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TITLE OF THE INVENTION

WATER-TREATING AGENT AND METHOD FOR TREATING WATER ✓

FIELD OF THE INVENTION

The present invention relates to a novel water treating agent and a method for treating water therewith.

More precisely, the present invention relates to a novel water treating agent which is used in boilers, cooling water systems, hot water systems and dust collecting water plants for preventing them from being disordered by heat transfer failure, flow rate depression and local corrosion to be caused by adhesion or deposition of scale, sludge and slime onto heating pipes, heat exchangers, condensers, reactors for polymerization and various pipe lines in themd also relates to a method of using the agent for treating water in then.

BACKGROUND OF THE INVENTION

Heretofore, poly phosphates and carboxylic acid polymers have been used in a scale inhibiting and fouling preventing agent to be used in boilers, cooling water systems, dust collecting water plants and water supply piping systems for the purpose of preventing the adhesion of scale onto the surfaces of the metal parts to be kept in contact with water, preventing the deposition of sludge

onto them and preventing the local corrosion to occur in the area under the fouled parts.

However, poly phosphates are defective in that they are easily hydrolyzed to give orthophosphates, which precipitate as calcium phosphate in water systems having high pH and high calcium hardness at high temperatures to often accelerate scale troubles in them. In addition, since waste waters containing phosphorus are problematic as causing eutrophication in closed water areas such as lakes, marshes and inland seas, the use of phosphorus containing chemicals must be limited.

On the other hand, carboxylic acid polymers form insoluble salts in water containing high concentrations of poly valent metal ions and the salts precipitate therein, with the result that the polymers are not effective in such water. In particular, where the polymers are applied to water having a high calcium ion concentration, the water becomes cloudy due to the calcium salts formed and precipitated therein.

In Japanese Laid Open Patent Application No. 2-9496, proposed is a phosphorus free water treating agent for scale inhibition, which comprises a copolymer of a conjugated dienesulfonic acid and (meth)acrylic acid and which is said to be effective even in systems having high metal ion concentrations without being precipitated therein.

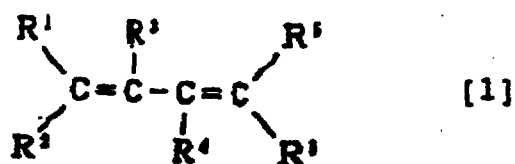
Comparing this with sodium polyacrylate which has heretofore been used in conventional water treating agents, the former is superior to the latter but is not satisfactorily good. Therefore, it is desired to obtain a water treating agent having much improved scale retarding and fouling preventing effects.

OBJECTS AND SUMMARY OF THE INVENTION

The object of the present invention is to provide a phosphorus free water treating agent which does not react with poly valent ions to form insoluble salts and which has an excellent and long lasting, scale inhibiting and fouling preventing effect, and also a method for treating water therewith. In addition, the object of the present invention is to provide a water treating agent having an excellent metal corrosion preventing effect, and also a method for treating water therewith.

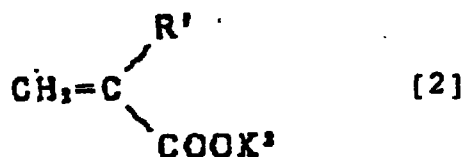
We, the present inventors, have assiduously studied so as to attain the above mentioned objects and, as a result, have found that a ternary copolymer comprising conjugated dienesulfonic acid units, (meth)acrylic acid units and 2-hydroxyethyl (meth)acrylate units or (meth)acrylamido-2-methylalkanesulfonic acid unit exhibits an excellent scale inhibit and fouling preventing effect. On the basis of this finding, we have completed the present invention.

Specifically, the first aspect of the present invention is to provide a water treating agent comprising a ternary copolymer which is synthesized from a conjugated dienesulfonic acid and/or its salt of the following general formula [1]:



wherein R^1 , R^2 , R^3 , R^4 , R^5 and R^6 each represent a hydrogen atom, a methyl group or $-\text{SO}_3\text{X}^1$, provided that one or more of R^1 to R^6 are methyl groups, one or more of the remaining R^1 to R^6 are groups of $-\text{SO}_3\text{X}^1$, and X^1 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group;

and a (meth)acrylic acid and/or its salts of the following general formula [2]:



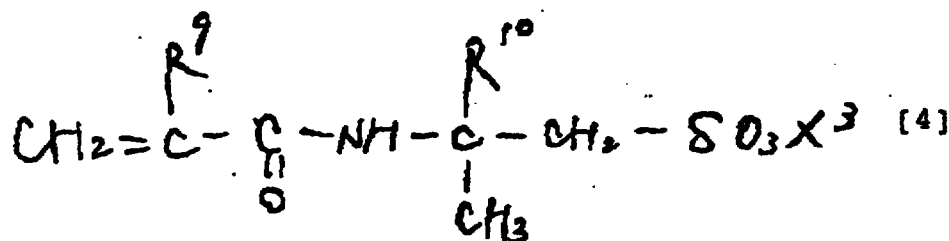
wherein R^7 represents a hydrogen atom or a methyl group; and X^2 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono-substituted by an organic group;

and further a 2-hydroxyethyl (meth)acrylate of the following general formula [3]:



wherein R^8 represents a hydrogen atom or a methyl group,

or a (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt of the following general formula [4]:



wherein R^9 and R^{10} each represent a hydrogen atom or a methyl group; and X^3 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono-substituted by an organic group.

As one embodiment of the first aspect of the invention, the ternary copolymer to be in the water treating agent comprises from 5 to 50 mol% of the unit derived from the conjugated dienesulfonic acid and/or its salt, from 40 to 90 mol% of the unit derived from the (meth)acrylic acid and/or its salt, and from 1 to 20 mol% of the unit derived from the 2-hydroxyethyl (meth)acrylate.

As another embodiment of the first aspect of the invention, the ternary copolymer to be in the water treating agent comprises from 5 to 50 mol% of the unit derived from the conjugated dienesulfonic acid and/or its salt, from 40 to 90 mol% of the unit derived from the (meth)acrylic acid and/or its salt, and from 1 to 20 mol% of the unit derived from the (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt.

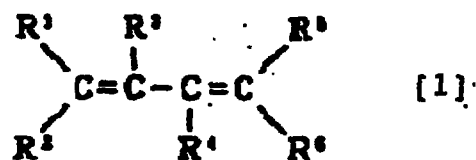
As still another embodiment of the first aspect of the invention, the ternary copolymer to be in the water treating agent has a weight average molecular weight of from 500 to 300,000.

As still another embodiment of the first aspect of the invention, the water treating agent further comprises a metal corrosion inhibitor.

As still another embodiment of the first aspect of the invention, the metal corrosion inhibitor to be optionally in the water treating agent comprises at least one selected

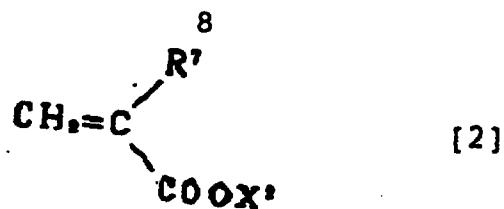
from the group consisting of polyvalent metal salts, phosphonates, azoles, phosphates, phosphocarboxylates, amines and phosphoric esters.

The second aspect of the present invention is to provide a method for treating water, comprising adding to water systems a water treating agent that comprises a ternary copolymer as synthesized from a conjugated dienesulfonic acid and/or its salt of the following general formula [1]:

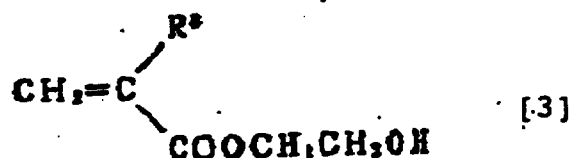


wherein R^1 , R^2 , R^3 , R^4 , R^5 and R^6 each represent a hydrogen atom, a methyl group or $-\text{SO}_3\text{X}^1$, provided that one or more of R^1 to R^6 are methyl groups, one or more of the remaining R^1 to R^6 are groups of $-\text{SO}_3\text{X}^1$, and X^1 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group;

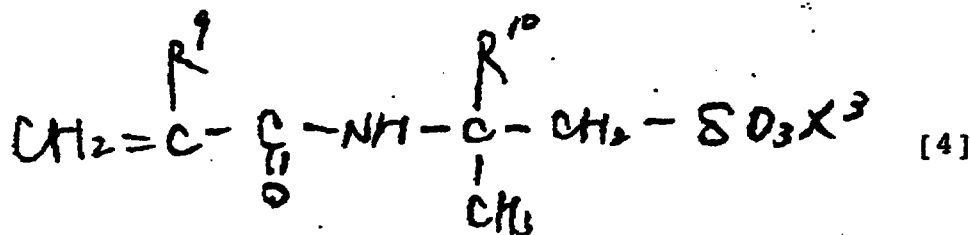
and a (meth)acrylic acid and/or its salts of the following general formula [2]:



wherein R^7 represents a hydrogen atom or a methyl group; and X^2 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group; and further a 2-hydroxyethyl (meth)acrylate of the following general formula [3]:



wherein R^8 represents a hydrogen atom or a methyl group, or a (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt of the following general formula [4]:



wherein R^9 and R^{10} each represent a hydrogen atom or a methyl group; and X^3 represents a hydrogen atom, a

monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group, in an amount of from 0.1 to 1000 mg/liter.

As one embodiment of the second aspect of the invention, the ternary copolymer to be in the water treating agent comprises from 5 to 50 mol% of the unit derived from the conjugated dienesulfonic acid and/or its salt, from 40 to 90 mol% of the unit derived from the (meth)acrylic acid and/or its salt, and from 1 to 20 mol% of the unit derived from the 2-hydroxyethyl (meth)acrylate.

As another embodiment of the second aspect of the invention, the ternary copolymer to be in the water treating agent comprises from 5 to 50 mol% of the unit derived from the conjugated dienesulfonic acid and/or its salt, from 40 to 90 mol% of the unit derived from the (meth)acrylic acid and/or its salt, and from 1 to 20 mol% of the unit derived from the (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt.

As still another embodiment of the second aspect of the invention, the ternary copolymer to be in the water treating agent has a weight-average molecular weight of from 500 to 300,000.

As still another embodiment of the second aspect of the invention, the water treating agent further comprises a

metal corrosion inhibitor in addition to the ternary copolymer.

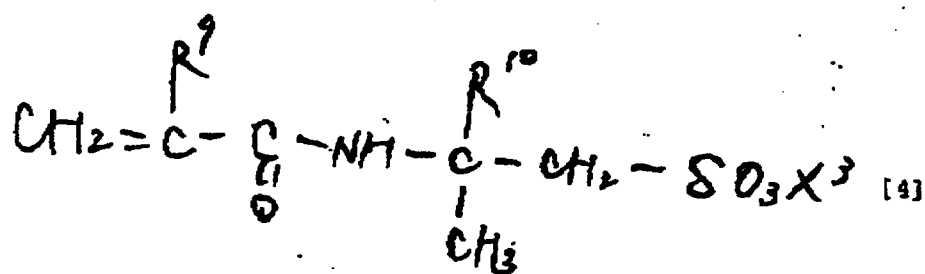
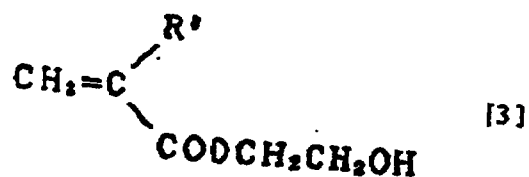
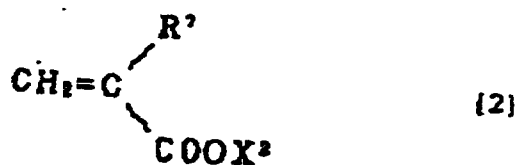
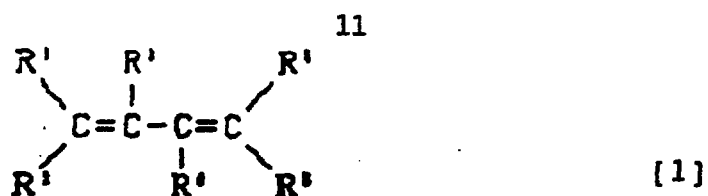
As still another embodiment of the second aspect of the invention, the metal corrosion inhibitor to be optionally in the water treating agent comprises at least one selected from the group consisting of polyvalent metal salts, phosphonates, azoles, phosphates, phosphocarboxylates, amines and phosphoric esters.

