



5<sup>th</sup> International CTI Conference

# Emission Reduction for Off-Highway Applications

⇒ 26 and 27 September 2012, Lindau, Germany

## The Topics include e.g.:

- International Emission Legislation [Umweltbundesamt]
- Challenges for Future Emission Concepts [Liebherr]
- Megatrends in Construction Machines [ZF Friedrichshafen]
- SCR Based Aftertreatment Options for Tier 4 final [Haldor Topsøe]
- Layout and Validation of a SCR System [MTU Friedrichshafen]

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## Chairman:

**Prof. Dr. Werner Müller,**  
Professor at the Internal Combustion  
Engines Department, Technical University of  
Kaiserslautern (Germany)

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D. Stephan, Bosch Emission Systems



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## Countdown zur Emissionsgesetzgebung Tier 4 final Countdown for Emission Legislation Tier 4 final

Die Hersteller von mobilen Arbeitsmaschinen haben mit einer Flut an Normen und Vorschriften zu kämpfen. Dabei beeinflussen die Abgasgesetzgebung in Europa, Nordamerika und in Japan mit ihren erheblich verschärften Grenzwerten den Aufbau und die Antriebstechnik der Maschinen massiv. Mit TIER 4 final sind ab 2014 nur noch rund 10% der heutigen Ruß- und NO<sub>x</sub>-Emissionen zulässig. Dies erfordert eine umfangreiche Abgasnachbehandlung. Auf dieser Konferenz erfahren Sie, welche Problemstellungen und Lösungsansätze hierzu erarbeitet wurden.

The manufacturers of mobile machinery struggle with a flood of standards and regulations. The emissions laws in Europe, North America and Japan with their sharply tightened limits have a huge effect on the construction and drive technology of the machinery. With TIER 4 final, coming into force in 2014, only about 10% of the current soot and NO<sub>x</sub> emissions will be permitted. This requires an extensive emission aftertreatment. This conference gives an overview of the problems and informs about solutions which have been developed.



**Erster Konferenztag:  
Mittwoch, 26. September 2012**

**Moderation: Prof. Dr. Werner Müller,**  
Professor am Lehrstuhl für Verbrennungskraftmaschinen  
an der TU Kaiserslautern und derzeit freier Berater

8.30 – 9.00 Empfang mit Kaffee und Tee,  
Ausgabe der Tagungsunterlagen

9.00 – 9.10  
**Begrüßung durch CTI und Eröffnung durch  
Prof. Dr. Müller**

### Internationale Emissionsgesetzgebung

9.10 – 9.40  
**Die internationale Emissionsgesetzgebung –  
Entwicklungen und Perspektiven für Off-Highway  
Motoren**

- Umweltprobleme verursacht durch NRMM
- Trends und Veränderungen der Gesetzgebung
- Vorschläge für technische NRMM-Standards
- In-Service Conformity (ISC) und NO<sub>x</sub>-Kontrolle
- Ausblick/CO<sub>2</sub>

**Helge Jahn,** Technischer Angestellter,  
Umweltbundesamt Dessau-Roßlau



**Day 1:  
Wednesday, 26 September 2012**

**Chairman: Prof. Dr. Werner Müller,**  
Professor at the Internal Combustion Engines Department,  
University of Kaiserslautern, currently freelance consultant

8.30 – 9.00 Tea and coffee reception, hand  
out of conference documents

9.00 – 9.10  
**Welcome by CTI and opening  
by Prof. Dr. Müller**

### International Emissions Legislation

9.10 – 9.40  
**The International Emission Legislation –  
Developments and Perspectives for Off-HW Engines**

- Environmental problems caused by non-road mobile machinery
- Trends and changes of legislation
- Proposals for NRMM standards
- In-Service Conformity (ISC) und NO<sub>x</sub>-Control
- Outlook/CO<sub>2</sub>

**Helge Jahn,** Technical Employee,  
Federal Environmental Agency Dessau-Roßlau

## Konzepte zur Erfüllung der neuen Emissionsgesetzgebung

9.40 – 10.20

### Herausforderungen an künftige Emissionskonzepte

- Anforderungen
- Variantenvielfalt und Systemintegration
- DPF- und SCR-Systemlayouts und Installationsbeispiele
- Einfluss der Teilhybridisierung

