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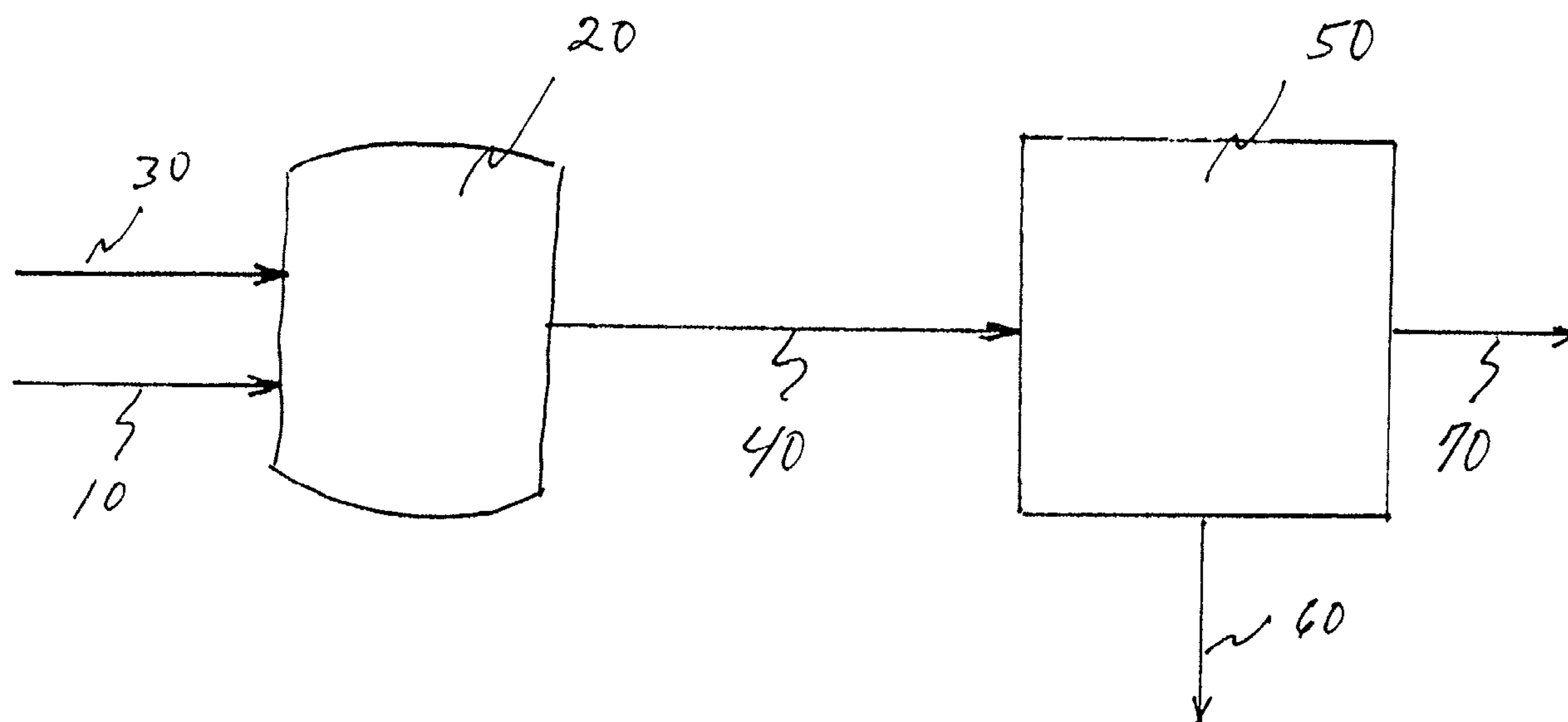
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(57) Abrégé/Abstract:

COS, and/or CS₂ is contacted, in the presence of oxygen, with a vanadium oxide supported catalyst, using one or more of a variety of different metal oxide supports, preferably selected from the group consisting of zirconia (ZrO₂), ceria (CeO₂), niobia (Nb₂O₅), silica (SiO₂) and alumina (Al₂O₃), to selectively oxidize these organic sulfur compounds to CO and SO₂.



IMPROVED PRODUCTION OF HYDROGEN FROM HYDROGEN SULFIDE

ABSTRACT OF THE DISCLOSURE

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COS, and/or CS₂ is contacted, in the presence of oxygen, with a vanadium oxide supported catalyst, using one or more of a variety of different metal oxide supports, preferably selected from the group consisting of zirconia (ZrO₂), ceria (CeO₂), niobia (Nb₂O₅), silica (SiO₂) and alumina (Al₂O₃), to selectively oxidize

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these organic sulfur compounds to CO and SO₂.

IMPROVED PRODUCTION OF HYDROGEN FROM HYDROGEN SULFIDE

FIELD OF THE INVENTION

The present invention is directed to a catalytic process for selectively oxidizing carbonyl sulfide (COS) and carbon disulfide (CS₂) to carbon monoxide (CO) and sulfur dioxide (SO₂). The process of the invention is particularly useful in combination with the known equilibrium reaction for producing hydrogen from hydrogen sulfide. Such combination provides a cost effective way of producing hydrogen from what are often considered waste sulfur streams. The so-produced hydrogen can be used for a variety of purposes as is well known in the art.

BACKGROUND OF THE INVENTION

Carbonyl sulfide (COS) is found in many industrial process streams such as those associated with natural gas production, petroleum refineries and coal gasification plants. COS often is catalytically converted by hydrogenation to methane (CH₄), hydrogen sulfide (H₂S) and water; by hydrolysis to carbon dioxide (CO₂) and H₂S, or by oxidation to CO₂ and sulfur dioxide (SO₂). Hydrogenation is an expensive waste of valuable hydrogen (H₂), while hydrolysis and total oxidation produces CO₂, considered by many to be an environmental threat due to its alleged impact on global warming.

