

FIGURE 34

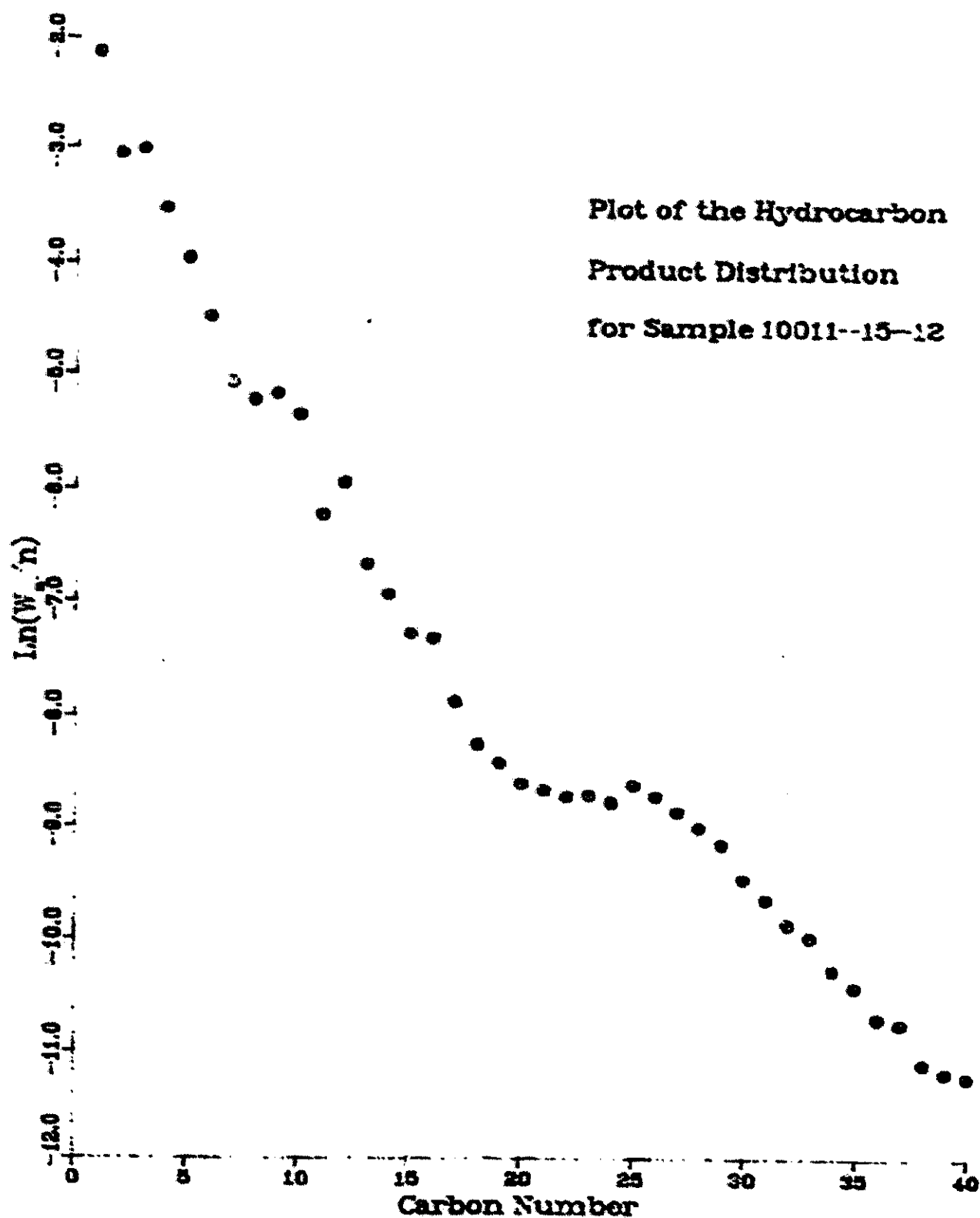


FIGURE 35

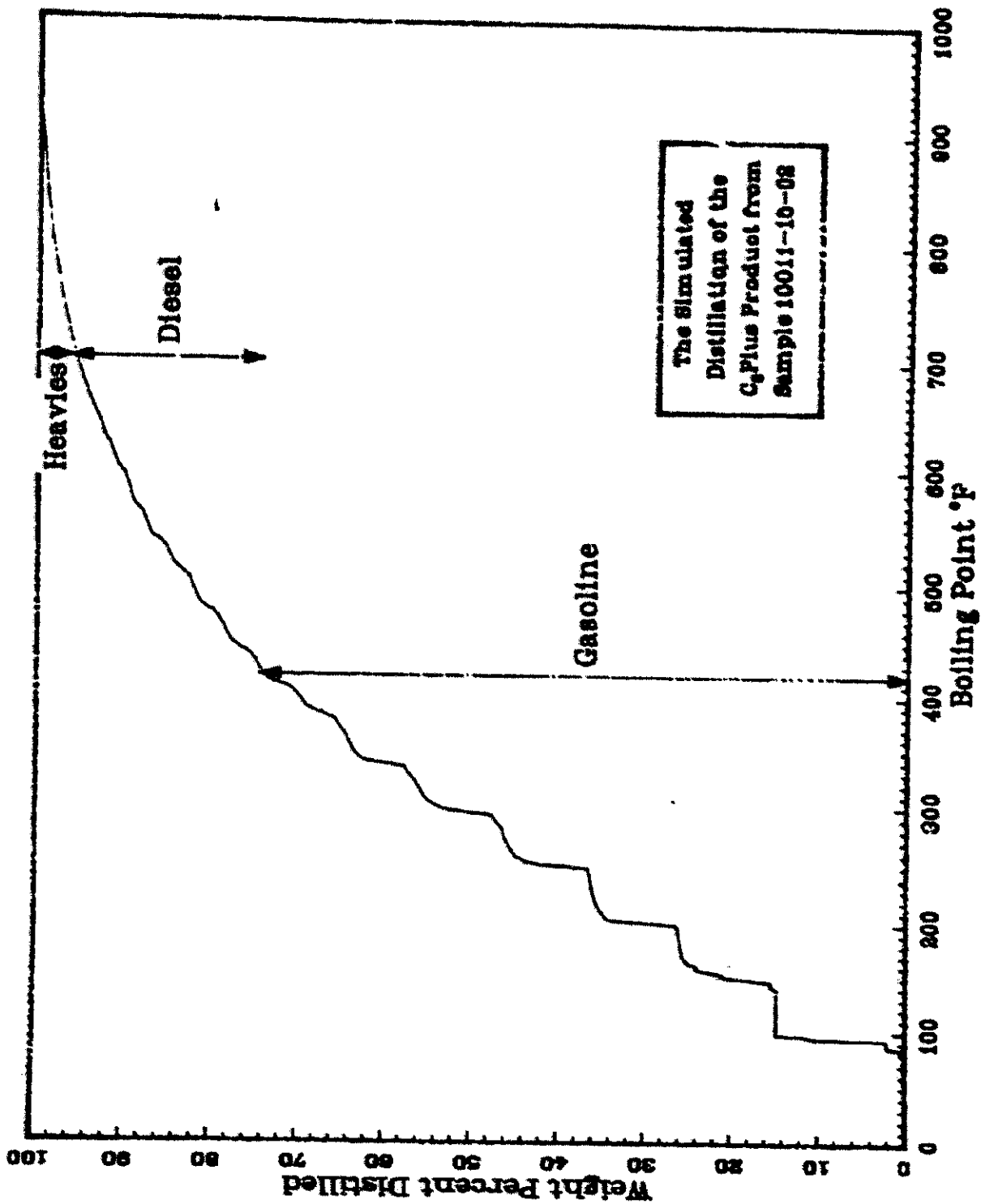


FIGURE 36

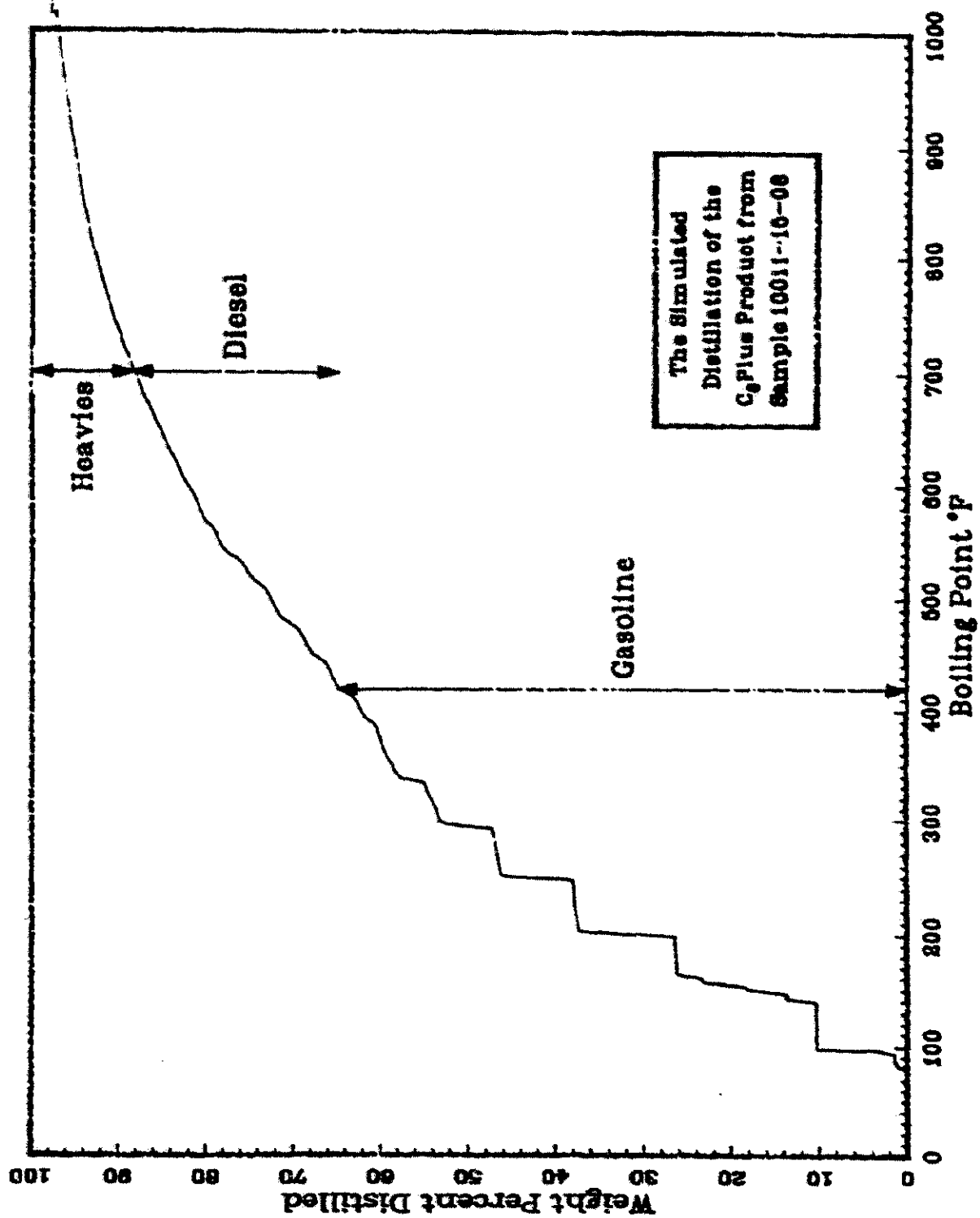