**Francois Jaussi**, Hauptabteilungsleiter Produktmanagement Dieselmotoren & Hydraulik, Liebherr Machines Bulle SA



10.20 – 10.30 Diskussion

10.30 – 11.00 Pause mit Kaffee und Tee

11.00 – 11.40

### Megatrends bei Baumaschinen – Herausforderungen in Bezug auf Kraftstoffeinsparung, Emissionen und lokale Marktproduktion

- Verringerung von Kraftstoffverbrauch und Emissionen
- Lokale Märkte und lokale Produktion
- Achs- und Getriebetechnologie

**Dr. Mark Mohr**, Leiter der Produktlinie Baumaschinensysteme, ZF Friedrichshafen AG



## Innovative Systeme und Komponenten

11.40 – 12.20

### SCRf-Technologie (SCR on Filter) – zukünftiger Trend für Dieselpartikelfilter

- Dows Entwicklungspfad zu innovativen Partikelfiltersubstraten
- Filtersubstrate und Innovationen bei der Beschichtung zur Aktivierung von SCRf
- Umwandlung von Abgasnachbehandlungssystemen für Diesel zu multifunktionalen Vorrichtungen
- Anwendungsrelevante Testdaten mit Katalysatorprototypen für SCRf

**Mathias Warnecke**, Marketing Manager Antriebsstrang & Emissionen in Europa, Dow Chemical



12.20 – 12.30 Diskussion mit Sprechern

12.30 – 13.30 Gemeinsames Mittagessen

13.30 – 14.10

### Integration des Abgasstrangs bei Non-Road-Fahrzeugen für Tier 4 F – mit besonderer Aufmerksamkeit auf das AdBlue®-Gemisch

- Mischkonzept für Tier 4 final
- Vermeidung von Harnstoffkristallisation bei Niedertemperaturbetrieb

**Arno Amberla**, Vizepräsident Technologie, Proventia Emission Control Oy



## Concepts to meet the new Emission Legislation

9.40 – 10.20

### Challenges for Future Emission Concepts

- Requirements
- Diversity of variants and system integration
- DPF and SCR system layout and examples of installations
- Influence of part-hybridization

**Francois Jaussi**, Head of Department Product Management Diesel Engines & Hydraulics, Liebherr Machines Bulle SA

10.20 – 10.30 Discussion

10.30 – 11.00 Break with coffee and tea

11.00 – 11.40

### Megatrends in Construction Machines – The Challenges regarding Fuel Efficiency, Emissions and Local Markets Production

- Fuel efficiency and emission reduction
- Local markets and local production
- Axle and transmissions technology

**Dr. Mark Mohr**, Head of Product Line Construction Machinery Systems, ZF Friedrichshafen AG

## Innovative Systems and Components

11.40 – 12.20

### SCR on Filter (SCRf) – A Future Trend for DPF

- Dow's development path forward for innovative particulate filter substrates
- Filter substrates and coating innovations as enablers for SCRf
- Convergence of diesel aftertreatment systems into multifunctional devices
- Application relevant test data with prototype SCRf layouts of catalysts

**Mathias Warnecke**, Market Manager Powertrain & Emissions in Europe, Dow Chemical

12.20 – 12.30 Discussion with speakers

12.30 – 1.30 Joint lunch break

1.30 – 2.10

### Tier 4 F Non-Road Exhaust Line Integration – Special Attention to AdBlue® Mixing

- Mixing concept for Tier 4 final
- Avoiding urea crystallization under low temperature operation

**Arno Amberla**, Vice President Technology, Proventia Emission Control Oy

14.10 – 14.50

**Thermomanagement für Tiefsttemperaturanwendungsprofile**

- Thermische Regeneration bei allen Temperaturbedingungen
- Einfluss von niedrigem Kraftstoffverbrauch
- Zusätzliches Luftmanagement wird nicht benötigt
- Standalone-Funktionen für AGN