Carbon disulfide (CS₂) is another organic sulfur pollutant. CS₂ is commonly encountered in paper manufacturing waste streams and in petroleum refineries. It can be treated much like COS to yield the same end products. Even though these methods provide the important removal of environmentally unsafe reduced sulfur compounds, they do not produce valuable chemicals from the original sulfur pollutants.

H₂S is commonly encountered in petroleum refineries where hydrodesulfurization is widely used to remove sulfur from gasoline. A significant

amount of H_2S (oftentimes as much as 10-30%) also is found in natural gas recovered from geological formations. The H_2S is typically separated from the methane and the resulting de-sulfurized methane typically is distributed for industrial and personal uses, such as for home heating. The isolated H_2S often is converted to elemental sulfur via the Claus Process. In the Claus Process, a first portion of the separated hydrogen sulfide is converted (oxidized) to sulfur dioxide (SO_2) and water and the remaining portion of the hydrogen sulfide is reacted with the water-laden sulfur dioxide in the presence of a suitable catalyst to produce additional water and elemental sulfur. The so-produced sulfur represents a low value-added, commodity product, while essentially all of the potentially valuable hydrogen resident in the H_2S is converted into water. The development of a cost effective alternative for using the hydrogen sulfide, and especially for recovering at least a portion of its hydrogen content, would significantly improve the economies of sour natural gas recovery and processing and would greatly benefit the operation of petroleum refinery operations.

Herrington et al., U.S. 4,618,723 describes processes for using H_2S as a reducing agent to reduce carbon oxides and generate hydrogen which is then used, as described, to make such organic compounds as alkanes, alcohols, alkenes and the like. The focus of such processes is to upgrade carbon dioxide and carbon monoxide to valuable organic compounds using H_2S as a reducing agent. The patent presents the equilibrium reaction in which H_2S is used to produce H_2 from carbon monoxide, with by-product COS. The patent also shows the oxidation reaction involving COS to produce CO and SO_2 . This reaction, however, is conducted either in the absence of a catalyst or in the presence of quartz chips (SiO_2) as a catalyst. Unfortunately, the yield (conversion) and selectivity of this step, as obtained under these conditions, has simply not been sufficiently high to make hydrogen production from H_2S a cost effective alternative.

Thus, it would be advantageous if a process were available for selectively converting organic sulfur pollutants, such as COS and CS_2 , at high yield (conversion) and selectivity to CO and SO_2 . Such a process would make practicably

feasible the conversion of H₂S to the valuable end product, H₂.

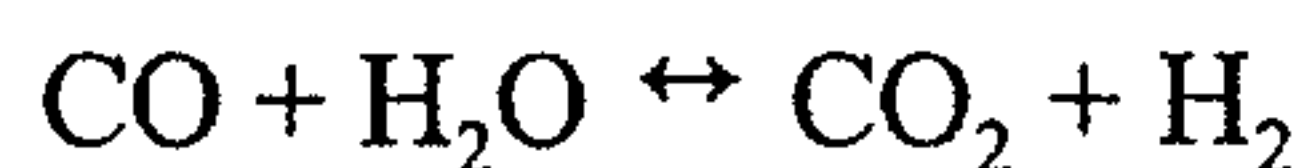
U.S. Patent 4,427,576 generally describes catalytically oxidizing H₂S and/or organosulfur compounds to SO₂ using titanium dioxide (titania) with zirconia or silica (SiO₂), an alkaline earth metal sulfate and one of the elements Cu, Ag, Zn, Cd, Y, lanthanides, V, Cr, Mo, W, Mn, Fe, Co, Rh, Ir, Ni, Pd, Pt, Sn and Bi.

SUMMARY OF THE INVENTION

The present invention is directed to a process for selectively oxidizing carbonyl sulfide (COS) and carbon disulfide (CS₂) to carbon monoxide (CO) and sulfur dioxide (SO₂):



The CO can be used to produce valuable hydrogen, such as via the water gas shift reaction;



or more preferably from H₂S via the known equilibrium reaction:



In this later reaction, the COS, in turn, is used to generate additional CO for the above reaction with H₂S. The by-product SO₂ also can be converted, if desired, to elemental sulfur, or to sulfuric acid.

In particular, the present invention is based on the discovery that by contacting COS, and/or CS₂, in the presence of excess oxygen, with a supported vanadia catalyst, one can selectively oxidize these organic sulfur compounds to CO and SO₂. In particular, applicants have discovered that a vanadium oxide (vanadia - V₂O₅) supported catalyst, using one or more of a variety of different metal oxide supports selected from the group consisting of antimony oxides, tantalum, tin oxide,

lanthana, indium oxides, iron oxides, nickel oxide, cobalt oxide, gallium oxides, manganese oxides, chromia, tungsten oxide, hafnia, zirconia, ceria, niobia, silica and alumina, is able to promote the selective oxidation of COS and CS₂ to CO and SO₂. On the basis of cost and availability the preferred metal oxide supports are selected from the group consisting of zirconia (ZrO₂), ceria (CeO₂), niobia (Nb₂O₅), silica (SiO₂) and alumina (Al₂O₃). Especially preferred are a 5% V₂O₅ on Nb₂O₅ catalyst, which for COS oxidation at 290° C provides a selectivity to CO of 98% and for CS₂ oxidation provides an 80% selectivity to CO and a V₂O₅ on SiO₂ catalyst which for CS₂ oxidation provides a selectivity towards CO higher than 90% at 270° C.

By coupling these oxidation reactions with the known equilibrium reaction involving the conversion of H₂S and CO to H₂ and COS (and often some CS₂ and CH₃SH as byproducts), one is able to convert what are otherwise environmentally undesirable sulfur pollutants to a very valuable material, H₂ and by-product SO₂. The SO₂ is not laden with as much moisture as when produced directly from H₂S oxidation and thus can be sent to a Claus plant for more efficient conversion to elemental sulfur, or alternately it can be further oxidized to sulfuric acid (H₂SO₄).

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a simplified schematic flow diagram illustrating a basic aspect of the present invention.

