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54 **Process for slurry fischer-tropsch hydrocarbon synthesis with high surface area reduced-carbided iron/manganese catalysts.**

57 Slurried, high surface area, Cu and Group IA or IIA dual metal promoted Mn-Fe spinels which are fully reduced and carburized provide exceptionally high catalytic activity and selectivity in the conversion of CO+H<sub>2</sub> to alpha-olefins, particularly when reduced and carbided in-situ. These copper and Group IA or IIA metal promoted iron-manganese catalysts maintain good activity and selectivity under low pressure reaction conditions in a slurry bubble column reactor.

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**PROCESS FOR SLURRY FISCHER-TROPSCH HYDROCARBON SYNTHESIS WITH HIGH SURFACE AREA REDUCED-CARBIDED IRON/MANGANESE CATALYSTS**

BACKGROUND OF THE INVENTION

Field of the Invention

5 This invention relates to new, dual promoted, high surface area, iron/manganese spinel compositions promoted with copper and with a Group IA or Group IIA metal, their preparation and use in a slurry bubble column reactor. More particularly, this invention relates to new, unsupported, single phase Fe-Mn spinel compositions, dual promoted with copper and a Group IA or Group IIA metal, their preparation and use as catalysts in Fischer-Tropsch slurry processes for producing alpha olefins from mixtures of CO and H<sub>2</sub>. These catalysts have  
10 a surface area greater than about 30 M<sup>2</sup>/g in which the atomic ratio of Fe to Mn is greater than 2:1.

Background of the Disclosure

15 Fischer-Tropsch processes have long been known to produce gaseous and liquid hydrocarbons containing C<sub>2</sub>-C<sub>4</sub> olefins. Because of the importance of C<sub>2</sub>-C<sub>4</sub> olefins, particularly as feedstocks for the chemical industry, modifications of the Fischer-Tropsch process are constantly being pursued toward the goals of maximizing C<sub>2</sub>-C<sub>4</sub> olefin selectivity with the particular objective of maintaining high catalyst activity and stability under the reaction conditions. The main thrust of the efforts in this area has been in the area of catalyst formulation.

20 Coprecipitated and/or supported iron-based catalysts, including those containing manganese, are known for producing C<sub>2</sub>-C<sub>4</sub> olefins. Examples of disclosures in the art directed to such iron-manganese catalysts and/or alloys include: W.L. vanDijk, et al., Appl. Catal., 2, 273 (1982); Eur. Pat. Appl. 49888 to Ruhrchemie (1981); H.J. Lehman, 73rd AIChE Meeting Paper #103D; W.D. Deckwer, et al., Chem. Ing. Tech., 53 (10), 818 (1981); V. Rao and R. Gormley, Hydrocarbon Processing, 139, November (1981); H. Kolbel and K. Tillmetz, U.S. Patent 4,177,203 (1970); EPO Patent Publication 0,071,770; U.S. Patent 2,605,275; U.S. Patent 2,850,515; Prepr. Div. Pet. Chem. Am. Chem. Soc. (1978) 23(2) pp 513-20; Intersoc. Energy Convers. Eng. Conf. 1978, 13(1) pp 482-6; U.S. Patent 4,186,112; EP 49,888; React. Kinet. Catal. Lett. 1982, 20(1-2) pp 175-80; U.S. Patent 2,778,845; Khim. (1) Tekhnol. Topliv i Masel (Russ.) 10(6) 5-10 (1965); UK Patent Appln. 2,050,859 A; German Patent Appln. DT 2919-921; Prace Ustavu Vyzkum Paliv 8, p. 39-81 (1964) (Czech).

30 An iron-manganese spinel of the formula, Fe<sub>2</sub>MnO<sub>4</sub>, is reported as a catalyst component formed during Fischer-Tropsch synthesis in which a coprecipitated Fe/Mn oxide catalyst is initially employed in Applied Catalysis 5(1983) pp. 151-170.

U.S. Patent No. 2,778,845 to McGrath, et al. discloses a non-spinel type, low surface area, sintered catalyst composition containing reduced or metallic iron as a major component. These compositions are used to synthesize hydrocarbons from mixtures of hydrogen and carbon monoxide and are formed via a high temperature fusion in an electric arc furnace. The sintered or fused composition must then be reduced, preferably in hydrogen, to form the metallic iron-containing catalyst. U.S. Patent No. 2,605,275 to Kearby, et al. discloses forming hydrocarbons from mixtures of CO and H<sub>2</sub> employing low surface area, sintered, spinel type catalysts containing iron and a divalent metal of the general formula Fe<sub>2</sub>MeO<sub>4</sub> wherein Me is the divalent metal. The molar ratio of Me to Fe<sub>2</sub>O<sub>3</sub> is preferably greater than 1:1. Thus, the ratio of Fe/Me is no greater than 2/1 and preferably less  
40 than 2/1.

U.S. Patent No. 3,970,738 to Matsui, et al. discloses an iron oxide composition containing a minor amount of manganese oxide and a process for making same. The object of the invention in this disclosure is stated as being able to provide iron oxide products substantially free from manganese compounds as impurities. The upper limit on the manganese component of these iron oxide products is taught and claimed as being less than  
45 0.2 weight percent calculated as MnO. Maiti, et al. in "Iron/Manganese Oxide Catalysts for Fischer-Tropsch Synthesis. Part I: Structural and Textural Changes By Calcination, Reduction and Synthesis", J. Applied Catalysis, v5, p. 151-170 (1983) discloses the use of iron-manganese containing catalysts in a Fischer-Tropsch process to produce olefins. Spinel compositions are suggested as being present in the catalysts used in this reference. This reference does not disclose the use of copper and potassium promoted spinels.

50 Van Dijk, et al. in "Effects of Manganese Oxide and Sulfate on the Olefin Selectivity of Iron Catalysts in the Fischer-Tropsch Reaction", J. Applied Catalysis, v2, p. 273-288 (1982) disclose a Fischer-Tropsch catalyst which, on page 277, is set forth as a mixture of alpha iron oxide, alpha iron hydroxide and Mn<sub>2</sub>O<sub>3</sub>. This reference discloses that these catalysts produce substantially more than about 20% methane make and an equilibrium methane selectivity (on page 283) of over 30%. U.S. Patent No. 4,177,203 to Kolbel, et al. discloses, in line

6-9 of column 3, a Fischer-Tropsch process using a catalyst which contains more than 50% manganese and less than 50% iron. This process produces low molecular weight olefins. Kolbel, et al. in "Feedstock For Chemical Industry By Selective Fischer-Tropsch-Synthese", 1978 Society of Automotive Engineers, p. 482-486, disclose a Fischer-Tropsch catalyst consisting of a precipitated mixture of gamma  $Mn_2O_3$  and alpha  $Fe_2O_3$  inserted in the manganese oxide lattice. Thus, the catalyst composition of this reference consists of mixed oxide phases. Further, the ratio of manganese to iron oxide of the catalyst disclosed therein is set forth as being between 8 and 10.

European Patent 71,770 discloses iron-manganese catalysts promoted with potassium, wherein the maximum ratio of iron to manganese is 1:2. Compositions set forth in the Tables on pages 11 and 13 of this reference disclose iron/manganese ratios of 1:3.

