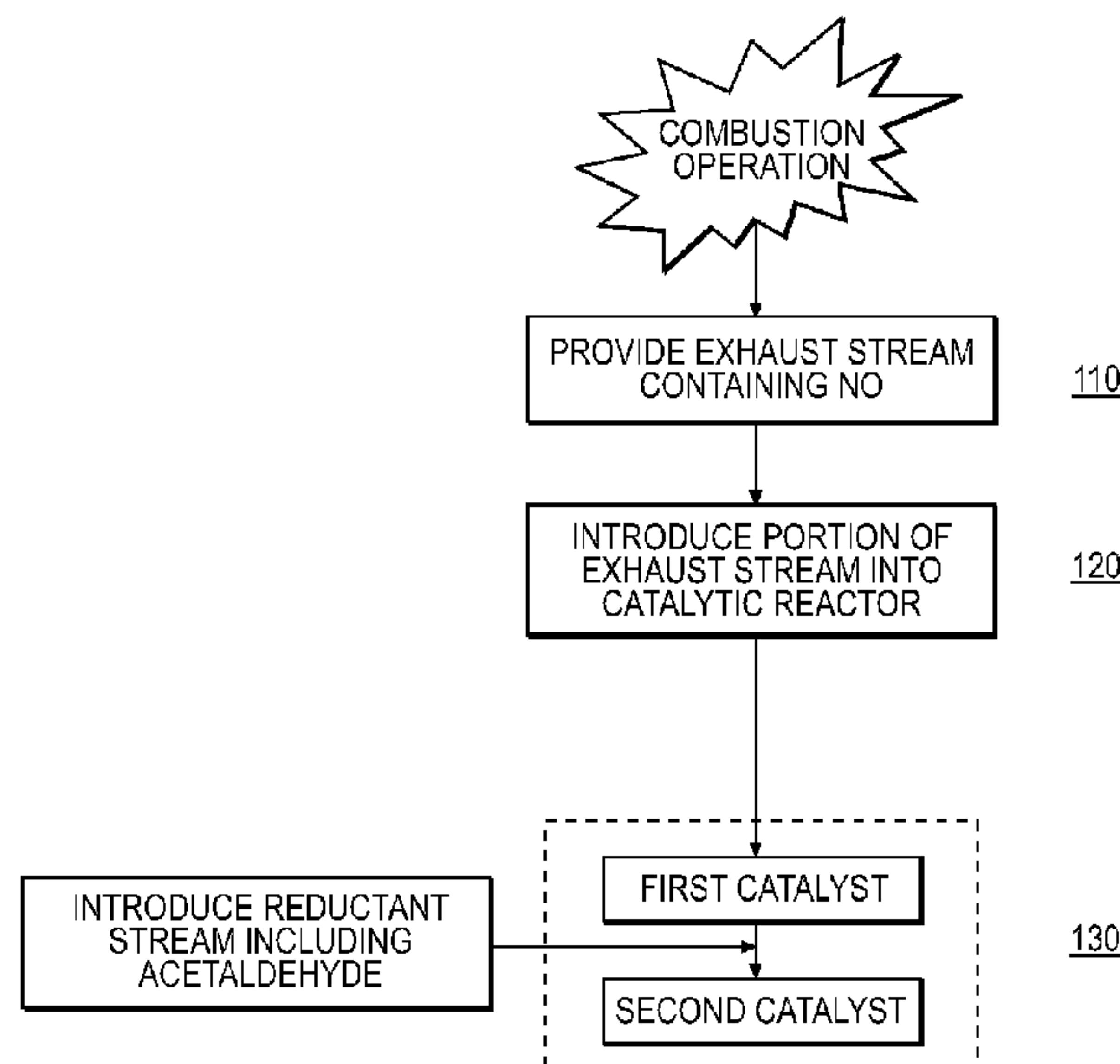




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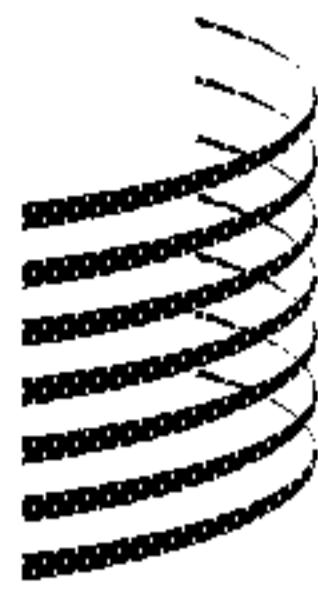
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Methods and systems are provided for selective catalytic reduction of NO_x with a low molecular weight aldehyde, e.g., acetaldehyde, as a reductant using a catalyst system including two catalysts. An exhaust stream containing an amount of NO from a combustion operation is provided. A portion of the exhaust stream is introduced to a first catalyst to convert the NO to NO₂. The exhaust stream from the first catalyst with NO₂ and a reductant stream containing a low molecular weight aldehyde, e.g., acetaldehyde, are introduced to the second catalyst to convert the NO₂ to N₂. The first catalyst can be bulk CO₃O₄, Ru or Pt loaded on alumina; the second catalyst can be various zeolites, or zeolites loaded with potassium.

