



UNITED NATIONS
INDUSTRIAL DEVELOPMENT ORGANIZATION

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SUSTAINABLE
COOLING
FORUM

Session 1

Promotion of Natural Refrigerants in the
Cooling Industry



Opening Remarks

Speakers



Mr. Ciyong Zou

Deputy to the Director General
and Managing Director
UNIDO



Ms. Wang Feng

Director in the Department of
Atmospheric Environment
Ministry of Ecology and
Environment, China



Mr. Paul Krajnik

Deputy Director in the Directorate
General of the Environment and
Circular Economy
Ministry of Agriculture and
Forestry, Austria



Mr. Alessandro Giuliano Peru

Directorate-General for European and
International Affairs and Sustainable
Finance
Ministry of Environment and
Energy Security, Italy

Moderator



Mr. Alois Mhlanga

Director of the Climate Innovation
and Montreal Protocol Division
UNIDO



Technical Presentations

Speakers



Mr. Chen Jianming

Senior Manager

China Household Electrical
Appliances Association



Mr. Andreas Klaudus

CEO and Co-Founder

Austrian Academy of
Refrigeration Technology

Moderator



Mr. Yunrui Zhou

Industrial Development Officer

UNIDO



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Standards and Industrial Transformation for the Adoption of Natural Refrigerants in Chinese RAC Sector

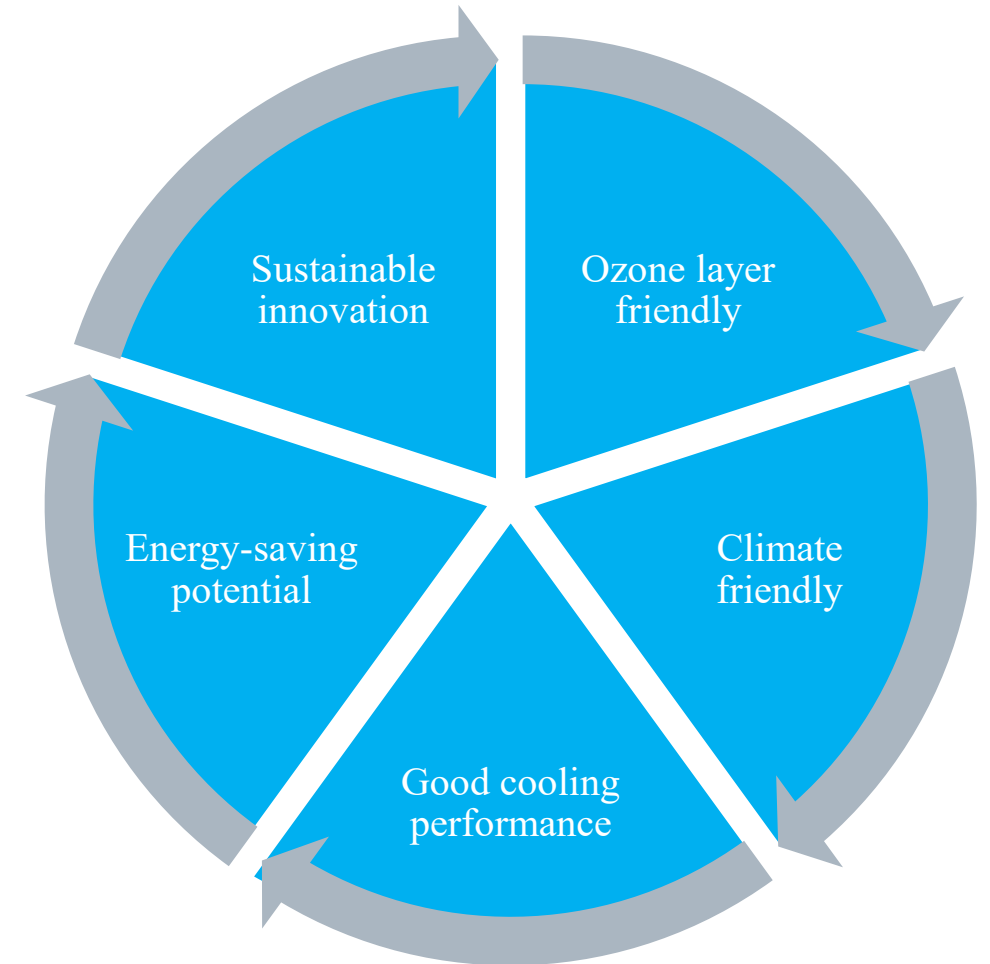


中国家用电器协会

China Household Electrical Appliances Association

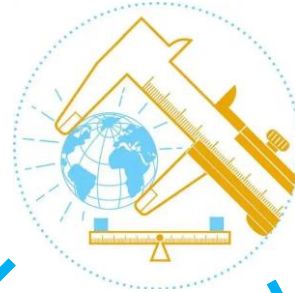
SESSION 1: R290 - Green sustainable cooling solution recommended by Chinese RAC sector

- Chinese RAC sector, for the compliance with the Montreal Protocol and the sustainable development of the industry, has chosen R290 as alternative to HCFC-22 and HFCs. With ultra-low GWP and good energy-saving potential, R290 turns out a green and sustainable cooling solution, which will contribute to continuous GHG emission reduction of RAC sector and collaborative innovation of the industrial chain.



SESSION 2: Standards-Provide specifications and guidance to R290 adoption

Development and revision of industrial standards covering manufacturing, installation and servicing as well as short-distance and long-distance transportation of R290 RACs.



Revision of EE standard GB 21455-2019 (under revision).

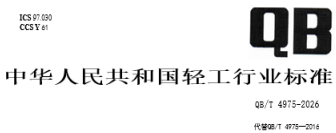


房间空气调节器能效限定值及能效等级

Minimum allowable values of the energy efficiency and energy efficiency grades for room air conditioners

2019-12-31 发布
 2020-07-01 实施
 国家市场监督管理总局 发布
 国家标准化管理委员会

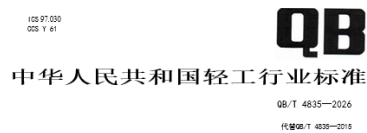
Revision of safety standard GB/T 4706.32-2024 for RAC products, which adopts the 7.0th edition of IEC 60335-2-40 by equivalent.



使用可燃性制冷剂生产家用和类似用途房间空气调节器的特殊要求

Particular requirements for manufacturing household and similar air-conditioner employed the flammable refrigerants

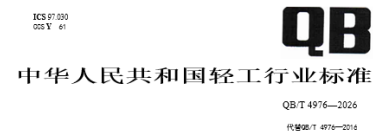
2026-03-11 发布
 2026-09-01 实施
 中华人民共和国工业和信息化部 发布



使用可燃性制冷剂房间空气调节器安装、维修和运输的特殊要求

Particular requirements for installation, repair and transportation of room air-conditioner employed the flammable refrigerants

2026-03-11 发布
 2026-09-01 实施
 中华人民共和国工业和信息化部 发布



使用可燃性制冷剂房间空气调节器运输的特殊要求

Particular requirements for transportation of room air-conditioner employed the flammable refrigerants

2026-03-11 发布
 2026-09-01 实施
 中华人民共和国工业和信息化部 发布



家用和类似用途电器的安全 第32部分：热泵、空调器和除湿机的特殊要求

Safety of household and similar electrical appliances—Part 32: Particular requirements for electrical heat pumps, air-conditioners and dehumidifiers

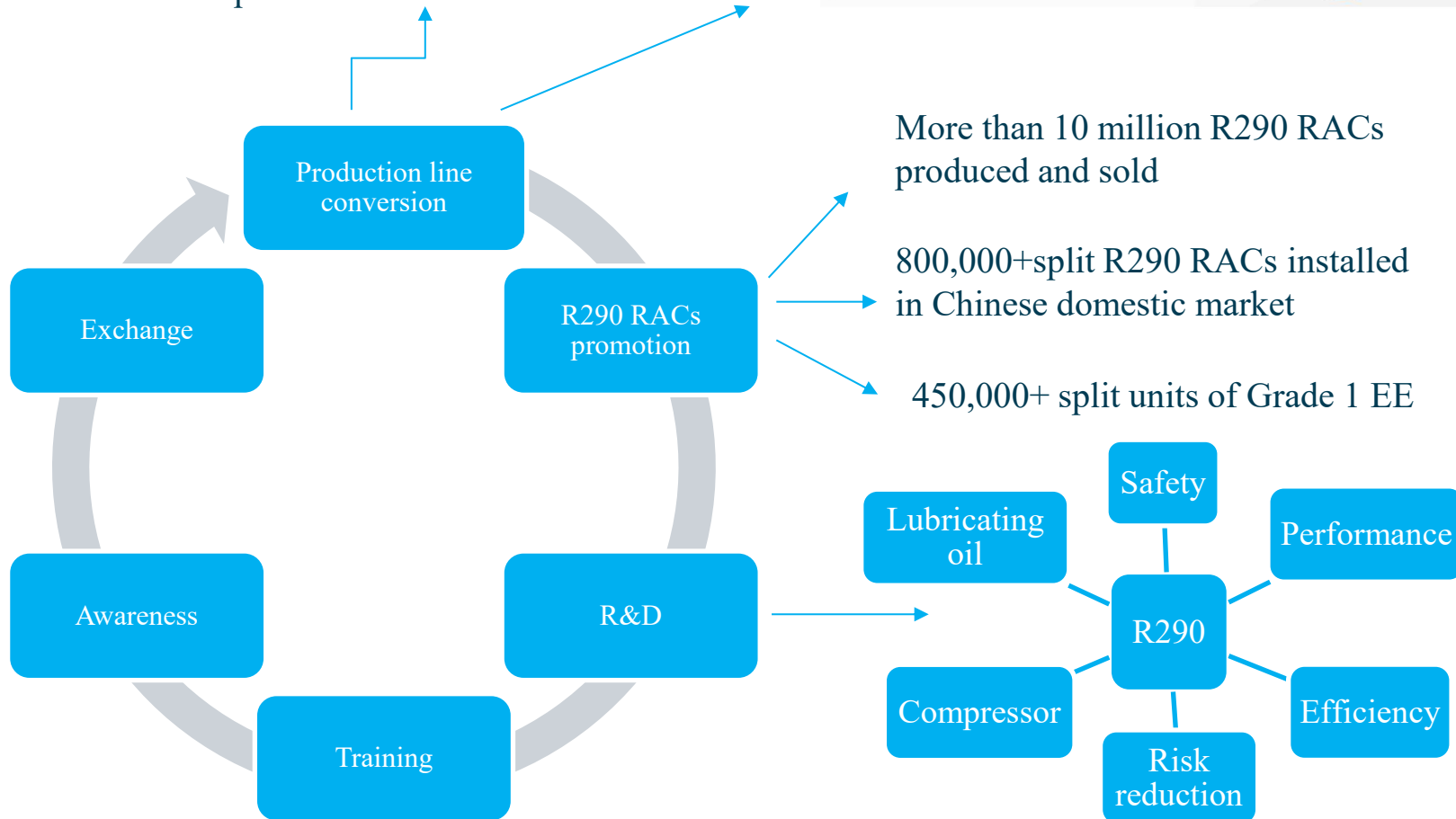
IEC 60335-2-40:2022, Household and similar electrical appliances—Safety—Part 2-40, Particular requirements for electrical heat pumps, air-conditioners and dehumidifiers (IDT)