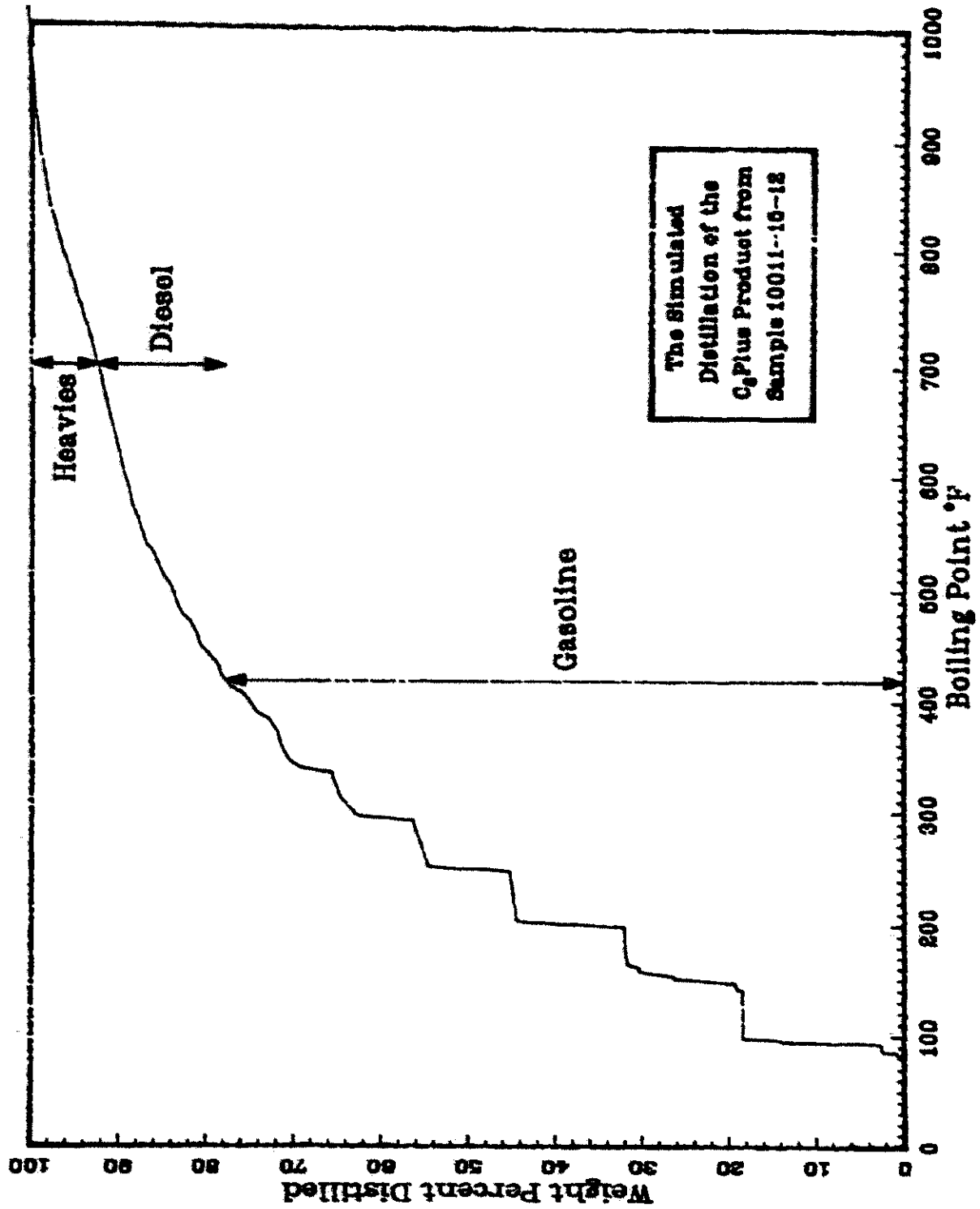


FIGURE 37



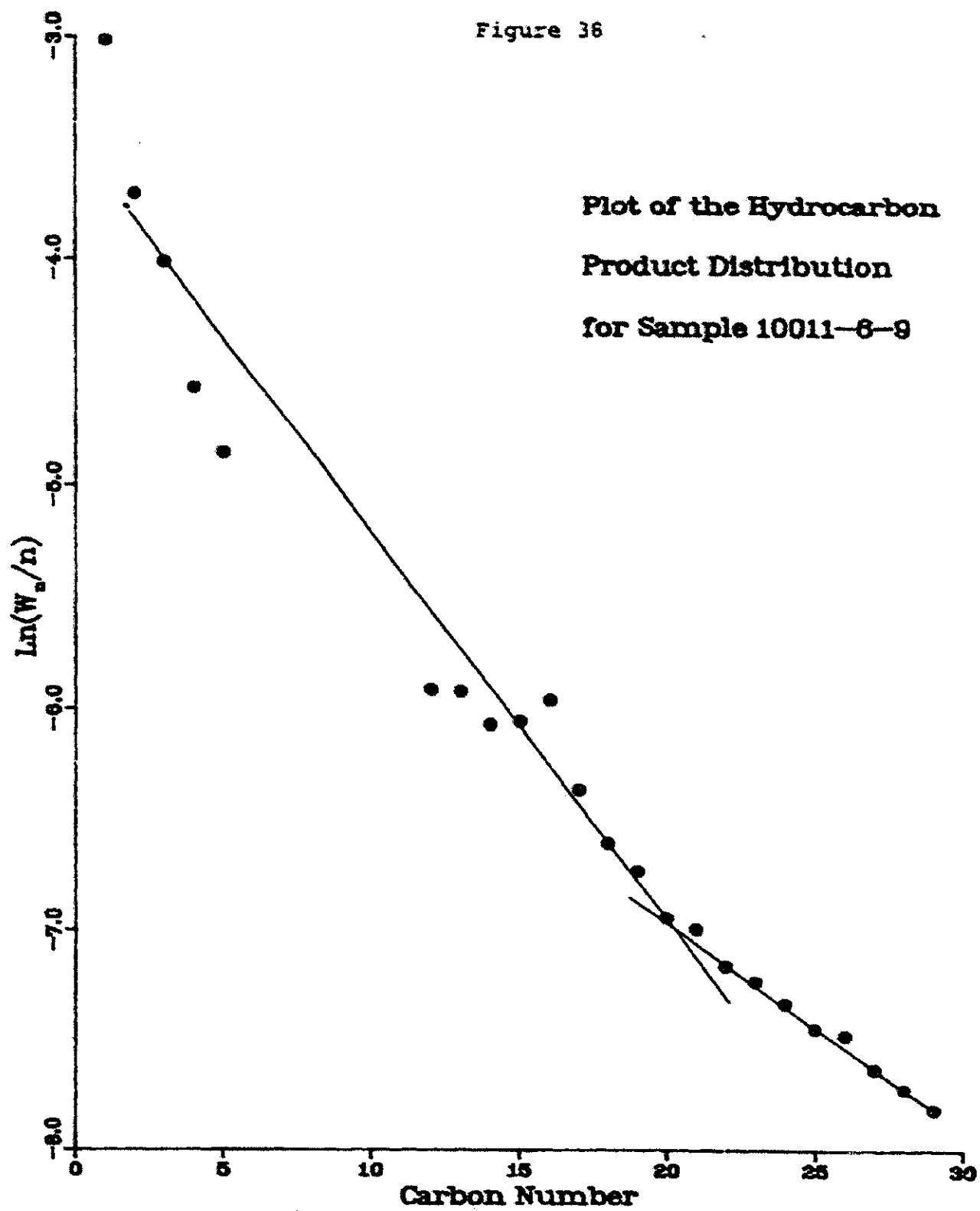
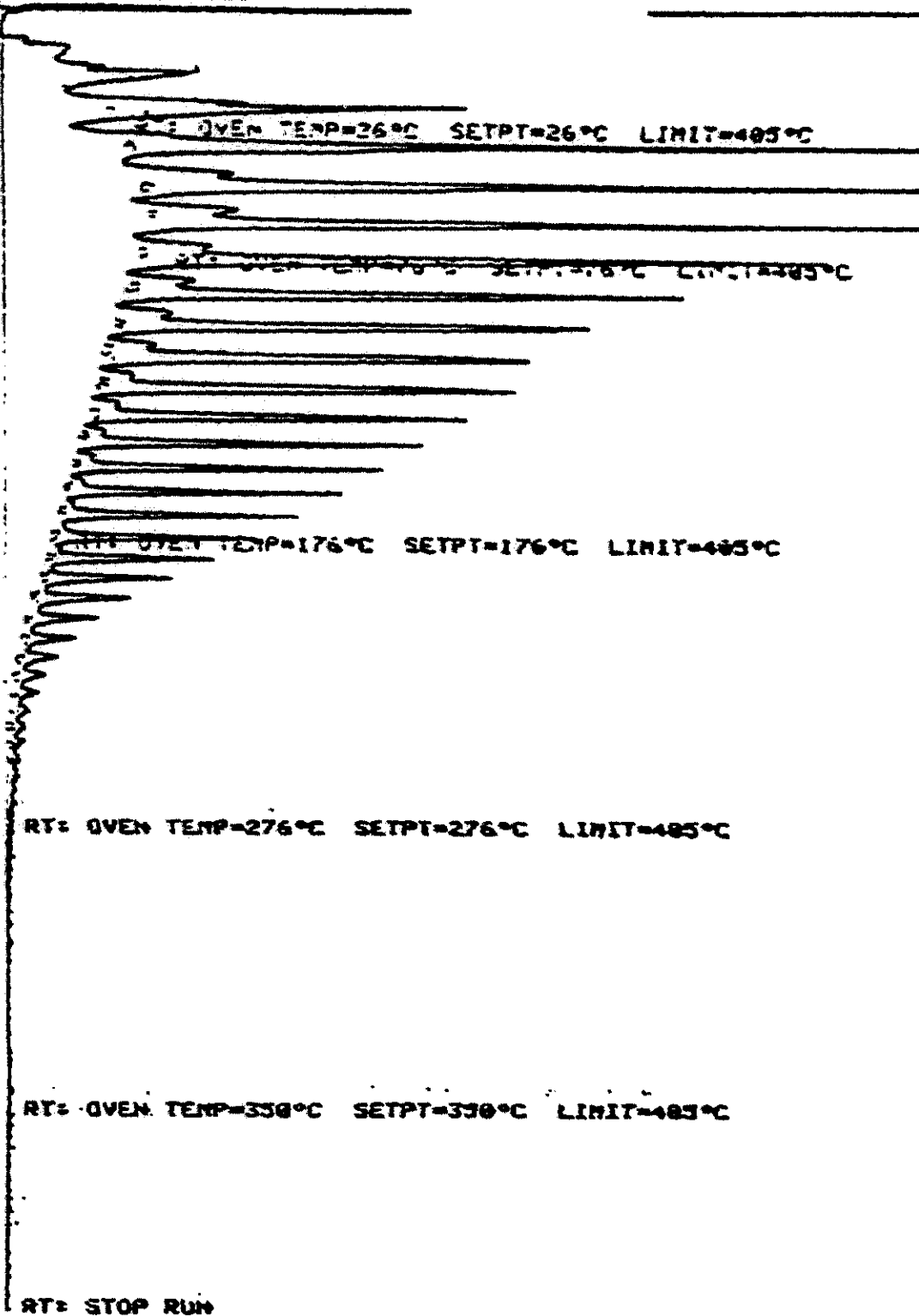