Bruce, et al. in "Light Olefin Production From CO/H<sub>2</sub> Over Silica Supported Fe/Mn/K Catalysts Derived From a Bimetallic Carbonyl Anion, [Fe<sub>2</sub>Mn(CO)<sub>12</sub>]", React. Kinet. Catal. Lett., v. 20, Nos. 1-2, p. 175-180 (1982) disclose olefin production using supported catalysts prepared from carbonyl precursors, with silica being the support. Methane selectivity incurred with the use of this catalyst in Fischer-Tropsch hydrocarbon synthesis reactions is disclosed as about 31% (unpromoted) and 18% (potassium promoted).

Jenson, et al. in "Studies on Iron-Manganese Oxide Carbon Monoxide Catalysts; I. Structure of Reduced Catalyst", J. of Catalysts, v. 92, p. 98-108 (1985) disclose iron-manganese catalysts showing enhanced selectivity for low molecular weight olefins from synthesis gas. The reduced catalyst composition is disclosed as having been found to be an alpha iron oxide and a manganese (II oxide) as separate phases, with the manganese oxide phase containing some divalent iron oxide in solid solution. Maiti, et al. in "Iron/Manganese Oxide Catalysts For Fischer-Tropsch Synthesis. Part II, Crystal Phase Composition, Activity and Selectivity" J. Appl. Catal. 16 (2) 215-25 (1985) disclose structural changes in the Fe-Mn oxide system under synthesis gases as a function of various pretreatments.

French Patent 2,554,433 discloses passing a mixture of H<sub>2</sub> and CO over a spinel catalyst having the general formula of  $Li_xCu_{1-x}Fe_6O_8$  and French Patent 2,553,399 discloses a similar process employing a catalyst having the general formula of  $Cu_xMn_{1-x}Fe_yCr_{1-y}O_4$ .

Finally, Pennline, et al. in "The Effect of Activation and Promotion on a Fischer-Tropsch Catalyst" 189th ACS National Meeting (Miami Beach 4-28-5/3/85) ACS Div. Fuel Chem. Prep. 30# 2:310-17 (1985) disclose a Fischer-Tropsch catalyst employed in a slurry reactor employing catalysts containing 21% iron 79% manganese oxide activated in-situ, under various conditions.

However, none of the references cited above describe a Fischer-Tropsch hydrocarbon process employing an unsupported single phase Fe/Mn spinel catalyst having an Fe:Mn atomic ratio above 2:1 and a surface area greater than about 30 M<sup>2</sup>/g and being dual promoted with both copper and a Group IA or IIA metal promoter agent in a slurry bubble column reactor.

Co, Ru and Fe catalysts are used to produce high molecular weight hydrocarbons from CO and H<sub>2</sub> in fixed bed reactors. Co and Ru do not catalyze the water-gas shift reaction ( $CO + H_2O \rightarrow CO_2 + H_2$ ) at synthesis temperatures, while Fe catalysts do ( $CO_2$  selectivity > 30%). Fe catalysts produce a more olefinic product, but high recycle ratios are required to decrease the CO<sub>2</sub> production rate. It is very desirable to develop Fe-based catalysts that can produce high C<sub>5</sub>+ yields with low shift selectivity.

Iron catalysts coming close to fulfilling these requirements are used commercially at SASOL. These are Fe-based catalysts promoted with Si, K, and Cu; they are reported to produce ~20% CO<sub>2</sub> and high molecular weight products. Mn is apparently not a crucial component in such catalysts. Our uniquely prepared, high surface area Fe-Mn spinels, show unexpected and desirable behavior. They are the subject of a recently filed patent application (U.S. Serial No. 814,040, filed 12/27/85) that describes their use as fine powders in a slurry reactor to produce C<sub>5</sub>-C<sub>15</sub> α-olefins from CO and H<sub>2</sub>. In slurry reactors, these catalysts convert 40% of the feed CO to CO<sub>2</sub> at 270°C, 75 psi, and 2/1 H<sub>2</sub>/CO. Other researchers have reported that Fe-Mn catalysts prepared differently from these can be useful to produce C<sub>2</sub>-C<sub>4</sub> olefins from CO and H<sub>2</sub>; they do not report low shift activity or high C<sub>5</sub>+ selectivities. The instant invention teaches the unusual combination of low shift activity, low CH<sub>4</sub> selectivity and high C<sub>5</sub>+ yields using pelletized high-surface area Fe/Mn spinels, promoted with K and Cu, and run in fixed bed reactors at low temperature (200-240°C), and high pressure (250-500 psi).

#### SUMMARY OF THE INVENTION

The present invention relates to relatively high surface area, unsupported, single phase, iron-manganese spinels which are dual promoted with both copper and a Group IA or IIA metal useful for synthesizing alpha olefins from mixtures of CO and H<sub>2</sub> in a slurry process, said spinels having the empirical formula:



wherein x and y are integer or decimal values, other than zero, with the proviso that the sum of x + y is 3 and

the ratio of  $x/y$  is above 2:1, wherein said spinel exhibits a powder X-ray diffraction pattern substantially isostructural with  $\text{Fe}_3\text{O}_4$ , with said promoter metals being substantially deposited on the surface of said spinel and said surface area of said spinel being greater than about  $30 \text{ M}^2/\text{g}$ .

5 These catalyst compositions provide greater catalytic activity and also greater selectivity towards alpha olefins than similar compositions such as the relatively low surface area iron-manganese spinels. Further, the catalyst compositions of this invention are active both in fixed bed and in slurry hydrocarbon synthesis processes, compared to the catalysts of said co-pending applications which are substantially inactive in slurry processes.

10 The high surface area catalyst compositions of this invention can be prepared by a process of adding an alpha-hydroxy aliphatic carboxylic acid, e.g., glycolic acid, to an acidic aqueous solution containing dissolved iron and manganese salts and subsequently evaporating the solution to dryness to yield an amorphous, mixed metal glycolate, which, on calcining at elevated temperature, forms a mixed metal oxide exhibiting a spinel crystal structure and possessing a high surface area. The unsupported, high surface area Mn-Fe spinels prepared in this manner possess BET surface areas greater than  $30 \text{ M}^2/\text{g}$ . Typically, the spinels of this invention will have surface areas ranging between about  $50\text{-}200 \text{ M}^2/\text{g}$ .

15 The so-formed mixed metal oxide or spinel is then converted to the catalyst by contacting, at elevated temperature, with a mixture of  $\text{H}_2$  and  $\text{CO}$  to form the reduced-carbided catalysts. Preferably the reduction and carbiding is accomplished in-situ in a slurry bed.

20 The spinels prepared according to the process of this invention may be promoted by surface impregnation or deposition with Group IA or Group IIA and copper metal salts prior to the reduction and carbiding step.

#### DETAILED DESCRIPTION OF THE INVENTION

25 The unsupported, high surface area, copper and alkali- or alkaline earth metal salt promoted iron-manganese single phase spinels of this invention are new compositions of matter which are isostructural with  $\text{Fe}_3\text{O}_4$ , as determined by X-ray diffractometry using copper K alpha radiation and exhibit a single spinel phase. By the term "spinel" is meant a crystal structure whose general stoichiometry corresponds to  $\text{AB}_2\text{O}_4$ , where A and B can be the same or different cations. Included within this definition is the commonly found spinel,  $\text{MgAl}_2\text{O}_4$ , A and B can have the following cationic charge combinations:  $A=+2, B=+3$ ,  $A=+4, B=+2$ , or  $A=+6, B=+1$ . Spinels contain an approximately cubic close-packed arrangement of oxygen atoms with  $1/8$ th of the available tetrahedral interstices and  $1/2$  of the octahedral interstices filled, and can exhibit hundreds of different phases. Further description of the spinel structure can be found in "Structural Inorganic Chemistry" by A.F. Wells, Third Edition, Oxford Press, and the Article "Crystal Chemistry and Some Magnetic Properties of Mixed Metal Oxides with the Spinel Structure" by G. Blasse, Phillips Research Review Supplement, Volume 3, pp 1-30 (1964). By the term "isostructural" is meant crystallizing in the same general structure type such that the arrangement of the atoms remains very similar with only minor change in unit cell constants, bond energies and angles. By the term "single phase spinel", as used herein, is meant one structural and compositional formula, corresponding to a single spinel material into which all of the metal components are incorporated, and exhibiting one characteristic X-ray diffraction pattern.

