

## Contents

	<b>Preface</b>	XVII
	<b>Notation</b>	XXI
<b>1</b>	<b>Introduction</b>	<b>1</b>
1.1	What is Chemical Technology?	1
1.2	The Chemical Industry	2
<b>2</b>	<b>Chemical Aspects of Industrial Chemistry</b>	<b>7</b>
2.1	<b>Stability and Reactivity of Chemical Bonds</b>	<b>7</b>
2.1.1	Factors that Influence the Electronic Nature of Bonds and Atoms	7
2.1.2	Steric Effects	8
2.1.3	Classification of Reagents	9
2.2	<b>General Classification of Reactions</b>	<b>10</b>
2.2.1	Acid–Base Catalyzed Reactions	11
2.2.2	Reactions via Free Radicals	11
2.2.3	Nucleophilic Substitution Reactions	13
2.2.4	Reactions via Carbocations	14
2.2.5	Electrophilic Substitution Reactions at Aromatic Compounds	15
2.2.6	Electrophilic Addition Reactions	17
2.2.7	Nucleophilic Addition Reactions	17
2.2.8	Asymmetric Synthesis	17
2.3	<b>Catalysis</b>	<b>19</b>
2.3.1	Introduction and General Aspects	20
2.3.2	Homogeneous, Heterogeneous, and Biocatalysis	26
2.3.3	Production and Characterization of Heterogeneous Catalysts	29
2.3.4	Deactivation of Catalysts	32
2.3.5	Future Trends in Catalysis Research	35
<b>3</b>	<b>Thermal and Mechanical Unit Operations</b>	<b>39</b>
3.1	<b>Properties of Gases, Liquids, and Solids</b>	<b>40</b>
3.1.1	Ideal and Real Gas	40
3.1.2	Heat Capacities and the Joule–Thomson Effect	45
3.1.3	Physical Transformations of Pure Substances: Vaporization and Melting	48
3.1.4	Transport Properties (Diffusivity, Viscosity, Heat Conduction)	52
3.1.4.1	Basic Equations for Transfer of Heat, Mass, and Momentum	52
3.1.4.2	Transport Coefficients of Gases	57
3.1.4.3	Transport Coefficients of Liquids	61
3.2	<b>Heat and Mass Transfer in Chemical Engineering</b>	<b>65</b>
3.2.1	Heat Transport	66
3.2.1.1	Heat Conduction	66
3.2.1.2	Heat Transfer by Convection (Heat Transfer Coefficients)	67

3.2.1.3	Boiling Heat Transfer	78
3.2.1.4	Heat Transfer by Radiation	79
3.2.1.5	Transient Heat Transfer by Conduction and Convection	80
3.2.2	Mass Transport	84
3.2.2.1	Forced Flow in Empty Tubes and Hydrodynamic Entrance Region	84
3.2.2.2	Steady-State and Transient Diffusive Mass Transfer	85
3.2.2.3	Diffusion in Porous Solids	89
3.3	<b>Thermal Unit Operations</b>	93
3.3.1	Heat Exchangers (Recuperators and Regenerators)	94
3.3.2	Distillation	97
3.3.2.1	Distillation Principles	98
3.3.2.2	Design of Distillation Columns (Ideal Mixtures)	101
3.3.2.3	Azeotropic, Extractive, and Pressure Swing Distillation	106
3.3.2.4	Reactive Distillation	108
3.3.3	Absorption (Gas Scrubbing)	108
3.3.3.1	Absorption Principles	108
3.3.3.2	Design of Absorption Columns	113
3.3.4	Liquid–Liquid Extraction	116
3.3.4.1	Extraction Principles	116
3.3.4.2	Design of Extraction Processes	118
3.3.5	Adsorption	120
3.3.5.1	Adsorption Principles	120
3.3.5.2	Design of Adsorption Processes	130
3.3.6	Fluid–Solid Extraction	136
3.3.6.1	Principles of Fluid–Solid Extraction	136
3.3.6.2	Design of Fluid–Solid Extractions	139
3.3.7	Crystallization	140
3.3.7.1	Ideal Binary Eutectic Phase System	140
3.3.7.2	Ideal Binary Phase System with Both Solids Completely Soluble in One Another	141
3.3.8	Separation by Membranes	144
3.3.8.1	Principles of Membrane Separation	144
3.3.8.2	Applications of Membrane Separation Processes	147
3.4	<b>Mechanical Unit Operations</b>	151
3.4.1	Conveyance of Fluids	152
3.4.1.1	Pressure Loss in Empty Tubes	152
