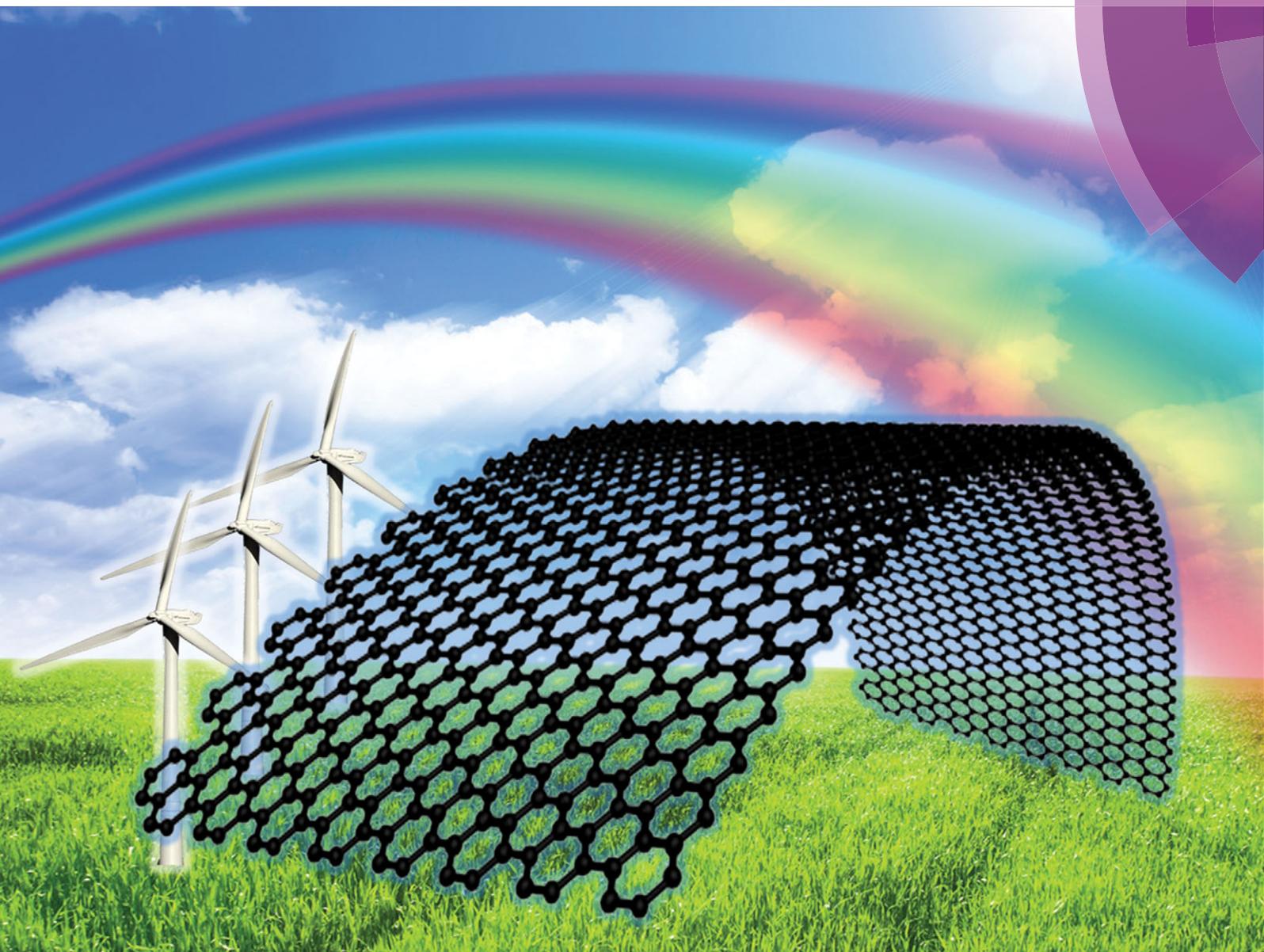


# ChemComm

Chemical Communications

[www.rsc.org/chemcomm](http://www.rsc.org/chemcomm)



ISSN 1359-7345



FEATURE ARTICLE

Yi-Jun Xu, Mario Pagliaro *et al.*

Commercialization of graphene-based technologies: a critical insight



Cite this: *Chem. Commun.*, 2015, 51, 7090

## Commercialization of graphene-based technologies: a critical insight

Rosaria Ciriminna,<sup>a</sup> Nan Zhang,<sup>b</sup> Min-Quan Yang,<sup>b</sup> Francesco Meneguzzo,<sup>c</sup> Yi-Jun Xu\*<sup>b</sup> and Mario Pagliaro\*<sup>a</sup>

Carbon in its single layer atomic morphology has exceptional thermal, optical, electronic and mechanical properties, which may form the basis for several functional products and enhanced technologies that go from electricity storage to polymer nanocomposites of so far unsurpassed characteristics. Due to the high cost, however, the current global production of graphene does not exceed 120 tonnes. New chemical and physical methods to exfoliate graphite, however, were recently engineered and commercialized, which open the route to massive adoption of graphene as the “enabler” of numerous important technologies, including enhanced electricity storage. This feature article presents an updated, critical overview that will be useful to nanochemistry and nanotechnology research practitioners and to entrepreneurs in advanced materials.

