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(54) Title: PREPARATION OF CATIONIC SURFACTANTS

(57) Abstract: Compositions that include cationic surfactants and methods of synthesizing compositions that include cationic surfactants. The surfactants include a quaternary amine and a saturated or unsaturated alkyl chain with 4 to 28 carbons. The surfactants can be generated by reacting a fatty acid modified with an amino alkyl group and an epihalohydrin in the presence of a base. The cationic surfactants can be generated by reacting a fatty acid modified with an amino alkyl group, an epihalohydrin, and a carboxylic acid. The cationic surfactants can be generated by reacting a carboxylic acid, an epihalohydrin, and a catalyst to afford a halo-substituted alkyl ester, followed by reacting the halo-substituted alkyl ester with a fatty acid modified with an amino alkyl group.



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PREPARATION OF CATIONIC SURFACTANTS

CLAIM OF PRIORITY

[0001] This application claims priority to U.S. Patent Application No. 16/942,565 filed on July 29, 2020, the entire contents of which are hereby incorporated by
5 reference.

TECHNICAL FIELD

[0002] This document relates to cationic surfactants and methods of preparation of cationic surfactants.

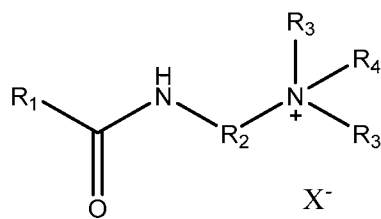
BACKGROUND

10 [0003] Surfactants are useful in many household and commercial applications. For example, new surfactants that are soluble and stable under harsh conditions would be useful in oil and gas recovery.

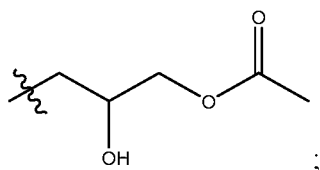
SUMMARY

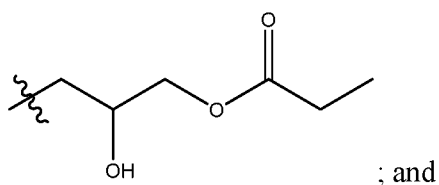
[0004] This disclosure describes cationic surfactants composed of erucyl
15 amidopropyl groups, with different head groups introduced by reaction with an epihalohydrin. This disclosure also describes one- and two-step methods of producing the cationic surfactants.

[0005] In some implementations, a composition includes a compound of Formula I:

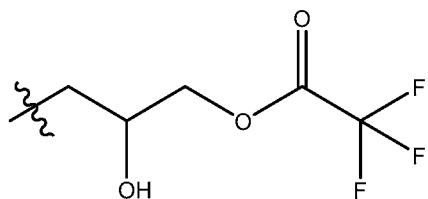


20 , where X is halide, R₁ is a saturated or unsaturated alkyl with 4 to 28 carbons, R₂ is alkyl, R₃ is methyl, and R₄ is selected from the group consisting of

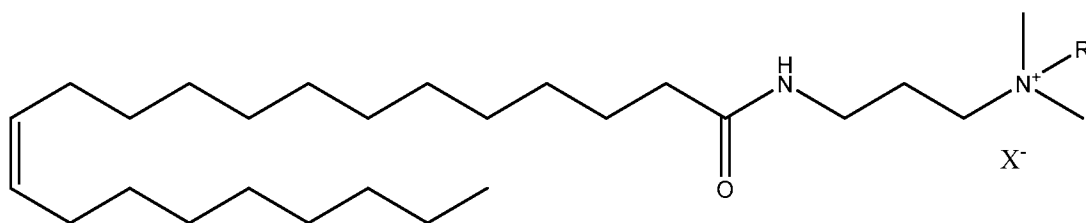




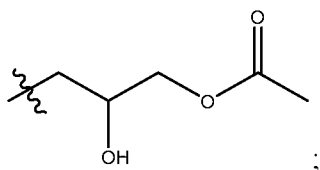
; and



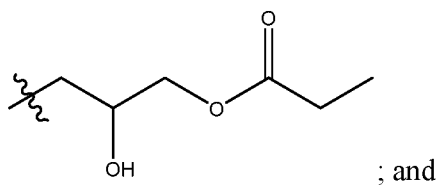
[0006] In some implementations, a composition includes a compound of Formula II:



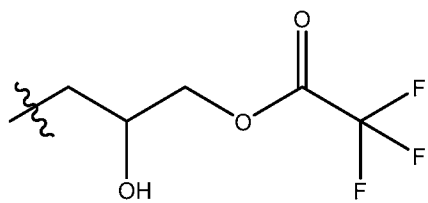
where R is selected from the group consisting of:



;



; and



10

, and where X is halide.

[0007] In some implementations, a process includes reacting a fatty acid modified with an amino alkyl group and an epihalohydrin, the presence of a base, to afford a cationic surfactant.

[0008] In some implementations, a process includes reacting a fatty acid modified with an amino alkyl group, an epihalohydrin, and a carboxylic acid to afford a cationic surfactant.

[0009] In some implementations, a process includes reacting a carboxylic acid, an epihalohydrin, and a catalyst to afford a halo-substituted alkyl ester. The process includes reacting the halo-substituted alkyl ester with a fatty acid modified with an amino alkyl group to afford a cationic surfactant. The details of one or more implementations of the disclosure are set forth in the accompanying drawings and the description that follows. Other features, objects, and advantages of the disclosure will be apparent from the description and drawings, and from the claims.