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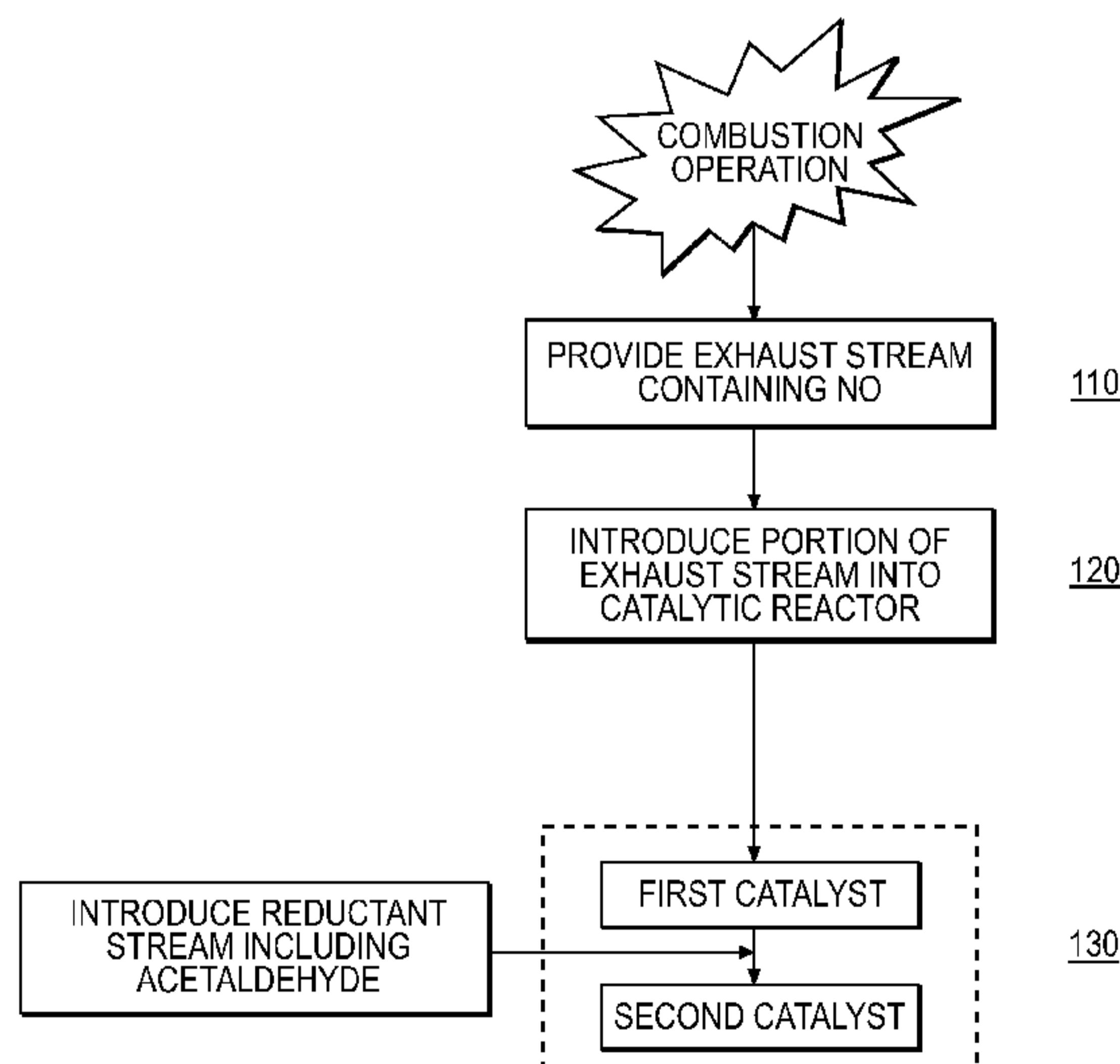
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(54) Title: CATALYTIC REDUCTION OF NO_x WITH HIGH ACTIVITY CATALYSTS WITH ACETALDEHYDE REDUCTANT



(57) Abstract: Methods and systems are provided for selective catalytic reduction of NO_x with a low molecular weight aldehyde, e.g., acetaldehyde, as a reductant using a catalyst system including two catalysts. An exhaust stream containing an amount of NO from a combustion operation is provided. A portion of the exhaust stream is introduced to a first catalyst to convert the NO to NO₂. The exhaust stream from the first catalyst with NO₂ and a reductant stream containing a low molecular weight aldehyde, e.g., acetaldehyde, are introduced to the second catalyst to convert the NO₂ to N₂. The first catalyst can be bulk CO₃O₄, Ru or Pt loaded on alumina; the second catalyst can be various zeolites, or zeolites loaded with potassium.

FIG. 1

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LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK,
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CATALYTIC REDUCTION OF NO_x WITH HIGH ACTIVITY CATALYSTS WITH ACETALDEHYDE REDUCTANT

BACKGROUND

Field

[0001] The presently disclosed subject matter relates to methods and systems for removing pollutant gases from the exhaust gas stream formed by a combustion process, such as internal combustion engines, furnaces, power plants, and so forth. Particularly, the disclosed subject matter is related to the use of zeolite catalysts loaded with various of metals for selective catalytic reduction of nitrogen oxides (NO_x) from the exhaust gases resulting directly or indirectly from a combustion process in the exploration, production, refining, manufacture, supply, transport, formulation or blending of petroleum, petrochemicals or the direct products thereof.

Description of Related Art

[0002] Combustion devices in commercial applications, such as those in the petroleum and petrochemical processing field, which includes the exploration, production, refining, manufacture, supply, transport, formulation or blending of petroleum, petrochemicals, or the direct products thereof, are a source of NO_x emissions. A continuing effort has been made over the years to develop methods and systems to remove pollutant gases from exhaust gases produced by combustion unit operations.

[0003] Increasingly stringent environmental regulations have been enacted world-wide in an effort to reduce the emission of pollutant gases into the atmosphere from combustion equipment used by numerous unit operations within a commercial operation. Of particular interest is the production of nitrogen oxides (NO_x).

[0004] Nitrogen oxides (NO_x) are produced, for example, when nitrogen reacts with oxygen within a combustion chamber under high temperature and pressure conditions. NO_x can also be produced, for example, in fluid catalytic converters (FCCs) and furnaces due to combustion of nitrogen from FCC feeds, heating oil, and/or fuel oil. Such nitrogen oxides can include either one or a combination of nitrogen monoxide and nitrogen dioxide.

[0005] Various selective catalytic reduction (SCR) methods have been developed in an effort to reduce NOx emissions. SCR is a catalytic technique to convert NOx to diatomic nitrogen, N₂, and water, H₂O. Typically, a fluid reductant—such as anhydrous ammonia, aqueous ammonia or urea—is added to a stream of exhaust gas and absorbed onto a catalyst.

[0006] However, such known techniques can be expensive to operate and/or may have limited capacity or efficiency. As such, there is a continued need for improved methods and apparatus for removing NOx from the exhaust gas stream of a combustion device, particularly those found in chemical processing and/or petrochemical refining operations.

SUMMARY OF THE INVENTION

[0007] In accordance with one aspect of the disclosed subject matter, a method for selective catalytic reduction of NOx is provided. The method includes providing an exhaust stream from a combustion operation, the exhaust stream containing an amount of NO. At least a portion of the exhaust stream is introduced to a first catalytic reactor comprising a first catalyst at suitable operating conditions to convert an amount of NO in the exhaust stream to NO₂. The first catalyst is selected from the group consisting of bulk Co₃O₄, Ru loaded on a metal oxide, and Pt loaded on a metal oxide. The exhaust stream with NO₂ from the first catalyst and a reductant stream including a low molecular weight aldehyde (e.g., acetaldehyde) are directed to a second catalyst including a zeolite at suitable operating conditions to reduce at least a portion of the NO₂ to N₂. In some embodiments, the first catalytic reactor includes a vessel or similar structure, and the second catalyst is within the structure of the first catalytic reactor. In other embodiments, the second catalyst is in a second catalytic reactor located downstream of the first catalytic reactor.

