
HYDROCARBON PROCESSING®
IRPC
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Sulfur Removal:
A pathway for Energy Reduction and Decarbonization

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A Pathway For
Energy Reduction and Decarbonization

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Operating West Texas location

- US privately-owned company in business since 2014 based in Houston, Texas, delivering engineered solutions. Two divisions:

- Environmental Services: focused on removing harmful H2S from upstream and midstream natural gas on a turnkey basis. 60 units in operation.

- Technology Licensing : Focused on

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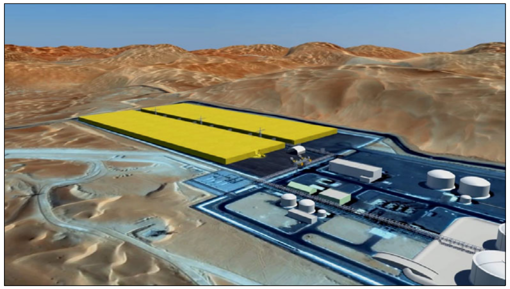
- ❑ Innovative Sulfur Removal Pathways
- ❑ Refining and Petrochemical Technologies
- ❑ Energy Transition: CO_2 utilization and Green H_2

Background

- Sulfur removal traditionally viewed as regulatory compliance implementation.



- Development of new media and catalysts have enabled it to be an energy efficiency and decarbonization tool

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Fuel Gas

- Typically 20-100 ppm S, controlled by amine system.
- Usually set to meet an overall site emission limit.
- Sulfur compounds convert to SO_2 and SO_3. SO_3 condenses with water to form H_2SO_4.
- To avoid condensation, flue stack is kept at elevated temperature.
- Primary S species: H_2S and light mercaptans

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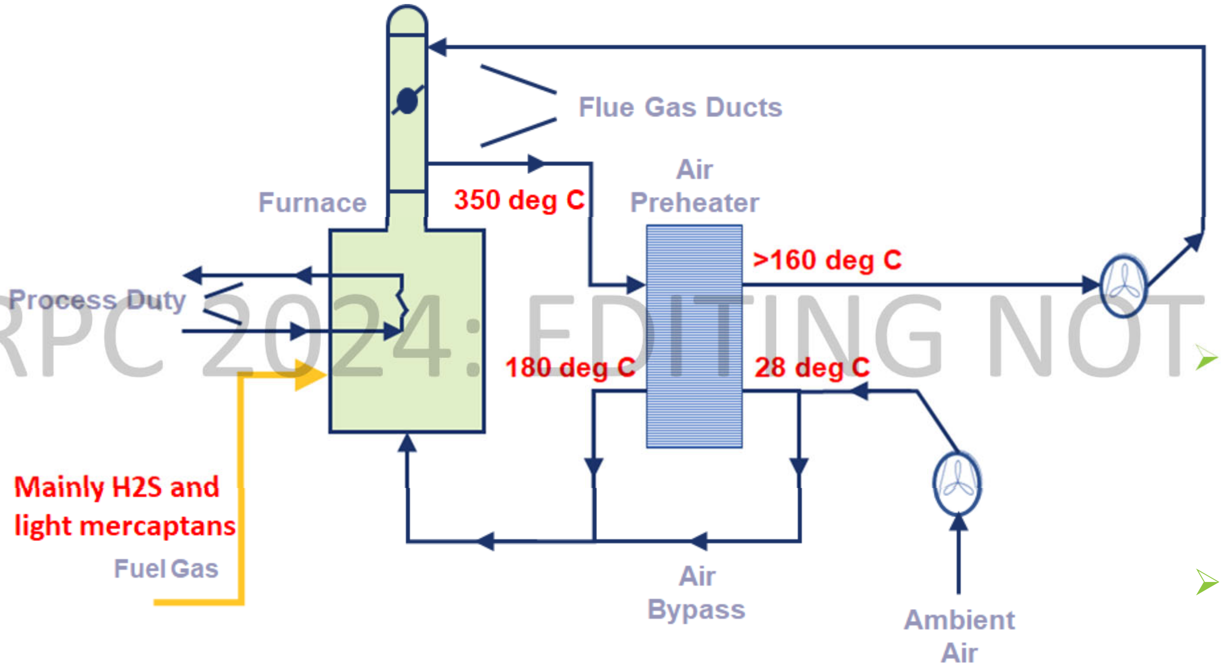
Example of Air Pre-heater Operation



