

RESTRICTED

APPENDIX C

Documents Relating to
Relocating Moers Equipment

RESTRICTED

3)
Discussions in Berlin at the GbChem and Geilenbergstab on
25.10.44

Topic of discussion: Karburol Plant 2 Rheinpreussen and
Alcohol Plant Rheinpreussen.

Present were:

Dr. Altpeter, GbChem/Berlin.
Dr. Arnold " "
Dr. Sorg " "
Dr. Pflaundler " " (A.R.P. reporter)
Dr. Gerich " " (Reporter for the locality
for erecting new plants).
Dr. Romberg, Production Board.
Dir. Dr. Grimme, Rheinpreussen/Moers.
Ing. Cullmann, Rheinpreussen/Moers.

4)
Discussion at the Riebeck'schen Montanwerken Concordia
Nachterstedt on 26.10.44.

Topic of discussion: Karburol Plant 2 (Jakob 9).

Present were:

Dr. Pfaff, Concordia/Nachterstedt
Dr. Gerich, GbChem/Berlin
Dr. Seifert, Wintershall A.G./Salzbergen
Obering. Weiss, DBHG/Berlin
Dr. Schmidt, Still/Recklinghausen
Obering. Breitbach, Still/Recklinghausen
Dir. Dr. Grimme, Rheinpreussen/Moers
Ing. Cullmann, Rheinpreussen/Moers

- 5) Discussion and Inspection in Messinghausen and Bredelar.
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Topic of discussion: Karburol Plant 1 (Jakob II and Alcohol Plant).

Present were:

Dr. Seifert, Wintershall A.G./Salzbergen

Dr. Schmidt, Still/Recklinghausen

Obering. Breitbach, Still/Recklinghausen

Obering. Weiss, DBJG/Berlin

O.T.-Stab, Building site, Messinghausen

Dir. Dr. Grimme, Rheinpreussen/Moers

Ing. Cullmann, Rheinpreussen/Moers

- 1) Karburol Plant (Jakob 9) Rheinpreussen.

The existing Karburol Plant Rheinpreussen is to be set up in combination with a new vacuum distillation. A few parts from the greatly damaged Viktor Rauxel Plant are to be taken to supplement the former. Provisions have been made to use as a raw product lignite distillation tar or BGR tar which is to be supplied by the Riebeck'schen Montanwerken Nachterstedt near Aschersleben. The originally intended locality of the plant in Miltisch-Roitschen near Meissen was, to begin with, changed for Frose (in the vicinity of Riebeck'schen Montanwerk), but this suggestion was turned down by the GbChem (Mr. Pfanndler) for A.R.P.-technical reasons because there is an exceptional accumulation of large-size industrial plants at the proposed locality (closed-down lignite mine). Dr. Gerich of GbChem has immediately gone in search of a new locality in the vicinity of Nachterstedt. As soon as a suitable locality has been found Dr. Gerich will advise us immediately. Special attention was called by Rheinpreussen and the firm Still to the fact that, owing to constant changes in the selection of the locality, the dismantling and assembling work has already been delayed by six weeks, as a result of which the demanded starting date (18.1.45) has been rendered doubtful.

The same conditions apply to the plants Karburol 1 and 3. In order to be able to carry out the dismantling work at an accelerated pace, however, it was agreed that until a final decision has been reached in regard to the locality the dismantled parts are to be sent for storage to the Riebeck'schen Montanwerk. Dr. Pfaff (Riebeck'sche Montanwerke) declared his willingness to make suitable premises available for that purpose. The unloading of the trucks will be supervised by our gang leader Tombrink. 12 men have been asked for by teleprinter from the O.T. through Dr. Sorg (GbChem) for the purpose of unloading. The unloading gang is to arrive at Nachterstedt on 31.10.44.

The temporary despatch address reads:
"Steinkolenbergwerk Rheinpreussen
i.Fa. Riebeck'sche Montanwerke,
Neues Schwelwerk,
Nachterstedt-Hoym".

In regard to the trucks which have already been despatched to Miltisch Reitschen, the goods yards there have been informed telegraphically that the trucks arriving are to be passed on to the new address.

Data for Karburol Plant 2.

Trustee administration until completion: Head Engineer
Weiss of the
DBHG/Berlin.

Building supervision for building and power supply:
DBHG/Berlin.

Building supervision for apparatus components: Firm Still/
Rechlinghausen.

Works Commissar for Construction & Erection: Dr. Kox,
DBHG/Berlin.

Works Commissar for Production: ?