[0008] The source of the exhaust stream can be a refinery component, selected from the group consisting of a combustion furnace, a boiler, a heater turbine, and a fluid catalytic cracking unit. The first catalytic reactor can be located near a flue of the at least one refinery component to maintain the first catalytic reactor at an operating temperature between about 200 °C and 400 °C. Alternatively, the first catalytic reactor can be maintained at an operating temperature between about 200 °C and 400 °C by heating or cooling the exhaust stream.

[0009] The exhaust stream can about 0.1% to about 20% oxygen, e.g., about 2% to about 9% oxygen, and about 1% to about 10% water, e.g., about 5% water. The operating temperature of the first catalytic reactor can be between about 200 °C and about 400 °C, for example, at about 300 °C. In some embodiments, the operating temperature of the second catalyst can be about 200 °C to about 300 °C. The ratio of acetaldehyde in the reductant stream and NO₂ from the first catalyst can be about 0.5 to 4.

[0010] In some embodiments, the first catalyst comprises 2 wt. % Ru loaded on alumina, 2 wt. % Pt loaded on alumina. In certain embodiments, the second catalyst includes a zeolite selected from the group consisting of ZSM-57, MCM-68, ZSM-5B, Mordenite, Chabazite, ZSM-35, MCM-49, ZSM-11, ZSM-5C, MCM-22, USY, ZSM-48, Beta. In a representative embodiment, the second catalyst comprises Beta loaded with potassium. In another representative embodiment, the second catalyst comprises ZSM-5C loaded with potassium.

[0011] The exhaust stream from the second catalyst can include a residual amount of NO_x, and the exhaust stream with the residual amount of NO_x can be recycled to the first catalytic reactor.

[0012] In accordance with another aspect of the disclosed subject matter, a system for selective catalytic reduction of NO_x is provided. The system includes a conduit in fluid communication with a source of an exhaust stream from a combustion operation, the exhaust stream containing an amount of NO; a first catalytic reactor in fluid communication with the conduit and the source of the reductant stream, the first catalytic reactor comprising a first catalyst selected from the group consisting of bulk Co₃O₄, Ru loaded on a metal oxide, and Pt loaded on a metal oxide; an outlet in fluid communication with the first catalytic reactor to direct the NO_x treated exhaust stream from the first catalytic reactor; a second catalyst including a zeolite, the second catalyst in fluid communication with the first catalyst; and a reductant feedline in fluid communication with the second catalyst to introduce a reductant stream including a low molecular weight aldehyde to the second catalyst. In one embodiment, the low molecular weight aldehyde is acetaldehyde. In some embodiments, the first catalytic reactor includes a vessel or similar structure, and the second catalyst is within the structure of the first catalytic reactor. In other embodiments, the second catalyst

is in a second catalytic reactor located downstream of the first catalytic reactor. The various embodiments regarding the source of the exhaust stream, the operating conditions of the first catalytic reactor, the first and second catalysts, and other parameters of the method discussed above are also applicable to the system disclosed herein.

BRIEF DESCRIPTION OF THE DRAWINGS

[0013] **Fig. 1** is a flow diagram of a method for NOx reduction according to an embodiment of the disclosed subject matter.

[0014] **Fig. 2A** is a schematic diagram of a system for NOx reduction according to an embodiment of the disclosed subject matter.

[0015] **Fig. 2B** is a schematic diagram of a system for NOx reduction according to an alternative embodiment of the disclosed subject matter.

DETAILED DESCRIPTION

[0016] As used herein, the term “NOx” refers generally to a compound consisting of nitrogen and at least one oxygen molecule, and particularly to one or more of nitrogen monoxide, nitrogen dioxide and di-nitrogen or nitrous oxide. As used herein, the term “NOx-reduced stream” includes a fluid stream having a reduction of such nitrogen monoxide, nitrogen dioxide, and nitrous oxide.

[0017] As used herein, the term “combustion operation” refers to any process wherein an energy-storing material is burned to produce energy or other byproduct. For example, a “combustion operation” can include a unit operation within a commercial operation or the like in which NOx is emitted as the result of a combustion reaction. A combustion operation can include, but is not limited to, the operation of a combustion engine, furnace, boiler, heater and a turbine. A combustion operation can further include a fluid catalytic converter (“FCC”) regenerator operation, in which NOx is found in a FCC regenerator exhaust stream.

[0018] As used herein, the term “GHSV” refers to term "gaseous hourly space velocity" and is the ratio of the gaseous volumetric flow rate, at standard conditions of 60° F and one atmosphere of pressure, to the catalyst volume.

[0019] As used herein, the term “commercial operation” refers to any operation in which a commodity (e.g., electricity), chemical, petroleum or other article of commercial interest (including a chemical intermediate to an article of commerce interest) is manufactured, produced or otherwise provided. The term “commercial operation” can include the exploration, production, refining, manufacture, supply, transport, formulation or blending of petroleum, petrochemicals, or the direct products thereof. As embodied herein, the article of commercial interest can be manufactured, produced or otherwise provided in an industrial scale.

[0020] As used herein, the term “provided in an industrial scale” refers to a scheme in which, for example, gasoline or other product of commercial interest is produced on a generally continuous basis (with the exception of necessary outages for plant maintenance or upgrades) over an extended period of time (e.g., over at least a week, or a month, or a year) with the expectation or object of generating revenues from the sale or distribution of the product of commercial interest, regardless of whether for profit or not for profit. Production in an industrial scale is distinguished from laboratory or pilot plant settings which are typically maintained only for the limited period of the experiment or investigation, and are conducted for research purposes and not with the expectation of generating revenue from the sale or distribution of the end product produced thereby.

[0021] The term “about” as used herein in reference to quantitative measurements refers to a value one of ordinary skill in the art would consider equivalent to the recited value (i.e., having the same function or result), or a value that can occur, for example, through typical measurement and process procedures.