40 The catalyst of the instant invention is prepared by calcining a glycolate complex of iron and manganese as described in detail in U.S. 814,040. Ferric nitrate and manganese nitrate are dissolved in water, and mixed together. A second solution is prepared by adding to glycolic acid a sufficient amount of ammonium hydroxide to keep the pH of the resulting ammonium glycolate solution at about 6.5. The amount of glycolic acid is chosen such that the molar ratio of glycolic acid to iron plus manganese is about 1:1. The ammonium glycolate and iron-manganese nitrate solutions are combined, and the resulting solution on evaporation swells to form an amorphous mass. When heated between  $175\text{-}500^\circ\text{C}$  a high surface area ( $50\text{-}100 \text{ m}^2/\text{gm}$ ) mono-phasic iron manganese spinel, isomorphous with magnetite forms. This spinel is promoted with 2% K and 1% Cu, piled, and sieved to retain  $150\text{-}500 \mu$  particles ( $40\text{-}100$  mesh).

50 The catalyst was then charged into a fixed bed reactor and run at the conditions described in the attached Tables. Table 6 compares the catalyst described here with the SASOL Fe-based catalysts. Table 7 compares the catalyst performance in fixed bed and continuously stirred slurry reactors. Tables 11 and 12 show the performance in a slurry bubble column reactor.

55 The copper and Group IA or Group IIA metal promoted iron-manganese spinels of this invention possesses a BET surface area of over  $30 \text{ M}^2/\text{g}$  and typically of from about  $50\text{-}100 \text{ M}^2/\text{g}$  with about  $100 \text{ M}^2/\text{g}$  being a general average surface area, as determined by the well-known BET surface area measurement technique as described in the reference JACS 60, p. 309 (1938) by S. Brunauer, P. H. Emmett, and G. Teller. This range of surface area generally corresponds to a particle size range of about 100 to 200 angstroms.

The spinel can be represented by the formula:  $\text{Fe}_x\text{Mn}_y\text{O}_4$ , wherein x and y are decimal or integer values,

other than zero, and wherein the sum of x plus y is 3, and the ratio of x to y is greater than 2:1, preferably being from above 2:1 to about 19:1. Particularly preferred is where the iron to manganese atomic ratio is about 3:1 to 7:1. The composition can further be comprised of a mixture of single phase spinels, of different iron-manganese atomic ratios.

5 Representative examples of the various spinels corresponding to the formula are  $\text{Fe}_{2.85}\text{Mn}_{0.15}\text{O}_4$ ,  $\text{Fe}_{2.625}\text{Mn}_{0.375}\text{O}_4$ ,  $\text{Fe}_{2.25}\text{Mn}_{0.75}\text{O}_4$ . A dual promoted spinel composition of the subject invention which is set forth in the Examples below is  $\text{Fe}_{2.25}\text{Mn}_{0.75}\text{O}_4/2\% \text{K}$ , 1% Cu.

In general, the physical properties of the subject spinels of this invention are similar to those of magnetite and include melting point of above 1400°C, and a color of brownish-red. The dual promoted, iron-manganese spinels of this invention are used in unsupported form in  $\text{H}_2/\text{CO}$  hydrocarbon synthesis.

10 Representative examples of suitable classes of the copper and Group IA and IIA metal promoter agents include carbonates, bicarbonates, organic acid and inorganic acid salts e.g. acetates, nitrates, halides, and hydroxide salts of copper and Group IA and IIA metals including lithium, sodium, potassium, cesium, rubidium, barium, strontium, magnesium and the like. The use of sulfate salts of the promoter metal should be avoided, because it has been found that the resulting catalyst will be inactive in the slurry process.

15 Representative examples of specific promoter agents include copper carbonate, copper bicarbonate, copper nitrate, potassium carbonate, potassium bicarbonate, cesium chloride, rubidium nitrate, lithium acetate, potassium hydroxide, and the like. Group IA compounds are preferred with the copper with potassium being particularly preferred. The Group IA and IIA promoters will be present in an amount of from about a 0.1 to 10 gram-atom % of the total gram-atoms of metals present. A preferred level of promoter agent is in the range of 1 to 2 gram-atom % of the total gram-atom metal present. In the empirical formulas used herein, the amount of the promoter agent, e.g., potassium, is expressed in terms of gram atom percent based on the total gram-atoms of metals used. Thus, "1 gram-atom percent of potassium signifies the presence of 1 gram-atom of potassium per 100 total gram atoms of combined gram atoms of Fe and Mn. Thus, the symbol "1% K" as used herein indicates 1 gram-atom percent potassium based on each 100 gram atom of the total gram atom of iron and manganese present.

The copper promoter metal will be present in the catalyst in an amount of from about 0.1 to 2.0 gram-atom percent based on the total metal content of the final catalyst composition and preferably from about 0.5 to 1.5 gram-atom percent.

20 The utility of these spinels is their ability upon subsequent reduction-carbiding, preferably in-situ in a slurry bed, to form active catalysts useful for making  $\text{C}_2\text{-C}_{20}$  olefins from CO/hydrogen in a Fischer-Tropsch slurry process.

The reduced-carbided forms of the above-described spinel are also subjects of this invention.

25 The copper and Group IA or IIA metal promoted spinels undergo unexpectedly facile in-situ reduction in a slurry liquid and pretreatment to form copper and Group IA or IIA metal promoted iron-manganese spinels in reduced form, which are further in-situ carbided to form slurry catalysts active in a Fischer-Tropsch slurry process for making  $\text{C}_2\text{-C}_{20}$  olefins from CO/hydrogen.

30 The spinels can be made by a process in which an aqueous solution of manganese and iron salts of an alpha-hydroxy aliphatic carboxylic acid, is evaporated to dryness, leaving an amorphous residue, which is then heated at elevated temperature to substantially form the spinel, as a single spinel phase, being isostructural with  $\text{Fe}_3\text{O}_4$  and possessing a surface area greater than 30  $\text{M}^2/\text{g}$ , preferably above 50  $\text{M}^2/\text{g}$ . The heating is conducted such that no significant loss in surface area of the final spinel is incurred.

35 The key to the synthesis of these high surface area spinels is in the use of an organic, saturated, aliphatic, alpha-hydroxy carboxylic acid to form a complex salt, which is soluble in the aforementioned aqueous medium, at a pH on the acidic side, i.e., pH of 5-7. The solubility of the iron and manganese organic salts of the alpha-hydroxy carboxylic acid prevent crystallization from occurring, which would result in a crystalline product being obtained from the solution, that would possess a relatively low surface area.