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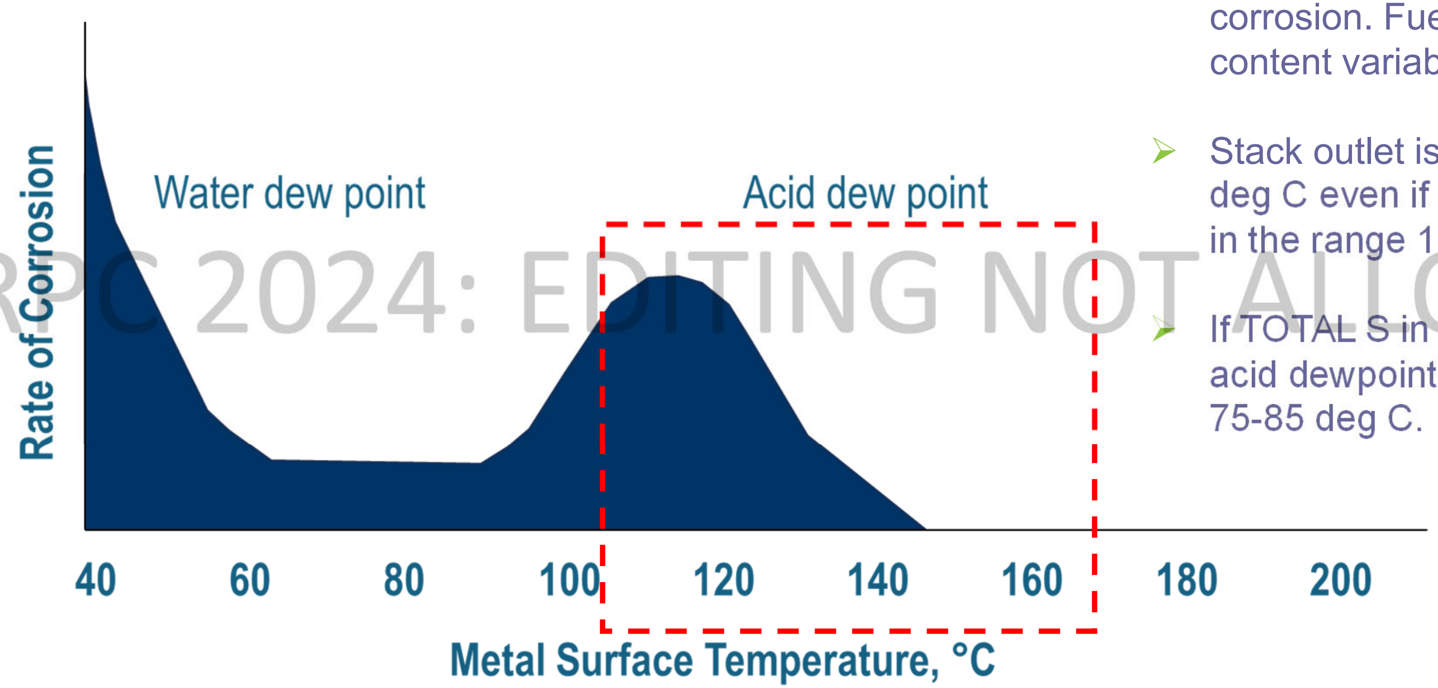
- Robust, but inefficient energy utilization operation due to deliberate high stack outlet temperature.
- 60 deg C window of heat recovery possible across Air Preheater.

Air Pre-heater – Acid Dew Point



- Operator avoids zone of high corrosion. Fuel gas sulfur content variability.
- Stack outlet is maintained >160 deg C even if acid dew point is in the range 100 – 150 deg C.
- If TOTAL S in Fuel gas <1 ppmv, acid dewpoint falls in the range 75-85 deg C.

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SweetTreat-O™

- Proprietary mixed metal oxide- hydroxide based solid adsorbent for H_2S and light mercaptan removal.
- Exceptionally high H_2S removal capacity: *120 wt% loading!*
- Optimal combination of different media achieves <1 ppmv TOTAL S.
- Expected Acid Dewpoint at <1 ppmv TOTAL S in Fuel Gas: 75-85 deg C.

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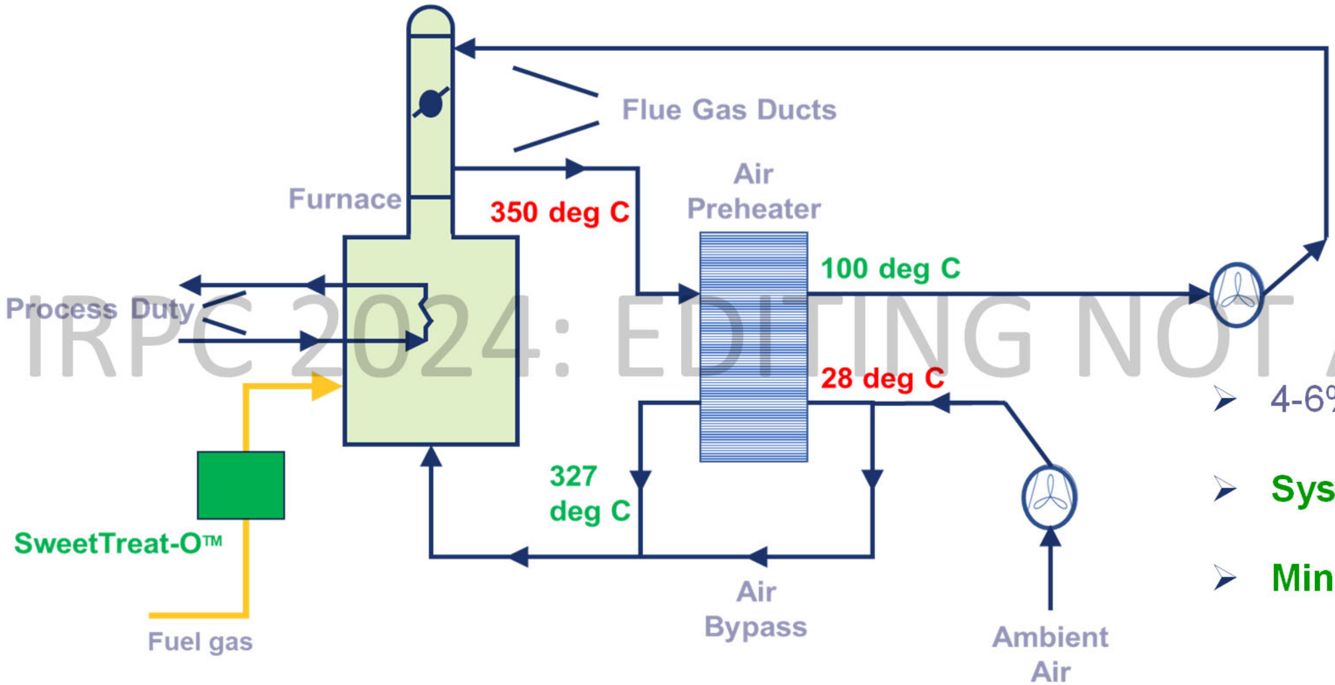
Minimal Pressure Drop (<3 psi)