[0022] In accordance with one aspect of the disclosed subject matter, a method for selective catalytic reduction of NO_x is provided. The method includes providing an exhaust stream from a combustion operation, the exhaust stream containing an amount of NO. At least a portion of the exhaust stream is introduced to a first catalytic reactor comprising a first catalyst at suitable operating conditions to convert an amount of NO in the exhaust stream to NO₂. The first catalyst is selected from the group consisting of bulk Co₃O₄, Ru loaded on a metal oxide, and Pt loaded on a metal oxide. The exhaust stream with NO₂

from the first catalyst and a reductant stream including a low molecular weight aldehyde are directed to a second catalyst including a zeolite at suitable operating conditions to reduce at least a portion of the NO₂ to N₂.

[0023] In accordance with another aspect of the disclosed subject matter, a system for selective catalytic reduction of NO_x is provided. The system includes a conduit in fluid communication with a source of an exhaust stream from a combustion operation, the exhaust stream containing an amount of NO; a first catalytic reactor in fluid communication with the conduit and the source of the reductant stream, the first catalytic reactor comprising a first catalyst selected from the group consisting of bulk Co₃O₄, Ru loaded on a metal oxide, and Pt loaded on a metal oxide; an outlet in fluid communication with the first catalytic reactor to direct the NO_x treated exhaust stream from the first catalytic reactor; a second catalyst including a zeolite, the second catalyst in fluid communication with the first catalyst; and a reductant feedline in fluid communication with the second catalyst to introduce a reductant stream including a low molecular weight aldehyde to the second catalyst. In one embodiment, the low molecular weight aldehyde is acetaldehyde. In some embodiments, the second catalyst is within the first catalytic reactor. In other embodiments, the second catalyst is in a second catalytic reactor located downstream of the first catalytic reactor.

[0024] Particular embodiments of the method and system are described below, with reference to **Figs. 1** and **2**, for purposes of illustration, and not limitation. For purposes of clarity the method and system are described concurrently and in conjunction with each other.

[0025] In one embodiment, and with reference to **Figs. 1** and **2**, an exhaust stream **220** containing NO_x, in particular NO, is provided (**step 110**) from a combustion operation **210**. The combustion operation **210** can be any combustion operation that produces an exhaust stream containing NO_x. The combustion operation can be, for example, a combustion operation in a refining operation involving a refinery component. Such refinery component can include a combustion furnace, a boiler, a heater turbine, or a fluid catalytic cracking unit among others. The combustion operation generally has a flue or similar outlet, such that the exhaust stream **220** exits the combustion operation via the flue outlet.

[0026] The exhaust stream **220** can include other gases in addition to NOx. For example, the exhaust stream can include an amount of oxygen, water, and other byproducts of the combustion operation. In the refinery setting, for example, the exhaust stream can also contain trace amounts of hydrocarbons. For purpose of example and not limitation, the exhaust stream can include about 0.1% to about 20% oxygen, e.g., about 2% to about 9% oxygen, and about 1% to about 10% water, e.g., about 5% water.

[0027] The exhaust stream **220** is introduced (**step 120**) to a first catalytic reactor **230**. For example, and as depicted in **Fig. 2**, the first catalytic reactor **230** is in fluid communication with a conduit **231** extending from the source of the exhaust stream. The conduit **231** can be attached to the first catalytic reactor by suitable means and provided with a suitable inlet adapter as needed for flow of the exhaust stream to the first catalytic reactor **230**. For example, the conduit **231** can be threaded, welded, or otherwise attached to a port in the first catalytic reactor **230**. In one embodiment, the first catalytic reactor **230** is located proximate a refinery flue outlet of the at least one refinery component to maintain the first catalytic reactor at an operating temperature between about 200 °C and about 400 °C, as described further below. Alternatively, the exhaust stream **220** can first pass through one or more valves or treatment devices **270** prior to the first catalytic reactor **230**. For example, the exhaust stream can pass through a heat exchanger to control the temperature of the exhaust stream. Additionally or alternatively, a pump can be used to provide a desired flow rate to the first catalytic reactor.

[0028] As previously noted, and as embodied herein, the first catalytic reactor **230** can be a vessel or similar structure of suitable construction for the intended operating conditions, and includes a first catalyst **240** including bulk Co₃O₄, Ru loaded on a metal oxide, or Pt loaded on a metal oxide. The metal oxide can be alumina. The first catalyst **240** can be structurally arranged, for example, on catalyst beds or the like within the first catalytic reactor **230**. The first catalyst **240** can be in a variety of suitable structural or solid forms, such as powders, pellets, particles, washcoated or formed monoliths such as a honeycomb structure and the like, to allow the exhaust stream to contact the catalyst. The first catalyst **240** can be prepared using procedures known in the art. For example, γ -alumina substrate

can be prepared by a complexing agent-assisted sol gel method, followed by calcination. Ru or Pt can be loaded onto the γ -alumina via incipient wetness impregnation techniques, for example, using a precursor solution of the respective metal to impregnate alumina, followed by calcination at appropriate temperature to obtain the target level of loading. This is a conventional standard wet impregnation technique. For example, Ru or Pt can be loaded at about 2 wt. % based on the total weight of the first catalyst.

[0029] As the exhaust stream containing NO contacts the first catalyst at suitable operating conditions, at least a portion of the NO contained in the exhaust stream is oxidized to NO₂. The reactant NO and the product NO₂ in this phase can reach an equilibrium at the operating condition. The exhaust stream from the first catalyst containing NO₂ can be directed to a second catalyst **340**, thereby converting the NO₂ to N₂, as will be further described below.

[0030] As previously noted, a reductant stream **365** is also introduced (**step 130**) with the exhaust stream **250** to the second catalyst **340**. The reductant stream **365** includes an effective amount of low molecular weight aldehyde, such as acetaldehyde, to oxidize the NO₂ contained in the exhaust stream **250** from the first catalyst. In an exemplary embodiment, the amount of acetaldehyde in the reductant stream **365** can be an amount sufficient to provide about a 1:1 to 2:1 molar ratio of acetaldehyde to the NO₂ in the exhaust stream **250**. For example, if the amount of NO₂ in the exhaust stream **250** is 250 ppm, the amount of acetaldehyde in the reductant stream **365** can be between about 250-500 ppm.