40 This method of preparation utilizes an alpha-hydroxy aliphatic carboxylic acid which acts as a solubilizing agent for the iron and cobalt salts in the aqueous solution. Any saturated aliphatic alpha-hydroxy carboxylic acid, containing at least one alpha-hydroxy grouping, can be used to form the soluble iron and manganese salts in the subject invention process in aqueous solution, is deemed to be included within the scope of this invention. Representative examples of such acids which can be mono-hydroxy or di-hydroxy or monocarboxylic or di-carboxylic are glycolic, malic, glyceric, mandelic, tartaric, lactic acids and mixtures thereof. A preferred carboxylic acid used in the process is glycolic acid.

45 The amount of acid used is at least the stoichiometric amount, i.e., 1 to 1 molar ratio for each metal present and preferably in about a 5-10% molar excess of the stoichiometric amount. Higher ratios can be used, if it is economical to do so. Lower amounts can also be used but would result in incomplete iron and cobalt acid salt formation.

The first step in the process comprises forming an aqueous solution by dissolving iron salts and manganese salts, in a water-soluble salt form such as their nitrates, sulfates, chlorides, acetates, and the like, in water.

The concentration of the salts in the aqueous liquid is not critical to the extent that the salts are present in less than a saturated solution to avoid precipitation. For example, an 80-90% saturated solution, of combined dissolved metal molarities for avoiding precipitation in the process, can be effectively used.

The temperature of the aqueous solution is not critical and may be above room temperature to aid in the solubilizing process. However, room temperature is adequate and is the temperature generally used in the process. The pressure also is not critical in the process and atmospheric pressure is generally used.

The aqueous solution can also contain a small amount of organic solvent such as ethanol, acetone, and the like for aiding in the solubilizing of the iron and manganese salts of the alpha-hydroxy carboxylic acid.

Following the dissolving of the iron and manganese salts, the alpha-hydroxy carboxylic acid is added, together with a sufficient quantity of base, usually being ammonium hydroxide, sodium hydroxide, potassium hydroxide, and the like, preferably ammonium hydroxide, to solubilizing the resulting acid salts. The amount of base added is sufficient to keep the pH in the range of about 5 to 7.0.

It should be noted that the exact sequence of steps need not be adhered to as described above, with the proviso that the resulting aqueous solution contain dissolved iron and manganese salts in stoichiometric amounts as iron and manganese salts of alpha-hydroxy carboxylic acid in solution. If there are any insoluble materials present after addition of the base and organic acid, they should be filtered prior to the evaporation step.

At this point, the resulting solution is evaporated, as for example, by air drying, or under reduced pressure, at elevated temperature, as practiced in a rotary evaporator, or in a vacuum drying oven.

The resulting material from the evaporation step is an amorphous residue, generally being a powder. This residue is heated at elevated temperature at 100 to 350°C preferably 100-200°C and still more preferably 150-200°C for about 1 to 24 hours in generally air to result in a substantially single spinel phase which is isostructural with  $\text{Fe}_3\text{O}_4$ , as determined by X-ray diffractometry, as previously described herein. Preferred temperature range is 100-400°C, and particularly preferred is about 350°C for single phase spinel formation.

The dual promoted spinel is then reduced and carbided to form the catalyst. This reduction and carbiding is done by contacting the dual promoted spinel, at elevated temperature, with a suitable reactant such as CO, CO/H<sub>2</sub>, aliphatic or aromatic hydrocarbons, and the like. Preferably the reduction and carbiding is accomplished simultaneously with a mixture of CO/H<sub>2</sub> with a CO/H<sub>2</sub> molar ratio of from about 1:10 to 10:1. A ratio of 1:2 has been found to be convenient in the laboratory. Still more preferably this reduction and carbiding will be accomplished in-situ in a slurry liquid in a reactor.

The reduction-carbiding step is generally conducted at a temperature of about 250°C, or above and preferably at 300 to 400°C and still more preferably 270-290°C. A preferred method of reducing and carbiding the catalyst is in-situ in the slurry liquid to be used in the Fischer-Tropsch process. A particularly preferred method is where the promoted spinel is treated with a mixture of CO/hydrogen and reduced and carbided in-situ in one step prior to hydrocarbon synthesis. The pressure is generally about 1 atmosphere, and a space velocity of about 20-20,000 v/v/hr is chosen in order to completely carbide the iron present in the spinel.

The resulting carbide is an active slurry catalyst for producing C<sub>2</sub>-C<sub>20</sub> olefins in the described Fischer-Tropsch slurry process.

Also, a subject of the instant invention is a Fischer-Tropsch process for producing C<sub>2</sub>-C<sub>20</sub> olefins by utilizing the Group IA or IIA metal and copper promoted iron-manganese spinel, and the reduced, carbided, Group IA or IIA metal and copper promoted iron-manganese spinel catalyst described hereinabove.

Although a fixed bed process can be used, a preferred process mode for operating the Fischer-Tropsch process utilizing the catalysts described herein is a slurry-type process wherein the catalyst in fine particle size and high surface area being above 30 M<sup>2</sup>/g is suspended in a liquid hydrocarbon and the CO/hydrogen mixture forced through the catalyst slurry allowing good contact between the CO/hydrogen and the catalyst to initiate and maintain the hydrocarbon synthesis process. Especially preferred is a slurry process conducted in a bubble column reactor.

Advantages of a slurry process over that of a fixed bed process are that there is better control of the exothermic heat produced in the Fischer-Tropsch process during the reaction and that better control over catalyst activity maintenance by allowing continuous recycle, recovery, and rejuvenation procedures to be implemented. The slurry process can be operated in a batch or in a continuous cycle, and in the continuous cycle, the entire slurry can be circulated in the system allowing for better control of the primary products residence time in the reaction zone.

The slurry liquid used in the slurry process must be liquid at the reaction temperature, must be chemically inert under the reaction conditions and must be a relatively good solvent for CO/hydrogen and possess good slurrying and dispersing properties for the finely divided catalyst. Representative classes of organic liquids

which can be utilized are high boiling paraffins, aromatic hydrocarbons, ethers, amines, or mixtures thereof. The high boiling paraffins include C<sub>10</sub>-C<sub>50</sub> linear or branched paraffinic hydrocarbons; the aromatic hydrocarbons include C<sub>2</sub>-C<sub>20</sub> single ring and multi- and fused ring aromatic hydrocarbons; the ethers include aromatic ethers and substituted aromatic ethers where the ether oxygen is sterically hindered from being hydrogenated; the amines include long chain amines which can be primary, secondary, and tertiary amines, wherein primary amines preferably contain at least a C<sub>12</sub> alkyl group in length, secondary amines preferably contain at least two alkyl groups being C<sub>7</sub> or greater in length, and tertiary amines preferably contain at least three alkyl groups being C<sub>6</sub> or higher in length. The slurry liquid can contain N and O in the molecular structure but not S, P, As or Sb, since these are poisons in the slurry process. Representative examples of specific liquid slurry solvents useful are dodecane, tetradecane, hexadecane, octadecane, cosane, tetracosane, octacosane, dotriacontane, hexatriacontane, tetracontane, tetratetracontane, toluene, o-, m-, and p-xylene, mesitylene, C<sub>1</sub>-C<sub>12</sub> mono- and multi-alkyl substituted benzenes, dodecylbenzene, naphthalene, anthracene, biphenyl, diphenylether, dodecylamine, dinonylamine, trio-cetylamine, and the like. Preferred liquid hydrocarbon slurry solvent is octacosane or hexadecane.

