

Contents

Preface — v

About the author — vii

1 Chemical technology as science — 1

- 1.1 Basic principles — 1
 - 1.1.1 Continuous or batch? — 2
 - 1.1.2 Multilevel chemical processing — 4
 - 1.1.3 Large or small chemical plants? — 7
- 1.2 Alternative production routes — 9
- 1.3 Evaluation of chemical processes — 11
- 1.4 Chemical process design — 12
 - 1.4.1 Economic aspects — 12
 - 1.4.2 Flow schemes — 16
 - 1.4.3 Sustainable and safe chemical technology: process intensification — 21
 - 1.4.4 Waste management — 35
 - 1.4.5 Conceptual process design — 37
 - 1.4.6 Product design — 45
 - 1.4.7 Patents — 47

2 Physico-chemical foundations of chemical processes — 49

- 2.1 Stoichiometry — 49
- 2.2 Thermodynamics — 51
- 2.3 Catalysis — 55
- 2.4 Kinetics — 57
- 2.5 Mass transfer — 60

3 Chemical processes and unit operations — 67

- 3.1 Overview of unit operations — 67
- 3.2 Mechanical processes — 68
 - 3.2.1 Filtration — 68
 - 3.2.2 Cyclonic separation by gravitation — 70
- 3.3 Mass transfer processes — 71
 - 3.3.1 Distillation — 71
 - 3.3.2 Extraction — 76
 - 3.3.3 Crystallization — 78
 - 3.3.4 Adsorption — 81
 - 3.3.5 Absorption — 83
- 3.4 Chemical reactors — 87
 - 3.4.1 Homogeneous processes — 87

3.4.2	Non-catalytic heterogeneous processes — 88
3.4.3	Catalytic reactors — 91
3.4.3.1	Two-phase catalytic reactors — 92
3.4.3.2	Three-phase catalytic reactors — 96
4	Chemical process industry — 103
4.1	General overview — 103
4.2	Feedstock for chemical process industries — 108
4.3	Oil refining — 116
4.4	Natural gas processing — 122
4.5	Processing of coal — 124
4.6	Biomass processing — 127
5	Hydrogen and syngas generation — 137
5.1	Steam reforming of natural gas — 137
5.2	Gasification — 148
5.3	Water-gas shift reaction — 153
6	Cracking — 157
6.1	General — 157
6.2	Visbreaking — 157
6.3	Hydrocracking — 160
6.4	Fluid catalytic cracking — 170
6.5	Steam cracking — 182
7	Catalytic reforming of gasoline fractions: combining isomerization and dehydrogenation — 191
8	Halogenation — 197
8.1	Radical chlorination — 197
8.1.1	Liquid-phase chlorination — 198
8.1.2	Gas-phase chlorination — 200
8.2	Catalytic chlorination — 203
8.3	Hydrohalogenation — 204
8.4	Oxychlorination — 205
8.5	Fluorination — 208
9	Oxidation — 209
9.1	Oxidation of inorganic compounds — 209
9.1.1	Nitric acid — 209
9.1.2	Sulfuric acid — 212
9.2	Oxidation of organic compounds — 217
9.2.1	Heterogeneous catalytic oxidation — 217

9.2.1.1	Ethylene and propylene oxide — 219
9.2.1.2	Acrylic acid — 222
9.2.1.3	Formaldehyde — 224
9.2.1.4	Maleic anhydride — 227
9.2.1.5	Phthalic anhydride — 230
9.2.1.6	Acrylonitrile — 237
9.2.2	Liquid-phase oxidation — 239
9.2.2.1	Cyclohexane oxidation — 241
9.2.2.2	Cyclohexanol oxidation — 242
9.2.2.3	Xylene oxidation to terephthalic acid — 244
9.2.2.4	Wacker process: oxidation of ethylene to acetaldehyde — 246
9.2.2.5	Synthesis of phenol and acetone by isopropylbenzene oxidation — 249
10	Hydrogenation and dehydrogenation — 253
10.1	General — 253
10.2	Ammonia synthesis — 256
10.3	Gas-phase hydrogenation — 264
10.4	Liquid-phase hydrogenation — 265
10.5	Hydrotreating — 268
10.6	Dehydrogenation — 270
10.6.1	Dehydrogenation of light alkanes — 270
10.6.2	Dehydrogenation of ethylbenzene to styrene — 276
11	Reactions involving water: hydration, dehydration, etherification, hydrolysis, and esterification — 281
11.1	Hydration and dehydration — 281
11.2	Hydrolysis — 284
11.2.1	Acid-catalyzed hydrolysis of wood — 285
11.2.2	Enzymatic hydrolysis of acyl-L-amino acids — 287
11.2.3	Hydrolysis of fatty acids triglycerides — 288
11.3	Esterification — 289
12	Alkylation — 293
12.1	Alkylation of aromatics — 293
12.2	Alkylation of olefins — 300
12.3	O-Alkylation — 306
12.4	N-Alkylation — 311
12.5	Oxyalkylation — 312
13	Reactions with CO, CO₂, and synthesis gas — 317
13.1	Carbonylation — 317
13.2	Carboxylation — 321
13.2.1	Kolbe-Schmidt synthesis — 321

- 13.2.2 Urea from CO_2 and ammonia — 323
- 13.2.3 Synthesis of melamine — 332
- 13.3 Methanol from synthesis gas — 336
- 13.4 Hydrocarbons from synthesis gas: Fischer-Tropsch synthesis — 344
- 13.5 Reactions of olefins with synthesis gas: hydroformylation — 357

14 Key reactions in the synthesis of intermediates: nitration, sulfation, sulfonation, alkali fusion, ketone, and aldehyde condensation — 371

- 14.1 Nitration — 371
- 14.2 Sulfation and sulfonation — 375
 - 14.2.1 Sulfation — 375
 - 14.2.2 Sulfonation — 378
- 14.3 Alkali fusion — 383
- 14.4 Carbonyl condensation reactions — 384
 - 14.4.1 Condensation with aromatic compounds — 386
 - 14.4.2 Aldol condensation — 388
- 14.5 Caprolactam production — 389
 - 14.5.1 Condensation of cyclohexanone to cyclohexanone oxime and subsequent Beckmann rearrangement — 389
 - 14.5.2 Methods for caprolactam production — 395

15 Polymerization — 401

- 15.1 Polymers — 401
- 15.2 Step-growth polymerization — 402
- 15.3 Polymerization process options — 407
 - 15.3.1 Homogeneous polymerization in substance — 407
 - 15.3.2 Homogeneous polymerization in solution — 409
- 15.4 Heterogeneous polymerization — 410
 - 15.4.1 Precipitation polymerization — 410
 - 15.4.2 Suspension and emulsion polymerization — 415

Final words — 419

Index — 421