[0031] As depicted in **Fig. 2A**, the second catalyst **340** is in a second catalyst reactor **330**. However, the second catalytic reactor can be provided within the same structure as the first catalytic reactor as shown with dotted lines in **Fig. 2A**. Alternatively, as depicted in **Fig. 2B**, the first catalyst and the second catalyst can be located in the same catalytic reactor, i.e., the first catalytic reactor. As used herein, a catalytic reactor is a structural element that includes one or more catalyst. As such, a catalytic reactor can include as a vessel or similar structure of suitable construction containing the desired catalyst. As illustrated in **Fig. 2A**, the second catalytic reactor **330** can be located downstream from the first catalytic reactor **230**, for example, at a distance downstream from the first catalytic reactor **230** such that the

operating temperature of the second catalytic reactor **330** can be cooler than that of the first catalytic reactor. Additionally or alternatively, the exhaust stream **250** with NO₂ can flow through a heat exchanger to achieve a desired temperature at the second catalytic reactor **330**.

[0032] If the first catalyst and the second catalyst are both in the first catalytic reactor as illustrated in **Fig. 2B**, the two catalysts can be arranged with the second catalyst in a relative downstream position. The first catalyst and the second catalyst can be stacked directly against each other, or have a gap therebetween. In this configuration, the reductant stream containing acetaldehyde can be introduced upstream of the second catalyst.

[0033] Depending on the configurations of the first catalyst and second catalyst, the operating temperature can be varied. For example, where both the first catalyst and the second catalyst are in the first catalytic reactor, as illustrated in **Fig. 2B**, the operating temperature of the first catalytic reactor **230** can be between about 200 °C and about 300 °C. Alternatively, if the first catalyst is in the first catalytic reactor and the second catalyst is in the second catalytic reactor, the operating temperature for each of the catalytic reactors can be same or different.

[0034] The reductant stream **365** can be provided by a reductant stream source **360**, such as a storage vessel for storing acetaldehyde. For example, acetaldehyde can be stored as a liquid, and can be first vaporized before being introduced to the first catalytic reactor. The second catalytic reactor **330** can have a port **334** in fluid communication with the reductant stream source **360** to receive the reductant stream **365**. The port **334** can include a valve, or a plurality of valves to regulate the flow rate of the reductant stream.

[0035] As noted above, the second catalyst **340** can include various zeolites including ZSM-57, MCM-68, ZSM-5B, Mordenite, Chabazite, ZSM-35, MCM-49, ZSM-11, ZSM-5C, MCM-22, USY, ZSM-48, Beta. In a representative embodiment, the second catalyst comprises Beta loaded with potassium. In another representative embodiment, the second catalyst comprises ZSM-5C loaded with potassium. The second catalyst **340** can be structurally arranged, for example, on catalyst beds or the like, and can be in the form of

powders, pellets, particles, washcoated or formed monoliths such as a honeycomb structure, and the like.

[0036] Similar to the preparation of the first catalyst, the potassium-loaded second catalyst can be prepared by permeating into the zeolite an amount of a potassium containing salt solution. The potassium-modified zeolite is then calcinated in air to obtain between 0.2% and 2% weight loading of the potassium.

[0037] The desired operating temperature of the first catalytic reactor (and/or the second catalytic reactor, if present) can be obtained in various ways. Combustion operations, such as in refinery equipment, often produce flue gas in the temperature range above 500 °C. As such, and in one embodiment, the operating temperature of the first catalytic reactor **230** can be maintained at the desired range or value by locating the first catalytic reactor **230** downstream from the combustion operation **210** at a location where the exhaust stream **220** is expected to have such a temperature range or value. For example, this location can be downstream of the combustion operation **210**, with the exhaust stream **220** exiting the combustion operation **210** and flowing through the conduit **231** to the first catalytic reactor **230** after the exhaust stream has lost certain amount of thermal energy. Alternatively, the desired operating temperature can be maintained with the use of a heat exchanger **270** or the like. The heat exchanger **270** can be located downstream from the exhaust flue source (i.e., the flue of the combustion operation **210**) and upstream from the first catalytic reactor **230**. Various mechanisms and devices for modulating the temperature of a flue gas are known. For example, an air heater or economizer can be disposed in the stream. In some embodiments, the heat exchanger uses byproduct heat or thermal energy from the refinery for increased efficiency. Other suitable devices and techniques can also be suitable to maintain the operating temperature.

[0038] The flow rate of the exhaust stream **220** through the first catalytic reactor **230** (and/or the second catalytic reactor, if present) can be controlled or maintained at a desired level through the first catalytic reactor **230** to utilize or maximize the capacity of the first (and/or the second) catalytic reactor. For example, flow regulators and/or pumps or the like, such as an induced-draft fan can be disposed in fluid communication with the system

disclosed herein to maintain a desired flow rate through the first catalytic reactor **230**. With reference to the disclosed system and method, the GHSV can be, for example, between about 30K cc per hour and about 120K cc per hour based on catalyst provided in powder form. Likewise, the GHSV can be least 5000 cc per hour, for example where the catalyst is provided on washcoated or bulk monoliths..

[0039] The NOx-reduced exhaust stream **350** (in **Fig. 2A**, or **250**, in **Fig. 2B**) can be directed away from the second catalyst through the outlet conduit **332** (in **Fig. 2A**, or **232** in **Fig. 2B**). The further reduced NOx-reduced exhaust stream can then be released into the atmosphere, for example through a stack.

EXAMPLES

[0040] The present application is further described by means of the examples, presented below. The use of such examples is illustrative only and in no way limits the scope and meaning of the invention or of any exemplified term. Likewise, this application is not limited to any particular preferred embodiments described herein. Indeed, many modifications and variations of the invention will be apparent to those skilled in the art upon reading this specification. The invention is to be understood by the terms of the appended claims along with the full scope of equivalents to which the claims are entitled.

[0041] In a first example, a gas mixture consisting of about 250 ppm of NO, about 2% O₂, and about 5% H₂O is treated with a first catalyst as described above. The total flow rate is such that the GHSV ranged from 30K to 120K cc per hour. The operating temperature is about 300 °C.

Table 1

First Catalyst	NO Conversion to NO ₂ (%)
Bulk Co ₃ O ₄	89.1
2% Ru on Al ₂ O ₃	84.3
2% Pt on Al ₂ O ₃	82.4

[0042] In a second example, a gas mixture consisting of about 250 ppm of NO₂, about 2% O₂, and about 5% H₂O is treated with a second catalyst as described above by a reductant stream containing about 250 ppm of acetaldehyde to reduce the NO₂ to N₂. The total flow rate is such that the GHSV ranged from 30K to 120K cc per hour. The operating temperature is about 250 °C. The second catalyst can be in a second catalytic reactor located downstream of the first catalytic reactor containing the first catalyst, or the second catalyst can be stacked in series in a same catalytic reactor within which the first catalyst is located, with the first catalyst positioned relatively upstream of the second catalyst. The results of NO₂ reduction are shown in Table 2 below for different catalyst.