FIGURE 39

RT: SLICES 9.28



SAMPLE:D1011-15-4L

FIGURE 40

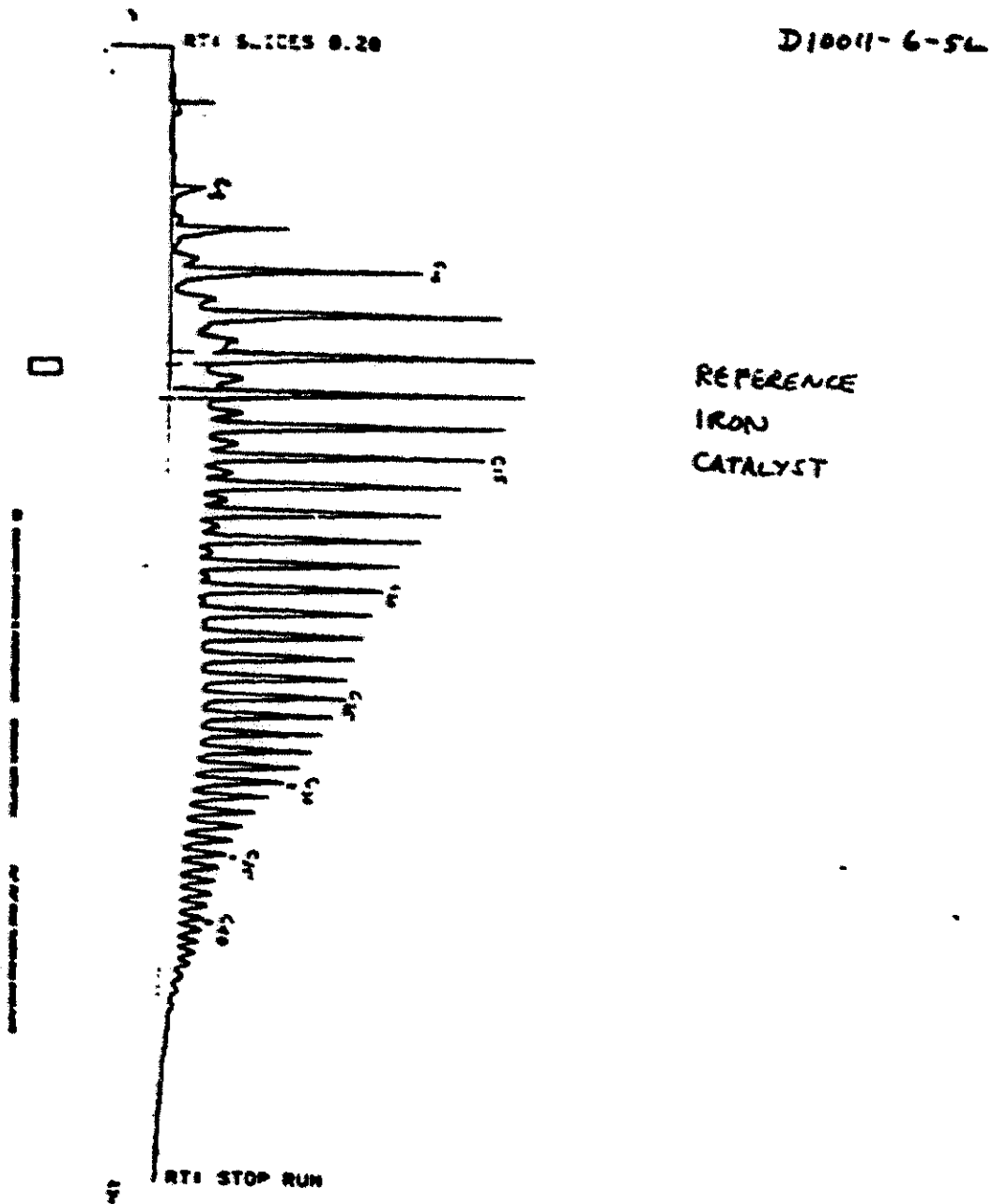


TABLE 9A

RESULT OF SYNGAS OPERATION

RUN NO.	10011-15				
CATALYST	PPT-Fe,K +AL2O3 #10042-17 80CC 84.2G (98.7 AFTER RUN,+14.5G)				
FEED	H2:CO:ARGON OF 50:50: 0 @ 400 CC/MN OR 300 GHSV				
RUN & SAMPLE NO.	10011-15-01	011-15-02	011-15-03	011-15-04	011-15-05
FEED H2:CO:AR	50:50: 0	50:50: 0	50:50: 0	50:50: 0	50:50: 0
HRS ON STREAM	5.0	21.67	28.84	46.34	51.34
PRESSURE,PSIG	295	300	301	288	290
TEMP. C	250	251	251	251	251
FEED CC/MIN	400	400	400	400	400
HOURS FEEDING	5.00	21.67	7.17	24.67	5.00
EFFLNT GAS LITER	53.97	256.20	89.67	312.25	70.95
GM AQUEOUS LAYER	3.69	15.99	4.80	16.53	1.72
GM OIL	5.29	22.94	9.16	31.54	5.72
MATERIAL BALANCE					
GM ATOM CARBON %	91.14	96.55	104.03	101.92	101.78
GM ATOM HYDROGEN %	91.44	96.04	103.52	100.89	99.76
GM ATOM OXYGEN %	98.08	106.77	110.12	107.33	104.71
RATIO CHX/(H2O+CO2)	0.8669	0.8180	0.8936	0.8982	0.9351
RATIO X IN CHX	2.1789	2.2016	2.1927	2.1870	2.1900
USAGE H2/CO PRODT	0.6525	0.6259	0.6436	0.6565	0.6329
RATIO CO2/(H2O+CO2)	0.8081	0.8189	0.8338	0.8205	0.8644
K SHIFT IN EFFLNT	35.65	34.39	36.54	16.90	14.65
CONVERSION					
ON CO %	95.83	95.19	94.99	89.61	79.70
ON H2 %	64.80	63.23	63.33	61.19	52.40
ON CO+H2 %	80.29	79.25	79.20	75.47	66.19
PRDT SELECTIVITY,WT %					
CH4	6.70	7.52	7.15	6.94	7.01
C2 HC'S	7.49	8.12	7.55	7.19	6.90
C3H8	1.76	1.93	1.89	1.82	1.86
C3H6=	11.12	11.38	10.84	9.59	8.86
C4H10	1.73	1.80	1.75	1.68	1.78
C4H8=	9.17	8.93	8.64	7.66	7.36
C5H12	2.45	2.51	2.43	2.25	2.25
C5H10=	7.23	6.34	6.17	5.38	5.32
C6H14	2.22	2.21	2.18	2.06	2.20
C6H12= & CYCLO'S	4.24	4.09	3.91	3.65	3.74
C7+ IN GAS	12.53	12.37	11.90	13.62	14.06
LIQ HC'S	33.36	32.80	35.60	38.16	38.65

