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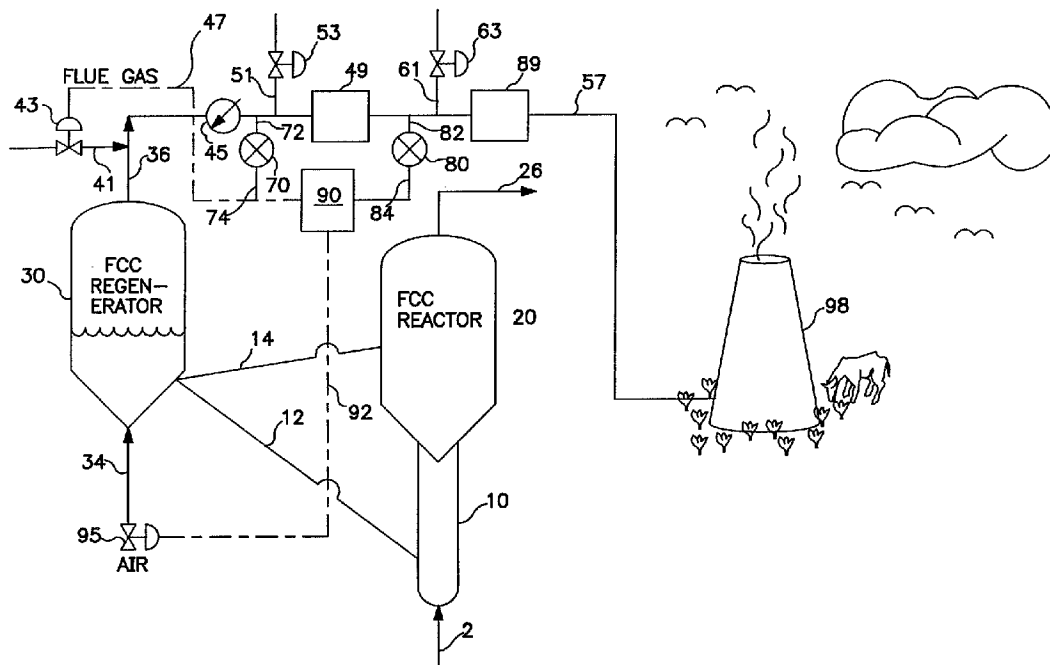
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(54) **REGENERATEUR A CRAQUAGE CATALYTIQUE FLUIDE PAR
COMBUSTION PARTIELLE DE CO ET ADJONCTION D'AIR
EN AVAL**

(54) **FCC REGENERATOR IN PARTIAL CO BURN WITH
DOWNSTREAM AIR ADDITION**



(57) On réduit des émissions d'oxyde d'azote (NO_x) provenant d'un régénérateur à craquage catalytique fluide (30) en le faisant fonctionner en mode de combustion partielle de CO pour produire des gaz brûlés contenant plus de CO que d' O_2 , ainsi que des précurseurs de NO_x . On enrichit alors ces gaz brûlés

(57) Oxides of nitrogen (NO_x) emissions from an FCC regenerator (30) are reduced by operating the regenerator (30) in partial CO burn mode to produce flue gas with more CO than O_2 and with NO_x precursors. This flue gas is then enriched with controlled amounts of oxygen and charged over catalyst, preferably Group VIII noble metal





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avec des quantités dosées d'oxygène et on les envoie sur un catalyseur, de préférence un métal noble du groupe VIII disposé sur un support, pour obtenir la conversion de l'essentiel de ces précurseurs de NO_x en azote. On peut alors envoyer ces gaz brûlés vers un brûleur (89) de CO. On peut éliminer plus de 90 % des émissions de NO_x en faisant fonctionner le régénérateur à craquage catalytique fluide (30) en mode de combustion partielle de CO, puis en ajoutant de l'air et en procédant à la conversion catalytique de précurseurs de NO_x dans des conditions sous-stoechiométriques. On peut aussi obtenir la conversion des NO_x s'il s'en forme dans ce régénérateur (30).

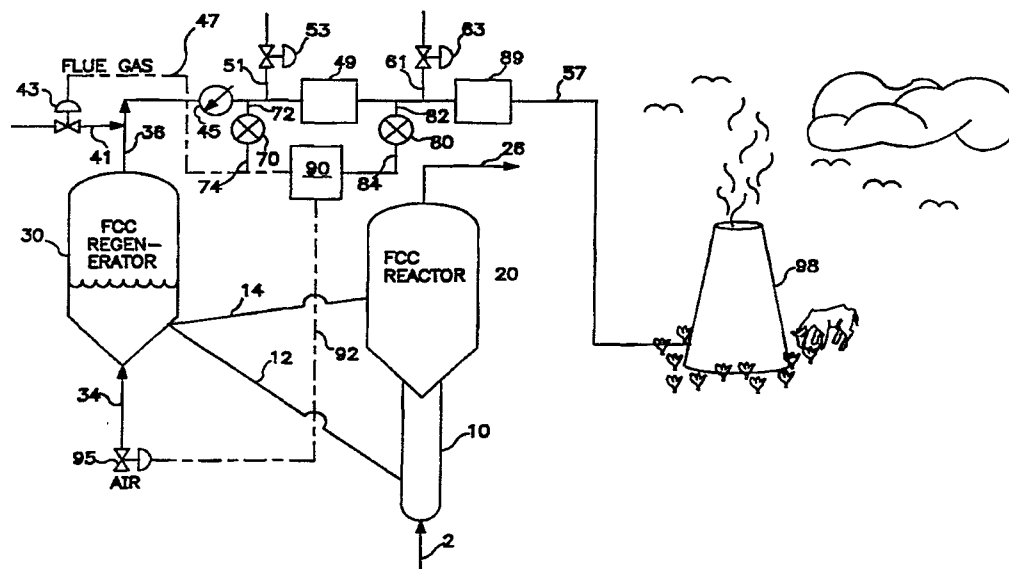
on a support, to convert most NO_x precursors to nitrogen. Flue gas may then be charged to a CO boiler (89). Eliminating more than 90 % of NO_x emissions is possible by operating the FCC regenerator (30) in partial CO burn mode, then adding air and catalytically converting NO_x precursors at substoichiometric conditions. Conversion of NO_x if formed in the regenerator (30) may be achieved as well.



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(21) International Application Number: PCT/US96/12907 (22) International Filing Date: 9 August 1996 (09.08.96) (30) Priority Data: 08/521,177 30 August 1995 (30.08.95) US (71) Applicant: MOBIL OIL CORPORATION [US/US]; 3225 Gallows Road, Fairfax, VA 22037 (US). (72) Inventors: HARANDI, Mohsen, Nadimi; 210 Whitehall Court, Voorhees, NJ 08043 (US). SCHIPPER, Paul, Herbert; 3155 Antler Drive, Doylestown, PA 18901 (US). SHIHABI, David, Said; Harbourn Woodsville Road, R.R. 1, Box 334A, Pennington, NJ 08534 (US). STEVENSON, Scott, Andrew; 24 Newburyport Road, Langhorne, PA 19053 (US). (74) Agents: KEEN, Malcom, D. et al.; Mobil Oil Corporation, 3225 Gallows Road, Fairfax, VA 22037 (US).		(81) Designated States: AU, CA, JP, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>

(54) Title: FCC REGENERATOR IN PARTIAL CO BURN WITH DOWNSTREAM AIR ADDITION**(57) Abstract**

Oxides of nitrogen (NO_x) emissions from an FCC regenerator (30) are reduced by operating the regenerator (30) in partial CO burn mode to produce flue gas with more CO than O_2 and with NO_x precursors. This flue gas is then enriched with controlled amounts of oxygen and charged over catalyst, preferably Group VIII noble metal on a support, to convert most NO_x precursors to nitrogen. Flue gas may then be charged to a CO boiler (89). Eliminating more than 90 % of NO_x emissions is possible by operating the FCC regenerator (30) in partial CO burn mode, then adding air and catalytically converting NO_x precursors at substoichiometric conditions. Conversion of NO_x if formed in the regenerator (30) may be achieved as well.

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FCC REGENERATOR IN PARTIAL CO BURN
WITH DOWNSTREAM AIR ADDITION

The invention relates to regeneration of spent catalyst from an FCC unit.

NO_x, or oxides of nitrogen, in flue gas streams from FCC regenerators is a pervasive problem. FCC units process heavy feeds containing nitrogen compounds, and some of this material is eventually converted into NO_x emissions, either in the FCC regenerator (if operated in full CO burn mode) or in a downstream CO boiler (if operated in partial CO burn mode). Thus all FCC units processing nitrogen containing feeds can have a NO_x emissions problem due to catalyst regeneration, but the type of regeneration employed (full or partial CO burn mode) determines whether NO_x emissions appear sooner (regenerator flue gas) or later (CO boiler).

Although there may be some nitrogen fixation, or conversion of nitrogen in regenerator air to NO_x, most NO_x emissions are believed to come from oxidation of nitrogen compounds in the feed.

Several powerful ways have been developed to deal with the problem. The approaches fall into roughly five categories:

1. Feed hydrotreating, to keep NO_x precursors from the FCC unit.

2. Segregated cracking of fresh feed.

3. Process and hardware approaches which reduce the NO_x formation in a regenerator in complete CO burn mode, via regenerator modifications.

4. Catalytic approaches, using a catalyst or additive which is compatible with the FCC reactor, which suppress NO_x formation or catalyze its reduction in a regenerator in complete CO burn mode.

5. Stack gas cleanup methods which are isolated from the FCC process.

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The FCC process will be briefly reviewed, followed by a review of the state of the art in reducing NO_x emissions.

FCC PROCESS

Catalytic cracking of hydrocarbons is carried out in the absence of externally added H₂ in contrast to hydrocracking, in which H₂ is added during the cracking step. An inventory of particulate catalyst continuously cycles between a cracking reactor and a catalyst regenerator. In FCC, hydrocarbon feed contacts catalyst in a reactor at 425C-600C, usually 460C-560C. The hydrocarbons crack, and deposit carbonaceous hydrocarbons or coke on the catalyst. The cracked products are separated from the coked catalyst. The coked catalyst is stripped of volatiles, usually with steam, and is then regenerated. In the catalyst regenerator, the coke is burned from the catalyst with oxygen-containing gas, usually air. Coke burns off, restoring catalyst activity and heating the catalyst to, e.g., 500C-900C, usually 600C-750C. Flue gas formed by burning coke in the regenerator may be treated to remove particulates and convert carbon monoxide, after which the flue gas is normally discharged into the atmosphere.