3.4.1.2	Pressure Loss in Fixed, Fluidized, and Entrained Beds	156
3.4.1.3	Compressors and Pumps	159
3.4.2	Contacting and Mixing of Fluids	161
3.4.3	Crushing and Screening of Solids	163
3.4.3.1	Particle Size Reduction	163
3.4.3.2	Particle Size Analysis	164
3.4.3.3	Screening and Classification of Particles (Size Separation)	166
3.4.3.4	Solid–Solid Separation (Sorting of Different Solids)	167
3.4.4	Separation of Solids from Fluids	168
3.4.4.1	Filtration	168
3.4.4.2	Separation of Solids from Fluids by Sedimentation	168
3.4.4.3	Screening and Classification of Particles (Size Separation)	171
4	<b>Chemical Reaction Engineering</b>	175
4.1	<b>Main Aspects and Basic Definitions of Chemical Reaction Engineering</b>	176
4.1.1	Design Aspects and Scale-Up Dimensions of Chemical Reactors	176
4.1.2	Speed of Chemical and Biochemical Reactions	177
4.1.3	Influence of Reactor Type on Productivity	178

4.1.4	Terms used to Characterize the Composition of a Reaction Mixture	179
4.1.5	Terms used to Quantify the Result of a Chemical Conversion	179
4.1.6	Reaction Time and Residence Time	180
4.1.7	Space Velocity and Space–Time Yield	181
<b>4.2</b>	<b>Chemical Thermodynamics</b>	<b>182</b>
4.2.1	Introduction and Perfect Gas Equilibria	183
4.2.2	Real Gas Equilibria	190
4.2.3	Equilibrium of Liquid–Liquid Reactions	193
4.2.4	Equilibrium of Gas–Solid Reactions	195
4.2.5	Calculation of Simultaneous Equilibria	197
<b>4.3</b>	<b>Kinetics of Homogeneous Reactions</b>	<b>200</b>
4.3.1	Rate Equation: Influence of Temperature and Reaction Order	200
4.3.1.1	<i>First-Order Reaction</i>	204
4.3.1.2	<i>Reaction of n-th Order</i>	204
4.3.1.3	<i>Second-Order Reaction</i>	205
4.3.2	Parallel Reactions and Reactions in Series	206
4.3.2.1	<i>Two Parallel First-Order Reactions</i>	206
4.3.2.2	<i>Two First-Order Reactions in Series</i>	207
4.3.3	Reversible Reactions	210
4.3.4	Reactions with Varying Volume (for the Example of a Batch Reactor)	213
<b>4.4</b>	<b>Kinetics of Fluid–Fluid Reactions</b>	<b>216</b>
4.4.1	Mass Transfer at a Gas–Liquid Interface (Two-Film Theory)	217
4.4.2	Mass Transfer with (Slow) Homogeneous Reaction in the Bulk Phase	219
4.4.3	Mass Transfer with Fast or Instantaneous Reaction near or at the Interface	220
<b>4.5</b>	<b>Kinetics of Heterogeneously Catalyzed Reactions</b>	<b>226</b>
4.5.1	Spectrum of Factors Influencing the Rate of Heterogeneously Catalyzed Reactions	227
4.5.2	Chemical Reaction Rate: Surface Kinetics	231
4.5.2.1	<i>Sorption on the Surface of Solid Catalysts</i>	231
4.5.2.2	<i>Rate Equations for Heterogeneously Catalyzed Surface Reactions</i>	231
4.5.3	Reaction on a Solid Catalyst and Interfacial Transport of Mass and Heat	235
4.5.3.1	<i>Interaction of External Mass Transfer and Chemical Reaction</i>	235
4.5.3.2	<i>Combined Influence of External Mass and Heat Transfer on the Effective Rate</i>	239
4.5.4	Chemical Reaction and Internal Transport of Mass and Heat	247
4.5.4.1	<i>Pore Diffusion Resistance and Effective Reaction Rate</i>	247
4.5.4.2	<i>Combined Influence of Pore Diffusion and Intraparticle Heat Transport</i>	252
4.5.5	Simultaneous Occurrence of Interfacial and Internal Mass Transport Effects	254
4.5.5.1	<i>Irreversible First-Order Reaction</i>	254
4.5.5.2	<i>Reversible First-Order Reaction with the Influence of External and Internal Mass Transfer</i>	256
4.5.6	Influence of External and Internal Mass Transfer on Selectivity	259
