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(54) **Titre : AGENTS DE SOUTÈNEMENT ET ADDITIFS ANTI-REFLUX COMPORTANT DE L'ARGILE DE KAOLIN**  
 (54) **Title: PROPPANTS AND ANTI-FLOWBACK ADDITIVES INCLUDING KAOLIN CLAY**

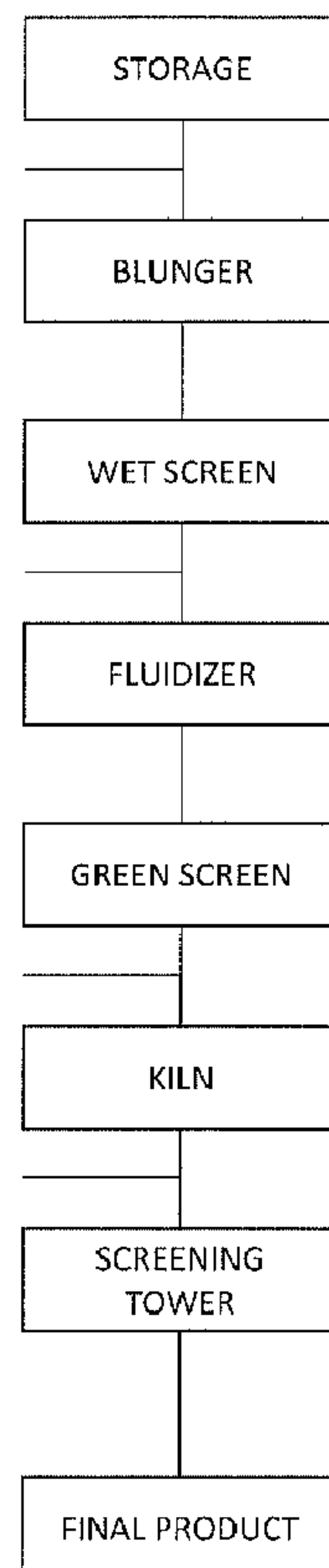


FIG. 1

(57) **Abrégé/Abstract:**

A method of making a sintered ceramic proppant may include providing a kaolin clay. The kaolin clay may include an Al<sub>2</sub>O<sub>3</sub> content no greater than about 46% by weight, and a K<sub>2</sub>O content no greater than 0.1 % by weight. The kaolin clay may have a particle size

**(57) Abrégé(suite)/Abstract(continued):**

distribution such that greater than 70% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, and a shape factor less than about 18. The method may further include blunging the kaolin clay, agglomerating the kaolin clay, and sintering the agglomerated kaolin clay to produce a sintered ceramic proppant. The kaolin clay may have an A-bob Hercules viscosity of at least about 3,300 rpm at 18 kilodyne-cm and 70% solids.

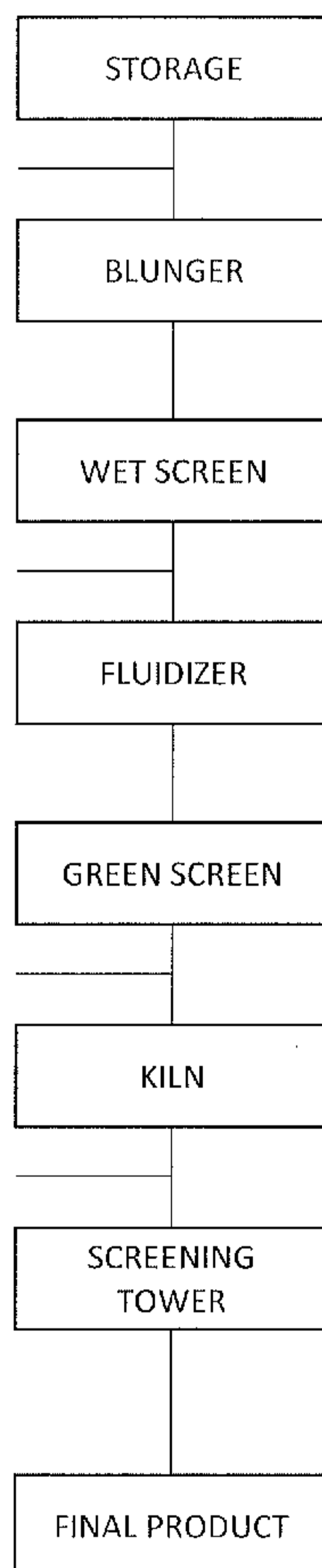
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(54) Title: PROPPANTS AND ANTI-FLOWBACK ADDITIVES INCLUDING KAOLIN CLAY



(57) Abstract: A method of making a sintered ceramic proppant may include providing a kaolin clay. The kaolin clay may include an Al<sub>2</sub>O<sub>3</sub> content no greater than about 46% by weight, and a K<sub>2</sub>O content no greater than 0.1 % by weight. The kaolin clay may have a particle size distribution such that greater than 70% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, and a shape factor less than about 18. The method may further include blunging the kaolin clay, agglomerating the kaolin clay, and sintering the agglomerated kaolin clay to produce a sintered ceramic proppant. The kaolin clay may have an A-bob Hercules viscosity of at least about 3,300 rpm at 18 kilodyne-cm and 70% solids.

FIG. 1



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**PROPPANTS AND ANTI-FLOWBACK ADDITIVES INCLUDING KAOLIN CLAY****CLAIM OF PRIORITY**

[001] This PCT International Application claims the benefit of priority of U.S. Provisional Application No. 61/861,815, filed August 2, 2013, the subject matter of which is incorporated herein by reference in its entirety.

**FIELD OF THE DISCLOSURE**

[002] The present disclosure relates to proppants and anti-flowback additives including kaolin clay for use in fracturing operations, and more particularly, to sintered ceramic proppants including kaolin clay and methods for making sintered ceramic proppants including kaolin clay.

**BACKGROUND OF THE DISCLOSURE**

[003] Naturally occurring deposits containing oil and natural gas are located throughout the world. Given the porous and permeable nature of the subterranean structure, it is possible to bore into the earth and set up a well where oil and natural gas are pumped out of the deposit. These wells are large, costly structures that are typically fixed at one location. As is often the case, a well may initially be very productive, with the oil and natural gas being pumpable with relative ease. As the oil or natural gas near the well bore is removed from the deposit, other oil and natural gas may flow to the area near the well bore so that it may be pumped as well. However, as a well ages, and sometimes merely as a consequence of the subterranean geology surrounding the well bore, the more remote oil and natural gas may have difficulty flowing to the well bore, thereby reducing the productivity of the well.