Most FCC units now use zeolite-containing catalyst having high activity and selectivity. These catalysts are believed to work best when coke on catalyst after regeneration is relatively low.

Two types of FCC regenerators are commonly used, the high efficiency regenerator and the bubbling bed type.

The high efficiency regenerator mixes recycled regenerated catalyst with spent catalyst, burns much of the coke in a fast fluidized bed coke combustor, then discharges catalyst and flue gas up a dilute phase transport riser where additional coke combustion may occur and CO is afterburned to CO₂. These regenerators are designed for complete CO combustion and usually produce

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clean burned catalyst and flue gas with little CO and modest amounts of NO_x.

The bubbling bed regenerator maintains the catalyst as a bubbling fluidized bed, to which spent catalyst is added and from which regenerated catalyst is removed. These usually have more catalyst inventory in the regenerator because gas/catalyst contact is not as efficient in a bubbling bed as in a fast fluidized bed.

Many bubbling bed regenerators operate in complete CO combustion mode, i.e., the mole ratio of CO₂/CO is at least 10. Many refiners burn CO completely in the catalyst regenerator to conserve heat and to minimize air pollution.

Many refiners add a CO combustion promoter metal to the catalyst or to the regenerator. U.S. Patent No. 2,647,860 proposed adding 0.1 to 1 weight percent chromic oxide to a cracking catalyst to promote combustion of CO. U.S. Patent No. 3,808,121, taught using relatively large-sized particles containing CO combustion-promoting metal into a regenerator. The small-sized catalyst cycled between the cracking reactor and the catalyst regenerator while the combustion-promoting particles remain in the regenerator.

U.S. 4,072,600 and 4,093,535 taught use of Pt, Pd, Ir, Rh, Os, Ru and Re in cracking catalysts in concentrations of 0.01 to 50 ppm, based on total catalyst inventory. Most FCC units now use Pt CO combustion promoter. This reduces CO emissions, but usually increases nitrogen oxides (NO_x) in the regenerator flue gas.

It is difficult in a catalyst regenerator to burn completely coke and CO in the regenerator without increasing the NO_x content of the regenerator flue gas. Many jurisdictions restrict the amount of NO_x that can be in a flue gas stream discharged to the atmosphere. In response to environmental concerns, much effort has been spent on finding ways to reduce NO_x emissions.

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The NO_x problem is acute in bubbling dense bed regenerators, perhaps due to localized high oxygen concentrations in the large bubbles of regeneration air. Even high efficiency regenerators, with better catalyst/gas contacting, produce significant amounts of NO_x, though usually about 50 - 75 % of the NO_x produced in a bubbling dense bed regenerator cracking a similar feed.

Much of the discussion that follows is generic to any type of regenerator while some is specific to bubbling dense bed regenerators, which have the most severe NO_x problems.

FEED HYDROTREATING

Some refiners hydrotreat feed. This is usually done to meet sulfur specifications in products or a SO_x limit in regenerator flue gas, rather than a NO_x limitation. Hydrotreating removes some nitrogen compounds in FCC feed, and this reduces NO_x emissions from the regenerator.

SEGREGATED FEED CRACKING

US 4,985,133, Sapre et al, incorporated by reference, taught reducing NO_x emissions, and improving performance in the cracking reactor, by keeping high and low nitrogen feeds segregated, and adding them to different elevations in the FCC riser.

PROCESS AND HARDWARE APPROACHES TO NO_x CONTROL

Process modifications are suggested in U.S. 4,413,573 and U.S. 4,325,833, to two-and three-stage FCC regenerators, which reduce NO_x emissions.

U.S. 4,313,848 taught countercurrent regeneration of spent FCC catalyst, without backmixing, minimized NO_x emissions.

U.S. 4,309,309 taught adding fuel vapor to the upper portion of an FCC regenerator to minimize NO_x. Oxides of nitrogen formed in the lower portion of the regenerator

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were reduced by burning fuel in upper portion of the regenerator.

U.S. 4,542,114 taught minimizing the volume of flue gas by using oxygen rather than air in the FCC regenerator. This reduced the amount of flue gas produced.

In Green et al, U.S. 4,828,680, incorporated by reference, NO_x emissions from an FCC unit were reduced by adding sponge coke or coal to the circulating inventory of cracking catalyst. The coke absorbed metals in the feed and reduced NO_x emissions. Many refiners are reluctant to add coal or coke to their FCC units, as such materials burn and increase heat release in the regenerator.

DENO_x WITH COKE

US 4,991,521 Green and Yan used coke on spent FCC catalyst to reduce NO_x emissions from a two stage FCC regenerator. Flue gas from a second stage of regeneration contacted coked catalyst in a first stage. Although reducing NO_x emissions this approach is not readily adaptable to existing units.

DENO_x WITH REDUCING ATMOSPHERES

Another approach to reducing NO_x emissions is to create a reducing atmosphere in part of the regenerator by segregating the CO combustion promoter. US 4,812,430 and 4,812,431 used as CO combustion promoter Pt on a support which "floated" or segregated in the regenerator. Large, hollow, floating spheres gave a sharp segregation of CO combustion promoter in the regenerator and this helped reduce NO_x emissions.

CATALYTIC APPROACHES TO NO_x CONTROL

The work that follows is generally directed at catalysts which burn CO but do not promote formation of NO_x.

U.S. 4,300,997 and U.S. 4,350,615, use Pd-Ru CO-

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combustion promoter. The bi-metallic CO combustion promoter is reported to do an adequate job of converting CO while minimizing NO_x formation.

5 U.S. 4,199,435 suggests steaming conventional metallic CO combustion promoter to decrease NO_x formation without impairing too much the CO combustion activity of the promoter.

10 U.S. 4,235,704 suggests that for an FCC regenerator operating in complete CO combustion mode too much CO combustion promoter causes NO_x formation, and calls for monitoring the NO_x content of the flue gases, and adjusting the concentration of CO combustion promoter in the regenerator based on the amount of NO_x in the flue gas. As an alternative to adding less Pt the patentee suggests
15 deactivating it in place by adding lead, antimony, arsenic, tin or bismuth.

20 US 5,002,654, Chin, incorporated by reference, taught a zinc based additive for reducing NO_x. Relatively small amounts of zinc oxides impregnated on a separate support with little cracking activity produced an additive circulated with the FCC E-cat and reduced NO_x emissions.

US 4,988,432 Chin, incorporated by reference, taught an antimony based additive for reducing NO_x.

25 Many refiners are reluctant to add metals to their catalyst out of environmental concerns. Zinc may vaporize under conditions experienced in some FCC units. Antimony addition may make disposal of spent catalyst more difficult.

30 Such additives add to the cost of the FCC process, may dilute the E-cat and may not be as effective as desired.

In addition to these catalytic approaches, there are hybrid approaches involving catalyst and process modifications.

35 US 5,021,144, Altrichter, taught operating the regenerator in partial CO burn mode with excess Pt. Adding excess Pt reduced NO_x in the CO boiler stack gas. This is

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similar to a refiner operating in partial CO burn mode with excess Pt to ensure stable operation.

US 5,268,089, Avidan et. al, incorporated by reference, taught reducing NO_x emissions by running the FCC regenerator between full and partial CO burn mode with combustion of CO containing flue gas in a downstream CO boiler. Although a CO boiler was preferred the patent mentioned use of Pt gauze, or honeycombs coated with Pt or similar CO combustion promoter to reduce CO emissions. Avidan found this "uncomfortable" mode of regenerator operation made it possible to burn many of the NO_x precursors to N₂ in the generally reducing atmosphere of the FCC regenerator. The flue gas from the CO boiler had less NO_x than if the regenerator were run in full CO burn mode or partial CO burn mode with a CO boiler.

The '089 approach provides a good way to reduce NO_x emissions, but some refiners want even greater reductions, or may be reluctant to operate their FCC regenerator in such an "uncomfortable" region which is difficult to control. Some may simply want the ability to operate their FCC regenerators solidly in the partial CO burn region, which makes the FCC unit as a whole much more flexible.

Considerable effort has also been spent on downstream treatment of FCC flue gas. This area will be reviewed next.

STACK GAS TREATMENT

First it should be mentioned that FCC regenerators present special problems. FCC regenerator flue gas will usually have large amounts, from 4 to 12 mole %, of steam, and significant amounts of sulfur compounds. The FCC environment changes constantly, and relative amounts of CO/O₂ can and do change rapidly.

The FCC unit may at times make reduced nitrogen species such as ammonia, and may make oxidized nitrogen species such as NO_x. In some units, especially bubbling

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dense bed regenerators, both oxidized and reduced nitrogen contaminant compounds are present at the same time. It is as if some portions of the regenerator had a highly oxidizing atmosphere, and other had a reducing atmosphere. Many bubbling bed regenerators are believed to have reducing atmospheres, e.g., where feed is added, and oxidizing atmospheres, for catalyst particles near bubbles of regeneration air. Even if air distribution is perfectly synchronized with spent catalyst addition at the start-up of a unit, something will usually change during the course of normal operation which upset the balance of the unit. Typical upsets include changes in feed rate and composition, air distribution nozzles in the regenerator which break off, and slide valves and equipment that erode over the course of the 1 - 3 year run length of the FCC unit operation.

Any process used for FCC regenerator flue gas must be able to deal with the poisons and contaminants, such as sulfur compounds, which are inherent in FCC operation. The process must be robust and tolerate great changes in flue gas composition. Ideally, the process should be able to oxidize reduced nitrogen species and also have the capability to reduce oxidized nitrogen species which may be present.

Stack gas treatments have been developed which reduce NO_x in flue gas by reaction with NH_3 . NH_3 is a selective reducing agent which does not react rapidly with the excess oxygen which may be present in the flue gas. Two types of NH_3 process have evolved, thermal and catalytic.

Thermal processes, e.g. the Exxon Thermal DeNO_x process, operate as homogeneous gas-phase processes at 1550-1900 F. More details are disclosed by Lyon, R. K., Int. J. Chem. Kinet., 3, 315, 1976, incorporated by reference.

Catalytic systems have been developed which operate at lower temperatures, typically at 300-850 F.

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U.S. 4,521,389 and 4,434,147 disclose adding NH_3 to flue gas to reduce catalytically the NO_x to nitrogen.