4.5.6.1	<i>Influence of External Mass Transfer on the Selectivity of Reactions in Series</i>	259
4.5.6.2	<i>Influence of External Mass Transfer on the Selectivity of Parallel Reactions</i>	262
4.5.6.3	<i>Influence of Pore Diffusion on the Selectivity of Reactions in Series</i>	263
4.5.6.4	<i>Influence of Pore Diffusion on the Selectivity of Parallel Reactions</i>	267

<b>4.6</b>	<b>Kinetics of Gas–Solid Reactions</b>	<b>268</b>
4.6.1	Spectrum of Factors Influencing the Rate of Gas–Solid Reactions	269
4.6.2	Reaction of a Gas with a Non-porous Solid	270
4.6.2.1	<i>Survey of Border Cases and Models for a Reaction of a Gas with a Non-porous Solid</i>	270
4.6.2.2	<i>Shrinking Non-porous Unreacted Core and Solid Product Layer</i>	270
4.6.2.3	<i>Shrinking Non-porous Unreacted Core and Gaseous Product(s)</i>	273
4.6.3	Reaction of a Gas with a Porous Solid	276
4.6.3.1	<i>Survey of Border Cases and Models for a Reaction of a Gas with a Porous Solid</i>	276
4.6.3.2	<i>Basic Equations for the Conversion of a Porous Solid with a Gaseous Reactant</i>	277
4.6.3.3	<i>General Closed Solution by Combined Model (Approximation)</i>	277
4.6.3.4	<i>Homogeneous Uniform Conversion Model (No Concentration Gradients)</i>	280
4.6.3.5	<i>Shrinking Unreacted Core Model (Rate Determined by Diffusion Through Product Layer)</i>	280
<b>4.7</b>	<b>Criteria used to Exclude Interphase and Intraparticle Mass and Heat Transport Limitations in Gas–Solid Reactions and Heterogeneously Catalyzed Reactions</b>	<b>282</b>
4.7.1	External Mass Transfer Through Boundary Layer	282
4.7.2	External Heat Transfer	283
4.7.3	Internal Mass Transfer	284
4.7.4	Internal Heat Transfer	284
<b>4.8</b>	<b>Kinetics of Homogeneously or Enzyme Catalyzed Reactions</b>	<b>287</b>
4.8.1	Homogeneous and Enzyme Catalysis in a Single-Phase System	287
4.8.2	Homogeneous Two-Phase Catalysis	290
<b>4.9</b>	<b>Kinetics of Gas–Liquid Reactions on Solid Catalysts</b>	<b>291</b>
4.9.1	Introduction	291
4.9.2	High Concentration of Liquid Reactant B (or pure B) and Slightly Soluble Gas	295
4.9.3	Low Concentration of Liquid Reactant B and Highly Soluble Gas and/or High Pressure	295
<b>4.10</b>	<b>Chemical Reactors</b>	<b>296</b>
4.10.1	Overview of Reactor Types and their Characteristics	296
4.10.1.1	<i>Brief Outline of Ideal and Real Reactors</i>	296
4.10.1.2	<i>Classification of Real Reactors Based on the Mode of Operation</i>	298
4.10.1.3	<i>Classification of Real Reactors According to the Phases</i>	299
4.10.2	Ideal Isothermal Reactors	305
4.10.2.1	<i>Well-Mixed (Discontinuous) Isothermal Batch Reactor</i>	306
4.10.2.2	<i>Continuously Operated Isothermal Ideal Tank Reactor</i>	307
4.10.2.3	<i>Continuously Operated Isothermal Ideal Tubular Reactor</i>	308
4.10.2.4	<i>Continuously Operated Isothermal Tubular Reactor with Laminar Flow</i>	309
4.10.2.5	<i>Continuously Operated Isothermal Cascade of Tank Reactors</i>	311
4.10.2.6	<i>Ideal Isothermal Tubular Recycle Reactor</i>	311
4.10.2.7	<i>Comparison of the Performance of Ideal Isothermal Reactors</i>	313
4.10.3	Non-isothermal Ideal Reactors and Criteria for Prevention of Thermal Runaway	316
4.10.3.1	<i>Well-Mixed (Discontinuously Operated) Non-isothermal Batch Reactor</i>	317
4.10.3.2	<i>Continuously Operated Non-isothermal Ideal Tank Reactor (CSTR)</i>	322