DESCRIPTION OF DRAWINGS

[0010] FIG. 1 shows an example structure of a cationic surfactant.

[0011] FIG. 2 is a flow chart of an example method for the quaternization of a tertiary amine.

[0012] FIG. 3 is an example reaction of N, N-dimethyl-erucyl-1,3-propylenediamine with epichlorohydrin.

[0013] FIG. 4 is a flow chart of an example method of a two-step synthesis of cationic surfactants.

[0014] FIG. 5A is an example reaction of a carboxylic acid and epichlorohydrin, catalyzed by tetrabutylammonium bromide.

[0015] FIG. 5B is an example reaction of N,N-dimethyl-erucyl-1,3-propylenediamine with the chloro-hydroxyl alkyl ester synthesized in FIG. 5A.

[0016] FIG. 6 is a flow chart of an example method of a one-step synthesis of cationic surfactants.

[0017] FIG. 7 is an example reaction of N,N-dimethyleerucyl-1,3-propylenediamine, a carboxylic acid, and epichlorohydrin.

[0018] FIG. 8 is an example IR spectrum of erucyl amidopropyl-2,3-dihydroxypropyl ammonium chloride.

[0019] FIG. 9 is an example ¹HNMR spectrum of erucyl amidopropyl-2,3-dihydroxypropyl ammonium chloride.

[0020] FIG. 10 is an example IR spectrum of erucyl amidopropyl-2-hydroxy-3-acetoxypromyl ammonium chloride.

[0021] FIG. 11 is an example ^1H NMR spectrum of erucyl amidopropyl-2-hydroxy-3-acetoxypentyl ammonium chloride.

[0022] FIG. 12 is an example IR spectrum of erucyl amidopropyl-2-hydroxy-3-(2, 2 – trifluoroacetoxy) pentyl ammonium chloride.

5 [0023] FIG. 13 is an example ^1H NMR spectrum of erucyl amidopropyl-2-hydroxy-3-(2, 2, 2 – trifluoroacetoxy) pentyl ammonium chloride.

[0024] FIG. 14 is an example IR spectrum of erucyl amidopropyl-2-hydroxy-3-propionyloxy pentyl ammonium chloride.

10 [0025] FIG. 15 is an example ^1H NMR spectrum of erucyl amidopropyl-2-hydroxy-3-propionyloxy pentyl ammonium chloride.

[0026] Like reference symbols in the various drawings indicate like elements.

DETAILED DESCRIPTION

[0027] Reference will now be made in detail to certain embodiments of the disclosed subject matter, examples of which are illustrated in part in the accompanying
15 drawings. While the disclosed subject matter will be described in conjunction with the enumerated claims, it will be understood that the exemplified subject matter is not intended to limit the claims to the disclosed subject matter.

[0028] Provided in this disclosure, in part, are cationic surfactants and methods of producing cationic surfactants. These surfactants are useful in enhanced oil recovery
20 applications. For example, many carbonate reservoirs have high temperatures and high brine salinity. Currently available surfactants and polymers have limited utility in these high temperature, high salinity formations. Accordingly, it is essential to develop new surfactants that are stable and useful at high temperature and high salinity situations. In addition, the surfactants with ultra-low interfacial tension, for example
25 tension below 10^{-3} mN/m, are useful for releasing trapped oil in a reservoir. Accordingly, there is a need for surfactants that are stable at high temperature and high salinity formations that also display low or ultra-low interfacial tension with brine solutions.

[0029] FIG. 1 shows the structure of an example cationic surfactant. In some
30 implementations, the surfactants include a hydrophobic tail R_a , an alkyl spacer where $n = 1$ to 6, and a cationic amine with two methyl groups and a functional group R_c . The resulting cationic surfactants, described in more detail below, are stable in high

temperature and high salinity environments. Accordingly, these surfactants are useful in drilling and oil recovery applications, for example, for chemical flooding in a carbonate wellbore.

[0030] In some implementations, the hydrophobic tail R_a is derived from a saturated or unsaturated fatty acid with 4 to 28 carbons. The fatty acid tail can be branched, unbranched, saturated, or unsaturated in either a cis- or trans- configuration. The properties of the fatty acid tail can influence the properties of the surfactant, for example, by influencing the melting point, stability, solubility, or the critical micelle concentration of the surfactants in seawater.

[0031] In some implementations, the surfactants include ultra-long fatty acid chains, for example chains of 18 or more carbons. In some implementations, the fatty tail can be derived from erucic acid, a monounsaturated C22:1 ω 9 fatty acid. Ultra-long fatty acid chains are very hydrophobic and typically not soluble in high salinity environments. However, the cationic surfactants described in this application have low interfacial tension and can be used in high salinity environments.

[0032] In some implementations, the fatty acid head group is modified with an alkyl spacer. For example, the carboxylic acid head group of a fatty acid can be reacted with an alkyl amine to form an amide bond between an alkyl spacer and a fatty acid. The alkyl spacer can be saturated alkyl group containing 1 to 6 carbons. For example, the spacer can be a propyl group. In some implementations, the spacer can include a tertiary amine functional group. This tertiary amine can be quaternized. For example, the reaction between a tertiary amine and an epihalohydrin results in a quaternary amine.