2026-07-24 发布
 2026-08-01 实施
 国家市场监督管理总局 发布
 国家标准化管理委员会

SESSION 3: Industrial transformation – Actions taken by Chinese RAC sector to promote R290

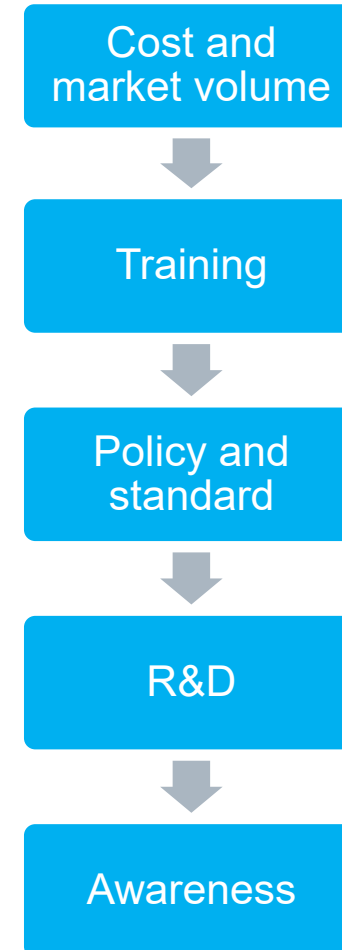


30 RAC and 7 compressor production lines converted



SESSION 4: Challenges and tasks

- The No.1 challenge is the higher cost of R290 RACs caused by safety enhancing measures applied and small production volume. It is the key task of the industry to scale up the market volume to average down the cost of R290 RACs.
- More training for servicing technicians is needed, which plays an essential role in the promotion of split R290 RACs, as main risk points of R290 RACs lie in installation and servicing processes .
- Coordination between policies and standards of different countries is necessary to clear the way for the adoption of R290 RACs worldwide and expand the environmental benefits of R290.
- More investment in R&D is indispensable to decrease the cost and improve energy efficiency to accelerate the adoption of R290 RACs.
- Joint efforts to increase stakeholders and consumer awareness will be helpful for the promotion of R290 RACs.





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Thank you

Jianming Chen
CHEAA
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UNIDO's approach

Shaping markets through policies

European Best Practices in Scaling the Adoption of Nature Refrigerants

Andreas Klaudus

Austrian Refrigeration Academy



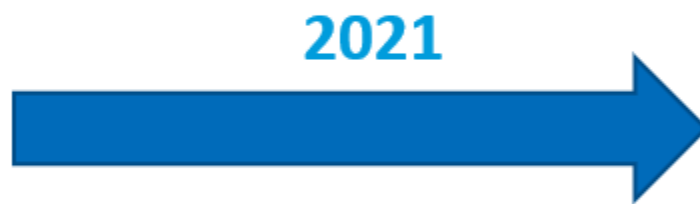


A brief introduction to the Austrian Assoziation of Refrigeration (ÖGKT) and Austrian Academy of Refrigeration Technology

“We are the independent network of everyone interested in refrigeration, air conditioning and heat pump technology”



Österreichische
Gesellschaft **der**
KÄLTETECHNIK



2021



Österreichische
Akademie **der**
KÄLTETECHNIK



CEN/TC 182
"Refrigerating systems, safety and
environmental requirements"



CEN/TC 182/WG 6 "Revision of EN 378"

AUSTRIAN
STANDARDS

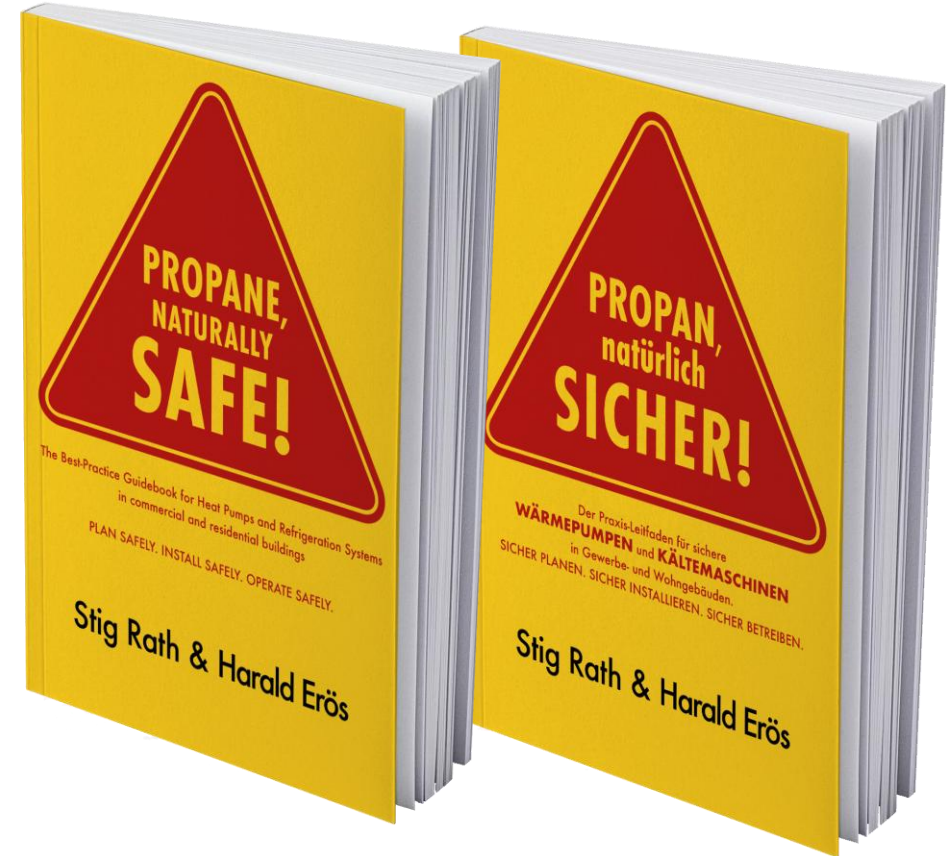


IEA HPT Annex 64

Bundesministerium
Klimaschutz, Umwelt,
Energie, Mobilität,
Innovation und Technologie

IEA Forschungskooperation

FFG



New since January 2026 also in English



Apprenticeship training





Specialization Training for R-290





Specialization Training for R-744





Brazing training and certification





Refrigeration Masterclass





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Thank you

Andreas Klaudus
CEO and Cofounder
Austrian Refrigeration Academy
office@kaelte-akademie.at



Panel Discussion

Scaling up Natural Refrigerants: Challenges, Opportunities and Enabling Conditions

Speakers



Mr. Xiaoyan Li

Senior Program Manager

Ministry of Ecology and Environment,
China



Mr. Harald Eroes

CEO and Co-Founder

Austrian Academy of
Refrigeration Technology



Mr. Alfonso William Mauro

Refrigeration and Heat Pumps
Professor

Federico II University of Naples



Mr. Baolong Wang

Professor at the Department of
Architecture

Tsinghua University

Moderator



Mr. Yunrui Zhou

Industrial Development Officer

UNIDO



Industry Case Studies

Speakers



Mr. Gao Hao

R290 RAC Development
Manager
Midea



Ms. Ju Chengcheng

Deputy Director
Moon-Tech



Mr. Ren Tao

Director
Haier

Moderator



Mr. Yunrui Zhou

Industrial Development Officer
UNIDO

Innovation and Commercialization of Midea R290 RAC for the Implementation of the Kigali Amendment

Hao Gao | MIDEA

2026-04-09

1 Properties of R290 and Technological Challenges

□ Properties of R290

- Environmentally Friendly, High Energy Efficiency, Flammability

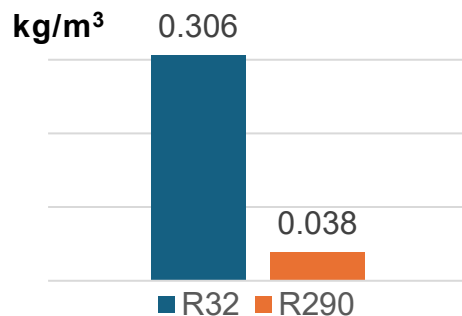
□ Technological Challenges

Safety

- The LFL of R290 approximately one-eighth of R32

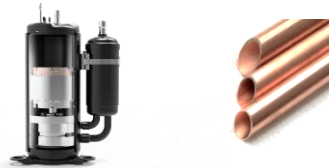


LFL

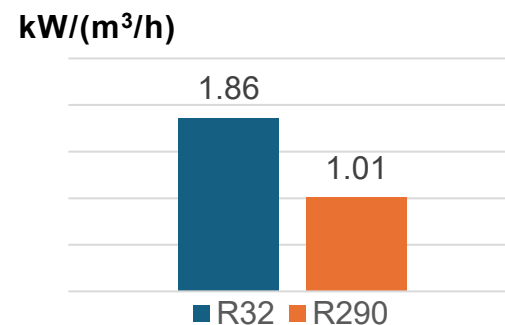


Cost

- The specific volumetric cooling capacity of R290 is 48% of R32



Volumetric cooling capacity



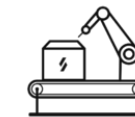
Reliability

- Stricter safety requirements and Verification



Industry Chain

- The whole chain needs upgrading accordingly



Manufacturing



Logistics



Storage



Recycling



Service



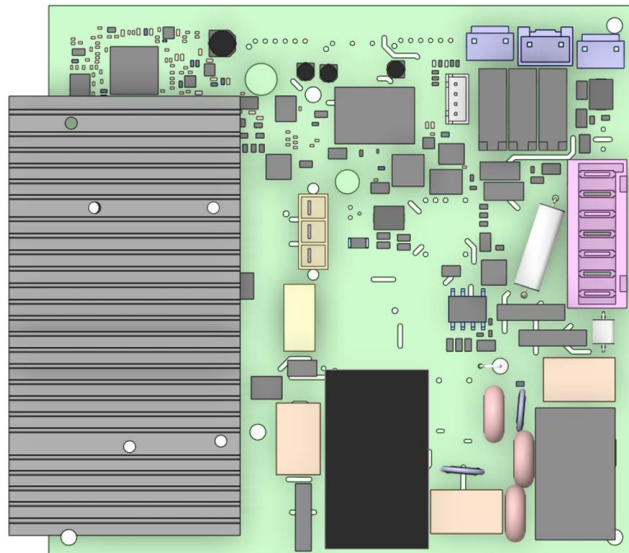
Installation

R&D of R290 RAC

□ Breakthrough of Electrical Controller

Ignition-Source-Free

- Explosion-proof certification for some key components
- Control of the highest operating surface temperature