Responsible for the Apparatus Section: Dr. Schmidt, Still/
Recklingh.

Old locality: Rheinpreussen/Meerbeck.

New locality: Will be decided later.

Raw product to be used: Lignite distillation tar or EGR tar.

Capacity: 16,000 tons per year = 2,000 tons per month = 65 tons per day = 2.7 per hour with 250 working days.

Ultimate Products:

Raw benzine	25%	= 16 tons per day.
Raw Diesel fuel	25%	= 16 tons per day.
Gas	12%	= 8 tons per day.
Heating oil residue	36%	= 23.5 tons per day.
Loss	2%	= 1.5 tons per day.
	<u>100%</u>	<u>= 65 tons per day.</u>

Power requirements:

Steam (10 atm.)	10 tons per hour.
Water (150C)	300 m ³ per hour.
Current (500 V)	200 Kwh.

<u>Commencement of dismantling</u>	17.10.44	<u>End of dismantling:</u>	15.11.44 in Moers.
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<u>Commencement of dismantling</u>	1.11.44	<u>End of dismantling:</u>	30.11.44 in Rauxel.
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Commencement of work on the building site	1.12.44) Provided the ultimate locality is announced immediately
Commencement of assembly	15.12.44	
Starting date	28.2.45	
Date for beginning of operation	15.3.45	

Quota Agent: The firm Still via DBHG/Berlin

Quota weight: 120 tons unalloyed.
22 tons alloyed.
50 tons tank.
0.5 tons NE

Condition of the old plant:

Apparatuses, scaffoldings, furnaces well preserved.
2 Tanks destroyed.
All measuring instruments and regulators damaged or in need of repair.
A few regulators are missing.
1 x 300 m³ Gasometer must be newly erected.
The boiler plant will be procured by the Olbau.

Personnel essential for assembly:

By 15.12.44

5 E-Welders 5 A-Welders 10 Fitters 20 Assistants.

By 1.1.45

10 E-Welders 10 A-Welders 20 Fitters 40 Assistants.

By 10.1.45

15 E-Welders 15 A-Welders 30 Fitters 60 Assistants.

Current (220 V) must be available on the building site by 15.12.44.

Traffic: Incoming: 6 trucks per day.
 Outgoing: 5 trucks per day.

A.R.P.: Camouflage of the plants, bunker or galleries.

Cost of the plant: Will be decided later.

Report on the progress of dismantling (number of trucks despatched, number of men employed, erection of the parts despatched, etc.) must be made every week to Head Engineer Weiss, DBHG.

Berlin-Charlottenburg 2
Knesebeckstr. 99: Tel. 31 80 21

Place where the parts to be despatched are warehoused:

Temporarily: Riebeck'sche Montanwerke Nachterstedt-Hoym

2) Karburol Plant 1 (Jakob 11). Luetzendorf.

Contractor: Wintershall A. G.

Trustee administration until completion: DBHG/Berlin.

Building supervision for buildings and power supply:
DBHG/Berlin

Building supervision for apparatus components: The firm
of Still/Recklinghausen

Works Commissar for Construction & Erection: Dr. Kox,
DBHG/Berlin

Works Commissar for Production: Dr. Seifert, Wintershall A.A./
Salzbergen.

Responsible for the Apparatus Section: Dr. Schmidt,
Still/Recklinghausen.

Old Locality: Luetzendorf.

New Locality: Bredelar

Despatch address for goods traffic: Bredelar, junction
railway Zechitwerke.

Raw product to be used:

Mineral oil residue 60,000-75,000 tons per year = 5,000-
6,250 tons per month = 240-300 tons per day = 10-12.5 tons
per hour, 250 working-days.

Ultimate products:

Raw benzine	25% = 60 - 75 tons per day.
Raw Diesel fuel	25% = 60 - 75 tons per day.
Gas	12% = 29 - 36 tons per day.
Heating Oil Residue	36% = 86 - 108 tons per day.
Loss	2% = 5 - 6 tons per day.

100% = 240 - 300 tons per day.

Power requirements: Steam (10 atm) 30 tons per hour.
Water (15°C) 600 m³/h.
Current (220 V) 600 KWH

The power supply is arranged in such a manner that the
power for the alcohol plant of Rheinpreussen can be supplied
by the cracking plant.