BRIEF DESCRIPTION OF THE DRAWING

Fig. 1 is a flow diagram of the pilot plant of a water-cooling system as used here in Examples 19 to 21 and Comparative Examples 41 to 42.

DETAILED DESCRIPTION OF THE INVENTION

The water treating agent of the present invention comprises a copolymer which is synthesized from a conjugated dienesulfonic acid and/or its salts of the following general formula [1], a (meth)acrylic acid and/or its salts of the following general formula [2], and a 2-hydroxyethyl (meth)acrylate of the following general formula [3] or a (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt of the following general formula [4]:



In formula [1], R^1 , R^2 , R^3 , R^4 , R^5 and R^6 each represent a hydrogen atom, a methyl group or $-\text{SO}_3\text{X}^1$, provided that one or more of R^1 to R^6 are methyl groups, one or more of the remaining R^1 to R^6 are groups of $-\text{SO}_3\text{X}^1$, and X^1 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group. In formula [2], R^7 represents a hydrogen

atom or a methyl group; and X^2 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group. In formula [3], R^8 represents a hydrogen atom or a methyl group. In formula [4], R^9 and R^{10} each represent a hydrogen atom or a methyl group; and X^3 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono-substituted by an organic group. The ammonium group as mono substituted by an organic group is an ammonium group to be formed through the reaction of $-SO_3H$ or $-COOH$ with a primary amine. The primary amine that can give such an ammonium group as mono substituted by an organic group includes, for example, methylamine, ethylamine, propylamine, isopropylamine, butylamine, isobutylamine, sec butylamine, tert butylamine, pentylamine, hexylamine, cyclohexylamine, benzylamine, and monoethanolamine.

In the water treating agent of the present invention which has the ability to inhibit scaling and to prevent fouling in water plants, X^1 and X^2 each are preferably an alkali metal, more preferably sodium.

The conjugated dienesulfonic acid of formula [1] includes, for example, 2-methyl-1,3-butadiene-1-sulfonic acid, 2-methyl-1,3-butadiene-3-sulfonic acid, 2-methyl-1,3-butadiene-4-sulfonic acid, 1,3-pentadiene-1-sulfonic acid, 1,3-pentadiene-2-sulfonic acid, 1,3-pentadiene-3-sulfonic

acid, 1,3-pentadiene-4-sulfonic acid, 2,3-dimethylbutadiene-1-sulfonic acid, 2-methyl-1,3-pentadiene-4-sulfonic acid, 3-methyl-1,3-pentadiene-1-sulfonic acid, 2-methyl-1,3-butadiene-1,3-disulfonic acid, and 2-methyl-1,3-butadiene-1,4-disulfonic acid.

The (meth)acrylic acid of formula [2] includes acrylic acid and methacrylic acid. Acrylic acid is preferably used in the water treating agent of the present invention.

The 2-hydroxyethyl (meth)acrylate of formula [3] includes 2-hydroxyethyl acrylate and 2-hydroxyethyl methacrylate. 2-Hydroxyethyl methacrylate is preferably used in the water treating agent of the present invention.

The method of copolymerizing the conjugated dienesulfonic acid and/or its salt of formula [1], the (meth)acrylic acid and/or its salt of formula [2], and the 2-hydroxymethyl (meth)acrylate of formula [3] or the (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt of formula [4] to obtain the ternary copolymer for use in the present invention is not specifically defined but may be any conventional one. The monomer of formula [1], the monomer of formula [2] and the monomer of formula [3] or [4] are all soluble in water, and the ternary copolymer to be obtained through copolymerization of these monomers is also soluble in water. Therefore, solution polymerization using water as the medium is preferably

employed to copolymerize these monomers. One example of solution polymerization using water as the medium, which is employable in the present invention, is such that the predetermined monomers are dissolved in water, then the atmosphere around the resulting system is substituted with nitrogen, a water soluble, radical polymerization initiator is added thereto, and the system is heated.

The radical polymerization initiator includes, for example, hydrogen peroxide, sodium persulfate, potassium persulfate, ammonium persulfate, 2,2'-azobis(2-amidinopropane) dihydrochloride, and t butyl hydroperoxide. The polymerization initiator can be added successively or all at a time.

The amount of the polymerization initiator to be added may be generally from 0.01 to 5 parts by weight, preferably from 0.1 to 3 parts by weight, relative to 100 parts by weight of the monomers in total. If it is less than 0.01 parts by weight, the polymerization of the monomers could not be conducted efficiently, but if it is more than 5 parts by weight, the cost of the catalyst uneconomically increases too much.

To promote the radical polymerization, a reducing agent, such as sodium pyrodisulfite, ferrous sulfate, copper sulfate, triethanolamine, glucose, formaldehyde sodium sulfoxylate, L-ascorbic acid or its salt or sodium

hydrogensulfite, and also a chelating agent, such as glycine, alanine or sodium ethylenediaminetetraacetate, can be added to the polymerization system.

A chain transfer agent can be used as the agent for controlling the molecular weight of the copolymer to be produced. The chain transfer agent includes, for example, mercaptans such as t dodecylmercaptan, n tetradecylmercaptan, octylmercaptan, t hexylmercaptan and n hexylmercaptan, halides such as ethylene bromide, hydrocarbons such as 9,10-dihydroanthracene, 1,4-cyclohexadiene and 1,4-dihydroanthracene, heterocyclic compounds such as 2,5-dihydrofuran, as well as α -methylstyrene dimers, and xanthogen disulfides. In general, the chain transfer agent can be added in an amount of less than 10 parts by weight relative to 100 parts by weight of the monomers in total.

The polymerization temperature may be from -50 to +200_c, preferably from +50 to +150_C. The polymerization time may be from 0.1 to 30 hours, within which the radical polymerization shall be conducted.

It is desirable to successively add the monomers to the polymerization reactor. In order to produce a uniform composition of the monomers added and to remove the polymerization heat from the reactor, the time for the

addition of the monomers shall be from 0.5 to 5 hours, preferably from 1 to 3 hours.

It is desirable that the copolymer to be in the water treating agent of the present invention which has the ability to inhibit scaling and to prevent fouling in water plants comprises from 5 to 50 mol% of the unit derived from the conjugated dienesulfonic acid and/or its salt, from 40 to 90 mol% of the unit derived from the (meth)acrylic acid and/or its salt, and from 1 to 20 mol% of the unit derived from the 2-hydroxyethyl (meth)acrylate or the unit derived from the (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt. More preferably, the copolymer comprises from 10 to 30 mol% of the unit derived from the conjugated dienesulfonic acid and/or its salt, from 60 to 90 mol% of the unit derived from the (meth)acrylic acid and/or its salt, and from 2 to 15 mol% of the unit derived from the 2-hydroxyethyl (meth)acrylate or the unit derived from the (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt.

If the content of the unit derived from the conjugated dienesulfonic acid and/or its salt in the copolymer, which is in the water treating agent of the present invention having the ability to inhibit scaling and to prevent fouling in water systems, is less than 5 mol% or more than 50 mol%, the scale inhibiting and fouling preventing effect

of the water treating agent will be lowered. If the content of the unit derived from the (meth)acrylic acid and/or its salt in the copolymer is less than 40 mol% or more than 90 mol%, the scale inhibiting and fouling preventing effect of the water treating agent will be also lowered. If the content of the unit derived from the 2-hydroxyethyl (meth)acrylate or that of the unit derived from the (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt is less than 1 mol% or more than 20 mol%, the scale inhibiting and fouling preventing effect of the water treating agent will be also lowered.

The copolymer to be in the water treating agent of the present invention which has the ability to inhibit scaling and to prevent fouling in water system may comprise any other monomer units, in addition to the unit derived from the conjugated dienesulfonic acid and/or its salt of formula [1], the unit derived from the (meth)acrylic acid and/or its salt of formula [2], and the unit derived from the 2-hydroxymethyl (meth)acrylate of formula [3] or the unit derived from the (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt of formula [4]. The copolymer of this type comprising such additional monomer units can be obtained by copolymerizing the monomer of formula [1], the monomer of formula [2], the monomer of formula [3] or [4], and a monomer copolymerizable with

these monomers, according to any known methods. The monomer copolymerizable with the monomer of formula [1], the monomer of formula [2] and the monomer of formula [3] or [4] includes, for example, 3-allyloxy-2-hydroxypropanesulfonic acid, vinylsulfonic acid, acid phosphoxyethyl methacrylate, acid phosphoxyethyl acrylate, acid phosphoxy polyoxyethylene glycol monomethacrylate, (meth)acrylamide, (meth)acrylonitrile, methyl (meth)acrylate, glycidyl (meth)acrylate, N methylol(meth)acrylamide, maleic acid, maleic anhydride, styrene, α methylstyrene, vinyltoluene, p methylstyrene, and vinyl acetate.

It is desirable that the copolymer to be in the water treating agent of the present invention having the ability to inhibit scaling and to prevent fouling in water systems has a weight average molecular weight of from 500 to 300,000, more preferably from 5,000 to 50,000. If the copolymer in the water treating agent has a weight average molecular weight of less than 500, the scale inhibiting and fouling preventing effect of the agent will be lowered. If the copolymer has a weight average molecular weight of more than 300,000, the viscosity of the water treating agent comprising it will be too high so that the agent will be not easy to handle.

To use the water treating agent of the present invention, its amount to be added to water systems shall be suitably selected, depending on the quality of water to be treated therewith, which includes its pH, hardness and alkalinity, the temperature of water and also the heat-transferring conditions in the system. In general, the amount of the water treating agent to be added shall be from 0.1 to 1,000 mg/liter, in terms of the solid content of the copolymer in the agent. In most cases, the amount may be from 1 to 100 mg/liter, in terms of the solid content of the copolymer in the agent, in order to make the agent exhibit a satisfactory scale inhibiting and fouling preventing effect.

The water treating agent of the present invention is used in boiler systems, cooling water systems, industrial water supply plants, dust collecting water plants, drainage systems and slug cooling systems in the iron industry, and ash cooling systems in garbage incinerators, for preventing them from being disordered by heat transfer failure and flow rate depression to be caused by adhesion or deposition of scale, sludge and slime onto the surfaces of metal parts in them and by local corrosion to occur in the area under the fouled parts. The method of adding to such water systems the water treating agent of the present invention having the ability to inhibit scaling and to prevent

fouling in them is not specifically defined. The agent can be added thereto all at a time or either intermittently or continuously.

The water treating agent can be used singly by itself but is preferably used along with a metal corrosion inhibitor to synergistically exhibit the metal corrosion inhibiting effect.

The metal corrosion inhibitor includes polyvalent metal salts such as zinc salts, nickel salts, molybdates and tungstates; phosphonates; azoles such as triazoles; phosphates such as orthophosphates and polyphosphates; phosphonocarboxylates; amines and phosphoric esters.

The metal corrosion inhibitor, if used, can be added to the copolymer having the ability to inhibit scaling and to inhibit fouling in water systems, in an amount of from 0.1 to 10 parts by weight relative to one part of the copolymer. To combine the inhibitor and the copolymer, predetermined amounts of these can be previously mixed to give one formulation which shall be added to water systems, or alternatively, the two can be separately added to water systems in such a manner that predetermined amounts of the two shall exist therein.

