

# Contents

<b>Preface</b>	<b>xiii</b>
<b>1 Introduction</b>	<b>1</b>
References	6
General Literature	6
<b>2 The Chemical Industry</b>	<b>7</b>
2.1 A Brief History	7
2.1.1 Inorganic Chemicals	7
2.1.2 Organic Chemicals	10
2.1.3 The Oil Era	11
2.1.4 The Age of Sustainability	12
2.2 Structure of the Chemical Industry	13
2.3 Raw Materials and Energy	16
2.3.1 Fossil Fuel Consumption and Reserves	16
2.3.2 Biomass as an Alternative for Fossil Fuels	19
2.3.3 Energy and the Chemical Industry	21
2.3.4 Composition of Fossil Fuels and Biomass	23
2.4 Base Chemicals	35
2.5 Global Trends in the Chemical Industry	37
References	39
General Literature	40
<b>3 Processes in the Oil Refinery</b>	<b>41</b>
3.1 The Oil Refinery – An Overview	41
3.2 Physical Processes	42
3.2.1 Desalting and Dehydration	42
3.2.2 Crude Distillation	43
3.2.3 Propane Deasphalting	45
3.3 Thermal Processes	46
3.3.1 Visbreaking	46
3.3.2 Delayed Coking	47
3.3.3 Flexicoking	48
3.4 Catalytic Processes	49
3.4.1 Octane and Cetane Numbers	49
3.4.2 Catalytic Cracking	51
3.4.3 Catalytic Reforming	63
3.4.4 Alkylation	69
3.4.5 Hydroprocessing	76

3.5	Current and Future Trends in Oil Refining	91
3.5.1	Stricter Environmental Regulations	92
3.5.2	Refinery Configurations	94
	References	96
<b>4</b>	<b>Production of Light Alkenes</b>	<b>99</b>
4.1	Introduction	99
4.2	Cracking Reactions	100
4.2.1	Thermodynamics	100
4.2.2	Mechanism	101
4.2.3	Kinetics	102
4.3	The Industrial Process	103
4.3.1	Influence of Feedstock on Steam Cracker Operation and Products	103
4.3.2	Cracking Furnace	106
4.3.3	Heat Exchanger	109
4.3.4	Coke Formation	110
4.4	Product Processing	111
4.5	Novel Developments	113
4.5.1	Selective Dehydrogenation of Light Alkanes	114
4.5.2	Metathesis of Alkenes	116
4.5.3	Production of Light Alkenes from Synthesis Gas	118
4.5.4	Dehydration of Bioethanol	121
4.5.5	Direct Conversion of Methane	122
	References	123
<b>5</b>	<b>Production of Synthesis Gas</b>	<b>127</b>
5.1	Introduction	127
5.2	Synthesis Gas from Natural Gas	129
5.2.1	Reactions and Thermodynamics	129
5.2.2	Steam Reforming Process	131
5.2.3	Autothermal Reforming Process	137
5.2.4	Novel Developments	139
5.3	Coal Gasification	142
5.3.1	Gasification Reactions	142
5.3.2	Thermodynamics	143
5.3.3	Gasification Technologies	146
5.3.4	Recent Developments in Gasification Technology	151
5.3.5	Applications of Coal Gasification	154
5.3.6	Integrated Gasification Combined Cycle	156
5.3.7	Why Gasify, Not Burn for Electricity Generation?	158
5.3.8	Carbon Capture and Storage (CCS)	159
5.4	Cleaning and Conditioning of Synthesis Gas	161
5.4.1	Acid Gas Removal	161
5.4.2	Water–Gas Shift Reaction	163
5.4.3	Methanation	166
	References	168