TOTAL	100.00	100.00	100.00	100.00	100.00
SUB-GROUPING					
C1 -C4	37.96	39.67	37.82	34.87	33.77
C5 - 420 F	46.03	44.68	43.31	45.06	43.43
420-700 F	13.35	13.06	15.67	16.71	17.78
700-END PT	2.67	2.59	3.20	3.36	5.03
C5+ -END PT	62.04	60.33	62.18	65.13	66.23
ISO/NORMAL MOLE RATIO					
C4	0.1399	0.1338	0.1330	0.1194	0.1093
C5	0.1575	0.1540	0.1589	0.1733	0.1614
C6	0.1980	0.1989	0.2115	0.1862	0.1646
C4=	0.0000	0.0000	0.0000	0.0000	0.0000
PARAFFIN/OLEFIN RATIO					
C3	0.1509	0.1617	0.1660	0.1807	0.2006
C4	0.1817	0.1942	0.1960	0.2122	0.2331
C5	0.3302	0.3841	0.3820	0.4063	0.4108
LIQ HC COLLECTION					
PHYS. APPEARANCE	---	CLDY OIL	---	CLDY OIL	---
DENSITY	---	0.773	---	0.777	---
N. REFRACTIVE INDEX	---	1.4302	---	1.4291	---
SIMULT'D DISTILLATE					
10 WT % @ DEG F	---	258	---	280	---
16	---	295	---	303	---
50	---	413	---	436	---
84	---	610	---	630	---
90	---	673	---	690	---
RANGE(16-84 %)	---	315	---	327	---
WT % @ 420 F	---	52.30	---	47.40	---
WT % @ 700 F	---	92.10	---	91.20	---

TABLE 9B

RESULT OF SYNGAS OPERATION

RUN NO. 10011-15

CATALYST PPT-FE, K +AL2O3 #10042-77 BOCC 84.2G (98.7 AFTER RUN, +14.5G)

FEED H2:CO:ARGON OF 50:50: 0 & 60:30:10 @ 400 CC/MN OR 300 GHSV

RUN & SAMPLE NO.	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
DATE	10/15/15	10/15/15	10/15/15	10/15/15	10/15/15
TIME	10:00	10:00	10:00	10:00	10:00
LOCATION	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WIND DIRECTION	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WIND SPEED	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
TEMPERATURE	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
HUMIDITY	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
PRESSURE	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
SEA STATE	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
CLOUD COVER	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
VISIBILITY	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE HEIGHT	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
SWELL PERIOD	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
SWELL DIRECTION	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE PERIOD	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE DIRECTION	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE SLOPE	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE FREQUENCY	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Wavelength	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Amplitude	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Energy	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Power	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Force	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Pressure	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Stress	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Torque	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Moment	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Acceleration	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Velocity	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Displacement	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Strain	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Stress Intensity Factor	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Fatigue Crack Growth Rate	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Fracture Toughness	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Residual Strength	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Ultimate Tensile Strength	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Yield Strength	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Elastic Modulus	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Poisson's Ratio	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Thermal Expansion Coefficient	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Thermal Conductivity	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Thermal Diffusivity	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Specific Heat Capacity	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Density	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Viscosity	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Surface Tension	10011-15-06	011-15-07	011-15-08	011-15-09	011-15-10
WAVE Contact Angle	10011-15-				

FEED H2:CO:AR	50:50: 0	50:50: 0	50:50: 0	60:30:10	60:30:10
HRS ON STREAM	70.59	74.74	93.74	100.74	117.24
PRESSURE,PSIG	293	292	295	290	298
TEMP. C	251	251	250	281	281

FEED CC/MIN	400	400	400	400	400
HOURS FEEDING	24.25	4.25	23.25	7.00	23.50
EFFLNT GAS LITER	361.89	63.43	354.14	100.20	348.52
GM AQUEOUS LAYER	8.36	1.30	7.09	8.28	27.79
GM OIL	27.74	5.30	28.99	5.93	19.90

MATERIAL BALANCE

GM ATOM CARBON %	104.61	104.83	104.42	108.82	111.52
GM ATOM HYDROGEN %	101.66	102.96	102.10	102.25	105.17
GM ATOM OXYGEN %	109.05	107.49	106.13	100.39	103.04
RATIO CHX/(H2O+CO2)	0.9032	0.9408	0.9591	1.1446	1.1425
RATIO X IN CHX	2.1938	2.1861	2.1877	2.2663	2.2692
USAGE H2/CO PRODT	0.6208	0.6286	0.6460	1.0702	1.0619
RATIO CO2/(H2O+CO2)	0.8638	0.8709	0.8605	0.5552	0.5619
K SHIFT IN EFFLNT	13.40	14.69	11.44	13.22	13.62

CONVERSION

ON CO %	77.36	77.67	72.96	91.07	90.95
ON H2 %	50.77	50.52	48.74	49.66	49.07
ON CO+H2 %	64.26	64.22	60.98	64.04	63.58

PRDT SELECTIVITY, WT %

CH4	7.25	6.92	7.03	10.54	10.55
C2 HC'S	6.72	6.53	6.43	8.33	4.17
C3H8	1.91	1.80	1.75	2.26	2.35
C3H6=	8.81	8.21	7.82	10.80	10.71
C4H10	1.84	1.73	1.64	1.99	2.04
C4H8=	6.79	6.65	6.19	7.97	8.46
C5H12	2.14	2.12	2.01	2.40	2.39
C5H10=	4.84	4.86	4.53	6.60	6.26
C6H14	2.04	2.00	1.90	2.25	2.27
C6H12= & CYCLO'S	3.47	3.37	3.10	3.89	3.83
C7+ IN GAS	14.83	13.78	13.37	13.01	13.57
LIQ HC'S	39.37	42.02	44.23	29.97	29.40

TOTAL	100.00	100.00	100.00	100.00	100.00
SUB-GROUPING					
C1 -C4	33.31	31.84	30.85	41.85	42.28
C5 -420 F	43.38	35.80	35.22	35.99	36.02
420-700 F	18.27	21.43	22.60	13.85	13.58
700-END PT	5.04	10.92	11.32	8.27	8.11
C5+ -END PT	66.69	68.16	69.15	58.11	57.72
ISO/NORMAL MOLE RATIO					
C4	0.0978	0.1020	0.0969	0.1086	0.1048
C5	0.1530	0.1467	0.1491	0.1607	0.1573
C6	0.1812	0.1540	0.1803	0.2030	0.1939
C4=	0.0000	0.0000	0.0000	0.0000	0.0000
PARAFFIN/OLEFIN RATIO					
C3	0.2064	0.2094	0.2138	0.1994	0.2099
C4	0.2612	0.2513	0.2555	0.2413	0.2325
C5	0.4293	0.4250	0.4303	0.3531	0.3701
LIQ HC COLLECTION					
PHYS. APPEARANCE	CLDY OIL	- -	CLDY OIL	---	CLDY OIL
DENSITY		---		---	
N, REFRACTIVE INDRX		---		---	
SIMULT'D DISTILATN					
10 WT % @ DEG F	302	---	352	---	337
16	334	---	392	---	380
50	460	---	538	---	539
84	672	---	800	---	799
90	730	---	912	---	889
RANGE(16-84 %)	338	---	408	---	419
WT % @ 420 F	40.80	---	23.30	---	26.20
WT % @ 700 F	87.20	---	74.40	---	72.40

TABLE 9C

RESULT OF SYNGAS OPERATION

RUN NO. 10011-15
 CATALYST PPT- FE, K +AL2O3 #10042-77 80CC 84.2G (98.7 AFTER RUN, +14.5G)
 FEED H2:CO:ARGON OF 60:30:10 @ 400 CC/MIN OR 300 GHSV

RUN & SAMPLE NO. 10011-15-11 011-15-12 011-15-13

	60:30:10	60:30:10	60:30:10
FEED H2:CO:AR	60:30:10	60:30:10	60:30:10
HRS ON STREAM	125.49	141.49	147.49
PRESSURE, PSIG	298	296	298
TEMP. C	281	281	281
FEED CC/MIN	400	400	400
HOURS FEEDING	8.25	24.25	6.00
EFFLNT GAS LITER	124.29	361.10	87.95
GM AQUEOUS LAYER	10.10	29.70	7.42
GM OIL	4.15	12.21	3.17

MATERIAL BALANCE

	103.09	102.67	102.84
GM ATOM CARBON %	103.09	102.67	102.84
GM ATOM HYDROGEN %	103.74	103.40	102.61
GM ATOM OXYGEN %	103.66	103.26	103.01
RATIO CHX/(H2O+CO2)	0.9907	0.9905	0.9972
RATIO X IN CHX	2.3072	2.3031	2.2934
USAGE H2/CO PRODT	1.0158	1.0057	1.0077
RATIO CO2/(H2O+CO2)	0.5614	0.3683	0.5664
K SHIFT IN EFFLNT	18.03	25.46	26.16

CONVERSION

	92.39	94.52	94.81
ON CO %	92.39	94.52	94.81
ON H2 %	46.77	47.33	47.92
ON CO+H2 %	61.92	62.98	63.57

PRDT SELECTIVITY, WT %

	11.99	11.91	11.50
CH4	11.99	11.91	11.50
C2 HC'S	9.45	9.44	9.23
C3H8	2.72	2.64	2.58
C3H6=	12.16	12.13	11.98
C4H10	2.40	2.28	2.27
C4H8=	9.74	9.50	9.59
C5H12	2.78	2.65	2.67
C5H10=	7.48	6.93	6.96
C6H14	2.64	2.54	2.51
C6H12= & CYCLO'S	4.45	4.21	4.29
C7+ IN GAS	14.70	16.53	16.40
LIQ HC'S	19.48	19.23	20.02