US 5,015,362, Chin, incorporated by reference, taught contacting flue gas with sponge coke or coal and a catalyst promoting reduction of NO_x around such carbonaceous substances.

None of the approaches described is the perfect solution.

Feed pretreatment is expensive, and usually only justified for sulfur removal. Segregated feed cracking helps but requires segregated high and low nitrogen feeds.

Multi-stage or countercurrent regenerators, reduce NO_x but require extensive rebuilding of the FCC regenerator.

Various catalytic approaches, e.g., adding lead or antimony, to degrade the efficiency of the Pt function may help some but fail to meet the ever more stringent NO_x emissions limits set by local governing bodies. Stack gas cleanup is powerful, but the capital and operating costs are high.

The approach disclosed in US 5,268,089 gave a good way to reduce NO_x emissions with little additional cost, but a refiner did not have as much flexibility in operating the FCC unit and this approach did not always reduce NO_x to the extent desired. Of particular concern to many refiners was the difficulty of maintaining the regenerator "on the brink" - an uncomfortable operation of the FCC regenerator. While the NO_x reductions were substantial, the unit was much harder to control because classical control methods no longer worked, adding more air might cool the regenerator (by dilution) or heat it up (if the regenerator was somewhat in partial combustion mode).

We wanted a better way to reduce NO_x emissions associated with FCC regenerators. We liked the approach disclosed in '089, but wanted more NO_x reduction and wanted to give refiners more flexibility in operating their units. We also wanted to shift at least some heat generation out

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of the FCC regenerator to a downstream CO boiler or the like, so that heavier feeds could be cracked in the FCC unit.

We discovered a way to operate the FCC regenerator solidly in partial CO burn mode, producing flue gas with at least 1 mole % CO, and preferably with 2 mole % CO, plus or minus 1 mole % CO, and large amounts of NO_x precursors. It is also possible to operate with even smaller amounts of CO, such as 0.5 to 1.0 mole % CO, but this is only possible when there is very little, or essentially no oxygen.

We selectively convert the NO_x precursors with oxygen. The oxygen source can be excess oxygen in the flue gas, added air, added oxygen and/or any oxygen containing oxidation agent. We discharge to the atmosphere a flue gas, after complete CO combustion, having less than half as much NO_x as a prior art process simply using a CO boiler. By careful control of process conditions, we were able to convert more than 75 % of the NO_x precursors to nitrogen, with conversions of 90 % or more possible with very careful control or by using multiple stage flue gas conversion downstream of the FCC regenerator.

BRIEF SUMMARY OF THE INVENTION

Accordingly the present invention provides a process for cracking a nitrogen containing hydrocarbon feed comprising cracking said feed in a cracking reactor with a source of regenerated, equilibrium cracking catalyst to produce catalytically cracked products which are removed as a product and spent catalyst containing nitrogen containing coke; regenerating spent catalyst in a regenerator by contact with a controlled amount of air or an oxygen-containing gas at regeneration conditions to produce regenerated catalyst which is recycled to said cracking reactor and regenerator flue gas; removing a regenerator flue gas stream comprising less than 1 mole % oxygen, at least 0.5 mole % carbon monoxide, volatilized NO_x

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precursors, and wherein the molar ratio of carbon monoxide to oxygen is at least 1:1; adding additional oxygen or oxygen containing gas to said regenerator flue gas stream to produce oxygen enriched flue gas; catalytically
5 converting in a catalytic NO_x precursor conversion means containing a NO_x precursor conversion catalyst volatilized NO_x precursors in said oxygen enriched flue gas and reducing at least 50 mole % of said NO_x precursors to nitrogen.

10 In another embodiment, the present invention provides a fluidized catalytic cracking process for cracking a nitrogen containing hydrocarbon feed comprising cracking said feed in a fluidized catalytic cracking (FCC) reactor with a source of regenerated, equilibrium cracking catalyst
15 to produce catalytically cracked products which are removed as a product and spent catalyst containing nitrogen containing coke; regenerating said spent catalyst in a bubbling fluidized bed catalyst regenerator by contact with a controlled amount of air or an oxygen-containing
20 regeneration gas at regeneration conditions to produce regenerated catalyst which is recycled to said cracking reactor and regenerator flue gas; removing from said regenerator a regenerator flue gas stream comprising less than 2 mole % oxygen, at least 1 mole % carbon monoxide,
25 and volatilized NO_x precursors selected from the group of HCN and NH₃, and mixtures; and NO_x; adding additional oxygen or oxygen containing gas to said regenerator flue gas stream to produce oxygen enriched flue gas but limiting said oxygen addition so that the resulting enriched flue
30 gas has at least a 2:1 carbon monoxide:oxygen mole ratio; catalytically converting in a catalytic NO_x precursor conversion means containing a Group VIII noble metal on a support catalyst at least 50 mole % of said volatilized NO_x precursors to nitrogen to produce flue gas with a reduced
35 NO_x precursor content and carbon monoxide; and adding oxygen or oxygen containing gas to said flue gas with a

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reduced NO_x precursor content to form an oxidizing atmosphere and catalytically converting in a downstream stage of said catalytic NO_x precursor at least a portion of said NO_x precursors to nitrogen and oxides of nitrogen and oxidizing at least a majority of carbon monoxide present to carbon dioxide.

In another embodiment, the present invention provides a fluidized catalytic cracking process for cracking a nitrogen containing hydrocarbon feed comprising cracking said feed in a fluidized catalytic cracking (FCC) reactor with a source of regenerated, equilibrium cracking catalyst to produce catalytically cracked products which are removed as a product and spent catalyst containing nitrogen containing coke; regenerating said spent catalyst in a bubbling fluidized bed catalyst regenerator by contact with a controlled amount of air or an oxygen-containing regeneration gas at regeneration conditions including localized oxidizing and localized reducing zone to produce regenerated catalyst which is recycled to said cracking reactor and regenerator flue gas; removing from said regenerator a regenerator flue gas stream comprising less than 1 mole % oxygen, at least 1 mole % carbon monoxide, volatilized NO_x precursors and NO_x; adding additional oxygen or oxygen containing gas to said regenerator flue gas stream to produce oxygen enriched flue gas but limiting said oxygen addition so that the resulting enriched flue gas has at least a 2:1 carbon monoxide:oxygen mole ratio; and catalytically converting said enriched flue gas in a reactor containing a Group VIII noble metal on a support at least 50 mole % of said volatilized NO_x precursors to nitrogen and converting at least 25 % of said NO_x to nitrogen to produce treated flue gas with a reduced NO_x precursor content and a reduced NO_x content.

In an embodiment which involves use of non-catalytic CO conversion downstream of the FCC regenerator, the present invention provides a fluidized catalytic cracking

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process for cracking a nitrogen containing hydrocarbon feed comprising cracking said feed in a fluidized catalytic cracking (FCC) reactor with a source of regenerated, equilibrium cracking catalyst to produce catalytically cracked products which are removed as a product and spent catalyst containing nitrogen containing coke; regenerating said spent catalyst in a bubbling fluidized bed catalyst regenerator by contact with a controlled amount of air or an oxygen-containing regeneration gas at regeneration conditions including localized oxidizing and localized reducing zone to produce regenerated catalyst which is recycled to said cracking reactor and regenerator flue gas; removing from said regenerator a regenerator flue gas stream comprising less than 1 mole % oxygen, at least 1 mole % carbon monoxide, volatilized NO_x precursors and NO_x ; adding additional oxygen or oxygen containing gas to said regenerator flue gas stream to produce oxygen enriched flue gas but limiting said oxygen addition so that the resulting enriched flue gas has at least a 2:1 carbon monoxide:oxygen mole ratio; and catalytically converting said enriched flue gas in a reactor containing a Group VIII noble metal on a support at least 50 mole % of said volatilized NO_x precursors to nitrogen and converting at least 25 % of said NO_x to nitrogen to produce treated flue gas with a reduced NO_x precursor content and a reduced NO_x content and containing CO; and adding air or oxygen containing gas to said treated flue gas and thermally converting, in a thermal CO conversion means operating at thermal CO oxidation conditions, said treated flue gas to produce a low CO and low NO_x stack gas.

Other embodiments relate to preferred catalysts, such as a rhodium based catalyst.

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BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 shows a simplified process flow diagram of an FCC unit with a flue gas NO_x precursor converter and a CO boiler.

5 Figure 2 is a graphical presentation of actual tests of catalytic conversion of a gas stream containing CO, NH₃ and varying amounts of oxygen.

DETAILED DESCRIPTION

10 The present invention is ideal for use with a catalytic cracking process. This process is reviewed with a review of the Figure, which is conventional up to flue gas line 36.

15 A heavy, nitrogen containing feed is charged via line 2 to riser reactor 10. Hot regenerated catalyst removed from the regenerator via line 12 vaporizes fresh feed in the base of the riser reactor, and cracks the feed. Cracked products and spent catalyst are discharged into vessel 20, and separated. Spent catalyst is stripped in a stripping means not shown in the base of vessel 20, then
20 stripped catalyst is charged via line 14 to regenerator 30. Cracked products are removed from vessel 20 via line 26 and charged to an FCC main column, not shown.

25 Spent catalyst is maintained as a bubbling, dense phase fluidized bed in vessel 30. Regeneration gas, almost always air, sometimes enriched with oxygen, is added via line 34 to the base of the regenerator. Air flow is controlled by flow control valve 95. Regenerated catalyst is removed via line 12 and recycled to the base of the riser reactor. Flue gas is removed from the regenerator
30 via line 36.

35 Much of the process and equipment recited above are those used in conventional FCC regenerators. Many FCC regenerators use such bubbling bed regenerators, which have more severe NO_x emissions characteristics than high efficiency regenerators. Both types (bubbling fluid bed

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and fast fluid bed or high efficiency) will benefit from the practice of the present invention, which will now be reviewed.

5 Flue gas containing CO, HCN, NH₃ and the like is removed from the FCC regenerator via line 36, and may be cooled in optional cooling means 45, and charged with added air or oxygen to NO_x precursor catalytic conversion zone 49 and then preferably charged to CO conversion means 89, typically a pre-existing CO boiler or a newly added
10 catalytic converter. This permits substoichiometric combustion of the majority of the NO_x precursors in the catalytic converter 49, and conversion of CO in the downstream CO converter. This is preferred for maximum conversion, but is not essential, and the downstream CO
15 converter may be eliminated if desired. The resulting low NO_x and low CO flue gas is discharged via line 57 and stack 98.