<b>6</b>	<b>Bulk Chemicals and Synthetic Fuels Derived from Synthesis Gas</b>	<b>171</b>
6.1	Ammonia	171
6.1.1	Background Information	171
6.1.2	Thermodynamics	173
6.1.3	Commercial Ammonia Synthesis Reactors	175
6.1.4	Ammonia Synthesis Loop	178
6.1.5	Integrated Ammonia Plant	180
6.1.6	Hydrogen Recovery	182
6.1.7	Production of Urea	185
6.2	Methanol	191
6.2.1	Background Information	191
6.2.2	Reactions, Thermodynamics, and Catalysts	192
6.2.3	Synthesis Gas for Methanol Production	195
6.2.4	Methanol Synthesis	196
6.2.5	Production of Formaldehyde	199
6.3	Synthetic Fuels and Fuel Additives	201
6.3.1	Fischer–Tropsch Process	202
6.3.2	Methanol-to-Gasoline (MTG) Process	212
6.3.3	Recent Developments in the Production of Synthetic Fuels	214
6.3.4	Fuel Additives – Methyl Tert-Butyl Ether	215
	References	218
<b>7</b>	<b>Processes for the Conversion of Biomass</b>	<b>221</b>
7.1	Introduction	221
7.2	Production of Biofuels	223
7.2.1	Bioethanol and Biobutanol	224
7.2.2	Diesel-Type Biofuels	226
7.3	Production of Bio-based Chemicals	231
7.3.1	Ethanol	232
7.3.2	Glycerol	233
7.3.3	Succinic Acid	234
7.3.4	Hydroxymethylfurfural (HMF)	236
7.4	The Biorefinery	236
7.4.1	Biorefinery Design Criteria and Products	236
7.4.2	Biorefinery Concepts	238
7.4.3	Core Technologies of a Thermochemical Biorefinery	239
7.4.4	Existing and Projected Biorefineries	243
7.4.5	Possibility of Integrating a Biorefinery with Existing Plants	243
7.4.6	Biorefinery versus Oil Refinery	245
7.5	Conclusions	246
	References	246
<b>8</b>	<b>Inorganic Bulk Chemicals</b>	<b>249</b>
8.1	The Inorganic Chemicals Industry	249
8.2	Sulfuric Acid	250
8.2.1	Reactions and Thermodynamics	252
8.2.2	SO <sub>2</sub> Conversion Reactor	252

8.2.3	Modern Sulfuric Acid Production Process	254
8.2.4	Catalyst Deactivation	256
8.3	Sulfur Production	256
8.4	Nitric Acid	260
8.4.1	Reactions and Thermodynamics	260
8.4.2	Processes	262
8.4.3	NO <sub>x</sub> Abatement	266
8.5	Chlorine	268
8.5.1	Reactions for the Electrolysis of NaCl	269
8.5.2	Technologies for the Electrolysis of NaCl	270
	References	274
<b>9</b>	<b>Homogeneous Transition Metal Catalysis in the Production of Bulk Chemicals</b>	<b>275</b>
9.1	Introduction	275
9.2	Acetic Acid Production	278
9.2.1	Background Information	278
9.2.2	Methanol Carbonylation – Reactions, Thermodynamics, and Catalysis	281
9.2.3	Methanol Carbonylation – Processes	284
9.3	Hydroformylation	286
9.3.1	Background Information	286
9.3.2	Thermodynamics	288
9.3.3	Catalyst Development	289
9.3.4	Processes for the Hydroformylation of Propene	292
9.3.5	Processes for the Hydroformylation of Higher Alkenes	294
9.3.6	Comparison of Hydroformylation Processes	296
9.4	Ethene Oligomerization and More	297
9.4.1	Background Information	297
9.4.2	Reactions of the SHOP Process	298
9.4.3	The SHOP Process	299
9.5	Oxidation of <i>p</i> -Xylene: Dimethyl Terephthalate and Terephthalic Acid Production	301
9.5.1	Background Information	301
9.5.2	Conversion of <i>p</i> -Toluic Acid Intermediate	302
9.5.3	Processes	303
9.5.4	Process Comparison	305
9.6	Review of Reactors Used in Homogeneous Catalysis	305
9.6.1	Choice of Reactor	306
9.6.2	Exchanging Heat	308
9.7	Approaches for Catalyst/Product Separation	308
9.7.1	Biphasic Catalyst Systems	309
9.7.2	Immobilized Catalyst Systems	309
	References	311
<b>10</b>	<b>Heterogeneous Catalysis – Concepts and Examples</b>	<b>313</b>
10.1	Introduction	313
10.2	Catalyst Design	314
10.2.1	Catalyst Size and Shape	314
10.2.2	Mechanical Properties of Catalyst Particles	316

10.3	Reactor Types and Their Characteristics	316
10.3.1	Reactor Types	316
10.3.2	Exchanging Heat	319
10.3.3	Role of Catalyst Deactivation	321
10.3.4	Other Issues	322
10.4	Shape Selectivity – Zeolites	323
10.4.1	Production of Isobutene	325
10.4.2	Isomerization of Pentanes and Hexanes	328
10.4.3	Production of Ethylbenzene	330
10.5	Some Challenges and (Unconventional) Solutions	334
10.5.1	Adiabatic Reactor with Periodic Flow Reversal	334
10.5.2	Highly Exothermic Reactions with a Selectivity Challenge – Selective Oxidations	338
10.6	Monolith Reactors – Automotive Emission Control	344
10.6.1	Exhaust Gas Composition	346
10.6.2	Reduction of Exhaust Gas Emissions	347
	References	354
	General Literature	355
<b>11</b>	<b>Production of Polymers – Polyethene</b>	<b>357</b>
11.1	Introduction	357
11.2	Polymerization Reactions	357
11.2.1	Step growth Polymerization	358
11.2.2	Chain growth Polymerization – Radical and Coordination Pathways	360
11.3	Polyethenes – Background Information	363
11.3.1	Catalyst Development	363
11.3.2	Classification and Properties	364
11.3.3	Applications	365
11.4	Processes for the Production of Polyethenes	366
11.4.1	Monomer Production and Purification	366
11.4.2	Polymerization – Exothermicity	367
11.4.3	Production of Polyethenes	367
	References	375
<b>12</b>	<b>Production of Fine Chemicals</b>	<b>377</b>
12.1	Introduction	377
12.2	Role of Catalysis	380
12.2.1	Atom Economy	380
12.2.2	Alternative Reagents and Catalysts	381
12.2.3	Novel Reaction Routes	384
12.2.4	Selectivity	384
12.2.5	Biocatalysis	392
12.3	Solvents	394
12.3.1	Conventional Solvents	394
12.3.2	Alternative Solvents	395