Received 14th February 2015,  
Accepted 5th March 2015

DOI: 10.1039/c5cc01411e

www.rsc.org/chemcomm

### Introduction

Keeping in mind the fullerene and carbon nanotube (CNT) research boom in the 1990s and early 2000s,<sup>1</sup> graphene has become the favorite research topic in materials chemistry and nanotechnology. Since 2004, when Geim, Novoselov and co-workers reported the use of adhesive tape to exfoliate graphite to obtain graphene, and characterized it as a single ultrathin (0.3 nm) layer of carbon atoms arranged in two-dimension in a honeycomb lattice,<sup>2</sup> about 10 000 research articles have appeared in the scientific literature (Fig. 1).<sup>3</sup>

Graphene has 50 times the mechanical strength of steel but half the density of aluminum. Furthermore it is optically transparent and flexible. These unique properties (Table 1) derive from its unique two-dimensional atomic morphology and electronic structure,<sup>4</sup> and make of graphene an “enabling technology” with which to develop functional products in several areas of application.<sup>5</sup> Indeed, more than 10 000 patents have been granted to graphene-related technologies in just a decade,<sup>6</sup> since the inception of the mechanical exfoliation technique.

Small graphene sheets and large area graphene films are already manufactured on a small industrial scale in several countries (in Europe, in the US and in Asia). The market, however, is industrially not yet significant, with \$12 million annual

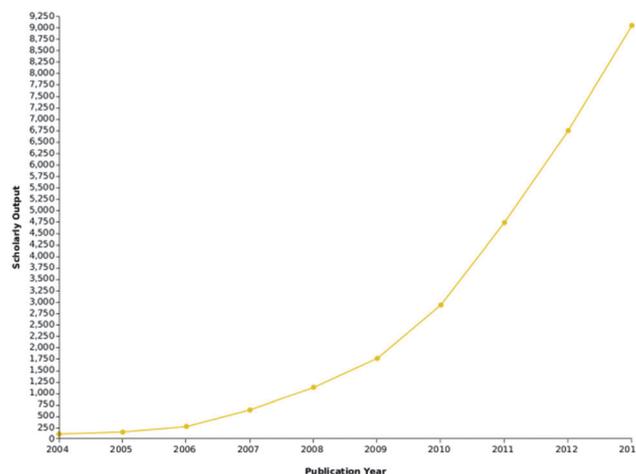


Fig. 1 Scholarly output (articles only) published in the period 2004–2013 from a search for “graphene” in the titles, abstracts or keywords. [Reproduced from ref. 3, with kind permission.]

sales reported in 2013, and global production not exceeding 120 tonnes.<sup>6</sup> For comparison, production of carbon nanotubes, made of single- or multi-wall graphene cylinders, in 2011 amounted to 4000 tonnes.<sup>16</sup>

As commercialization of graphene-based products seems to be “within reach in a range of areas”,<sup>17</sup> a critical insight into graphene-based technologies seems timely and useful for a balanced evaluation of the market potential of this unique material, especially considering that graphene might play a groundbreaking role in the purposeful storage, and also in the efficient utilization of clean electricity obtained from sun

<sup>a</sup> Istituto per lo Studio dei Materiali Nanostrutturati, CNR, via U. La Malfa 153, 90146 Palermo, Italy. E-mail: mario.pagliaro@cnr.it

<sup>b</sup> State Key Laboratory of Photocatalysis on Energy and Environment, College of Chemistry, Fuzhou University, Fuzhou 350002, P. R. China. E-mail: yjxu@fzu.edu.cn

<sup>c</sup> Istituto di Biometeorologia, CNR, via Caproni 8, 50145 Firenze, Italy

**Table 1** Unique properties of graphene (adapted from ref. 7, with kind permission)

Property	Ref.
High electronic mobility ( $2.5 \times 10^5 \text{ cm}^2 \text{ V}^{-1} \text{ s}^{-1}$ at room temperature)	8
High thermal conductivity ( $> 3000 \text{ W m K}^{-1}$ )	9
High capability to sustain high electric current densities (106 times higher than copper)	10
High specific surface area ( $2360 \text{ m}^2 \text{ g}^{-1}$ of a single graphene sheet)	11
Extraordinary tensile elasticity ( $\sim 1 \text{ TPa}$ )	12
High intrinsic strength ( $\sim 130 \text{ GP}$ )	13
Complete impermeability to any gases	14
Optical transmittance ( $\sim 97.7\%$ )	15

and wind,<sup>18</sup> namely the most important technical need for solving the daily and seasonal local intermittency of solar radiation and wind availability.