The water treating agent of the present invention may further contain any other known water treating agents. Known water treating agents include known scale inhibiting

and fouling preventing chemicals, microbicides (slime retarding agents), acids and alkalis. The known scale inhibiting chemicals include, for example, polyacrylates, polyacrylamides and their partial hydrolysis products, maleic acid polymers, itaconic acid polymers, and binary acrylic copolymers comprising 2-hydroxyethyl methacrylate and hydroxyallyloxypromanesulfonic acid.

The microbicides (slime controlling agents) include, for example, chlorine compounds such as chlorine gas, sodium and potassium hypochlorite, and sodium chloroisocyanurate; inorganic and organic, bromine containing agents; organic nitrogen sulfur compounds; and quaternary ammonium salts.

Next, the present invention is described in more detail with reference to the following production examples and examples, which, however, are not intended to restrict the scope of the present invention.

EXAMPLES

Production Example 1:

189.1 g of isoprenesulfonic acid (commercially-available product with an acid content of 40 % by weight), 200.3 g of acrylic acid (commercially available product with an acid content of 80 % by weight) and 40.6 g of 2-hydroxyethyl methacrylate (commercially available product with an ester content of 95 % by weight) were mixed to

prepare an aqueous solution comprising the monomers. The molar ratio of isoprenesulfonic acid/acrylic acid/2-hydroxyethyl methacrylate in the aqueous solution was 15/75/10.

228.7 g of water and 13.7 g of 30 wt.-%-hydrogen peroxide aqueous solution were put into a one liter, four neck separable flask equipped with a stirrer, a reflux condenser, a dropping funnel and a nitrogen gas introducing tube, and the aqueous monomer solution that had been prepared in the above was dropwise added thereto over a period of 2 hours while keeping the inner temperature of the flask at 100°C. After the addition, the polymerization was conducted for further one hour, and then 40.8 g of , 48 wt.-%-sodium hydroxide aqueous solution was added to the reaction mixture to partially neutralize it. Thus was obtained a copolymer having a number average molecular weight of 14,000. The copolymer was used in Example 2.

In the same manner as above but varying the compositional ratio of the monomers to be reacted, various copolymers having different monomer compositions were obtained as shown in Tables 1 to 4.

Example 1:

Test for Gelling of Scale inhibiting and fouling preventing Agent with Calcium Ion:

Demineralized water, a pH buffering solution comprising boric acid and sodium borate, a solution of sodium salt of isoprenesulfonic acid/acrylic acid/2-hydroxyethyl methacrylate (20/75/5, by mol) copolymer having a weight average molecular weight of 14,000 (this is a scale inhibiting and fouling preventing agent), and a solution of calcium chloride were put into a 500 ml conical beaker in that order, to prepare 500 ml of a test liquid having a pH of 8.5, a solid content of the scale inhibiting and fouling preventing agent of 100 mg/liter, and a calcium hardness, in terms of CaCO_3 content, of 50 mg/liter.

While varying the amount of the calcium chloride solution added, the same process as above was repeated to prepare various test liquids of 500 ml each, having a calcium hardness, in terms of CaCO_3 content, of 100, 200, 300, 400, 500, 600, 700, 800, 900, 1,000, 1,100 or 1,200 mg/liter.

The conical beakers each were sealed with a polyethylene film, and left in a water bath filled with water having a controlled temperature of 90°C, for 1 hour. After this, the degree of turbidity of each test liquid, which shall result from the gel to be formed therein through bonding of calcium ions to the copolymer of the scale inhibiting and fouling preventing agent, was measured. The test liquids having a calcium concentration, in terms

of CaCO_3 , of 900 mg/liter or less did not become turbid, while those having a calcium concentration, in terms of CaCO_3 , of 1000 mg/liter or more became turbid. The minimum calcium hardness (calcium concentration) that shall make the test liquid cloudy (turbid) was defined to be the anti gelling concentration for the copolymer tested. According to this definition, the anti gelling concentration for the copolymer of the scale inhibiting and fouling preventing agent tested herein was 1000 mg of CaCO_3 /liter.

Example 2:

The same experiment as in Example 1 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid/2 hydroxyethyl methacrylate (15/75/10, by mol) copolymer having a weight average molecular weight of 14,000 was used as the scale inhibiting and fouling preventing agent. The anti gelling concentration for the inhibiting retarding and fouling preventing agent tested herein was 500 mg of CaCO_3 /liter.

Comparative Example 1:

The same experiment as in Example 1 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid (25/75, by mol) copolymer having a weight average molecular weight of 10,000 was used as the scale retarding and soil preventing agent. The anti gelling

concentration for the scale inhibiting and fouling preventing agent tested herein was 400 mg of CaCO_3 /liter.

Comparative Example 2:

The same experiment as in Example 1 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid (25/75, by mol) copolymer having a weight average molecular weight of 15,000 was used as the scale inhibiting and fouling preventing agent. The anti gelling concentration for the scale inhibiting and fouling preventing agent tested herein was 400 mg of CaCO_3 /liter.

Comparative Example 3:

The same experiment as in Example 1 was repeated, except that a solution of sodium polyacrylate having a weight average molecular weight of 5,000 was used as the scale retarding and soil preventing agent. The anti gelling concentration for the scale inhibiting and fouling preventing agent tested herein was 100 mg of CaCO_3 /liter.

The results of Examples 1 and 2 and Comparative Examples 1 to 3 are shown in Table 1.

Table 1

	Scale inhibiting and fouling preventing Agent	IPS/AA/HEMA (by mol)	Molecular Weight	Amount Added (mg of solid content/liter)	Anti-gelling Concentration (mg of CaCO ₃ /liter)
Example 1	IPS/AA/HEMA Copolymer(1)	20/75/5	14,000	100	1000
Example 2	IPS/AA/HEMA Copolymer(1)	15/75/10	14,000	100	500
Comparative Example 1	IPS/AA Copolymer(1)	25/75/0	10,000	100	400
Comparative Example 2	IPS/AA Copolymer(1)	25/75/0	15,000	100	400
Comparative Example 3	Sodium Polyacrylate	0/100/0	5,000	100	100

Notes:

(1) Sodium Salt

IPS: Isoprenesulfonic Acid

AA: Acrylic Acid

HEMA: 2-Hydroxyethyl Methacrylate

The scale inhibiting and fouling preventing agent, for which the anti gelling concentration is higher, can be dissolved more stably in water having a high calcium hardness while exhibiting a more stable scale inhibiting and fouling preventing effect. It is known from the results of the above mentioned examples and comparative examples that the scale inhibiting and fouling preventing agents of the present invention, each comprising an isoprenesulfonic acid/acrylic acid/2-hydroxyethyl methacrylate copolymer, exhibit a higher anti gelling ability and therefore can be dissolved more stably in water having a high calcium hardness than the comparative agent comprising a sodium polyacrylate and even than the other comparative agents each comprising an isoprenesulfonic acid/acrylic acid copolymer, the comparative agents being referred to herein as samples of prior art products.

Example 3:

Test for Preventing Precipitation of Calcium Phosphate:

Demineralized water, a pH buffering solution comprising boric acid and sodium borate, a solution of calcium chloride, a solution of sodium salt of isoprenesulfonic acid/acrylic acid/2-hydroxyethyl methacrylate (20/75/5, by mol) copolymer having a weight-average molecular weight of 14,000 (this is a scale inhibiting and fouling preventing agent), and a solution of

sodium phosphate were put into a 500-ml conical beaker in that order, to prepare 500 ml of a test liquid having a pH of 8.6, a solid content of the scale inhibiting and fouling-preventing agent of 8 mg/liter, a calcium hardness, in terms of CaCO_3 content, of 100 mg/liter, and a phosphate ion concentration, in terms of PO_4^{3-} , of 10 mg/liter.

The conical beaker was sealed with a polyethylene film, and left in a waterbath filled with water having a controlled temperature of 60°C. After 40 hours, the test liquid was taken out and filtered through a filter paper having a pore diameter of 0.1 μm , and the phosphate ion concentration remained in the resulting filtrate was measured to be 9.5 mg PO_4^{3-} /liter.

Example 4:

The same experiment as in Example 3 was repeated, using the same scale inhibiting and fouling preventing agent as that used in Example 3, except that the concentration of the agent was varied to 6 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 4.2 mg PO_4^{3-} /liter.

Example 5:

The same experiment as in Example 3 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid/2-hydroxyethyl methacrylate (15/75/10, by

mol) copolymer having a weight average molecular weight of 14,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 8 mg, in terms of the solid content, per liter. The phosphato ion concentration remained in the filtrate was 9.1 mg PO_4^{3-} /liter.

Example 6:

The same experiment as in Example 3 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Example 5 was used and that the concentration of the agent was varied to 6 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 2.8 mg PO_4^{3-} /liter.

Comparative Example 4:

The same experiment as in Example 3 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid (25/75, by mol) copolymer having a weight average molecular weight of 15,000 was used as the scale inhibiting and the fouling preventing agent and that the concentration of the agent was 12 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 9.2 mg PO_4^{3-} /liter.

Comparative Example 5:

The same experiment as in Example 3 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Comparative Example 4 was used and that the concentration of the agent was varied to 10 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 6.3 mg PO_4^{3-} /liter.

Comparative Example 6:

The same experiment as in Example 3 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Comparative Example 4 was used and that the concentration of the agent was varied to 8 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 3.2 mg PO_4^{3-} /liter.

Comparative Example 7:

The same experiment as in Example 3 was repeated, except that a solution of sodium polyacrylate having a weight average molecular weight of 5,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 12 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 2.5 mg PO_4^{3-} /liter.

Comparative Example 8:

The same experiment as in Example 3 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Comparative Example 7 was used and that the concentration of the agent was varied to 8 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 1.0 mg PO_4^{3-} /liter.

Comparative Example 9:

The same experiment as in Example 3 was repeated, except that no scale inhibiting and fouling preventing agent was added. The phosphate ion concentration remained in the filtrate was 0.3 mg PO_4^{3-} /liter.

The results of Examples 3 to 6 and Comparative Examples 4 to 9 are shown in Table 2.

Table 2

	Scale inhibiting and fouling preventing Agent	IPS/AA/HEMA (by mol)	Molecular Weight	Amount Added (mg of solid content/liter)	Phosphate Ion Concentration Remained (mg PO ₄ ³⁻ /liter)
Example 3	IPS/AA/HEMA Copolymer(1)	20/75/5	14,000	8	9.5
Example 4	IPS/AA/HEMA Copolymer(1)	20/75/5	14,000	6	4.2
Example 5	IPS/AA/HEMA Copolymer(1)	15/75/10	14,000	8	9.1
Example 6	IPS/AA/HEMA Copolymer(1)	20/75/5	14,000	6	2.8
Comparative Example 4	IPS/AA Copolymer(1)	25/75/0	15,000	12	9.2
Comparative Example 5	IPS/AA Copolymer(1)	25/75/0	15,000	10	6.3
Comparative Example 6	IPS/AA Copolymer(1)	25/75/0	15,000	8	3.2
Comparative Example 7	Sodium Polyacrylate	0/100/0	5,000	12	2.5
Comparative Example 8	Sodium Polyacrylate	0/100/0	5,000	8	1.0
Comparative Example 9	Not Added.	-	-	0	0.3

Notes:

(1) Sodium Salt

IPS: Isoprenesulfonic Acid

AA: Acrylic Acid

HEMA: 2-Hydroxyethyl Methacrylate

If the effect of the scale inhibiting and fouling-preventing agent tested against the precipitation of calcium phosphate is larger, the test liquid to which the agent was added shall produce a smaller amount of the precipitate of calcium phosphate therein and therefore the phosphate ion content of the filtrate from the test liquid containing the agent shall be near to the original phosphate ion content of the test liquid, which is 10 mg PO_4^{3-} /liter. However, if the effect of the scale inhibiting and fouling preventing agent tested against the precipitation of calcium phosphate is smaller, the test liquid to which the agent was added shall produce a larger amount of the precipitate of calcium phosphate therein. Since the precipitate is removed through the filtration of the test liquid containing the agent, the filtrate shall have a smaller phosphate ion content.