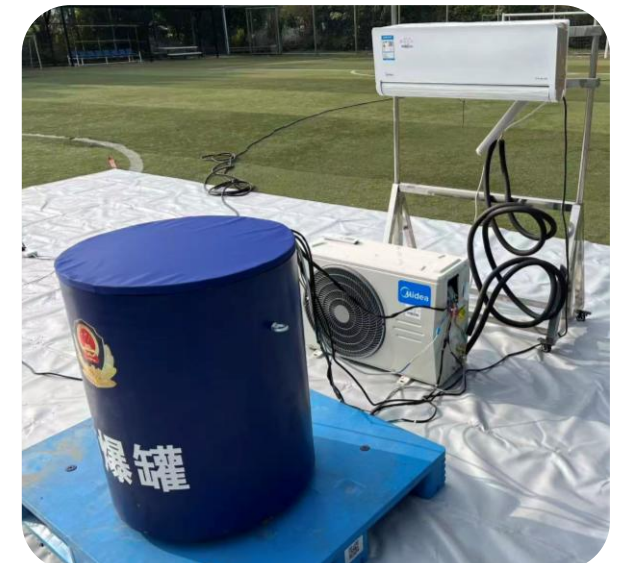
Validation Under Extreme Environment

- An environment with 85°C and 85% RH
- Accelerated life test with 1000 hours of continuous operation



Validation Under Flammable Conditions

- Flammable environment
- Operate safely with heavy load



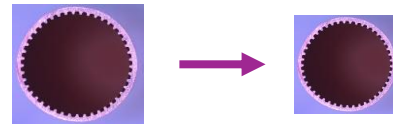
R&D of R290 RAC

□ Breakthrough of Heat Exchanger

• Smaller Diameter Tubes

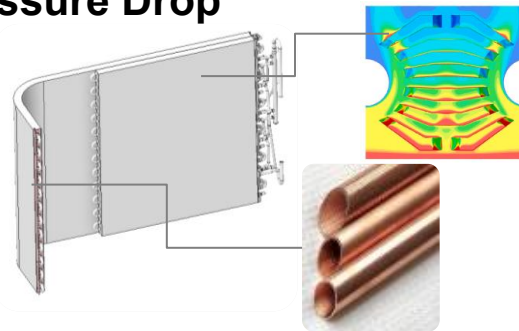
- Refrigerant charge amount reduce 49%
- Cost and Efficiency Optimization

Optimized diameter from 7 to 5 mm



• High Heat Transfer & Low Pressure Drop

- Efficient slit fin with quasi-radial strips
- New copper pipe with lower flow resistance and higher heat flux



• Research Findings

- Published over 20 research papers in top-tier international journals, including *Energy* and *Applied Energy*

Energy 318 (2023) 134818

Contents lists available at ScienceDirect

Energy

journal homepage: www.elsevier.com/locate/energy

Variable-circuitry heat exchanger for performance improvement of R290 air source heat pump system

Longxiang Hu^a, Tong Xiong^{a*}, Guoqiang Liu^a, Qideng Xiao^a, Tingxun Li^b, Jinbo Li^c, Gang Yan^d

^a Department of Refrigeration and Cryogenic Engineering, School of Energy and Power Engineering, Xi'an Jiaotong University, Xi'an, 710049, China

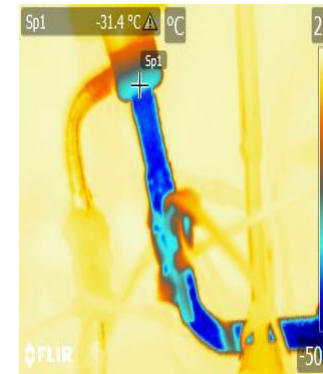
^b School of Building Systems Engineering, Sun Yat-sen University, No. 66, Gongzheng Road, Shenzhen, 518027, China

^c Guangdong Midea Refrigeration Equipment Co. Ltd., Foshan, 528311, China

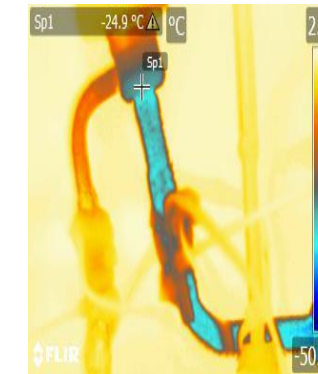
□ Breakthrough of System Reliability

• Oil Blockage

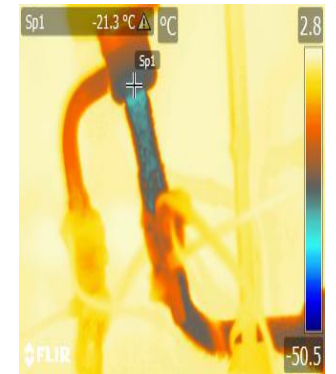
- Large compressor displacement
- Low refrigerant charge
- Low operating pressure



t=60s



t=180s



t=360s

Temperature change of expired EEV

• Design Optimization

- Lower oil discharge compressor
- Higher flux EEV
- New control logic



3

Commercialization of R290 RAC

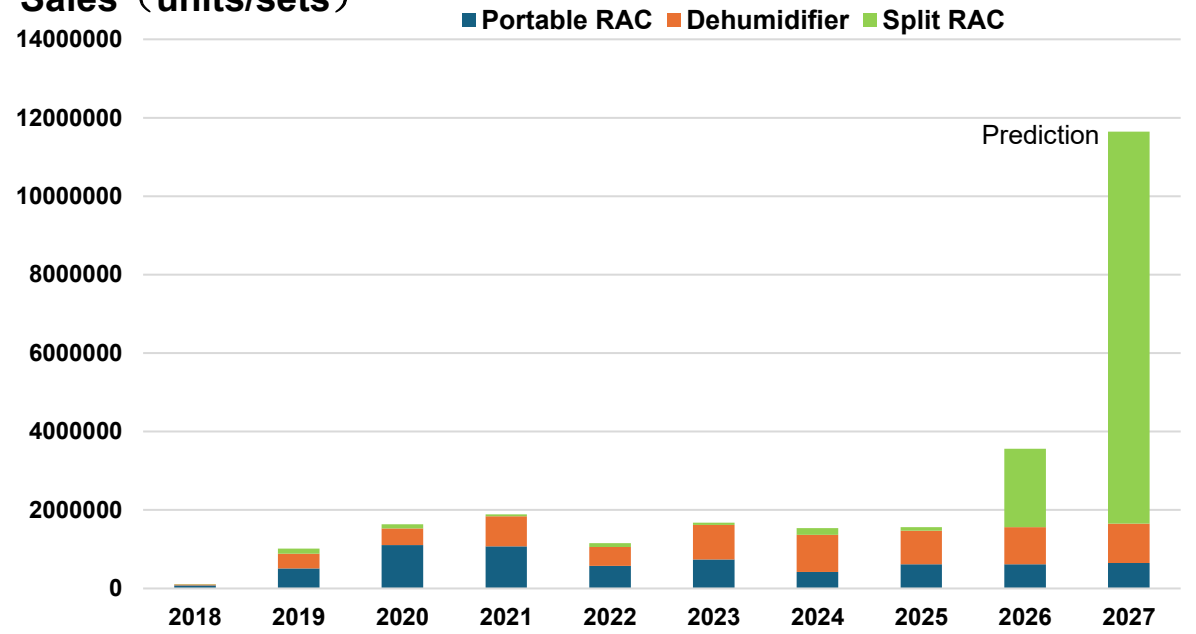
Product Breakthroughs



Market Performance

- Launched in 73 countries and regions , sales had exceeded 10 million units
- Refrigerant replacement has reduced greenhouse gas emissions by approximately 5.11 million tCO₂e, equivalent to the annual carbon sequestration of 6.06 million hectares of Amazon rainforest

Sales (units/sets)



3 Commercialization of R290 RAC

Production Line Upgrade

- A total of 13 production lines have been upgraded, capable of an annual production capacity of 7 million units