Air Pre-heater Optimized Operation



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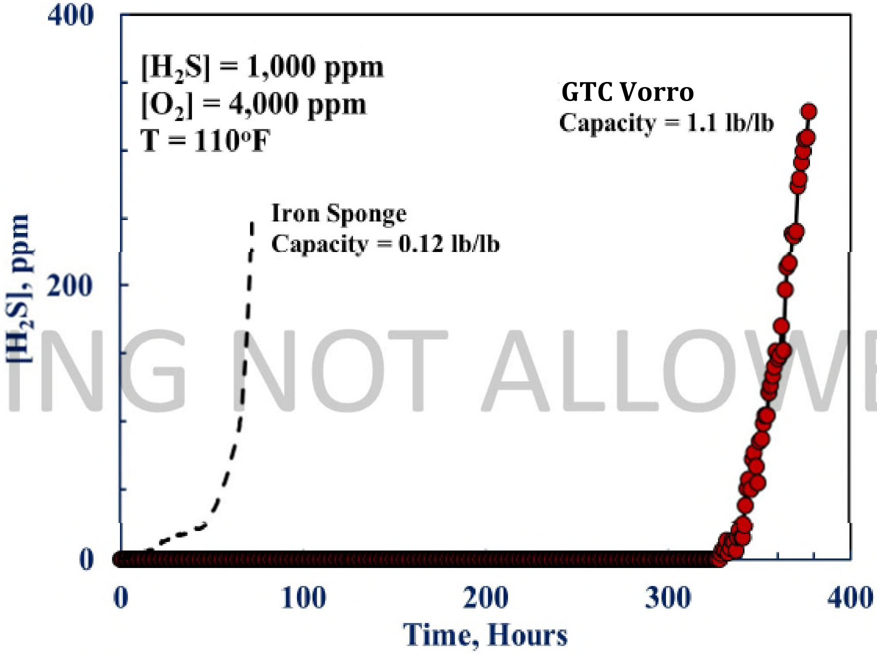
- 4-6% overall energy savings
- **System Payback period < 1 year.**
- **Minimal CO_2 and SO_2 emissions**

Improved Media

Proprietary Mixed metal oxide – hydroxide with high metal content and porous structure.



H_2S Removal – Iron Sponge vs GTC Vorro

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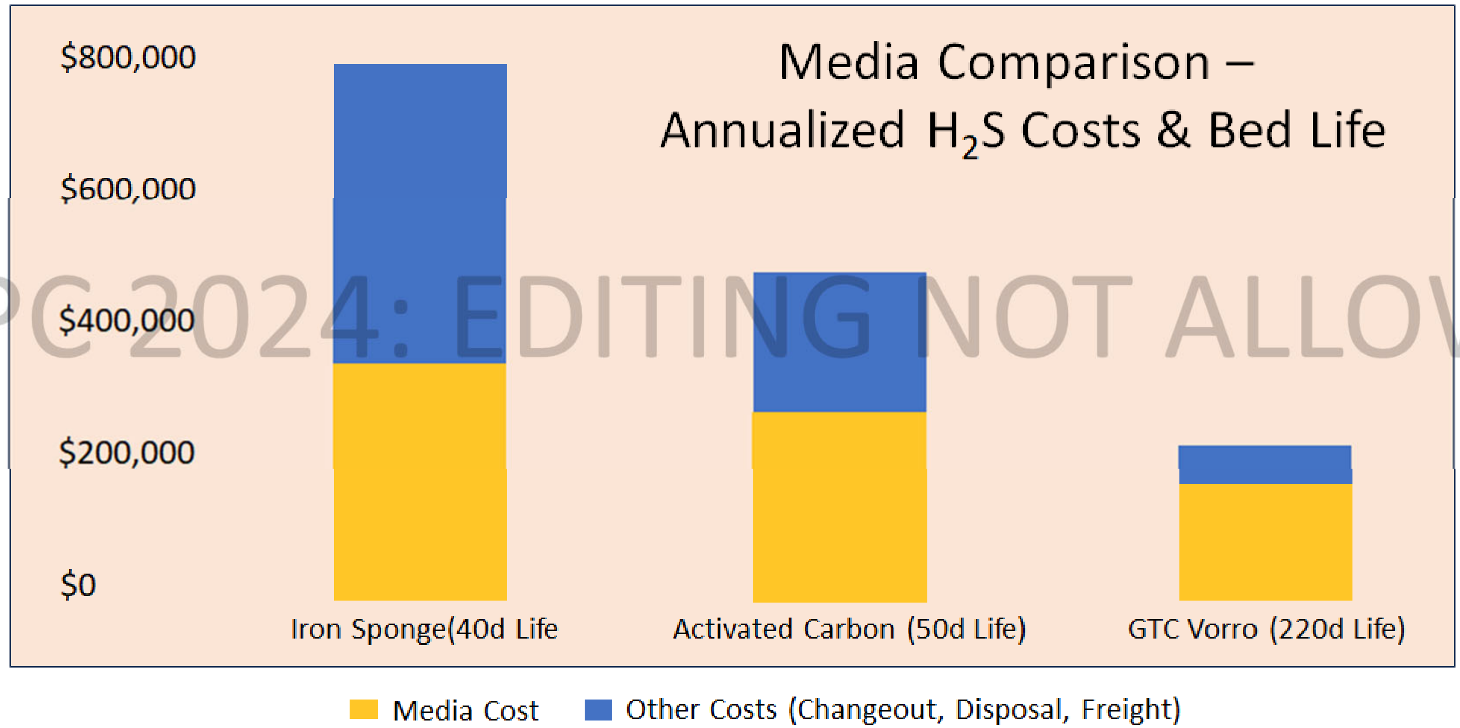
Lowest Total Cost for H_2S Removal