From the results in Table 2, it is known that, when the scale inhibiting and fouling preventing agent of the present invention comprising an isoprenesulfonic acid/acrylic acid/2-hydroxyethyl methacrylate copolymer was added to the test liquid in an amount of 8 mg, in terms of the solid content of the agent, per liter of the test liquid, the phosphate ion concentration in the filtrate was larger than 9 mg PO_4^{3-} /liter. This verifies the excellent effect of the agent against the precipitation of calcium

phosphate in the test liquid or, that is, against the formation of scale. As opposed to this, when the comparative agent comprising an isoprenesulfonic acid/acrylic acid copolymer was added to the same test liquid in an amount of 8 mg, in terms of the solid content of the agent, per liter of the test liquid, the phosphate ion concentration in the filtrate was only 3.2 mg PO_4^{3-} /liter. Thus, there is a significant difference between the scale inhibiting and fouling preventing agent of the present invention and the comparative agent in the ability to prevent the precipitation of calcium phosphate. Only when the comparative agent was added in an amount of 12 mg, in terms of the solid content of the agent, per liter of the test liquid, the phosphate ion concentration in the filtrate was larger than 9 mg PO_4^{3-} /liter. Regarding the other comparative agent comprising a sodium polyacrylate, even when it was added to the same test liquid in an amount of 12 mg, in terms of the solid content of the agent, per liter of the test liquid, the phosphate ion concentration in the filtrate was only 2.5 mg PO_4^{3-} /liter.

Example 7:

Test for Preventing Precipitation of Zinc Phosphate:

Demineralized water, a solution of calcium chloride, a solution of sodium salt of isoprenesulfonic acid/acrylic acid/2 hydroxyethyl methacrylate (20/75/5, by mol)

copolymer having a weight average molecular weight of 14,000 (this is a scale inhibiting and fouling preventing agent), a solution of zinc chloride and a solution of sodium hydrogencarbonate were put into a 500 ml conical beaker in that order. Last, an aqueous solution of 1 wt.-% sodium hydroxide was added thereto to adjust the pH of the resulting mixture. Thus was prepared 500 ml of a test liquid having a pH of 8.6, a solid content of the scale inhibiting and soil preventing agent of 4 mg/liter, a calcium hardness, in terms of CaCO_3 content, of 100 mg/liter, an M alkalinity, in terms of CaCO_3 content, of 100 mg/liter, a phosphate ion concentration, in terms of PO_4^{3-} , of 6.0 mg/liter and a zinc ion concentration, in terms of Zn^{2+} , of 3.5 mg/liter.

The conical beaker was sealed with a polyethylene film, and left in a water bath filled with water having a controlled temperature of 60°C. After 40 hours, the test liquid was taken out and filtered through a filter paper having a pore diameter of 0.1 μm , and the phosphate ion concentration and the zinc ion concentration remained in the resulting filtrate were measured to be 9.4 mg/liter in total of the two.

Comparative Example 10:

The same experiment as in Example 7 was repeated except that a solution of sodium salt of isoprenesulfonic

acid/acrylic acid (25/75, by mol) copolymer having a weight-average molecular weight of 22,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 4 mg, in terms of the solid content, per liter. The sum of the phosphate ion concentration and the zinc ion concentration remained in the filtrate was 9.0 mg/liter.

Comparative Example 11:

The same experiment as in Example 7 was repeated except that a solution of sodium polyacrylate having a weight-average molecular weight of 5,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 10 mg, in terms of the solid content, per liter. The sum of the phosphate ion concentration and the zinc ion concentration remained in the filtrate was 3.5 mg/liter.

Comparative Example 12:

The same experiment as in Example 7 was repeated except that no scale inhibiting and fouling preventing agent was added. The sum of the phosphate ion concentration and the zinc ion concentration remained in the filtrate was 0.2 mg/liter.

The results of Example 7 and Comparative Examples 10 to 12 are shown in Table 3.

Table 3

	Scale inhibiting and fouling preventing Agent	IPS/AA/HEMA (by mol)	Molecular Weight	Amount Added (mg of solid content/liter)	Sum of Phosphate Ion Concentration and Zinc Ion Concentration Remained (mg/liter)
Example 7	IPS/AA/HEMA Copolymer(1)	20/75/5	14,000	4	9.4
Comparative Example 10	IPS/AA Copolymer(1)	25/75/0	22,000	4	9.0
Comparative Example 11	Sodium Polyacrylate	0/100/0	5,000	10	3.5
Comparative Example 12	Not added.	-	-	0	0.2

39

Notes:

(1) Sodium Salt

IPS: Isoprenesulfonic Acid

AA: Acrylic Acid

HEMA: 2-Hydroxyethyl Methacrylate

If the effect of the scale inhibiting and fouling preventing agent tested against the precipitation of zinc phosphate is larger, the test liquid to which the agent was added shall produce a smaller amount of the precipitate of zinc phosphate therein and therefore the sum of the phosphate ion content and the zinc ion content of the filtrate from the test liquid containing the agent shall be near to the sum of the phosphato ion content and the zinc ion content of the original test liquid, which is 9.5 mg/liter. However, if the effect of the scale inhibiting and fouling preventing agent tested against the precipitation of zinc phosphate is smaller, the test liquid to which the agent was added shall produce a larger amount of the precipitate of zinc phosphate therein. Since the precipitate is removed through the filtration of the test liquid containing the agent, the filtrate shall have a smaller phosphate ion content and a smaller zinc ion content.

From the results in Table 3, it is known that both the addition of the scale inhibiting and fouling preventing agent of the present invention comprising an isoprenesulfonic acid/acrylic acid/2 hydroxyethyl methacrylate copolymer to the test liquid in an amount of 4 mg, in terms of the solid content of the agent, per liter of the test liquid and the addition of the comparative

agent comprising an isoprenesulfonic acid/acrylic acid copolymer to the same in the same amount resulted in almost the same amount of the sum of the phosphate ion concentration and the zinc ion concentration remained in the filtrate, which is about 9.0 mg/liter. This verifies that the two agents have almost the same effect against the precipitation of zinc phosphate in the test liquid. However, as has been known from the results in Table 2, the effect of the scale inhibiting and fouling preventing agent of the present invention comprising an isoprenesulfonic acid/acrylic acid/2 hydroxyethyl methacrylate against the precipitation of calcium phosphate is higher than that of the comparative agent comprising an isoprenesulfonic acid/acrylic acid against the same. From these, therefore, it is understood that the scale inhibiting and fouling preventing agent of the present invention is preferable to the comparative agent, as being more effectively applicable to various objects than the latter

Regarding the other comparative agent comprising a sodium polyacrylate, even when it was added to the same test liquid in an amount of 10 mg, in terms of the solid content of the agent, per liter of the test liquid, the sum of the phosphate ion concentration and the zinc ion concentration remained in the filtrate was only 3.5 mg/liter.

Example 8:

Test for Preventing Precipitation of Iron Oxide and Iron Hydroxide:

Demineralized water, a solution of sodium salt of isoprenesulfonic acid/acrylic acid/2-hydroxyethyl methacrylate (20/75/5, by mol) copolymer having a weight-average molecular weight of 14,000 (this is a scale inhibiting and fouling preventing agent), a solution of sodium hydrogencarbonate, a solution of sodium silicate No. 3, a solution of calcium chloride, a solution of magnesium sulfate and a solution of ferric chloride were put into a 500-ml conical beaker in that order. Last, an aqueous solution of 1 wt.% sulfuric acid was added thereto to adjust the pH of the resulting mixture. Thus was prepared 500 ml of a test liquid having a pH of 8.8, a solid content of the scale inhibiting and fouling-preventing agent of 5.0 mg/liter, a calcium hardness, in terms of CaCO_3 content, of 250 mg/liter, a magnesium hardness, in terms of CaCO_3 content, of 100 mg/liter, an M alkalinity, in terms of CaCO_3 content, of 250 mg/liter, a silica content, in terms of SiO_2 , of 100 mg/liter and a total iron content, in terms of Fe, of 10 mg/liter.

The conical beaker was sealed with a polyethylene film, and left in a water bath filled with water having a controlled temperature of 30_C, for 20 hours. After this,

the beaker was taken out, and the dissolved iron content of the supernatant thus separated in the beaker was measured to be 10.0 mg Fe/liter.

Example 9:

The same experiment as in Example 8 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid/2 hydroxyethyl methacrylate (15/75/10, by mol) copolymer having a weight average molecular weight of 14,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 5.0 mg, in terms of the solid content, per liter. The dissolved iron content of the supernatant was 10.0 mg Fe/liter.

Comparative Example 13:

The same experiment as in Example 8 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid (25/75, by mol) copolymer having a weight-average molecular weight of 16,000 was used as the scale inhibiting and the fouling preventing agent and that the concentration of the agent was 7.5 mg, in terms of the solid content, per liter. The dissolved iron content of the supernatant was 10.0 mg Fe/liter.

Comparative Example 14:

The same experiment as in Example 8 was repeated, except that the same scale inhibiting and fouling

preventing agent as that used in Comparative Example 13 was used and that the concentration of the agent was varied to 5.0 mg, in terms of the solid content, per liter. The dissolved iron content of the supernatant was 7.8 mg Fe/liter.

Comparative Example 15:

The same experiment as in Example 8 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid (25/75, by mol) copolymer having a weight average molecular weight of 22,000 was used as the scale inhibiting and the fouling-preventing agent and that the concentration of the agent was 7.5 mg, in terms of the solid content, per liter. The dissolved iron content of the supernatant was 10.0 mg Fe/liter.

Comparative Example 16:

The same experiment as in Example 8 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Comparative Example 15 was used and that the concentration of the agent was varied to 5.0 mg, in terms of the solid content, per liter. The dissolved iron content of the supernatant was 8.0 mg Fe/liter.

Comparative Example 17:

The same experiment as in Example 8 was repeated, except that a solution of sodium hexametaphosphate was used

as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 10.0 mg, in terms of the solid content, per liter. The dissolved iron content of the supernatant was 3.3 mg Fe/liter.

Comparative Example 18:

The same experiment as in Example 8 was repeated, except that a solution of sodium hexametaphosphate was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 7.5 mg, in terms of the solid content, per liter. The dissolved iron content of the supernatant was 2.4 mg Fe/liter.

Comparative Example 19:

The same experiment as in Example 8 was repeated, except that a solution of sodium polyacrylate having a weight average molecular weight of 5,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 10.0 mg, in terms of the solid content, per liter. The dissolved iron content of the supernatant was 6.0 mg Fe/liter.

Comparative Example 20:

The same experiment as in Example 8 was repeated, except that no scale inhibiting and fouling preventing agent was added. The dissolved iron content of the supernatant was 0.4 mg Fe/liter.

The results of Examples 8 to 9 and Comparative Examples 13 to 20 are shown in Table 4.

Table 4

	Scale inhibiting and fouling preventing Agent	IPS/AA/HEMA (by mol)	Molecular Weight	Amount Added (mg of solid content/liter)	Dissolved Iron Concentration Remained (mg Fe/liter)
Example 8	IPS/AA/HEMA Copolymer(1)	20/75/5	14,000	5.0	10.0
Example 9	IPS/AA/HEMA Copolymer(1)	15/75/10	14,000	5.0	10.0
Comparative Example 13	IPS/AA Copolymer(1)	25/75/0	16,000	7.5	10.0
Comparative Example 14	IPS/AA Copolymer(1)	25/75/0	16,000	5.0	7.8
Comparative Example 15	IPS/AA Copolymer(1)	25/75/0	22,000	7.5	10.0
Comparative Example 16	IPS/AA Copolymer(1)	25/75/0	22,000	5.0	8.0
Comparative Example 17	Sodium Hexameta- phosphate	-	-	10.0	3.3
Comparative Example 18	Sodium Hexameta- phosphate	-	-	7.5	2.4
Comparative Example 19	Sodium Polyacrylate	0/100/0	5,000	10.0	6.0
Comparative Example 20	Not Added.	-	-	0	0.4

Notes:

(1) Sodium Salt

IPS: Isoprenesulfonic Acid

AA: Acrylic Acid

HEMA: 2-Hydroxyethyl Methacrylate

If no scale inhibiting and fouling preventing agent is added to the test liquid or if the effect of the scale inhibiting and fouling preventing agent as added thereto is not satisfactory, the iron component as existing in the test liquid shall be precipitated in the form of iron oxide hydrate or iron hydroxide. Therefore, the effect of the scale inhibiting and fouling preventing agent as added to the test liquid for dispersing the iron oxide or iron hydroxide precipitate formed in the test liquid can be evaluated from the data of the dissolved iron content of the supernatant separated from the test liquid to which the agent was added.

