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Title: Scale-up and viscosity effects on gas-liquid mass transfer rates in unbaffled stirred tanks

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Highlights

- Scale-up effects on mass transfer coefficient in unbaffled stirred tanks are presented.
- Similar or higher mass transfer coefficients were obtained in larger vessels.
- The same result is obtained at increased liquid viscosity.
- At high power inputs mass transfer performance is identical to sparged baffled tanks
- Unbaffled tanks can be regarded as a strong candidate for many industrial applications.

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