Cooling of the FCC regenerator flue gas discharged via line 36 by means not shown is preferred, but not essential.

20 Air, or oxygen, or oxygen enriched air or oxygen enriched inert gas addition to this flue gas line is essential, but may occur immediately downstream of the regenerator via line 41, after optional cooling and/or just upstream of or even within the NO_x precursor conversion
25 means 49. Air is preferably added via line 51 and flow control valve 53. Additional air may be added upstream of the CO conversion stage 89, if used, with air or oxygen containing gas being charged via line 61 and control valve 63.

30 Much conventional equipment, third stage separators to remove traces of particulates, power recovery turbines, and waste heat boilers, are omitted. There will frequently be some waste heat recovery means, not shown, downstream of the CO conversion means, and frequently there will be a
35 power recovery turbine as well. These are preferred, but conventional.

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CONTROL METHODS

The aims disclosed in US 5,268,089 may be used herein, though the targets are somewhat different. In '089 an "on the brink" FCC regenerator operation was sought. We prefer to operate with more CO present in flue gas from the FCC regenerator.

Many ways are available to the refinery engineer to control the process. All control methods should provide for a way to have very precise control of CO/O₂ ratios in the substoichiometric converter 49. At no time should there be more than 125 % of stoichiometric air in the inlet to converter 49, or to the inlet of the catalyst bed if the air inlet is integral with converter 49 rather than upstream of it as shown in the Figure.

The CO content may be unusually low - typically around 1 or 2 mole % CO, and the CO content may fluctuate rapidly. The control system must be both sensitive and fast responding.

As a way to put the difficult control task in perspective, most fired heaters in a refinery operate with 1 or 2 mole % oxygen in the flue gas from the heater, with essentially no CO present, typically less than 1000 ppm CO. Such a typical fired heater operates with several thousand % of stoichiometric air, while our process requires operation with less than 125 % of stoichiometric air, and preferably with 80 to 100 % of stoichiometric air.

In a typical FCC regenerator practicing our invention, the flue gas in line 36 will have 1 or 2 mole % CO, and usually have an order of magnitude less free oxygen. We add enough additional oxygen containing gas so that at the inlet to converter 49, the O₂ content is roughly 1/2 that of the CO content, say 0.5 % oxygen for a flue gas containing 1.0 mole % CO.

If the operator allowed oxygen content to reach 0.75 mole %, selectivity of NO_x precursor conversion would plummet from over 95 % to less than 20 %. Most of the

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benefit of our process would be lost, due to adding only 0.25 mole % oxygen. In many refineries it will take new oxygen sensors, and extensive operator training, to convince operators that the best way to burn NO_x precursors is with not enough oxygen, and to never let the process operate with oxygen levels approaching 1/10th those in conventional flue gas streams from fired heaters and the like.

In the embodiment shown in the Figure, the CO and/or NO_x content of the flue gas is preferably continuously monitored upstream and downstream of the NO_x precursor converter means 49 via flue gas analyzer controllers 70 and 80, connected via taps 72 and 82 respectively. The CO content sends a signal via signal transmission means 47 to control valve 43, which regulates addition of oxygen or oxygen containing gas via line 41 to the flue gas line upstream of (or via an oxygen line directly into, by means not shown,) NO_x precursor conversion means 49.

The NO_x precursor converter will usually not be used as a CO boiler, and if there is too much CO in flue gas line 36 the operation of the FCC regenerator should be changed to bring the flue gas composition back into the desired range. One way to accomplish this is to use a master controller means 90 receiving signals via lines 74 and 84 of conditions in the flue gas stream upstream of and downstream of converter 49. If there is too much CO coming from the regenerator, a signal may be sent via transmission means 92 to valve 95 to admit more air to the regenerator.

Our NO_x precursor conversion process tolerates very well the presence of large amounts of CO, and may be used, in part, as a CO boiler, but then some means will usually be provided for heat removal from the NO_x precursor conversion means, such as a heat exchanger, not shown. The approach is the same when larger amounts of CO are present, but the heat release and temperature riser problems must be dealt with.

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A similar control approach using flue gas analyzer controllers not shown may be used around the CO conversion means 89.

Although the present invention is useful for both moving bed and fluidized bed catalytic cracking units, the discussion that follows is directed to FCC units which are the state of the art.

FCC FEED

Any conventional FCC feed can be used. The process of the present invention is good for processing nitrogenous charge stocks, those having more than 500 ppm total nitrogen compounds, and especially useful in processing stocks containing high levels of nitrogen compounds, e.g., having more than 1000 wt ppm total nitrogen compounds.

The feeds may range from the typical, such as petroleum distillates or residual stocks, either virgin or partially refined, to the atypical, such as coal oils and shale oils. The feed frequently contains recycled hydrocarbons, light and heavy cycle oils which have already been subjected to cracking.

Preferred feeds are gas oils, vacuum gas oils, atmospheric resids, and vacuum resids. The invention is most useful with feeds having an initial boiling point above about 650 F.

FCC CATALYST

Commercially available FCC catalysts may be used. The catalyst preferably contains relatively large amounts of large pore zeolite for maximum effectiveness, but such catalysts are readily available. The process will work with amorphous catalyst, but few modern FCC units use amorphous catalyst.

Preferred catalysts contain at least 10 wt % large pore zeolite in a porous refractory matrix such as silica-alumina, clay, or the like. The zeolite content is

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preferably higher and usually will be at least 20 wt %. For best results the catalyst should contain from 30 to 60 wt % large pore zeolite.

5 All zeolite contents discussed herein refer to the zeolite content of the makeup catalyst, rather than the zeolite content of the equilibrium catalyst, or E-Cat. Much crystallinity is lost in the weeks and months that the catalyst spends in the harsh, steam filled environment of modern FCC regenerators, so the equilibrium catalyst will
10 contain a much lower zeolite content by classical analytic methods. Most refiners usually refer to the zeolite content of their makeup catalyst, and the MAT (Modified Activity Test) or FAI (Fluidized Activity Index) of their equilibrium catalyst, and this specification follows this
15 naming convention.

Conventional zeolites such as X and Y zeolites, or aluminum deficient forms of these zeolites such as dealuminized Y (DEAL Y), ultrastable Y (USY) and ultrahydrophobic Y (UHP Y) may be used as the large pore
20 cracking catalyst. The zeolites may be stabilized with Rare Earths, e.g., 0.1 to 10 wt % RE.

Relatively high silica zeolite containing catalysts are preferred. Catalysts containing 20-60% USY or rare earth USY (REUSY) are especially preferred.

25 The catalyst inventory may contain one or more additives, present as separate additive particles, or mixed in with each particle of the cracking catalyst. Additives can be added to enhance octane (medium pore size zeolites, sometimes referred to as shape selective zeolites, i.e.,
30 those having a Constraint Index of 1-12, and typified by ZSM-5, and other materials having a similar crystal structure). Other additives which may be used include CO combustion promoters and SO_x removal additives, each discussed at greater length hereafter.

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CO COMBUSTION PROMOTER

Use of a CO combustion promoter in the regenerator is not essential for the practice of the present invention, however, some may be present. These materials are well-known.

U.S. 4,072,600 and 4,235,754, incorporated by reference, teach operating an FCC regenerator with 0.01 to 100 ppm Pt. Good results are obtained with 0.1 to 10 wt. ppm platinum on the catalyst. We usually will operate with just enough CO combustion additive to control afterburning. Conventional procedures can be used to determine if enough promoter is present. In most refineries, afterburning shows up as a 30 F, 50 F or 75 F temperature increase from the catalyst bed to the cyclones above the bed, so sufficient promoter may be added so no more afterburning than this occurs. Our NO_x reduction process works well with large amounts of afterburning. Although we cannot prove it from the data available, afterburning may be necessary in some units to achieve large NO_x reductions.

SOx ADDITIVES

Additives may be used to adsorb SOx. These are believed to be various forms of alumina, rare-earth oxides, and alkaline earth oxides, containing minor amounts of Pt, on the order of 0.1 to 2 ppm Pt. Additives are available from several catalyst suppliers, such as Davison's "R" or Katalistiks International, Inc.'s "DESOX."

Our invention permits efficient use of these additives even though the regenerator is not in complete CO burn mode. When a regenerator is in complete CO burn mode, SOx capture additives recover 60 to 70 % of the SOx, while in conventional partial CO burn mode SOx capture drops to 30 % or so. In our process SOx additives can still capture more than 40 %, and preferably more than 50 % of the SOx while NO_x emissions are drastically reduced.

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The FCC catalyst composition, per se, forms no part of the present invention.

FCC REACTOR CONDITIONS

5 The reactor operation will usually be conventional all riser cracking FCC, such as disclosed in U.S. 4,421,636, incorporated by reference. Typical riser cracking reaction conditions include catalyst/oil ratios of 0.5:1 to 15:1 and preferably 3:1 to 8:1, and a catalyst contact time of 0.1- 10 50 seconds, and preferably 0.5 to 10 seconds, and most preferably about 0.75 to 5 seconds, and riser top temperatures of 900 to about 1100, preferably 950 to 1050 F.

15 It is important to have good mixing of feed with catalyst in the base of the riser reactor, using conventional techniques such as adding large amounts of atomizing steam, use of multiple nozzles, use of atomizing nozzles and similar technology. The Atomax nozzle, available from the M. W. Kellogg Co, is preferred. Details about an excellent nozzle are disclosed in US 5,289,976 and 20 5,306,418 which are incorporated by reference.

It is preferred, but not essential, to have a riser catalyst acceleration zone in the base of the riser.

25 It is preferred, but not essential, for the riser reactor to discharge into a closed cyclone system for rapid separation of cracked products from spent catalyst. A closed cyclone system is disclosed in U.S. 4,502,947 to Haddad et al, incorporated by reference.

30 It is preferred but not essential, to strip rapidly the catalyst as it exits the riser and upstream of the catalyst stripper. Stripper cyclones disclosed in U.S. 4,173,527, Schatz and Heffley, incorporated by reference, may be used.

35 It is preferred, but not essential, to use a hot catalyst stripper. Hot strippers heat spent catalyst by adding hot, regenerated catalyst to spent catalyst. A hot

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stripper is shown in U.S. 3,821,103, Owen et al, incorporated by reference. After hot stripping, a catalyst cooler may cool heated catalyst before it is sent to the regenerator. A preferred hot stripper and catalyst cooler is shown in U.S. 4,820,404, Owen, incorporated by reference.