[004] To address this problem and to increase the flow of oil and natural gas to the well bore, a technique may be employed of fracturing the subterranean area around the well to create more paths for the oil and natural gas to flow toward the well bore. This fracturing may be performed by hydraulically injecting a fracturing fluid at high pressure into the area surrounding the well bore. This fracturing fluid is thereafter removed from the fracture to the extent possible so that it does not impede the flow of oil or natural gas back to the well bore. Once the fracturing fluid is removed, however, the fractures may tend to collapse due to the high compaction pressures experienced at well-depths, which may exceed 20,000 feet.

[005] To reduce the likelihood of the fractures closing, a propping agent, also known as a "proppant" or "anti-flowback additive," may be included in the fracturing fluid, so that as much of the fracturing fluid as possible may be removed from the fractures while leaving the proppant behind to hold the fractures open. As used in this application, the term "proppant" refers to any non-liquid material that is present in a proppant pack (a plurality of proppant particles) and provides structural support in a propped fracture. "Anti-flowback additive" refers to any material that is present in a proppant pack and reduces the flowback of proppant particles but still allows for production of oil at desired rates. The terms "proppant" and "anti-flowback additive" are not necessarily mutually exclusive, so a single particle type may meet both definitions. For example, a proppant particle may provide structural support in a fracture, and it may also be shaped to have anti-flowback properties, allowing it to meet both definitions.

[006] Because there may be extremely high closing pressures in fractures, it may be desirable to provide proppants and anti-flowback additives that have a high crush

resistance. For example, the useful life of the well may be shortened if the proppant particles break down, allowing the fractures to collapse and/or clog with “fines” created by the broken-down proppant particles. For this reason, it may be desirable to provide proppants that are resistant to breakage, even under high crush pressures.

[007] In addition, it may also be desirable to provide a proppant or anti-flowback additive that packs well with other proppant particles and the surrounding geological features, so that the nature of this packing of particles does not unduly impede the flow of the oil and natural gas through the fractures. For example, if the proppant particles become too tightly packed and create low porosity, they may actually inhibit the flow of the oil or natural gas to the well bore rather than increase it.

[008] The nature of the packing may also affect the overall turbulence generated as the oil or natural gas flows through the fractures. Too much turbulence may increase the flowback of the proppant particles from the fractures toward the well bore, which may undesirably decrease the flow of oil and natural gas, contaminate the well, cause abrasion to the equipment in the well, and/or increase the production cost as the proppants that flow back toward the well must be removed from the oil and natural gas. In addition, too much turbulence may also increase a non-Darcy flow effect, which may ultimately result in decreased conductivity.

[009] As resources become more scarce, the search for oil and natural gas may involve penetration into deeper geological formations, and the recovery of the such resources may become increasingly difficult. Therefore, there may be a desire to provide proppants and anti-flowback additives that have an excellent conductivity and permeability under extreme conditions. In addition, there may be a desire to provide

proppants and anti-flowback additives formed from less costly or more prevalent materials that still provide one or more desirable characteristics for propping fractures in modern wells.

### SUMMARY

[010] According to one aspect, a method of making a sintered ceramic proppant may include providing a kaolin clay. The kaolin clay may include an  $\text{Al}_2\text{O}_3$  content no greater than about 46% by weight, and a  $\text{K}_2\text{O}$  content no greater than 0.1% by weight. The kaolin clay may have a particle size distribution of particles of the kaolin clay such that greater than 70% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, and a shape factor less than about 18. The method may further include blunging the kaolin clay, agglomerating the kaolin clay, and sintering the agglomerated kaolin clay to produce a sintered ceramic proppant.

[011] As will be appreciated by those skilled in the art, the particle size distribution of a particulate material such as the kaolin clay may be determined by measuring the sedimentation speeds of the dispersed particles of the particulate material under test through a standard dilute aqueous suspension using a SEDIGRAPH® instrument (e.g., SEDIGRAPH 5100® obtained from Micromeritics Corporation, USA). The size of a given particle may be expressed in terms of the diameter of a sphere of equivalent diameter (i.e., the “equivalent spherical diameter” or esd), which sediments through the suspension, which may be used to characterize the particulate material. The SEDIGRAPH records the percentage by weight of particles having an esd less than a particular esd value, versus that esd value.

[012] A kaolin product of relatively high shape factor may be considered to be more “platey” than a kaolin product of low shape factor, which may be considered to be more “blocky.” “Shape factor” as used herein is a measure of an average value (on a weight average basis) of the ratio of mean particle diameter to particle thickness for a population of particles of varying size and shape, as measured using the electrical conductivity method and apparatus described in GB No. 2,240,398, U.S. Patent No. 5,128,606, EP No. 0 528 078, U.S. Patent No. 5,576,617, and EP 631 665, and using the equations derived in these publications. For example, in the measurement method described in EP No. 0 528 078, the electrical conductivity of a fully dispersed aqueous suspension of the particles under test is caused to flow through an elongated tube. Measurements of the electrical conductivity are taken between (a) a pair of electrodes separated from one another along the longitudinal axis of the tube, and (b) a pair of electrodes separated from one another across the transverse width of the tube, and by using the difference between the two conductivity measurements, the shape factor of the particulate material under test is determined. “Mean particle diameter” is defined as the diameter of a circle, which has the same area as the largest face of the particle.

[013] According to a further aspect, the kaolin clay may have an  $\text{Al}_2\text{O}_3$  content ranging from about 42% by weight to about 46% by weight, for example, an  $\text{Al}_2\text{O}_3$  content ranging from about 43% by weight to about 45% by weight.

[014] According to still another aspect, the kaolin clay may include a blend of a first kaolin clay including less than about 0.1% by weight  $\text{K}_2\text{O}$  and a second kaolin clay including greater than about 0.1% by weight  $\text{K}_2\text{O}$ . The blend may include at least about

10% by weight of the first kaolin clay, for example, at least about 25% by weight of the first kaolin clay.

[015] According to still another aspect, the kaolin clay may include a blend of a first kaolin clay including not greater than about 46% by weight  $\text{Al}_2\text{O}_3$  and a second kaolin clay including greater than about 47% by weight  $\text{Al}_2\text{O}_3$ . For example, the second kaolin clay may have an  $\text{Al}_2\text{O}_3$  content ranging from about 49% to about 55% by weight, or from about 50% to about 53% by weight. The blend may include at least about 10% by weight of the first kaolin clay, for example, at least about 25% by weight of the first kaolin clay.

[016] According to a further aspect, the particle size distribution of the kaolin clay may be such that greater than 75% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, such as, for example, greater than about 77%, or even greater than about 81%. For example, the particle size distribution of the kaolin clay may be such that about 70% to about 85% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, such as, for example, from about 75% to about 82%.