TOTAL	100.00	100.00	100.00
SUB-GROUPING			
C1 - C4	48.46	47.90	47.14
C5 -420 F	39.66	40.37	39.98
420-700 F	7.73	7.63	8.77
700-END PT	4.15	4.10	4.10
C5+END PT	51.54	52.10	52.86
ISO/NORMAL MOLE RATIO			
C4	0.1064	0.1060	0.1049
C5	0.1478	0.1464	0.1570
C6	0.2084	0.2065	0.2032
C4=	0.0000	0.0000	0.0000
PARAFFIN/OLEFIN RATIO			
C3	0.2137	0.2073	0.2052
C4	0.2381	0.2315	0.2281
C5	0.3617	0.3721	0.3732
LIQ HC COLLECTION			
PHYS. APPEARANCE	---	CLDY SLD	CLDY SLD
DENSITY	---		
N, REFRACTIVE INDEX	---		
SIMULT'D DISTILLATN			
10 WT % @ DEG F	---	309	319
16	---	339	348
50	---	474	480
84	---	752	755
90	---	805	813
RANGE(16-84 %)	---	413	407
WT % @ 420 F	---	39.00	35.75
WT % @ 700 F	---	78.70	79.50

Physical Mixture of Potassium Promoted Iron and UCC-104, Run 10011-10

This physical mixture was synthesized from the same metal component that was used in the previously reported physical mixtures used in Runs 10011-6 and 10011-15. In this catalyst the SSC was UCC-104, one of the best Task 1 catalysts.

The conversion, product selectivity, percent iso- of the pentanes and percent olefins of the C_4 's are presented in Figures 41 to 44. The Schultz-Flory product distributions are shown in Figures 45 to 57. The C_5^+ product distributions of selected samples are shown in Figures 58 to 61. Tables 10A through 10E contain the detailed material balance and selectivity data.

The metal component again had high initial syngas conversion with characteristics similar to those seen with the physical mixture with $\alpha\text{-Al}_2\text{O}_3$. This catalyst did not deactivate initially as other catalyst had. The temperature increase from 250°C to 280°C did not significantly alter the conversion or the H_2/CO usage ratio. These are characteristics of the metal component and therefore they should be similar to Run 10011-15. The cause of the differences between these two runs could be due to slight changes in the activation or process parameters or even possibly an effect of the molecular sieve. Further tests will help clarify this.

The product distribution is very different from that produced in Run 10011-6 or 10011-15. This catalyst produces more gaseous hydrocarbons than other catalysts (the reference iron or the physical mixture with $\alpha\text{-Al}_2\text{O}_3$. The methane yield is above 10% and increased steadily over the run. The total C_5^+ decreased steadily. The C_5^+ product accounted for only 50% of the total hydrocarbons produced. This dropped to 35% by the end of the run at 280°C. The carbon number product distributions, Figures 45 to 57, have some unusual features. There are marked deviations from a linear distribution even in samples not immediately following a process change. The later samples at the initial process conditions seem to have a double α with excess products in the C_{20}^+ range. This is very similar to what was seen in Run 10011-6 with the reference iron catalyst. In this case, the effect could be due to the molecular sieve. One effect of the sieve in these catalysts is

to intercept intermediates. This affects the probability of chain growth, α . If the molecular sieve could not intercept the larger intermediates, possibly for diffusional reasons, the α of the heavier hydrocarbons could be greater than those of the lighter hydrocarbons. At 280°C the S-F distribution shows curvature, again giving less of the intermediate weight hydrocarbons.

Almost all the C_5^+ product boils in the gasoline range with some diesel oil but very little heavier. The quality of this gasoline should be significantly better than that of normal F-T catalysts. The C_4 's show the product started out olefinic but became more paraffinic as the run continued. The refractive index of the liquid does not follow this trend. The liquid product does become more paraffinic with time at 250°C but at 280°C, the liquid becomes olefinic again and remains that way through the run. The iso-normal ratio of the pentanes shows a sharp drop with time on stream. The chromatograms from the simulated distillations presented in Figures 62 to 65, again show this is not the case for the liquid as a whole. The liquid product is highly isomerized throughout the run. The gasoline produced should have a high octane number because it is so isomerized. There was insufficient volume of liquid to determine the octane number. Preparation of such a large volume of liquid is outside the range of the exploratory portion of this task but such testing of the promising catalysts will commence soon.

The yield of gasoline and diesel oil produced by this catalyst is not extraordinarily high, but it is not unacceptable. It compares well with the other iron based catalysts. The remarkable aspect is the indication of superior quality of the gasoline. This liquid product is more isomerized than that from the physical mixture with UCC-101, run 10011-9. The chromatogram from the simulated distillation of one of the samples from Run 10011-9 is shown in Figure 66. The liquid from the present run is more isomerized and probably much higher octane.