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GTCV Media: Pressure Drop

- Media has low density (23-26 lb/ft3) and porous structure.
- Sulfur deposits inside the pores, while the gas flows on the outside.
- Fuel Gas systems have limited pressure drop margin. 7-10 psi.
- Media's unique pore structure results in < 3 psi pressure drop across entire skid at end-of-run.

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Media Changeout

- Changeout is done via a manhole located on side of the vessel. Media is free-flowing when spent.
- Conventional iron oxide-based media changeouts are difficult and need careful media handling.
- Conventional spent Iron oxide media is pyrophoric, while spent GTCV media is not.
- No need for hydrovaccuming the spent media from top.

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Introducing Catalytic Adsorption: NanoSØRB

- Singular dimension nano-wire technology gives much higher dispersion of metals with improved activity and selectivity.
- Revolutionary improvement compared to current-state-of-the-art.
- Capable of removing H_2S, Mercaptans, Disulfides and Thiophenes.

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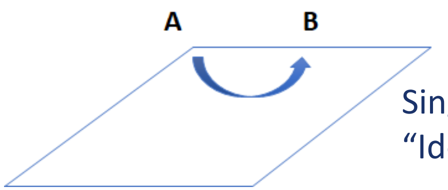
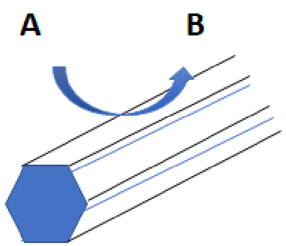
Principles of Nanowire Technology



Single crystal surface
"Ideal"

Traditional catalysts: Spherical particles with many different surfaces "Low reactivity & selectivity"



Nanorods:
single crystal surfaces
"high reactivity & selectivity"

Nanowire transforms catalysis

- Ultra-fine dispersion of active metals onto substrate
- Higher activity, selectivity and durability against sintering
- Dual-function: **catalytic** and **adsorptive**. "Chemisorption" or "Catalytic Adsorption"

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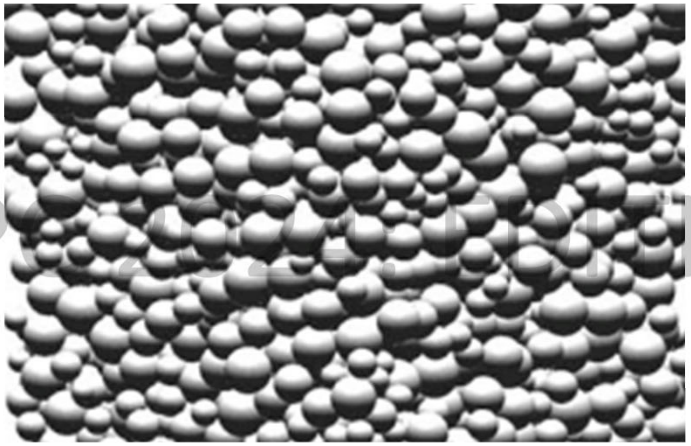
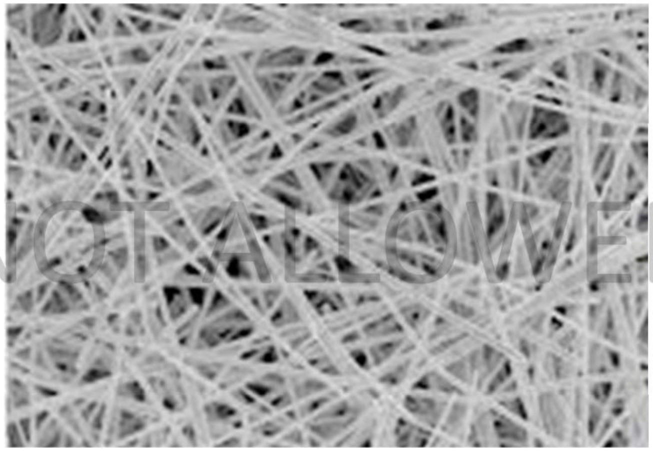
Metals Dispersion

Traditional Metals Deposition



Packing of spherical powders: sinter over time – Lose surface area and activity

Nanowire Structure



Packing of nanowires: No sintering and loss of area, resulting in higher lifetime