Table 2

Second Catalyst	NO ₂ Reduction (%)
ZSM-57	69
MCM-68	65
ZSM-5B	64
Modenite	52
Chabazite	47
ZSM-35	45
MCM-49	41
ZSM-11	41
ZSM-5C	38
MCM-22	37
USY	31
ZSM-48	27
Beta	24
ZSM-12	11

[0043] NO₂ reduction can be improved by addition of potassium to the H form zeolites above. The results are demonstrated in **Table 3** at two different levels of acetaldehyde concentration.

Table 3

Acetaldehyde Concentration	Second Catalyst	Operating Temperature °C	NO ₂ Reduction (%)
250 ppm	K ⁺ on Beta	200	54
	K ⁺ on Beta	250	55
	K ⁺ on Beta	300	44
	Beta	200	18
	Beta	250	24
	Beta	300	22
500 ppm	K ⁺ on Beta	200	78
	K ⁺ on Beta	250	83
	K ⁺ on Beta	300	67
	Beta	200	47
	Beta	250	42
	Beta	300	24
250 ppm	K ⁺ on ZSM-5C	200	66
	K ⁺ on ZSM-5C	250	66
	K ⁺ on ZSM-5C	300	60
	ZSM-5C	200	43
	ZSM-5C	250	38
	ZSM-5C	300	37
500 ppm	K ⁺ on ZSM-5C	200	79
	K ⁺ on ZSM-5C	250	79
	K ⁺ on ZSM-5C	300	79
	ZSM-5C	200	68
	ZSM-5C	250	51
	ZSM-5C	300	33

* * *

[0044] The presently disclosed subject matter is not to be limited in scope by the specific embodiments described herein. Indeed, various modifications of the invention in addition to those described herein will become apparent to those skilled in the art from the foregoing description and the accompanying figures. Such modifications are intended to fall within the scope of the appended claims.

CLAIMS:

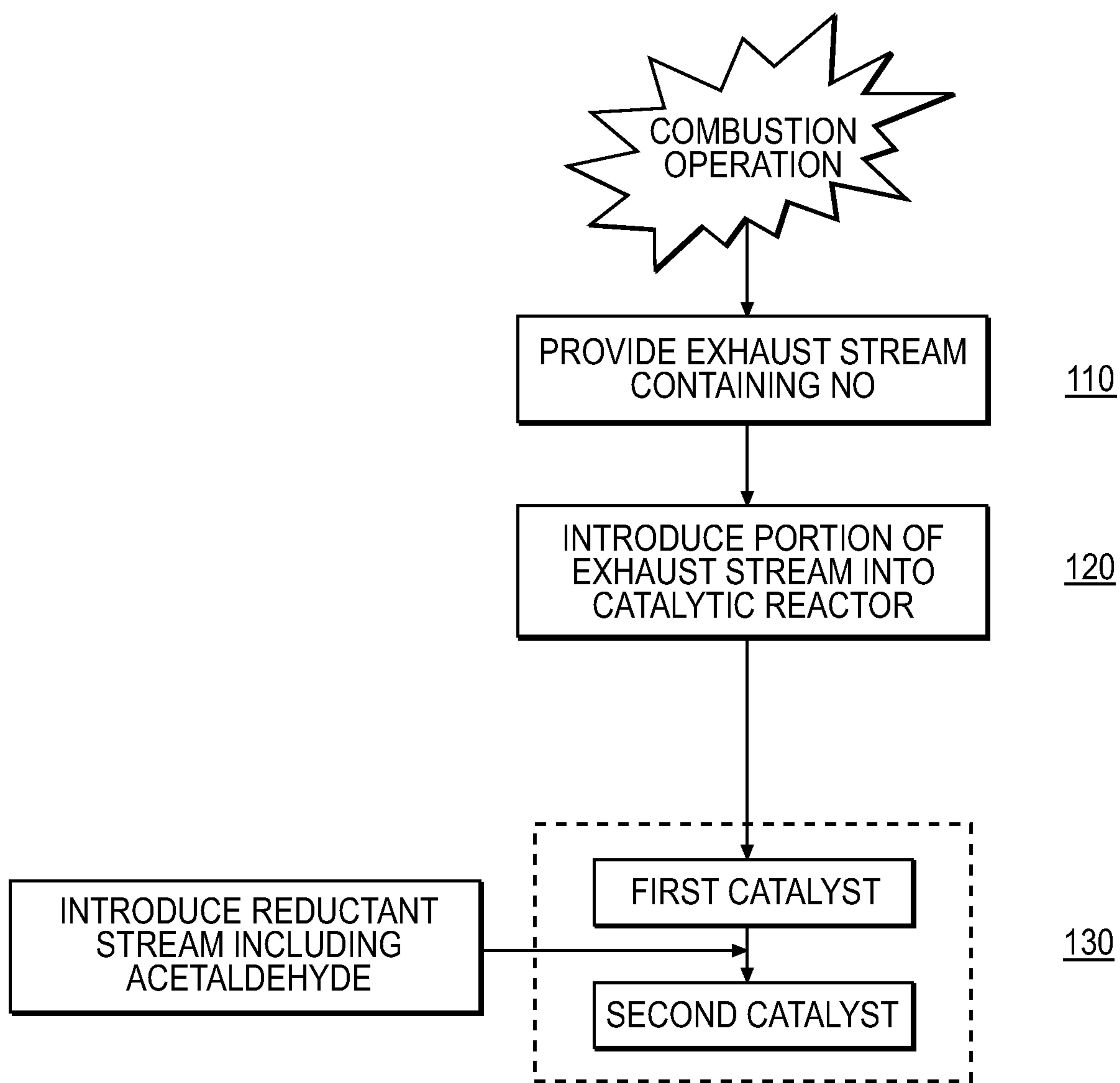
1. A method for selective catalytic reduction of NO_x comprising:
 - providing an exhaust stream from a combustion operation, the exhaust stream containing an amount of NO;
 - introducing at least a portion of the exhaust stream to a first catalytic reactor comprising a first catalyst at suitable operating conditions to convert an amount of NO in the exhaust stream to NO₂, wherein the first catalyst is selected from the group consisting of bulk Co₃O₄, Ru loaded on a metal oxide, and Pt loaded on a metal oxide;
 - directing the exhaust stream with NO₂ from the first catalyst and a reductant stream including a low molecular weight aldehyde to a second catalyst including a zeolite at suitable operating conditions to reduce at least a portion of the NO₂ to N₂.
2. The method of claim 1, wherein the first catalytic reactor includes a vessel, and the second catalyst is within the vessel of the first catalytic reactor.
3. The method of claim 1, wherein the second catalyst is in a second catalytic reactor located downstream of the first catalytic reactor.
4. The method of claim 1, wherein the low-molecular aldehyde is acetadehyde.
5. The method of claim 4, wherein the exhaust stream includes between about 0.1 % and about 20 % oxygen and about 1% to about 10 % water.
6. The method of claim 4, wherein the operating temperature of the first catalytic reactor is between about 150 °C and about 450 °C.
7. The method of claim 4, wherein the operating temperature of the first catalytic reactor is about 300 °C.