FIG. 2 is a simplified schematic flow diagram describing a preferred method of utilizing the present invention for producing hydrogen by reducing carbon monoxide with hydrogen sulfide.

DETAILED DESCRIPTION OF THE INVENTION

In its basic form the present invention provides a process for the conversion of COS and/or CS₂ to CO by subjecting the same to oxidation, as with air or oxygen, in the presence of a catalyst essentially comprising a supported vanadium oxide (vanadia - V₂O₅) catalyst. In accordance with the present invention, the vanadia can be supported on a variety of different metal oxide supports selected from the group consisting of antimony oxides, tantalum, tin oxide, lanthana, indium oxides, iron oxides, nickel oxide, cobalt oxide, gallium oxides, manganese oxides, chromia, tungsten oxide, hafnia, zirconia, ceria, niobia, silica and alumina. On the basis of cost and availability the preferred metal oxide supports are selected from the group consisting of zirconia (ZrO₂), ceria (CeO₂), niobia (Nb₂O₅), silica (SiO₂) and alumina (Al₂O₃). The supported vanadia catalyst is able to promote the selective oxidation of COS and CS₂ to CO and SO₂.

In another of its preferred features, the present invention provides a process, as hereinbelow described, wherein the catalytic oxidation of COS to CO and SO₂ is integrated with the equilibrium reduction of CO with H₂S so as to provide an efficient and cost effective manner of dealing with reduced sulfur pollutants, such as H₂S, CS₂ and mercaptans, while producing a valuable product, hydrogen.

Other aspects, concepts, objects, and the several advantages of the invention are apparent from a study of this disclosure and the appended claims.

According to the present invention there is provided a process for the conversion of COS and/or CS₂ to CO and SO₂ by subjecting said organic sulfur compounds to oxidation as with air or oxygen. The partial oxidation of carbonyl sulfide to carbon monoxide and sulfur dioxide is a known reaction. See such articles as *Journal of the Chemical Society*, Bawn, C. E. H., 1933, 145 and *Combustion and Flame*, Cullis, C. F. and Mulcahy, M. F. R., 18, 225 (1972). The oxidation of carbon disulfide to carbon monoxide and sulfur dioxide also is known. While it is known that such combustion reactions can proceed in the absence of a catalyst, the present invention is based on the discovery of a class of catalysts that selectively promote

the oxidation of these sulfur compounds to CO, so as to minimize the undesired formation of by-product CO₂. The partial oxidation reaction thus is conducted in the presence of a catalyst system comprising vanadia supported on a metal oxide support. In the broad practice of the present invention, the metal oxide support can be selected from the group consisting of antimony oxides, tantalum, tin oxide, lanthana, indium oxides, iron oxides, nickel oxide, cobalt oxide, gallium oxides, manganese oxides, chromia, tungsten oxide, hafnia, zirconia, ceria, niobia, silica and alumina. On the basis of cost and availability, the preferred metal oxide supports include those selected from the group consisting of zirconia (ZrO₂), ceria (CeO₂), niobia (Nb₂O₅), silica (SiO₂) and alumina (Al₂O₃). With reference to Figure 1, this basic aspect of the present invention will be described.

A source of carbonyl sulfide (COS), and/or carbon disulfide (CS₂) is delivered through conduit 10 to a reactor 20. Separately, a stream of air, or more preferably oxygen, is fed into the reactor through conduit 30. Reactor 20 contains a supported vanadia catalyst with the vanadia supported on a metal oxide. Preferably, the metal oxide is one selected from the group consisting of zirconia (ZrO₂), ceria (CeO₂), niobia (Nb₂O₅), silica (SiO₂) and alumina (Al₂O₃). As will be explained in more detail hereinafter, the vanadia supported catalyst can take any convenient physical shape including tablets, spheres, pellets, extrusions, powder. The catalytic reactions of carbonyl sulfide and carbon disulfide with oxygen is a vapor-phase reaction and thus can be conducted in any vapor-phase reactor including the various known fixed- and fluid-bed configurations. In accordance with the present invention, the reactions are typically conducted at a temperature range of about 150° to 500° C, preferably at a temperature in the range of about 220° to 350° C, more preferably between 230° and 330° C. Normally the COS oxidation proceeds better, in terms of the conversion and selectivity to desired products, at the higher end of the noted temperature ranges, while the CS₂ oxidation favors the lower ends of these ranges. The oxidation reaction can conveniently be conducted at a pressure in the range of from about atmospheric pressure up to about 1,000 psig. Normally it will

be carried out at a pressure in the range of from atmospheric pressure to 500 psig. Subatmospheric pressure conditions are not excluded, but normally do not provide a benefit commensurate with the expense and complexity. Generally, a large stoichiometric excess of oxygen relative to the carbonyl sulfide, or carbon disulfide is preferred. Contact time will vary with the process conditions, but typically in a fixed-bed reactor a contact time between about 1 and about 20, preferably between about 2 and about 10, seconds should be sufficient.

The reaction conditions are selected so as to maximize both the conversion of the feed COS and/or CS₂ and to maximize the selectivity of the oxidation to CO and SO₂. A stream containing CO and SO₂ flows out from reactor 20 through conduit 40. When CS₂ is oxidized, COS likely will also be a significant reaction product. The product stream will also contain excess oxygen, nitrogen (if air, or enriched air is used as the oxygen source) and unreacted feed materials. The reaction mixture then is processed in separation zone 50 to produce separate streams of CO and SO₂. Any of a wide variety of separation processes (and their combination) can be employed for separator zone 50, such for example as selective absorption, selective adsorption, rectification, molecular sieving and the like, to separate a stream of predominately CO, in conduit 60, from the SO₂ in conduit 70. For example, carbon monoxide may be selectively absorbed in an absorber using specific absorbents introduced into the separation zone 50 (by means not shown) and recovered therefrom. Other components (not shown) in the product stream from reactor 20, including COS, N₂, O₂ and the like, also are separated using known procedures. Any CS₂ and /or COS that is recovered from the reaction product in conduit 40 can be recycled to reactor 20 (not shown). Specific processing that can be used to produce the separate streams of CO and SO₂ are well-understood by those skilled in the art; the specific techniques and procedures form no part of the present invention and for that reason are not described herein.