The scale inhibiting and fouling preventing agent of the present invention comprising an isoprenesulfonic acid/acrylic acid/2 hydroxyethyl methacrylate copolymer, when added to the test liquid in an amount of 5 mg, in terms of the solid content thereof, per liter, inhibited the precipitation of iron of 10 mg/liter, while acting to completely disperse and keep it in water in the test liquid. As opposed to this, however, when the comparative agent comprising an isoprenesulfonic acid/acrylic acid copolymer was added to the same test liquid in an amount of 5 mg, in terms of the solid content thereof, per liter, it could not inhibit the precipitation of iron of 10 mg/liter. In order to inhibit the precipitation of iron of 10 mg/liter in the

test liquid, it was necessary to add 7.5 mg/liter, in terms of the solid content, of the comparative agent to the test liquid. Regarding the other comparative agents comprising sodium hexametaphosphate or sodium polyacrylate of the prior art, they could not inhibit the precipitation of iron of 10 mg/liter in the test liquid even when they were added to the test liquid in an amount of 10 mg, in terms of the solid content, per liter. From these, it is understood that the scale inhibiting and fouling preventing agent of the present invention has a much more excellent effect for dispersing iron oxide and iron hydroxide in water than the comparative agents comprising sodium hexametaphosphate or sodium polyacrylate.

Production Example 2:

252.1 g of isoprenesulfonic acid (commercially-available product with an acid content of 40 % by weight), 200.3 g of acrylic acid (commercially available product with an acid content of 80 % by weight) and 31.4 g of acrylamido 2 methylpropanesulfonic acid (commercially available product with an acid content of 98 % by weight) were mixed to prepare an aqueous solution comprising the monomers. The molar ratio of isoprenesulfonic acid/acrylic acid/acrylamido 2 methylpropanesulfonic acid in the aqueous solution was 20/75/5.

228.7 g of water and 13.7 g of 30 wt.-%-hydrogen peroxide aqueous solution were put into a one liter, four neck separable flask equipped with a stirrer, a reflux condenser, a dropping funnel and a nitrogen gas-introducing tube, and the aqueous monomer solution that had been prepared in the above was dropwise added thereto over a period of 2 hours while keeping the inner temperature of the flask at 100°C. After the addition, the polymerization was conducted for further one hour, and then 67.3 g of an 48 wt.-%-sodium hydroxide aqueous solution was added to the reaction mixture to partially neutralize it. Thus was obtained a copolymer having a number average molecular weight of 22,000. The copolymer was used in Example 11.

In the same manner as above but varying the compositional ratio of the monomers to be reacted and varying the amount of hydrogen peroxide to be added, various copolymers having different monomer compositions were obtained as shown in Tables 5 to 8.

Example 10:

Test for Gelling of Scale inhibiting and fouling preventing Agent with Calcium Ion:

Demineralized water, a pH buffering solution comprising boric acid and sodium borate, either (A1) a solution of sodium salt of isoprenesulfonic acid/acrylic acid/2 hydroxyethyl methacrylate (20/75/5, by mol)

copolymer having a weight average molecular weight of 14,000 or (B1) a solution of sodium salt of isoprenesulfonic acid/acrylic acid/acrylamido-2-methylpropanesulfonic acid (20/75/5, by mol) copolymer having a weight average molecular weight of 15,000 (this is a scale inhibiting and fouling-preventing agent), and a solution of calcium chloride were put into a 500-ml conical beaker in that order, to prepare 500 ml of a test liquid having a pH of 8.5, a solid content of the scale inhibiting and fouling preventing agent of 100 mg/liter, and a calcium hardness, in terms of CaCO_3 content, of 50 mg/liter.

While varying the amount of the calcium chloride solution added, the same process as above was repeated to prepare various test liquids of 500 ml each, having a calcium hardness, in terms of CaCO_3 content, of 100, 200, 300, 400, 500, 600, 700, 800, 900, 1,000, 1,100 or 1,200 mg/liter.

The conical beakers each were sealed with a polyethylene film, and left in a water bath filled with water having a controlled temperature of 90°C, for 1 hour. After this, the degree of turbidity of each test liquid, which shall result from the gel to be formed therein through bonding of calcium ions to the copolymer of the scale inhibiting and fouling preventing agent, was measured. The test liquids comprising (A1) and having a calcium

concentration, in terms of CaCO_3 , of 900 mg/liter or less did not become turbid, while those comprising (A1) and having a calcium concentration, in terms of CaCO_3 , of 1000 mg/liter or more became turbid. The minimum calcium hardness (calcium concentration) that shall make the test liquid cloudy (turbid) was defined to be the anti gelling concentration for the copolymer tested. According to this definition, the anti gelling concentration for the copolymer of the scale inhibiting and fouling preventing agent (A1) tested herein was 1000 mg of CaCO_3 /liter.

On the other hand, the test liquids comprising (B1) and having a calcium concentration, in terms of CaCO_3 , of 500 mg/liter or less did not become turbid, while those comprising (B1) and having a calcium concentration, in terms of CaCO_3 , of 600 mg/liter or more became turbid. The anti gelling concentration for the copolymer of the scale inhibiting and fouling preventing agent (B1) tested herein was 600 mg of CaCO_3 /liter.

Example 11:

The same experiment as in Example 10 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid/acrylamido 2 methylpropanesulfonic acid (20/75/5, by mol) copolymer having a weight average molecular weight of 22,000 was used as the scale retarding and soil preventing agent. The anti gelling concentration

for the scale inhibiting and fouling preventing agent tested herein was 600 mg of CaCO_3 /liter.

Comparative Example 21:

The same experiment as in Example 10 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid (25/75, by mol) copolymer having a weight average molecular weight of 10,000 was used as the scale inhibiting and fouling preventing agent. The anti gelling concentration for the scale inhibiting and fouling preventing agent tested herein was 400 mg of CaCO_3 /liter.

Comparative Example 22:

The same experiment as in Example 10 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid (25/75, by mol) copolymer having a weight average molecular weight of 15,000 was used as the scale inhibiting and fouling preventing agent. The anti gelling concentration for the scale inhibiting and fouling preventing agent tested herein was 400 mg of CaCO_3 /liter.

Comparative Example 23:

The same experiment as in Example 10 was repeated, except that a solution of sodium polyacrylate having a weight average molecular weight of 5,000 was used as the scale inhibiting and fouling preventing agent. The anti gelling concentration for the scale inhibiting and fouling preventing agent tested herein was 100 mg of CaCO_3 /liter.

The results of Examples 10 and 11 and Comparative Examples 21 to 23 are shown in Table 5.

Table 5

	Scale inhibiting and fouling preventing Agent	IPS/AA/AMPS (by mol)	Molecular Weight	Amount Added (mg of solid content/liter)	Anti-gelling Concentration (mg of CaCO ₃ /liter)
Example 10	IPS/AA/AMPS Copolymer(1)	20/75/5	15,000	100	600
Example 11	IPS/AA/AMPS Copolymer(1)	20/75/5	22,000	100	600
Comparative Example 21	IPS/AA Copolymer(1)	25/75/0	10,000	100	400
Comparative Example 22	IPS/AA Copolymer(1)	25/75/0	15,000	100	400
Comparative Example 23	Sodium Polyacrylate	0/100/0	5,000	100	100

Notes:

(1) Sodium Salt

IPS: Isoprenesulfonic Acid

AA: Acrylic Acid

AMPS: Acrylamido-2-methylpropanesulfonic Acid

The scale inhibiting and fouling preventing agent, for which the anti gelling concentration is higher, can be dissolved more stably in water having a high calcium hardness while exhibiting a more stable scale inhibiting and fouling preventing effect. It is known from the results of the above mentioned examples and comparative examples that the scale inhibiting and fouling preventing agents of the present invention, each comprising an isoprenesulfonic acid/acrylic acid/acrylamido 2-methylpropanesulfonic acid copolymer, exhibit a higher anti gelling ability and therefore can be dissolved more stably in water having a high calcium hardness than the comparative agent comprising a sodium polyacrylate and even than the other comparative agents each comprising an isoprenesulfonic acid/acrylic acid copolymer, the comparative agents being referred to herein as samples of prior art products.

Example 12:

Test for Preventing Precipitation of Calcium Phosphate:

Demineralized water, a pH buffering solution comprising boric acid and sodium borate, a solution of calcium chloride, a solution of sodium salt of isoprenesulfonic acid/acrylic acid/acrylamido-2-methylpropanesulfonic acid (20/75/5, by mol) copolymer having a weight average molecular weight of 15,000 (this is

a scale inhibiting and fouling preventing agent), and a solution of sodium phosphate were put into a 500-ml conical beaker in that order, to prepare 500 ml of a test liquid having a pH of 8.6, a solid content of the scale inhibiting and fouling-preventing agent of 8 mg/liter, a calcium hardness, in terms of CaCO_3 content, of 100 mg/liter, and a phosphate ion concentration, in terms of PO_4^{3-} , of 10 mg/liter.

The conical beaker was sealed with a polyethylene film, and left in a water bath filled with water having a controlled temperature of 60°C. After 40 hours, the test liquid was taken out and filtered through a filter paper having a pore diameter of 0.1 μm , and the phosphate ion concentration remained in the resulting filtrate was measured to be 9.4 mg PO_4^{3-} /liter.

Example 13:

The same experiment as in Example 12 was repeated, using the same scale inhibiting and fouling preventing agent as that used in Example 12, except that the concentration of the agent was varied to 6 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 2.4 mg PO_4^{3-} /liter.

Example 14:

The same experiment as in Example 12 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid/acrylamido 2 methylpropanesulfonic acid (20/75/5, by mol) copolymer having a weight average molecular weight of 22,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 8 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 9.2 mg PO_4^{3-} /liter.

Example 15:

The same experiment as in Example 12 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Example 14 was used and that the concentration of the agent was varied to 6 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 1.6 mg PO_4^{3-} /liter.

Comparative Example 24:

The same experiment as in Example 12 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid (25/75, by mol) copolymer having a weight average molecular weight of 15,000 was used as the scale inhibiting and the fouling preventing agent and that the concentration of the agent was 12 mg, in terms of the solid

content, per liter. The phosphate ion concentration remained in the filtrate was 9.2 mg PO_4^{3-} /liter.

Comparative Example 25:

The same experiment as in Example 12 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Comparative Example 24 was used and that the concentration of the agent was varied to 10 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 6.3 mg PO_4^{3-} /liter.

Comparative Example 26:

The same experiment as in Example 12 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Comparative Example 24 was used and that the concentration of the agent was varied to 8 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 3.2 mg PO_4^{3-} /liter.

Comparative Example 27:

The same experiment as in Example 12 was repeated, except that a solution of sodium polyacrylate having a weight-average molecular weight of 5,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 12 mg, in terms of the solid

content, per liter. The phosphato ion concentration remained in the filtrate was 2.5 mg PO_4^{3-} /liter.

Comparative Example 28:

The same experiment as in Example 12 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Comparative Example 27 was used and that the concentration of the agent was varied to 8 mg, in terms of the solid content, per liter. The phosphate ion concentration remained in the filtrate was 1.0 mg PO_4^{3-} /liter.

Comparative Example 29:

The same experiment as in Example 12 was repeated, except that no scale inhibiting and fouling preventing agent was added. The phosphate ion concentration remained in the filtrate was 0.3 mg PO_4^{3-} /liter.