**Michael Himmen**, Leiter Vertrieb & Marketing und Prokurist, HJS Emission Technology GmbH & Co. KG



14.50 – 15.10 Diskussion mit den Sprechern  
15.10 – 15.40 Pause mit Kaffee und Tee

15.40 – 16.20

**Nachrüstsysteme für Off-Highway-Anwendungen**

- Reduzierung der Partikelemissionen
- Verringerung von NO<sub>2</sub>- und NO<sub>x</sub>-Emissionen
- Kombisysteme zur Reduzierung von Partikel- und NO<sub>x</sub>-Emissionen

**Dr. Claus Görsmann**, Leiter HDD Non-Road- und Nachrüsttechnologie, Johnson Matthey PLC



16.20 – 17.00

**Auf SCR basierende Nachbehandlungsoptionen für Tier 4 final**

- Vanadium-basierte SCR für Off-Highway-Anwendungen
- Kombisysteme für Off-Highway-Anwendungen
- Ammoniak-schlupf-Katalysator und Emissionsgrenzen für Off-Road-Anwendungen
- Haltbarkeit und Validierung von Abgasnachbehandlungssystemen für Tier 4 final

**Dr. Milica Folić**, Forschungsingenieurin, Haldor Topsøe



17.00 – 17.15 Diskussion mit den Sprechern  
17.15 Ende des ersten Konferenztages



Zum Ausklang des ersten Konferenztages sind Sie herzlich zu einem Abendessen eingeladen. Nutzen Sie die entspannte Atmosphäre des Get-together mit Kollegen und Referenten, um wertvolle Kontakte zu knüpfen.

2.10 – 2.50

**Thermal Management for Ultra Low Temperature Application Profiles**

- Thermal regeneration under all temperature conditions
- Low fuel consumption impact
- No additional air management needed
- Stand alone functionality for EGA

**Michael Himmen**, Head of Sales & Marketing and Authorized Officer, HJS Emission Technology GmbH & Co. KG

2.50 – 3.10 Discussion with speakers  
3.10 – 3.40 Break with coffee and tea

3.40 – 4.20

**Retrofit Systems for Off-Highway Applications**

- Particulate Matter Reduction
- NO<sub>2</sub> and NO<sub>x</sub> Reduction
- Combined Particulate Matter and NO<sub>x</sub> Reduction systems

**Dr. Claus Görsmann**, HDD Non-Road and Retrofit Technology Manager, Johnson Matthey PLC

4.20 – 5.00

**SCR Based Aftertreatment Options for Tier 4 final**

- Vanadium-based SCR for Off-Highway applications
- Combined systems for Off-Highway applications
- Ammonia slip catalyst and Off-Road emission standards
- Durability and validation for Tier 4 final aftertreatment systems

**Dr. Milica Folić**, Principle Research Engineer, Haldor Topsøe

5.00 – 5.15 Discussion with speakers  
5.15 End of the first conference day!



After the official programme, we invite you to a social get-together. Take the opportunity to make important contacts and to exchange ideas and experiences in a relaxed atmosphere.

**Infoline: +49 (0)2 11/96 86-36 45**

Haben Sie Fragen zur Konferenz? Wir helfen Ihnen gern weiter.  
If you have any questions about the conference, we will be pleased to help you.



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**Zweiter Konferenztag:  
Donnerstag, 27. September 2012**

8.00 – 8.30 Empfang mit Kaffee und Tee

8.30 – 8.35

**Eröffnung des zweiten Konferenztages durch den Vorsitzenden Prof. Dr. Müller**

8.35 – 9.15

**Hochleistungs-SCR Technologie mit minimalen NO<sub>x</sub>-Emissionen für zukünftige Gesetzgebung**

- NRMM Randbedingungen und Anforderungen
- Limitationen und Freiheitsgrade für die Konstruktion
- Robuste Systeme mit integrierten Lösungen für kombinierte Emissionsminderung
- Hochleistungs SCR Technologie

**Klaus Müller-Haas**, Leiter Anwendungsentwicklung Non-Road; Co-Autor: **Oswald Holz**, Anwendungsingenieur, Heavy Duty Non-Road, Emitec GmbH