[0033] Quaternization of the tertiary amine introduces functional group R_c and results in the cationic surfactant. The positively charged amine of the cationic surfactant influences the solubility and stability of the surfactants. For example, in high-salinity environments the cation can reduce surfactant adsorption in carbonate reservoirs. The cation can also improve the stability of the surfactant at high salinity environments, for example in brines with high concentrations of divalent ions such as Ca^{2+} and Mg^{2+} .

[0034] Quaternization of the tertiary amine can be achieved by a reaction with an epihalohydrin. For example, epichlorohydrin can quaternized the tertiary amine.

Other epihalohydrins can also quaternized the tertiary amine. This results in an amine functionalized with an epoxy group. Under basic conditions, the epoxy can hydrolyze, yielding a dihydroxy functional group.

[0035] FIG. 2 shows an example flow chart of a reaction scheme 200 for quaternization of a modified fatty acid. At 202, a fatty acid modified with a tertiary amine is combined with an epihalohydrin in a 1:1 molar ratio in a solvent. Suitable epihalohydrins include epichlorohydrin. At 204, the mixture is stirred, with heating, for 5-24 hours. At 206, the pH of the mixture is decreased to induce a basic condition. At 208, the solvent is removed from the mixture. At 210, the product is recrystallized. At 212, the final product is obtained by filtration.

[0036] An example of the reaction scheme 200 is shown in FIG. 3, where N, N-dimethyl-erucyl-1,3-propylenediamine is reacted with epichlorohydrin. This functionalizes the quaternary amine with an epoxide. Under basic conditions, the epoxide can hydrolyze, yielding a 1,2-dihydroxypropyl functional group. Recrystallization of the product results in the cationic surfactant erucyl amidopropyl-2,3-dihydroxypropyl ammonium chloride.

[0037] Cationic surfactants can also be synthesized using a two-step process 400. FIG. 4 shows an example flow chart of a reaction scheme 400 to synthesize cationic surfactants. At 402, a carboxylic acid is combined with an epihalohydrin at a 1.25:1 to 2:1 molar ratio in the presence of a catalyst. The choice of carboxylic acid can be used to introduce additional functional groups, such as hydroxyl, ester, or polymerizable groups such as a vinyl double bond. At 404, the mixture is stirred with heating for 5-20 hours. At 406, the pH of the mixture is adjusted to approximately 7. At 408, the mixture is filtered to obtain the halogenated alkyl ester product. At 410, the halogenated alkyl ester is mixed with a modified fatty acid that contains a tertiary amine. At 412, the mixture is refluxed for 5-24 hours. At 414, the solvent is removed. At 416, the product is recrystallized. At 418, the final product, the cationic surfactant, is obtained by filtering.

[0038] FIG. 5A shows an example reaction of the first step of the two-step process 400 between a carboxylic acid (COOR) and epichlorohydrin, catalyzed by tetrabutylammonium bromide (TBAB). Suitable carboxylic acids include, but are not limited to, acetic acid ($R = -CH_3$), trifluoroacetic acid ($R = -CF_3$), and propionic acid

(R = -CH₂-CH₃). FIG. 5B shows an example reaction of the second step of the two-step process 400, where N,N-dimethyl-erucyl-1,3,-propylenediamine is combined with the chloro-hydroxyl alkyl ester synthesized in FIG. 5A. This generates a cationic surfactant that is compatible with brine solutions and has low oil-brine interfacial tension.

[0039] In some implementations, the cationic surfactants can be synthesized using a one-step process. In the one-step process, a carboxylic acid, an epichlorohydrin, and an alkyl-modified fatty acid containing a tertiary amine are reacted to generate the cationic surfactant. FIG. 6 shows an example flow chart of a reaction scheme 600 for a one-step synthesis of cationic surfactants. At 602, a modified fatty acid that contains a tertiary amine is combined in solution with a carboxylic acid in a 1:1 molar ratio. At 604, the mixture is refluxed for 0.5 – 2 hours. At 606, an epichlorohydrin is added to the mixture, in a 1:1:1 ratio with the modified fatty acid and carboxylic acid. At 608, the mixture is stirred with heating for 5-24 hours. At 610, the solvent is removed. At 612, the product is recrystallized. At 614, the final product, the cationic surfactant, is obtained by filtering. FIG. 7 shows an example reaction of the one-step process 600, where N,N-dimethyleerucyl-1,3,-propylenediamine is combined with a carboxylic acid and epichlorohydrin to yield the cationic surfactant. Suitable carboxylic acids include, but are not limited to, acetic acid (R = -CH₃), trifluoroacetic acid (R = -CF₃), and propionic acid (R = -CH₂-CH₃).

[0040] Examples

[0041] Tables 1 and 2 summarize the reactants for the one- and two-step synthetic processes, described in more detail below.