The separate streams of CO and SO₂ can then be used and/or further processed according to any of the wide variety techniques known in the art. For

example, the SO_2 can be sent to a Claus plant for conversion to elemental sulfur, or further oxidized to sulfuric acid (H_2SO_4). The CO stream can be reacted with water in contact with an appropriate catalyst for carrying out the well known water gas shift reaction, leading to the production of hydrogen. Preferably, the CO stream is integrated into a process for converting H_2S to hydrogen, avoiding, or at least minimizing the formation of CO_2 , considered by many to be an environmental threat due to its alleged impact on global warming. If a separate COS stream is produced (not shown) as may occur when oxidizing CS_2 or if the conversion of COS is incomplete, it can be separated and returned to the reactor 30 for reaction with excess oxygen.

With reference to Figure 2, a preferred embodiment of the present invention now will be described. Separate streams of H_2S and CO, in conduits 1 and 2, respectively, are fed into reactor 3 where the equilibrium reaction leading to the formation of hydrogen is conducted. The reaction of carbon monoxide with hydrogen sulfide to form carbonyl sulfide and hydrogen is a known vapor phase reaction and is described in such articles as *Journal of Catalysis*, 49, 379 (1977) and *Bulletin of Chemistry for Japan*, 51, 150 (1978), both by Fukuda et al. The reaction is typically conducted within a temperature range of 200° to 600° C, preferably in the range of from 250° to 400° C. Reaction pressures are generally within the range of from atmospheric pressure up to about 1,000 psig, and more usually are within the range of atmospheric pressure up to 500 psig. While a stoichiometric amount of each reactant is required, preferably a stoichiometric excess of one of the reactants, preferably hydrogen sulfide, is used as a means of shifting the equilibrium to the desired hydrogen product.

Preferably this reaction is conducted in the presence of a catalyst. Known catalysts include an oxide or sulfide of a Group 6b or 8 metal of the Periodic Table, which is optionally promoted with one or more metal compounds from Groups 4a, 1b and 2a. These catalysts can be supported or unsupported and if supported, the support can be selected from a wide range of materials including such compounds as

alumina, silica, silica-alumina, zirconium oxide, thorium oxide, titanium oxide, etc. The catalyst can take any convenient physical shape including tablets, spheres, pellets, extrusions, powder. This reaction can be conducted in any vapor-phase reactor including the various fixed- and fluid-bed configurations and the contact time of the reactants over the catalyst bed will vary with the other process parameters. Typically, a contact time of 1-20, preferably 2-10, seconds is employed.

The reaction product containing a mixture of hydrogen and COS, along with unreacted H_2S and CO, is delivered through conduit 4 into separator 5 where the H_2 is separated from the COS. Any of a wide variety of separation processes (and their combination) can be employed for separator 5, such for example as selective absorption, selective adsorption, rectification, molecular sieving and the like, to separate a stream of predominately COS, in conduit 6, from the H_2 in conduit 7. Hydrogen, for example, may be removed in separation zone 5 using a selective permeable membrane (not shown). Other components (not shown) in the product stream from reactor 3, including H_2S and CO and the like, also are separated using known procedures. For example, an absorption step can be used in separation zone 5 to remove H_2S by means of amine solutions, from which it can be recovered for recycle by a temperature controlled desorption (not shown). Specific processing that can be used to produce the separate streams of COS and H_2 , separate from any unreacted feed material, are well-understood by those skilled in the art. The specific techniques and procedures form no part of the present invention and for that reason are not described herein.

The hydrogen stream in conduit 7 can be used as a feedstock and/or further processed according to any of the wide variety processes known in the art. The COS stream in conduit 6 is delivered into reactor 20, joining a separate oxygen stream 30, for contacting with a supported vanadia catalyst in accordance with the present invention. Reactor 20 may also receive a separate (optional) feed of COS and/or CS_2 through conduit 8. In accordance with the present invention, the partial oxidation reaction of the COS (and optionally CS_2) is conducted at a temperature in the range

of about 150° to 500° C, preferably at a temperature in the range of about 250° to 350° C, and at a pressure in the range of from about atmospheric pressure up to about 1,000 psig, normally at a pressure in the range of from atmospheric pressure to 500 psig. Other operating conditions are consistent with those described in connection with the embodiment of Figure 1.

A stream containing CO and SO₂ (and other likely constituents as identified in connection with the embodiment of Figure 1) flows out from reactor 20 through conduit 40. As described in connection with the embodiment of Figure 1, the reaction mixture then is processed in separation zone 50 to produce, among others, separate streams of CO and SO₂. As before, any of a wide variety of separation processes can be employed for separation zone 50, such for example as selective absorption, selective adsorption, rectification, molecular sieving and the like, to provide separate streams of predominately CO, in conduit 60, and SO₂ in conduit 70. The CO stream is recycled as at least part of the feed stream for reactor 3, while the SO₂ stream can be used and/or further processed according to any of the wide variety of techniques known in the art. As noted above, the SO₂ can be sent to a Claus plant for conversion to elemental sulfur, or further oxidized to sulfuric acid (H₂SO₄).

As evident from the data hereinbelow presented, the one-step process of the invention is operative to yield a high conversion and selectivity of the COS and CS₂ oxidation to CO.