The results of Examples 12 to 15 and Comparative Examples 24 to 29 are shown in Table 6.

Table 6

	Scale inhibiting and fouling preventing Agent	IPS/AA/AMPS (by mol)	Molecular Weight	Amount Added (mg of solid content/liter)	Phosphate Ion Concentration Remained (mg PO ₄ ³⁻ /liter)
Example 12	IPS/AA/AMPS Copolymer(1)	20/75/5	15,000	8	9.4
Example 13	IPS/AA/AMPS Copolymer(1)	20/75/5	15,000	6	2.4
Example 14	IPS/AA/AMPS Copolymer(1)	20/75/5	22,000	8	9.2
Example 15	IPS/AA/AMPS Copolymer(1)	20/75/5	22,000	6	1.6
Comparative Example 24	IPS/AA Copolymer(1)	25/75/0	15,000	12	9.2
Comparative Example 25	IPS/AA Copolymer(1)	25/75/0	15,000	10	6.3
Comparative Example 26	IPS/AA Copolymer(1)	25/75/0	15,000	8	3.2
Comparative Example 27	Sodium Polyacrylate	0/100/0	5,000	12	2.5
Comparative Example 28	Sodium Polyacrylate	0/100/0	5,000	8	1.0
Comparative Example 29	Not Added.	-	-	0	0.3

64

Notes:

(1) Sodium Salt

IPS: Isoprenesulfonic Acid

AA: Acrylic Acid

AMPS: Acrylamido-2-methylpropanesulfonic Acid

If the effect of the scale inhibiting and fouling preventing agent tested against the precipitation of calcium phosphate is larger, the test liquid to which the agent was added shall produce a smaller amount of the precipitate of calcium phosphate therein and therefore the phosphate ion content of the filtrate from the test liquid containing the agent shall be near to the original phosphato ion content of the test liquid which is 10 mg PO_4^{3-} /liter. However, if the effect of the scale inhibiting and fouling preventing agent tested against the precipitation of calcium phosphate is smaller, the test liquid to which the agent was added shall produce a larger amount of the precipitate of calcium phosphate therein. Since the precipitate is removed through the filtration of the test liquid containing the agent, the filtrate shall have a smaller phosphate ion content.

From the results in Table 6, it is known that, when the scale inhibiting and fouling preventing agent of the present invention comprising an isoprenesulfonic acid/acrylic acid/acrylamido-2-methylpropanesulfonic acid copolymer was added to the test liquid in an amount of 8 mg, in terms of the solid content of the agent, per liter of the test liquid, the phosphate ion concentration in the filtrate was larger than 9 mg PO_4^{3-} /liter. This verifies the excellent effect of the agent against the precipitation

of calcium phosphate in the test liquid or, that is, against the formation of scale. As opposed to this, when the comparative agent comprising an isoprenesulfonic acid/acrylic acid copolymer was added to the same test liquid in an amount of 8 mg, in terms of the solid content of the agent, per liter of the test liquid, the phosphate ion concentration in the filtrate was only 3.2 mg PO_4^{3-} /liter. Thus, there is a significant difference between the scale inhibiting and fouling preventing agent of the present invention and the comparative agent in the ability to prevent the precipitation of calcium phosphate. Only when the comparative agent was added in an amount of 12 mg, in terms of the solid content of the agent, per liter of the test liquid, the phosphate ion concentration in the filtrate was larger than 9 mg PO_4^{3-} /liter. Regarding the other comparative agent comprising a sodium polyacrylate, even when it was added to the same test liquid in an amount of 12 mg, in terms of the solid content of the agent, per liter of the test liquid, the phosphate ion concentration in the filtrate was only 2.5 mg PO_4^{3-} /liter.

Example 16:

Test for Preventing Precipitation of Zinc Phosphate:

Demineralized water, a solution of calcium chloride, a solution of sodium salt of isoprenesulfonic acid/acrylic acid/acrylamido 2 methylpropanesulfonic acid (20/75/5, by

mol) copolymer having a weight average molecular weight of 22,000 (this is a scale inhibiting and fouling preventing agent), a solution of zinc chloride and a solution of sodium hydrogencarbonate were put into a 500-ml conical beaker in that order. Last, an aqueous solution of 1 wt.-% sodium hydroxide was added thereto to adjust the pH of the resulting mixture. Thus was prepared 500 ml of a test liquid having a pH of 8.6, a solid content of the scale inhibiting and fouling preventing agent of 4 mg/liter, a calcium hardness, in terms of CaCO_3 content, of 100 mg/liter, an M-alkalinity, in terms of CaCO_3 content, of 100 mg/liter, a phosphate ion concentration, in terms of PO_4^{3-} , of 6.0 mg/liter and a zinc ion concentration, in terms of Zn^{2+} , of 3.5 mg/liter.

The conical beaker was sealed with a polyethylene film, and left in a water bath filled with water having a controlled temperature of 60°C. After 40 hours, the test liquid was taken out and filtered through a filter paper having a pore diameter of 0.1 μm , and the phosphate ion concentration and the zinc ion concentration remained in the resulting filtrate were measured to be 9.0 mg/liter in total of the two.

Comparative Example 30:

The same experiment as in Example 16 was repeated except that a solution of sodium salt of isoprenesulfonic

acid/acrylic acid (25/75, by mol) copolymer having a weight-average molecular weight of 22,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 4 mg, in terms of the solid content, per liter. The sum of the phosphato ion concentration and the zinc ion concentration remained in the filtrate was 9.0 mg/liter.

Comparative Example 31:

The same experiment as in Example 16 was repeated except that a solution of sodium polyacrylate having a weight average molecular weight of 5,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 10 mg, in terms of the solid content, per liter. In this, an aqueous solution of 1 wt.-%-sodium hydroxide was used for the adjustment of the pH of the mixture in the last step. The sum of the phosphate ion concentration and the zinc ion concentration remained in the filtrate was 3.5 mg/liter.

Comparative Example 32:

The same experiment as in Example 16 was repeated except that no scale inhibiting and fouling preventing agent was added. In this, an aqueous solution of 1 wt.-%-sodium hydroxide was used for the adjustment of the pH of the mixture in the last step. The sum of the phosphate ion

concentration and the zinc ion concentration remained in the filtrate was 0.2 mg/liter.

The results of Example 16 and Comparative Examples 30 to 32 are shown in Table 7.

Table 7

	Scale inhibiting and fouling preventing Agent	IPS/AA/AMPS (by mol)	Molecular Weight	Amount Added (mg of solid content/liter)	Sum of Phosphate Ion Concentration and Zinc Ion Concentration Remained (mg/liter)
Example 16	IPS/AA/AMPS Copolymer(1)	20/75/5	22,000	4	9.0
Comparative Example 30	IPS/AA Copolymer(1)	25/75/0	22,000	4	9.0
Comparative Example 31	Sodium Polyacrylate	0/100/0	5,000	10	3.5
Comparative Example 32	Not added.	-	-	0	0.2

71

Notes:

(1) Sodium Salt

IPS: Isoprenesulfonic Acid

AA: Acrylic Acid

AMPS: Acrylamido-2-methylpropanesulfonic Acid

If the effect of the scale inhibiting and fouling preventing agent tested against the precipitation of zinc phosphate is larger, the test liquid to which the agent was added shall produce a smaller amount of the precipitate of zinc phosphate therein and therefore the sum of the phosphate ion content and the zinc ion content of the filtrate from the test liquid containing the agent shall be near to the sum of the phosphato ion content and the zinc ion content of the original test liquid which is 9.5 mg/liter. However, if the effect of the scale inhibiting

and fouling preventing agent tested against the precipitation of zinc phosphate is smaller, the test liquid to which the agent was added shall produce a larger amount of the precipitate of zinc phosphate therein. Since the precipitate is removed through the filtration of the test liquid containing the agent, the filtrate shall have a smaller phosphate ion content and a smaller zinc ion content.

From the results in Table 7, it is known that both the addition of the scale inhibiting and foling preventing agent of the present invention comprising an isoprenesulfonic acid/acrylic acid/acrylamido 2 methylpropanesulfonic acid copolymer to the test liquid in an amount of 4 mg, in terms of the solid content of the agent, per liter of the test liquid and the addition of the

comparative agent comprising an isoprenesulfonic acid/acrylic acid copolymer to the same in the same amount resulted in the same amount of the sum of the phosphate ion concentration and the zinc ion concentration remained in the filtrate, which is 9.0 mg/liter. This verifies that the two agents have the same effect against the precipitation of zinc phosphate in the test liquid. However, as has been known from the results in Table 6, the effect of the scale inhibiting and fouling preventing agent of the present invention comprising an isoprenesulfonic acid/acrylic acid/acrylamido 2 methylpropanesulfonic acid against the precipitation of calcium phosphate is higher than that of the comparative agent comprising an isoprenesulfonic acid/acrylic acid against the same. From these, therefore, it is understood that the scale inhibiting and fouling preventing agent of the present invention is preferable to the comparative agent, as being more effectively applicable to various objects than the latter

Regarding the other comparative agent comprising a sodium polyacrylate, even when it was added to the same test liquid in an amount of 10 mg, in terms of the solid content of the agent, per liter of the test liquid, the sum of the phosphate ion concentration and the zinc ion

concentration remained in the filtrate was only 3.5 mg/liter.

Example 17:

Test for Preventing Precipitation of Iron Oxide and Iron Hydroxide:

Demineralized water, a solution of sodium salt of isoprenesulfonic acid/acrylic acid/acrylamido-2-methylpropanesulfonic acid (20/75/5, by mol) copolymer having a weight average molecular weight of 15,000 (this is a scale inhibiting and fouling preventing agent), a solution of sodium hydrogencarbonate, a solution of sodium silicate No. 3, a solution of calcium chloride, a solution of magnesium sulfate and a solution of ferric chloride were put into a 500-ml conical beaker in that order. Last, an aqueous solution of 1 wt.% sulfuric acid was added thereto to adjust the pH of the resulting mixture. Thus was prepared 500 ml of a test liquid having a pH of 8.8, a solid content of the scale inhibiting and fouling preventing agent of 5.0 mg/liter, a calcium hardness, in terms of CaCO_3 content, of 250 mg/liter, a magnesium hardness, in terms of CaCO_3 content, of 100 mg/liter, an M alkalinity, in terms of CaCO_3 content, of 250 mg/liter, a silica content, in terms of SiO_2 , of 100 mg/liter and a total iron content, in terms of Fe, of 10 mg/liter.

The conical beaker was sealed with a polyethylene film, and left in a water bath filled with water having a controlled temperature of 30_C, for 20 hours. After this, the beaker was taken out, and the dissolved iron content of the supernatant thus separated in the beaker was measured to be 10.0 mg Fe/liter.

Example 18:

The same experiment as in Example 17 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid/acrylamido 2 methylpropanesulfonic acid (20/75/5, by mol) copolymer having a weight average molecular weight of 22,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 5.0 mg, in terms of the solid content, per liter. The dissolved iron content of the supernatant was 10.0 mg Fe/liter.

Comparative Example 33:

The same experiment as in Example 17 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid (25/75, by mol) copolymer having a weight average molecular weight of 16,000 was used as the scale inhibiting and the fouling preventing agent and that the concentration of the agent was 7.5 mg, in terms of the solid content, per liter. In this, an aqueous solution of 1 wt.-%-sulfuric acid was used for the adjustment of the pH

of the mixture in the last step. The dissolved iron content of the supernatant was 10.0 mg Fe/liter.

Comparative Example 34:

The same experiment as in Example 17 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Comparative Example 33 was used and that the concentration of the agent was varied to 5.0 mg, in terms of the solid content, per liter. In this, an aqueous solution of 1 wt.-%-sulfuric acid was used for the adjustment of the pH of the mixture in the last step. The dissolved iron content of the supernatant was 7.8 mg Fe/liter.