1001110

1:1 H₂:CO
300 PSIG
250°C

280°C

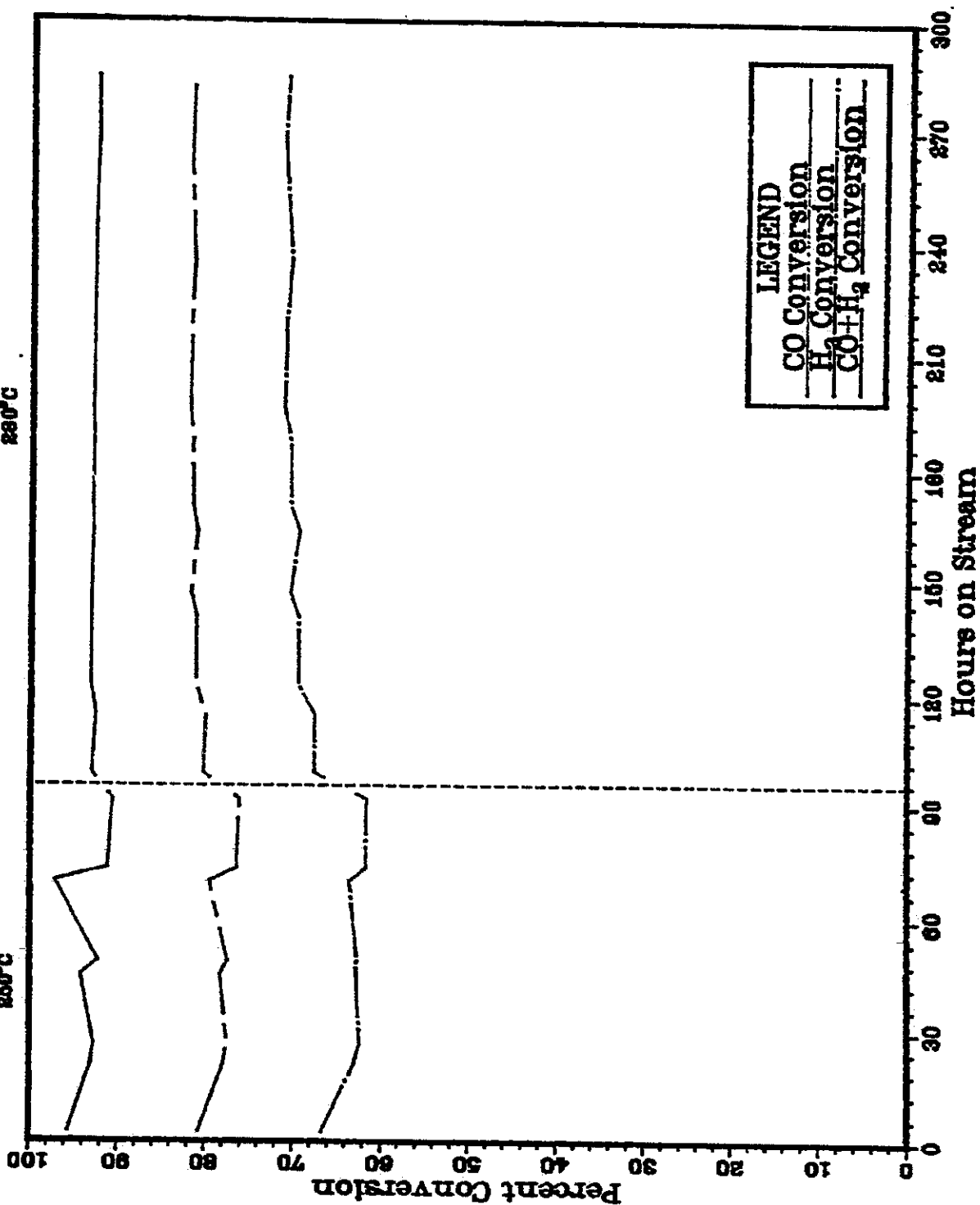


FIGURE 41

10011110

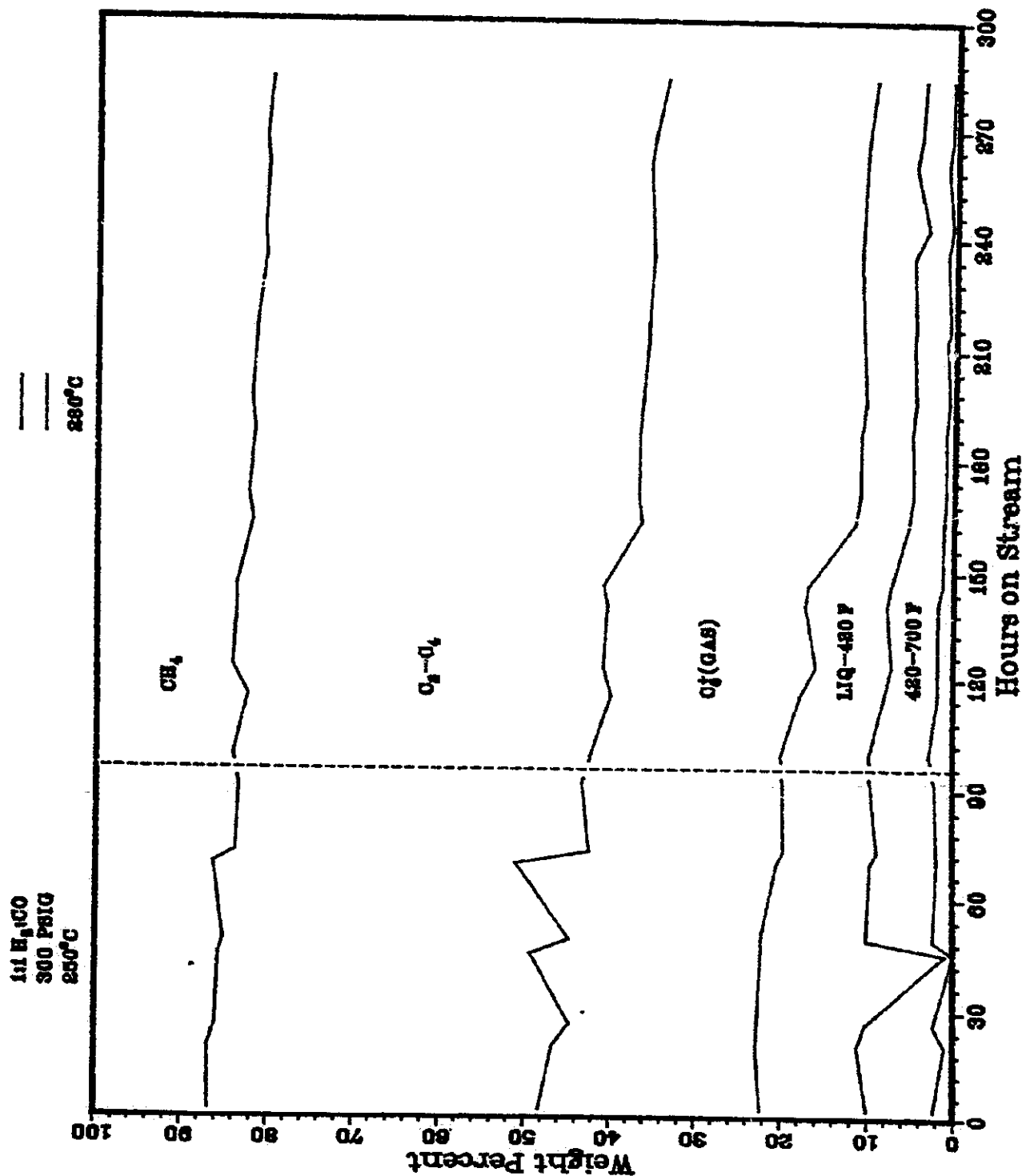
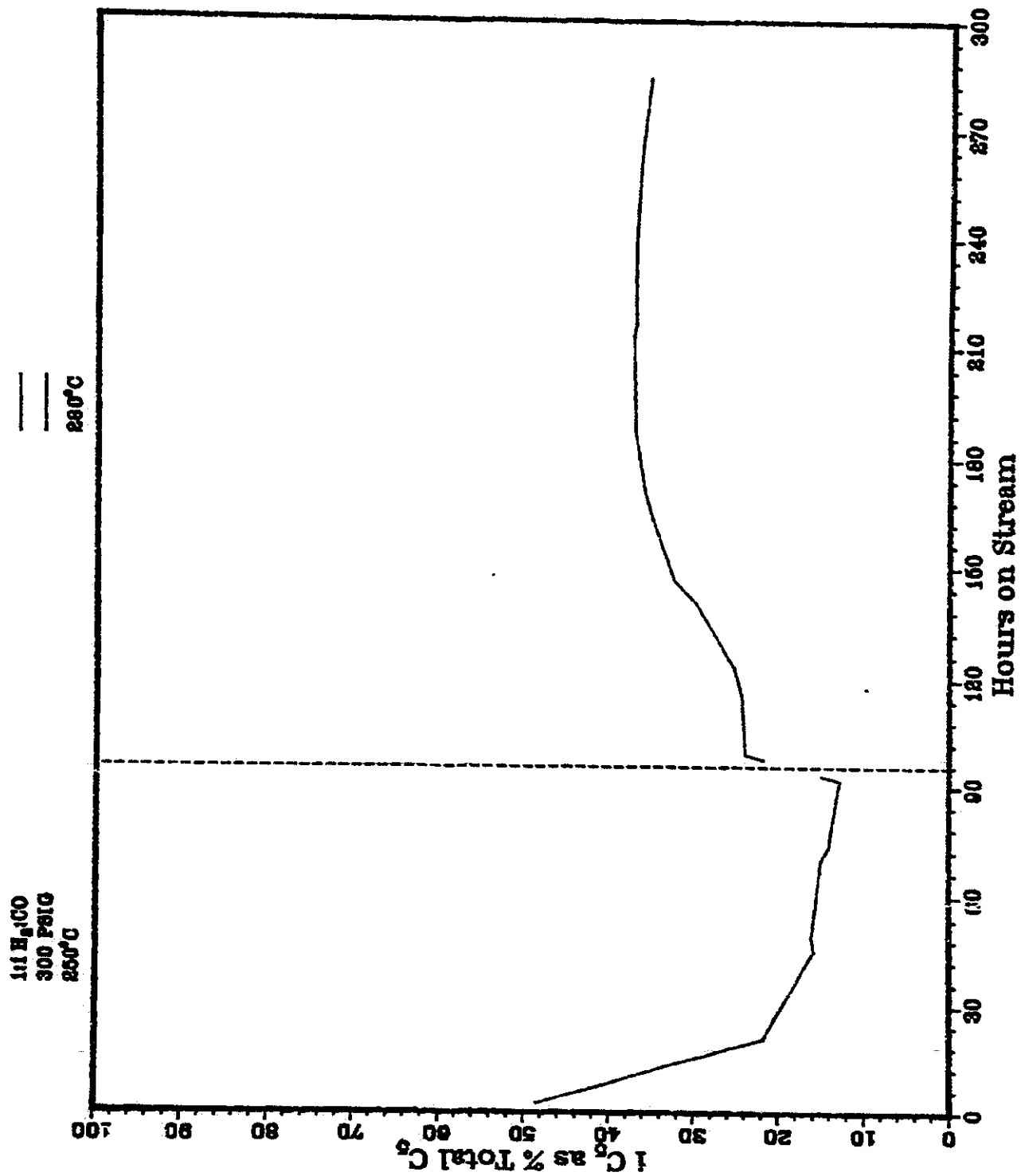