New Apparatuses for Feeding the "Gasol" to the Alcohol Plant:

- 1 Gasometer 300 m³
- 2 Compressors (from Rheinpreussen)

Dates:

Commencement of dismantling:	16.10.44.	End of dismantling:	30.11.44.
Commencement of Assembly:	15.11.44		
Starting date	: 18.1.45		

3). Alcohol Plant Rheinpreussen.

A basic agreement was made with the Wintershall A. G. to the effect that the alcohol plant is to be erected in conjunction with the Karburol Plant 1 (Luetzgenforf). The raw product to be used (7,200 - 9,000 tons per year cracking gas with 30% Olefin content = 12% of the quantity used for the Karburol Plant) is supplied by the latter so that it is advisable to set the alcohol plant up in the immediate vicinity of the Karburol Plant. The locality coming into consideration which is about 200 m away from the cracking plant (Bredelar Sauerland) was inspected very thoroughly. The gas is fed to the alcohol plant in a compressed state (smaller pipelines) for which a small gasometer (200 m³) and 2 compressors are required; the latter will be provided by Rheinpreussen.

The steam required of 6.5 t/h (10 atm) as well as water (200 m³/h) and current (65 KWh, 500 V) will be taken from the power production of the Karburol Plant 2 which will be constructed on a correspondingly larger scale. In addition, a transformer 500 V, 65 KWA must be procured because the cracking plant operates on 220 V.

It has been possible to convince the competent authorities of the GbChem (Dr. Altpeter and Dr. Sorg) as well as the Production Board (Dr. Romberg) of the necessity for immediate decentralisation of the alcohol plant.

In spite of the greatest efforts made it has not been possible to obtain a definite decision from Herr Geilenberg or Herr Leidreiter - a decision desired by Rheinpreussen - because a discussion did not take place on that day as these gentlemen were too busy. Herr Thelen is to try to obtain from Herr Leidreiter the official permit for dismantling and if possible for the assembly of the alcohol plant.

The attention of the various service departments has repeatedly been called to the urgent necessity for the immediate dismantling of the Karburol and the alcohol plant because dismantling at a later date would be rendered doubtful owing to expected enemy action. The following points must be clarified immediately:

The fundamental permit for dismantling and/or reassembly and the provision of the corresponding number of workmen, furthermore the definite erection locality so that the individual apparatuses can be removed from the works one after the other and a bottleneck on the dismantling site avoided.

Draft for the Building Maturity Declaration.

for the decentralisation of the alcohol plant and acetone plant of the Fuel Works Rheinpreussen, Homberg/Niederrhein, to Bredelar (Sauerld).

Alcohol-Acetone Plant Rheinpreussen

Consisting of:

a) Polymerisation.

- 2 Stirring Plants.
- 2 Mixers.
- 4 Boilers
- 2 Coolers (100 m²)
- 6 Pumps (each 3 m³/h)
- Various Small Tanks and Apparatuses.

b) Sulphuric acid regeneration.

- 2 Evaporators.
- 2 Re-evaporators.
- 1 Vacuum Condenser.
- 2 Vacuum Pumps.
- Various small apparatuses.

c) Water Extraction from Alcohol.

- 1 Column 900 ϕ x 15000
- 2 " 700 ϕ x 7000
- 3 " 700 ϕ x 4000
- 12 Condensers totalling 150 m²
- 10 Pumps each 3 m³/h
- Various small apparatuses and tanks.

- d) Acetone Plant.
1 Tube Furnace
3 Blowers
1 Evaporator
1 Distillation Column
4 Pumps
Various containers

- e) Tank Store.
6 Tanks 2000 ϕ x 8500
11 Tanks 1600 ϕ x 6000

All above plant components are undamaged and in good condition.

Quota requirements:

Machine iron	35 tons
Construction iron	40 tons
NE metals.	5 tons

Costs

for construction	RM 50,000.-
for assembly	RM 80,000.-

Capacity:

To be used:	25 tons per day cracking gas (30% Olefin content) = 7.5 tons per day Olefine from the Jakob 11 plant.
Product:	7 tons per day alcohol. 1.2 tons per day acetone. 7 tons per day liquid gas (for fuel purposes) Rest: Heating gas.

Labour:

12 Men
15 Women

Operating Means:

H ₂ SO	5 tons per month
NaOH	5 tons per month

Operating Means:

H₂SO₄ 5 tons per month
NaOH 5 tons per month

Power:

Water (15°C) 200 m³/h
Current (500 V) 65 KWh
Steam (10 atm.) 2 t/h
Steam (2.5 ") 4.5 t/h

Fixed date suggestion:

Commencement of dismantling 1.11.44
End of dismantling 1.12.44
Commencement of construction 15.11.44
Commencement of assembly 15.12.44
End of assembly 15. 2.45

Assembly personnel required:

(not including building workers)

	15.12	1.1	15.1
A-Welders	7	10	15
E-Welders	3	5	15
Fitters	10	20	30
Assistants	20	40	60

Traffic:

Incoming: 3 tank wagons per month
Outgoing: 14 tank wagons per month
10 tank gas wagons.