The vanadia supported catalyst used in the process of this invention may be prepared by impregnation techniques well-known in the art, such as incipient wetness, grafting, equilibrium adsorption, vapor deposition, thermal spreading, *etc.* When using an incipient wetness impregnation technique, which is preferred, an aqueous or non-aqueous solution containing a vanadium oxide precursor compound(s) is contacted with the metal oxide support or substrate material, preferably zirconia (ZrO₂), ceria (CeO₂), niobia (Nb₂O₅), silica (SiO₂) and alumina (Al₂O₃), for a time sufficient to deposit a vanadia precursor material onto the support such as by selective adsorption or alternatively, excess solvent may be evaporated

leaving behind the vanadia precursor compound or salt. If an incipient wetness impregnation technique is used to prepare the catalyst for use in this invention, the vanadia precursor (e.g., salt) solution used may be aqueous or organic, the only requirement being that an adequate amount of the precursor compound be soluble in the solvent used in preparing this solution. Other impregnation techniques, such as vapor deposition and thermal spreading, do not require use of a solvent as does incipient wetness, and may be desirable in some circumstances to avoid the problem of volatile organic carbon (VOC) emissions.

For example, one way to disperse vanadium oxide on a zirconia (metal oxide) support or substrate is to impregnate spheres or powder (spheres or powder are used as representative examples of shapes of the zirconia support material) with a solution containing a vanadium compound. Generally, an aqueous solution is preferred. Criteria used to choose the vanadium compound for impregnation include whether the vanadium compound is soluble in the desired solvent and whether the vanadium compound decomposes at an acceptable rate at a high, calcination temperature to give the appropriate metal oxide (vanadia). Illustrative of suitable compounds of vanadium are the halides of vanadium, oxyacids, oxyacid salts and oxysalts of vanadium. Specific examples are vanadium tribromide, vanadium dichloride, vanadium trichloride, vanadium oxychloride, vanadium oxydichloride, vanadic acid, vanadyl sulfate, vanadium alkoxides (such as triisopropoxide), vanadium oxalate (which may be formed *in situ* by reaction of V_2O_5 and an aqueous solution of oxalic acid), and ammonium meta-vanadate.

The impregnation of the metal oxide support or substrate, e.g., a zirconia (ZrO_2), ceria (CeO_2), niobia (Nb_2O_5), silica (SiO_2) or/and alumina (Al_2O_3) support spheres or powder, with the metal oxide (vanadia) precursor compound solution may be carried out, as noted above, in ways well known in the art using either wet or dry impregnation techniques. One convenient method is to place the metal oxide support or substrate particles into a rotary evaporator which is equipped with a steam jacket. An impregnating solution of the precursor compound which contains an amount of

vanadium to be included in the finished catalyst (as the metal) is added to the support particles and the mixture is cold rolled (no steam) for a time from about 10 to 60 minutes sufficient to impregnate the support with the precursor compound solution. Next, steam is introduced and the solvent is evaporated from the impregnated solution. This usually takes from about 1 to about 4 hours. The impregnated support will normally be dried at temperatures ranging from about 50° - 300° C. to remove excess solvent.

Water soluble vanadia precursor compounds are generally preferred for industrial applications because of the environmental concern about VOC emissions. Nonetheless, when using an organic solvent, initial heating may be done in a nitrogen atmosphere to remove any flammable solvent. Finally, the support particles are removed from the rotary evaporator and calcined in a suitable oxidizing atmosphere such as air, oxygen, etc. at a temperature of about 150° to 800°C, and more usually from 400° - 600° C, preferably for about 1 to about 3 hours, sufficient to decompose the vanadium precursor compound to the corresponding vanadium oxide. In some cases, as recognized by those skilled in the art, calcining conditions may need to be adjusted to avoid undesirably reducing catalyst surface area.

If any of the precursor compounds are air/moisture sensitive, they can conveniently be prepared under a nitrogen atmosphere as is recognized by those skilled in this art. The time required to calcine the composite will, of course, depend on the temperature and in general will range from about 0.5 - 7 hours. Calcination at 450°C for about 2 hours has proven to be suitable for 1% vanadia on one of the noted oxide supports. The precise time and temperature for calcination should be selected to avoid adversely affecting the metal oxide support and any degradation of extended surface areas. Selection of a suitable combination of time and temperature is a matter of routine testing to those skilled in the art.

The vanadia metal oxide precursors can be decomposed by using an inert atmosphere, such as nitrogen or helium, or by using a reducing atmosphere. To avoid potential safety concerns, the resulting composite should be calcined to

convert the reduced metal component to the oxide form.

The vanadia supported catalysts used in the process of this invention will generally have surface vanadia loading of from about 0.5 to 35 wt.% metal oxide based on the total active catalyst composition, preferably from about 1 to 20 wt.%, more usually from about 1 - 15 wt. %, and most preferably 1-10 wt.% based on the total active catalyst composition. With the exception of a silica support, it is preferred that the vanadia be provided in an amount of up to a monolayer on the metal oxide support surface, and that generally no less than about 50% of the monolayer amount be used. As a rule of thumb, a monolayer coverage of vanadia is obtained at a vanadia loading of about 1% by weight vanadia per 10 m²/g of support surface area. The metal oxide used as the catalyst support component in accordance with the present invention generally should have a surface area in the range of about 1 to about 150 m²/g and higher, and preferably above about 5 m²/g. In the case of a silica support, on which a monolayer of vanadia cannot be formed, lower vanadia loadings are preferred. In particular, a vanadia loading between about 0.1 to 10%, and more preferably 1 to 5%, is preferred for a silica support.

These catalyst materials may be used in any configuration, shape or size which exposes their surface and the vanadia layer dispersed thereon to the gaseous stream passed in contact therewith. For example, these oxide supports, such as zirconia can conveniently be employed in a particulate form or deposited (before or after impregnation with the vanadia overlayer) on a monolithic carrier or onto ceramic rings or pellets. As particles, the support, such as zirconia, can be formed in the shape of pills, pellets, granules, rings, spheres and the like. Use of free particulates might be desirable when large catalyst volumes are needed or if the catalyst bed is operated in a fluidized state. A monolithic form or deposition of the active catalyst on an inert ceramic support might be preferred in applications where catalyst movement is to be avoided because of concerns about catalyst attrition and dusting, and a possible increase in pressure drop across a particulate bed. In a preferred approach, a vanadia supported catalyst, such as a vanadia on zirconia

catalyst, may be deposited on a ceramic carrier such as silicon carbide, silicon nitride, carborundum steatite, alumina and the like, provided in the shape of rings or pellets. Typically, the active catalyst will be applied to the inert ceramic support in an amount to provide 1 to 20% by weight of the supported catalyst.