4.10.3.3	<i>Continuously Operated Non-isothermal Ideal Tubular Reactor</i>	328

4.10.3.4	<i>Optimum Operating Lines of Continuous Ideal Non-isothermal Reactors</i>	332
4.10.4	<i>Non-ideal Flow and Residence Time Distribution</i>	336
4.10.5	<i>Tanks-in-Series Model</i>	340
4.10.5.1	<i>Residence Time Distribution of a Cascade of Ideal Stirred Tank Reactors</i>	340
4.10.5.2	<i>Calculation of Conversion by the Tanks-in-Series Model</i>	342
4.10.6	<i>Dispersion Model</i>	343
4.10.6.1	<i>Axial Dispersion and Residence Time Distribution</i>	343
4.10.6.2	<i>Calculation of Conversion by the Dispersion Model</i>	348
4.10.6.3	<i>Dispersion and Conversion in Empty Pipes</i>	349
4.10.6.4	<i>Dispersion of Mass and Heat in Fixed Bed Reactors</i>	352
4.10.6.5	<i>Radial Variations in Bed Structure: Wall Effects in Narrow Packed Beds</i>	354
4.10.7	<i>Modeling of Fixed Bed Reactors</i>	355
4.10.7.1	<i>Fundamental Balance Equations of Fixed Bed Reactors</i>	355
4.10.7.2	<i>Criteria used to Exclude a Significant Influence of Dispersion in Fixed Bed Reactors</i>	357
4.10.7.3	<i>Radial Heat Transfer in Packed Bed Reactors and Methods to Account for This</i>	363
4.10.8	<i>Novel Developments in Reactor Technology</i>	370
4.10.8.1	<i>Hybrid (Multifunctional) Reactors</i>	370
4.10.8.2	<i>Monolithic Reactors</i>	372
4.10.8.3	<i>Microreactors</i>	373
4.10.8.4	<i>Adiabatic Reactors with Periodic Flow Reversal</i>	376
4.11	<b>Measurement and Evaluation of Kinetic Data</b>	379
4.11.1	<i>Principal Methods for Determining Kinetic Data</i>	380
4.11.1.1	<i>Microkinetics</i>	380
4.11.1.2	<i>Macrokinetics</i>	380
4.11.1.3	<i>Laboratory Reactors</i>	380
4.11.1.4	<i>Pros and Cons of Integral and Differential Method</i>	382
4.11.2	<i>Evaluation of Kinetic Data (Reaction Orders, Rate Constants)</i>	382
4.11.3	<i>Laboratory-Scale Reactors for Kinetic Measurements</i>	385
4.11.4	<i>Transport Limitations in Experimental Catalytic Reactors</i>	388
4.11.4.1	<i>Ideal Plug Flow Behavior: Criteria to Exclude the Influence of Dispersion</i>	389
4.11.4.2	<i>Gradientless Ideal Particle Behavior: Criteria to Exclude the Influence of Interfacial and Internal Transport of Mass and Heat</i>	390
4.11.4.3	<i>Criterion to Exclude the Influence of the Dilution of a Catalytic Fixed Bed</i>	392
4.11.5	<i>Case Studies for the Evaluation of Kinetic Data</i>	392
4.11.5.1	<i>Case Study I: Thermal Conversion of Naphthalene</i>	392
4.11.5.2	<i>Case Study II: Heterogeneously Catalyzed Hydrogenation of Hexene</i>	394
4.11.5.3	<i>Case Study III: Heterogeneously Catalyzed Multiphase Reaction</i>	395
4.11.5.4	<i>Case Study IV: Non-isothermal Oxidation of Carbon Nanotubes and Fibers</i>	400
<b>5</b>	<b>Raw Materials, Products, Environmental Aspects, and Costs of Chemical Technology</b>	<b>407</b>
5.1	<b>Raw Materials and Energy Sources</b>	<b>408</b>
5.1.1	<i>Energy Consumption, Reserves and Resources of Fossil Fuels and Renewables</i>	<b>408</b>
5.1.1.1	<i>Global and Regional Energy Consumption and Fuel Shares</i>	<b>408</b>
5.1.1.2	<i>World Energy Consumption and World Population</i>	<b>410</b>

5.1.1.3	<i>Economic and Social Aspects of Energy Consumption</i>	410
5.1.1.4	<i>Conventional and Non-conventional Fossil Fuels</i>	418
5.1.1.5	<i>Nuclear Power</i>	420
5.1.1.6	<i>Renewable Energy</i>	421
5.1.1.7	<i>Energy Mix of the Future</i>	422