Conventional FCC steam stripping conditions can be used, with the spent catalyst having essentially the same temperature as the riser outlet, and with 0.5 to 5 % stripping gas, preferably steam, added to strip spent catalyst.

The FCC reactor and stripper conditions, per se, can be conventional.

CATALYST REGENERATION

The process and apparatus of the present invention can be used with bubbling dense bed FCC regenerators or high efficiency regenerators. Bubbling bed regenerators will be considered first.

BUBBLING BED CATALYST REGENERATORS

In these regenerators much of the regeneration gas, usually air, passes through the bed in the form of bubbles. These pass through the bed, but contact it poorly.

These units operate with large amounts of catalyst. The bubbling bed regenerators are not very efficient at burning coke so a large catalyst inventory and long residence time in the regenerator are needed to produce clean burned catalyst.

The carbon levels on regenerated catalyst can be conventional, typically less than 0.3 wt % coke, preferably less than 0.15 wt % coke, and most preferably even less. By coke we mean not only carbon, but minor amounts of hydrogen associated with the coke, and perhaps even very minor amounts of unstripped heavy hydrocarbons which remain on catalyst. Expressed as wt % carbon, the numbers are

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essentially the same, but 5 to 10 % less.

Although the carbon on regenerated catalyst can be the same as that produced by conventional FCC regenerators, the flue gas composition may range from conventional partial CO burn with large amounts of CO to flue gas with significant amounts of both CO and oxidized nitrogen species. Thus operation may range from deep in partial CO burn to something which is still partial CO burn in that there is more than 1 % CO present but contains some NO_x as well. There should always be enough CO present in the flue gas so that the FCC regenerator may be reliably controlled using control techniques associated with partial CO combustion, e.g, use of afterburning in the regenerator to control regenerator air rate.

Strictly speaking, the CO content could be disregarded if sufficient resources are devoted to analyzing the NO_x precursors directly, e.g., HCN. It would also be possible to run oxygen and carbon balances, and develop some sort of feed forward model which might be used to calculate some property of flue gas or of regenerator operation which would yield the same information in terms of controlling the unit as measuring the CO content of the regenerator flue gas. In most refineries this is neither practical nor necessary as the CO content of the flue gas is a sensitive indicator of the NO_x precursors generated by a particular regenerator processing a particular feed.

The CO content of flue gas should be considered with the oxygen content of the flue gas. There must be at least as much CO, by volume or molar amount, as oxygen.

Preferably the CO:O₂ ratio is above 2:1, and more preferably at least 3:1, 4:1, 5:1, 10:1 or higher.

The lower limit on CO content may be as low as 0.1 mole % or 0.5 %, but only when the oxygen content is less than 50 % of the CO content, and most regenerators in partial CO burn mode can not produce such low CO content flue gas. Poor air distribution, or poor catalyst

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circulation in the regenerator, and presence of large air bubbles in the dense bed will require most refiners to operate with at least 1 mole % CO, and preferable with 2 to 6 mole % CO.

5 The regenerator flue gas may contain significant amounts of oxygen but does not have to. If oxygen is present, it should be present in substoichiometric amounts. Our process allows bubbling bed regenerators to make excellent use of regeneration air. It is possible to
10 operate the FCC regenerator with essentially no waste of combustion air.

 Temperatures in our regenerator can be similar to conventional regenerators in complete CO combustion mode. Much of the coke on catalyst may be burned to form CO₂
15 rather than CO. Temperatures can also be cooler than in a conventional regenerator, as the regenerator operation shifts deeper into partial CO burn mode.

 Catalyst coolers, or some other means for heat removal from the regenerator, can be used to cool the regenerator.
20 Addition of torch oil or other fuel can be used to heat the regenerator.

 We prefer to keep regenerator temperatures low, to make such afterburning as may occur less troublesome and to limit downstream temperature rise. We prefer to operate
25 with temperatures below 1300 F, and preferably below 1250 F, but many units will be run above 1300 F, e.g., from 1330 to 1400 F.

FAST FLUIDIZED BED REGENERATORS

 Our process may also be used with high efficiency
30 regenerators (H.E.R.), with a fast fluidized bed coke combustor, dilute phase transport riser, and second bed to collect regenerated catalyst. It will be necessary to operate these in partial CO burn mode to make CO specifications.

35 H.E.R.'s inherently make excellent use of regeneration

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air. Most operate with 1 or 2 mole % O₂ or more in the flue gas when in complete CO burn mode. When in partial CO burn mode most operate with little excess oxygen, usually in the ppm range, always less than 1/10th %. For HER's, significant reductions in the amount of air added may be necessary to produce a flue gas with the correct CO/O₂ ratio. Reducing or eliminating CO combustion promoter may be necessary to generate a flue gas with twice as much CO as oxygen.

Although most regenerators are controlled primarily by adjusting the amount of regeneration air added, other equivalent control schemes are available which keep the air constant and change some other condition. Constant air rate, with changes in feed rate changing the coke yield, is an acceptable way to modify regenerator operation. Constant air, with variable feed preheat, or variable regenerator air preheat, are also acceptable. Finally, catalyst coolers can be used to remove heat from a unit. If a unit is not generating enough coke to stay in heat balance, torch oil, or some other fuel may be burned in the regenerator.

Up to this point in the FCC process, through the regenerator flue gas, the operation can be within the limits of conventional operation. In many instances the refiner will choose to operate the regenerator solidly in partial CO burn mode, which is highly conventional. Other refiners will operate with much lower amounts of CO in the regenerator flue gas, but always controlling regenerator operation so that the CO content is at least twice that of the oxygen content, molar basis.

This type of regenerator operation lays a proper foundation for the catalytic, post-regenerator conversion of NO_x precursors, discussed hereafter.

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CATALYTIC POST-REGENERATOR, NO_x PRECURSOR CONVERSION

While there are many variations, discussed below, the unifying theme of the present invention is formation of NO_x precursors in the regenerator coupled with selective conversion of NO_x precursors downstream of the FCC regenerator. The catalytic conversion step is upstream of, and in some embodiments can be a substitute for, a CO boiler. Following catalytic conversion of NO_x precursors, and conversion of CO, a flue gas stream with a greatly reduced NO_x content may be sent to a stack which discharges to the atmosphere. All embodiments of the present invention involve injecting air, or oxygen containing gas into CO and NO_x precursor containing flue gas downstream of the FCC regenerator and upstream of a catalytic NO_x precursor conversion zone.

Two types of catalytic NO_x precursor conversion have been developed, selective and non-selective. Selective conversion uses a NO_x precursor selective conversion catalyst and permits great latitude in operating conditions. The non-selective catalyst permits many catalysts to be used, but requires more careful control of the environment around the catalyst.

NO_x PRECURSOR SELECTIVE CATALYSTS

Some catalysts selectively convert NO_x precursors at the conditions found in FCC regenerator flue gas streams. An example is Na₂O₃/SiO₂. This catalyst can oxidize most HCN in a typical FCC regenerator flue gas stream while oxidizing less than 10 % of the CO present. The process is extremely simple, enough air or oxygen containing gas is added to the regenerator flue gas stream to oxidize the desired amount of reduced nitrogen species. Typically 100 to 200 % the air required by stoichiometry for combustion of the NO_x precursors present should be added, but more air may be safely added. The NO_x precursors comprise an extremely small part of the volume of the FCC regenerator

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flue gas, and an upper limit on oxygen addition would be that where an undesired amount of CO combustion occurs, either catalytically or thermally.

Selective catalytic conversion of NO_x precursors permits the FCC regenerator to operate deep in partial CO burn mode with significant heat release shifted from the regenerator to a downstream CO boiler.

No vendor sells selective catalysts. Availability, experience and stability will be a concern to many refiners. Until selective catalysts are commercially available, many refiners will prefer to use proven conventional oxidation catalysts, which are not so selective, and adjust operating conditions to favor conversion of NO_x precursors, as discussed hereafter.

CATALYTIC CONVERSION AT SUBSTOICHIOMETRIC CONDITIONS

We discovered that conventional oxidation catalysts, such as Pt or Rh on an amorphous support, can selectively convert HCN and NH₃ to nitrogen even in the presence of CO provided the operating conditions are properly maintained. Careful selection of operating conditions, and gas feed, allows catalysts as simple as Pt on an amorphous support to convert most of the NO_x precursors in a gas stream containing CO without converting most CO present.

The presence of both CO and oxygen is essential, in addition to the HCN, NH₃ or other reduced nitrogen species which will also be present. It is important that there be more CO than oxygen, on a molar basis. Preferably the mole ratio CO:O₂ is 2:1 or higher.

The temperature may range from 300 to 800 C, preferably 400 to 700 C. Temperatures near the higher ends of these ranges generally give higher conversions.

The catalyst may be disposed as a fixed, fluidized, or moving bed. To simplify design, and reduce pressure drop, it may be beneficial to dispose the catalyst as a plurality of honeycomb monoliths, or as a radial flow fixed bed, or

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as a bubbling fluidized bed.

Gas hourly space velocities, GHSV's, may vary greatly. There is no lower limit on GHSV other than that set by economics or space constraints. These reactions proceed quickly, very high space velocity operation is possible, especially with fresh catalyst and/or operation in the higher end of the temperature range.

Most refiners will operate with GHSV's above 1000, typically with GHSV's from 2000 to 250,000 hr⁻¹, preferably from 2500 to 125,000 Hr⁻¹, and most preferably from 25000 to 50,000 hr⁻¹.

Large amounts of water vapor may be tolerated. We have tested this chemistry with several different catalysts and found several that tolerate up to 9 mole % H₂O vapor while achieving selective NO_x precursor conversion, although conversion was lowered to some extent as water content increased.

Our process was tested on flue gas with 500 ppm NH₃ or HCN. We are confident that the process will treat gas streams containing more NO_x precursors, but FCC regenerators usually have less than 500 ppm of either NH₃ or HCN.

It is beneficial to limit conversion in the NO_x precursor conversion means so that some of the CO survives. If all CO is converted, there will be, in some places in the NO_x precursor conversion zone, some places with no CO, or where oxygen exceeds CO, molar basis. When this occurs, NO_x precursors can still be converted, but form both NO_x and nitrogen. Another alternative is that NO_x precursors are converted into NO_x and reduced by reaction with CO, in some as yet not completely understood reaction mechanism.