The second relevant aspect is that since about 2008 chemists have started to apply different methods to the synthesis of graphene materials and their derivatives by the nanochemistry bottom-up approach praised by Ozin toward different applications.<sup>19</sup> For example, in the context of artificial photocatalysis with graphene–semiconductor composites, chemists are learning to optimize the individual components and interfacial synergy in the composite in terms of size, shape, morphology and electronic conductivity so as to improve the electron transfer pathway, and attempt to make artificial photosynthesis of chemicals and fuels a reality.<sup>20</sup>

Progress in the field is so rapid that reviews covering the state of the art of graphene chemistry or nanochemistry are at a risk to become obsolete a few months after publication. Recent progress, for example, includes the proof of concept of proton-conducting graphene membranes (though decorated with Pt nanoparticles).<sup>21</sup>

The aim of this work is not to provide a comprehensive review of existing graphene nanochemistry or graphene-based technologies, but rather to articulate a critical insight into commercialization of graphene-based technology applications written after a decade of strenuous research and entrepreneurial efforts. That such an insight might be timely is perhaps illustrated by the recent findings of Kamat and co-workers, who reported that reduced graphene oxide (RGO), widely proposed as a support for nanostructured catalyst particles such as  $\text{TiO}_2$  for photocatalytic degradation of pollutants, is vulnerable toward hydroxyl radical attack in an aqueous phase when the interfacial contact is very poor for RGO– $\text{TiO}_2$  composite photocatalysts.<sup>22</sup>

At least in Europe, no other materials science technology has received public funding of similar entity. For example, in 2013, the European Union launched a 1 billion € fund supporting research projects across Europe (the Graphene Flagship)<sup>23</sup> targeting the future applications of graphene. Similarly, the United Kingdom Government and the European Union have financed £70 million for the creation of a National Graphene Institute in the city where the material was first isolated (Manchester).<sup>24</sup>

In this study, we offer a perspective view according to which we believe that numerous applications of graphene, relying on

the ability to transfer its exceptional properties into functional materials of enhanced characteristics, will rapidly follow the recent development of low-cost graphite exfoliation chemical routes.

## Enabling graphene: the new graphite exfoliation routes

In 2013, one of the world's largest chemical company exited the carbon nanotube business as “*the potential areas of application that once seemed promising from a technical standpoint are currently either very fragmented or have few overlaps with the company's core products*”.<sup>25</sup>

“*There is feeling*”, a leading graphene industry practitioner commented at the end of 2014, “*that graphene is following in the footsteps of carbon nanotubes, which were hugely hyped in their early days too, with small incremental market share across multiple market segments*”.<sup>26</sup>

Echoing these arguments, Banks and co-workers questioned whether or not graphene research should be attracting the large funding it is receiving, considering that carbon nanotubes did not yield many significant improvements in commercial technologies.<sup>27</sup> So far, indeed, CNTs have found use in new water filters, car parts, and sporting goods, which stride with huge expectations of a class of materials, widely explored since the publication<sup>28</sup> of Iijima in 1991, originally proposed to revolutionize electronics.<sup>29</sup>

Yet, we argue in the following, the story of graphene-based technologies will be different, even though graphene currently continues to cost \$100 to \$1000 a gram (depending on defects density crystal size and other quality parameters).<sup>30</sup>

Following the first decade of applied research largely financed by Governments worldwide, significant progress towards innovative graphite exfoliation methods for manufacturing high amounts of quality (defect-free) graphene layers of large surface areas has been achieved.<sup>6</sup>

Companies manufacturing graphene according to the reported rapidly evolving methods include (to mention but a few) Applied Graphene Materials, Graphoid, Incubation Alliance, Directa Plus, XG Sciences, Graphene Technologies, Graphene Frontiers, Graphenea, Haydale, Angstrom, Graphensic, CVD Equipment Corporation, Graphene Supermarket and Graphene Square. In China only, the graphene industry was recently reported<sup>31</sup> to have an annual production capacity of small graphene sheets and large graphene films exceeding, respectively, 400 tonnes and  $110\,000 \text{ m}^2$ .

Chemical vapor deposition of precursor gases, requiring high temperature (*ca.*  $1000 \text{ }^\circ\text{C}$ ) and complicated transfer processes, or high-temperature epitaxial growth under strictly controlled conditions, is no longer the unique method to afford graphene layers of high quality. Similarly, the multi-step solution-based method consisting of reduction with hazardous hydrazine of graphene oxide (GO) obtained *via* oxidation of graphite with harsh oxidants such as  $\text{KMnO}_4$  in the presence of  $\text{H}_2\text{SO}_4$ , and exfoliation of GO by sonication in a solvent is no longer the only solution-based route to achieve the production of graphene micron-sized single layers (up to  $20 \times 40 \text{ }\mu\text{m}$  in 2009).<sup>32</sup>

In 2014, the solution-based route based on exfoliation of graphite in the liquid phase affording large platelets of pristine graphene was dramatically improved by Coleman and coworkers in Ireland, who developed a simple shear exfoliation of graphite in solution in the presence of a surfactant,<sup>33</sup> which goes much beyond the previously reported exfoliation route in organic solvents such as *N*-methylpyrrolidone whose surface energies match that of graphene.<sup>34</sup> It is enough to stir (with a 400 Watt blender) a suspension of graphite powder (20–50 g) in water (500 mL) containing the liquid surfactant (10–25 mL), to obtain a large number of micrometer-sized graphene flakes suspended in water in 10–30 minutes.

The first commercial shipment of graphene nanoplatelets under the trade name *Elicarb* manufactured in a pilot line affording 1 kg of product per day at chemical company Thomas Swan started in the second half of 2014.<sup>35</sup>

Almost concomitantly, Canada's Ontario Grafoid opened its first production facility where high-purity *MesoGraf* graphene is produced electrochemically using a one-step chemical exfoliation process starting from unprocessed graphite ore extracted in Québec.<sup>36</sup> Developed in 2011 by Loh and co-workers at the National University of Singapore, the elegant electrolytic process uses the graphite ore as the electrode. A voltage is applied to an electrolytic cell whose electrolyte includes, along with ions, intercalating organic compounds that are driven by the applied current into the interlayer spacings between the atomic interlayers of graphite, affording graphene stacked in two or three layers (multilayer graphene).

