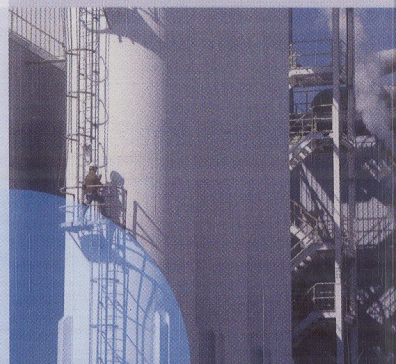
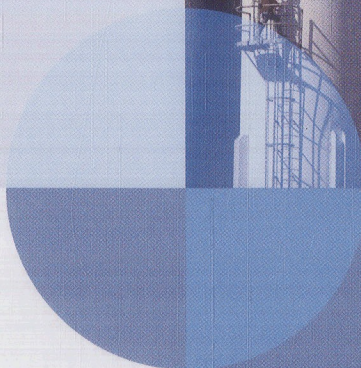
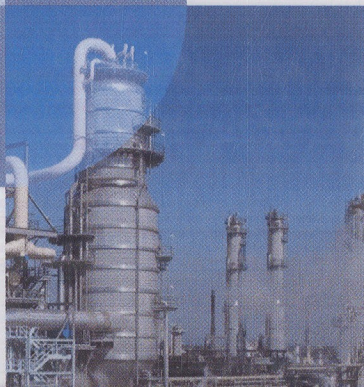
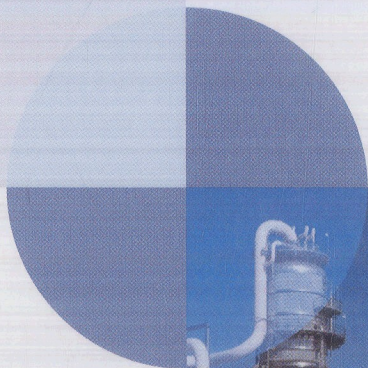


MEENA MARAFI
ANTONY STANISLAUS
EDWARD FURIMSKY

HANDBOOK OF SPENT HYDROPROCESSING CATALYSTS



Contents

Preface	<i>xi</i>
List of acronyms	<i>xiii</i>
Chapter 1: Introduction	1
Chapter 2: Development in Petroleum Refining	5
2.1 Conventional Refinery	7
2.2 Revamped Conventional Refinery	10
2.3 Advanced Refineries	13
Chapter 3: Hydroprocessing of Petroleum	17
3.1 Feeds for Hydroprocessing	17
3.1.1 Light Feeds.....	19
3.1.2 Medium Heavy Feeds	19
3.1.2.1 Heavy and Extra Heavy Feeds	20
3.2 Hydroprocessing Reactions.....	21
3.3 Hydroprocessing Catalysts.....	22
3.3.1 Structure and Chemical Composition	23
3.3.1.1 Co(Ni)-Mo(W)-S Phase	24
3.3.1.2 Brim Sites Model	25
3.3.1.3 Co-Mo-S(S) Phase	26
3.3.1.4 Effect of Support.....	27
3.3.2 Physical Properties	28
3.3.3 Improved Hydroprocessing Catalysts	32
3.4 Hydroprocessing Reactors and Processes	35
3.4.1 Fixed Bed Reactor Systems	38
3.4.1.1 Unibon Process.....	42
3.4.1.2 Atmospheric Residue Desulfurization (ARDS) and HYVAHL Processes.....	43
3.4.2 Moving Bed and Ebullated Bed Reactors	44
3.4.3 Comparison of Hydroprocessing Reactors.....	48