9.15 – 9.50

**Entwicklung eines künftigen kompletten Abgassystems inklusive einer SCR-F Lösung basierend auf einem hochporösem Siliziumkarbid-Filtersubstrat**

- Neue Art eines hochporösen Siliziumkarbids
- Mögliches Substrat für künftige SCR-F-Systeme
- Testergebnisse vom Motorenprüfstand
- Mögliche SCR-F-Aufbauten

**Lars Christian Larsen**, Director R&D, Dinex



9.50 – 10.00 Diskussion mit den Sprechern

10.00 – 10.30 Pause mit Kaffee und Tee

**Erfahrungsberichte aus unterschiedlichen Anwendungsbereichen**

10.30 – 11.10

**Herausforderungen bei der Einhaltung der Euro-4-Norm für landwirtschaftliche Anwendungen**

- Unterschiede zwischen möglichen Technologien, Einfluss auf die Leistung und Bauart
- Anforderungen zur Abgasnachbehandlung und Einbau im Fahrzeug
- AGCOs Strategie zur Einhaltung der Normen Euro 4 und Tier 4 Final

**Jarno Ratia**, Entwicklungsleiter – Emissions- und Leitungsverhalten, AGCO Sisu Power



**Day 2:  
Thursday, 27 September 2012**

8.00 – 8.30 Tea and coffee reception

8.30 – 8.35

**Opening of the second day by the chairman Prof. Dr. Müller**

8.35 – 9.15

**High-Performance SCR Technology with Ultra-Low NO<sub>x</sub> Emissions for Future Regulations**

- NRMM: constraints and requirements
- Limits und degrees of freedom in design
- Robust systems with integrated solutions for combined emissions reduction
- High-performance SCR technology

**Klaus Müller-Haas**, Manager Application Engineering Non-Road; Co-author: **Oswald Holz**, Application Engineering Non-Road, Emitec GmbH

9.15 – 9.50

**Development of a Future Complete Exhaust System Solution including a SCR-F based on High Porous Silicon Carbide Filter Substrates**

- New type of a high porous Silicon Carbide
- Candidate for a substrate for future SCR-F systems
- Results from engine dynamometer tests
- Possible SCR-F setups

**Lars Christian Larsen**, Director R&D, Dinex

9.50 – 10.00 Discussion with speakers

10.00 – 10.30 Break with coffee and tea

**Experience Reports from different Areas of Application**

10.30 – 11.10

**Challenges to meet regarding Stage 4 Emission Regulations in Agricultural Applications**

- Differences between possible technologies, impact on performance and design
- Aftertreatment requirements and vehicle installations
- AGCO's strategy to meet Stage 4 and Tier 4 Final

**Jarno Ratia**, Development Manager – Emissions and Performance, AGCO Sisu Power

11.10 – 11.50

**Entwicklung eines SCR-Systems für Schienenfahrzeugmotoren**

- Aufbau des Katalysators
- Optimierung des Gasdurchsatzes und Harnstoffaufbereitung
- Analyse der Alterungsaspekte
- Entwicklung eines Steuerungsalgorithmus

**Klaus Rusch**, Leiter Abgasnachbehandlung, MTU Friedrichshafen GmbH



11.50 – 12.00 Diskussion mit den Sprechern

12.00 – 13.15 Gemeinsames Mittagessen

13.15 – 13.55

**Stationäre Anwendungen im Hinblick auf NO<sub>x</sub> in Griechenland und Zypern – aktueller Stand und Aussichten**

- Umsetzung der EU-Gesetzgebung zu NO<sub>x</sub>-Emissionen in Griechenland und Zypern
- Erfahrungen mit der erfolgreichen Umsetzung von Maßnahmen zur Reduzierung von NO<sub>x</sub>-Emissionen bei stationären und Marineanwendungen in Griechenland und Zypern
- Herausforderungen bei der Anwendung von NO<sub>x</sub>-Reduktionstechnologien in Kraftwerken, Raffinerien, Verbrennungsanlagen und Zementfabriken in Griechenland und Zypern
- Aussichten für NO<sub>x</sub>-Technologieanbieter in Griechenland und Zypern