Another uniquely efficient process, developed by Mercuri,<sup>37</sup> starts from graphite which is thermally elongated and then exfoliated by the so called "G+" process affording a broad range of products from expanded graphite to fully exfoliated graphene nanoplatelets, each with its market value. The technology involves chemical intercalation of graphite, followed by its thermal expansion through a plasma at a temperature >6000 °C. Finally, the expanded graphite is exfoliated in the liquid phase.

Since mid 2014, the technology is used by the Italian company Directa Plus to manufacture graphene sheets at 30 tonnes per year production. The continuous industrial process is so efficient that the company offers a range of products at €50–500 per kg (depending on the product: from super-expanded graphite to highly concentrated water-based pastes of graphene nanoplatelets).<sup>38</sup>

## Emerging applications

Now that low cost chemical routes to produce graphene have become available, applications will rapidly follow. For example, graphene-based supercapacitors are ready to be commercialized in flexible electronics like roll-up displays, TV sets, e-paper and even wearable electronics.<sup>39</sup>

Here we focus on three important technologies, namely cost-effective electricity storage, polymer nanocomposites and environmental remediation.

### Graphene in electricity storage and utilization

Electricity is the most versatile and relevant energy form available (whether powering a cell phone or an electric vehicle,

electron has become "the ultimate currency of modern industrial societies").<sup>40</sup>

In today's electricity "second coming-of-age"<sup>41</sup> scenario, batteries of lower cost, lighter and capable of recharging more rapidly are in urgent demand. Similarly, fuel cells of lower cost – using H<sub>2</sub> fuel easily generated by water electrolysis<sup>42</sup> using today's low cost renewable electricity – remain to be developed and commercialized.

The development of enhanced electricity storage technologies is an urgent global need for the potentially huge economic and environmental impact. Indeed, along with dramatic cost reduction, both developed and developing countries are massively adopting solar photovoltaic (PV) and wind energy to produce huge amounts of electricity. For comparison, the installed solar PV capacity that reached 137 GW in 2013 was less than 1 GW in 2003.<sup>43</sup> In 2014 only another 45 GW were added worldwide;<sup>44</sup> and (in the conservative case) at least 60 GW will be installed in the course of 2015.<sup>45</sup>

Immense wind and solar "parks" comprising several hundreds of MW are built and connected to the grid, replacing power originating from thermoelectric power units. Notably, most of this power is installed without incentives, but rather through 20-year power purchase agreements in which a single photovoltaic kWh is sold, for example, at less than 7 c€, such as in the recent public tender of Brazil's Bahia State.<sup>46</sup>

Batteries, electrolyzers and fuel cells are the three main electrochemical energy technologies. All have in common the use of electrodes, many of which are comprised of graphite. Indeed, thanks to its good electrical and thermal conductivity, refractoriness and resistance to acids, the hexagonal layered mineral graphite is widely used since decades to make electrodes in batteries, hydrogen fuel cells, and electrolyzers.

Graphene, with its extraordinary strength, enhanced electron conductivity (10 times more conductive than graphite), lightness, flexibility and ease of chemical processability, is the ideal material which is used to functionalize and enhance a conventional electrode. The use of highly conductive graphene to produce both anodes and cathodes has already led to breakthrough progress, at least on a laboratory scale;<sup>47</sup> even though researchers recently reviewing the field first concluded that "it is not yet clear whether graphene could really lead to progress in the field";<sup>48</sup> to later convene that in energy storage applications "cost-effective production of graphene related materials on an industrial scale is needed to create the future energy value chain".<sup>49</sup>

The first major advance was reported in 2011 by Kung and co-workers who made a Li-ion battery whose anode consisting of multiple graphene sheets is able to store ten times more power (30 000 mA h instead of 3000) with a tenfold increase in charging speed (15 minutes instead of 2 h), five times more effective after 150 charge–discharge cycles than the state of the art Li-ion battery.<sup>50</sup> In detail, the team created tiny (10–20 nm) nanoholes in graphene sheets allowing for Li<sup>+</sup> ions to pass through, and introduced Si nanocrystals between each layer of graphene, capable of holding four Li<sup>+</sup> ions.

In the complementary approach explored by Yang and co-workers, the nanostructured cathode leads to a battery,

capable of recharging in 20 seconds and retaining more than 90 percent of its capacity even after 1000 cycles of use.<sup>51</sup> In detail, graphene is mixed with vanadium oxide by heating inexpensive vanadium pentoxide together with graphene oxide (GO) nanosheets in water. Single-crystalline VO<sub>2</sub>-graphene nanoribbons for the cathode spontaneously form which serve as cathodes for ultrafast Li storage.

In Quebec, the researchers of Hydro-Quebec used the high-density graphene composition of *MesoGraf* to form a graphene-coated lithium iron phosphate (LFP) cathode in batteries for enhanced performance in terms of power, energy density, and extended life. Multiple patents have been filed for graphene LFP batteries, addressing electric vehicle batteries and portable energy storage.<sup>52</sup> Being already manufactured on an industrial scale, batteries using lithium iron phosphate as the cathode material are capable of delivering current top values in terms of high power and energy density.