Chapter 4: Catalyst Deactivation	51
4.1 Deactivation Due to Structural Change of Catalyst	55
4.2 Deactivation by Coke and Nitrogen Bases.....	56
4.3 Combined Effect of Coke and Metals on Deactivation	60
4.4 Effect of Temperature and Hydrogen Pressure	67
4.5 Effect of Mechanical Properties of Catalyst	71
4.6 Mechanism of Catalyst Deactivation	73
4.6.1 Mechanism of Coke Formation.....	73
4.6.1.1 Chemical Aspects	73
4.6.1.2 Physical Aspects	78
4.6.2 Mechanism of Metal Deposition.....	80
4.6.2.1 Deposition of Inorganic Solids	80
4.6.2.2 Deposits of Organometallic Origin.....	81
4.6.2.2.1 Vanadium containing deposits.....	81
4.6.2.2.2 Nickel and mixed deposits.....	83
4.7 Modeling of Deactivation	85
 Chapter 5: Environmental and Safety Aspects of Spent Hydroprocessing Catalysts	 93
5.1 Regulatory Affairs.....	94
5.1.1 Classification of Spent Hydroprocessing Catalysts	96
5.1.2 Transportation of Spent Catalysts	97
5.1.3 Recycling and Disposal of Spent Catalysts.....	99
5.1.4 Handling of Spent Catalysts on Refinery Site.....	101
5.1.5 Cradle to Grave Approach to Spent Catalyst Management	105
5.2 Hazardous Characteristics of Spent Hydroprocessing Catalysts	105
5.2.1 Exposure to Air	109
5.2.1.1 Reactions of Air with Coke	109
5.2.1.2 Reactions of Air with Catalyst.....	112
5.2.2 Leachability.....	115
5.3 Pretreatment of Spent Catalysts for Disposal.....	116
 Chapter 6: Regeneration	 121
6.1 Regenerability of Spent Catalysts	121
6.2 Oxidative Regeneration.....	125
6.2.1 Mechanism of Oxidative Regeneration.....	125
6.2.1.1 Oxidation of Coke	125
6.2.1.2 Involvement of Metals.....	134
6.2.2 Kinetics of Oxidative Regeneration	140
6.2.2.1 Chemically Controlled Kinetics	141
6.2.2.2 Diffusion Controlled Kinetics	146

6.2.3	Modeling of Oxidative Regeneration.....	148
6.2.4	Characterization of Regenerated Catalyst.....	149
6.2.4.1	Surface Properties.....	150
6.2.4.2	Activity of Regenerated Catalysts.....	154
6.2.4.3	Chemical Structure.....	158
6.2.5	Safety and Environmental Aspects of Oxidative Regeneration.....	160
6.2.6	Other Oxidizing Agents.....	164
6.3	Other Regeneration Methods.....	165
6.3.1	Regeneration in H ₂ O and CO ₂	165
6.3.2	Regeneration with Nitrogen Oxides.....	167
6.3.3	Reactivation.....	168
6.3.4	Regeneration Aided by Radiation Treatment.....	169
6.3.5	Reductive Regeneration.....	170
6.3.6	Regeneration by Attrition Slash Abrasion.....	172
6.3.7	Resulfidation of Regenerated Catalysts.....	172
6.4	Industrial Regeneration.....	173
6.4.1	In-Situ Regeneration.....	174
6.4.2	Off-Site Regeneration.....	176
6.4.3	Mechanical Separation of Spent Catalysts.....	178
6.4.4	Commercial Regeneration Processes.....	182
6.4.4.1	Belt Regeneration Process.....	182
6.4.4.2	TRICAT Regeneration Process.....	185
6.4.4.3	EUROCAT Process.....	187
6.4.4.4	REACT Process.....	188
6.4.4.5	ReFRESH Process.....	188
6.4.4.6	Rotary Kilns.....	188
6.4.5	Comparison of Regeneration Processes.....	189

Chapter 7: Rejuvenation 191

7.1	Organic Agents.....	193
7.1.1	Mechanism of Rejuvenation by Organic Agents.....	201
7.1.2	Kinetics of Rejuvenation.....	207
7.1.2.1	Particle Constant Size.....	207
7.1.2.2	Particle Changing Size (Shinking Particle) Model.....	208
7.1.3	Emissions from Rejuvenation by Organic Agents.....	212
7.1.3.1	Gaseous Emissions.....	213
7.1.3.2	Liquid Emissions.....	213
7.1.3.3	Solid Emissions.....	214
7.1.4	Rejuvenation Process Design.....	214
7.1.4.1	De-oiling.....	214
7.1.4.2	Mechanical Separation.....	214
7.1.4.3	Metals Leaching Process.....	217