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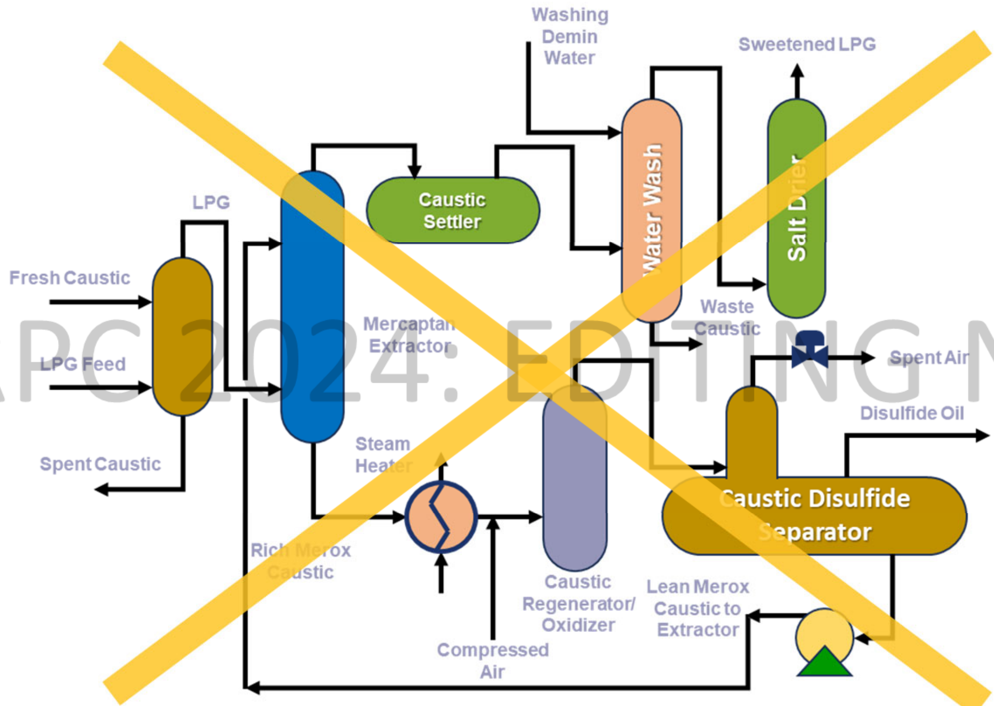
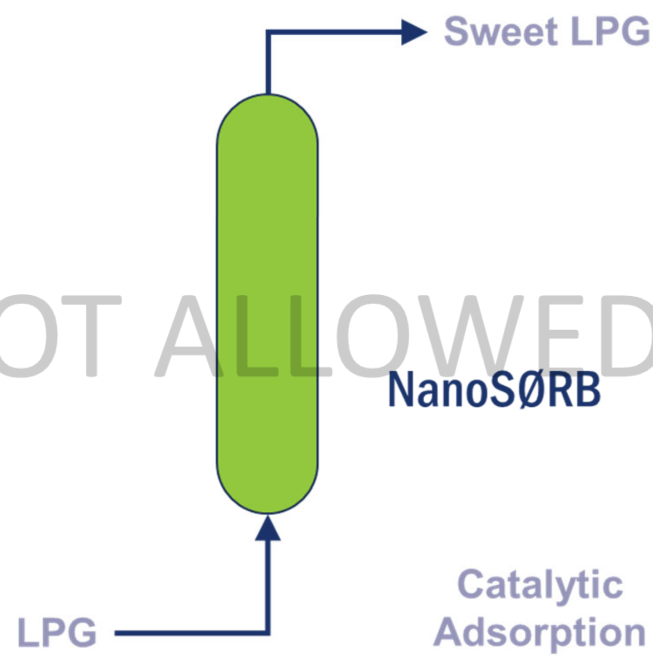
LPG - Caustic Treater Option