4). Karburol Plant 3, Plant Bergkamen.

The plant is already dismantled partly, but the erection site is not yet known so that the dismantling work on this plant is also hindered owing to the change in the assembly site. Hoyerswerda/Lausitz is intended as the prospective locality.

- 5). Top Plant Taube 1 in Messinghausen.
Taube 2 in Muehlenbein.

These plants were inspected. They are two new twin plants with 3,000 tons per month raw material operating on 50% residue. The construction of the plants is very primitive (brick furnaces, small suspended roof, cooler and heat exchanges without compensation and without facility for switching off, no regulators, pumps in the open, steam supply from old locomotive boilers).

The date for starting was fixed at about 6 weeks ago, but neither of the two twin plants are ready for operation as yet. Considerable difficulties will presumably occur in the maintenance of the plant in the event of snow and severe cold.

The erection of Taube 1 in regard to A.R.P. is good, that of Taube 2 poor, as the latter is built into the centre of a circular stone quarry (crude oil tank with furnace).

Points to be clarified.

a) Karburol Plant 2:

- 1). Fixing ultimate locality and ultimate despatch address.
- 2). Advising the Army Order Number by GbChem via DBHG to Still.
- 3). Works Commissar for Production.

b) Alcohol Plant:

- 1). Permit for dismantling from Geilenberg and the provision of labor.
- 2). Permit for re-assembly from Geilenberg and provision of labor.
- 3). Definite confirmation of the projected site Bredelar.
- 4). Despatch address for the new site.
- 5). Ascertaining name of the Trustee Administrator (DBHG?)
- 6). Ascertaining name of the Works Commissar for Construction and Erection (DBHG?)
- 7). Ascertaining the name of the assembly firm (Dr. Otto?)

8). Ascertaining the name of the Werke Commissar for Production (Rheinpreussen).

Re: Storage Places.

Please be advised that for purposes of efficiency, the various storage places have been given individual account numbers. These are as follows:-

22030: All expenditures pertaining to shipments made to Alem, Stiepel, Mann.-Linden, Coswig, Hildesheim, Heilbronn, Bugstall. In the case of the last two cities only those expenditures which are not made for the laboratories, are to be considered.

22031: Shipping expenditures to Herdersleben abd Herdersleben-Nachterstedt.

22032: Expenditures for shipments to Bredelar.

Expenditures incurred for any other shipments, such as for laboratories, experimental stations, etc, shall, as heretofore, be entered under number 2203, next to the account of the consignee.

For example:

2203/490 for Laboratories

2203/491 for motor testing labs.

2203/600 for experimental stations.

Expenditures entered in accounts no. 2203-22032 should show the purpose of the individual shipment.

To the Rustungskommando

Essen - Bredency

Am Wiesental 10.

February 24, 1945

Re New Location

Replying to your letter of the 10th inst. we herewith, give you a list of the new locations of our chemical plants.

The Alcohol & Acetone Plants will be moved to Bredolar in Sauerland. All necessary machines, apparatus and pipefittings have been forwarded there. The building order for this plant has been

The Carburol Plant will be built in a larger scale in Hedersleben near Nachterstadt. The necessary machines, apparatus and pipe fittings have already arrived on the new location; the building order has been given and is being carried out.

For the Fischer Synthesis Plant we have a moving order to Alme in Sauerland. A great part of the machinery apparatus and pipe-fittings for it has arrived. A building order has not yet been given.

The Addresses to which we are moving are as follows: -

Dr. Hermann Häusser & Co., Bredolar

Paul Cullmann & Co., Hedersleben

Karl Henkel & Co., Alme

The Research Laboratories have been moved to Ludenscheid. The order has been given as well.

The Experimental Plant for Research on Iron Catalysts has been moved to Bochum-Stiepel to the building of our Mine Gibraltar-Erbstollen. Here we also intend to erect a pilot plant. The order for the pilot plant has not yet been given.

Up to now 354 railway trucks have left to the new locations.

Steinkohlen Bergwerk

"Rheinpreussen"

Die Direktion

Gez. Kost