

WORLDWIDE REFINERY PROCESSING REVIEW – 2Q2008
Hydrotreating and Visbreaking

Table of Contents

1. Introduction.....	1
2. Hydrotreating.....	5
2.1 MARKET/TECHNOLOGY TRENDS & OPPORTUNITIES	5
2.1.1 Introduction	5
2.1.2 Market Conditions and Outlook.....	5
2.1.2.1 Capacity Expansion and Unit Revamps.....	6
2.1.2.2 Hydrotreating Catalysts Market.....	6
2.1.3 Technology Competition, Directions, and Future Prospects.....	8
2.1.3.1 Catalysts.....	9
2.1.3.2 Process Design and Hardware	10
2.1.3.3 Trends in R&D	12
2.2 STATE-OF-THE-ART TECHNOLOGY	12
2.2.1 Introduction	12
2.2.2 Commercial and Emerging Catalysts and Guard Materials	13
2.2.2.1 Advanced Refining Technologies.....	14
2.2.2.1.1 SmART.....	15
2.2.2.1.2 ApART	16
2.2.2.2 Albemarle	18
2.2.2.2.1 STARS Series.....	18
2.2.2.2.2 NEBULA Series	22
2.2.2.2.3 Combined Implementation	26
2.2.2.2.4 KF 901, KF 902, KF 905, KF 859.....	28
2.2.2.2.5 KF 200.....	28
2.2.2.2.6 Guard Catalysts	29
2.2.2.3 Axens	29
2.2.2.3.1 HR 400 Series.....	29
2.2.2.3.2 HR 500 Series.....	30
2.2.2.3.3 AX 740 Hydrogenation Catalysts.....	31
2.2.2.3.4 ACT Grading Materials	32
2.2.2.4 BASF	32
2.2.2.5 Catalysts & Chemicals Industries	32
2.2.2.6 Chevron Lummus Global	33
2.2.2.7 Cosmo Oil.....	34
2.2.2.8 Criterion Catalysts & Technologies.....	34
2.2.2.8.1 CENTINEL	34
2.2.2.8.2 CENTINEL GOLD	36
2.2.2.8.3 ASCENT	38
2.2.2.8.4 ENCORE Revitalization Technology.....	41
2.2.2.9 Crystaphase Products.....	41
2.2.2.10 ExxonMobil.....	41
2.2.2.10.1 RT-225.....	42
2.2.2.10.2 OCTGAIN Catalysts	42
2.2.2.11 Haldor Topsøe	43
2.2.2.11.1 Coker Naphtha Hydrotreating	43
2.2.2.11.2 FCC Feed Pretreat	44

WORLDWIDE REFINERY PROCESSING REVIEW – 2Q2008
Hydrotreating and Visbreaking

2.2.2.11.3	ULSD Production	45
2.2.2.11.4	Reduction of Diesel Density and Aromatics	46
2.2.2.11.5	Hydrocracker Pretreating	47
2.2.2.11.6	Graded Bed Products for Pressure Drop Control.....	47
2.2.2.12	Johnson Matthey Catalysts.....	48
2.2.2.13	Nippon Oil	49
2.2.2.14	Orient Catalyst	49
2.2.2.15	Süd-Chemie.....	50
2.2.2.16	TRICAT Inc.	50
2.2.2.16.1	Guardian Catalyst Grading Bed Materials	51
2.2.2.16.2	TRICAT Regeneration Process.....	51
2.2.2.17	UOP.....	52
2.2.3	<i>Summary of Commercially Available Hydrotreating Catalysts</i>	53
2.2.4	<i>Commercial and Emerging Process Technology</i>	56
2.2.4.1	Albemarle.....	56
2.2.4.1.1	UD-HDS	56
2.2.4.1.2	HDAr	58
2.2.4.1.3	PLEX Reactor Internals	59
2.2.4.2	Axens	59
2.2.4.2.1	Prime-G+	60
2.2.4.2.2	Prime-D and TPH	62
2.2.4.2.3	Benzene Saturation	64
2.2.4.2.4	EquiFlow Reactor Internals	65
2.2.4.3	Catalyst & Chemicals Ind.	66
2.2.4.4	Catalytic Distillation Technologies.....	66
2.2.4.4.1	CDHydro®.....	67
2.2.4.4.2	CDHydro/CDHDS®	68
2.2.4.5	CB&I Howe-Baker	70
2.2.4.6	Chevron Lummus Global.....	71
2.2.4.7	DuPont Clean Technologies.....	72
2.2.4.8	ExxonMobil Research & Engineering/KBR	73
2.2.4.8.1	GO-Fining.....	73
2.2.4.8.2	HYDROFINING/Diesel Oil Deep Desulfurization (DODD).....	74
2.2.4.8.3	SCANfining	75
2.2.4.8.4	OCTGAIN	77
2.2.4.9	Fushun Research Institute of Petroleum and Petrochemicals (Sinopec).....	79
2.2.4.9.1	FHI Diesel Hydro-upgrading/Isodewaxing Process	79
2.2.4.9.2	FRS	80
2.2.4.9.3	OTA	80
2.2.4.9.4	OCT-M.....	81
2.2.4.10	Haldor Topsøe.....	81
2.2.4.10.1	Conventional Hydrotreating.....	81
2.2.4.10.2	Coker Naphtha Hydrotreating.....	83
2.2.4.10.3	HDS/HDA.....	85
2.2.4.10.4	Aroshift	86
2.2.4.10.5	Reactor Internals	87
2.2.4.11	Instituto Mexicano del Petróleo	90
2.2.4.12	JGC	90
2.2.4.13	Lummus Technology/Criterion Catalysts & Technologies/Shell Global.....	91
2.2.4.13.1	SynSat	93
2.2.4.13.2	SynShift	94
2.2.4.13.3	CC Deep SynHDS.....	95