**Symeon Georgiadis**, Geschäftsführer, Environmental Protection Engineering S.A.



13.55 – 14.35

**Abgasnachbehandlung von schwerölgefeuerten Schiffsmotoren – Anforderungen und Betriebs-erfahrungen**

- IMO MARPOL Annex VI – SO<sub>x</sub> und NO<sub>x</sub> Grenzwerte
- Kombiniertes DeSO<sub>x</sub>- und DeNO<sub>x</sub>-Verfahren
- Erfahrungen aus dem Schiffsbetrieb

**Ralf Jürgens**, Leiter F&E, Couple Systems GmbH

**Simulation als Entwicklungswerkzeug**

14.35 – 15.15

**Simulation in der Abgasnachbehandlung**

- DOC, SCR, DPF und NH<sub>3</sub>-Oxidation
- Modellanwendung: Optimierung der NH<sub>3</sub> Dosierung

**Dr. Martin Votsmeier**, Senior Manager, Umicore AG & Co. KG



15.15 – 15.45 Diskussion mit Sprechern

15.45 Ende der Konferenz

11.10 – 11.50

**Development of a SCR System for Railcar Engines**

- Layout of catalysts
- Optimization of gas flow and urea processing
- Analysis of aging aspects
- Development of control algorithms

**Klaus Rusch**, Manager Exhaust Gas Aftertreatment, MTU Friedrichshafen GmbH

11.50 – 12.00 Discussion with speakers

12.00 – 1.15 Joint lunch break

1.15 – 1.55

**NO<sub>x</sub> Stationary Applications in Greece and Cyprus – Current Status and Perspectives**

- Implementation of the EU NO<sub>x</sub> emission legislation in Greece and Cyprus
- Experience from cases of successful implementation of NO<sub>x</sub> emission abatement control in stationary and marine applications in Greece and Cyprus
- Challenges for the application of NO<sub>x</sub> emission abatement technologies in power plants, refineries, incinerators and cement plants in Greece and Cyprus
- Perspectives for NO<sub>x</sub> technology providers in Greece and Cyprus

**Symeon Georgiadis**, Executive Director, Environmental Protection Engineering S.A.

1.55 – 2.35

**Exhaust Aftertreatment for Ship Engines Running on Heavy Fuel Oil – Requirements and Experience**

- IMO MARPOL Annex VI – SO<sub>x</sub> and NO<sub>x</sub> standards
- Combined DeSO<sub>x</sub> and DeNO<sub>x</sub> process
- Experience from shipping

**Ralf Jürgens**, Head R&D, Couple Systems GmbH

**Simulation as Development Tool**

2.35 – 3.15

**Simulation of Exhaust Aftertreatment Systems**

- DOC, SCR, DPF and NH<sub>3</sub> oxidation
- Model application: Optimization of NH<sub>3</sub> dosing

**Dr. Martin Votsmeier**, Senior Manager, Umicore AG & Co. KG

3.15 – 3.45 Discussion with speakers

3.45 End of the conference

## Who will you meet?

International Off-Highway engine manufacturers, Tier 1 and 2 suppliers for engine and exhaust gas aftertreatment systems. CEOs, Directors, Senior Engineers and Project Managers of the following departments:

- Research & Development, Advanced Development
- Engine & Powertrain
- Emission Systems, SCR Systems, Exhaust Gas Aftertreatment
- Engine Design and Applications
- SCR-System Entwicklung
- Emission Legislative
- Diesel Particulate Filters
- Catalysts
- Simulation
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5th International CTI Conference

# Emission Reduction for Off-Highway Applications

**NO<sub>x</sub>** Emission Regulation **SCR**  
 Challenges **Catalysts** Concepts **OBD**  
**Trends** **Non-Road** Tier 4 F  
**DPF** **Aftertreatment**  
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### Conference Venue and Accommodation

26. – 27.09.2012, Hotel Bad Schachen  
 Bad Schachen 1, 88131 Lindau am Bodensee  
 Phone: +49 (0)83 82.298-0

In the conference hotel, there is a limited allocation of rooms available at a reduced price. Please arrange the room reservation directly with the hotel quoting the reference "CTI conference".

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## Registration and information

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