Complete CO conversion is therefore not desirable in the NO_x precursor conversion means. Complete CO conversion is also not necessary, as the process preferably retains a more or less conventional CO boiler, or equivalent, downstream of the NO_x precursor conversion reactor,

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discussed next.

CO CONVERSION MEANS

Basically any of the devices disclosed in US 5,268,089 may be used. Many refiners have conventional CO boilers in place, but some may prefer to use a catalytic converter, such as Pt on alumina on a monolith support, similar to the honeycomb elements used to burn CO and resin from flue gas produced in wood stoves.

The CO conversion means can operate conventionally, typically with enough excess oxygen to provide 1 - 2 mole % oxygen in the flue gas from the CO conversion means.

CO, NO_x EMISSIONS AFTER CO COMBUSTION

Regardless of the intermediate steps, the flue gas going up the stack will have unusually low levels of both NO_x and CO. The NO_x and CO levels should be below 100 ppm. Preferably the NO_x and CO levels are each below 50 ppm.

EXAMPLE 1 - Pt on Alumina Catalyst

The catalyst was prepared by the incipient wetness impregnation of H₂PtCl₆ onto commercial gamma-alumina, followed by air calcination at 535 C for two hours. The chloride concentration of the catalyst was approximately 0.73%. Chemisorption studies found H/Pt and O/Pt ratios of 1.25 and 0.62, respectively, indicating that the platinum was highly dispersed. The catalyst contained approximately 1.05% Pt on Al₂O₃.

EXAMPLE 2 - Tests w/ Pt Catalyst

0.25 g of catalyst, which was in the form of 1/8" beads, was loaded into a 3/8" OD quartz tube and fixed between plugs of quartz wool. The total amount of Pt in the reactor was approximately 2.6 mg. The catalyst bed temperature was varied between 400 and 600 C. A gas stream containing CO, O₂, and HCN or NH₃ was passed over this

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catalyst at a rate of $400 \text{ cm}^3/\text{min}$, giving a total space velocity of approximately $50,000 \text{ hr}^{-1}$. The concentrations of CO, CO₂, H₂O, HCN, NH₃, NO, NO₂ and N₂O in the exit gas were determined using FTIR; the concentration of N₂ was estimated by mass balance.

Two additional experiments were performed to test the resistance of the catalyst to SO₂ poisoning and to high temperature treatment. Because of the potential for damage to the FTIR cell, SO₂ treatments were effected by passing a gas stream containing 300 ppm SO₂ in balance argon over the catalyst for one hour at 600 C; the reactor was then flushed for one hour at 400 C in pure Ar before measurements were continued. In the high temperature test, catalyst activity was measured before and after the catalyst was exposed to 2% CO and 1% O₂ at 850 C for one hour.

RESULTS AND DISCUSSION

Table 1 shows the conversion of 2% CO and 200 ppm NH₃ with 1% O₂ as a function of reaction temperature. Conversion of CO is essentially constant at 95%. Ammonia conversion increases with increasing temperature; conversion exceeds 95% for temperatures of 450 C and above. Selectivity of ammonia conversion to molecular nitrogen is 100% at all temperatures studied. Table 1 indicates that raising the space velocity by increasing the total gas flow rate had little effect on conversion or selectivity. CO and NH₃ conversion appear to be limited by the amount of oxygen fed and not by the amount of catalyst, suggesting that the process could be run at significantly higher space velocities.

The effect of CO/O₂ ratio is shown in Table 2 and Figure 2, which show data collected at 500 C with 2% CO, 200 ppm NH₃ and 0.5 to 3.5% O₂. CO and NH₃ conversion increase in parallel as the inlet oxygen concentration is increased, but selectivity to N₂ drops quickly once the

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stoichiometric amount of oxygen is exceeded. Significant amounts of NO and NO₂ are formed when the inlet CO/O₂ ratio falls below two. Similar data are shown in Table 3 for the conversion of 100 ppm HCN. As long as the CO/O₂ ratio is greater than or equal to two, HCN is converted exclusively to molecular nitrogen. When more than stoichiometric oxygen is present, little N₂ is formed and the products are primarily NO and NO₂. A comparison of Tables 2 and 3 shows that, under the same conditions, HCN is converted more rapidly than ammonia, although selectivity to N₂ follows the same pattern.

If the CO/O₂ ratio is near two, the catalyst can convert large amounts of ammonia without a loss in selectivity, as shown by the data in Table 4, where the inlet ammonia concentration was varied from 66 to 468 ppm. Both NH₃ and CO conversion fall slightly as the inlet ammonia concentration is increased. This is most plausibly ascribed to the increasing amount of oxygen needed for a given conversion; the combustion of the hydrogen in 468 ppm ammonia to water requires approximately 0.035% O₂, decreasing the amount of oxygen available for CO oxidation. For all inlet ammonia concentrations, however, the selectivity of ammonia conversion to molecular nitrogen remained 100%.

FCC regenerators, especially bubbling dense bed regenerators, may under certain circumstances form NO as well as HCN and NH₃, we also determined the conversion of NO in the presence of CO, NH₃, and O₂ over the Pt/Al₂O₃ catalyst; these data are shown in Table 5. As long as significant amounts of NH₃ were present, NO was converted to N₂ with 100% selectivity; in the absence of ammonia, NO conversion fell to 92%. This suggests that if a unit operating in partial CO combustion mode forms some NO, it will be converted to N₂ along with the NH₃ and HCN. Of course this conversion will occur only so long as the unit is in partial CO combustion mode, since operation in full

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CO combustion mode will preclude the presence of percent levels of CO. From other studies we expect the concentration of NH_3 and HCN will always be greater than the NO concentration for a unit operating in partial CO combustion mode.

In order to determine the resistance of the catalyst to SO_2 , we treated a sample for one hour at 600 C in a gas stream containing 300 ppm SO_2 , as described above. The effect of this treatment on catalyst activity and selectivity, as shown in Table 6, was negligible. These data suggest that SO_2 does not have a strong inhibiting effect on either the activity or selectivity of this catalyst.

Finally, in order to study the effect of temperature excursions on catalyst stability, we treated a catalyst sample for 30 minutes at 850 C in 2% CO and 1% O_2 . As can be seen in Table 7, this treatment has little or no effect on the catalyst activity or selectivity. This experiment suggests that short excursions to temperatures as high as 850 C can be tolerated. In practice, the maximum temperature can be limited by limiting the amount of air that is supplied to the catalyst.

REACTION MECHANISMS

Considering these results, it is interesting to speculate on the mechanism of the conversion of NH_3 to N_2 . Three possibilities might be suggested: (1) adsorption and dissociation of NH_3 followed by direct combination of surface nitrogen atoms, (2) oxidation of NH_3 to NO followed by reduction of NO by CO, and (3) oxidation of some of the NH_3 to NO followed by reduction of NO by NH_3 . Although Pt is known to catalyze the reduction of NO by NH_3 , that is unlikely as HCN is converted at an even more rapid rate than NH_3 and because the selectivity to N_2 was extremely high at all temperatures, a result which requires that the reduction of NO be much faster than its formation. Pt is

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also known to catalyze the reduction of CO by NO; however, most research suggests that this reduction is not direct but involves the adsorption and dissociation of NO followed by the combination of surface nitrogen atoms to form N₂ and removal of the oxygen from the platinum surface by reaction with CO. In this case, the reduction of NO by CO and the conversion of NH₃ to N₂ would proceed by essentially the same route, dissociation followed by reaction of two surface nitrogen atoms.

Given these considerations, it seems likely that the role of CO is to maintain the platinum in a reduced state so that it can rapidly dissociate NH₃ without forming NO. This is consistent with the observation that selectivity to N₂ falls dramatically when a small amount of excess oxygen is present. If NO was an intermediate for N₂ formation and the role of CO was to reduce the NO, it seems unlikely that such a small increase in oxygen would have such a large effect on the N₂ selectivity, since the rates of CO and NH₃ conversion are not greatly different (see Figure 1.) If, however, the role of CO is to keep the Pt in a reduced state, even a small amount of excess oxygen would convert the active metal from platinum to platinum oxide, changing the selectivity of the catalyst.

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T (C)	Space velocity (hr-1)	% CO		% NH ₃		% N ₂	
		Conversion	Conversion	Conversion	Conversion	Selectivity	Selectivity
400	50,000	95		89		100	
450	50,000	96		96		100	
500	50,000	95		99		100	
500	75,000	95		98		100	
500	100,000	95		98		100	
550	50,000	95		99		100	
600	50,000	95		100		100	

Table 1: Conversion of CO and NH₃ as a function of temperature.Inlet conditions: 2% CO, 1% O₂, 200 ppm NH₃

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inlet O2 (%)	% CO Conversion	% NH3 Conversion	% N2 Selectivity
0.50	47	46	100
0.75	71	77	100
1.01	96	96	100
1.26	100	99	29
1.51	100	100	18
2.01	100	100	14
3.48	100	100	14

Table 2: Conversion of CO and NH3 as a function of inlet O2 concentration.

Conditions: T = 500 C, 2% CO, 200 ppm NH3 fed

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inlet O2 (%)	% CO Conversion	% HCN Conversion	% N2 Selectivity
0.75	69	94	100
1.01	96	98	100
1.51	98	99	12

Table 3: Conversion of CO and HCN as a function of inlet O2 concentration.

Conditions: T = 500 C, 2% CO, 100 ppm HCN fed

inlet NH3 (ppm)	% CO Conversion	% NH3 Conversion	% N2 Selectivity
66	96	100	100
100	97	100	100
200	96	100	100
300	95	98	100
400	94	97	100
468	94	96	100

Table 4: Effect of inlet NH3 concentration on conversion.

Conditions: T = 500 C, 2% CO, 1% O2 fed

inlet NH3 (ppm)	inlet NO (ppm)	% CO Conversion	% NH3 Conversion	% N2 Selectivity
590	0	93	95	100
480	79	95	96	100
404	134	95	96	100
305	205	96	97	100
207	276	97	97	100
0	424	100	-	92

Table 5: Effect on NO addition.

Conditions: T = 500 C, 2% CO, 1% O₂, 200 ppm NH₃ fed

T (C)	% CO conversion before	after SO ₂	% NH ₃ conversion before	after SO ₂	% N ₂ selectivity before	after SO ₂
450	96	95	96	98	100	100
500	95	95	99	99	100	100
550	95	95	99	99	100	100
600	95	95	100	99	100	100

Table 6: Effect of SO₂ treatment on conversion.

