of claim 36, wherein said water vapor transfer unit comprises a plurality of porous microtubes configured to promote the passage of a humidifying fluid therethrough and into said chamber to increase the humidity of said pressurized air therein.

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