5.1.1.8	<i>Global Warming</i>	425
5.1.1.9	<i>Ecological Footprint and Energy Consumption</i>	425
5.1.1.10	<i>Energy Demand and Energy Mix to Reconcile the World's Pursuit of Welfare and Happiness with the Necessity to Preserve the Integrity of the Biosphere</i>	428
5.1.2	<i>Composition of Fossil Fuels and Routes for the Production of Synthetic Fuels</i>	431
5.1.3	<i>Natural Gas and Other Technical Gases</i>	433
5.1.3.1	<i>Properties of Natural Gas and Other Technical Gases</i>	433
5.1.3.2	<i>Conditioning of Natural Gas, Processes and Products Based on Natural Gas</i>	435
5.1.4	<i>Crude Oil and Refinery Products</i>	437
5.1.4.1	<i>Production, Reserves, and Price of Crude Oil</i>	437
5.1.4.2	<i>Properties of Crude Oil</i>	440
5.1.4.3	<i>Properties of Major Refinery Products</i>	442
5.1.4.4	<i>Refinery Processes</i>	443
5.1.5	<i>Coal and Coal Products</i>	445
5.1.5.1	<i>Properties of Coal and Other Solid Fuels</i>	445
5.1.5.2	<i>Processes and Products Based on Coal</i>	447
5.1.6	<i>Renewable Raw Materials</i>	450
5.1.6.1	<i>Base Chemicals from Renewable Raw Materials</i>	450
5.1.6.2	<i>Fats and Vegetable Oils</i>	451
5.1.6.3	<i>Carbohydrates</i>	453
5.1.6.4	<i>Extracts and Excreta from Plants</i>	455
5.2	<b>Inorganic Products</b>	457
5.3	<b>Organic Intermediates and Final Products</b>	459
5.3.1	<i>Alkanes and Syngas</i>	460
5.3.2	<i>Alkenes, Alkynes, and Aromatic Hydrocarbons</i>	464
5.3.3	<i>Organic Intermediates Functionalized with Oxygen, Nitrogen, or Halogens</i>	472
5.3.3.1	<i>Alcohols</i>	472
5.3.3.2	<i>Ethers</i>	477
5.3.3.3	<i>Epoxides</i>	478
5.3.3.4	<i>Aldehydes</i>	478
5.3.3.5	<i>Ketones</i>	481
5.3.3.6	<i>Acids</i>	481
5.3.3.7	<i>Amines and Nitrogen-Containing Intermediates</i>	484
5.3.3.8	<i>Lactams, Nitriles, and Isocyanates</i>	486
5.3.3.9	<i>Halogenated Organic Intermediates</i>	488
5.3.4	<i>Polymers</i>	491
5.3.4.1	<i>Polyolefins and Polydienes</i>	492
5.3.4.2	<i>Vinyl-Polymers and Polyacrylates</i>	493
5.3.4.3	<i>Polyesters, Polyamides, and Polyurethanes</i>	497
5.3.5	<i>Detergents and Surfactants</i>	500
5.3.5.1	<i>Structure and Properties of Detergent and Surfactants</i>	500
5.3.5.2	<i>Cationic Detergents</i>	501
5.3.5.3	<i>Anionic Detergents</i>	502
5.3.5.4	<i>Non-ionic Detergents</i>	504
5.3.6	<i>Fine Chemicals</i>	505

5.3.6.1	<i>Dyes and Colorants</i>	506
5.3.6.2	<i>Adhesives</i>	506
5.3.6.3	<i>Fragrance and Flavor Chemicals</i>	506
5.3.6.4	<i>Pesticides</i>	506
5.3.6.5	<i>Vitamins, Food, and Animal Feed Additives</i>	508
5.3.6.6	<i>Pharmaceuticals</i>	508
<b>5.4</b>	<b>Environmental Aspects of Chemical Technology</b>	<b>509</b>
5.4.1	<i>Air Pollution</i>	510
5.4.2	<i>Water Consumption and Pollution</i>	512
5.4.3	<i>“Green Chemistry” and Quantifying the Environmental Impact of Chemical Processes</i>	515
<b>5.5</b>	<b>Production Costs of Fuels and Chemicals Manufacturing</b>	<b>517</b>
5.5.1	<i>Price of Chemical Products</i>	517
5.5.2	<i>Investment Costs</i>	518
5.5.3	<i>Variable Costs</i>	521
5.5.4	<i>Operating Costs (Fixed and Variable Costs)</i>	522
<b>6</b>	<b>Examples of Industrial Processes</b>	<b>525</b>
<b>6.1</b>	<b>Ammonia Synthesis</b>	<b>525</b>
6.1.1	<i>Historical Development of Haber–Bosch Process</i>	525
6.1.2	<i>Thermodynamics of Ammonia Synthesis</i>	528
6.1.3	<i>Kinetics and Mechanism of Ammonia Synthesis</i>	529