5 While the metal oxide, e.g., silica, zirconia, alumina, niobia, ceria, and the like are conveniently referred to as supports or substrates in the description of the preferred embodiment of the present invention, based to a large degree on the way the catalysts are prepared, it should be noted that they may well provide important roles as active catalytic components in the supported vanadia catalyst. Combination
10 supports may also be advantageous for use in catalysts suitable for practicing the present invention.

 Further details on the preparation and structure of vanadia supported catalysts useful in the practice of the present invention can be found in Jehng et al., *Applied Catalysis A*, **83**, (1992) 179-200; Kim and Wachs, *Journal of Catalysis*, **142**, (1993) 166-171; Jehng and Wachs, *Catalysis Today*, **16**, (1993) 417-426; Kim and Wachs, *Journal of Catalysis*, **141**, (1993) 419-429; Deo et al., *Applied Catalysis A*, **91**, (1992) 27-42; Deo and Wachs, *Journal of Catalysis*, **146**, (1994) 323-334; Deo and Wachs, *Journal of Catalysis*, **146**, (1994) 335-345; Jehng et al., *J. Chem. Soc. Faraday Trans.*, **91**(5), (1995) 953-961; Kim et al., *Journal of Catalysis*, **146**, (1994) 268-277; Banares et al., *Journal of Catalysis*, **150**, (1994) 407-420 Jehng and Wachs, *Catalyst Letters*, **13**, (1992) 9-20; Sun et al., *Methane and Alkane Conversion Chemistry*, pp. 219-226 (1995); Herman et al., *Catalysis Today*, **37**: (1997) 1-14 and Sun et al., *J. of Catalysis*, **165**, (1997) 91-101, the disclosure of which are
20 incorporated herein by reference.

25 Particularly preferred supported vanadia catalysts for the present invention include 5% V₂O₅ on Nb₂O₅ catalyst, which for COS oxidation at 290° C provides a selectivity to CO of 98% and for CS₂ oxidation provides an 80% selectivity to CO, and a 1% V₂O₅ on SiO₂ catalyst.

EXAMPLES

To facilitate a more complete understanding of the invention, a number of Examples are provided below. The scope of the invention, however, is not limited to specific embodiments disclosed in these Examples, which are for purposes of illustration only.

EXAMPLE 1: Catalyst Preparation and Characterization

Supported vanadia catalysts were prepared by the incipient wetness method. A vanadia on zirconia metal oxide supported catalyst was prepared in accordance with the following procedure. The vanadia-zirconia catalyst was prepared by using ZrO_2 (from Degussa -having a surface area of $\sim 39 \text{ m}^2/\text{g}$) as the support. The vanadia precursor (vanadium triisopropoxide ($\text{VO}(\text{C}_3\text{H}_7\text{O})_3$) (available from Alfa at 95-99% purity) was supplied in isopropanol (Fisher certified ACS 99.9% pure). The ZrO_2 support was initially supplied as a fluffy powder. It was wet with isopropanol and dried at 120°C for 16 hours to produce suitable particles for impregnation. The support particles then were calcined in air at 500°C overnight. The vanadium oxide overlayer on the ZrO_2 support was prepared in a glove box under a nitrogen environment, since the alkoxide precursor is air and moisture sensitive. A solution of a known amount of vanadium triisopropoxide oxide and isopropanol, corresponding to the incipient wetness impregnation volume and the final amount of vanadium required, were prepared in a glove box filled with nitrogen. The solution of the vanadium precursor and isopropanol was then thoroughly mixed with the zirconia support and dried at room temperature in the glove box for 16 hr. The impregnated samples then were heated for one hour at 120°C in flowing nitrogen and another hour at 300°C . The catalyst particles then were calcined in flowing air also at 300°C for one hour and at 450°C for two hours.

Other supported catalysts were made using substantially the same procedure, but substituting ceria (from Engelhard with a surface area of $\sim 36 \text{ m}^2/\text{g}$), niobia (from Niobium Products Company with a surface area of $\sim 55 \text{ m}^2/\text{g}$), alumina (from Harshaw with a surface area of $\sim 180 \text{ m}^2/\text{g}$) and silica (from Cabot with a surface

area of $\sim 300 \text{ m}^2/\text{g}$). To ready a silica powder for making a catalyst, it may be advantageous to mix the powdered silica with water until it becomes a gel. The gel is dried at 120°C for 16 hours and then ground into particles. If necessary, the catalyst can then be pelletized, crushed and sieved to obtain catalyst particles sizes between 80 to $200 \mu\text{m}$.

EXAMPLE 2:

The Catalytic Reactor

The oxidation reactions involving these catalysts were carried out in an isothermal fixed-bed integral mode reactor operating at atmospheric pressure. The quartz reactor (0.25 inch OD) was kept in a vertical position. Catalyst (25-50 mg for the COS oxidation and 25 mg for the CS_2 oxidation) was held at the middle of the reactor tube between glass wool plugs. Each catalyst sample was always pretreated by heating at 500°C for 2 to 3 hours in flowing air, to remove adsorbed moisture on the catalyst surface prior to initiation of an experiment. The COS or CS_2 reactants were diluted in ultra high purity helium, as the carrier gas and excess oxygen was added. The reactor exit was directly connected to an on-line chromatograph (HP 5890A) equipped both with a Thermal Conductivity Detector (TCD) and a Sulfur Chemiluminescence Detector (SCD, Sievers 355). The reactants and products were sampled using a 10-port valve (Valco), equipped with two identical $100 \mu\text{l}$ sampling loops. Two identical packed columns (2.0m x 1/8 in. O.D. Silicosmooth™ tubing packed with Rt-Sulfur™ Polymer) operating in parallel were installed prior to the detectors. Data gathered by the detectors was processed with the aid of HP Chemstation V. 4.0 software.