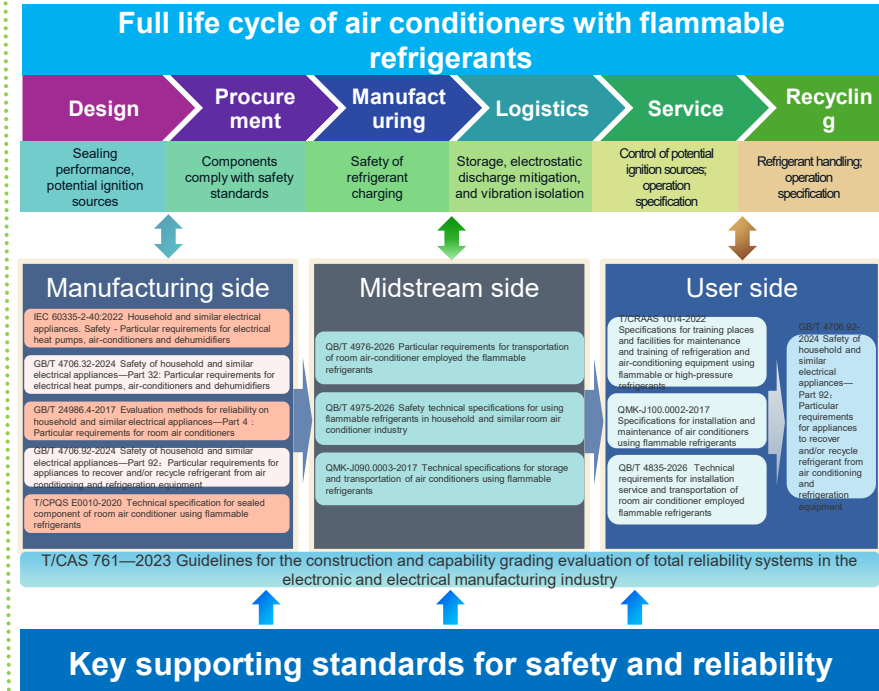
After-sales Capability Building

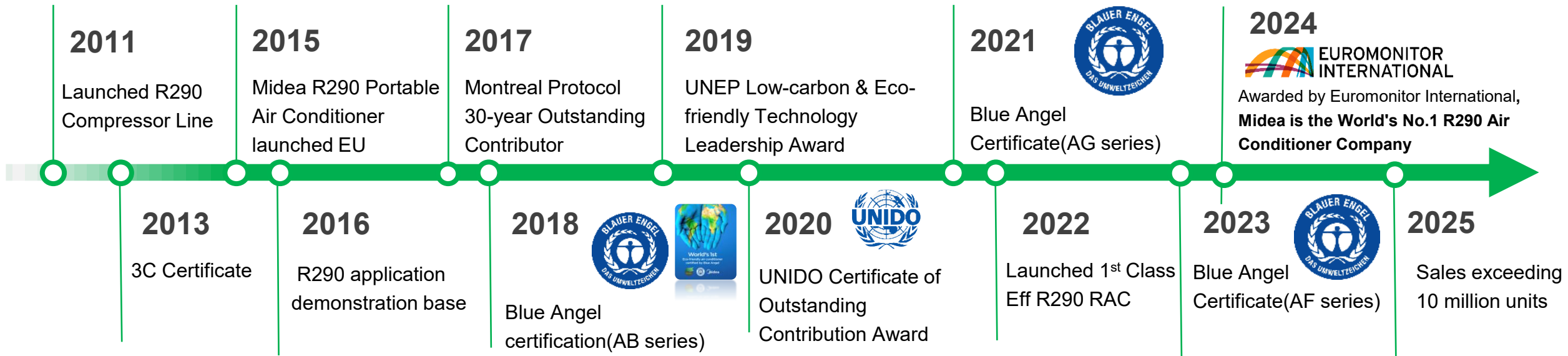
- Midea have carried out a special training program for R290 installation and maintenance, with over 100,000 personnel trained nationwide



Standards System Construction

- Midea have built core reliability standards covering the entire life cycle and whole industrial chain of flammable refrigerant air conditioners, forming a complete industrialization standard system





Challenge

Responsibility

Collaboration

Green Tomorrow

Thank you

Gao Hao
R290 RAC Manager
Midea Residential Air Conditioner(RAC) Division
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Technology and application of Alternative Eco-friendly Refrigerant and Energy efficiency improvement in room and commercial Air conditioners

Tao Ren, Ph.D, Haier Smart Home Co. Ltd

The author is RTOC Member, this presentation is given in my personal capacity

Haier



Haier's Journey in Refrigerant Transformation



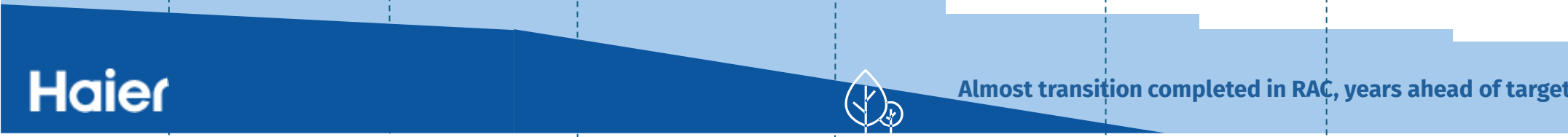
Achieved significant GWP emission reductions since 2019
Drove charge reduction techniques: small diameter copper tubes HX, and microchannel HX
R290 promotion & **developing CO2 Air conditioning technologies**

2010 2015 2019 2020 2022 2025 2030 2035

R22



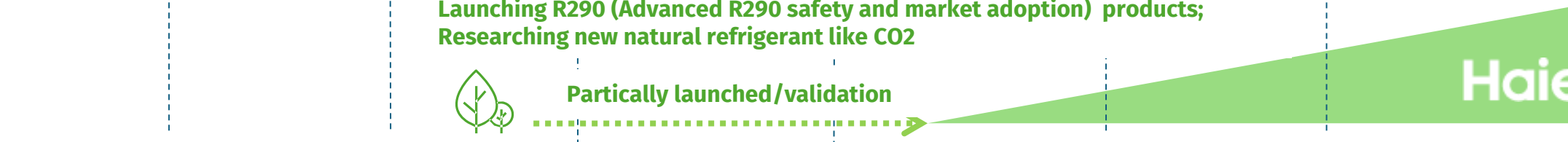
R410A



R32



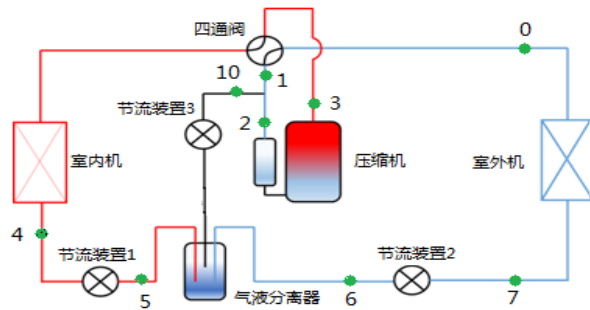
R290 /others



R290 Residential AC: Technology Development and Deployment

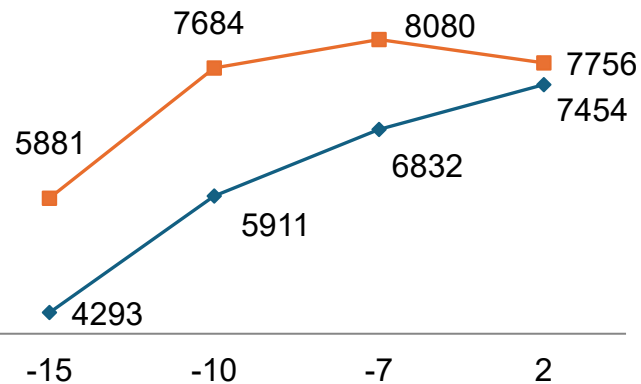
New type of dynamic air replenishment and enthalpy increasing cycle

- ✓ low insulation index
- ✓ low-temperature heating capacity



External ambient temperature °C

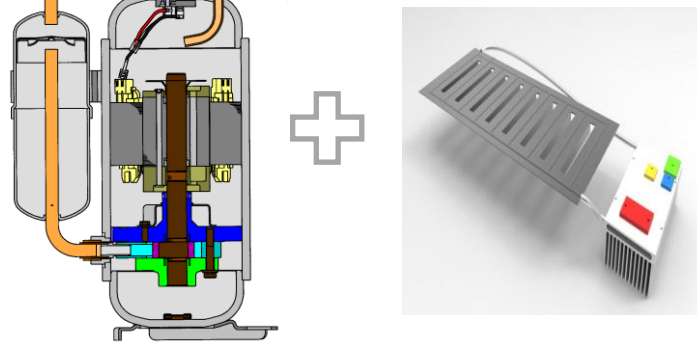
- ◆ R290-Original System
- R290-New System



Chip cooling scheme using heat pipe heat exchange

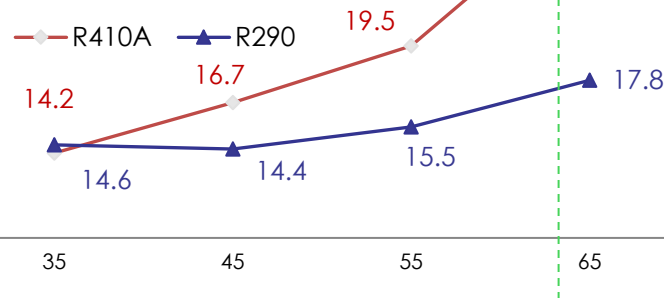
- ⊕ High critical temperature & high-temperature performance

High temperature & pressure compressors + Heat pipes for heat dissipation of chips and IGBTs



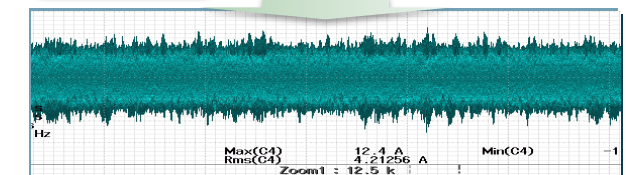
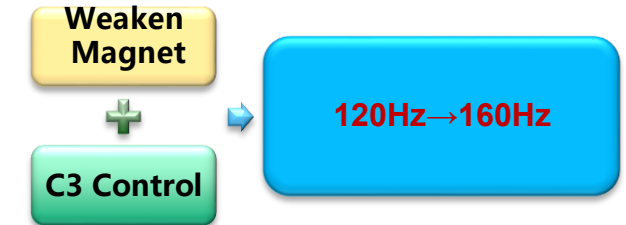
R290

Outlet air temperature °C

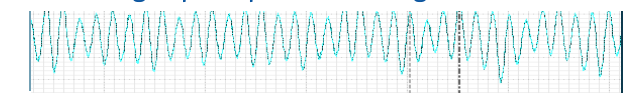


Deep weak magnetic suppression of voltage pulsation technology

- ✓ low cooling capacity per unit volume



Before: High speed pulsation: large and unstable



After: 160Hz Operating waveform, small pulsation, stable

R290: Safety Advocacy and Market Growth:

R290 Power Series *New*

+Safety Control

Fully sealed control cabinet

+Explosion-proof electric control design

+Safety: Silver brazing welding

-Leak: Reduce welding joints and advanced welding technology



+Safety :Refrigerant sensor

Refrigerant leak detection for enhanced safety

8+ Refrigerant Leak Prevention and Safety Design



Professional Safety Training:

Refrigerant Handling/Installation Accumulated Training of 3,000 R290 Service Personnel



Market Growth: 60+ R290 Products Launched, 186,000 Units Sold In China

Fixed Frequency:KF serials

Variable Frequency:KFR serials



Refrigerant Transition in Commercial AC: R32 to R290 In Heat Pump

Energy efficiency

increases around 10%, compared to R32

R290 Heat pump (6 kW)

COP 3.5 (55°C)

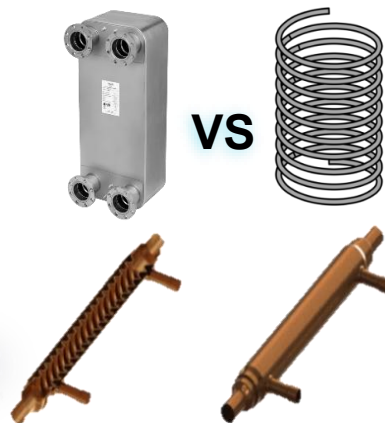
SCOP 3.85 (55°C)

R32 Heat pump (6 kW)

COP 3.02 (55°C)

SCOP 3.52 (55°C)

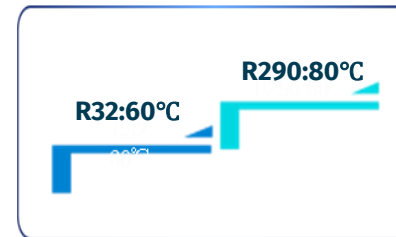
With the help of high efficiency compressor, main HX, and heat recovery HX,



Confort:

High temp water

Max. Leaving water temp 80°C



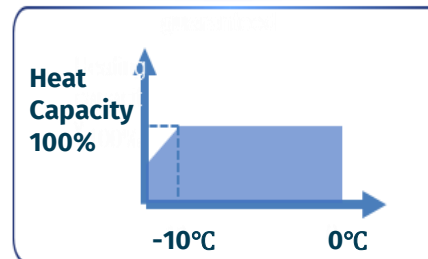
Wide operating range

Heating at -28°C



Low temp heating

-10°C nominal capacity output



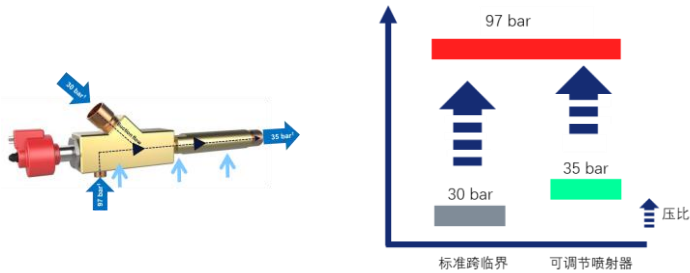
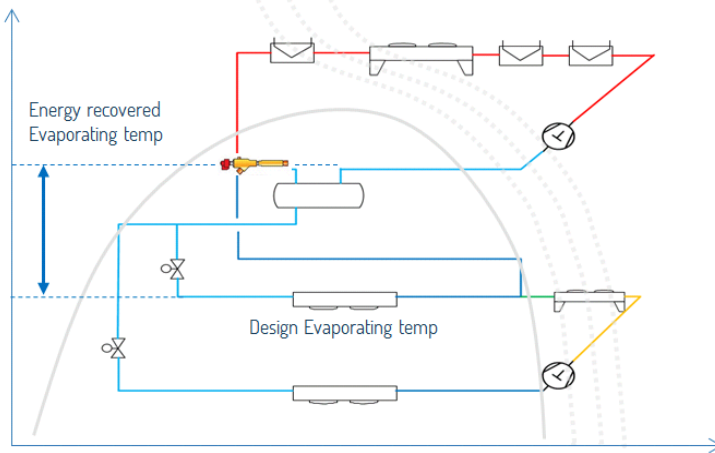
Low sound level

Sound power level down to 54dB(A)

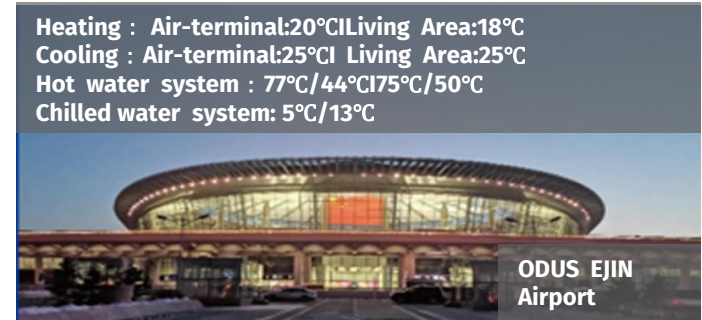


Refrigerant Transition in Commercial Application: CO₂ Technologies and Applications

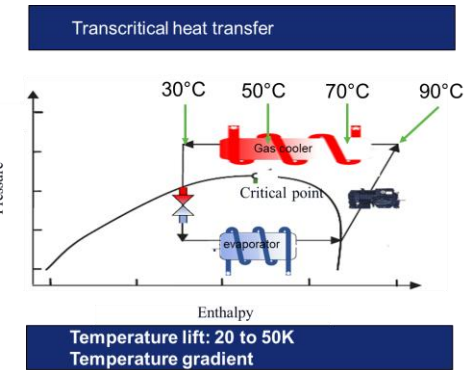
CO₂ Cooling Technologies



Commercial Heating and Cooling



CO₂ system annual energy saving ~ 28% compared to HFC *
CO₂ energy saving around 2 million kWh of electricity per year



**Annual Combined heating and cooling energy saving:
5 Million kWh >50%**

Multi-Temperature Heat Recovery up to 85°C

Gradient heat recovery (35-85°C)/ gas cooler pressure modulation.
40% + heat recovery capacity VS HFC/HFO and NH₃ systems



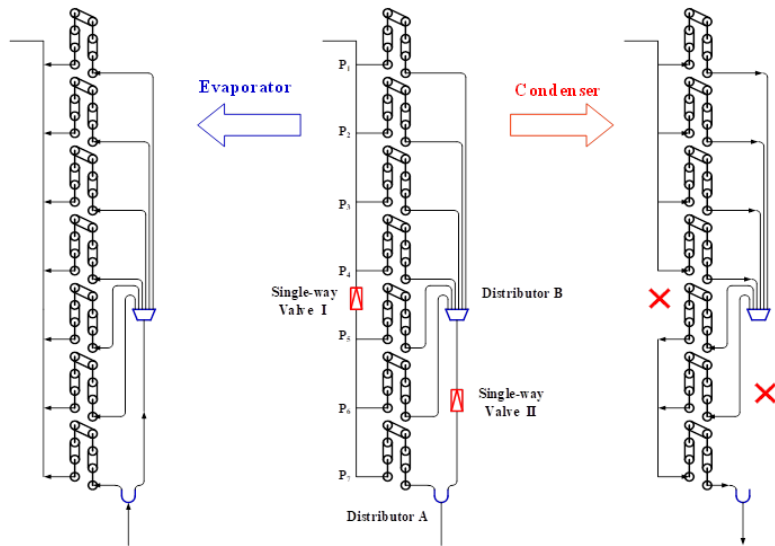
**Annual reduction of carbon emissions 5,500t
>90% Near-zero carbon emissions.**

Energy Efficiency Enhancement Technology: Variable flow path

Solve the contradiction of reverse demand for condensation and evaporation convection paths, and achieve synchronous efficiency enhancement of condensation and evaporation

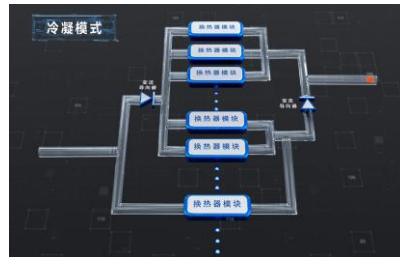
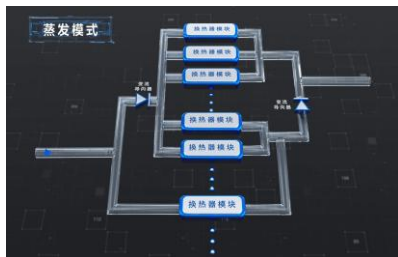
Condensation series few branches, strong overcooling