[017] According to a further aspect, the particle size distribution of the kaolin clay may be such that greater than 90% of the particles have an equivalent spherical diameter of less than 2 microns as measured by Sedigraph, such as, for example, greater than about 93%, greater than about 94%, greater than about 95%, or even greater than about 96%. For example, the particle size distribution of the kaolin clay may be such that greater than about 85% of the particles have an equivalent spherical diameter of less than 1 micron as measured by Sedigraph, such as, for example,

greater than about 87%, greater than about 89%, greater than about 90%, or even greater than about 92%. For example, the particle size distribution of the kaolin clay may be such that greater than about 40% of the particles have an equivalent spherical diameter of less than 0.25 microns as measured by Sedigraph, such as, for example, greater than about 45%, greater than about 50%, or even greater than about 55%.

[018] According to a further aspect, the kaolin clay may include a  $K_2O$  content ranging from about 0.005% by weight to about 0.08% by weight. For example, the kaolin clay may include a  $K_2O$  content ranging from about 0.01% by weight to about 0.06% by weight.

[019] According to still another aspect, the shape factor may be less than about 15, or less than about 10. For example, the shape factor may range from about 2 to about 15, from about 2 to about 10, or from about 5 to about 8.

[020] According to yet another aspect, the kaolin clay particles may have a BET surface area of greater than about  $15 \text{ m}^2/\text{g}$ . For example, the kaolin clay particles may have a BET surface area of greater than about  $20 \text{ m}^2/\text{g}$ , or greater than about  $35 \text{ m}^2/\text{g}$ . According to another aspect, the kaolin clay particles may have a BET surface area ranging from about  $15 \text{ m}^2/\text{g}$  to about  $35 \text{ m}^2/\text{g}$ .

[021] According to another aspect, the sintered ceramic proppant may have a specific gravity greater than about 2.65, a specific gravity greater than about 2.68, for example, a specific gravity greater than about 2.7.

[022] According to still a further aspect, the sintered ceramic proppant may have a bulk density greater than about  $1.44 \text{ g}/\text{cm}^3$ . For example, the sintered ceramic proppant may have a bulk density greater than about  $1.45 \text{ g}/\text{cm}^3$ , greater than about

1.46 g/cm<sup>3</sup>, greater than about 1.47 g/cm<sup>3</sup>, or greater than about 1.48 g/cm<sup>3</sup>. For example, the sintered ceramic proppant may have a bulk density ranging from about 1.45 g/cm<sup>3</sup> to about 1.50 g/cm<sup>3</sup>. According to yet another aspect, the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi may be less than about 6% fines by weight, for example, for a 30/50 mesh size proppant. For example, the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi may be less than about 5% fines by weight, or less than about 4% fines by weight.

[023] The strength of a proppant may be indicated from a proppant crush resistance test described in ISO 13503-2: "Measurement of Properties of Proppants Used in Hydraulic Fracturing and Gravel-packing Operations." In this test, a sample of proppant is first sieved to remove any fines (i.e., undersized pellets or fragments that may be present), then placed in a crush cell where a piston is then used to apply a confined closure stress of some magnitude above the failure point of some fraction of the proppant pellets. The sample is then re-sieved and the weight percent of fines generated as a result of pellet failure is reported as percent crush. A comparison of the percent crush of two equally sized samples is a method of gauging the relative strength of the two samples.

[024] Permeability is part of the proportionality constant in Darcy's Law, which relates flow rate and fluid physical properties (e.g., viscosity) to the stress level applied to a proppant pack. Permeability is a property specifically relating to a proppant pack, not the fluid. Conductivity, on the other hand, describes the ease with which fluid moves through pore spaces in a proppant pack. Conductivity depends on the intrinsic

permeability of a proppant pack as well as the degree of saturation. In particular, conductivity expresses the amount of water that will flow through a cross-sectional area of a proppant pack under the desired stress level.

[025] According to a further aspect, wherein the kaolin clay may have an A-bob Hercules viscosity of at least about 3,300 rpm at 18 kilodyne-cm and 70% solids. For example, the kaolin clay may have an A-bob Hercules viscosity of at least about 3,700 rpm at 18 kilodyne-cm and 70% solids, at least about 4,000 rpm at 18 kilodyne-cm and 70% solids, or at least about 4,400 rpm at 18 kilodyne-cm and 70% solids, or less than 18 kilodyne-cm at 4,400 rpm measured at 70% solids.

[026] Hercules viscometers provide a measure of a kaolin clay slurry's high shear viscosity. Hercules viscosity is measured by placing a cylinder (i.e., a bob) of appropriate diameter and length (e.g., the A-bob) into a sample cup containing clay slurry. Hercules viscosities of various samples can be compared by holding constant the percent solids concentration of the sample, the bob size, and the applied force. The Hercules viscometer applies a force to the bob, which causes it to spin at a controlled accelerating rate. As the viscometer increases the bob spin rate, the viscous drag on the cup increases. Clay slurries with poor high shear rheology will exert the maximum measurable force on the cup at a lower bob rpm than clay slurries with "good" high shear rheology. Hercules viscosity is therefore typically expressed in terms of bob spin rates, for example, in revolutions per minute (rpm). A "dyne endpoint" is an indication of a very low Hercules viscosity. A dyne endpoint is reached when the bob reaches its maximum rpm before the maximum measurable force is exerted on the cup. For more

fluid slurries, the Hercules viscosity is reported as a function of the force in kilodyne-cm required to spin the bob at its maximum speed of 4,400 rpm.

[027] According to yet another aspect, a method of making a sintered ceramic proppant may include providing a kaolin clay. The kaolin clay may include an  $\text{Al}_2\text{O}_3$  content no greater than about 46% by weight, and a  $\text{K}_2\text{O}$  content no greater than 0.1% by weight. The kaolin clay may have a particle size distribution of particles of the kaolin clay such that greater than 70% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, and an A-bob Hercules viscosity of at least about 3,300 rpm at 18 kilodyne-cm and 70% solids. The method may further include blunging the kaolin clay, agglomerating the kaolin clay, and sintering the agglomerated kaolin clay to produce a sintered ceramic proppant. According to another aspect, the kaolin clay may have a shape factor less than about 18. For example, the kaolin clay may have a shape factor less than about 15, less than about 10, for example, a shape factor ranging from about 2 to about 10, or from about 5 to about 8.

[028] It is to be understood that both the foregoing general description and the following detailed description are exemplary and explanatory only and are not restrictive of the invention.

#### **BRIEF DESCRIPTION OF THE DRAWING**

[029] Fig. 1 is a schematic diagram of an exemplary process for making exemplary sintered ceramic proppants consistent with exemplary methods disclosed herein.

### DESCRIPTION OF EXEMPLARY EMBODIMENTS

[030] Reference will now be made to exemplary embodiments.

[031] Applicant has surprisingly found that relatively fine kaolin clay having a relatively low shape factor may be used as a feed material for producing proppants and anti-flowback additives that may exhibit one or more desirable proppant properties, such as, for example, relatively high crush resistance, relatively high conductivity, relatively high permeability, a desirable bulk density, and/or a desirable specific gravity. This fine, blocky kaolin clay may be used as a feed material that is processed, including sintering, to form a sintered ceramic proppant.