12.4	Production Plants	398
12.4.1	Multiproduct and Multipurpose Plants (MMPs)	398
12.4.2	Dedicated Continuous Plants	406
12.5	Batch Reactor Selection	407
12.5.1	Reactors for Liquid and Gas–Liquid Systems	408
12.5.2	Reactors for Gas–Liquid–Solid Systems	409
12.6	Batch Reactor Scale-up Effects	411
12.6.1	Temperature Control	411
12.6.2	Heat Transfer	411
12.6.3	Example of the Scale-up of a Batch and Semi-Batch Reactor	412
12.6.4	Summary of the Scale-up of Batch Reactors	416
12.7	Safety Aspects of Fine Chemicals	416
12.7.1	Thermal Risks	416
12.7.2	Safety and Process Development	417
	References	419
<b>13</b>	<b>Biotechnology</b>	<b>423</b>
13.1	Introduction	423
13.2	Principles of Fermentation Technology	424
13.2.1	Mode of Operation	425
13.2.2	Reactor Types	426
13.2.3	Sterilization	432
13.3	Cell Biomass – Bakers’ Yeast Production	433
13.3.1	Process Layout	433
13.3.2	Cultivation Equipment	434
13.3.3	Downstream Processing	434
13.4	Metabolic Products – Biomass as Source of Renewable Energy	435
13.4.1	Bioethanol and Biobutanol	435
13.4.2	Biogas	438
13.5	Environmental Application – Wastewater Treatment	438
13.5.1	Introduction	438
13.5.2	Process Layout	438
13.5.3	Aerobic Treatment Processes	440
13.5.4	Anaerobic Treatment Processes	443
13.6	Enzyme Technology – Biocatalysts for Transformations	445
13.6.1	General Aspects	445
13.6.2	Immobilization of Enzymes	446
13.6.3	Production of L-Amino Acids	447
13.6.4	Production of Artificial Sweeteners	448
	References	452
	General Literature	453
<b>14</b>	<b>Process Intensification</b>	<b>455</b>
14.1	Introduction	455
14.1.1	What is Process Intensification	455
14.1.2	How to Intensify Processes	457
14.2	Structured Catalytic Reactors	459
14.2.1	Types of Structured Catalysts and Reactors	460

14.2.2	Monoliths	462
14.2.3	Microreactors	468
14.3	Multifunctional Reactors/Reactive Separation	472
14.3.1	Reactive Distillation	473
14.3.2	Coupling Reaction and Membrane Separation	477
14.3.3	Coupling Reaction and Adsorption	481
	References	482
<b>15</b>	<b>Process Development</b>	<b>485</b>
15.1	Dependence of Strategy on Product Type and Raw Materials	485
15.2	The Course of Process Development	487
15.3	Development of Individual Steps	489
15.3.1	Exploratory Phase	489
15.3.2	From Process Concept to Preliminary Flow Sheet	489
15.3.3	Pilot Plants/Miniplants	494
15.4	Scale-up	499
15.4.1	Reactors with a Single Fluid Phase	499
15.4.2	Fixed Bed Catalytic Reactors with One or More Fluid Phases	501
15.5	Safety and Loss Prevention	505
15.5.1	Safety Issues	505
15.5.2	Reactivity Hazards	511
15.5.3	Design Approaches to Safety	513
15.6	Process Evaluation	514
15.6.1	Capital Cost Estimation	515
15.6.2	Operating Costs and Earnings	523
15.6.3	Profitability Measures	524
15.7	Current and Future Trends	526
	References	528
	General Literature	529
	Magazines	529
<b>Appendix A</b>	<b>Chemical Industry – Figures</b>	<b>531</b>
<b>Appendix B</b>	<b>Main Symbols Used in Flow Schemes</b>	<b>535</b>
<b>Index</b>		<b>539</b>