Evaporation parallel multiple branches, reducing pressure loss

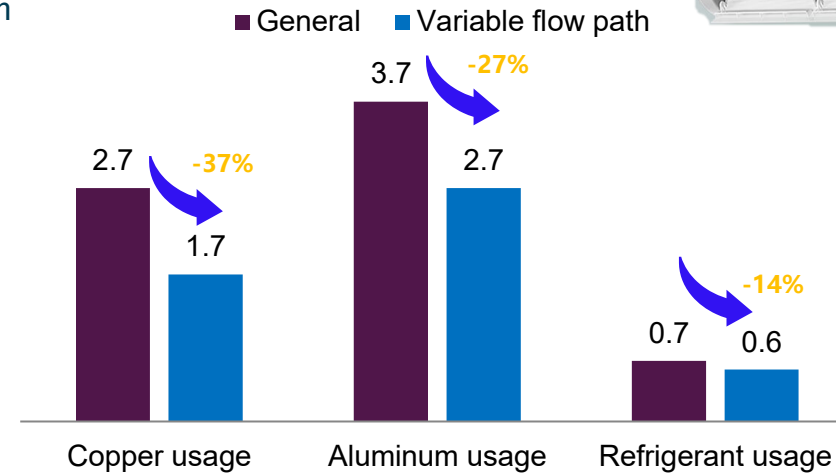


Evaporating Mode

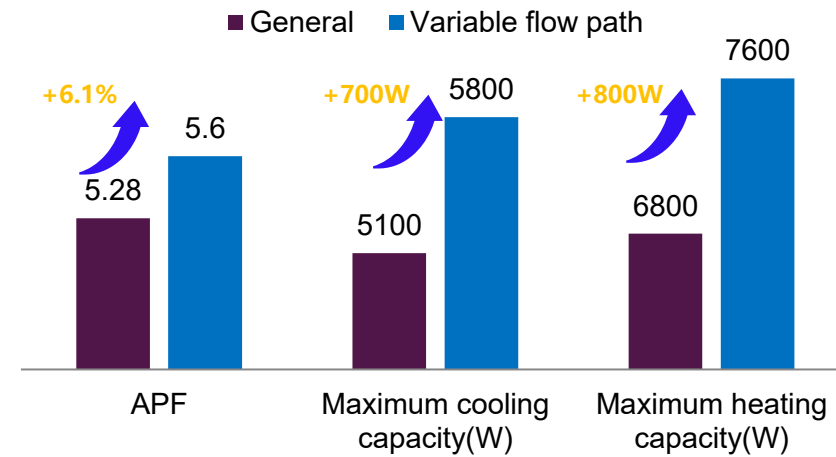
Condensing mode



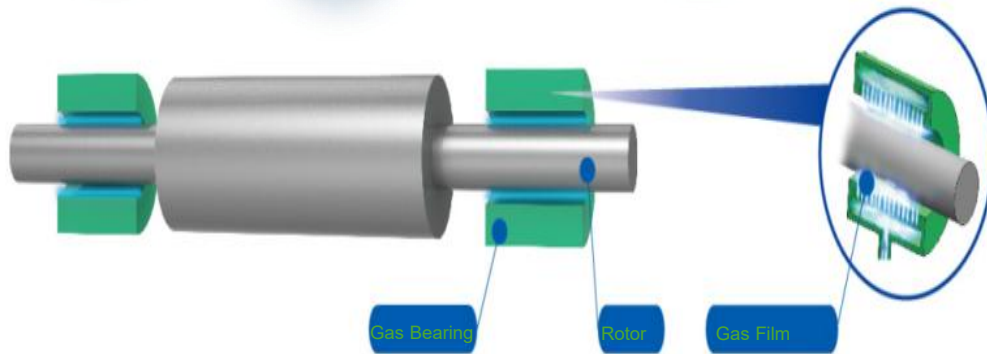
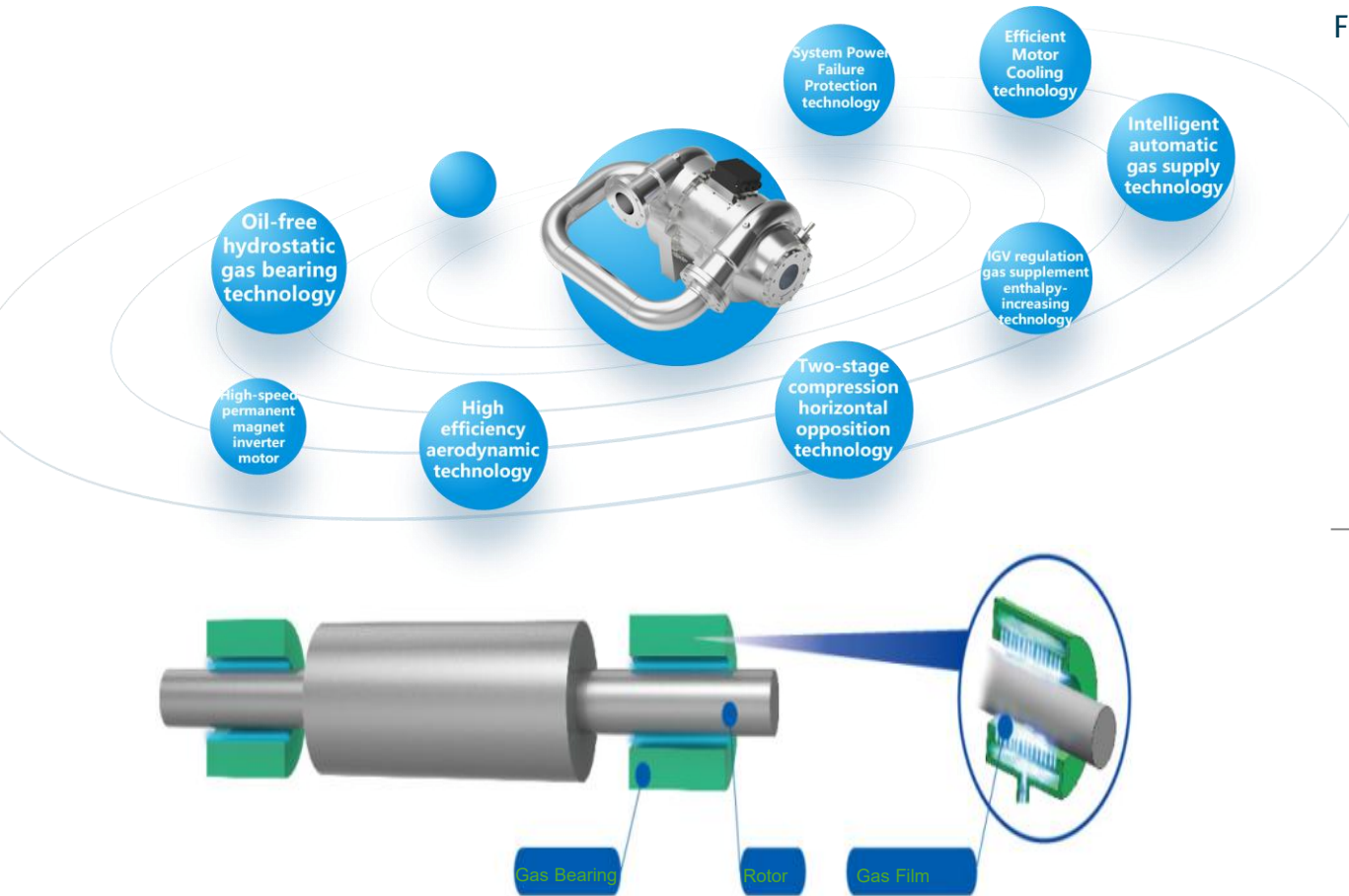
With the same energy efficiency



With the same cost

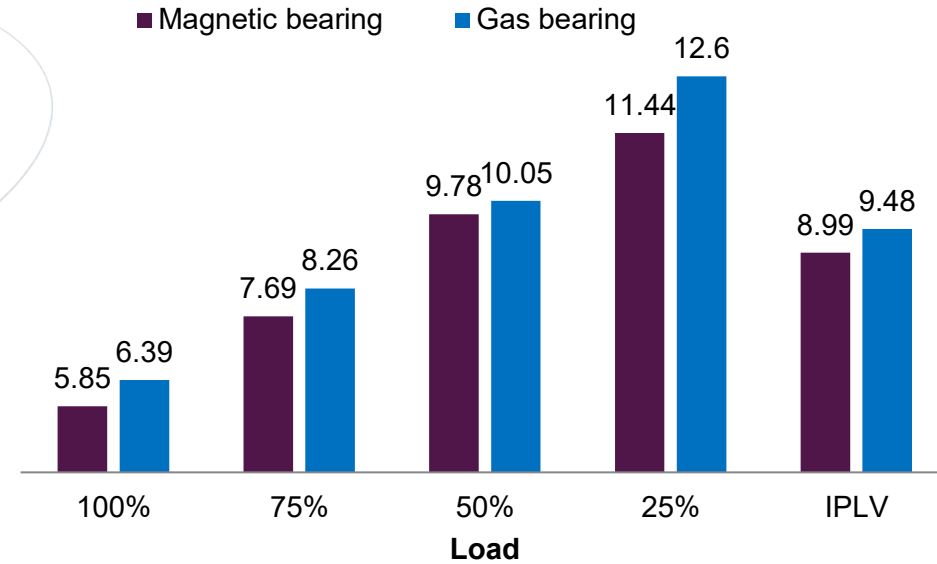


Energy-Efficient Technologies: Gas Bearing Solutions



The compressor utilizes gas to generate buoyancy force to realize rotor suspension and self-adjustment, which greatly simplifies the suspension mechanism and control algorithms compared to magnetic bearing compressors.

For the 700RT unit, energy efficiency improves by 9.23% in COP and 5.45% in IPLV.





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The Promotion of Natural Refrigerants in China's Industrial and Commercial Refrigeration

JU Chengcheng
MOON-TECH

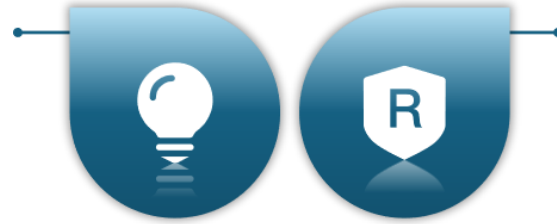


冰轮环境
MOON-TECH

SESSION 1: Progress on the Natural Refrigerant Technology Roadmap

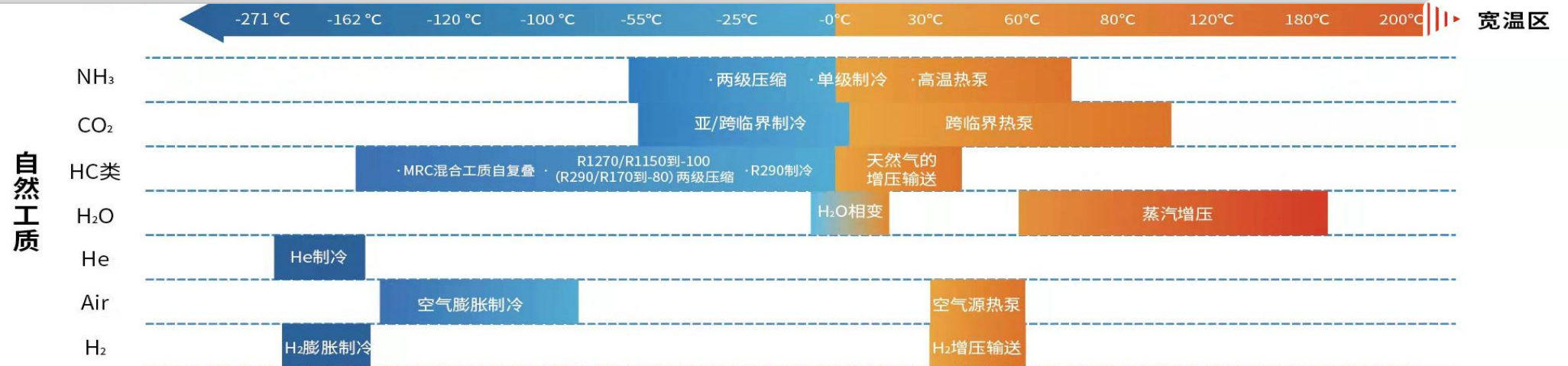
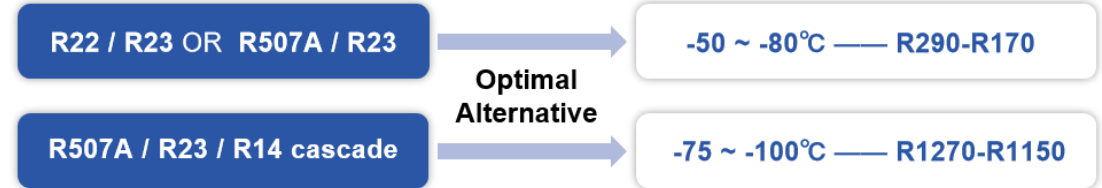
NH₃/CO₂ Cascade Refrigeration Technologies