### Graphene-polymer nanocomposites

In 2008, Brinson and co-workers reported that the polymer nanocomposite comprising the polymer functionalized with ultralow loadings of nanometre graphene sheets provides remarkable improvement in the thermal and mechanical properties of commodity polymers.<sup>53</sup> To amplify, a large shift in glass transition temperature of over 40 °C was obtained for poly(acrylonitrile) at 1 wt% graphene load, and an improvement of nearly 30 °C with only 0.05 wt% load in poly(methyl methacrylate).

Such a large improvement at similar low loadings is also due to the huge interfacial area between the graphene nanofiller and the polymer. Furthermore, as put by Macosko,<sup>54</sup> graphene provides a combination of the benefits achieved with carbon nanotubes (electrical and thermal conductivity) and layered silicates (gas permeation barrier and stiffness).

Researchers at Hyundai and Kia, two car manufacturing companies, developed the use of graphene nanoparticles for stabilizing the low cost polymeric proton exchange membrane (PEM) separating the electrodes in high power density PEM fuel cells.<sup>55</sup> With a graphene nanoparticle content between 0.1 and 10 wt%, the sulfonated poly(phenylene) and poly(ether ether ketone) employed to develop inexpensive membranes do not suffer any longer from mechanical damage due to large dimensional changes caused by water gain and loss during fuel cell operation (the ability to maintain the dynamic balance of water in the membrane-electrode in order to achieve appropriate membrane hydration is a critical issue affecting both performance and durability of the fuel cell; while the proton conduction ability relies on the “hopping” of protons *via* the -SO<sub>3</sub>H groups in the presence of water).

Graphene, furthermore, helps to retain the flexibility, and improves the thermal resistance of the nanocomposite membrane due to its higher glass transition temperature.

To understand the relevance of these findings, it should be kept in mind that PEMFCs are the most successful fuel cell technology with several thousand units installed worldwide.<sup>56</sup> Motor vehicles including automobiles, buses, trucks, boats and even aircraft<sup>57</sup> powered by PEMFC running on hydrogen fuel have already been built and tested for millions of kilometers

with excellent technical performance, but poor economy due to the high cost.

Such high cost stems from two components. One is the cost of Pt nanoparticles used as the catalyst for the oxygen reduction reaction, and the other derives from the extremely expensive perfluorosulfonic acid fluorinated polymer under the trade name “Nafion” used to make the proton exchange membrane in commercial PEMFCs.

At ultralow loadings, graphene nanoplatelets are able to confer excellent mechanical reinforcement. At higher concentrations, the same nanostructures provide electrical and thermal conductivity, infrared and electromagnetic shielding, and improved rheological and gas barrier properties (anti-corrosive and flame-retardancy). As economically viable graphene becomes increasingly available, the areas for applications of graphene polymer nanocomposites extend from aerospace and automotive industries to medical and consumer products of enhanced mechanical, anti-static and barrier properties, improved dimensional stability, higher resistance to micro-cracking, and extended product life.<sup>58</sup>

### Graphene in environmental remediation

Being hydrophobic and strongly lipophilic, and with a uniquely high surface area (>2300 m<sup>2</sup> g<sup>-1</sup>), graphene has exceptional capacity to adsorb organic molecules that can be exploited to purify air, soil and water contaminated with organic pollutants. Not only is 1 g of graphene obtained *via* plasma-exfoliated graphite able to adsorb up to 90 g of fuel oil<sup>59</sup> (four times higher capacity than the best performing current commercial adsorbent, *Green Oil*), but graphene also acts as a chemical sponge capable of rapidly adsorbing and concentrating organic molecules at its surface, and removing it from the environmental matrix.

Finally, the adsorbed oils can be removed with a solvent or even by mechanical squeezing and the adsorbent recycled, saving all or most of the oil adsorbed, will no longer be burned under controlled conditions.<sup>60</sup> No toxic and persistent oil dispersants, such as those used for conventional oil spill remediation, are required.

More recently, the company successfully tested the product inside a Romanian former refinery water basin containing about 16 million Litres of water contaminated with 56 ppm oil hydrocarbons (>1 tonne of oil to be removed; with 5 ppm being the maximum oil concentration acceptable for the discharge of treated water). Eighty kilograms of graphene-based product (5 g m<sup>-3</sup>) were able to bring the hydrocarbon concentration down to 1 ppm in only 10 minutes of contact with the contaminated water. Low cost graphene has clearly enormous potential in removing different types of pollutants from contaminated water on a global scale, especially considering that pristine graphene nanoplatelets and the graphene monolayer are biocompatible.<sup>61</sup>

## Outlook and conclusions

Five years after the isolation of graphene *via* physical exfoliation of graphite, trying to identify future directions in which graphene research and applications were likely to develop, Geim, a physicist, was calling attention to the fact that “*despite a cornucopia of*

possible findings and applications, graphene chemistry has so far attracted little interest from professional chemists";<sup>62</sup> adding that "the recent progress in making graphene suspensions has opened up a way to liquid phase chemistry, and, hopefully, the professional help that graphene researchers have long been waiting for is now coming".<sup>58</sup>

Five years later, graphene has become a central topic of chemical research. Research chemists worldwide have developed the chemistry of graphene<sup>63</sup> and graphene oxide,<sup>32</sup> making new graphene-based coatings,<sup>64</sup> photocatalytic composites,<sup>20</sup> electrodes,<sup>47–51</sup> polymer nanocomposites,<sup>53–57</sup> sorbents<sup>59–61</sup> and selective membranes.<sup>65</sup> Even more importantly, chemical ingenuity resulted in the introduction of several new graphite exfoliation methods affording graphene of high crystalline quality, similar to pristine (and prohibitively costly) nanoplatelets synthesized by chemical vapor deposition.