[0042] Table 1: Summary of One-Step Processes, Examples 1, 3, 5, and 7

<i>Example</i>	1	3	5	7
<i>modified fatty acid</i>	N, N-dimethyl-erucyl-1, 3-propylenediamine	N, N-dimethyl-erucyl-1, 3-propylenediamine	N, N-dimethyl-erucyl-1, 3-propylenediamine	N, N-dimethyl-erucyl-1, 3-propylenediamine
<i>epoxide</i>	epichlorohydrin	epichlorohydrin	epichlorohydrin	epichlorohydrin
<i>carboxylic acid</i>	none – base to open epichlorohydrin ring	acetic acid	trifluoroacetic acid	propionic acid

[0043] Table 2: Summary of Two-Step Processes, Examples 2, 4, and 6

<i>Example</i>	2	4	6
<i>carboxylic acid</i>	acetic acid	trifluoroacetic acid	propionic acid
<i>epoxide</i>	epichlorohydrin	epichlorohydrin	epichlorohydrin
<i>catalyst</i>	TBAB	TBAB	TBAB
<i>fatty acid</i>	N, N-dimethyl-erucyl-1, 3-propylenediamine	N, N-dimethyl-erucyl-1, 3-propylenediamine	N, N-dimethyl-erucyl-1, 3-propylenediamine

[0044] Example 1: Synthesis of dihydroxyl group: Erucyl amidopropyl-2, 3-dihydroxypropyl ammonium chloride (C₂₂APDAC)

50 mmol of N, N-dimethyl-erucyl-1, 3-propylenediamine and 55 mmol of epichlorohydrin were dissolved in 30 mL of ethanol. The mixture was stirred at 65°C for 7 hours. Next, 50 mmol of NaOH was added to the mixture by adding 6.67 ml of 30 wt% NaOH solution, and the mixture was continuously stirred for 3 hours. After 3 hours, the ethanol solvent was removed under reduced pressure. The synthesized product was recrystallized in acetone and refrigerated at -15°C for 48 hours. Following refrigeration, a light yellow paste was obtained by filtering. The yield of erucyl amidopropyl-2-hydroxy-3-acetoxypyl ammonium chloride (C₂₂APDAC) was 76.1% by weight.

[0045] FIG. 8 shows an example infrared (IR) spectrum of C₂₂APDAC, confirming the structure of C₂₂APDAC as synthesized in Example 1. The wide absorption at 3290 cm⁻¹ is due to the -N-H stretching vibration and the -O-H stretching vibration. The peaks at 2921 cm⁻¹ and 2857 cm⁻¹ are the stretching vibrations of the -CH₃ and -C-H (-CH₂-) groups, respectively. The peak at 1651 cm⁻¹ is the -C=O stretching vibration of the amide group. The peak at 716 cm⁻¹ indicates the existence of the alkyl chain. Accordingly, the IR spectrum in FIG. 8 confirms the structure of C₂₂APDAC.

[0046] FIG. 9 is an example ¹HNMR spectrum of C₂₂APDAC, confirming the structure of C₂₂APDAC as synthesized in Example 1. C₂₂APDAC was analyzed at 400 MHz in deuterated methanol. The following spectral peaks were observed, wherein s is a singlet, t is a triple, and m is a multiplet: 0.91 (m, 3H, 1), 1.31 (s, 30H, 2), 1.62 (s, 2H, 3), 2.05 (m, 6H, 4), 2.21 (m, 2H, 5), 3.30 (m, 14H, 6), 4.25 (m, H, 7), 5.35 (t, 2H, 8). The ¹HNMR spectrum provides additional confirmation of the structure of C₂₂APDAC.

[0047] Example 2: Two-step synthesis of erucyl amidopropyl-2-hydroxy-3-acetoxypentyl ammonium chloride (C₂₂APHAAC)

250 mmol of acetic acid, 200 mmol of epichlorohydrin, and 6.25 mmol of tetrabutylammonium bromide (TBAB) were combined. The reaction mixture was heated to 90°C with stirring for 10 hours. After the reaction, the mixture was washed with saturated NaCl solution until the pH of the mixture was around 7. The remaining water in the mixture was removed using Na₂SO₄. The product was recovered by filtering the solid. The yield of 3-chloro-2-hydroxypropyl acetate was about 65% by weight.

[0048] 25 mmol of N, N-dimethyl-erucyl-1, 3-propylenediamine and 30 mmol of 3-chloro-2-hydroxypropyl alkyl ester were dissolved in 30 mL ethanol. The mixture was refluxed at 65°C for 10 hours. The solvent was then removed under reduced pressure using a rotary evaporator. The synthesized product was recrystallized with acetone and refrigerated at -15°C for 48 hours. Following refrigeration, a light yellow paste was obtained by filtering the solution. The yield of the ester cationic surfactant erucyl amidopropyl-2-hydroxy-3-acetoxypentyl ammonium chloride (C₂₂APHAAC) was 82.5% by weight.

[0049] Example 3: One-step synthesis of Erucyl amidopropyl-2-hydroxy-3-acetoxypentyl ammonium chloride (C₂₂APHAAC)

50 mmol of N, N-dimethyl-erucyl-1, 3-propylenediamine was mixed with 50 mmol of acetic acid in 10 mL of isopropanol. The mixture was heated to 95°C for 0.5 hours. 60 mmol of epichlorohydrin was added to the mixture. The mixture was then refluxed at 95°C for 7 hours. The solvent was removed under reduced pressure to yield a yellow, oily product. The synthesized product was recrystallized with acetone at -15°C for 24 hours. The purified product was obtained by filtering. The yield of the ester cationic surfactant C₂₂APHAAC was 84.85% by weight.