WORLDWIDE REFINERY PROCESSING REVIEW – 2Q2008
Hydrotreating and Visbreaking

	2.2.4.13.4 SMDH	95
	2.2.4.13.5 Reactor Internals.....	96
	2.2.4.14 Neste Oil.....	97
	2.2.4.15 Nippon Oil.....	98
	2.2.4.16 RIPP.....	98
	2.2.4.17 SK Corp.....	99
	2.2.4.18 Shaw Group/BASF.....	101
	2.2.4.19 UOP.....	102
	2.2.4.19.1 MQD Unionfining.....	103
	2.2.4.19.2 VGO Unionfining.....	105
	2.2.4.19.3 ISAL.....	106
	2.2.4.19.4 SelectFining.....	107
	2.2.4.19.5 BenSat.....	108
	2.2.4.19.6 Unisar.....	110
	2.2.4.19.7 UltraMix Reactor Internals.....	111
2.2.5	<i>Summary of Hydrotreating Process Technologies.....</i>	<i>112</i>
2.2.6	<i>Commercially-Available Advanced Control and Optimization Systems.....</i>	<i>123</i>
	2.2.6.1 Aspen Technology.....	123
	2.2.6.2 Axens.....	123
	2.2.6.3 KBC Advanced Technologies.....	125
2.3	PLANT OPERATIONS AND PRACTICES.....	126
2.3.1	<i>Catalyst Management.....</i>	<i>126</i>
	2.3.1.1 In-Situ Catalyst Sulfiding vs. Ex-Situ Presulfiding.....	126
	2.3.1.2 Comparison of Various Sulfiding Agents.....	129
	2.3.1.3 Regenerating Type II Catalysts.....	130
	2.3.1.4 Using Regenerated Catalyst.....	131
	2.3.1.5 Catalyst Dense Loading.....	131
	2.3.1.6 Arsenic Contamination of Hydrotreating Catalyst.....	132
	2.3.1.7 Catalyst Deactivation by Carbon Monoxide in Selective HDS Units.....	133
	2.3.1.8 Guidance for Ultra-Low-Sulfur Diesel (ULSD) Catalyst Selection.....	133
2.3.2	<i>General Hydrotreating Operations.....</i>	<i>134</i>
	2.3.2.1 Reactor Pressure Drop Buildup: Causes and Remedies.....	134
	2.3.2.2 Maldistribution in Hydrotreaters.....	137
	2.3.2.3 Controlling Ammonium Chloride Fouling in Reactor Effluent Exchangers and Hydrogen Gas Compressors.....	139
	2.3.2.4 Operational Status of Emergency Depressurizing Valves and Interlocks.....	140
	2.3.2.5 Interruption of Operations (Emergency or Planned) and Recommended Actions.....	140
	2.3.2.6 Feed Drum Blanketing Gas.....	141
	2.3.2.7 Determining Sufficient Reserve Quench in ULSD Hydrotreaters.....	141
	2.3.2.8 Using High-Purity Hydrogen in Hydrotreaters.....	141
	2.3.2.9 Optimizing Hydrogen Partial Pressure and Catalyst Volume.....	142
	2.3.2.10 Optimizing the Hydrogen-to-Oil Ratio.....	143
	2.3.2.11 Limitations of Single Bed or Undersized ULSD Reactors.....	143
2.3.3	<i>Diesel Hydrotreating.....</i>	<i>143</i>
	2.3.3.1 Meeting ULSD Specs.....	143
	2.3.3.1.1 Operations.....	144
	2.3.3.1.2 Logistics.....	145
	2.3.3.1.3 The Role of Catalysts.....	146
	2.3.3.2 Meeting Diesel Cetane Requirements via Aromatics Saturation.....	149
	2.3.3.3 Options for Converting FCC LCO to ULSD.....	149
	2.3.3.4 Color Degradation During Distillate Hydrotreating.....	151