The older multi-step process in the liquid phase involving the oxidation of graphite followed by exfoliation and reduction of graphene oxide has been supplemented by new exfoliation routes, using surfactants, electrolysis, and plasma treatment. All the latter processes have been commercialized, with the recent introduction of low cost graphene-based products priced at €50–100 per kilogram vs. previous 100–1000 \$1000 per gram.

Graphene-based products and devices tailored to specific industrial, biomedical, electronic and optical applications will shortly emerge, amongst which we forecast cost-effective Li ion batteries, PEM fuel cells, and new sorbent materials for environmental remediation.

Many other practical applications will follow in the near future, including the chemical utilization of graphene for constructing graphene-based composites for the exploitation of visible light or sunlight in artificial photosynthesis to make chemicals and solar fuels.<sup>20</sup>

In conclusion, graphene will not remain a laboratory curiosity resulting in the publication of some 40 research papers per day.<sup>27</sup> This, to paraphrase Ozin<sup>19</sup> and Chiu,<sup>66</sup> will also require an educational effort through which materials and chemical synthetic methods of the past are broadened and updated to "embrace a future" that will bring many environmental and economic benefits. Hopefully, this study will encourage such progress.

## Acknowledgements

This article is dedicated to University of Toronto's Professor Geoffrey Alan Ozin for all he did to conceive and advance the concept and the practice of nanochemistry, and for many years of friendship with one of us (M.P.). Professor Yi-Jun Xu acknowledges the financial support from the National Natural Science Foundation of China (U1463204, 21173045, and 20903023).