6.1.4	<i>Technical Ammonia Process and Synthesis Reactors</i>	531
<b>6.2</b>	<b>Syngas and Hydrogen</b>	<b>536</b>
6.2.1	<i>Options to Produce Syngas and Hydrogen (Overview)</i>	536
6.2.2	<i>Syngas from Solid Fuels (Coal, Biomass)</i>	542
6.2.2.1	<i>Basic Principles and Reactions of Syngas Production from Solid Fuels</i>	542
6.2.2.2	<i>Syngas Production by Gasification of Solid Fuels</i>	543
6.2.2.3	<i>Case Study: Syngas and Hydrogen by Gasification of Biomass</i>	544
6.2.3	<i>Syngas by Partial Oxidation of Heavy Oils</i>	552
6.2.4	<i>Syngas by Steam Reforming of Natural Gas</i>	555
<b>6.3</b>	<b>Sulfuric Acid</b>	<b>558</b>
6.3.1	<i>Reactions and Thermodynamics of Sulfuric Acid Production</i>	558
6.3.2	<i>Production of SO<sub>2</sub></i>	559
6.3.3	<i>SO<sub>2</sub> Conversion into SO<sub>3</sub></i>	560
6.3.4	<i>Sulfuric Acid Process</i>	566
<b>6.4</b>	<b>Nitric Acid</b>	<b>568</b>
6.4.1	<i>Reactions and Thermodynamics of Nitric Acid Production</i>	568
6.4.2	<i>Kinetics of Catalytic Oxidation of Ammonia</i>	572
6.4.2.1	<i>Catalytic Oxidation of Ammonia on a Single Pt Wire for Cross-Flow of the Gas</i>	573
6.4.2.2	<i>Catalytic Oxidation of Ammonia in an Industrial Reactor, that is, on a Series of Pt Gauzes</i>	579
6.4.3	<i>NO Oxidation</i>	583
6.4.4	<i>Nitric Acid Processes</i>	584
<b>6.5</b>	<b>Coke and Steel</b>	<b>587</b>
6.5.1	<i>Steel Production (Overview)</i>	587
6.5.1.1	<i>Steel Production Based on the Blast Furnace Route</i>	588
6.5.1.2	<i>Steel Production based on Scrap and Direct Reduced Iron (DRI)</i>	589
6.5.2	<i>Production of Blast Furnace Coke</i>	589
6.5.2.1	<i>Inspection of Transient Process of Coking of Coal</i>	591
6.5.2.2	<i>Case I: Negligible Thermal Resistance of Coal/Coke Charge</i>	591
6.5.2.3	<i>Case II: Negligible Thermal Resistance of Heated Brick Wall</i>	592

6.5.2.4	<i>Case III: Thermal Resistances of Brick Wall and Coal Charge have to be Considered</i>	594
6.5.3	Production of Pig Iron in a Blast Furnace	595
6.5.3.1	<i>Coke Consumption of a Blast Furnace: Historical Development and Theoretical Minimum</i>	599
6.5.3.2	<i>Residence Time Distribution of a Blast Furnace</i>	601
<b>6.6</b>	<b>Basic Chemicals by Steam Cracking</b>	<b>604</b>
6.6.1	General and Mechanistic Aspects	605
6.6.2	Factors that Influence the Product Distribution	608
6.6.2.1	<i>Influence of Applied Feedstock</i>	608
6.6.2.2	<i>Influence of the Temperature in the Cracking Oven</i>	608
6.6.2.3	<i>Influence of Residence Time</i>	608
6.6.2.4	<i>Influence of Hydrocarbon Partial Pressure in the Cracking Oven</i>	609
6.6.3	Industrial Steam Cracker Process	610
6.6.4	Economic Aspects of the Steam Cracker Process	615
<b>6.7</b>	<b>Liquid Fuels by Cracking of Heavy Oils</b>	<b>616</b>
6.7.1	Thermal Cracking (Delayed Coking)	616
6.7.2	Fluid Catalytic Cracking (FCC Process)	620
<b>6.8</b>	<b>Clean Liquid Fuels by Hydrotreating</b>	<b>624</b>
6.8.1	History, Current Status, and Perspective of Hydrotreating	624
6.8.2	Thermodynamics and Kinetics of Hydrodesulfurization (HDS)	625
6.8.3	Hydrodesulfurization Process and Reaction Engineering Aspects	629
<b>6.9</b>	<b>High Octane Gasoline by Catalytic Reforming</b>	<b>633</b>
6.9.1	Reactions and Thermodynamics of Catalytic Reforming	633
6.9.2	Reforming Catalyst	636
6.9.3	Process of Catalytic Reforming	637
6.9.4	Deactivation and Regeneration of a Reforming Catalyst	638