The amount of catalyst used in the liquid hydrocarbon slurry solvent is generally about 1 to 100 g. of dry catalyst per 500 g. slurry liquid. Preferably about 5 to 50 g. dry catalyst per 500 g. slurry liquid slurry is utilized, being in about a respective 5:1 to 100:1 weight ratio.

The slurry system, comprised of the slurry liquid and finely divided catalyst, is generally stirred to promote good dispersion during the pretreatment in the process to avoid catalyst settling and to eliminate mass transport limitations between the gas and liquid phases when operated in a CSTR. Slurry recycle is employed when operating in a bubble column.

In the process, the hydrogen and CO are used in a molar ratio in the gaseous feedstream in about a 10:1 to 1:10 molar ratio, preferably 3:1 to 0.5:1, and particularly preferred 1:1 to 2:1 molar ratio.

The temperature used in the process of this invention will generally be at least about 250°C, i.e., 250-300°C, preferably being 260 to 280°C, and particularly preferred 260-270°C. Higher temperature ranges can also be used but tend to lead to lighter products and more methane, lower temperature ranges can also be used but tend to lead to lower activity and wax formation. The pressure useful in the process of this invention will range between about 50 to 400 psig and preferably about 70 to 225 psig. Higher pressure can also be used but tend to lead to waxy materials, particularly in combination with lower temperature.

The space velocity used in the process is generally about 100 to 20,000 volumes of gaseous feedstream/per volume of dry catalyst in the slurry/per hour and is preferably in the range of about 1,000 to 15,000 v/v/hr, more preferably 1,000-10,000 v/v/hr and still more preferably 5,000 to 10,000. Higher space velocities can also be used but tend to lead to lower % CO conversion, and lower space velocities can also be used but tend to lead to more paraffinic products.

The percent CO conversion obtainable in the subject process, while providing substantial quantities of C<sub>2</sub>-C<sub>20</sub> olefins, ranges from about 30 to 80 percent and usually about 50 to 60 percent for sufficient C<sub>2</sub>-C<sub>20</sub> olefin production.

"Total hydrocarbons" produced in the process is related to the selectivity of percent CO conversion to hydrocarbons being those hydrocarbons from C<sub>1</sub> to about C<sub>40</sub> inclusive. Total hydrocarbon selectivity is generally 0 to 70 percent and higher, of the total CO converted, and the remainder converted to CO<sub>2</sub>.

The percent C<sub>2</sub>-C<sub>20</sub> hydrocarbons of the total hydrocarbons produced including methane and above is about 60 to 90 wt%. The percent of C<sub>2</sub>-C<sub>20</sub> olefins produced, of the C<sub>2</sub>-C<sub>20</sub> total hydrocarbons produced is about 60 to 70 wt%. The olefins produced in the process are substantially alpha olefins.

The selectivity to methane based on the amount of CO conversion is about 1 to 10 weight percent of total hydrocarbons, produced. Preferably about 5 percent, and lower, methane is produced in the process.

As discussed above, the percent selectivity to CO<sub>2</sub> formation in the process is about 10 to 50 percent of CO converted.

Preferably, the reaction process variables are adjusted to minimize CO<sub>2</sub> production, minimize methane production, maximize percent CO conversion, and maximize percent C<sub>2</sub>-C<sub>20</sub> olefin selectivity, while achieving activity maintenance in the catalyst system. In the laboratory, it is convenient to use octacosane as the slurry liquid employing a catalyst represented by the formula Fe<sub>2.25</sub>Mn<sub>0.75</sub>O<sub>4</sub>/1% Cu, 2% K and the catalyst/liquid weight ratio of 7/500, while stirring the slurry at 600 rpm. The conditions used in the laboratory both to activate the catalyst in-situ in the slurry liquid and to conduct the Fischer-Tropsch hydrocarbon synthesis process include an H<sub>2</sub>/CO molar ratio of 2:1, a temperature of about 270°C, a total pressure of 75 psig and space velocity of 1,000-12,000 v/v/hr. These conditions have been found to result in efficient maintenance of the catalyst activity and C<sub>2</sub>-C<sub>20</sub> olefin production.

The effluent gases in the process exiting from the reactor may be recycled if desired to the reactor for further CO hydrocarbon synthesis.

Methods for collecting the products in the process are known in the art and include fractional distillation, and the like. Methods for analyzing the product liquid hydrocarbons and gaseous streams are also known in the art and generally include gas chromatography, liquid chromatography, high pressure liquid chromatography and the like.

5 This invention will be more readily understood by reference to the examples below.

## EXAMPLES

10 Unless otherwise indicated, the selectivity weight percentages, based on carbon, of product hydrocarbons is given on a CO<sub>2</sub>-free basis.

### Catalyst Evaluation Under CSTR-Slurry Reactor Conditions

15 Into a slurry reactor, being a 300 cc Parr CSTR (continuous stirred tank reactor) wash charged: 72 g of octacosane and 0.5-8.0 g. of the spinel or catalyst being studied. The system was purged with nitrogen while the temperature was increased from room temperature to 200°C. The system was then placed under CO hydrogenation reaction conditions by adjusting the reaction temperature to 270°C, the H<sub>2</sub>/CO volume ratio to 2:1, the space velocity to 1500-24,000 V gaseous feedstream/V dry catalyst/hr, the pressure to 75 psig, and the slurry stirrer speed to 600 rpm in the octacosane solvent. The effluent gas from the reactor was monitored by  
20 an HP-5840A Refinery Gas Analyzer to determine percent CO conversion and the nature of the hydrocarbon products.

### EXAMPLE 1

#### 25 Preparation of High Surface Area Fe<sub>2.25</sub>Mn<sub>0.75</sub>O<sub>4</sub> Spinel

30 39.1 grams of ferric nitrate (Fe(NO<sub>3</sub>)<sub>3</sub>·9H<sub>2</sub>O) in 55 cc of water and 9.3 grams of manganese nitrate Mn(NO<sub>3</sub>)<sub>2</sub>·6H<sub>2</sub>O in 10 cc of water were mixed together. A solution was prepared by adding to 11.5 grams of 85% glycolic acid a sufficient amount of ammonium hydroxide such that the resulting pH of the ammonium glycolate solution was about 6.5. The ammonium glycolate solution constituted .129 moles of glycolic acid such that about a one to one molar ratio of iron and manganese metal to glycolic acid resulted. The ammonium glycolate solution was added to the aqueous solution containing iron and manganese salts and the contents stirred. The resulting solution was allowed to evaporate by air drying at room temperature.

35 The resulting dry solid was shown by X-ray diffraction to be an amorphous material because of lack of sharp, discrete reflections. The solid was heated in air at 175°C for two hours. An X-ray diffraction pattern of the resulting material showed it to be a single phase, manganese/iron spinel isomorphous with Fe<sub>3</sub>O<sub>4</sub>. The X-ray diffraction peaks were broadened relative to a compositionally equivalent material obtained by a higher temperature procedure. This indicated that the resulting obtained material was of very small particle size. The surface area of the resulting material was about 100 square meters per gram.

40 The resulting material was then impregnated with (one or two) gram atomic percent of potassium using an aqueous solution of potassium carbonate and drying the resulting impregnated sample at 125°C. The resulting solid had an empirical formula of Fe<sub>2.25</sub>Mn<sub>0.75</sub>O<sub>4</sub>/2% K. For the samples also containing the Cu promoter, 1 gm atom % of Cu, via an aqueous copper nitrate solution was impregnated onto the sample which was then dried at 125°C.