[032] For example, according to some embodiments, a method of making a sintered ceramic proppant may include providing a kaolin clay, wherein the kaolin clay may include an  $\text{Al}_2\text{O}_3$  content no greater than about 46% by weight, and a  $\text{K}_2\text{O}$  content no greater than 0.1% by weight. The kaolin clay may have a particle size distribution such that greater than 70% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, and a shape factor less than about 18. The method may further include blunging the kaolin clay, agglomerating the kaolin clay, and sintering the agglomerated kaolin clay to produce a sintered ceramic proppant.

[033] According to some embodiments, the kaolin clay may have an  $\text{Al}_2\text{O}_3$  content ranging from about 42% by weight to about 46% by weight, for example, an  $\text{Al}_2\text{O}_3$  content ranging from about 43% by weight to about 45% by weight.

[034] According to some embodiments, the kaolin clay may include a blend of a first kaolin clay including less than about 0.1% by weight  $\text{K}_2\text{O}$  and a second kaolin clay

including greater than about 0.1% by weight  $K_2O$ . The blend may include at least about 10% by weight of the first kaolin clay, for example, at least about 25% by weight of the first kaolin clay.

[035] According to some embodiments, the kaolin clay may include a blend of a first kaolin clay including not greater than about 46% by weight  $Al_2O_3$  and a second kaolin clay including greater than about 47% by weight  $Al_2O_3$ . For example, the second kaolin clay may have an  $Al_2O_3$  content ranging from about 49% to about 55% by weight, or from about 50% to about 53% by weight. The blend may include at least about 10% by weight of the first kaolin clay, for example, at least about 25% by weight of the first kaolin clay.

[036] According to some embodiments, the particle size distribution of the kaolin clay may be such that greater than 75% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, such as, for example, greater than about 77%, or even greater than about 81%. For example, the particle size distribution of the kaolin clay may be such that about 70% to about 85% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, such as, for example, from about 75% to about 82%.

[037] According to some embodiments, the particle size distribution of the kaolin clay may be such that greater than about 90% of the particles have an equivalent spherical diameter of less than 2 microns as measured by Sedigraph, such as, for example, greater than about 93%, greater than about 94%, greater than about 95%, or even greater than about 96%. For example, the particle size distribution of the kaolin clay may be such that greater than about 85% of the particles have an equivalent

spherical diameter of less than 1 micron as measured by Sedigraph, such as, for example, greater than about 87%, greater than about 89%, greater than about 90%, or even greater than about 92%. For example, the particle size distribution of the kaolin clay may be such that greater than about 40% of the particles have an equivalent spherical diameter of less than 0.25 microns as measured by Sedigraph, such as, for example, greater than about 45%, greater than about 50%, or even greater than about 55%.

[038] According to some embodiments, the kaolin clay may include a  $K_2O$  content ranging from about 0.005% by weight to about 0.08% by weight. For example, the kaolin clay may include a  $K_2O$  content ranging from about 0.01% by weight to about 0.06% by weight. Although not wishing to be bound by theory, it is believed that  $K_2O$  provides an indicator of the presence of mica in the kaolin clay. Mica is generally associated with a high shape factor, which leads to a high viscosity of a kaolin clay slurry.

[039] According to some embodiments, the kaolin clay may have a shape factor less than about 15, or less than about 10. For example, the shape factor may range from about 2 to about 15, from about 2 to about 10, or from about 5 to about 8.

[040] According to some embodiments, the kaolin clay particles may have a BET surface area of greater than about  $15 \text{ m}^2/\text{g}$ . For example, the kaolin clay particles may have a BET surface area of greater than about  $20 \text{ m}^2/\text{g}$ , or greater than about  $35 \text{ m}^2/\text{g}$ . According to another aspect, the kaolin clay particles may have a BET surface area ranging from about  $15 \text{ m}^2/\text{g}$  to about  $35 \text{ m}^2/\text{g}$ .

[041] According to some embodiments, the sintered ceramic proppant may have a specific gravity greater than about 2.65, or a specific gravity greater than about 2.68. For example, the specific gravity may be greater than about 2.7.

[042] According to some embodiments, the sintered ceramic proppant may have a bulk density greater than about 1.44 g/cm<sup>3</sup>. For example, the sintered ceramic proppant may have a bulk density greater than about 1.45 g/cm<sup>3</sup>, greater than about 1.46 g/cm<sup>3</sup>, greater than about 1.47 g/cm<sup>3</sup>, or greater than about 1.48 g/cm<sup>3</sup>. For example, the sintered ceramic proppant may have a bulk density ranging from about 1.45 g/cm<sup>3</sup> to about 1.50 g/cm<sup>3</sup>.

[043] According to some embodiments, the crush strength measured under ISO 13503-2 of a 30/50 mesh sintered ceramic proppant at 10,000 psi may be less than about 6% fines by weight. For example, the crush strength measured under ISO 13503-2 of a 30/50 mesh sintered ceramic proppant at 10,000 psi may be less than about 5% fines by weight, or less than about 4% fines by weight.

[044] According to some embodiments, the kaolin clay may have an A-bob Hercules viscosity of at least about 3,300 rpm at 18 kilodyne-cm and 70% solids. For example, the kaolin clay may have an A-bob Hercules viscosity of at least about 3,700 rpm at 18 kilodyne-cm and 70% solids, at least about 4,000 rpm at 18 kilodyne-cm and 70% solids, or at least about 4,400 rpm at 18 kilodyne-cm and 70% solids.

[045] According to some embodiments, a method of making a sintered ceramic proppant may include providing a kaolin clay, wherein the kaolin clay may include an Al<sub>2</sub>O<sub>3</sub> content no greater than about 46% by weight, and a K<sub>2</sub>O content no greater than 0.1% by weight. The kaolin clay may have a particle size distribution of particles of the

kaolin clay such that greater than 70% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, and an "A-bob" Hercules viscosity of at least about 3,300 rpm at 18 kilodyne-cm and 70% solids. The method may further include blunging the kaolin clay, agglomerating the kaolin clay, and sintering the agglomerated kaolin clay to produce a sintered ceramic proppant. According to some embodiments, the kaolin clay may have a shape factor less than about 18. For example, the kaolin clay may have a shape factor less than about 15, less than about 10, for example, a shape factor ranging from about 2 to about 10, or from about 5 to about 8.