6.9.4.1	<i>Coke Burn-Off within a Single Catalyst Particle</i>	639
6.9.4.2	<i>Regeneration in a Technical Fixed Bed Reactor</i>	645
<b>6.10</b>	<b>Refinery Alkylation</b>	<b>652</b>
6.10.1	Reaction and Reaction Mechanism of Refinery Alkylation	652
6.10.2	Alkylation Feedstock and Products	654
6.10.3	Process Variables	655
6.10.3.1	<i>Reaction Temperature</i>	655
6.10.3.2	<i>Acid Strength and Composition</i>	656
6.10.3.3	<i>Isobutane Concentration</i>	656
6.10.3.4	<i>Effect of Mixing</i>	656
6.10.4	Commercial Alkylation Processes	657
6.10.4.1	<i>Commercial Processes using Hydrofluoric Acid as Liquid Catalyst</i>	657
6.10.4.2	<i>Commercial Processes Using Sulfuric Acid as Liquid Catalyst</i>	658
6.10.4.3	<i>Comparison of Commercially Applied Alkylation Processes</i>	661
<b>6.11</b>	<b>Fuels and Chemicals from Syngas: Methanol and Fischer–Tropsch Synthesis</b>	<b>662</b>
6.11.1	Fischer–Tropsch Synthesis	664
6.11.1.1	<i>Reactions and Mechanisms of Fischer–Tropsch Synthesis</i>	664
6.11.1.2	<i>Intrinsic and Effective Reaction Rate of Fischer–Tropsch Synthesis</i>	668
6.11.1.3	<i>History, Current Status, and Perspectives of Fischer–Tropsch Synthesis</i>	670
6.11.1.4	<i>Fischer–Tropsch Processes and Reactors</i>	674
6.11.1.5	<i>Modeling of a Multi-tubular Fixed Bed Fischer–Tropsch Reactor</i>	677
6.11.2	Methanol Synthesis	685
6.11.2.1	<i>Thermodynamics of Methanol Synthesis</i>	686
6.11.2.2	<i>Catalysts for Methanol Synthesis</i>	689
6.11.2.3	<i>Processes and Synthesis Reactors</i>	692

- 6.12 Ethylene and Propylene Oxide 695**
  - 6.12.1 Commercial Production of Ethylene Oxide 695
    - 6.12.1.1 Chlorohydrin Process 696
    - 6.12.1.2 Direct Oxidation of Ethylene 696
    - 6.12.1.3 Products Made of Ethylene Oxide 699
  - 6.12.2 Commercial Production of Propylene Oxide 700
    - 6.12.2.1 Chlorohydrin Process 700
    - 6.12.2.2 Indirect Oxidation of Propylene 702
    - 6.12.2.3 Products Made of Propylene Oxide 705
- 6.13 Catalytic Oxidation of *o*-Xylene to Phthalic Acid Anhydride 706**
  - 6.13.1 Production and Use of Phthalic Anhydride (Overview) 707
  - 6.13.2 Design and Simulation of a Multi-tubular Reactor for Oxidation of *o*-Xylene to PA 708
- 6.14 Hydroformylation (Oxosynthesis) 716**
  - 6.14.1 Industrial Relevance of Hydroformylation 717
  - 6.14.2 Hydroformylation Catalysis 718
  - 6.14.3 Current Hydroformylation Catalyst and Process Technologies 722
  - 6.14.4 Advanced Catalyst Immobilization Technologies for Hydroformylation Catalysis 730
    - 6.14.4.1 Immobilization of Homogeneous Hydroformylation Catalysts on Solid Surfaces by Covalent Anchoring 731
    - 6.14.4.2 Catalyst Separation by Size Exclusion Membranes 732
    - 6.14.4.3 Catalyst Immobilization in Liquid–Liquid Biphase Reaction Systems using Fluorous Phases, Supercritical CO<sub>2</sub> or Ionic Liquids 733
    - 6.14.4.4 Supported Liquid Hydroformylation Catalysis 736
- 6.15 Acetic Acid 739**
  - 6.15.1 Acetic Acid Synthesis via Acetaldehyde Oxidation 741
  - 6.15.2 Acetic Acid Synthesis via Butane or Naphtha Oxidation 742
  - 6.15.3 Acetic Acid Synthesis via Methanol Carbonylation 743
    - 6.15.3.1 BASF High-Pressure Process 743
    - 6.15.3.2 Monsanto Low-Pressure Process 744
    - 6.15.3.3 Cativa Process 747
  - 6.15.4 Other Technologies for the Commercial Production of Acetic Acid 747