[0050] FIG. 10 shows an example IR spectrum of C₂₂APHAAC, confirming the structure of C₂₂APHAAC as synthesized in Example 3. The wide absorption at 3290 cm⁻¹ is due to the N-H stretching vibration and the -O-H stretching vibration. The peaks at 2927 cm⁻¹ and 2850 cm⁻¹ are considered to be the stretching vibration of -CH₃ and -C-H - (CH₂-) groups. The peak at 1744 cm⁻¹ is considered to be the -C=O stretching vibration of the ester group and the peak at 1651 cm⁻¹ is considered to be the

–C=O stretching vibration of the amide group. The peak at 726 cm⁻¹ indicates the existence of the alkyl chain. Accordingly, the IR spectrum confirms the structure of C₂₂APHAAC as synthesized in Example 3.

[0051] FIG. 11 shows an example ¹HNMR spectrum of C₂₂APHAAC, confirming the structure of C₂₂APHAAC as synthesized in Example 3. C₂₂APHAAC was analyzed at 400 MHz in deuterated methanol. The following spectral peaks were observed, wherein s is a singlet, t is a triple, and m is a multiplet: 0.91 (m, 3H, 1), 1.31 (s, 30H, 2), 1.62 (s, 2H, 3), 2.05 (m, 5H, 4), 2.22 (m, 2H, 5), 2.90 (m, 3H, 6), 3.32 (m, 14H, 7), 4.09 (t, 1H, 8), 5.35 (t, 2H, 9). The ¹HNMR spectrum provides additional confirmation of the structure of C₂₂APHAAC.

[0052] Example 4: Two-step synthesis of Erucyl amidopropyl-2-hydroxy-3-(2,2,2-trifluoroacetoxy) propyl ammonium chloride (C₂₂APHFAC)

C₂₂APHFAC was prepared with the same two-step method as Example 2, except with trifluoroacetic acid instead of acetic acid. 250 mmol of trifluoroacetic acid, 200 mmol of epichlorohydrin, and 6.25 mmol of tetrabutylammonium bromide (TBAB) were combined. The reaction mixture was heated to 90°C with stirring for 10 hours. After the reaction, the mixture was washed with saturated NaCl solution until the pH of the mixture was around 7. The remaining water in the mixture was removed using Na₂SO₄. The product was recovered by filtering the solid. The yield of 3-chloro-2-hydroxypropyl 2, 2, 2-trifluoroacetate was 70% by weight.

[0053] 25 mmol of N, N-dimethyl-erucyl-1, 3-propylenediamine and 30 mmol of 3-chloro-2-hydroxypropyl 2, 2, 2-trifluoroacetate were dissolved in 30 mL ethanol. The mixture was refluxed at 65°C for 10 hours. The solvent was then removed under reduced pressure. The synthesized product was recrystallized with acetone and refrigerated at -15°C for 48 hours. A light yellow paste was obtained by filtering the solution. The yield of the ester cationic surfactant C₂₂APHFAC was 82.5%.

[0054] Example 5: One-step synthesis of Erucyl amidopropyl-2-hydroxy-3-(2, 2, 2-trifluoroacetoxy) propyl ammonium chloride (C₂₂APHFAC)

C₂₂APHFAC was prepared by a one-step method with the same procedures as Example 3, except trifluoroacetic acid was used instead of acetic acid. 50 mmol of N, N-dimethyl-erucyl-1, 3-propylenediamine was mixed with 50 mmol of trifluoroacetic acid in 10 mL of isopropanol. The mixture was heated to 95°C for 0.5 hours. 60 mmol

of epichlorohydrin was added to the mixture. The mixture was then refluxed at 95°C for 7 hours. The solvent was removed under reduced pressure. The synthesized product was recrystallized with acetone at -15°C for 24 hours. The purified product was obtained by filtering. The yield of the ester cationic surfactant C₂₂APFAC was 70% by weight.

[0055] FIG. 12 shows an example IR spectrum of C₂₂APFAC, as synthesized in Example 5. The IR spectrum shows a wide absorption at 3348 cm⁻¹ due to the -N-H stretching vibration and the -O-H stretching vibration. The peaks at 2919 cm⁻¹ and 2845 cm⁻¹ are considered to be the stretching vibrations of -CH₃ and -C-H (-CH₂-) groups. The peak at 1682 cm⁻¹ is considered to be the -C=O stretching vibration of the ester group and the peak at 1652 cm⁻¹ is considered to be the -C=O stretching of the amide group. The peak at 726 cm⁻¹ indicates the existence of the alkyl chain.

Accordingly, the IR spectrum confirms the structure of C₂₂APFAC.

[0056] FIG. 13 shows an example ¹HNMR spectrum, confirming the structure of C₂₂APFAC as synthesized in Example 5. C₂₂APFAC was analyzed at 400 MHz in deuterated methanol. The following spectral peaks were observed, wherein s is a singlet, t is a triple, and m is a multiplet: 0.90 (m, 3H, 1), 1.31 (s, 30H, 2), 1.63 (s, 2H, 3), 2.05 (m, 7H, 4), 3.21 (m, 14H, 5), 4.09 (t, 1H, 6), 5.36 (t, 2H, 7). The ¹HNMR spectrum provides additional confirmation of the structure of C₂₂APFAC.

[0057] Example 6: Two-step synthesis of Erucyl amidopropyl-2-hydroxy-3-propionylpropyl ammonium chloride (C₂₂APHPAC)

C₂₂APHPAC was prepared by a two-step method with the same procedures as example 2, except using propionic acid instead of acetic acid. 250 mmol of propionic acid, 200 mmol of epichlorohydrin, and 6.25 mmol of tetrabutylammonium bromide (TBAB) were combined. The reaction mixture was heated to 90°C with stirring for 10 hours. After the reaction, the mixture was washed with saturated NaCl solution until the pH of the mixture was around 7. The remaining water in the mixture was removed using Na₂SO₄. The product was recovered by filtering the solid. The yield of 3-chloro-2-hydroxypropyl propionate was 50% by weight.