[046] Fig. 1 is a schematic diagram of an exemplary process for making sintered ceramic proppants consistent with exemplary methods disclosed herein. As shown in Fig. 1, a kaolin clay, for example, a fine, blocky feed kaolin clay, is transferred from storage to a blunger for blunging in a conventional manner known to those skilled in the art with inorganic or organic dispersant (e.g., TSPP, SHMP, Na-polyacrylate, and/or similar dispersants). Thereafter, the blunged feed kaolin clay is wet-screened and degrittled, after which the degrittled feed kaolin clay is fluidized for agglomeration. According to some embodiments, agglomeration may be performed using a spray fluidizer such as, for example, a fluidizer marketed by NIRO. Following agglomeration, the feed kaolin clay is green-screened, and undersized material is recirculated to the fluidizer to serve as seeds. According to some embodiments, 35 mesh screen may be used. Thereafter, the feed kaolin clay may be sintered in a kiln. For example, the feed may be heated in a kiln with the temperature being increased at a rate of, for example, 10°C per minute until it reaches a temperature of, for example, 1,450°C. According to

some embodiments, this temperature may be maintained for, for example, about an hour, and thereafter, the temperature may be reduced at a rate of, for example, about 5°C per minute. Thereafter, the sintered and cooled material may be fed to a screening tower to classify the sintered material into different grades (e.g., oversized, undersized, and dust). Thereafter, the final sintered ceramic proppant may be obtained.

### **EXAMPLES**

[047] The following examples include five samples: three samples and two comparative samples of feed kaolin clays used to form sintered ceramic proppants of the five proppant samples tested. Table 1 below shows the chemical content in weight percent of the five feed kaolin clay samples.

<b>Sample</b>	<b>Total</b>	<b>Fired Basis</b>								<b>Total Alkali</b>
		<b>Fe2O3</b>	<b>MgO</b>	<b>Al2O3</b>	<b>SiO2</b>	<b>TiO2</b>	<b>CaO</b>	<b>Na2O</b>	<b>K2O</b>	
	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
Sample 1	100.5	1.11	0.07	44.52	52.14	2.53	0.05	0.01	0.03	0.16
Sample 2	100.5	1.08	0.05	43.80	51.84	3.59	0.06	0.00	0.05	0.16
Sample 3	100.6	1.57	0.07	43.88	52.68	2.14	0.06	0.07	0.09	0.29
Comparative Sample 1	100.2	1.53	0.08	43.77	52.40	2.02	0.09	0.01	0.17	0.36
Comparative Sample 2	101.1	0.44	0.06	52.16	46.43	2.01	0.04	0.00	0.09	0.19

**TABLE 1**

[048] Table 2 below shows material characteristics of the five feed kaolin clay samples listed in the same order as Table 1. Note that for Samples 1 and 2, the Hercules viscosity is shown in units of kilodyne-cm @ 4,400 rpm rather than rpm because for more fluid slurries, the Hercules viscosity is reported as a function of the force in kilodyne-cm required to spin the bob at its maximum speed of 4,400 rpm.

Shape Factor (NSF)					Solids(%)	w/SHMP	Hercules	pH	BET SA m <sup>2</sup> /g
	2um	1um	0.5um	0.25um		Poly (#/t)	rpm		
6	94.5	91.4	83.0	59.6	70	-	6.1	6.9	24.0
8	92.6	88.6	79.0	53.0	70	-	5.4	6.9	
11.3	92.9	88.3	78.2	57.5	70	17	3718	6.7	
18	94.8	90.5	81.0	58.4	69.7	11	2384		25.6
5	61.3	45.3	27.5	15.7	70	8	770	7.2	

TABLE 2

[049] Table 3 below shows the corresponding fired real density, fired bulk density, and crush resistance at 10,000 psi according ISO 13503-2 of five 30/50 mesh proppant samples prepared according to methods consistent with the exemplary methods disclosed previously herein, as follows: Samples 1-3 correspond to the feed kaolin clay Samples 1-3 shown in Tables 1 and 2; Comparative Sample 1 corresponds to Comparative Sample 1 of the feed kaolin clay; and the remaining sample is a blend of the feed kaolin clays of 50% by weight of Sample 3, 40% by weight of Comparative Sample 1, and 10% of a high-alumina content kaolin clay. All the proppant samples tested were screened to 325 mesh using 035 mesh plant seed. The proppant samples were obtained by being passed through a 30 mesh but retained on 50 mesh (i.e., "30/50").

Feed Sample	Fired real density (g/cc)	Fired Bulk density (g/cc)	10K Crush 30/50
Sample 1	2.69	1.49	3.6
Sample 2	2.66	1.49	3.3
Sample 3	2.66	1.46	5.8
Comparative Sample 1	2.57	1.42	7.3
50% Sample 3/ 40% Comparative Sample 1/ 10% High Alumina Kaolin	2.65	1.47	4

TABLE 3

[050] As shown in Table 3, the sintered ceramic proppant Samples 1-3 exhibit a better crush resistance (i.e., a lower percentage of fines) than Comparative Sample 1. In addition, the blended Sample also exhibits a better crush resistance than Comparative Sample 1, but an inferior crush resistance relative to Samples 1 and 2.

[051] For the avoidance of doubt, the present application is directed to the subject matter described in the following numbered paragraphs (i.e., numbered paragraphs 1-62 (also denoted by [052]-[0113])).

[052] 1. A method of making a sintered ceramic proppant, the method comprising: providing a kaolin clay comprising an  $\text{Al}_2\text{O}_3$  content of not greater than about 46% by weight, and a  $\text{K}_2\text{O}$  content no greater than 0.1% by weight, and having a particle size distribution of particles of the kaolin clay such that greater than 70% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, and a shape factor less than about 18; blunging the kaolin clay;

agglomerating the kaolin clay; and sintering the agglomerated kaolin clay to produce a sintered ceramic proppant.

[053] 2. The method according to numbered paragraph 1 (also denoted by [052]), wherein the kaolin clay has an  $\text{Al}_2\text{O}_3$  content ranging from about 42% by weight to about 46% by weight.

[054] 3. The method according to any preceding numbered paragraph (i.e., paragraphs 1 and 2 (also denoted by [052] and [053])), wherein the kaolin clay has an  $\text{Al}_2\text{O}_3$  content ranging from about 43% by weight to about 45% by weight.

[055] 4. The method according to any preceding numbered paragraph, wherein the kaolin clay comprises a blend of a first kaolin clay comprising less than about 0.1% by weight  $\text{K}_2\text{O}$  and a second kaolin clay comprising greater than about 0.1% by weight  $\text{K}_2\text{O}$ , wherein the blend comprises at least about 10% by weight of the first kaolin clay.

[056] 5. The method according to any preceding numbered paragraph, wherein the blend comprises at least about 25% by weight of the first kaolin clay.

[057] 6. The method according to any preceding numbered paragraph, wherein the particle size distribution of the kaolin clay is such that greater than 93% of the particles have an equivalent spherical diameter of less than 2 microns as measured by Sedigraph.

[058] 7. The method according to any preceding numbered paragraph, wherein the particle size distribution of the kaolin clay is such that greater than 85% of the particles have an equivalent spherical diameter of less than 1 micron as measured by Sedigraph.

