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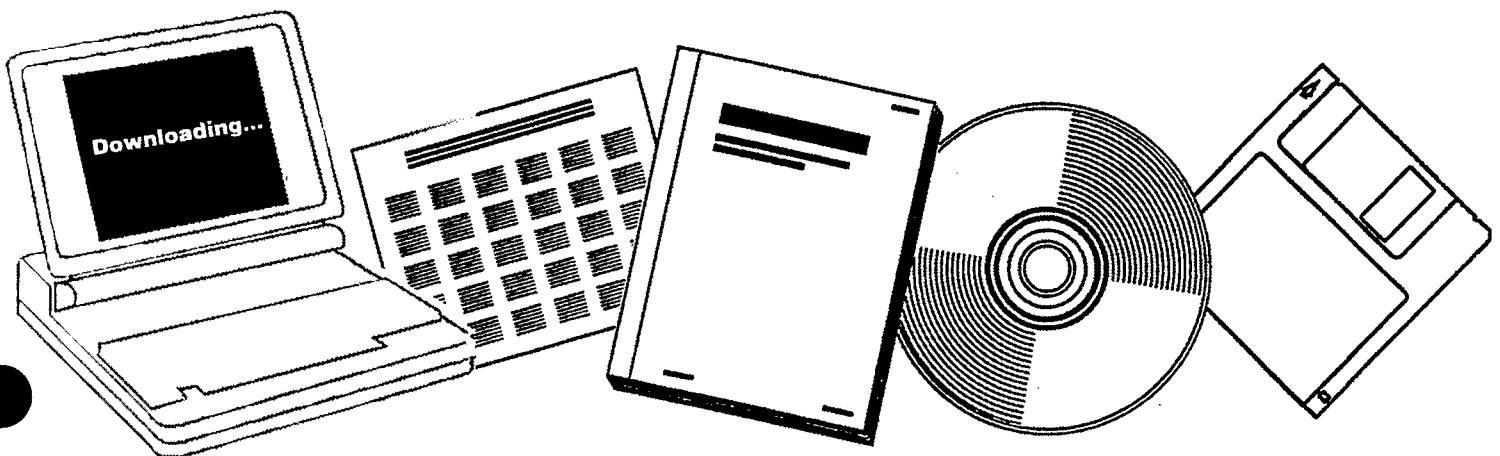
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**COAL LIQUEFACTION: INVESTIGATION OF
REACTOR PERFORMANCE, ROLE OF CATALYSTS,
AND PCT PROPERTIES. TECHNICAL PROGRESS
REPORT**

PITTSBURGH UNIV., PA. DEPT. OF CHEMICAL
AND PETROLEUM ENGINEERING

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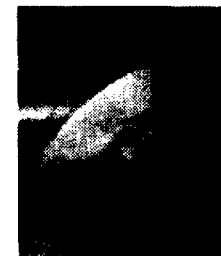
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TECHNICAL PROGRESS REPORT

Coal Liquefaction - Investigation of Reactor
Performance, Role of Catalysts,
and PCT Properties

by

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November, 1985

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INTRODUCTION

The production of liquid fuels from coal is an important area of coal processing science and technology. Future demands for such liquids are expected to increase, and expected declining supplies of petroleum-based fuels will be unable to meet anticipated needs. Three areas of special interest to coal liquefaction are being studied in an on-going project at the University of Pittsburgh. They are reactor design and performance, the role of catalysts, and properties of coal liquids and slurries in direct and indirect coal liquefaction. This report presents the findings of the second year of work. The first year's work was submitted as a Technical Progress Report in October, 1984 to the Department of Energy.

The work was performed by faculty members, staff, post doctoral students, and graduate students in the Chemical and Petroleum Engineering Department, University of Pittsburgh in the period from October 1, 1984 through September 30, 1985.

The faculty members who participated were Alan Brainard, Yatish Shah, John Tierney, and Irving Wender, together with A. Sayari, a visiting research associate. Sebastian Joseph was the postdoctoral student, and Awdhoot Kerkar and Sadettin Ozturk were the graduate students.

SUMMARY

The report is divided into two sections plus an appendix. The first section reports on computer simulations which were developed for three important coal liquefaction processes -- the Mobil Methanol to Gasoline (MTG) process, the Fischer-Tropsch (F-T) process, and the synthesis of methanol. The models are designed to be general and information such as new kinetic equations or new physical property information can be readily added. Each of the models also provides for alternate reactor configurations. For the MTG process either a fixed bed or a fluidized bed can be used. The F-T model provides for a bubble column slurry reactor, a fluidized bed reactor or a fixed bed reactor. Either a fixed bed or a slurry bed can be used in the methanol synthesis model. A comparison of results obtained using the models and results reported in the literature is included to verify the model. Comparisons of alternate processing methods are also included to provide guidance in the selection of a reactor configuration for a specific process. Complete program listings are given in the Appendix, and sample problems with inputs and outputs are provided for the user. The programs are written in the FORTRAN language. It is ultimately desirable to make these models available in a form which can be used in ASPEN, the process simulator developed for DOE. As a first step, the use of ASPEN PLUS to predict thermodynamic and transport properties of systems of interest to coal liquefaction was studied.