Catalyst treated for one hour at 600 C in 300 ppm SO₂

Conditions: T = 500C, 2% CO, 1% O₂, 200 ppm NH₃

	% CO conversion	% NH ₃ conversion	% N ₂ selectivity
before treatment	95	99	100
after treatment	96	98	100

Table 7: High temperature treatment does not deactivate Pt catalyst.

Conditions: T = 500 C, 2% CO, 1% O₂, 200 ppm NH₃

Catalyst treated 30 minutes at 850 C in 2% CO, 1% O₂

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EXAMPLE 3 - Rh/Al₂O₃ Catalyst

We obtained from Strem Chemicals a catalyst with about 0.50% Rh on Al₂O₃. 0.25 g of catalyst was loaded into a 3/8" OD quartz tube and fixed between plugs of quartz wool. The total amount of Rh in the reactor was approximately 1.25 mg, approximately half the 2.6 mg Pt used in our earlier studies.

Example 4 - Tests w/ Rh Catalyst

The catalyst bed temperature was varied between 450 and 650 C. A gas stream containing 2% CO, 0.5 to 1.5% O₂, zero to 9% H₂O, and 125 HCN or 200 ppm NH₃ was passed over this catalyst at a rate of 400 cm³/min, giving a total space velocity of approximately 55,000 hr⁻¹. The concentrations of CO, CO₂, H₂O, HCN, NH₃, NO, NO₂ and N₂O in the exit gas were determined using FTIR; the nitrogen concentration was estimated by mass balance.

RESULTS AND DISCUSSION

Table 8 shows the conversion of 2% CO and 200 ppm NH₃ with 1% O₂ as a function of reaction temperature from 450 to 650 C. Conversion of CO is essentially constant at 95 to 96%. Ammonia conversion is 100% at all temperatures studied, as is the selectivity to molecular nitrogen. These results compare favorably with those obtained using the 1% Pt/Al₂O₃ catalyst, where NH₃ conversions were somewhat lower even though the noble metal concentration was twice as high.

The effect of CO/O₂ ratio is shown in Table 9, which shows data collected at 500 C with 2% CO, 200 ppm NH₃ and 0.5 to 1.5% O₂. CO and NH₃ conversion both increase as the inlet oxygen concentration is increased, but selectivity to N₂ drops once the stoichiometric amount of oxygen is exceeded. When a substoichiometric amount of oxygen is fed, the rhodium catalyst converts ammonia at a faster rate than CO. Table 9 shows that 97% of the NH₃ but only 44% of the CO was converted when 2% CO and 0.5% O₂ were fed. In

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contrast, under the same conditions the platinum catalyst converted 47% of the CO and only 46% of the NH_3 .

Consistent with our earlier findings, considerable amounts of NO and NO_2 are formed when the inlet CO/ O_2 ratio falls below two. Significantly, however, the Rh/ Al_2O_3 catalyst still converts 64% of the NH_3 to N_2 when 1% CO and 1.5% O_2 are fed; under these conditions the Pt/ Al_2O_3 catalyst converted only 18% of the NH_3 to N_2 .

Tables 10 and 11 show the effect of the addition of up to 9% water on the conversion of NH_3 to N_2 at 500 and 600 C with a stoichiometric ratio of CO and O_2 . At both temperatures the CO conversion increases slightly as the water concentration increases; a similar result was observed from the Pt/ Al_2O_3 catalyst and is most likely due to the water-gas shift reaction. Ammonia conversions over the rhodium catalyst is 99% or greater at all conditions studied. In comparison, ammonia conversion over the platinum catalyst in the presence of 9% water fell to 82 and 91% at 500 and 600 C, respectively. Although conversions are too high to make accurate rate comparisons, these data suggest that the rhodium catalyst is at least two to three times more active than the platinum catalyst on a per-volume basis; since the Pt concentration was twice that of the Rh concentration, the total activity per unit weight of noble metal appears to be four to six times greater in the case of the Rh catalyst. It is not clear if this greater activity is due entirely to a higher intrinsic rate of ammonia conversion, or if the Rh catalyst is also more resistant to site blocking by water.

Table 12 shows the conversion of 125 ppm HCN in the presence of 2% CO, 1% O_2 , and zero to nine percent H_2O . As with ammonia, HCN is essentially completely converted to molecular nitrogen even when nine percent water is present.

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T (C)	% CO conversion	% NH ₃ conversion	% N ₂ selectivity
450	96	100	100
500	96	100	100
550	96	100	100
600	95	100	100
650	95	100	100

Table 8: Conversion of CO and NH₃ as a function of temperature over Rh/Alumina catalyst

Inlet conditions: 2% CO, 1% O₂, 200 ppm NH₃.

Space velocity = 55,000 hr⁻¹.

inlet O ₂ (%)	% CO conversion	% NH ₃ conversion	% N ₂ selectivity
0.50	44	97	100
0.75	70	99	100
1.01	94	100	100
1.51	94	100	64

Table 9: Conversion of CO and NH₃ as a function of inlet O₂ concentration over Rh/Alumina catalyst Conditions: T = 500 C, 2% CO, 200 ppm NH₃ fed.

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Inlet H ₂ O (%)	% CO conversion	% NH ₃ conversion	% N ₂ selectivity
0	95	100	100
1	98	100	100
3	100	100	100
6	100	100	100
9	100	99	100
0	96	100	100

Table 10: Conversion of CO and NH₃ in the presence of H₂O over Rh/Alumina catalyst.

Conditions: T = 500 C, 2% CO, 1% O₂, 200 ppm NH₃ fed.

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Inlet H ₂ O (%)	% CO conversion	% NH ₃ conversion	% N ₂ selectivity
0	96	100	100
1	97	100	100
3	99	100	100
6	100	100	100
9	100	100	100
0	96	100	100

Table 11: Conversion of CO and NH₃ in the presence of H₂O over Rh/Alumina catalyst.

Conditions: T = 600 C, 2% CO, 1% O₂, 200 ppm NH₃ fed.

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Inlet H ₂ O (%)	% CO conversion	% NH ₃ conversion	% N ₂ selectivity
0	95	100	100
1	98	100	100
3	98	100	100
6	98	100	100
9	99	98	100
6	99	99	100
0	96	100	100

Table 12: Conversion of CO and HCN in the presence of H₂O.Conditions: T = 500 C, 2% CO, 1% O₂, 125 ppm HCN fed.

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Although in our tests rhodium is more active for the conversion of HCN and NH_3 to N_2 than platinum, it does not necessarily follow that rhodium will be a better choice commercially. Rhodium is now somewhat more expensive than platinum per troy ounce. Additionally, we do not have catalyst lifetime data for either metal, so it is unknown which will last longer in service.

DISCUSSION

The process of the present invention can be readily used in existing bubbling bed or fast fluidized bed FCC regenerators with only minor hardware changes. Operation will be facilitated if the regenerator is equipped with sophisticated controls, permitting control to be based at least in part on one or more flue gas compositions, such as NO_x , CO, or free oxygen.

The process may also be used to efficiently convert flue gas streams containing NO_x precursors and carbon monoxide.

An especially powerful implementation of the process of the present invention will be a multi-bed NO_x pre-cursor conversion process, with the first bed operating in a reducing environment (substoichiometric oxygen), and subsequent beds operating with an oxidizing environment. The first bed will achieve 50 to 90 % conversion of NO_x precursors, but only 10 to 70 % conversion of CO. Because of the reducing conditions, such conversion of NO_x precursors as occurs will be extremely selective, on the order of 95+%, and typically 99+% selective. The downstream bed can operate at more robust conditions, as great selectivity is no longer necessary, with the elimination of most NO_x precursors upstream of this oxidizing portion of the bed.

It will also be feasible in many instances to use the two stage approach, and use a conventional CO boiler for CO conversion, rather than a catalyst. Thus the CO boiler can

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be used to convert the last amounts of NO_x precursors and CO into more oxidized species. The CO boiler will not be selective, but so long as the gross amount of NO_x precursors fed to the CO boiler is sufficiently reduced the net effect of the process will be reduction in NO_x emissions in the stack.

A single bed may, with staged air injection, simulate two separate reactors. A minority, less than 50 mole %, of the total air could be mixed with the feed gas to the inlet of the bed. A sparger or other air distribution means in a lower or downstream portion of the bed may be used for the remainder of the air injection to create an oxidizing atmosphere in that downstream portion.

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CLAIMS

1. A catalytic cracking process for cracking a nitrogen containing hydrocarbon feed by cracking the feed in a cracking reactor with a source of regenerated cracking catalyst to produce catalytically cracked products which are removed as a product and spent catalyst containing nitrogen containing coke; regenerating the spent catalyst in a catalyst regenerator by contact with a controlled amount of air or an oxygen-containing regeneration gas at regeneration conditions to produce regenerated catalyst which is recycled to the cracking reactor and regenerator flue gas; removing from the regenerator a regenerator flue gas stream comprising less than 1 mole % oxygen, at least 0.5 mole % carbon monoxide, volatilized NO_x precursors, and wherein the molar ratio of carbon monoxide to oxygen is at least 1:1; characterized by adding additional oxygen or oxygen containing gas to the regenerator flue gas stream to produce oxygen enriched flue gas; and reducing at least 50 mole % of the NO_x precursors to nitrogen by catalytically converting the volatilized NO_x precursors in the oxygen enriched flue gas in the presence of a NO_x precursor conversion catalyst.

2. The process of claim 1 wherein the oxygen enriched flue gas contains at least two moles of carbon monoxide per mole of oxygen.

3. The process of claim 1 or 2 wherein the regenerator flue gas contains from 0 to 1 mole % oxygen and 0.5 to 5 mole % CO and the oxygen enriched flue gas contains from 1 to 3 moles of CO per mole of oxygen.

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4. The process of claim 2 wherein the regenerator flue gas contains from 0.5 to 5 mole % CO, the CO content is more than twice the oxygen content, molar basis, and the oxygen enriched flue gas contains from 1.5 to 2.25 moles of CO per mole of oxygen.

5. The process of any of claims 1 to 4 wherein additional oxygen or oxygen containing gas is added to the reduced flue gas stream containing CO and most of the CO in the reduced flue gas stream is catalytically converted to CO₂.