8. The method of claim 4, wherein the operating temperature of the second catalyst is about 150 °C to about 400 °C.
9. The method of claim 4, wherein the molar ratio of acetaldehyde in the reductant stream and NO₂ from the first catalyst is about 0.5 to about 4.
10. The method of claim 4, wherein the first catalyst comprises 2 wt. % Ru loaded on alumina.
11. The method of claim 4, wherein the first catalyst comprises 2 wt. % Pt loaded on alumina.
12. The method of claim 4, wherein the second catalyst include a zeolite selected from the group consisting of ZSM-57, MCM-68, ZSM-5B, Mordenite, Chabazite, ZSM-35, MCM-49, ZSM-11, ZSM-5C, MCM-22, USY, ZSM-48, Beta.
13. The method of claim 4, wherein the second catalyst comprises Beta loaded with potassium.
14. The method of claim 4, wherein the second catalyst comprises ZSM-5C loaded with potassium.
15. The method of claim 1, wherein the exhaust stream from the second catalyst includes a residual amount of NO_x, the method further comprising recycling the exhaust stream with the residual amount of NO_x to the first catalytic reactor.
16. The method of claim 1, wherein the exhaust stream is provided from at least one refinery component selected from the group consisting of a combustion furnace, a boiler, a heater turbine, and a fluid catalytic cracking unit.