[0058] 25 mmol of N, N-dimethyl-erucyl-1, 3-propylenediamine and 30 mmol of 3-chloro-2-hydroxypropyl propionate were dissolved in 30 mL ethanol. The mixture was refluxed at 65°C for 10 hours. The solvent was then removed under reduced

pressure. The synthesized product was recrystallized with acetone and refrigerated at -15°C for 48 hours. The product was obtained by filtering the solution. The yield of C₂₂APHPAC was 53%.

[0059] Example 7: One-step synthesis of Erucyl amidopropyl-2-hydroxy-3-propionyloxy propyl ammonium chloride (C₂₂APHPAC)

C₂₂APHPAC was prepared by a one-step method with the same procedures as Example 3, except that propionic acid was used in place of acetic acid. 50 mmol of N, N-dimethyl-erucyl-1, 3-propylenediamine was mixed with 50 mmol of propionic acid in 10 mL of isopropanol. The mixture was heated to 95°C for 0.5 hours. 60 mmol of epichlorohydrin was added to the mixture. The mixture was then refluxed at 95°C for 7 hours. The solvent was removed under reduced pressure. The synthesized product was recrystallized with acetone at -15°C for 24 hours. The purified product was obtained by filtering. The yield of the cationic surfactant C₂₂APHPAC was 54%.

[0060] FIG. 14 shows an example IR spectrum of C₂₂APHPAC as synthesized in Example 7. The wide absorption at 3317 cm⁻¹ is due to the -N-H stretching vibration and the -O-H stretching vibration. The peaks at 2917 cm⁻¹ and 2835 cm⁻¹ are considered to be the stretching vibrations of the -CH₃ and -C-H- (-CH₂-) groups, respectively. The peak at 1680 cm⁻¹ is considered to be the -C=O stretching vibration of the ester group, and the peak at 1617 cm⁻¹ is considered to be the -C=O stretching vibration of the amide group. The peak at 716 cm⁻¹ indicates the existence of the alkyl chain. Accordingly, the IR spectrum confirms the structure of C₂₂APHPAC.

[0061] FIG. 15 shows an example ¹HNMR spectrum, confirming the structure of C₂₂APHPAC as synthesized in Example 7. C₂₂APHPAC was analyzed at 400 MHz in deuterated methanol. The following spectral peaks were observed, wherein s is a singlet, t is triple, and m is multiplet: 0.91 (m, 3H, 1), 1.31 (s, 33H, 2), 1.62 (s, 2H, 3), 2.05 (m, 7H, 4), 2.23 (m, 2H, 5), 3.27 (m, 10H, 6), 3.52 (m, 4H, 7), 4.41 (t, 1H, 8), 5.36 (t, 2H, 9). The ¹HNMR spectrum provides additional confirmation of the structure of C₂₂APHPAC.

[0062] Example 8: Properties of Product Surfactants

The properties of the surfactants in seawater including compatibility, critical micelle concentration (CMC) and the interfacial tension were investigated. The composition

of seawater is listed in Table 3 and the observed properties of the surfactants are presented in Table 4.

[0063] Table 3. Chemical composition of seawater

Seawater	Cations			Anions			Total salinity
	Na ⁺	Ca ²⁺	Mg ²⁺	Cl ⁻	HCO ₃ ⁻	SO ₄ ²⁻	
Concentration (ppm)	18,300	659	2,110	32,200	120	4,290	57,670

5

[0064] Table 4. Properties of surfactants

Surfactant	Compatibility ¹		CMC (mol/L)	IFT (mN/m)		
	25°C	95°C		500mg/L	1000mg/L	2000mg/L
C ₂₂ APDAC	A	A	9.58×10 ⁻⁶	2.11×10 ⁻⁴	1.21×10 ⁻⁴	1.1×10 ⁻³
C ₂₂ APHAAC	A	B	1.09×10 ⁻⁵	1.11	4.83×10 ⁻³	2.37×10 ⁻³
C ₂₂ APHFAC	A	B	1.08×10 ⁻⁵	0.31	1.87×10 ⁻²	7.12×10 ⁻³
C ₂₂ APHPAC	A	B	1.25×10 ⁻⁵	5.7×10 ⁻²	7×10 ⁻³	4.2×10 ⁻²

¹A = clear; B = phase separation.

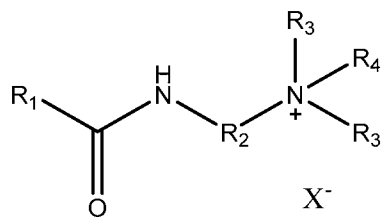
[0065] As shown in Table 4, the cationic surfactants synthesized in this disclosure have low interfacial tension and are soluble in high salinity environments. Low CMC values indicate the applicability of the surfactant at low concentrations. Accordingly, these solvents will be useful in a number of applications, including enhanced oil recovery.