6. The process of any of claims 1 to 5 wherein additional oxygen or oxygen containing gas is added intermediately during the conversion of the NO_x precursor or downstream of the NO_x precursor conversion.

7. The process of any of claims 1 to 6 wherein regenerator flue gas is cooled upstream of the catalytic NO_x precursor conversion means.

8. The process of any of claims 1 to 7 in which the regenerator flue gas stream comprises less than 1 mole % oxygen, at least 1 mole % carbon monoxide, and HCN and NH₃, and mixtures as volatilized NO_x precursors as well as NO_x and additional oxygen or oxygen containing gas is added to the regenerator flue gas stream to produce oxygen enriched flue gas having at least a 2:1 carbon monoxide:oxygen mole ratio.

9. The process of claim 8 in which at least 50 mole % of the volatilized NO_x precursors to nitrogen is catalytically converted in the presence of a Group VIII noble metal on a support catalyst to produce flue gas with a reduced NO_x precursor content and carbon monoxide; and oxygen or oxygen containing gas is added to the flue gas

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with a reduced NO_x precursor content to form an oxidizing atmosphere and at least a portion of the NO_x precursors to nitrogen and oxides of nitrogen and at least a majority of carbon monoxide present are catalytically converted to carbon dioxide in a downstream stage.

10. The process of claim 9 wherein at least 75 % of the NO_x precursors are converted in the first stage under reducing conditions, and sufficient additional amounts of the NO_x precursors are catalytically converted in stages downstream of the first stage to convert at least 90 mole % of the NO_x precursors to nitrogen.

11. The process of any of claims 1 to 10 in which the regenerator flue gas stream comprises less than 1 mole % oxygen, at least 1 mole % carbon monoxide, volatilized NO_x precursors and NO_x and adding additional oxygen or oxygen containing gas is added to the regenerator flue gas stream to produce oxygen enriched flue gas having at least a 2:1 carbon monoxide:oxygen mole ratio; and at least 50 mole % of the volatilized NO_x precursors to nitrogen and at least 25 % of the NO_x to nitrogen of the enriched flue gas is catalytically converted in the presence of a Group VIII noble metal catalyst.

12. The process of any of claims 1 to 11 in which the regenerator flue gas stream comprises less than 1 mole % oxygen, at least 1 mole % carbon monoxide, volatilized NO_x precursors and NO_x and additional oxygen or oxygen containing gas is added to the regenerator flue gas stream to produce oxygen enriched flue gas having at least a 2:1 carbon monoxide:oxygen mole ratio; and the enriched flue gas is catalytically converted in a reactor containing a Group VIII noble metal on a support so that at least 50 mole % of the volatilized NO_x precursors is converted to nitrogen and at least 25 % of the NO_x is converted to

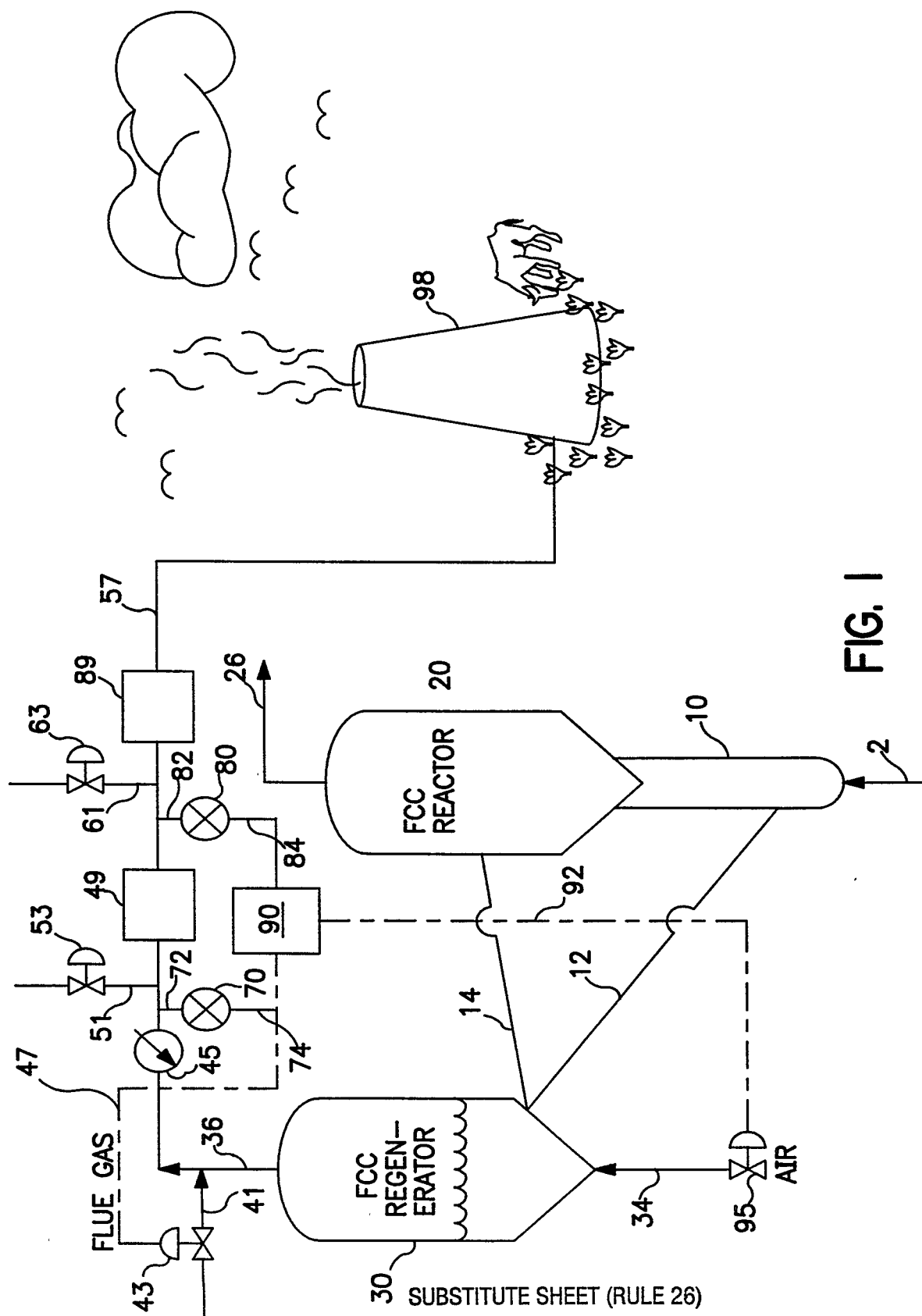
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nitrogen; and air or oxygen containing gas is added to the treated flue gas to produce a low CO and low NOx stack gas by thermally conversion of the the treated flue gas.

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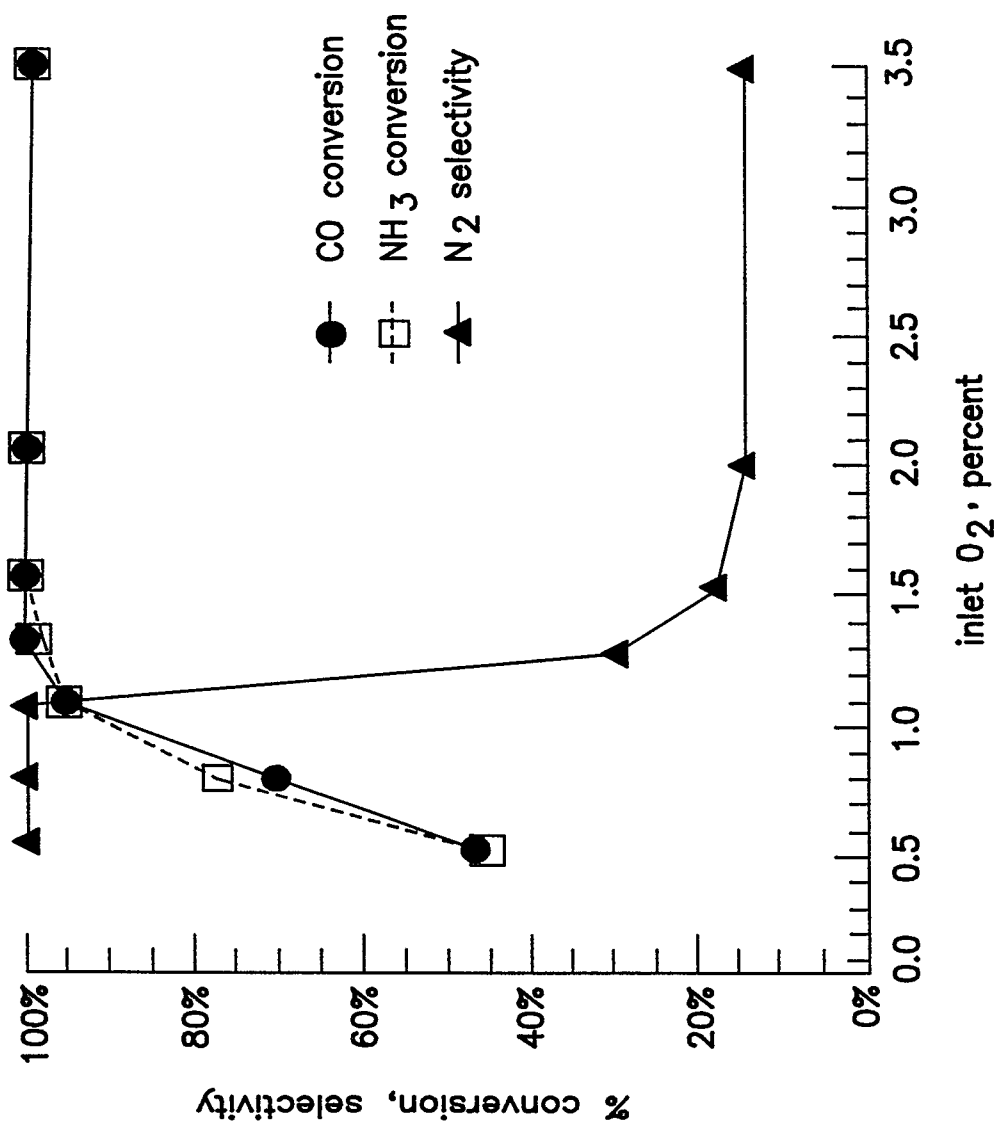


FIG. 2