    - 6.15.4.1 Direct Ethylene Oxidation 747
    - 6.15.4.2 Acetic Acid Production by Ethane and Methane Oxidation 748
- 6.16 Ethylene Oligomerization Processes for Linear 1-Alkene Production 749**
  - 6.16.1 Industrial Relevance of 1-Olefins 749
  - 6.16.2 Aluminum-alkyl-based “*Aufbaureaktion*” (Growth Reaction) 750
  - 6.16.3 Nickel-Catalyzed Oligomerization – Shell Higher Olefins Process (SHOP) 753
  - 6.16.4 Metallocycle Mechanism for Selective Ethylene Oligomerization 757
- 6.17 Production of Fine Chemicals (Example Menthol) 763**
  - 6.17.1 Menthol and Menthol Production (Overview) 763
  - 6.17.2 Thermodynamics and Kinetics of Epimerization of Menthol Isomers 764
  - 6.17.3 Influence of Mass Transfer on the Epimerization of Menthol Isomers 766
  - 6.17.4 Epimerization of Menthol Isomers in Technical Reactors 771
- 6.18 Treatment of Exhaust Gases from Mobile and Stationary Sources 773**
  - 6.18.1 Automotive Emission Control 773
    - 6.18.1.1 Emission Standards and Primary Measures for Reduction of Engine Emissions 773
    - 6.18.1.2 Catalytic Converters for Reduction of Car Engine Emissions 775

6.18.2	Selective Catalytic Reduction (SCR) of NO <sub>x</sub> from Flue Gas from Power Plants	778
6.18.2.1	<i>Treatment of Flue Gas from Power Plants (Overview)</i>	778
6.18.2.2	<i>Formation of Nitrogen Oxides during Fuel Combustion in Power Plants</i>	779
6.18.2.3	<i>Catalysts and Reactors for Selective Catalytic Reduction of NO<sub>x</sub></i>	780
6.18.2.4	<i>Reaction Chemistry of Selective Catalytic Reduction of NO<sub>x</sub></i>	781
6.18.2.5	<i>Reaction Kinetics and Design of SCR Reactor</i>	781
<b>6.19</b>	<b>Industrial Electrolysis</b>	<b>786</b>
6.19.1	Electrochemical Kinetics and Thermodynamics	786
6.19.1.1	<i>Faraday's Law and Current Efficiency</i>	786
6.19.1.2	<i>Electrochemical Potentials</i>	787
6.19.1.3	<i>Galvanic and Electrolysis Cells, Nernst's Law</i>	788
6.19.1.4	<i>Standard Electrode Potentials</i>	789
6.19.1.5	<i>Electrical Work and Thermoneutral Enthalpy Voltage</i>	789
6.19.1.6	<i>Overpotentials</i>	791
6.19.2	Chlorine and Sodium Hydroxide	791
6.19.2.1	<i>Applications of Chlorine and Sodium Hydroxide</i>	791
6.19.2.2	<i>Processes of Chlor-Alkali Electrolysis</i>	792
6.19.2.3	<i>Diaphragm Process</i>	793
6.19.2.4	<i>Mercury Cell Process</i>	795
6.19.2.5	<i>Membrane Process</i>	796
6.19.3	Electrolysis of Water	797
6.19.4	Electrometallurgy (Purification of Metals by Electrorefining)	800
6.19.4.1	<i>Electrolytic Refining in Aqueous Solution</i>	800
6.19.4.2	<i>Fused Salt Electrolysis (Production of Aluminum)</i>	801
<b>6.20</b>	<b>Polyethene Production</b>	<b>803</b>
6.20.1	Polyethene Classification and Industrial Use	803
6.20.2	General Characteristics of PE Production Processes	805
6.20.2.1	<i>Exothermicity of the Reaction and Thermal Stability of Ethene</i>	805
6.20.2.2	<i>Purity of Ethene</i>	805
6.20.3	Reaction Mechanism and Process Equipment for the Production of LDPE	806
6.20.4	Catalysts for the Production of HDPE and LLDPE	809
6.20.4.1	<i>Ziegler Catalyst Systems</i>	809
6.20.4.2	<i>Phillips Catalyst Systems</i>	810
6.20.4.3	<i>Single-Site Metallocene Catalyst Systems</i>	811
6.20.5	Production Processes for HDPE and LLDPE	812
6.20.6	PE Production Economics and Modern Developments in PE Production	815
	<b>References</b>	<b>817</b>
	<b>Index</b>	<b>833</b>