Comparative Example 35:

The same experiment as in Example 17 was repeated, except that a solution of sodium salt of isoprenesulfonic acid/acrylic acid (25/75, by mol) copolymer having a weight average molecular weight of 22,000 was used as the scale inhibiting and the fouling preventing agent and that the concentration of the agent was 7.5 mg, in terms of the solid content, per liter. In this, an aqueous solution of 1 wt.-%-sulfuric acid was used for the adjustment of the pH of the mixture in the last step. The dissolved iron content of the supernatant was 10.0 mg Fe/liter.

Comparative Example 36:

The same experiment as in Example 17 was repeated, except that the same scale inhibiting and fouling preventing agent as that used in Comparative Example 35 was used and that the concentration of the agent was varied to 5.0 mg, in terms of the solid content, per liter. In this, an aqueous solution of 1 wt.-%-sulfuric acid was used for the adjustment of the pH of the mixture in the last step. The dissolved iron content of the supernatant was 8.0 mg Fe/liter.

Comparative Example 37:

The same experiment as in Example 18 was repeated, except that a solution of sodium hexametaphosphate was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 10.0 mg, in terms of the solid content, per liter. In this, an aqueous solution of 1 wt.-%-sulfuric acid was used for the adjustment of the pH of the mixture in the last step. The dissolved iron content of the supernatant was 3.3 mg Fe/liter.

Comparative Example 38:

The same experiment as in Example 17 was repeated, except that a solution of sodium hexametaphosphate was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 7.5 mg, in terms of the solid content, per liter. In this, an aqueous solution

of 1 wt.-%-sulfuric acid was used for the adjustment of the pH of the mixture in the last step. The dissolved iron content of the supernatant was 2.4 mg Fe/liter.

Comparative Example 39:

The same experiment as in Example 17 was repeated, except that a solution of sodium polyacrylate having a weight average molecular weight of 5,000 was used as the scale inhibiting and fouling preventing agent and that the concentration of the agent was 10.0 mg, in terms of the solid content, per liter. In this, an aqueous solution of 1 wt.-%-sulfuric acid was used for the adjustment of the pH of the mixture in the last step. The dissolved iron content of the supernatant was 6.0 mg Fe/liter.

Comparative Example 40:

The same experiment as in Example 17 was repeated, except that no scale inhibiting and fouling preventing agent was added. In this, an aqueous solution of 1 wt.-%-sulfuric acid was used for the adjustment of the pH of the mixture in the last step. The dissolved iron content of the supernatant was 0.4 mg Fe/liter.

The results of Examples 17 to 18 and Comparative Examples 33 to 40 are shown in Table 8.

Table 8

	Scale inhibiting and fouling preventing Agent	IPS/AA/AMPS (by mol)	Molecular Weight	Amount Added (mg of solid content/liter)	Dissolved Iron Concentration Remained (mg Fe/liter)
Example 17	IPS/AA/AMPS Copolymer(1)	20/75/5	15,000	5.0	10.0
Example 18	IPS/AA/AMPS Copolymer(1)	20/75/5	22,000	5.0	10.0
Comparative Example 33	IPS/AA Copolymer(1)	25/75/0	16,000	7.5	10.0
Comparative Example 34	IPS/AA Copolymer(1)	25/75/0	16,000	5.0	7.8
Comparative Example 35	IPS/AA Copolymer(1)	25/75/0	22,000	7.5	10.0
Comparative Example 36	IPS/AA Copolymer(1)	25/75/0	22,000	5.0	8.0
Comparative Example 37	Sodium Hexameta- phosphate	-	-	10.0	3.3
Comparative Example 38	Sodium Hexameta- phosphate	-	-	7.5	2.4
Comparative Example 39	Sodium Polyacrylate	0/100/0	5,000	10.0	6.0
Comparative Example 40	Not Added.	-	-	0	0.4

Notes:

(1) Sodium Salt

IPS: Isoprenesulfonic Acid

AA: Acrylic Acid

AMPS: Acrylamido-2-methylpropanesulfonic Acid

If no scale inhibiting and fouling preventing agent is added to the test liquid or if the effect of the scale inhibiting and fouling preventing agent as added thereto is not satisfactory, the iron component as existing in the test liquid shall be precipitated in the form of iron oxide hydrate or iron hydroxide. Therefore, the effect of the scale inhibiting and fouling preventing agent as added to the test liquid for dispersing the iron oxide or iron hydroxide precipitate formed in the test liquid can be evaluated from the data of the dissolved iron content of the supernatant separated from the test liquid to which the agent was added.

The scale inhibiting and fouling preventing agent of the present invention comprising an isoprenesulfonic acid/acrylic acid/acrylamido 2 methylpropanesulfonic acid copolymer, when added to the test liquid in an amount of 5 mg, in terms of the solid content thereof, per liter, inhibited the precipitation of iron of 10 mg/liter, while acting to completely disperse and keep it in water in the test liquid. As opposed to this, however, when the comparative agent comprising an isoprenesulfonic acid/acrylic acid copolymer was added to the same test liquid in an amount of 5 mg, in terms of the solid content thereof, per liter, it could not inhibit the precipitation of iron of 10 mg/liter. In order to inhibit the

precipitation of iron of 10 mg/liter in the test liquid, it was necessary to add 7.5 mg/liter, in terms of the solid content, of the comparative agent to the test liquid. Regarding the other comparative agents comprising sodium hexametaphosphate or sodium polyacrylate of the prior art, they could not inhibit the precipitation of iron of 10 mg/liter in the test liquid even when they were added to the test liquid in an amount of 10 mg, in terms of the solid content, per liter. From these, it is understood that the scale inhibiting and fouling preventing agent of the present invention has a much more excellent effect for dispersing iron oxide and iron hydroxide in water than the comparative agents comprising sodium hexametaphosphate or sodium polyacrylate.

Examples 19 and 20, Comparative Example 41:

Scaling and Corrosion Tests in Pilot Plant of Open Recirculating, Cooling water System (Cooling Tower) - Part 1:

Using a pilot plant as shown in Fig. 1, the water-treating agent of the present invention was tested with respect to its preventing effect against scaling and corrosion therein. The test period was 23 days.

The water balance in the cooling system is shown in Table 9. The quality of make up water as supplied to the system and that of the cooling water as circulating therein

are shown in Table 10. The operational conditions for the heat exchangers used herein are shown in Table 11. The chemicals used herein and their concentrations are shown in Table 12.

Table 9 - Water Balance in Cooling System

Amount of Cooling Water (liter/hr)	810
Evaporation Loss (liter/hr)	6
Total Amount of Blow Water (liter/hr)	1.5
Amount of Make-up Water (liter/hr)	7.5
Cycles of Concentration(*1)	5.0
Supply Water Temperature (_C)	40
Return Water Temperature (_C)	47
Holding Water Volume (liter)	95
Retention Time(*2) (hr)	63

(*1) Cycles of COncentration

= (amount of water make-up water, liter/hr)/(amount
of total blowdown, liter/hr)

(*2) Retention Time (hr)

= (holding water volume of system, liter)/(amount
of total blowdown, liter/hr)

Table 10 - Quality of Make-up Water and Quality of Cooling Water

	Make-up water	Cooling Water
pH	7.5-7.9	8.9-9.2
Electrical conductivity ($\mu\text{S}/\text{cm}$)	297-352	1,483-1,760
Total Hardness (mg $\text{CaCO}_3/\text{liter}$)	91-120	455-598
Calcium Hardness (mg $\text{CaCO}_3/\text{liter}$)	70-92	350-460
Magnesium Hardness (mg $\text{CaCO}_3/\text{liter}$)	21-28	105-138
M-alkalinity (mg $\text{CaCO}_3/\text{liter}$)	75-80	375-400
Chloride Ion (mg/liter)	38-46	190-230
Sulfate Ion (mg/liter)	16-22	80-110
Silica (mg $\text{SiO}_2/\text{liter}$)	29-37	146-184

Table 11 - Operational Conditions of Heat Exchangers

Temperature of Water ($^{\circ}\text{C}$)	Inlet of Heat Exchanger Part No. 1 (H/E 1)	40
	Outlet of Heat Exchanger Part No. 4 (H/E 4)	47
Skin Temperature of Heat Exchanger Tube (at outlet of H/E 4) ($^{\circ}\text{C}$)		70
Water Flow Velocity in Heat Exchanger (m/s)		0.6
Heat Flux ($\text{kcal}/\text{m}^2\cdot\text{h}$)		39,000
Material of Heat Exchanger Tubes		Carbon Steel

Table 12 - Chemicals Used

		Example 19	Example 20	Comparative Example 41
Corrosion Inhibitor (mg/liter)	HEDP(*3)	4.0	4.0	4.0
	BT(*4)	0.5	0.5	0.5
Scale inhibiting Agent (mg solid/-liter)	IPS/AA/AMPS(*5)	11.0	-	-
	IPS/AA/HEMA(*6)	-	11.0	-
	IPS/AA(*7)	-	-	11.0

(*3): 2-hydroxyethylidene-diphosphonic Acid

(*4): Benzotriazole

(*5): Isoprenesulfonic acid (IPS)/Acrylic acid (AA)/Acrylamido-2-methylpropanesulfonic acid (AMPS) Copolymer having a molar ratio, IPS/AA/AMPS of 15/75/10 and a molecular weight of 15,000

(*6): IPS/AA/2-Hydroxyethyl methacrylate (HEMA) Copolymer having a molar ratio, IPS/AA/HEMA of 20/70/10 and a molecular weight of 13,000

(*7): IPS/AA Copolymer having a molar ratio, IPS/AA of 25/75 and a molecular weight of 16,000

The corrosion rate of the test electrodes as installed at the inlet of the heat exchanger No. 1 (H/E 1) and at the outlet of the heat exchanger No. 4 (H/E 4) was measured, using a corrosion monitor (Corrosion Monitor 500C Model, produced by Toho Giken KK) in accordance with a linear polarization method. The results obtained are shown in Table 13. The scaling rate on the heat transfer tube of each heat exchanger was measured and shown in Table 14.

Table 13 - Results of Corrosion Test

Installation of Electrode	Material of Electrode	Rate of Corrosion (mg/dm ² ·day)		
		Example 19	Example 20	Comparative Example 41
Inlet of H/E 1 (temperature of water: 40_C)	Carbon Steel	5.5	4.0	6.4
	Copper	0.5	0.5	0.8
Outlet of H/E 4 (temperature of water: 47_C)	Carbon Steel	7.4	6.3	10.1
	Copper	0.8	0.4	1.2

Table 14 - Results of Scaling Test

Heat Exchanger	Scaling Rate (mg/cm ² ·month)		
	Example 19	Example 20	Comparative Example 41
H/E 1 (temperature of water at inlet: 40 C)	0.9	1.1	3.4
H/E 2	0.9	1.1	3.5
H/E 3	2.0	1.0	8.9
H/E 4 (temperature of water at outlet: 47 C)	2.6	1.8	12.7

As is obvious from the test results mentioned above, the compositions of the present invention of Examples 19 and 20 are superior to the comparative composition of Comparative Example 41 as being more effective against the corrosion of carbon steel and copper and against the scaling of heat transfer tubes in the heat exchangers than the latter.

The scale formed in this experiment consisted essentially of magnesium silicate of 65 % of all the components constituting it in Comparative Example 41, while the magnesium silicate content of the scale formed in Example 19 was 35 % and that of the scale formed in Example

20 was 25 %. It is obvious from these that the effect of the compositions of the present invention against the formation of silica scale is higher than that of the comparative composition.

Accordingly, it is obvious from these data that the scale inhibiting and fouling preventing agent of the present invention, which is obtained by introducing a third component of acrylamido 2 methylpropanesulfonic acid and/or 2-hydroxyethyl methacrylate into an isoprenesulfonic acid-acrylic acid copolymer, exhibits a higher effect against corrosion and scaling in water systems, when combined with a corrosion inhibitor, than an isoprenesulfonic acid acrylic acid copolymer.