- Fresh Caustic Required
- Continuous Waste



- Regenerable Media
- Eliminates Waste Caustic

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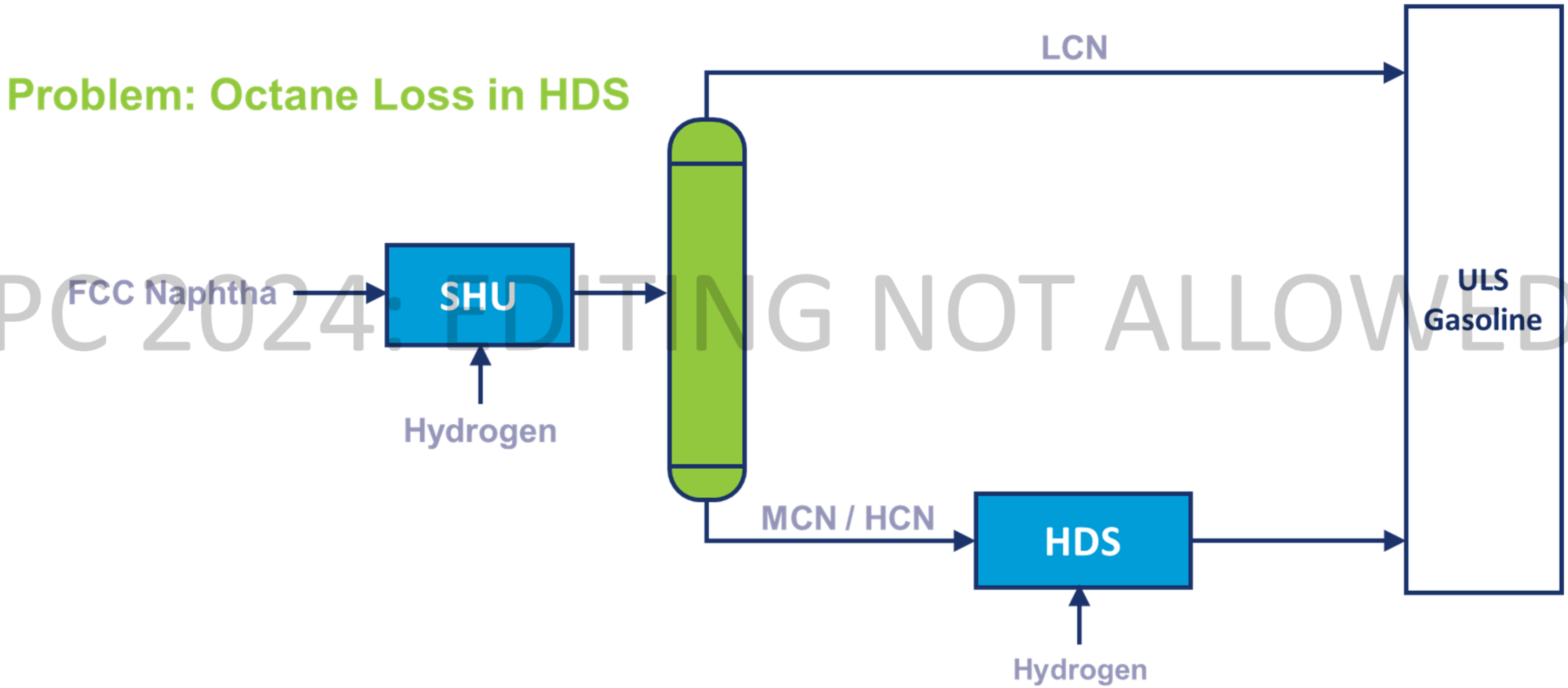
FCC Gasoline - Typical Hydrotreating/Desulfurization Process



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FCC Gasoline Octane Loss

There is inevitable octane loss due to saturation of olefins.

Olefin Saturation is the Problem	
	RON
C – C – C – C – C = C (Hexene)	76
C – C – C – C – C – C (Hexane)	24

Solution – reduce saturation of olefins by reconfiguring the process

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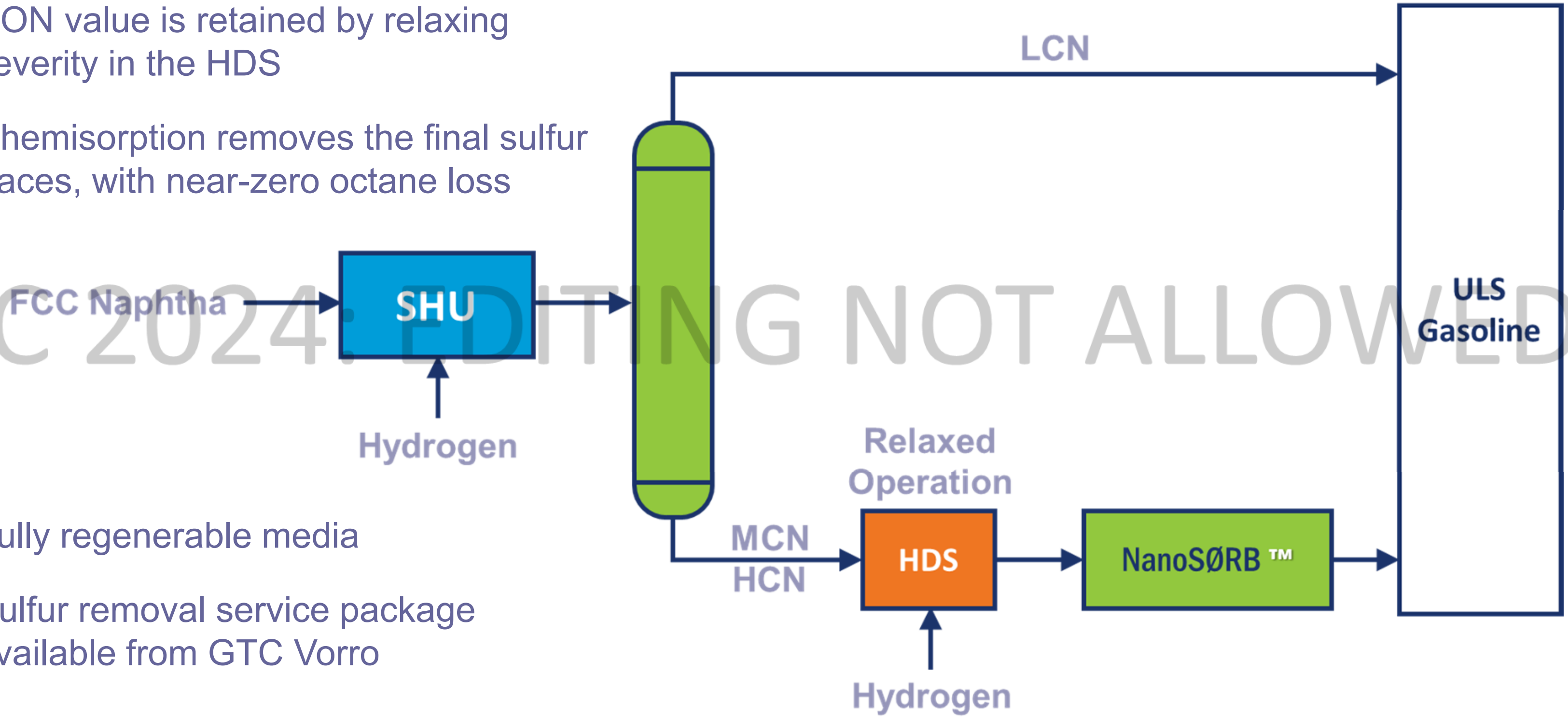
Polishing by Chemisorption