In the second section, five areas of potential importance to indirect and direct coal liquefaction are reviewed. They are the synthesis of methanol via methyl formate, the role of carbon dioxide in methanol synthesis, the

synthesis of methanol using noble metal catalysts, the catalytic synthesis of higher alcohols from a new, high-yield sulfur-tolerant catalyst, and the direct liquefaction of coal mixed with heavy oils -- so-called coprocessing. Some unexpected but desirable synergistic effects are found when these two forms of fossil fuels, coal and heavy oil, are processed together. For each of these topics, a careful review of the literature was made and the reported findings evaluated. In certain cases, notably the role of carbon dioxide in methanol synthesis, conflicting experimental results and theories have been reported, although it does appear that the commercial synthesis of methanol proceeds through a carbon dioxide intermediate.

CONTENTS

	<u>Page</u>
I	<u>MODELING OF REACTORS FOR INDIRECT COAL LIQUEFACTION</u>
I-A	METHANOL TO GASOLINE PROCESS..... I-1
	SUMMARY..... I-5
	Introduction..... I-6
	Methanol to Gasoline Process..... I-8
	Reaction Mechanism..... I-10
	Fluidized Bed Reactor..... I-13
	Case Study..... I-25
	Fixed Bed Reactor..... I-29
	Case Study..... I-41
	Comparison of Fixed and Fluidized Bed Reactors..... I-45
	Conclusions..... I-54
	Nomenclature..... I-56
	References..... I-58
	Appendix I-A..... I-A-1
I-B	MODELING OF FISCHER TROPSCH REACTORS
	SUMMARY..... I-66
	Introduction..... I-67
	Slurry Bubble Column Reactor..... I-70
	BCSR Model 1..... I-75
	BCSR Model 2..... I-89
	Fluidized Bed Reactor..... I-104
	FBR Model 1..... I-113
	FBR Model 2..... I-126
	Fixed Bed Reactor..... I-133

CONTENTS (Continued)

	<u>Page</u>
Comparison of Reactor Performance.....	I-141
Conclusions.....	I-157
Nomenclature.....	I-159
References.....	I-164
Appendix I-B.....	I-B-1
I-C	
METHANOL SYNTHESIS PROCESS	
SUMMARY.....	I-172
Introduction.....	I-173
Model Description.....	I-178
Fixed-Bed Reactor Design for Methanol Synthesis.....	I-180
Parameter Effect on Reactor Performance.....	I-195
Slurry-Bed Reactor Design for Methanol Synthesis.....	I-210
Parameter Effect on Reactor Performance.....	I-221
Comparison of the Performances of Fixed and Bubble Column Reactors for Methanol Synthesis.....	I-239
Parameter Estimation for Fixed-Bed Reactor.....	I-243
Parameter Estimation for Slurry-Bed Reactor.....	I-260
Nomenclature.....	I-265
References.....	I-268
Appendix I-C.....	I-C-1
I-D	
THE USE OF ASPEN PLUS PROCESS SIMULATOR.....	I-271
Introduction and Overview.....	I-275
ASPEN Input Language.....	I-277
Use of the RSTOIC Model for the Methanol Synthesis Reactor.....	I-279
Use of ASPEN Plus to Determine Activity Coefficients and Viscosities for Water-Methanol Mixtures.....	I-284

CONTENTS (Continued)

	<u>Page</u>
Incorporating User Models in ASPEN.....	I-288
II	
<u>THE INDIRECT LIQUEFACTION OF COAL AND COPROCESSING OF COAL WITH HEAVY OILS</u>	
II-A	
THE INDIRECT LIQUEFACTION OF COAL	
SUMMARY.....	II-1
The Synthesis of Methanol Via Methyl Formate.....	II-3
Recent Advances in Understanding the Mechanisms of the Synthesis of Methanol.....	II-14
Methanol Synthesis Over Transition Metals.....	II-33
Some Recent Work on the Catalytic Production of Higher Alcohols from Synthesis Gas.....	II-43
II-B	
COPROCESSING OF COAL WITH HEAVY OILS	
SUMMARY.....	II-51
Introduction.....	II-51
Review of Coprocessing Studies.....	II-53
Characterization of Coal-Oil Coprocessing.....	II-68
References.....	II-77