Example 21, Comparative Example 42:

Scaling and Corrosion Tests in the Pilot Plant of Open Recirculating, Cooling-water System (Cooling Tower) - Part 2:

Using the same pilot plant under the same operational conditions as in Examples 19 and 20 but varying the quality of water to be supplied into the plant, the water treating agent of the present invention was tested with respect to its effect against scaling and corrosion therein. The test period was 23 days. The water balance in the cooling system was the same as that in Table 9. The operational

conditions employed herein for the heat exchanger were the same as those in Table 11.

The quality of water as supplied to the system and that of the cooling water as circulating therein are shown in Table 15. The chemicals used herein and their concentrations are shown in Table 16.

Table 15 - Quality of Make-up Water and Quality of Cooling Water

	Make-up Water	Cooling Water
pH	7.3-7.6	8.3-8.7
Electrical conductivity ($\mu\text{S}/\text{cm}$)	172-192	810-1,016
Total Hardness (mg $\text{CaCO}_3/\text{liter}$)	42-58	196-305
Calcium Hardness (mg $\text{CaCO}_3/\text{liter}$)	35-46	163-245
Magnesium Hardness (mg $\text{CaCO}_3/\text{liter}$)	7-12	33-60
M-alkalinity (mg $\text{CaCO}_3/\text{liter}$)	37-41	158-215
Chloride Ion (mg/liter)	29-32	134-167
Sulfate Ion (mg/liter)	17-19	74-95
Silica (mg $\text{SiO}_2/\text{liter}$)	9-11	40-60

Table 16 - Chemicals Used

		Example 21	Comparative Example 42
Corrosion Inhibitor (mg/liter)	SHP(*8)	3.0	3.0
	NaH ₂ PO ₄	1.5	1.5
	PBTC(*9)	3.0	3.0
	ZnCl ₂	6.0	6.0
	TT(*10)	0.5	0.5
Scale inhibiting Agent (mg solid/- liter)	IPS/AA/HEM A(*11)	12.0	-
	IPS/AA(*12)	-	12.0

(*8): Sodium Hexametaphosphate

(*9): Phosphonobutane-tricarboxylic Acid

(*10): Tolyltriazole

(*11): Same as (*6) in Table 12

(*12): Same as (*7) in Table 12

In the same manner as in Example 19, The rate corrosion of the test electrodes and the scaling rate of the heat-transfer tubes were measured. The data obtained are shown in Tables 17 and 18.

Table 17 - Results of Corrosion Test

Installation of Electrode	Material of Electrode	Corrosion Rate (mg/dm ² ·day)	
		Example 21	Comparative Example 42
Inlet of H/E 1 (temperature of water: 40_C)	Carbon Steel	1.6	5.8
	Copper	0.3	0.4
Outlet of H/E 4 (temperature of water: 47_C)	Carbon Steel	1.7	7.2
	Copper	0.2	0.5

Table 18 - Results of Scaling Test

Heat Exchanger	Scaling Rate (mg/cm ² ·month)	
	Example 21	Comparative Example 42
H/E 1 (temperature of water at inlet: 40 C)	1.0	3.5
H/E 2	1.0	3.3
H/E 3	1.1	7.2
H/E 4 (temperature of water at outlet: 47 C)	1.5	8.1

As in Examples 19 and 20, the scale inhibiting and fouling preventing agent of the present invention exhibited a higher effect against corrosion and scaling in the water system tested herein, when combined with a corrosion

inhibitor, than the comparative, isoprenesulfonic acid-acrylic acid copolymer.

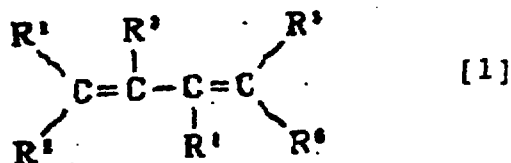
As has been described in detail and demonstrated concretely hereinabove, the water treating agent of the present invention, comprising a conjugated dienesulfonic acid/(meth)acrylic acid/2-hydroxyethyl (meth)acrylate copolymer or comprising a conjugated dienesulfonic acid/(meth)acrylic acid/(meth)acrylamido-2-methylalkanesulfonic acid copolymer exhibits an excellent anti scaling and anti fouling effect in water systems and can therefore prevent water systems from being disordered by thermal efficiency depression and water flow rate depression to be caused by adhesion or deposition of scale, sludge and slime onto heat exchangers, heat transfer heating pipes and pipe lines that constitute water systems.

While the invention has been described in detail and with reference to specific embodiments thereof, it will be apparent to one skilled in the art that various changes and modifications can be made therein without departing from the spirit and scope thereof.



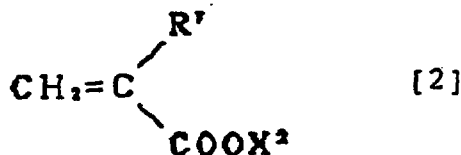
WHAT IS CLAIMED IS:

1. A water treating agent comprising a ternary copolymer which is synthesized from a conjugated dienesulfonic acid and/or its salt of the following general formula [1]:



wherein R^1 , R^2 , R^3 , R^4 , R^5 and R^6 each represent a hydrogen atom, a methyl group or $-SO_3X^1$, provided that one or more of R^1 to R^6 are methyl groups, one or more of the remaining R^1 to R^6 are groups of $-SO_3X^1$, and X^1 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group;

a (meth)acrylic acid and/or its salts of the following general formula [2]:



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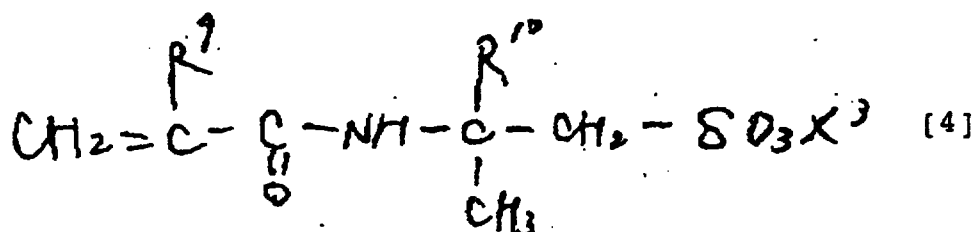
wherein R^7 represents a hydrogen atom or a methyl group; and X^2 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group;

and a 2 hydroxyethyl (meth)acrylate of the following general formula [3]:



wherein R^8 represents a hydrogen atom or a methyl group,

or a (meth)acrylamido 2 methylalkanesulfonic acid and/or its salt of the following general formula [4]:



wherein R^9 and R^{10} each represent a hydrogen atom or a methyl group; and X^3 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group.

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2. The water treating agent as claimed in claim 1, wherein the ternary copolymer comprises from 5 to 50 mol% of the unit derived from the conjugated dienesulfonic acid and/or its salt, from 40 to 90 mol% of the unit derived from the (meth)acrylic acid and/or its salt, and from 1 to 20 mol% of the unit derived from the 2 hydroxyethyl (meth)acrylate.

3. The water treating agent as claimed in claim 1, wherein the ternary copolymer comprises from 5 to 50 mol% of the unit derived from the conjugated dienesulfonic acid and/or its salt, from 40 to 90 mol% of the unit derived from the (meth)acrylic acid and/or its salt, and from 1 to 20 mol% of the unit derived from the (meth)acrylamido 2 methylalkanesulfonic acid and/or its salt.

4. The water treating agent as claimed in any one of claims 1 to 3, wherein the ternary copolymer has a weight-average molecular weight of from 500 to 300,000.

5. The water treating agent as claimed in claim 1, which further comprises a metal corrosion inhibitor.

6. The water treating agent as claimed in claim 5, wherein the metal corrosion inhibitor comprises at least one selected from the group consisting of polyvalent metal salts, phosphonates, azoles, phosphates, polyphosphates, phosphonocarboxylates, amines and phosphoric esters.

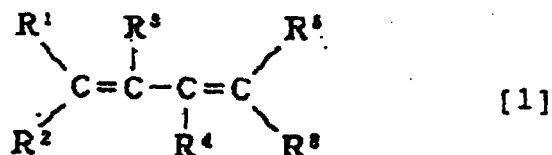
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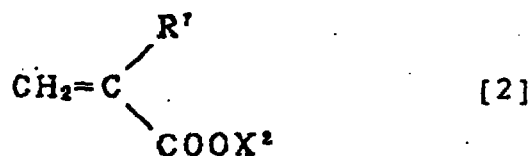


7. A method for treating water, comprising adding to water systems a water treating agent that comprises a ternary copolymer as synthesized from a conjugated dienesulfonic acid and/or its salt of the following general formula [1]:



wherein R^1 , R^2 , R^3 , R^4 , R^5 and R^6 each represent a hydrogen atom, a methyl group or $-\text{SO}_3\text{X}^1$, provided that one or more of R^1 to R^6 are methyl groups, one or more of the remaining R^1 to R^6 are groups of $-\text{SO}_3\text{X}^1$, and X^1 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group;

a (meth)acrylic acid and/or its salts of the following general formula [2]:



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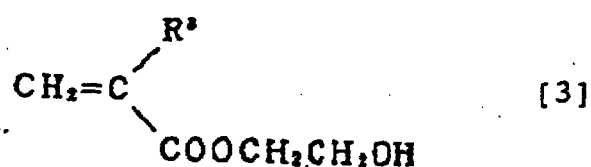
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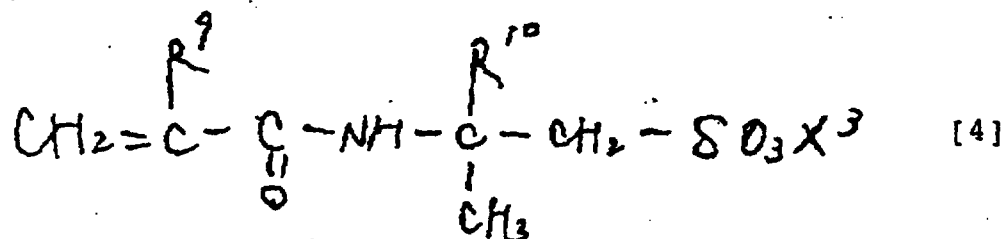
wherein R^7 represents a hydrogen atom or a methyl group; and X^2 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group;

and a 2 hydroxyethyl (meth)acrylate of the following general formula [3]:



wherein R^8 represents a hydrogen atom or a methyl group,

or a (meth)acrylamido 2 methylalkanesulfonic acid and/or its salt of the following general formula [4]:



wherein R^9 and R^{10} each represent a hydrogen atom or a methyl group; and X^3 represents a hydrogen atom, a monovalent metal, or an ammonium group unsubstituted or mono substituted by an organic group,

in an amount of from 0.1 to 1000 mg/liter.

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8. The method for treating water as claimed in claim 7, wherein the ternary copolymer to be in the water-treating agent comprises from 5 to 50 mol% of the unit derived from the conjugated dienesulfonic acid and/or its salt, from 40 to 90 mol% of the unit derived from the (meth)acrylic acid and/or its salt, and from 1 to 20 mol% of the unit derived from the 2 hydroxyethyl (meth)acrylate.

9. The method for treating water as claimed in claim 7, wherein the ternary copolymer to be in the water-treating agent comprises from 5 to 50 mol% of the unit derived from the conjugated dienesulfonic acid and/or its salt, from 40 to 90 mol% of the unit derived from the (meth)acrylic acid and/or its salt, and from 1 to 20 mol% of the unit derived from the (meth)acrylamido-2-methylalkanesulfonic acid and/or its salt.

10. The method for treating water as claimed in any one of claims 7 to 9, wherein the ternary copolymer to be in the water treating agent has a weight average molecular weight of from 500 to 300,000.

11. The method for treating water as claimed in claim 7, wherein the water treating agent further comprises a metal corrosion inhibitor in addition to the ternary copolymer.

12. The method for treating water as claimed in claim 11, wherein the metal corrosion inhibitor comprises at





101

least one selected from the group consisting of polyvalent metal salts, phosphonates, azoles, phosphates, polyphosphates, phosphonocarboxylates, amines and phosphoric esters.

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