## References

- 1 D. Lucio-Arias and L. Leydesdorff, *Scientometrics*, 2007, **70**, 603–632.
- 2 K. S. Novoselov, A. K. Geim, S. V. Morozov, D. Jiang, Y. Zhang, S. V. Dubonos, I. V. Grigorieva and A. A. Firsov, *Science*, 2004, **306**, 666–669.
- 3 A. Plume, *Research Trends*, 2014, <http://www.researchtrends.com/issue-38-september-2014/graphene-ten-years-of-the-gold-rush/>, last time accessed, 15 January 2015.
- 4 M. Koshino and T. Ando, Electronic Properties of Monolayer and Multilayer Graphene, in *Physics of Graphene*, ed. H. Aoki and M. S. Dresselhaus, Springer, New York, 2013, pp. 173–208.
- 5 X. Zhou, W. Wang and Z. Liu, Graphene Overview, in *Graphene: Energy Storage and Conversion Applications*, ed. Z. Liu and X. Zhou, CRC Press, Boca Raton, 2014.
- 6 A. Zurutuza and C. Marinelli, *Nat. Nanotechnol.*, 2014, **9**, 730–734.
- 7 L.-J. Wang, L. Li, J. Yu, Y. Wu, H. He, X. Ouyang, X. Zhao, Y.-C. Yen and L. J. Lee, *Carbon*, 2014, **79**, 294–301.
- 8 A. S. Mayorov, R. V. Gorbachev, S. V. Morozov, L. Britnell, R. Jalil and L. A. Ponomarenko, *Nano Lett.*, 2011, **11**, 2396–2399.
- 9 A. A. Balandin, *Nat. Mater.*, 2011, **10**, 569–581.
- 10 J. Moser, A. Barreiro and A. Bachtold, *Appl. Phys. Lett.*, 2007, **91**, 163513.
- 11 Y. Zhu, S. Murali, W. Cai, X. Li, J. W. Suk, J. R. Potts and R. S. Ruoff, *Adv. Mater.*, 2010, **22**, 3906–3924.
- 12 C. Lee, X. Wei, W. J. Kysar and J. Hone, *Science*, 2008, **321**, 385–388.
- 13 F. Liu, P. M. Ming and J. Li, *Phys. Rev. B: Condens. Matter Mater. Phys.*, 2007, **76**, 064720.
- 14 J. S. Bunch, S. S. Verbridge, J. S. Alden, A. M. van der Zande, J. M. Parpia, H. G. Craighead and P. L. McEuen, *Nano Lett.*, 2008, **8**, 2458–2462.
- 15 R. R. Nari, P. Blake, A. N. Grigorenko, K. S. Novoselov, T. J. Booth, T. Stauber and N. M. R. Peres, *Science*, 2008, **320**, 1308.
- 16 M. F. L. De Volder, S. H. Tawfik, R. H. Baughman and A. J. Hart, *Science*, 2013, **339**, 535–539.
- 17 Editorial, *Nat. Nanotechnol.*, 2014, **9**, 725.
- 18 *Graphene: Energy Storage and Conversion Applications*, ed. Z. Liu and X. Zhou, CRC Press, Boca Raton, 2014.
- 19 G. A. Ozin, A. Arsenault and L. Cademartiri, *Nanochemistry: A Chemical Approach to Nanomaterials*, RSC Publishing, Cambridge, 2008.
- 20 (a) M.-Q. Yang, N. Zhang, M. Pagliaro and Y.-J. Xu, *Chem. Soc. Rev.*, 2014, **43**, 8240–8254; (b) N. Zhang, Y. Zhang and Y.-J. Xu, *Nanoscale*, 2012, **4**, 5792–5813; (c) M.-Q. Yang and Y.-J. Xu, *Phys. Chem. Chem. Phys.*, 2013, **15**, 19102–19118.
- 21 S. Hu, M. Lozada-Hidalgo, F. C. Wang, A. Mishchenko, F. Schedin, R. R. Nair, E. W. Hill, D. W. Boukhvalov, M. I. Katsnelson, R. A. W. Dryfe, I. V. Grigorieva, H. A. Wu and A. K. Geim, *Nature*, 2014, **516**, 227–230.
- 22 J. G. Radich, A. L. Krenselewski, J. Zhu and P. V. Kamat, *Chem. Mater.*, 2014, **26**, 4662–4668.
- 23 <http://graphene-flagship.eu>, last time accessed, January 10, 2015.
- 24 <http://gow.epsrc.ac.uk/NGBOVViewGrant.aspx?GrantRef=EP/K005014/1>, last time accessed, January 10, 2015.
- 25 D. Smock, *Bayer Exits Highly Hyped Carbon Nanotubes Business*, 2013, <http://www.themoldingblog.com/2013/05/08/bayer-exits-highly-hyped-carbon-nanotubes-business/>.
- 26 M. Spasenovic, *Khasha Ghaffarzadeh*, Head of Consulting at IDTechEx, 2014, <http://www.graphenetracker.com/khasha-ghaffarzadeh-head-consulting-idtechex/>, last time accessed, March 4, 2015.
- 27 E. P. Randviir, D. A. C. Brownson and C. E. Banks, *Mater. Today*, 2014, **17**, 426–432.
- 28 S. Iijima, *Nature*, 1991, **354**, 56–58.
- 29 P. Ball, *Nature*, 1999, DOI: 10.1038/news991202-1.
- 30 GE Reports, Canada has the raw ingredient for technology's next miracle material, but will we refine it? September 23, 2014, <https://gereports.ca/canada-has-the-raw-ingredient-for-technologys-next-miracle-material-but-will-we-refine-it/>, last time accessed, January 15, 2015.
- 31 W. Ren and H.-M. Cheng, *Nat. Nanotechnol.*, 2014, **9**, 726–730.
- 32 D. R. Dreyer, S. Park, C. W. Bielawski and R. S. Ruoff, *Chem. Soc. Rev.*, 2010, **39**, 228–240.
- 33 K. R. Paton, E. Varrla, C. Backes, R. J. Smith, U. Khan, A. O'Neill, C. Boland, M. Lotya, O. M. Istrate, P. King, T. Higgins, S. Barwich, P. May, P. Puczkarski, I. Ahmed, M. Moebius, H. Pettersson, E. Long, J. Coelho, S. E. O'Brien, E. K. McGuire, B. Mendoza Sanchez, G. S. Duesberg, N. McEvoy, T. J. Pennycook, C. Downing, A. Crossley, V. Nicolosi and J. N. Coleman, *Nat. Mater.*, 2014, **13**, 624–630.
- 34 J. N. Coleman, *et al.*, *Nat. Nanotechnol.*, 2008, **3**, 563–568.
- 35 <http://www.thomas-swan.co.uk/news/graphene-exports-begin-uk-supplier>, last time accessed, March 4, 2015.