- RON value is retained by relaxing severity in the HDS
- Chemisorption removes the final sulfur traces, with near-zero octane loss



- Fully regenerable media
- Sulfur removal service package available from GTC Vorro

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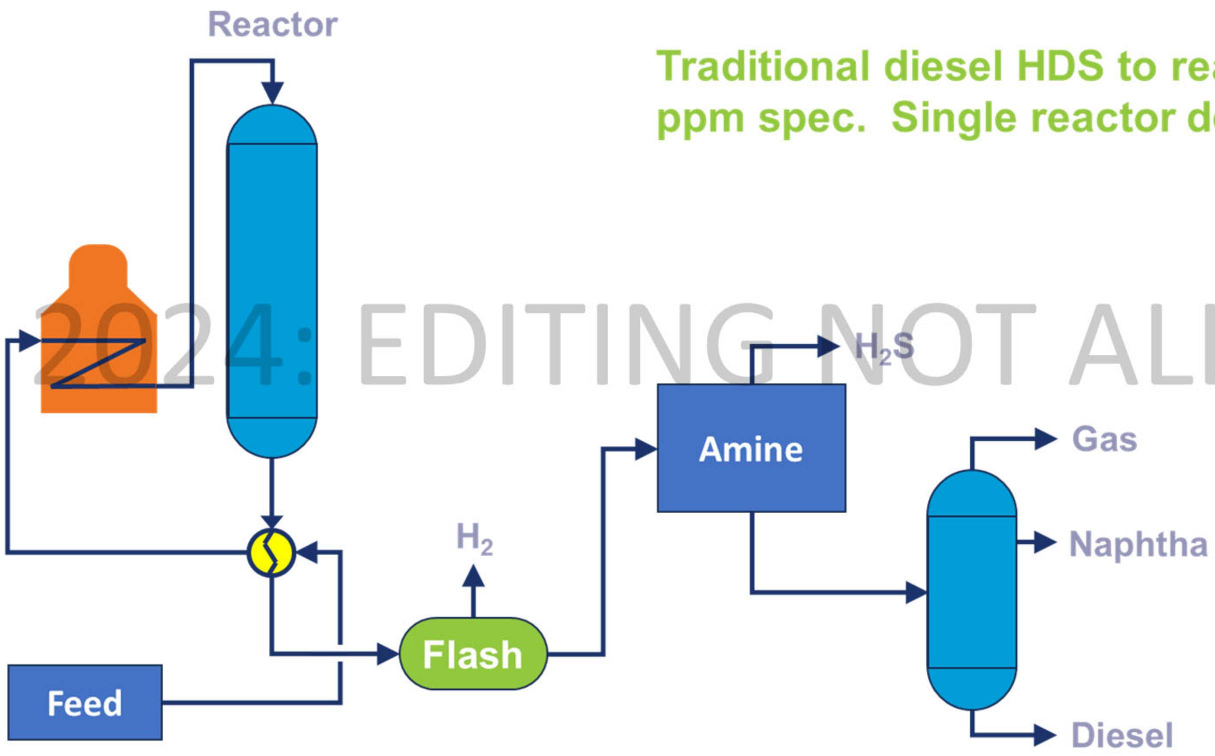
Diesel Desulfurization

Traditional diesel HDS to reach 500 ppm spec. Single reactor design.