[0066] The following units of measure have been mentioned in this disclosure:

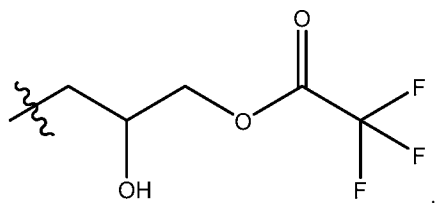
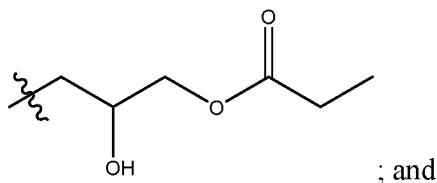
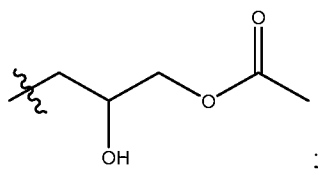
Unit of Measure	Full form
L	liter
mL	milliliter
mg	milligram
mmol	millimole
mN	milli Newtons
m	meter
ppm	parts per million
°C	degree Celsius
hr	hour

Unit of Measure	Full form
cm ⁻¹	inverse centimeter, wavenumber
MHz	megahertz

[0067] In some implementations, a composition includes a compound of Formula I:



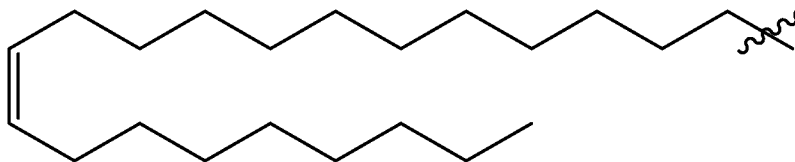
, where X is halide, R₁ is a saturated or unsaturated alkyl with 4 to 28 carbons, R₂ is alkyl, R₃ is methyl, and R₄ is selected from the group consisting of



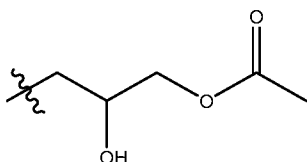
[0068] This aspect, taken alone or combinable with any other aspect, can include the following features. R₂ is propyl.

[0069] This aspect, taken alone or combinable with any other aspect, can include the following features. R₁ is a monounsaturated alkyl chain with 21 carbons.

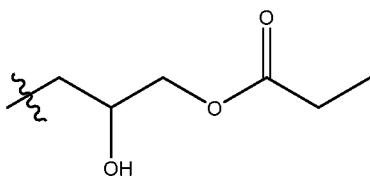
[0070] This aspect, taken alone or combinable with any other aspect, can include the following features. R₁ is



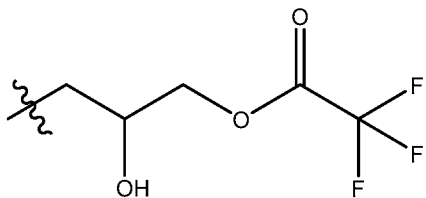
[0071] This aspect, taken alone or combinable with any other aspect, can include the following features. R₄ is



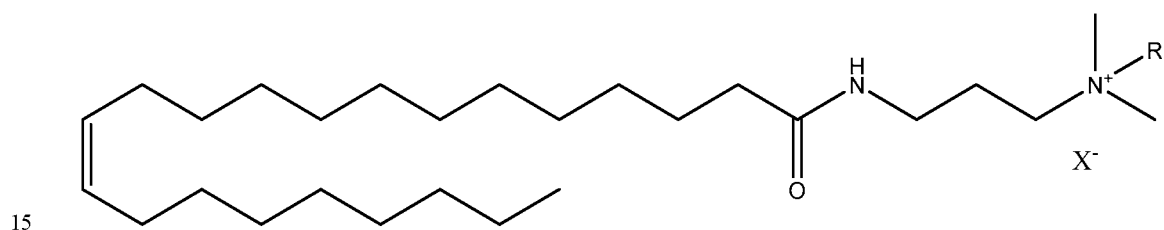
[0072] This aspect, taken alone or combinable with any other aspect, can include the following features. R₄ is



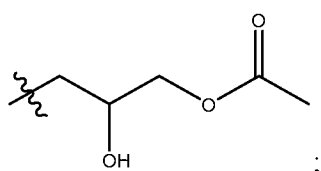
[0073] This aspect, taken alone or combinable with any other aspect, can include the following features. R₄ is



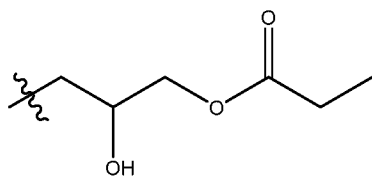
[0074] In some implementations, a composition includes a compound of Formula II:



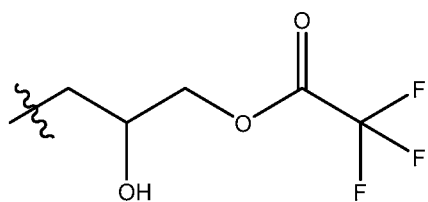
where R is selected from the group consisting of:



;

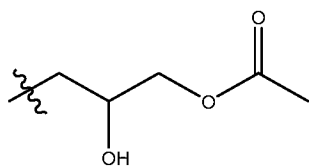


; and

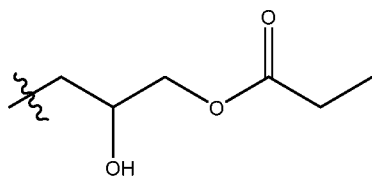


, and where X is halide.