The Catalytic Process

In a series of experiments, supported vanadia catalysts prepared in accordance with Example 1, comprising about 1% to 20% vanadia (V_2O_5) on the variety of supports, were contacted, in the presence of a large stoichiometric excess of oxygen, with a helium stream containing either COS or CS_2 at a total pressure of

one atmosphere absolute and over a wide temperature range in order to explore the nature of the catalyzed oxidation reactions. The total gas flow was maintained at 130 sccm and 100 sccm for COS and CS₂ oxidation, respectively. COS oxidation was conducted over the temperature range of 290° to 330 °C at a COS partial pressure of 400 ppm, while the CS₂ oxidation was conducted over the temperature range of 230° to 270 °C at a CS₂ partial pressure of 700 ppm. The oxygen partial pressure was 5 and 10% respectively for the COS and CS₂ oxidation. Under these conditions, COS conversions varied between 1.7 and 51.7%, while CS₂ conversion varied between 0.1 and 98%.

The catalytic process of this invention provided a selectivity to CO in the oxidation of COS over the entire temperature range tested of greater than about 80% using the following catalysts: 20% vanadia on alumina, 7% vanadia on niobia catalyst, 1-5% vanadia on silica, 4% vanadia on zirconia and 3% vanadia on ceria. Using the same supported catalysts, the catalytic process of this invention provided a selectivity to CO in the oxidation of CS₂ over the entire temperature range tested of over about 50% using the following catalysts: 20% vanadia on alumina, 7% vanadia on niobia catalyst, 1% vanadia on silica and 4% vanadia on zirconia.

It will be understood that while the invention has been described in conjunction with specific embodiments thereof, the foregoing description and examples are intended to illustrate, but not limit the scope of the invention. Other aspects, advantages and modifications will be apparent to those skilled in the art to which the invention pertains, and these aspects and modifications are within the scope of the invention, which is limited only by the appended claims. Reasonable variation and modification are possible within the scope of the foregoing description and the appended claims to the invention the essence of which is that there has been set forth a process for the conversion of a COS and/or CS₂ in high yield and high selectivity to CO and SO₂.

CLAIMS

I claim:

1. A process for the conversion of at least one of COS and CS₂ to CO and SO₂ comprising contacting, in the presence of oxygen, said at least one of COS and CS₂ with a supported vanadia catalyst, said support selected from the group consisting of antimony oxides, tantalum, tin oxide, lanthana, indium oxides, iron oxides, nickel oxide, cobalt oxide, gallium oxides, manganese oxides, chromia, tungsten oxide, hafnia, zirconia, ceria, niobia, silica and alumina.

2. A process according to claim 1 wherein said support is selected from the group consisting of zirconia (ZrO₂), ceria (CeO₂), niobia (Nb₂O₅), and alumina (Al₂O₃).

3. A process according to claim 1 wherein said support is silica (SiO₂).

4. A process according to claim 2 wherein said supported vanadia catalyst has a surface vanadia loading of 0.5 to 35 wt.% sufficient to provide from no less than about 50% of a monolayer amount up to a monolayer on the metal oxide support surface.

5. A process according to claim 3 wherein said supported vanadia catalyst has a surface vanadia loading of 0.1 to 5 wt.%.

6. A process according to claim 4 wherein said support is niobia (Nb₂O₅).

7. A process according to claim 4 wherein the support is alumina (Al₂O₃).

8. A process according to claim 4 wherein the support is zirconia (ZrO₂).

9. A process of reducing carbon monoxide with hydrogen sulfide to produce hydrogen, the method comprising:

(a) contacting carbon monoxide with hydrogen sulfide to form hydrogen and carbonyl sulfide,

(b) contacting the carbonyl sulfide produced in (a) with oxygen in the presence of a supported vanadia catalyst, said support selected from the group consisting of antimony oxides, tantalum, tin oxide, lanthana, indium oxides, iron oxides, nickel oxide, cobalt oxide, gallium oxides, manganese oxides, chromia, tungsten oxide, hafnia, zirconia, ceria, niobia, silica and alumina, to form carbon monoxide and sulfur dioxide.

10. A process according to claim 9 wherein said support is selected from the group consisting of zirconia (ZrO_2), ceria (CeO_2), niobia (Nb_2O_5), and alumina (Al_2O_3).

11. A process according to claim 9 wherein said support is silica (SiO_2).

12. A process according to claim 10 wherein said supported vanadia catalyst has a surface vanadia loading of 0.5 to 35 wt.% sufficient to provide from no less than about 50% of a monolayer amount up to a monolayer on the metal oxide support surface.

13. A process according to claim 11 wherein said supported vanadia catalyst has a surface vanadia loading of 0.1 to 5 wt.%.