FIGURE 42

1001110

FIGURE 43



1001110

FIGURE 44

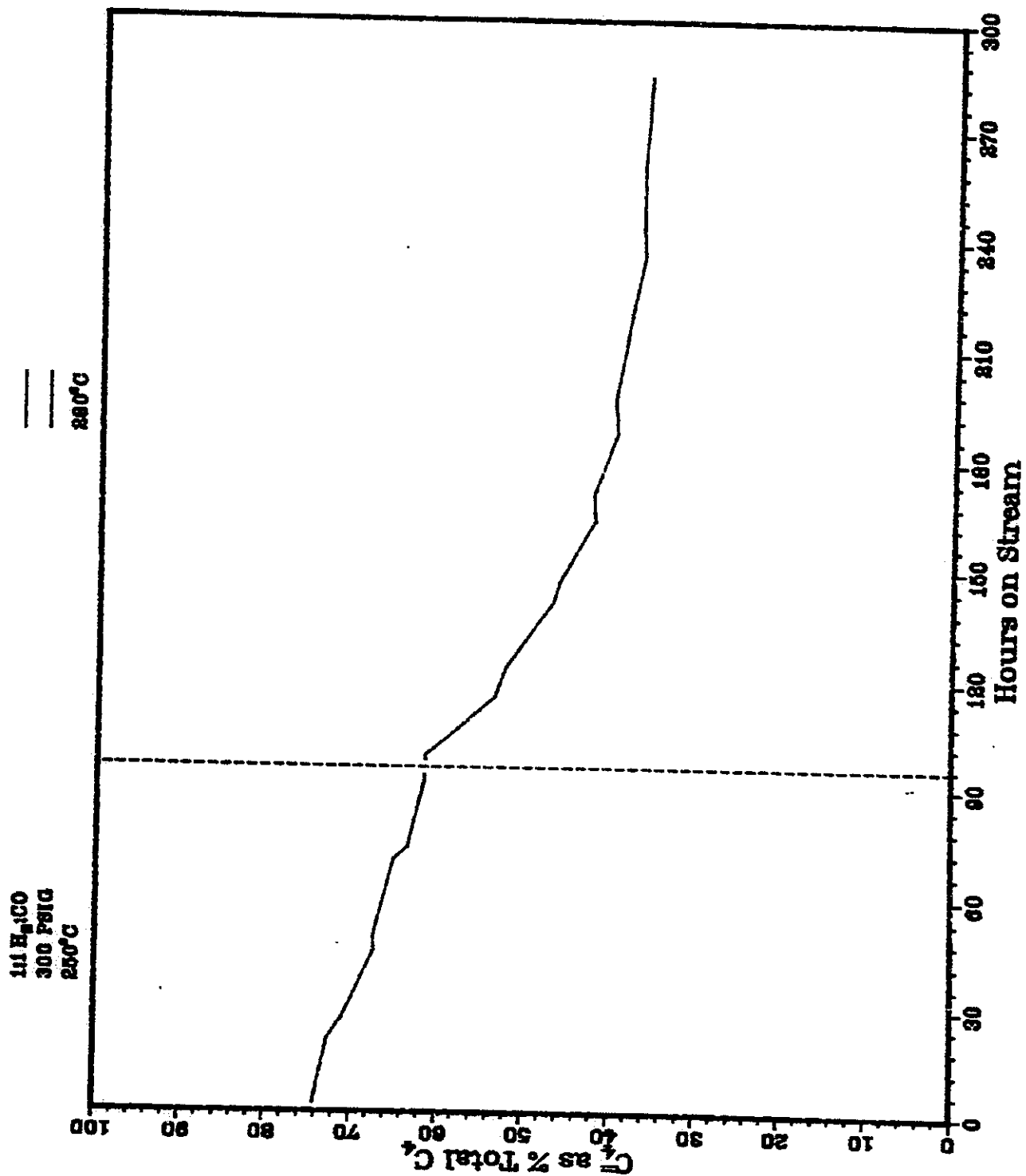


FIGURE 45

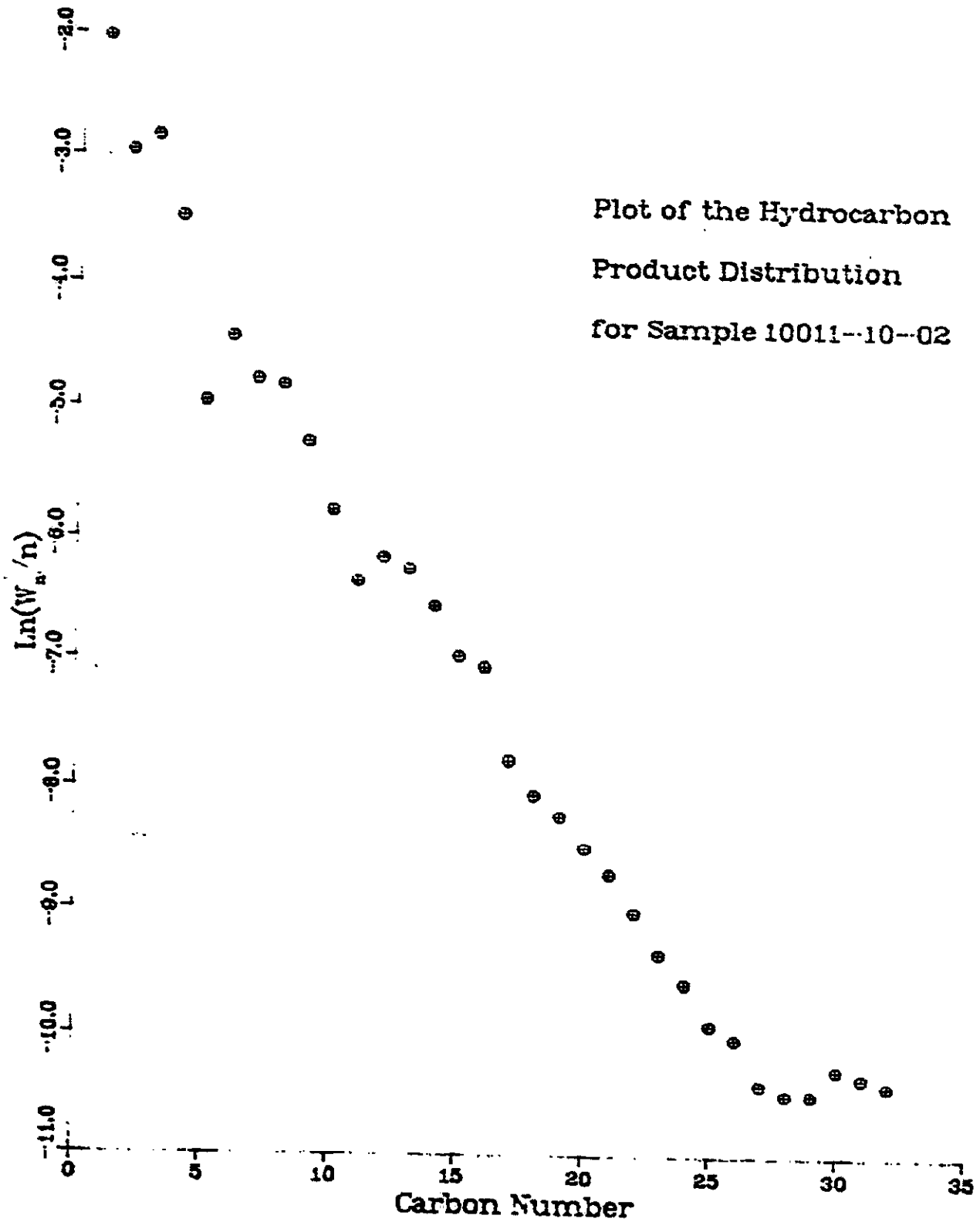


FIGURE 46

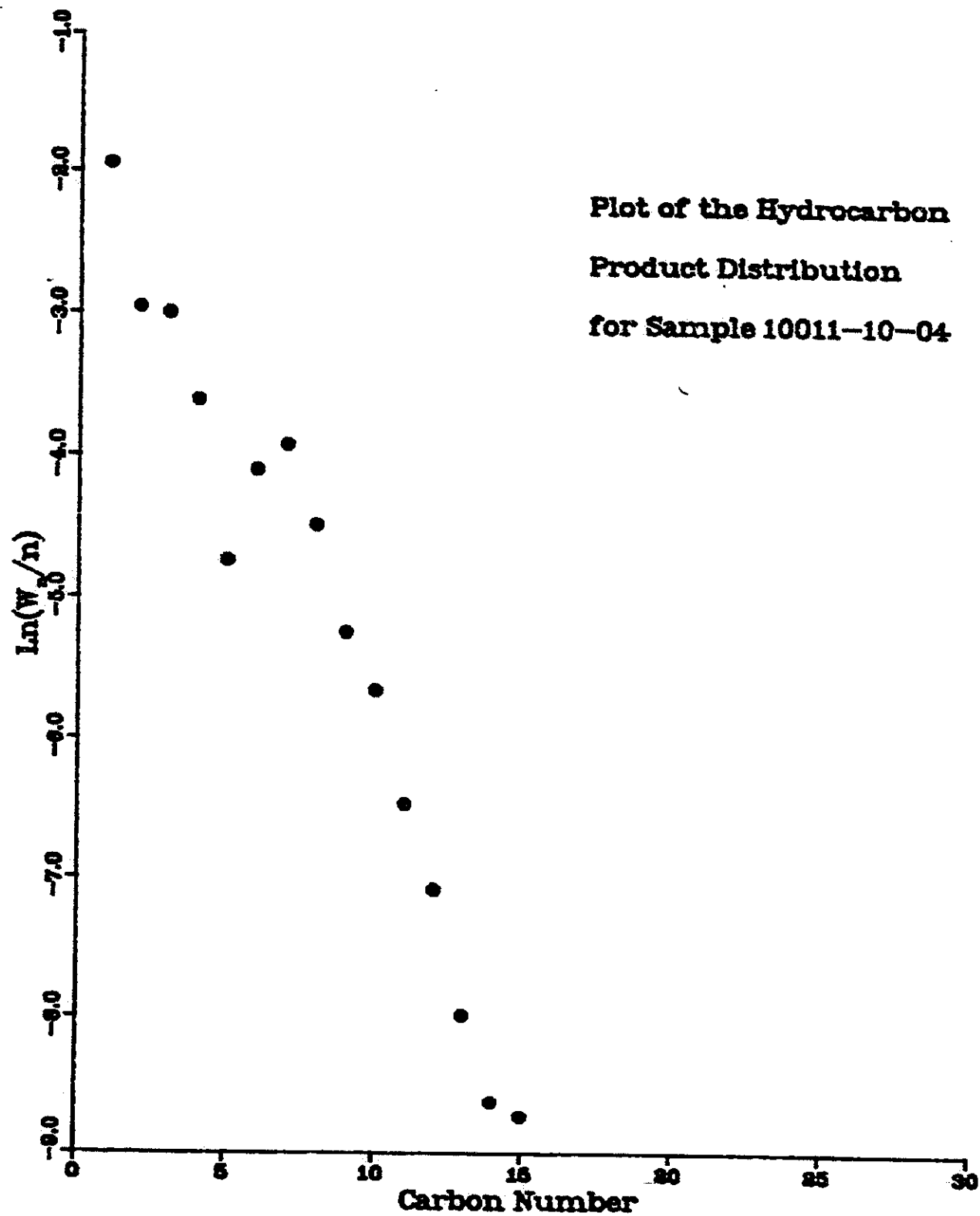