- Cold Chain and Commercial Freezing Applications
- Freon Replacement Above -50°C
- Low Charge & Safe, High Efficiency, Eco-Friendly, Smart O&M



HCs Refrigeration Technologies

- Petrochemical Industrial Refrigeration Applications
- Freon Replacement Above -100°C
- Readily Available Materials, Reliable Explosion-Proof Design, Eco-Friendly, Stable & Economy



SESSION 2: Expansion of the NH₃/CO₂ refrigeration system application market



Cold Chain Logistics

Guangzhou Nansha International Logistics
National Modern Grain Logistics (Wuhan) Base

- **Cold Chain Logistics**
Guangzhou Port—China's largest cold chain hub port & A benchmark engineering project for CO₂ refrigeration systems
 - Capacity: nearly 300,000 tons.
 - Including 3 eight-story cold storage facilities, 1 refrigerated container yard, and 1 supporting exhibition building.



Muyuan Meat Food
Fujian Sunner Holding Group



Meat Processing

Rugao Agricultural
Shandong Processed Food Manufacturing



Seasoned Foods
Process

- **Meat Processing**
A Project from One of the largest broiler processing companies in China
 - NH₃/CO₂ cascade system is adopted for the quick-freezing device, freezing room, and low-temperature cold storage.
 - Application of Frequency Conversion Technology & Intelligent System Control

Rushan Food Group
Zhoushan Seafood



Seafood Processing



Ice Cream and Cold
Drinks

Lanxi Cold Food
Hefei dairy



SESSION 2: Expansion of the NH₃/CO₂ refrigeration system application market

- **Seasoned Foods Process**

A central kitchen project from a leading enterprise in the prepared meal industry

- Committed to creating a series of "tens of millions of new products" including steamed dumplings and boiled dumplings
- Design of low refrigerant charge system with high-efficiency plate-and-shell heat exchanger

- **Seafood Processing**

Haidu Project—China's largest single-unit NH₃/CO₂ refrigeration system for freezing

- This system meets the demands of 12 single-unit seafood freezing devices and 120,000 tons of low-temperature logistics.
- The amount of NH₃ refrigerant required can be reduced by 90% compared to the NH₃ refrigeration system. Compared to the R22 refrigeration system, it can reduce the annual amount of R22 refrigerant required by 114 tons.



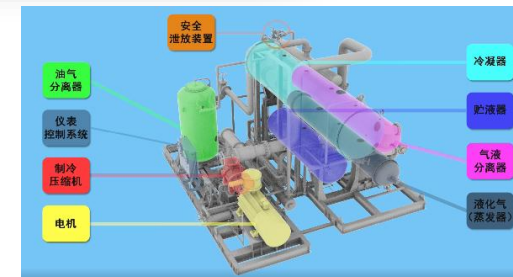
SESSION 2: Expansion of the NH₃/CO₂ refrigeration system application market

- AIST Outdoor Portable Unit**
 - Ultra-low refrigerant charge design with a plate-and-shell heat exchanger that incorporates a separate space, while the oil cooler and economizer utilize plate heat exchangers.
 - Outdoor portable unit with a design that does not require a separate machine room.
- Global Market — Achieves an overall energy saving of over 10%**
 - A company in Thailand — CO₂ Cascade and Secondary Refrigerant System.
 - A cold chain project in Indonesia — Cold storage capacity: 50,000 tons, with CO₂ cascade and secondary refrigerant system.
 - A cold chain project in Indonesia — Cold storage capacity: 50,000 tons, with CO₂ cascade and secondary refrigerant system.



- CCUS — A 2,000 tons/year lithium battery new material project in Shandong Province**

- Operating Condition: -50 °C / +36 °C



SESSION 3: Expansion of the HCs refrigeration system application market



Natural Gas Liquefaction

A Liaoning-based oil field
A Natural Gas Processing Complex in Yulin



VOCs Recovery

Vapor Recovery System for Ship Loading /
Unloading Operations at the Terminal



Polysilicon

A Silane Production Facility in Henan
A Silane Production Facility in Xuzhou

- **VOCs Recovery**

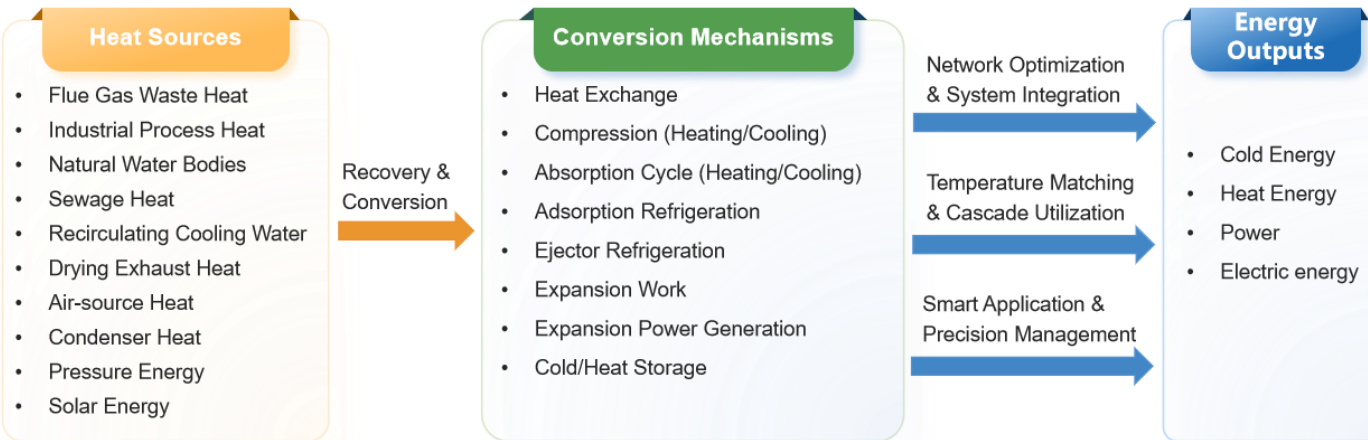
- VOCs, referring to **Volatile Organic Compounds**, cause environmental pollution and pose hazards to human health.
- Moon-tech's hydrocarbons refrigeration systems can be **custom-designed** for different types of VOCs, supported by integrated engineering services, which ensures stable system operation and achieves **excellent VOCs recovery efficiency**.

- MOON-TECH has hundreds of operational cases in HCs natural refrigerant compression, HCs/CO₂ cascade, and HCs cascade refrigeration systems, achieving broad commercial adoption.



SESSION 4: Heat Pump Based on Natural Working Fluids

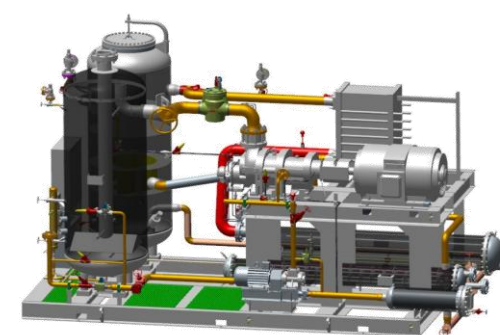
Roadmap for Integrated Energy Solutions



Heat Pump Applied to Distillation Column

Isobutane(R600A) Distillation Column Revamping Project

- Using R600A as working fluid
- Recovery overhead waste heat of R600A distillation column
- Generating high-temperature R600A for bottom heating of the distillation column
- Saving 14 tons of steam per hour, achieving annual cost savings of 16 million RMB, reducing CO₂ emissions by 27,000 tons



Heat Pump for Generating Hot Water

A Project of Charoen Pokphand Group in Fujian :A pig slaughtering project in Fujian Province with a capacity of 650 pigs per hour and an annual slaughtering volume of 2 million pigs.

- Using NH₃ as heatpump working fluid
- Recovery full condensation waste heat from refrigeration system
- Generating hot water up to 85°C for process water
- Running for 4 years, saving 10 million RMB ,reducing 12,000 tons of CO₂ emissions
- Using NH₃/CO₂ as the refrigerant



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Thank you

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Questions and Answers



Closing Remarks



Ms. Liazzat Rabbiosi

Chief, Montreal Protocol Unit

UNIDO



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Vienna Convention
MONTREAL PROTOCOL