[059] 8. The method according to any preceding numbered paragraph, wherein the particle size distribution of the kaolin clay is such that greater than 40% of the particles have an equivalent spherical diameter of less than 0.25 microns as measured by Sedigraph.

[060] 9. The method of according to any preceding numbered paragraph, wherein the kaolin clay comprises a  $K_2O$  content ranging from about 0.005% by weight to about 0.08% by weight.

[061] 10. The method according to any preceding numbered paragraph, wherein the kaolin clay comprises a  $K_2O$  content ranging from about 0.01% by weight to about 0.06% by weight.

[062] 11. The method according to any preceding numbered paragraph, wherein the shape factor is less than about 15.

[063] 12. The method according to any preceding numbered paragraph, wherein the shape factor is less than about 10.

[064] 13. The method according to any preceding numbered paragraph, wherein the shape factor ranges from about 2 to about 15.

[065] 14. The method according to any preceding numbered paragraph, wherein the shape factor ranges from about 5 to about 8.

[066] 15. The method according to any preceding numbered paragraph, wherein the kaolin clay particles have a BET surface area of greater than about 15  $m^2/g$ .

[067] 16. The method according to any preceding numbered paragraph, wherein the kaolin clay particles have a BET surface area of greater than about 20 m<sup>2</sup>/g.

[068] 17. The method according to any preceding numbered paragraph, wherein the kaolin clay particles have a BET surface area of greater than about 35 m<sup>2</sup>/g.

[069] 18. The method according to any preceding numbered paragraph, wherein the kaolin clay particles have a BET surface area ranging from about 15 m<sup>2</sup>/g to about 35 m<sup>2</sup>/g.

[070] 19. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a specific gravity greater than about 2.65.

[071] 20. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a specific gravity greater than about 2.68.

[072] 21. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a specific gravity greater than about 2.7.

[073] 22. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a bulk density greater than about 1.44 g/cm<sup>3</sup>.

[074] 23. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a bulk density greater than about 1.45 g/cm<sup>3</sup>.

[075] 24. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a bulk density ranging from about 1.45 g/cm<sup>3</sup> to about 1.50 g/cm<sup>3</sup>.

[076] 25. The method according to any preceding numbered paragraph, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 6% fines by weight.

[077] 26. The method according to any preceding numbered paragraph, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 5% fines by weight.

[078] 27. The method according to any preceding numbered paragraph, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 4% fines by weight.

[079] 28. The method according to any preceding numbered paragraph, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 3,300 rpm at 18 kilodyne-cm and 70% solids.

[080] 29. The method according to any preceding numbered paragraph, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 3,700 rpm at 18 kilodyne-cm and 70% solids.

[081] 30. The method according to any preceding numbered paragraph, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 4,000 rpm at 18 kilodyne-cm and 70% solids.

[082] 31. The method according to any preceding numbered paragraph, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 4,400 rpm at 18 kilodyne-cm and 70% solids.

[083] 32. A method of making a sintered ceramic proppant, the method comprising: providing a kaolin clay comprising an  $\text{Al}_2\text{O}_3$  content not greater than about 46% by weight, and a  $\text{K}_2\text{O}$  content no greater than 0.1% by weight, and having a particle size distribution of particles of the kaolin clay such that greater than 70% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, and an A-bob Hercules viscosity of at least about 3,300 rpm at 18 kilodyne-cm and 70% solids; blunging the kaolin clay; agglomerating the kaolin clay; and sintering the agglomerated kaolin clay to produce a sintered ceramic proppant.

[084] 33. The method according to any preceding numbered paragraph, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 3,700 rpm at 18 kilodyne-cm and 70% solids.

[085] 34. The method according to any preceding numbered paragraph, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 4,000 rpm at 18 kilodyne-cm and 70% solids.

[086] 35. The method according to any preceding numbered paragraph, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 4,400 rpm at 18 kilodyne-cm and 70% solids.

[087] 36. The method according to any preceding numbered paragraph, wherein the kaolin clay has an  $\text{Al}_2\text{O}_3$  content ranging from about 42% by weight to about 46% by weight.

[088] 37. The method according to any preceding numbered paragraph, wherein the kaolin clay has an  $\text{Al}_2\text{O}_3$  content ranging from about 43% by weight to about 45% by weight.

[089] 38. The method according to any preceding numbered paragraph, wherein the kaolin clay comprises a blend of a first kaolin clay comprising less than about 0.1% by weight  $\text{K}_2\text{O}$  and a second kaolin clay comprising greater than about 0.1% by weight  $\text{K}_2\text{O}$ , wherein the blend comprises at least about 10% by weight of the first kaolin clay.

[090] 39. The method according to any preceding numbered paragraph, wherein the blend comprises at least about 25% by weight of the first kaolin clay.

[091] 40. The method according to any preceding numbered paragraph, wherein the particle size distribution of the kaolin clay is such that greater than 93% of the particles have an equivalent spherical diameter of less than 2 microns as measured by Sedigraph.

[092] 41. The method according to any preceding numbered paragraph, wherein the particle size distribution of the kaolin clay is such that greater than 85% of the particles have an equivalent spherical diameter of less than 1 micron as measured by Sedigraph.

[093] 42. The method according to any preceding numbered paragraph, wherein the particle size distribution of the kaolin clay is such that greater than 40% of the particles have an equivalent spherical diameter of less than 0.25 microns as measured by Sedigraph.

[094] 43. The method according to any preceding numbered paragraph, wherein the kaolin clay comprises a  $K_2O$  content ranging from about 0.005% by weight to about 0.08% by weight.

[095] 44. The method according to any preceding numbered paragraph, wherein the kaolin clay comprises a  $K_2O$  content ranging from about 0.01% by weight to about 0.06% by weight.

[096] 45. The method according to any preceding numbered paragraph, wherein the kaolin clay has a shape factor less than about 18.

[097] 46. The method according to any preceding numbered paragraph, wherein the kaolin clay has a shape factor less than about 15.

[098] 47. The method according to any preceding numbered paragraph, wherein the kaolin clay has a shape factor less than about 10.

[099] 48. The method according to any preceding numbered paragraph, wherein the kaolin clay has a shape factor ranging from about 2 to about 15.

[0100] 49. The method according to any preceding numbered paragraph, wherein the kaolin clay has a shape factor ranging from about 5 to about 8.

[0101] 50. The method according to any preceding numbered paragraph, wherein the kaolin clay particles have a BET surface area of greater than about 15  $m^2/g$ .

[0102] 51. The method according to any preceding numbered paragraph, wherein the kaolin clay particles have a BET surface area of greater than about 20  $m^2/g$ .

[0103] 52. The method according to any preceding numbered paragraph, wherein the kaolin clay particles have a BET surface area of greater than about 35 m<sup>2</sup>/g.