FIGURE 47

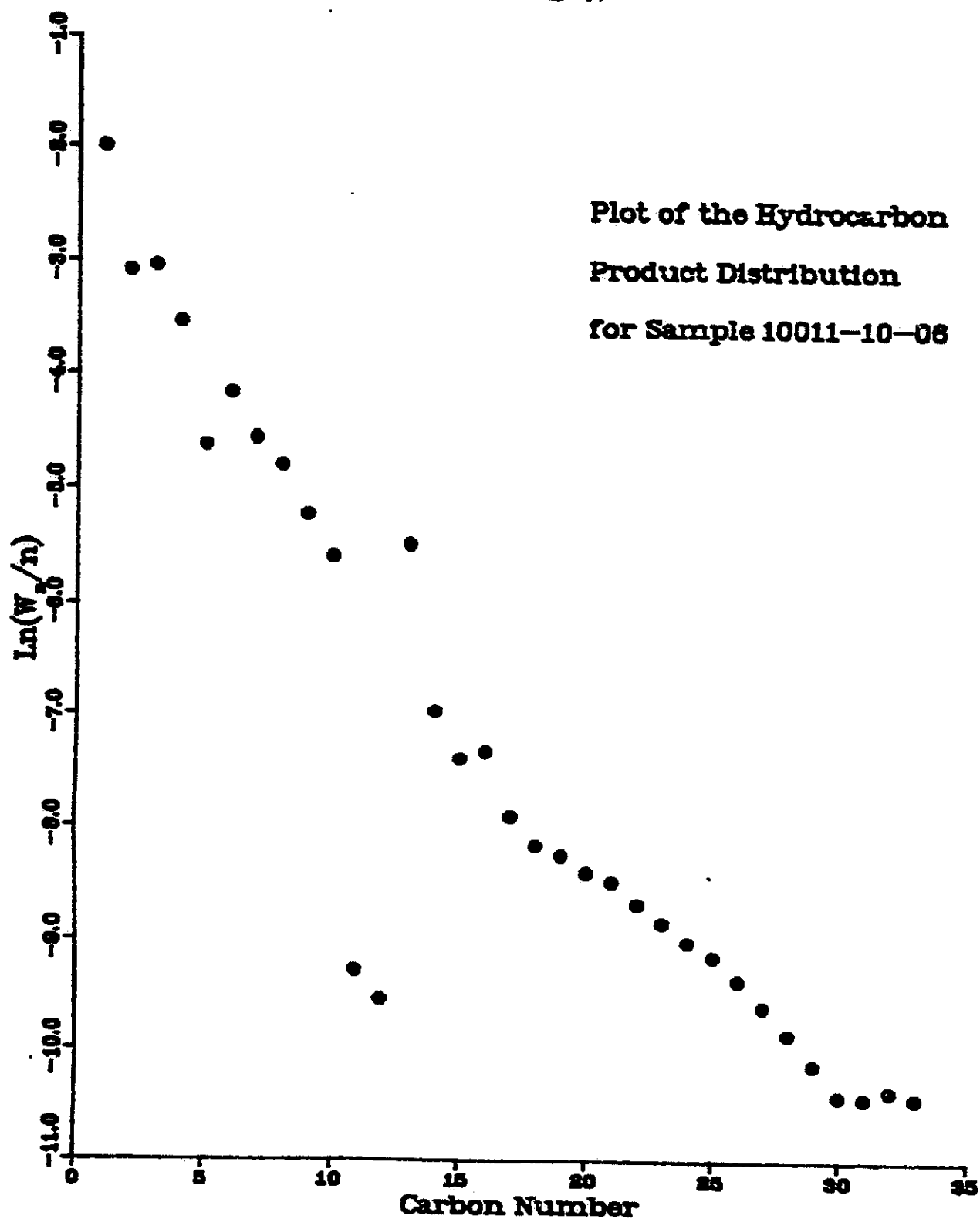


FIGURE 48

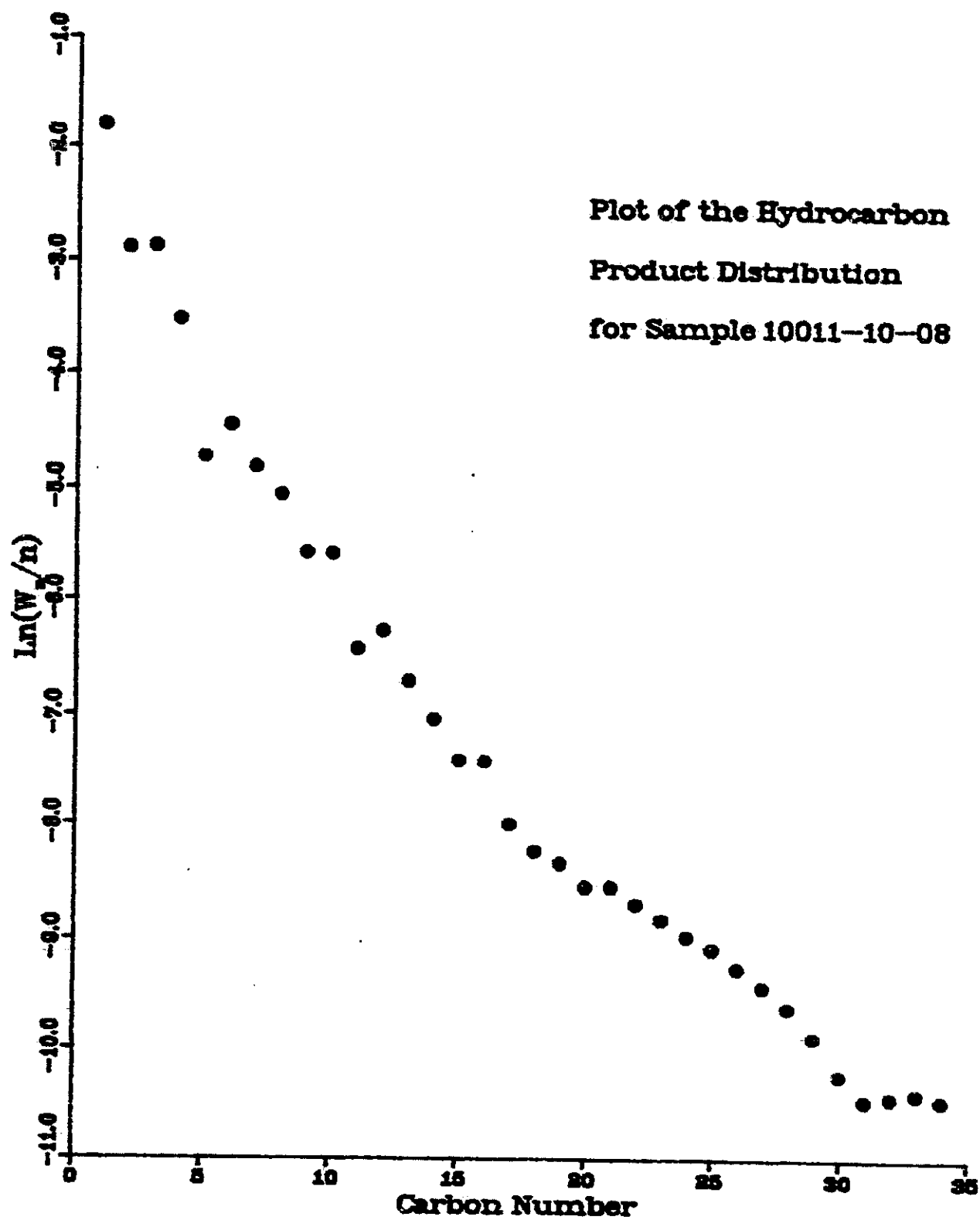


FIGURE 49

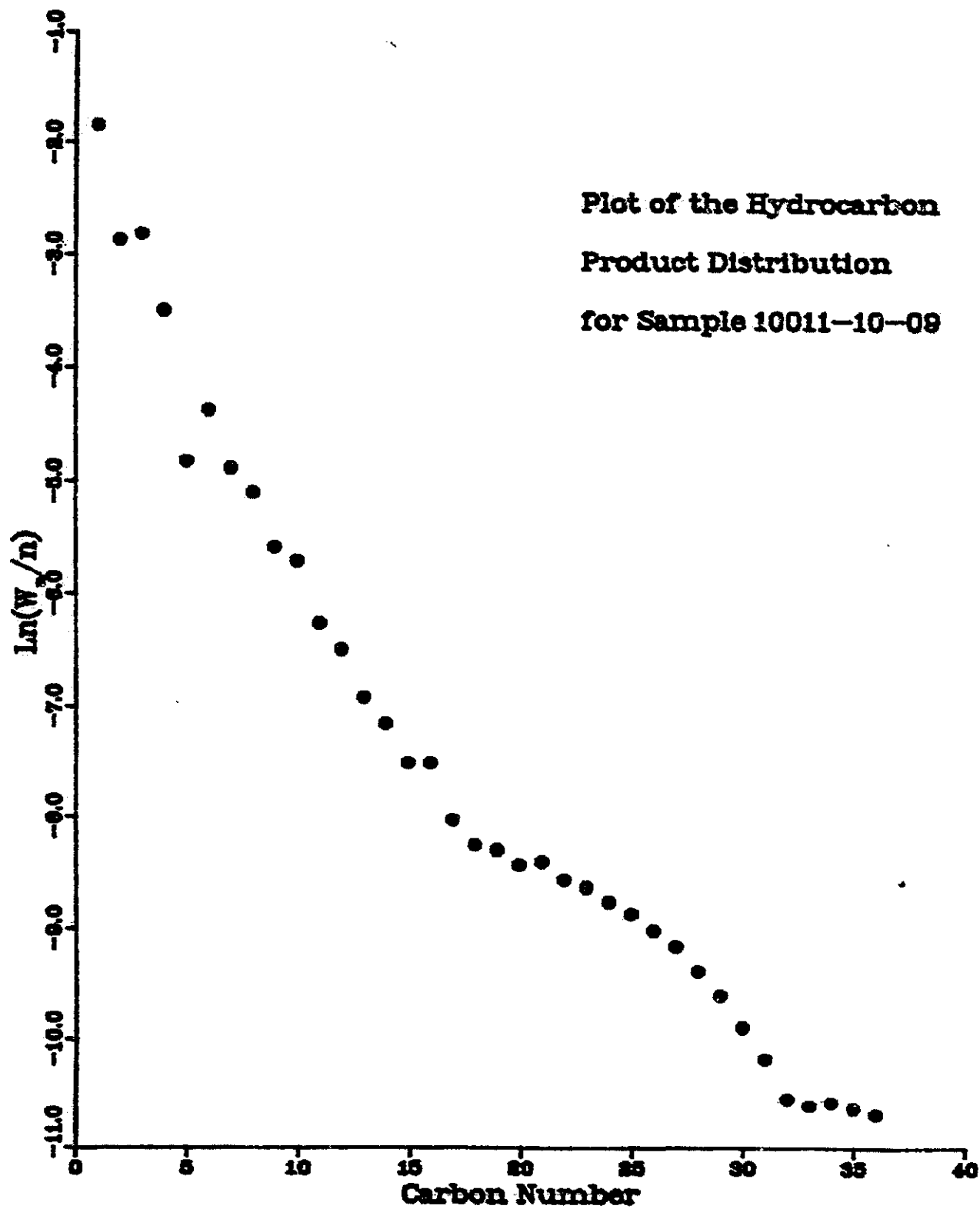


FIGURE 50