14. A process according to claim 12 wherein said support is niobia (Nb_2O_5).

15. A process according to claim 12 wherein the support is alumina (Al_2O_3).

16. A process according to claim 12 wherein the support is zirconia (ZrO_2).

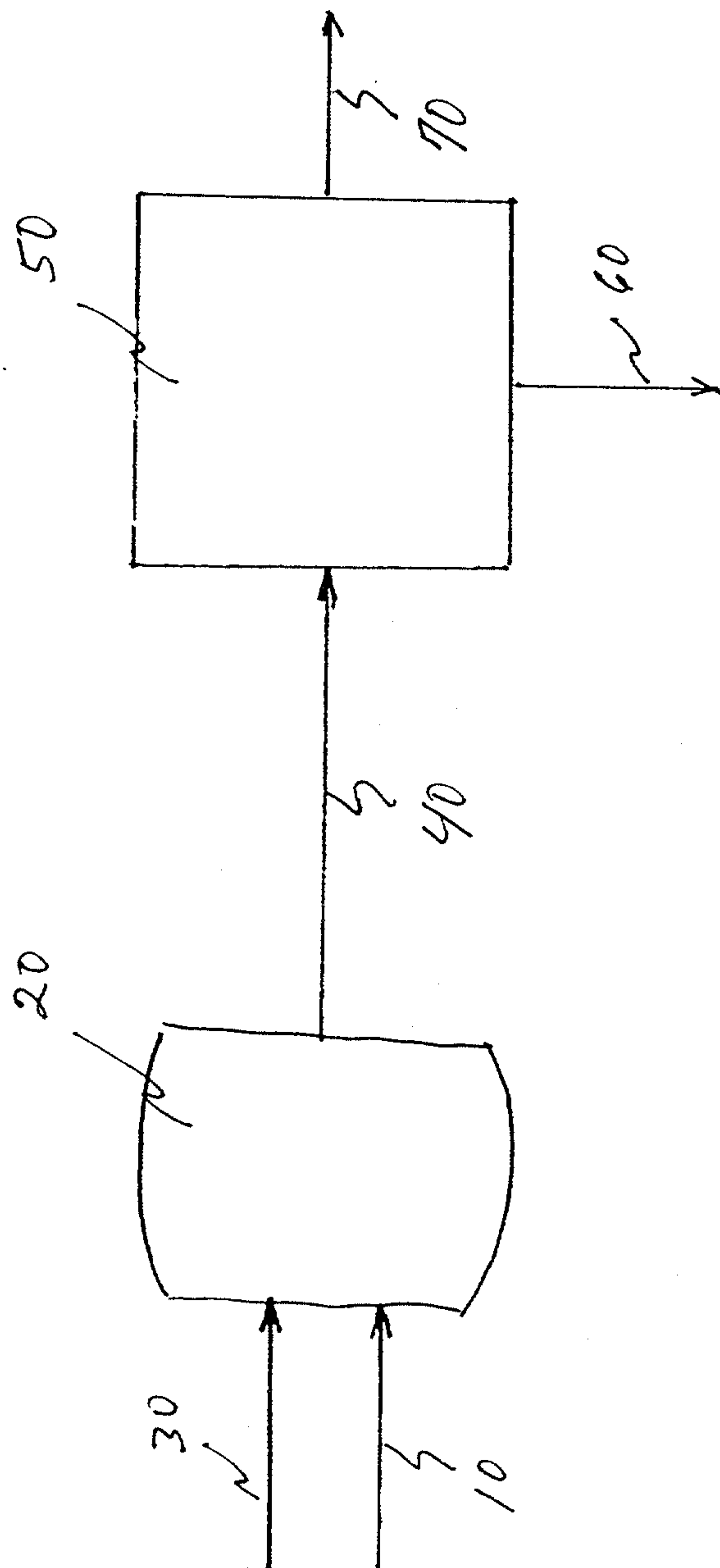


Fig. 1

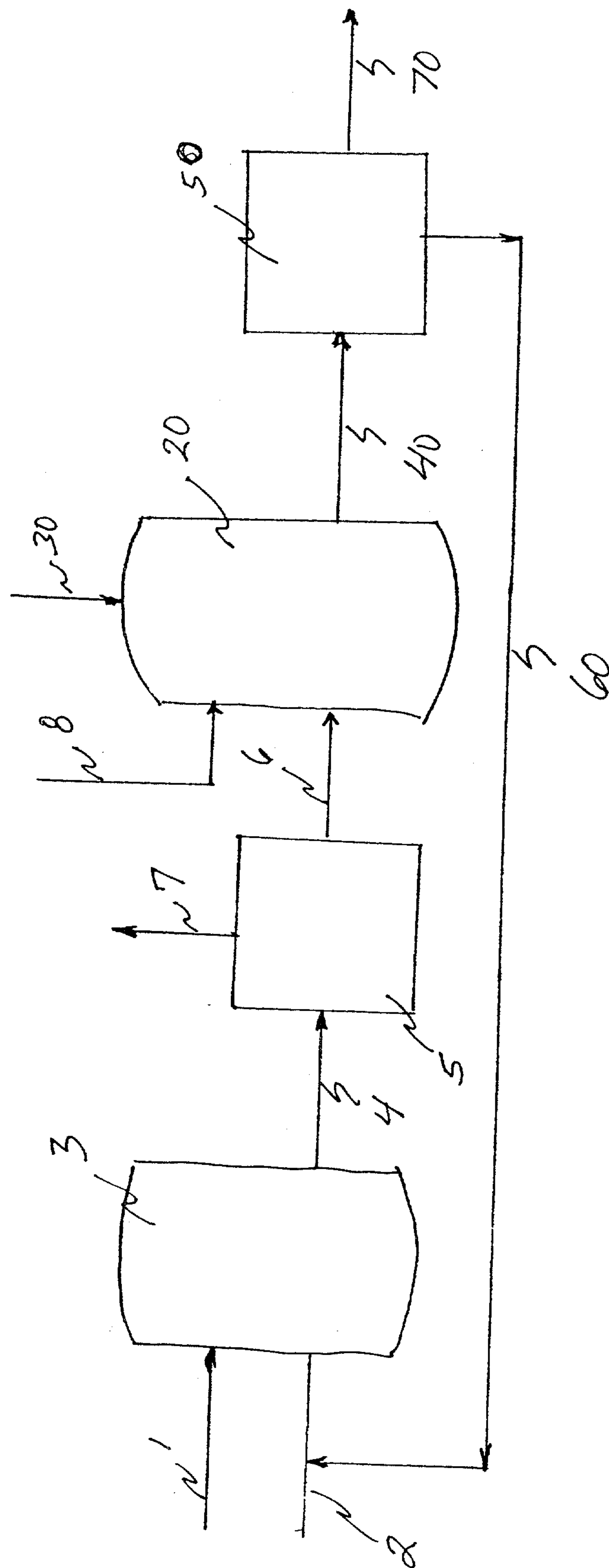


Fig. 2