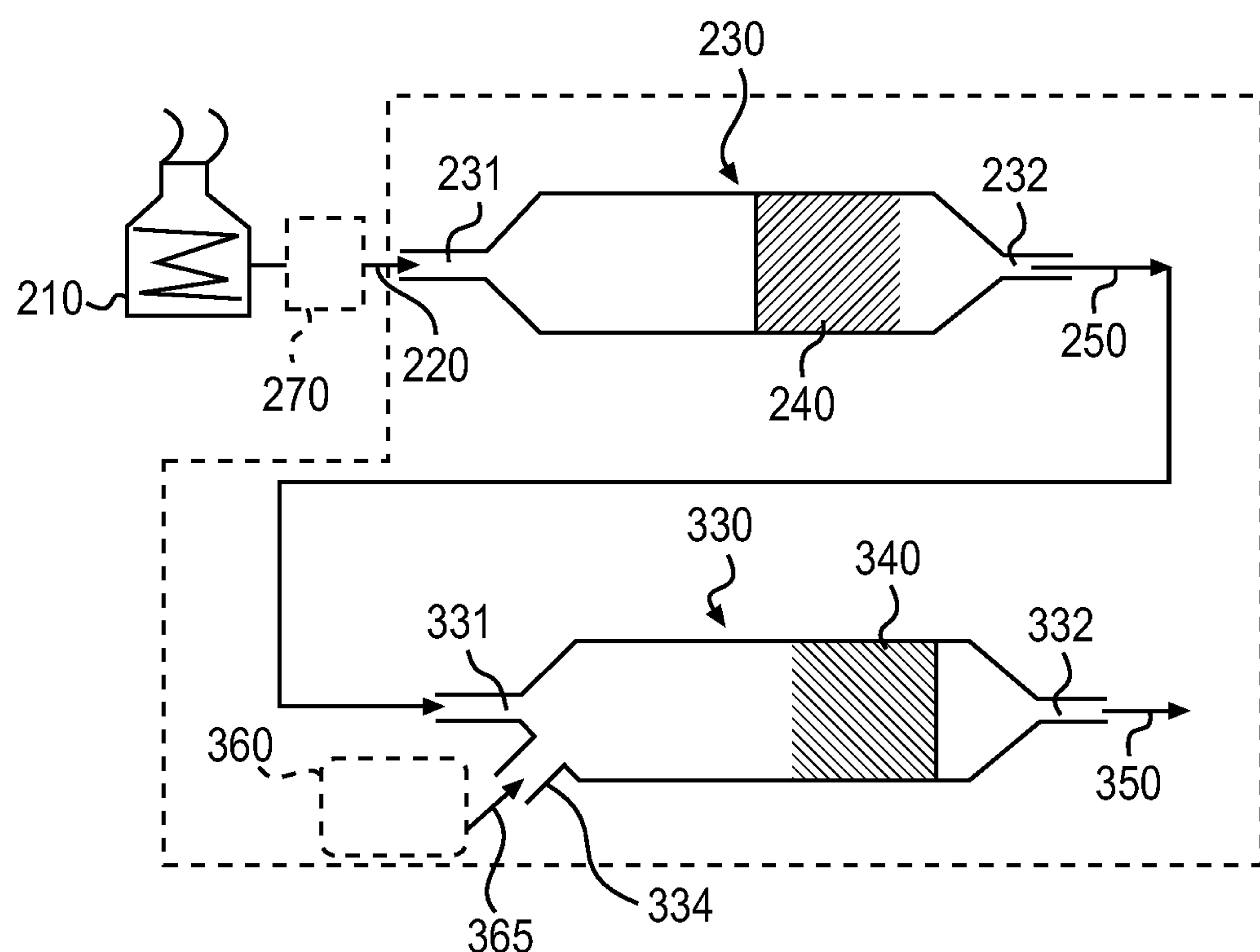
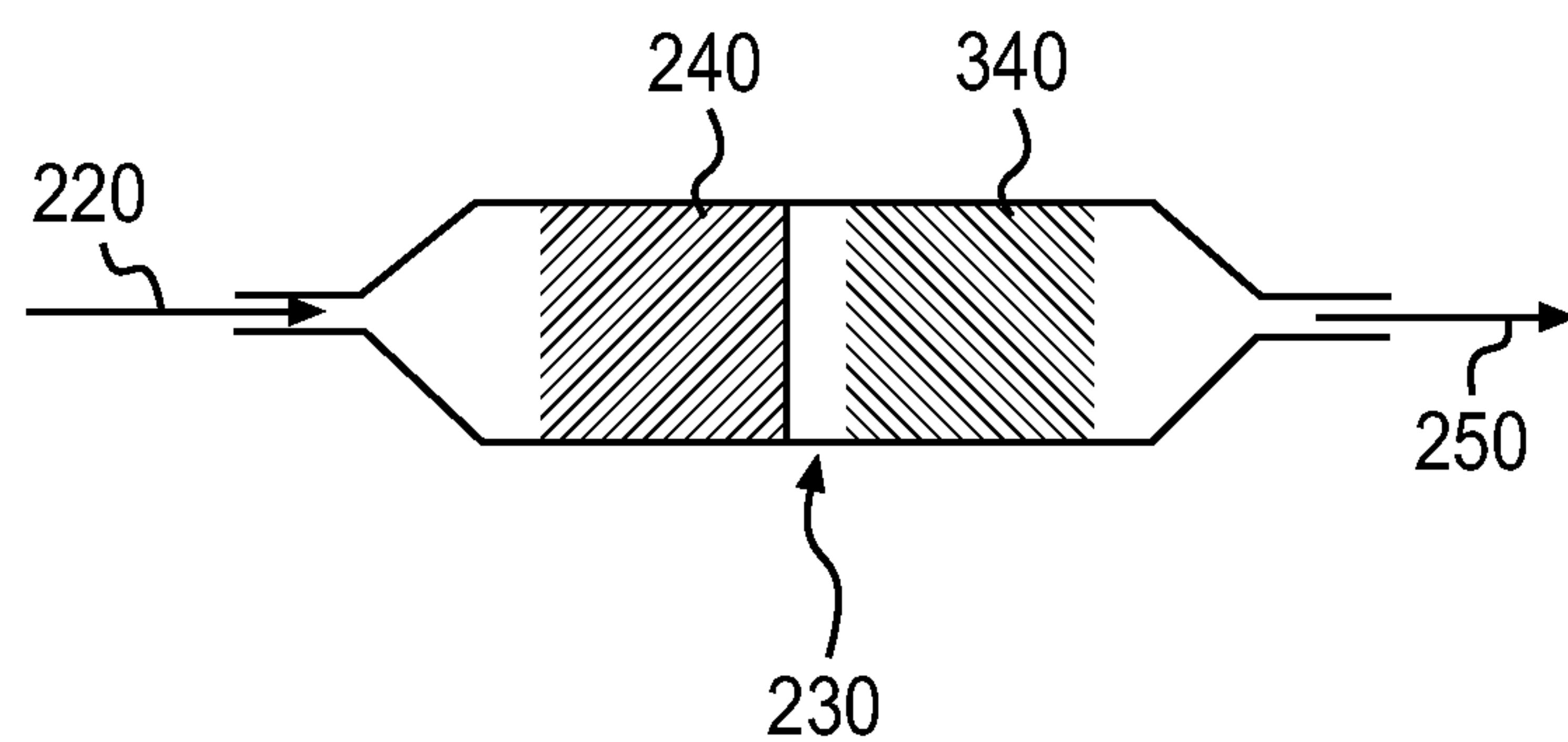
17. The method of claim 16, wherein the first catalytic reactor is located relative a refinery flue of the at least one refinery component to maintain the first catalytic reactor between 200 °C and 400 °C.
18. The method of claim 1, wherein the operating temperature of the first catalytic reactor is maintained between 200 °C and 400 °C by heating or cooling the exhaust stream.
19. A system for selective catalytic reduction of NOx comprising:
 - a conduit in fluid communication with a source of an exhaust stream from a combustion operation, the exhaust stream containing an amount of NO;
 - a first catalytic reactor in fluid communication with the conduit and a source of a reductant stream, the first catalytic reactor comprising a first catalyst selected from the group consisting of bulk Co₃O₄, Ru loaded on a metal oxide, and Pt loaded on a metal oxide;
 - an outlet in fluid communication with the first catalytic reactor to direct a NOx treated exhaust stream from the first catalytic reactor;
 - a second catalyst including a zeolite, the second catalyst in fluid communication with the first catalyst; and
 - a reductant feedline in fluid communication with the second catalyst to introduce the reductant stream including a low molecular weight aldehyde to the second catalyst.
20. The system of claim 19, wherein the first catalytic reactor includes a vessel, and the second catalyst is within the vessel of the first catalytic reactor.
21. The system of claim 19, wherein the second catalyst is in a second catalytic reactor located downstream of the first catalytic reactor.
22. The system of claim 19, wherein the low-molecular aldehyde is acetaldehyde.

23. The system of claim 19, wherein the first catalyst comprises 2 wt. % Ru loaded on alumina.
24. The system of claim 19, wherein the first catalyst comprises 2 wt. % Pt loaded on alumina.
25. The system of claim 19, wherein the second catalyst include a zeolite selected from the group consisting of ZSM-57, MCM-68, ZSM-5B, Mordenite, Chabazite, ZSM-35, MCM-49, ZSM-11, ZSM-5C, MCM-22, USY, ZSM-48, Beta.
26. The system of claim 19, wherein the second catalyst comprises Beta loaded with potassium.
27. The system of claim 19, wherein the second catalyst comprises ZSM-5C loaded with potassium.
28. The system of claim 19, wherein the source of the exhaust stream is a refinery component selected from the group consisting of a combustion furnace, a boiler, a heater turbine, and a fluid catalytic cracking unit.
29. The system of claim 28, wherein the first catalytic reactor is located downstream from a flue of the refinery component to maintain the first catalytic reactor between about 200 °C and about 400 °C.
30. The system of claim 19, further comprising a heat exchanger operatively coupled to heat the exhaust stream to maintain the first catalytic reactor at a temperature of between about 200 °C and about 400 °C.

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**FIG. 1**

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**FIG. 2A****FIG. 2B**