### EXAMPLE 2

#### Effect of Fe:Mn Ratio

50 Four high surface area Cu and K promoted spinels were made following the procedure set forth in Example 1. One spinel had the composition set forth in Example 1 whereas the Fe:Mn ratio of the other two spinels was changed by varying the relative amounts of the ferric and manganese nitrate reagents. Two grams of each spinel were then loaded into the CSTR reactor, with the results listed in Tables 1 and 2 below.

55



TABLE 1CSTR PERFORMANCE AS AFUNCTION OF Fe:Mn RATIO

5

Fe<sub>3-x</sub>Mn<sub>x</sub>O<sub>4</sub>/2%K, 1% Cu (>50 M<sup>2</sup>/g spinels)

X = 0.75 1.5 2.75

10

% CO Conversion 83 30 Nil

Wt% Selectivity (based on C<sub>1</sub>+ hydrocarbons)CH<sub>4</sub> 2.3 2.6 NA

15

% α-olefin in C<sub>2</sub>-C<sub>4</sub> 93 86 NA

Conditions: 2.0 gms catalyst, 270°C, 75 psig,  
120:60:20 SCCM H<sub>2</sub>:CO:N<sub>2</sub>, 72 gms octaco-  
sane solvent, 30+ hr on stream.

20

25 The data in Table 3 demonstrates the good activity and α-olefin selectivity obtained with the catalyst of the present invention containing Mn up to the Mn:Fe ratio of 1:3 i.e. x=0.75. In contrast, an identical catalyst containing higher levels of Mn where Mn:Fe = 1:1 or 11:1, i.e. x = 1.5 or 2.75, exhibited substantially lower activity under the indicated slurry reactor conditions.

30

TABLE 2CSTR PERFORMANCE AS A FUNCTION OF Fe:Mn RATIO

35

Fe<sub>3-x</sub>Mn<sub>x</sub>O<sub>4</sub>/2% K, 1% Cu (>50 M<sup>2</sup>/g spinels)

X = 0.15 0.75

% CO Conversion 79 87

40

Wt% Selectivity (Based on C<sub>1</sub>+ hydrocarbons)CH<sub>4</sub> 4.2 4.1% Olefins in C<sub>2</sub>-C<sub>4</sub> 94 92

45

Conditions: 8 gms catalyst, 270°C, 75 psig,  
120:60:20 SCCM H<sub>2</sub>:CO:N<sub>2</sub>, 72 gms octaco-  
sane solvent, 30+ hr on stream.

50

The data in Table 4 demonstrate the high activity and α-olefin selectivity of the catalyst of the present invention when the Fe/Mn ratio is maintained in the range 3/1 to 19:1.

EXAMPLE 3

55

In this example, the CSTR performance of two high surface area glycolate derived spinels prepared according to the procedure set forth in Example 1 were compared to a potassium promoted, precipitated Fe-Mn oxide prepared according to the procedure of Kolbel in U.S. 4,177,203 and H. Schulz, Proceedings 8th Int. Congress

on Catalysis, II, p. 123-133 (1985). Thus an aqueous solution of 57.5 g of  $Mn(NO_3)_2 \cdot 6H_2O$  in 100 cc of  $H_2O$  was added to a solution of 7.23 g of  $Fe(NO_3)_3 \cdot 9H_2O$  dissolved in 10 cc of  $H_2O$ . The combined solutions were heated to 80°C and about 100 cc of  $NH_4OH$  was added to form a precipitate which was filtered and dried in air overnight at 110°C. Four g of the resulting powder was impregnated with 2 cc of a solution prepared by dissolving 0.85 g  $K_2CO_3$  in 100 cc  $H_2O$  and dried.

The results are set forth in Table 5.

TABLE 3  
RELATIVE PERFORMANCE OF GLYCOLATE DERIVED  
SPINELS AND PRECIPITATED, LOW Fe-Mn RATIO CATALYST

	2% K, 1% Cu Promoted Glycolate Derived	1% Cu Glycolate Spinel	0.5% K Promoted, Precipitated, Fe-Mn
Fe:Mn	3:1	1:11	1:11
% CO Conversion	83	Nil	Nil
<u>Wt% Selectivity</u> (based on $C_1+$ hydrocarbons)			
CH <sub>4</sub>	1.9	*	*
% $\alpha$ -olefin in $C_2-C_4$	93	*	*

Conditions: 2 gms catalyst, 270°C, 75 psig,  
120:60:20 SCCM  $H_2:CO:N_2$ , 72 gms octa-  
cosane, 20+ hr on stream.

\* Insufficient quantities of product generated  
meaningful analysis.

The data in Table 3 demonstrate the superior performance of the catalyst of the present invention relative to a catalyst prepared by the method described in U.S. 4,177,203, etc. which was inactive in the slurry process. In addition, the catalyst prepared by the method of the present invention but containing Mn outside of the prescribed range, i.e. Fe-Mn = 1:11 is found to be inactive under the low pressure slurry conditions employed.

#### EXAMPLE 4

In this example, the CSTR performance of a high surface area Cu and K promoted spinel of this invention was compared to a precipitated Fe-Mn oxide prepared according to the procedure set forth by Maiti et al. Thus, a catalyst was prepared by the procedure described by Maiti et al. (Appl. Cat. 16(2), 215 (1985) in the Fe/Mn range where he observed his most olefinic products: 98.8 of  $Fe(NO_3)_3 \cdot 9H_2O$  and 2.2 gm  $Mn(NO_3)_2 \cdot 6H_2O$  were dissolved in 140 and 4 cc of  $H_2O$  respectively and mixed to form a single solution. A 10 wt%  $NH_4OH$  solution was added to bring the pH of the nitrate solution to 6.4. This solution was then heated to 70°C. This nitrate solution and the  $NH_4OH$  solution were placed in two separatory funnels and while stirring constantly, each solution was added dropwise into a single mixing vessel maintaining the pH of the solution between 9.2 and 9.6 while the precipitate formed. The precipitate was filtered, and washed several times with  $H_2O$ , dried at 120°C and finally calcined at 500°C.

The Maiti catalyst was charged into a CSTR reactor.

TABLE 4

5                    RELATIVE PERFORMANCE OF GLYCOLATE DERIVED  
SPINELS AND PRECIPITATED, HIGH Fe/Mn RATIO CATALYST

	<u>Glycolated Derived</u> Spinel, K, Cu Promoted	<u>Precipitated</u> Prep.
10		
	19:1	32
	1	2
15	68.9	20.5
	1.7	7.4
	93.5	87.2

20

The results show the higher activity, olefinuity and lower methane selectivity with the catalyst of this invention vs. the preparation described in Appl. Cat. 16(2), 215 (1985).

EXAMPLE 5

25

In this Example, the CSTR performance of a high surface area Cu and K promoted spinel of this invention was compared to a precipitated and sintered Fe-Mn composition prepared according to the procedure set forth in U.S. Patent 2,778,845.

30

35

An Fe/Mn catalyst was prepared as described by McGrath et al (U.S. 2,778,845). Thus, 10 gm of  $Mn(NO_3)_2 \cdot 6H_2O$  was dissolved in 2 cc of  $H_2O$  by heating to 80°C. This was mixed with 54 gm of  $Fe_3O_4$ , the analog of Alan Wood magnetite. The paste which formed was dried overnight at 90°C. 0.35 gm of  $K_2CO_3$  in 4 cc  $H_2O$  was heated to 90°C and mixed with the material dried above. An additional 2.5 cc of  $H_2O$  was added to thoroughly mix the  $K_2CO_3$  solution and the dried paste. This was then dried at 90°C for several hours. This mix was heated to 1400°C for 6 hours and cooled. The solidified chunk was ground and heated in a 20%  $H_2$ /80% He stream (at 500 cc/min total flow) at 371°C for 48 hours. The catalyst was gently passivated at room temperature with a 1%  $O_2$ /99% He stream. 2 gms catalyst was loaded in 72 gm of octacocane. The results are shown in Table 5.