7.1.4.4	Decoking of Leached Catalysts	217
7.1.4.5	Other Auxiliary Processes	217
7.1.4.6	Design Basis	217
7.2	Inorganic Agents	219
7.2.1	Acidic Agents.....	219
7.2.2	Basic Solutions.....	222
7.2.3	Environmental and Safety Aspects	224
7.3	Solvent Extraction.....	224
7.4	Biorejuvenation.....	225
7.5	Non-Leaching Methods for Contaminant Metals Removal.....	226
Chapter 8: Cascading		227
8.1	Cascading of Spent Catalysts	228
8.2	Cascading of Regenerated Catalysts	228
8.3	Cascading of Rejuvenated Catalysts	230
Chapter 9: New Catalysts from Spent Catalysts.....		231
9.1	Petroleum Applications.....	231
9.1.1	Reprocessing	232
9.1.1.1	Procedure and Analysis	232
9.1.1.2	Testing of Reprocessed Catalysts	236
9.1.1.3	Effect of Hydrothermal Treatment on Reprocessed Catalysts	242
9.1.2	Other Preparation Methods	244
9.1.3	Spent Catalysts in Slurry Bed Hydrocracking	246
9.2	Catalysts for Non-Petroleum Applications	247
9.3	Gas Treatment Sorbents	248
9.4	Preparation of Useful Materials from Spent Catalysts.....	250
9.4.1	Utilization in Cement Industry.....	250
9.4.2	Waster Water Treatment Agents.....	252
9.4.3	Other Materials.....	253
9.4.3.1	Abrasives and Alloys.....	253
9.4.3.2	Ceramic Materials.....	254
9.4.3.3	Synthetic Aggregates.....	256
9.4.3.4	Bricks Production	256
Chapter 10: Spent Catalysts from Dewaxing Operations		259
10.1	Conventional Catalysts	260
10.2	Dewaxing catalysts	261
10.2.1	Composition of Dewaxing Catalysts	261
10.2.2	Deactivation	263
10.2.3	Environment and Safety.....	264
10.2.4	Regeneration	264
10.2.5	Metal Reclamation.....	266

Chapter 11: Metal Reclamation from Spent Hydroprocessing Catalysts	269
11.1 Laboratory Studies on Metal Recovery from Spent Hydroprocessing Catalysts	269
11.1.1 Leaching Studies	270
11.1.1.1 Leaching with Ammonia and Ammonium Salts Solutions	270
11.1.1.2 Leaching with Acids	273
11.1.1.2.1 Inorganic acids	273
11.1.1.2.2 Organic acids	277
11.1.1.3 Alkali Leaching	281
11.1.1.4 Two-Stage Leaching	283
11.1.1.5 Bioleaching	285
11.1.2 Roasting with Alkali Compounds	289
11.1.2.1 Roasting with Sodium Salts	290
11.1.2.2 Roasting with Potassium Salts	295
11.1.3 Chlorination	297
11.1.4 Metal Recovery by Carbothermic Reduction	302
11.1.5 Metal Recovery Using Electrolytic Cells	302
11.1.6 Metal Recovery by Applying Thermal Plasma	303
11.1.7 Summary of Laboratory Studies	304
11.2 Separation of Metals from Solution	306
11.3 Commercial Processes	309
11.3.1 Gulf Chemical & Metallurgical Corporation Process	310
11.3.2 CRI-MET Process	311
11.3.3 EURECAT Process	311
11.3.4 Taiyo Koko Company Process	312
11.3.5 Full Yield Industry Process	312
11.3.6 Moxba-Metrex Process	313
11.3.7 Quanzhuo Jing-Tai Industry Process	314
11.3.8 Metallurg Vanadium Process	314
11.3.9 German Processes	314
11.3.10 Nippon Catalyst Cycle Co. Process	315
Chapter 12: Markets and Price Trends for Metals in Spent Hydroprocessing Catalysts	317
12.1 Molybdenum	317
12.2 Tungsten	318
12.3 Nickel	318
12.4 Cobalt	319
12.5 Vanadium	319
12.6 Alumina	320
Chapter 13: Future Perspectives	321
References	325
Index	343