

Table of contents

Table of contents	I
Summary	V
Zusammenfassung	VII
List of abbreviations	IX
List of figures	XI
List of tables	XIII
1 General introduction	3
1.1 Industrial biotechnology	3
1.1.1 Renewable resources	4
1.1.2 Acetate a promising example of renewable resources	6
1.2 Biosurfactants - multifunctional molecules	8
1.2.1 Applications of biosurfactants	10
1.2.2 Rhamnolipids as glycolipid example	11
1.3 Addressing foam-related issues in biosurfactant production	13
1.4 Bioprocess intensification for biosurfactants	14
1.4.1 Membrane aeration facilitates bubble-free aeration	14
1.4.2 Fermentation modes and feeding strategies for bioprocess optimization	15
1.5 <i>Alcanivorax borkumensis</i> – a biosurfactant-producing marine hydrocarbonoclastic bacterium	18
1.5.1 Glycine-glucolipid of <i>A. borkumensis</i> SK2 is cell-associated	21
1.6 Scope and outline of this thesis	23
2 Material and methods	27
2.1 Chemicals	27
2.2 Bacterial strains and media	27
2.3 Cultivations in small-scale	28
2.3.1 Shake flask – <i>Alcanivorax borkumensis</i> SK2	28
2.3.2 BioLector cultivation	28
2.3.3 Growth profiler cultivation	28
2.3.4 Transfer rate Online Measurement (TOM) cultivation	29
2.3.5 Shake flask – <i>Pseudomonas putida</i> KT2440	29
2.4 Stirred-tank bioreactor conditions	29
2.4.1 Batch fermentations with submerged bubble aeration with <i>A. borkumensis</i> SK2	29
2.4.2 Bubble-free batch fermentation with static membrane module aeration with <i>A. borkumensis</i> SK2	30
2.4.3 DO-based fed-batch fermentation with <i>A. borkumensis</i> SK2	31
2.4.4 pH-coupled fed-batch fermentation with <i>A. borkumensis</i> SK2	33

2.4.5	Batch fermentation with submerged bubble aeration with <i>P. putida</i> KT2440	33
2.4.6	Membrane-module stirrer for bubble-free aeration with <i>P. putida</i> KT2440	34
2.5	Analytical methods	35
2.5.1	Analysis of bacterial growth	35
2.5.2	Analysis of cell dry weight	35
2.5.3	Analysis of ammonium	36
2.5.4	Analysis of urea	36
2.5.5	Analysis of phosphate	36
2.5.6	Analysis of metabolites	37
2.5.7	Extraction and purification of glycine-glucolipids and aglycones	37
2.5.8	Analysis of glycine-glucolipids and aglycones	37
2.5.9	Analysis of rhamnolipids	38
2.5.10	Extraction of antifoaming agent	38
3	Results	43
3.1	High-quality physiology of <i>Alcanivorax borkumensis</i> SK2 producing glycolipids enables efficient stirred-tank bioreactor cultivation	43
3.1.1	Online growth monitoring shows nutrient limitations in ONR7a medium	43
3.1.2	Thermal optimum for growth and glycolipid production	44
3.1.3	Pyruvate is not an ideal hydrophilic carbon source	46
3.1.4	Expansion of the hydrophilic substrate spectrum	47
3.1.5	In-depth characterization of glycolipid production shows superiority of hydrophobic substrates	48
3.1.6	Cultivation in stirred-tank bioreactors increases the bioavailability of hydrophobic carbon sources	49
3.1.7	Hydrophilic substrates facilitate high-quality physiology in stirred-tank bioreactors 51	
3.1.8	Bubble-free membrane aeration prevents foam formation and thus antifoaming agent addition	52
3.1.9	Discussion	53
3.2	Optimized feeding strategies for biosurfactant production from acetate by <i>Alcanivorax borkumensis</i> SK2	61
3.2.1	Fed-batch fermentation increases glycolipid titers	61
3.2.1.1	DO-based fed-batch - a working process with bubble aeration	61
3.2.1.2	Membrane aeration sustains foam-free fermentation but with performance losses	63
3.2.2	Changing the nitrogen sources leads to improved glycolipid production	65
3.2.2.1	A promising nitrogen source – urea	65
3.2.2.2	Urea in DO-based fed-batch improves glycolipid production	67
3.2.3	Alteration of nitrogen availability leads to improved glycolipid production	69
3.2.3.1	Increasing C/N ratio enhances glycolipid production	69

3.2.3.2	A higher C/N ratio in the feed increases glycolipid amount but leads to acetate accumulation	70
3.2.3.3	Two-stage feed strategy eliminates acetate accumulation	72
3.2.3.4	Too high C/N ratio leads to acetate accumulation even with the two-stage feed strategy	74
3.2.4	pH-stat fed-batch fermentation for optimized glycolipid production	76
3.2.4.1	pH-stat fed-batch process - a highly optimized process with bubble aeration	76
3.2.4.2	Membrane aeration in pH-stat fed-batch sustains foam-free fermentation without performance loss	78
3.2.5	Discussion	80
3.3	A novel membrane stirrer system enables foam-free biosurfactant production	87
3.3.1	Foaming is the major problem during rhamnolipid production in aerated stirred-tank bioreactors	87
3.3.2	Membrane-module stirrer for foam-free rhamnolipid production	89
3.3.2.1	Rhamnolipid production with <i>P. putida</i> KT2440 SK4 in batch mode	89
3.3.2.2	Improving energy efficiency leads to increased rhamnolipid productivity	91
3.3.3	Nitrogen limitation leads to decreased recombinant rhamnolipid productivity	92
3.3.4	Process intensification by a tailored fed-batch strategy	94
3.3.4.1	KT2440 SK4 chassis in fed-batch mode	94
3.3.4.2	Energy-efficient chassis underperforms in intensified fermentation	96
3.3.5	Discussion	98
4	General discussion and outlook	103
4.1	<i>Alcanivorax borkumensis</i> as production host	103
4.2	Engineering aspects of biosurfactant up-scaling	105
4.3	Challenges and opportunities in utilizing alternative feedstocks	107
4.4	Conclusion and outlook	110
	Appendix	113
	References	121
	Curriculum vitae	141