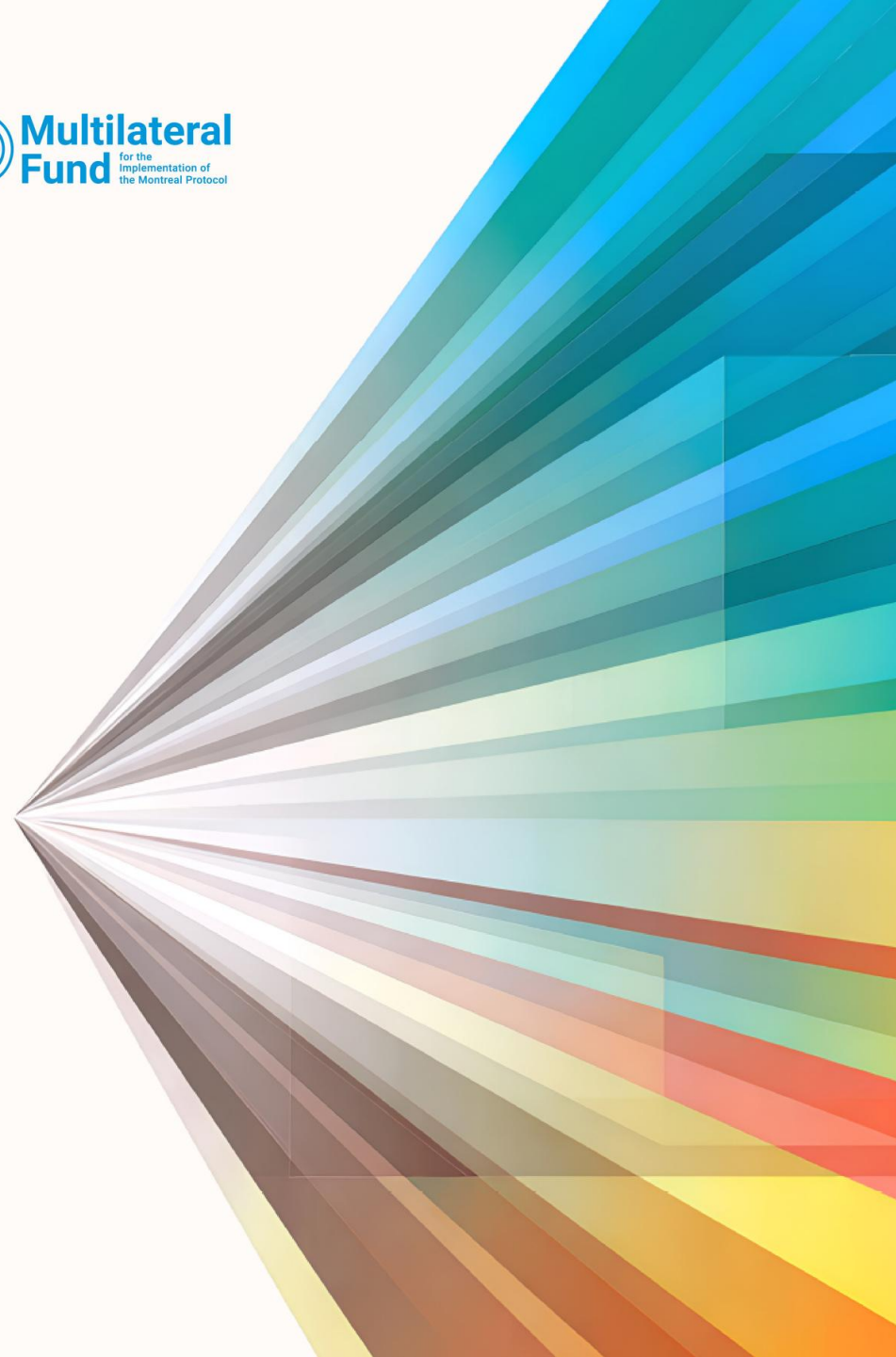
**Multilateral
Fund**
for the
Implementation of
the Montreal Protocol



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GN SEC











Global Network
Regional Sustainable
Energy Centres

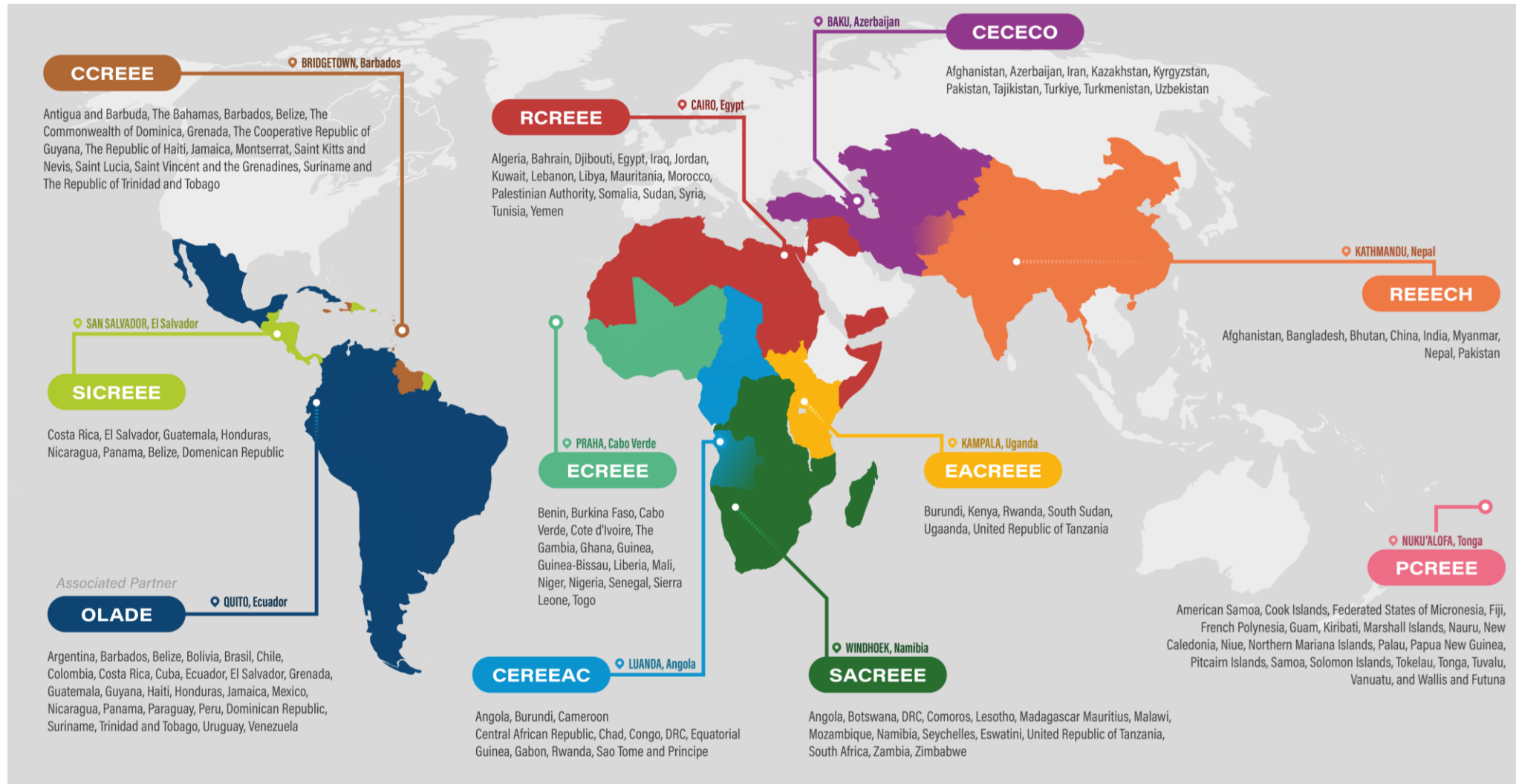
Think globally. Act regionally. Implement nationally.

ISEC 2026

The GN-SEC Platform facilitates South-South and Triangular Cooperation

Makerspace for joint:

-  Coordination
-  Learning
-  Projects
-  Replication
-  Upscaling
-  Advocacy
-  Campaigns
-  Tools
-  Knowledge
-  Fundraising



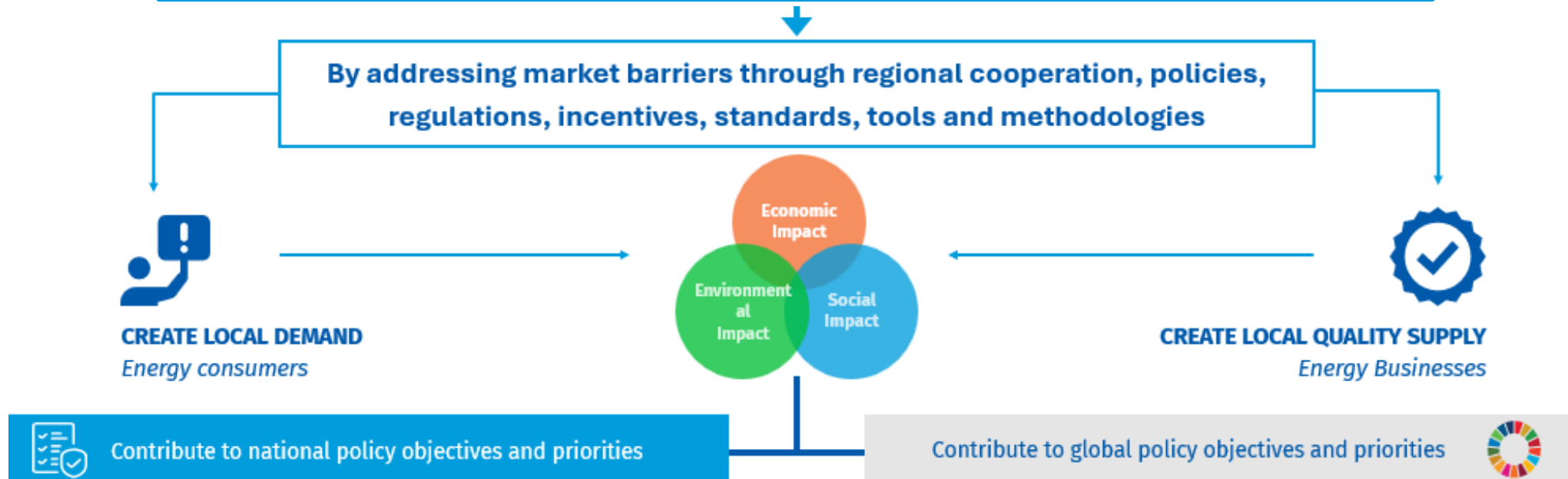
Theory of Change

Vision

To accelerate the energy transition from the regions for the regions, leveraging South-South and triangular cooperation to drive locally owned and sustainable change.

Mission

To reduce institutional, technical, and financial barriers that hinder the development and uptake of integrated and inclusive regional sustainable energy markets.



Activities and services of the regional centers

CREATE SPILL-OVER EFFECTS AND ADDRESS BARRIERS REGIONALLY



Policy, regulation and guidelines



Knowledge, analytics & awareness



Quality infrastructure & skills development



Investment, business & innovation



PROMOTE THE REGIONAL DIFFUSION AND INDUSTRIAL ROLL-OUT OF INNOVATIONS



Transferring and developing new technologies, business models and policies



Testing and demonstration of innovations



Commercializing, replicating and industrial roll-out of innovations

SCOPE OF SUPPORTED TECHNOLOGIES



Renewable Energy Solutions
(e.g. solar, wind, bioenergy, small hydro)



Energy Efficiency Solutions
(e.g. appliances, cooking, transport)



Cross-cutting and integrated solutions
(e.g. storage, hydrogen, gender and youth)

Broad range of direct beneficiaries and end-use sectors