WORLDWIDE REFINERY PROCESSING REVIEW – 2Q2008
Hydrotreating and Visbreaking

2.3.3.5	Revamps for ULSD Production	151
2.3.3.5.1	Case Study 1	152
2.3.3.5.2	Case Study 2	153
2.3.3.5.3	Case Study 3	154
2.3.3.5.4	Case Study 4	155
2.3.4	<i>Naphtha Hydrotreating</i>	155
2.3.4.1	Processing Coker and Visbreaker Naphtha.....	155
2.3.4.2	Hydrotreating FCC Naphtha—Octane Loss and Other Problems.....	157
2.3.5	<i>Gas Oil Hydrotreating</i>	159
2.3.5.1	Modifying a FCC Feed Pretreater to Increase Yield of Diesel	159
2.3.5.2	Impact of Feed Hydrotreatment on FCC Product Aromatics Content	160
2.3.5.3	FCC Feed Pretreatment vs. FCC Gasoline HDS	160
2.3.5.4	Hydrotreating Heavy Coker Gas Oil.....	161
2.4	REFINING R&D ALERT!.....	163
2.4.1	<i>Introduction</i>	163
2.4.2	<i>Naphtha Hydrotreating</i>	166
2.4.2.1	Process	166
2.4.2.1.1	Patents	166
2.4.2.1.2	Research.....	167
2.4.2.2	Catalyst.....	167
2.4.2.2.1	Patents	167
2.4.2.2.2	Research.....	169
2.4.3	<i>Middle Distillate Hydrotreating (Including ULSD Production)</i>	170
2.4.3.1	Process	170
2.4.3.1.1	Patents	170
2.4.3.1.2	Research.....	172
2.4.3.2	Catalyst.....	176
2.4.3.2.1	Patents	176
2.4.3.2.2	Research.....	178
2.4.4	<i>Gas Oil Hydrotreating</i>	181
2.4.4.1	Process	181
2.4.4.1.1	Patents	181
2.4.4.1.2	Research.....	182
2.4.4.2	Catalyst.....	183
2.4.4.2.1	Patents	183
2.4.4.2.2	Research.....	184
2.4.5	<i>General Hydrotreating</i>	187
2.4.5.1	Process	187
2.4.5.1.1	Patents	187
2.4.5.1.2	Research.....	188
2.4.5.2	Catalyst.....	188
2.4.5.2.1	Patents	188
2.4.5.2.2	Research.....	191
2.4.6	<i>Catalyst Deactivation/Coking</i>	194
2.4.6.1	Patents	194
2.4.6.2	Research.....	194
2.4.7	<i>Disposition of Spent Hydrotreating Catalyst</i>	195
2.4.7.1	Patents	195
2.4.7.2	Research.....	196
2.5	WORLDWIDE INSTALLED CAPACITY	197