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TABLE 5

5  
RELATIVE PERFORMANCE OF GLYCOLATE DERIVED  
 SPINELS AND HIGH TEMPERATURE Fe/Mn CATALYSTS

	Glycolated Derived Spinel Promoted With 2%K, 1% Cu	Precipitated Prep.
10		
	Fe:Mn	3:1
	% CO Conversion	83
15	Wt.% Selectivity (Based on C <sub>1</sub> + hydrocarbons)	7:1 Nil
20	CH <sub>4</sub>	1.9
	% $\alpha$ -olefin, C <sub>2</sub> -C <sub>4</sub>	*

25  
 Conditions: 2 gms catalyst, 270°C, 75 psig, 120:60:  
 20 SCCM H<sub>2</sub>:CO:N<sub>2</sub>, 72 gms octacosane,  
 20+ hr on stream.

30  
 \*Insufficient quantities of product generated for meaningful analysis.

The data in Table 5 demonstrates the superior performance of the catalyst of the present invention relative to a catalyst prepared by the method described in U.S. 2,778,845, which was inactive in the slurry process.

35  
EXAMPLE 6

40  
 The catalyst was prepared by calcining a glycolate complex of iron and manganese as described in detail in U.S. 4,618,597 Ferric nitrate and manganese nitrate are dissolved in water, and mixed together. A second solution is prepared by adding to glycolic acid a sufficient amount of ammonium hydroxide to keep the pH of the resulting ammonium glycolate solution at about 6.5. The amount of glycolic acid is chosen such that the molar ratio of glycolic acid to iron plus manganese is about 1:1. The ammonium glycolate and iron-manganese nitrate solutions are combined, and the resulting solution on evaporation swells to form an amorphous mass. When heated between 175-500°C a high surface area (50-100 m<sup>2</sup>/g) monophasic iron manganese spinel, iso-  
 45  
 morphous with magnetite forms. This spinel is promoted with 2% K and 1% Cu, pilled, and sieved to retain 150-500  $\mu$  particles (40-100 mesh).

The catalyst was then charged into a fixed bed reactor and run at the conditions described in the attached Tables. Table 8 compares the catalyst described here with the SASOL Fe-based catalysts. Table 9 compares the catalyst performance in fixed bed and slurry reactors. Space time yields on C<sub>5</sub>+ are similar on the two catal-  
 50  
 ysts, but CO<sub>2</sub> selectivities much lower on the Fe/Mn spinel, under identical reactor conditions.



TABLE 7

5

COMPARISON OF FIXED BED VERSUS SLURRY BED  
PERFORMANCE OF DUAL PROMOTED Fe-Mn CATALYSTS

Run	35-11	35-8	162
Reactor	fixed-bed	fixed-bed	CSTR slurry
Fe-time yield ( $\text{h}^{-1}$ )	1.5	2.0	11.2
Hours on Stream	200	25	58
CO conversion (%)	30	50	69
Selectivity (C-basis, %)			
CH <sub>4</sub>	4.5	8.6	1.1
C <sub>2</sub> -C <sub>4</sub>	16.5	26.4	1.8
C <sub>5</sub> +	79.0	65	97
CO <sub>2</sub>	8.0	35	38
% Olefin			
C <sub>2</sub> -C <sub>4</sub>	73	82	93
C <sub>10</sub>	50	65	63
Temperature ( $^{\circ}\text{C}$ )	228	263	270
Pressure (psig)	370	65	75
Catalyst Mesh	40-100	40-100	>140

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50

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TABLE 8

COMPARISON OF SASOL CATALYST  
 WITH CATALYST OF THIS INVENTION

	<u>Fe/Mn/Cu/K SASOL Fixed-Bed</u>	<u>Fixed-Bed (Published)</u>
CO Conversion (%)	48	n.a.
Metal-Time Yield (h <sup>-1</sup> )	3.8	n.a.
Space-Time Yield (H <sup>-1</sup> ) (H <sub>2</sub> +CO)	1200	520
Selectivity (% , CO <sub>2</sub> -Free)		
CH <sub>4</sub>	3.5	--
C <sub>2</sub> -C <sub>4</sub>	17.0	--
C <sub>5</sub> +	79.5	81
CO <sub>2</sub>	12.0	232
Temperature (°C)	229	365
Pressure (psig)	365	--
Catalyst Mesh	40-100	--
Run	42-240	--

TABLE 9

5

EFFECT OF ACTIVATION TEMPERATURE ON  
FISCHER-TROPSCH ACTIVITY AND SELECTIVITY

Activation Temperature*	255-260	275-280
(°C)		
	<u>Fe/Mn/Cu/K</u> <u>Fixed-Bed</u>	<u>Fe/Mn/Cu/K</u> <u>Fixed-Bed</u>
CO Conversion (%)	30	48
Metal-Time Yield (h <sup>-1</sup> )	1.5	3.8
Space-Time Yield	450	1200
(H <sup>-1</sup> ) (H <sub>2</sub> +CO)		
Selectivity (% , CO <sub>2</sub> -Free)		
CH <sub>4</sub>	4.5	3.5
C <sub>2</sub> -C <sub>4</sub>	16.5	17.0
C <sub>5</sub> +	79.0	79.5
CO <sub>2</sub>	8.0	12.0
Temperature (°C)	228	229
Pressure (psig)	370	365
Catalyst Mesh	40-100	40-100
Run	35-11	42-240

\* in H<sub>2</sub>/CO = 2/1, 65 psig, 24 h

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50

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TABLE 10

COMPARISON OF Fe Mn Cu K WITH EXXON  
 TEST OF RDV-1 (Arge) COMMERCIAL CATALYST

	Fe/Mn/Cu/K Fixed-Bed	Fe Cu K (Arge) (1)
CO Conversion (%)	48	77
Metal-Time Yield ( $h^{-1}$ )	3.8	n.a.
Space-Time Yield ( $H^{-1}$ ) ( $H_2+CO$ )	1200	540
Selectivity (% , $CO_2$ -Free)		
CH <sub>4</sub>	3.5	7.0
C <sub>2</sub> -C <sub>4</sub>	17.0	--
C <sub>5</sub> +	79.5	--
CO <sub>2</sub>	12.0	8.0
Temperature (°C)	229	220
Pressure (psig)	365	300
Catalyst Mesh	40-100	20-35
Run	42-240	--

(1) J. J. Steger, R. Fiato, T. Vanderspurt, Private  
 Commun. 6/23/82.