[0104] 53. The method according to any preceding numbered paragraph, wherein the kaolin clay particles have a BET surface area ranging from about 15 m<sup>2</sup>/g to about 35 m<sup>2</sup>/g.

[0105] 54. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a specific gravity greater than about 2.65.

[0106] 55. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a specific gravity greater than about 2.68.

[0107] 56. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a specific gravity greater than about 2.7.

[0108] 57. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a bulk density greater than about 1.44 g/cm<sup>3</sup>.

[0109] 58. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a bulk density greater than about 1.45 g/cm<sup>3</sup>.

[0110] 59. The method according to any preceding numbered paragraph, wherein the sintered ceramic proppant has a bulk density ranging from about 1.45 g/cm<sup>3</sup> to about 1.50 g/cm<sup>3</sup>.

[0111] 60. The method according to any preceding numbered paragraph, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 6% fines by weight.

[0112] 61. The method according to any preceding numbered paragraph, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 5% fines by weight.

[0113] 62. The method according to any preceding numbered paragraph, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 4% fines by weight.

[0114] Other embodiments may be apparent to those skilled in the art from consideration of the specification and practice of the exemplary embodiments disclosed herein. It is intended that the specification and examples be considered as exemplary only.

## WHAT IS CLAIMED IS:

1. A method of making a sintered ceramic proppant, the method comprising:  
providing a kaolin clay comprising  
    an Al<sub>2</sub>O<sub>3</sub> content no greater than about 46% by weight, and  
    a K<sub>2</sub>O content no greater than 0.1% by weight,  
and having  
    a particle size distribution of particles of the kaolin clay such that greater than 70% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, and  
    a shape factor less than about 18;  
blunging the kaolin clay;  
agglomerating the kaolin clay; and  
sintering the agglomerated kaolin clay to produce a sintered ceramic proppant.
2. The method of claim 1, wherein the kaolin clay has an Al<sub>2</sub>O<sub>3</sub> content ranging from about 42% by weight to about 46% by weight.
3. The method of claim 2, wherein the kaolin clay has an Al<sub>2</sub>O<sub>3</sub> content ranging from about 43% by weight to about 45% by weight.
4. The method of claim 1, wherein the kaolin clay comprises a blend of a first kaolin clay comprising less than about 0.1% by weight K<sub>2</sub>O and a second kaolin clay

comprising greater than about 0.1% by weight  $K_2O$ , wherein the blend comprises at least about 10% by weight of the first kaolin clay.

5. The method of claim 4, wherein the blend comprises at least about 25% by weight of the first kaolin clay.

6. The method of claim 1, wherein the particle size distribution of the kaolin clay is such that greater than 93% of the particles have an equivalent spherical diameter of less than 2 microns as measured by Sedigraph.

7. The method of claim 6, wherein the particle size distribution of the kaolin clay is such that greater than 85% of the particles have an equivalent spherical diameter of less than 1 micron as measured by Sedigraph.

8. The method of claim 7, wherein the particle size distribution of the kaolin clay is such that greater than 40% of the particles have an equivalent spherical diameter of less than 0.25 microns as measured by Sedigraph.

9. The method of claim 1, wherein the kaolin clay comprises a  $K_2O$  content ranging from about 0.005% by weight to about 0.08% by weight.

10. The method of claim 9, wherein the kaolin clay comprises a  $K_2O$  content ranging from about 0.01% by weight to about 0.06% by weight.

11. The method of claim 1, wherein the shape factor is less than about 15.
12. The method of claim 11, wherein the shape factor is less than about 10.
13. The method of claim 12, wherein the shape factor ranges from about 2 to about 15.
14. The method of claim 13, wherein the shape factor ranges from about 5 to about 8.
15. The method of claim 1, wherein the kaolin clay particles have a BET surface area of greater than about 15 m<sup>2</sup>/g.
16. The method of claim 15, wherein the kaolin clay particles have a BET surface area of greater than about 20 m<sup>2</sup>/g.
17. The method of claim 16, wherein the kaolin clay particles have a BET surface area of greater than about 35 m<sup>2</sup>/g.
18. The method of claim 1, wherein the kaolin clay particles have a BET surface area ranging from about 15 m<sup>2</sup>/g to about 35 m<sup>2</sup>/g.

19. The method of claim 1, wherein the sintered ceramic proppant has a specific gravity greater than about 2.65.

20. The method of claim 19, wherein the sintered ceramic proppant has a specific gravity greater than about 2.68.

21. The method of claim 20, wherein the sintered ceramic proppant has a specific gravity greater than about 2.7.

22. The method of claim 1, wherein the sintered ceramic proppant has a bulk density greater than about  $1.44 \text{ g/cm}^3$ .

23. The method of claim 22, wherein the sintered ceramic proppant has a bulk density greater than about  $1.45 \text{ g/cm}^3$ .

24. The method of claim 23, wherein the sintered ceramic proppant has a bulk density ranging from about  $1.45 \text{ g/cm}^3$  to about  $1.50 \text{ g/cm}^3$ .

25. The method of claim 1, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 6% fines by weight.

26. The method of claim 25, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 5% fines by weight.

27. The method of claim 26, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 4% fines by weight.

28. The method of claim 1, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 3,300 rpm at 18 kilodyne-cm and 70% solids.

29. The method of claim 28, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 3,700 rpm at 18 kilodyne-cm and 70% solids.

30. The method of claim 29, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 4,000 rpm at 18 kilodyne-cm and 70% solids.

31. The method of claim 30, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 4,400 rpm at 18 kilodyne-cm and 70% solids.

32. A method of making a sintered ceramic proppant, the method comprising:  
providing a kaolin clay comprising

an Al<sub>2</sub>O<sub>3</sub> content no greater than about 46% by weight, and

a K<sub>2</sub>O content no greater than 0.1% by weight,  
and having

a particle size distribution of particles of the kaolin clay such that greater than 70% of the particles have an equivalent spherical diameter of less than 0.5 microns as measured by Sedigraph, and

an A-bob Hercules viscosity of at least about 3,300 rpm at 18 kilodyne-cm and 70% solids;

blunging the kaolin clay;

agglomerating the kaolin clay; and

sintering the agglomerated kaolin clay to produce a sintered ceramic proppant.

33. The method of claim 32, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 3,700 rpm at 18 kilodyne-cm and 70% solids.

34. The method of claim 33, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 4,000 rpm at 18 kilodyne-cm and 70% solids.

35. The method of claim 34, wherein the kaolin clay has an A-bob Hercules viscosity of at least about 4,400 rpm at 18 kilodyne-cm and 70% solids.

36. The method of claim 32, wherein the kaolin clay has an Al<sub>2</sub>O<sub>3</sub> content ranging from about 42% by weight to about 46% by weight.