WORLDWIDE REFINERY PROCESSING REVIEW – 2Q2008
Hydrotreating and Visbreaking

2.6	CONSTRUCTION.....	201
2.6.1	<i>Recent Construction Activity</i>	201
2.6.2	<i>Completed Construction Projects</i>	216
2.7	REFERENCES	250
3.	Visbreaking.....	273
3.1	MARKET/TECHNOLOGY TRENDS & OPPORTUNITIES	273
3.1.1	<i>Introduction</i>	273
3.1.2	<i>Market Conditions and Outlook</i>	273
3.1.2.1	Fuel Oil.....	274
3.1.3	<i>Technology Competition, Directions, and Future Prospects</i>	275
3.1.3.1	Competition	275
3.1.3.2	Directions.....	277
3.1.3.3	Future Prospects	278
3.2	STATE-OF-THE-ART TECHNOLOGY	279
3.2.1	<i>Introduction</i>	279
3.2.2	<i>Commercial Processes</i>	281
3.2.2.1	Axens.....	281
3.2.2.2	CB&I Lummus Technology/Shell Global Solutions	283
3.2.2.2.1	Shell Soaker Visbreaking	284
3.2.2.2.2	Shell Deep Thermal Conversion.....	285
3.2.2.2.3	Shell Thermal Gasoil Process.....	286
3.2.2.3	Foster Wheeler/UOP.....	288
3.2.2.4	KBR (formerly Kellogg Brown & Root).....	291
3.2.2.5	Lurgi Öl Gas Chemie.....	292
3.2.2.6	UOP/PDVSA-Intevep/Foster Wheeler	293
3.2.3	<i>Summary of Commercial Visbreaking Processes</i>	295
3.3	PLANT OPERATIONS AND PRACTICES	297
3.3.1	<i>Results of Visbreaking Various Feeds</i>	297
3.3.2	<i>Soaker Visbreaking vs. Coil-type Visbreaking</i>	298
3.3.3	<i>Vacuum Flashing to Increase Distillate Yields</i>	299
3.3.4	<i>Controlling Fouling and Coking to Optimize Visbreaker Operation</i>	299
3.3.4.1	Monitoring Coke Formation	300
3.3.4.2	Operational and Design Heuristics to Reduce Coking	301
3.3.4.3	Coke-reducing Additives.....	301
3.3.4.4	Miscellaneous Refinery Case Studies.....	303
3.3.4.4.1	Furnace Tube Cracking at Cepsa's Algeciras Refinery in Spain	303
3.3.4.4.2	Coking Problem at an Agip Petroli Refinery.....	304
3.3.5	<i>Effects of FCCU Severity and Other Factors on Visbreaker Fuel Oil Stability</i>	304
3.4	REFINING R&D ALERT!	305
3.4.1	<i>Introduction</i>	305
3.4.2	<i>Processes</i>	307
3.4.2.1	Higher Severity Operations	307
3.4.2.1.1	Patents	307
3.4.2.1.2	Research	307
3.4.2.2	Distillate Yield Increases.....	308
3.4.2.2.1	Patents	308
3.4.2.2.2	Research	309
3.4.2.3	New Processes	310
3.4.2.3.1	Patents	310
3.4.2.3.2	Research	311

WORLDWIDE REFINERY PROCESSING REVIEW – 2Q2008
Hydrotreating and Visbreaking

3.4.2.4	Process Monitors and Controls	312
3.4.2.4.1	Patents	312
3.4.2.4.2	Research.....	312
3.4.3	<i>Crude Production and Upgrading</i>	314
3.4.3.1	Patents	314
3.4.3.2	Research	317
3.4.4	<i>Other</i>	318
3.4.4.1	Patents	318
3.5	WORLDWIDE INSTALLED CAPACITY	319
3.6	CONSTRUCTION	322
3.6.1	<i>Recent Construction Activity</i>	322
3.6.2	<i>Completed Construction Projects</i>	324
3.7	REFERENCES.....	327

4. Latest Refining TEchnology Developments & Licensing 333

4.1	FLUID CATALYTIC CRACKING	333
4.2	DESULFURIZATION (WITHOUT HYDROGEN)	342
4.3	BENZENE REDUCTION AND REMOVAL	343
4.4	ISO-OCTANE.....	345
4.5	CRUDE DISTILLATION	345
4.6	HEAVY OIL, EXTRA-HEAVY OIL, AND BITUMEN UPGRADING.....	348
4.7	COGENERATION AND INTEGRATED GASIFICATION COMBINED CYCLE.....	349
4.8	AROMATICS AND LIGHT OLEFINS PRODUCTION.....	350
4.9	CATALYST AND CARRIER SUPPORT DEVELOPMENTS.....	350
4.10	PROCESS CONTROLS AND SIMULATION	351
4.11	GAS-TO-LIQUID AND COAL-TO-LIQUID	351
4.12	BIOFUELS PRODUCTION	352
4.13	CO ₂ EMISSIONS (CARBON CAPTURE AND SEQUESTRATION).....	355
4.14	WASTE OIL REMOVAL	355
4.15	REFERENCES.....	356