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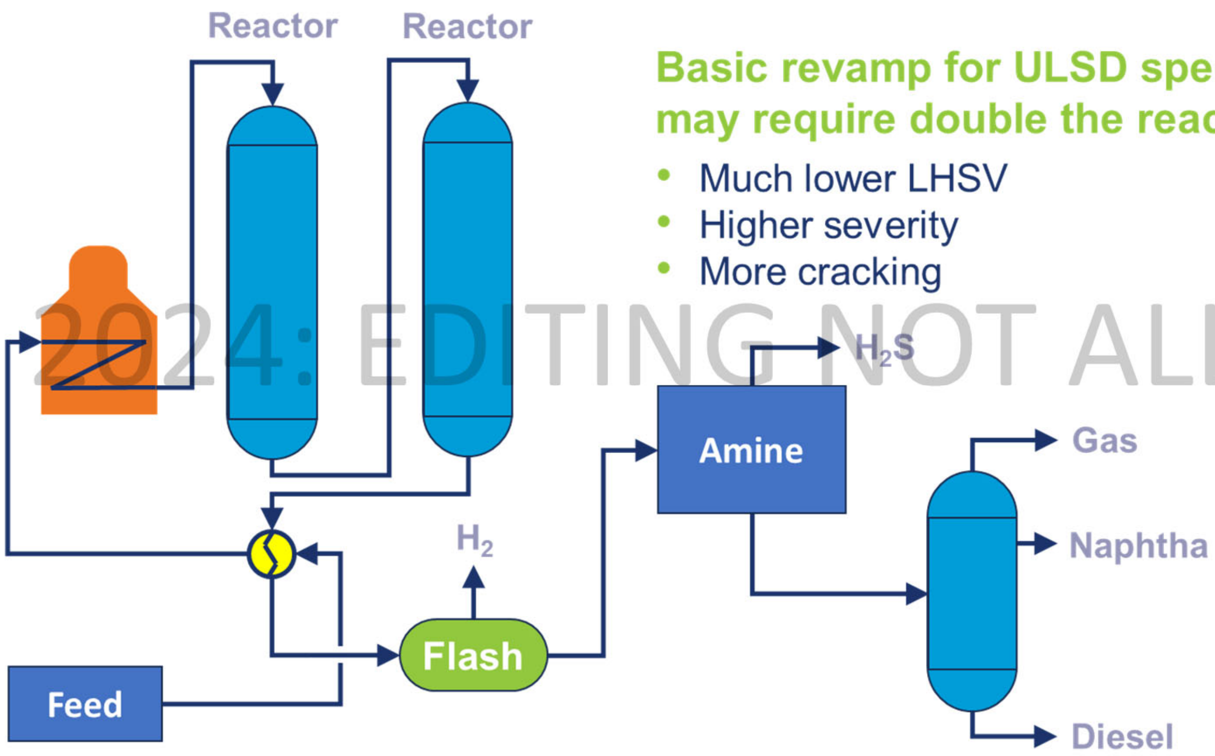
ULSD with New, Full-size Reactor



Basic revamp for ULSD specification, may require double the reactor volume

- Much lower LHSV
- Higher severity
- More cracking

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ULSD with Catalytic Adsorption Polishing System

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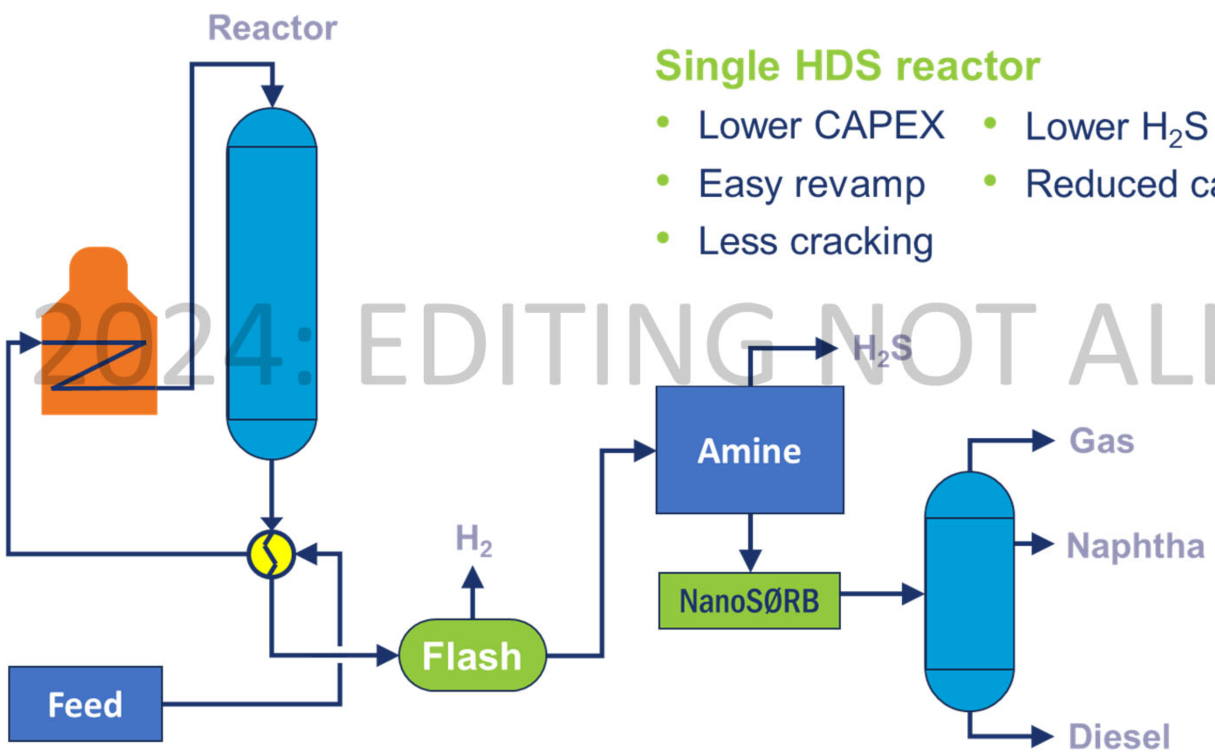
Single HDS reactor

- Lower CAPEX
- Easy revamp
- Less cracking
- Lower H_2S consumption
- Reduced catalyst quantity



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Summary

- Development of new media and catalysts opens doors for:
  - SO_2 emissions compliance
  - Achieving higher energy efficiency
  - Decarbonization

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- Fuel Gas, LPG, FCC Gasoline and Diesel are ripe candidates to achieve above goals via deployment of SweetTreat-O™ and NanoSØRB.

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