- 36 K. P. Loh, J. Wang, G. Chiu, *Process for forming expanded hexagonal layered minerals and derivatives using electrochemical charging*, US 20140027299 A1, 2014.
- 37 R. A. Mercuri, *Production of Exfoliated Graphite*, US Pat., 20130022530, 2013.
- 38 Cited in: G. Cantalupo, Inaugurato il primo impianto per la produzione di grafene in Italia, *L'Industria della Gomma Elastica*, September 2014; pp. 58–62. See at the URL: [http://issuu.com/edifis/docs/gomma\\_621\\_x\\_sfoglio/1?e=2663884/10151616](http://issuu.com/edifis/docs/gomma_621_x_sfoglio/1?e=2663884/10151616) last time accessed March 4, 2015.
- 39 J. Zhu, D. Yang, Z. Yin, Q. Yan and H. Zhang, *Small*, 2014, **10**, 3480–3498.
- 40 M. Pagliaro, G. Palmisano and R. Ciriminna, *Flexible Solar Cells*, Wiley-VCH, Weinheim, 2008, p. 9.
- 41 A. Bolduc, *Hydropower: looking to the future*, 2012, <http://www.hydroforthefuture.com/capsules/57/history>, last time accessed March 4, 2015.
- 42 C. A. Rodriguez, M. A. Modestino, D. Psaltis and C. Moser, *Energy Environ. Sci.*, 2014, **7**, 3828–3835.
- 43 International Energy Agency, *Trends in Photovoltaic Applications*, October 2014.
- 44 IHS, Q3 2014 PV Demand Market Tracker, October 2014.
- 45 R. Prabhu (Mercom Capital Group), PV installations in 2015 to reach 54.5 GW, PV Magazine, 6 January 2015, [http://www.pv-magazine.com/news/details/beitrag/pv-installations-in-2015-to-reach-545-gw\\_100017671/#ixzz3TKxzcTJ](http://www.pv-magazine.com/news/details/beitrag/pv-installations-in-2015-to-reach-545-gw_100017671/#ixzz3TKxzcTJ), last time accessed March 4, 2015.
- 46 Reuters, Enel Green Power SpA awarded 344 MW of wind and solar PV capacity in Brazilian public tender, 3 November 2014.
- 47 N. Mahmood, C. Zhang, H. Yin and Y. Hou, *J. Mater. Chem. A*, 2014, **2**, 15–32.
- 48 R. Raccichini, A. Varzi, S. Passerini and B. Scrosati, *Nat. Mater.*, 2015, **14**, 271–279.
- 49 F. Bonaccorso, L. Colombo, G. Yu, M. Stoller, V. Tozzini, A. C. Ferrari, R. S. Ruoff and V. Pellegrini, *Science*, 2015, **347**, 1246501.
- 50 X. Zhao, C. M. Hayner, M. C. Kung and H. H. Kung, *Adv. Energy Mater.*, 2011, **1**, 1079–1084.
- 51 S. Yang, Y. Gong, Z. Liu, L. Zhan, D. P. Hashim, L. Ma, R. Vajtai and P. M. Ajayan, *Nano Lett.*, 2013, **13**, 1596–1601.
- 52 K. Zaghbi, *et al.*, Lithium-ion secondary battery and method of producing same, WO 2013166598 A1, 2013.
- 53 T. Ramanathan, A. A. Abdala, S. Stankovich, D. A. Dikin, M. Herrera-Alonso, R. D. Piner, D. H. Adamson, H. C. Schniepp, X. Chen, R. S. Ruoff, S. T. Nguyen, I. A. Aksay, R. K. Prud'Homme and L. C. Brinson, *Nat. Nanotechnol.*, 2008, **3**, 327–331.
- 54 H. Kim, A. A. Abdala and C. W. Macosko, *Macromolecules*, 2010, **43**, 6515–6530.
- 55 H. H. Lee, *Hydrocarbon composite electrolyte membrane for fuel cell*, US 20130065154, 2013.
- 56 Fuel Cell Today, *The Fuel Cell Industry Review 2013*, Royston, UK, 2014.
- 57 N. Lapeña-Rey, J. Mosquera, E. Bataller and F. Ortí, *J. Aircr.*, 2010, **47**, 1825.
- 58 V. Mittal, *Macromol. Mater. Eng.*, 2014, **299**, 906–931.
- 59 CEAR Laboratori Riuniti, Certification of oil sorbent performances of Graphene Plus, 14 October 2013, <http://genius-project.com/wp-content/uploads/2014/09/131025-Oil-adsorption-certificate.pdf>, last time accessed March 4, 2015.
- 60 A. Pola, G. Cesareo and G. Tartari, *Graphene Plus: reusable eco-innovative sorbent for oil spills clean-up and polluted water treatment*, Ecomondo, Rimini, Italy, 2013. These findings are the outcome of a EU-funded project GENluS (Graphene Eco Innovative Sorbent, 2013–2015), following which Italy's Government approved the use of exfoliated graphite in oil spill clean-up activities.
- 61 J. Conroy, N. K. Verma, R. J. Smith, E. Rezvani, G. S. Duesberg, J. N. Coleman, Y. Volkov, Biocompatibility of Pristine Graphene Monolayers, Nanosheets and Thin Film, arXiv:1406.2497.
- 62 A. K. Geim, *Science*, 2009, **324**, 1530–1534.
- 63 K. P. Loh, Q. Bao, P. Kailian Anga and J. Yang, *J. Mater. Chem.*, 2010, **20**, 2277–2289.
- 64 H. Li, Y. Huang, Y. Mao, W. L. Xu, H. J. Ploehn and M. Yu, *Chem. Commun.*, 2014, **50**, 9849–9851.
- 65 (a) Y. Huang, H. Li, L. Wang, Y. Qiao, C. Tang, C. Jung, Y. Yoon, S. Li and M. Yu, Ultrafiltration Membranes with Structure-Optimized Graphene-Oxide Coatings for Antifouling Oil/Water Separation, *Adv. Mater. Interfaces*, 2015, DOI: 10.1002/admi.201400433; (b) H. Li, Z. Song, X. Zhang, Y. Huang, S. Li, Y. Mao, H. J. Ploehn, Y. Bao and M. Yu, *Science*, 2013, **342**, 95–98; (c) H. W. Kim, H. W. Yoon, S.-M. Yoon, B. Min Yoo, B. K. Ahn, Y. H. Cho, H. J. Shin, H. Yang, U. Paik, S. Kwon, J.-Y. Choi and H. B. Park, *Science*, 2013, **342**, 91–95.
- 66 G. Chiu, "Success without borders - imagination, teamwork and graphene", TEDxSarasota, 7 November 2014.