Example 7

Catalyst Evaluation Under Bubble-Column Slurry Reactor Conditions

The spinel catalyst of this invention was also evaluated in a slurry bubble-column reactor. The reactor consisted of a 1" diameter by 36" long stainless steel column equipped with a fluidized sandbath heater. The reactor inlet zone contained a 15 micron porous metal injector for introduction of gaseous feed and a separate feed line for introduction of catalyst slurry. Catalyst and the hydrocarbon carrier liquid were charged into a stirred holding vessel equipped with a slurry pump to transfer the mixture to the bubble column reactor, and a nitrogen feed system to maintain an inert environment. This system was operated in two modes: 1) the non-recycle mode where the reactor contained a single catalyst charge; 2) the recycle mode wherein the reactor was continuously fed with catalyst that had passed through the product recovery zone, was recovered in the slurry holding vessel and then fed back to the reactor. Products from the bubble column reactor were passed through a two-state pressure letdown system where volatile products were collected in an off gas stream and nonvolatile products collected in a hot and cold liquid separator. The off gas stream was analyzed on a Hewlett Packard 5840 Refinery Gas Analyzer to determine percent CO conversion and light hydrocarbon selectivity, and the heavy products analyzed by off-line analytical gas chromatography methods.

In the experiments described below, the overall system was first placed under an inert atmosphere of nitrogen, followed by introduction of the synthesis gas feed to the reactor zone. Both nitrogen and argon were added to the synthesis gas feed as tracer gases to monitor overall conversion and selectivity. The overall feed rates for H<sub>2</sub>/CO/N<sub>2</sub>/Ar and the slurry feed rate for the system are listed in the tables below. In those cases when catalyst slurry was not being recycled to the reactor, the slurry feed rate is listed as 0.0 cm<sup>3</sup>/min. The catalyst

in the examples below was prepared by the procedure of Example 1.

The catalyst of Example 1 was tested in a bubble column reactor under the conditions shown in Table 11.

5

Table 11

	Slurry Recycle Rate (cm <sup>3</sup> /min)	0.0	300.0	600.0
	% CO Conversion	30.4	49.0	52.0
10	Selectivity (%wt H <sub>2</sub> O Free)			
	CH <sub>4</sub>	1.2	1.7	1.7
	CO <sub>2</sub>	20.7	21.4	23.5
15	% 1-Olefin in C <sub>10</sub> Fraction	53.9	55.7	58.7

20 Conditions: 3.2 kg of C<sub>30</sub> saturated isoparaffin liquid phase, 100 g of Fe<sub>2.25</sub>Mn<sub>.75</sub>O<sub>4</sub>/2%K/1%Cu catalyst, 270°C, 75 psig, 1600/800/500/300 sccm feed rate of H<sub>2</sub>/COAr/N<sub>2</sub> gases.

25 The results in Table 11 show the low methane selectivity, high CO conversion and high selectivity to C<sub>10</sub> alpha-olefins that are possible with the catalytic process of the present invention when practiced in a bubble column reactor. The improved productivity possible when the system is run in the slurry recycle mode is also demonstrated.

30

Table 12

	Slurry Recycle Rate (cm <sup>3</sup> /min)	0.0	300.0
35	% CO Conversion	14.7	61.8
	Selectivity (%wt H <sub>2</sub> O Free)		
	CH <sub>4</sub>	3.5	2.8
40	CO <sub>2</sub>	20.7	33.0
	% 1-Olefin in C <sub>10</sub> Fraction	48.3	55.0

45 Conditions: 3.2 kg of C<sub>30</sub> saturated isoparaffin liquid phase, 100 g of Fe<sub>2.25</sub>Mn<sub>.75</sub>O<sub>4</sub>/2%K/1% Cu catalyst, 270°C, 150 psig, 1600/800/500/300 sccm feed rate of H<sub>2</sub>/CO/Ar/N<sub>2</sub> gases.

50

The data in Table 12 demonstrated the performance of the catalytic process of the instant invention at 150 psi. The benefits of operating in the slurry recycle mode to the bubble column reactor are evident in the increased CO conversion 61.8 vs. 14.7%, and the low methane and high C<sub>10</sub> alpha-olefin selectivity that are observed at 300 vs. 0.0 cm<sup>3</sup>/min recycle rates.

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NOTES

. U.S. (patent application) Serial No. 814,040 corresponds with European patent application No.

86307363.1, now granted as European patent EP-B-0261288.

- . particle mesh sizes herein are in accordance with the Tyler series
- . "sccm" denotes "standardised cubic centimeters per minute"
- . inch(") = 2.54 cm.
- . "cc" denotes "cm<sup>3</sup>".

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### Claims

- 10 1. A process for synthesizing a hydrocarbon mixture containing C<sub>2</sub>-C<sub>20</sub> olefins comprising contacting in a slurry bubble column reactor a catalyst composition, comprising at least one unsupported, single phase, iron-manganese spinel dual promoted with both copper and a Group IA or IIA metal, said spinel exhibiting a single phase being isostructural with Fe<sub>3</sub>O<sub>4</sub> as determined by powder X-ray diffractometry, and possessing a BET surface area (at least initially) of at least 30 m<sup>2</sup>/g and an Fe:Mn atomic ratio of at least 2/1 (e.g.,
- 15 from 2:1 to 19:1), with a mixture of CO and hydrogen under conditions of pressure, space velocity, and elevated temperature for a time sufficient to produce said C<sub>2</sub>-C<sub>20</sub> olefins (e.g., 60 wt.% C<sub>2</sub>-C<sub>20</sub> olefins in the resulting product hydrocarbon mixture).
- 20 2. The process of claim 1 wherein said catalyst has been reduced and carbided prior to use, either ex situ or in situ (e.g., in situ in the slurry liquid).
3. The process of claim 1 or claim 2 conducted in slurry liquid (e.g., a Fischer-Tropsch slurry liquid) and/or a slurry liquid selected from high boiling liquid paraffins, aromatic hydrocarbons, ethers, amines, or mixtures thereof, under slurry process conditions.
- 25 4. The process of any one of claims 1 to 3 wherein the slurry liquid comprises high boiling liquid paraffins which are C<sub>12</sub>-C<sub>60</sub> linear or branched saturated aliphatic hydrocarbons, e.g., octacosane, hexadecane, or mixtures thereof.
- 30 5. The process of any one of claims 1 to 4 wherein said hydrogen and CO are present in a hydrogen/ CO molar ratio of from 1:10 to 10:1.
6. The process of any one of claims 1 to 5 wherein said temperature is in the range of from about 200 to 300°C.
- 35 7. The process of any one of claims 1 to 6 wherein said pressure is in the range of from about 50 to 250 psig (0.345 to 1.724 MPa).
8. The process of any one of claims 1 to 7 wherein said space velocity is in the range of from about 500 to 20, 000 v/v/hr.
- 40 9. The process of any one of claims 1 to 8 wherein the weight ratio of slurry liquid to dry catalyst is in the range of from about 100:1 to 5:1.
10. The process of any one of claims 1 to 9 wherein said iron and manganese are present in an iron to manganese atomic ratio of 2:1 or above and wherein said copper is present in an amount of from about 0.1 to 5 gram atom % of the iron plus manganese.
- 45 11. The process of any one of claims 1 to 10 wherein said spinel is of the formula: Fe<sub>x</sub>Mn<sub>y</sub>O<sub>4</sub> wherein x and y are integer or decimal values, other than zero, wherein the sum of x+y is 3 and wherein the ratio of x/y is from about 2:1 to 19:1.
- 50 12. The process of any one of claims 1 to 11 wherein said Group IA or IIA promoter agent (e.g., potassium carbonate) is present in said catalyst in the range of from about 0.1 to 10 gram-atom percent of said total gram-atoms of Fe and Mn metals content.
- 55 13. The process of any one of claims 1 to 12 wherein said promoter agent salt substantially does not contain sulfate ions.

14. The process according to any one of claims 1 to 13 wherein catalyst slurry, hydrogen, and CO are concurrently fed to said reactor.

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