37. The method of claim 36, wherein the kaolin clay has an  $\text{Al}_2\text{O}_3$  content ranging from about 43% by weight to about 45% by weight.

38. The method of claim 32, wherein the kaolin clay comprises a blend of a first kaolin clay comprising less than about 0.1% by weight  $\text{K}_2\text{O}$  and a second kaolin clay comprising greater than about 0.1% by weight  $\text{K}_2\text{O}$ , wherein the blend comprises at least about 10% by weight of the first kaolin clay.

39. The method of claim 38, wherein the blend comprises at least about 25% by weight of the first kaolin clay.

40. The method of claim 32, wherein the particle size distribution of the kaolin clay is such that greater than 93% of the particles have an equivalent spherical diameter of less than 2 microns as measured by Sedigraph.

41. The method of claim 40, wherein the particle size distribution of the kaolin clay is such that greater than 85% of the particles have an equivalent spherical diameter of less than 1 micron as measured by Sedigraph.

42. The method of claim 41, wherein the particle size distribution of the kaolin clay is such that greater than 40% of the particles have an equivalent spherical diameter of less than 0.25 microns as measured by Sedigraph.

43. The method of claim 32, wherein the kaolin clay comprises a K<sub>2</sub>O content ranging from about 0.005% by weight to about 0.08% by weight.

44. The method of claim 43, wherein the kaolin clay comprises a K<sub>2</sub>O content ranging from about 0.01% by weight to about 0.06% by weight.

45. The method of claim 32, wherein the kaolin clay has a shape factor less than about 18.

46. The method of claim 45, wherein the kaolin clay has a shape factor less than about 15.

47. The method of claim 46, wherein the kaolin clay has a shape factor less than about 10.

48. The method of claim 45, wherein the kaolin clay has a shape factor ranging from about 2 to about 15.

49. The method of claim 48, wherein the kaolin clay has a shape factor ranging from about 5 to about 8.

50. The method of claim 32, wherein the kaolin clay particles have a BET surface area of greater than about 15 m<sup>2</sup>/g.

51. The method of claim 50, wherein the kaolin clay particles have a BET surface area of greater than about 20 m<sup>2</sup>/g.

52. The method of claim 51, wherein the kaolin clay particles have a BET surface area of greater than about 35 m<sup>2</sup>/g.

53. The method of claim 32, wherein the kaolin clay particles have a BET surface area ranging from about 15 m<sup>2</sup>/g to about 35 m<sup>2</sup>/g.

54. The method of claim 32, wherein the sintered ceramic proppant has a specific gravity greater than about 2.65.

55. The method of claim 54, wherein the sintered ceramic proppant has a specific gravity greater than about 2.68.

56. The method of claim 55, wherein the sintered ceramic proppant has a specific gravity greater than about 2.7.

57. The method of claim 32, wherein the sintered ceramic proppant has a bulk density greater than about 1.44 g/cm<sup>3</sup>.

58. The method of claim 57, wherein the sintered ceramic proppant has a bulk density greater than about  $1.45 \text{ g/cm}^3$ .

59. The method of claim 58, wherein the sintered ceramic proppant has a bulk density ranging from about  $1.45 \text{ g/cm}^3$  to about  $1.50 \text{ g/cm}^3$ .

60. The method of claim 32, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 6% fines by weight.

61. The method of claim 60, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 5% fines by weight.

62. The method of claim 61, wherein the crush strength measured under ISO 13503-2 of the sintered ceramic proppant at 10,000 psi is less than about 4% fines by weight.

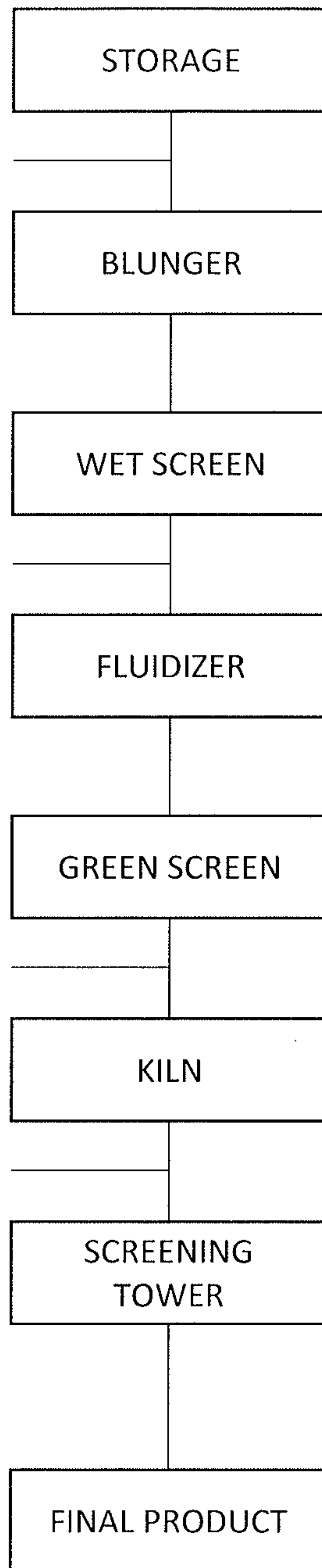
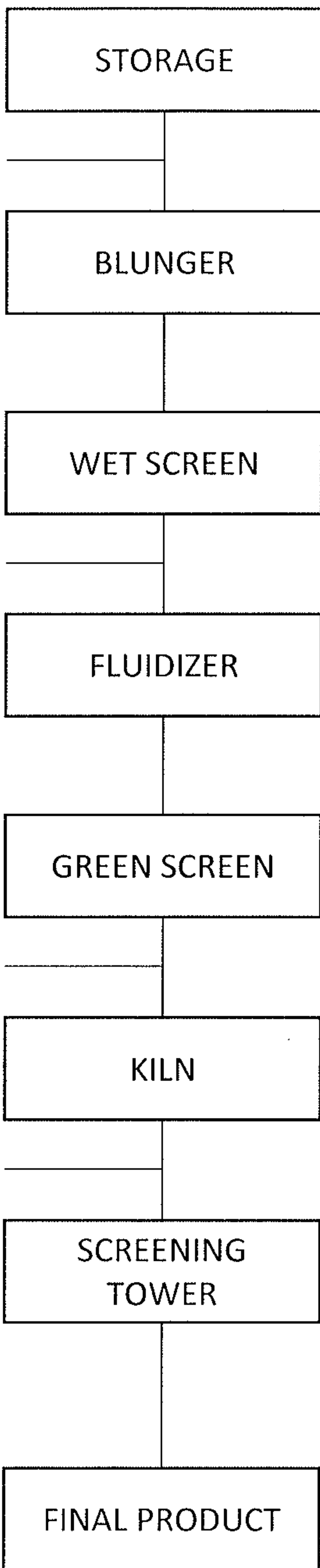


FIG. 1



**FIG. 1**