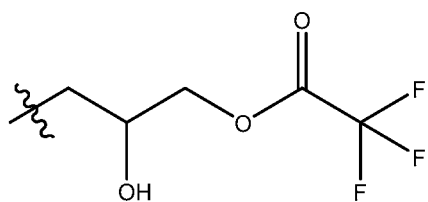
[0075] This aspect, taken alone or combinable with any other aspect, can include the following features. R is



[0076] This aspect, taken alone or combinable with any other aspect, can include the following features. R is



[0077] This aspect, taken alone or combinable with any other aspect, can include the following features. R is



[0078] In some implementations, a process includes reacting a fatty acid modified with an amino alkyl group and an epihalohydrin, the presence of a base, to afford a cationic surfactant.

[0079] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting the fatty acid modified with an amino alkyl group includes reacting N, N-dimethyl-erucyl-1,3,-propylenediamine.

[0080] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting the epihalohydrin includes reacting epichlorohydrin.

[0081] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting in the presence of a base includes reacting in a presence of sodium hydroxide.

[0082] In some implementations, a process includes reacting a fatty acid modified with an amino alkyl group, an epihalohydrin, and a carboxylic acid to afford a cationic surfactant.

[0083] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a fatty acid modified with an amino alkyl group includes reacting N,N-dimethyl-erucyl-1,3,-propylenediamine.

[0084] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting an epihalohydrin includes reacting epichlorohydrin.

[0085] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a carboxylic acid includes reacting a carboxylic acid selected from acetic acid, propionic acid; and trifluoroacetic acid.

[0086] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a carboxylic acid includes reacting acetic acid.

[0087] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a carboxylic acid includes reacting propionic acid.

[0088] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a carboxylic acid includes reacting trifluoroacetic acid.

[0089] In some implementations, a process includes reacting a carboxylic acid, an epihalohydrin, and a catalyst to afford a halo-substituted alkyl ester. The process includes reacting the halo-substituted alkyl ester with a fatty acid modified with an amino alkyl group to afford a cationic surfactant.

[0090] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a catalyst includes reacting tetrabutylammonium bromide.

[0091] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting an epihalohydrin includes reacting epichlorohydrin.

[0092] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a carboxylic acid includes reacting a carboxylic acid selected from acetic acid, propionic acid, and trifluoroacetic acid.

[0093] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a carboxylic acid includes reacting acetic acid.

[0094] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a carboxylic acid includes reacting propionic acid.

[0095] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a carboxylic acid includes reacting trifluoroacetic acid.

[0096] This aspect, taken alone or combinable with any other aspect, can include the following features. Reacting a fatty acid modified with an amino alkyl group includes reacting N, N-dimethyl-erucyl-1,3,-propylenediamine.

[0097] The term "about" as used in this disclosure can allow for a degree of variability in a value or range, for example, within 10%, within 5%, or within 1% of a stated value or of a stated limit of a range.

[0098] The term "substantially" as used in this disclosure refers to a majority of, or mostly, as in at least about 50%, 60%, 70%, 80%, 90%, 95%, 96%, 97%, 98%, 99%, 99.5%, 99.9%, 99.99%, or at least about 99.999% or more.

[0099] The term "alkyl," employed alone or in combination with other terms, refers to a saturate hydrocarbon group that may be straight-chain or branched.

[0100] The terms "halo" or "halogen," used alone or in combination with other terms, refers to fluoro, chloro, bromo, and iodo.

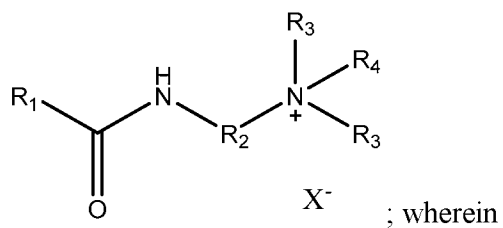
[0101] The term "solvent" as used in this disclosure refers to a liquid that can dissolve a solid, another liquid, or a gas to form a solution. Non-limiting examples of solvents are silicones, organic compounds, water, alcohols, ionic liquids, and supercritical fluids.

[0102] As used in this disclosure, “weight percent” (wt %) can be considered a mass fraction or a mass ratio of a substance to the total mixture or composition. Weight percent can be a weight-to-weight ratio or mass-to-mass ratio, unless indicated otherwise.

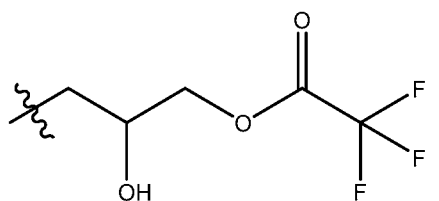
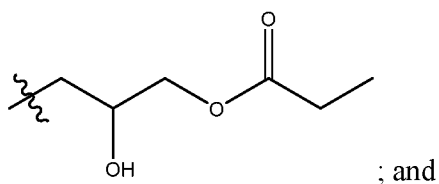
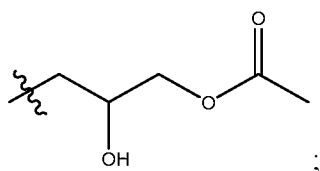
- 5 [0103] A number of implementations of the disclosure have been described. Nevertheless, it will be understood that various modifications may be made without departing from the spirit and scope of the disclosure.

WHAT IS CLAIMED IS:

1. A compound of Formula I:

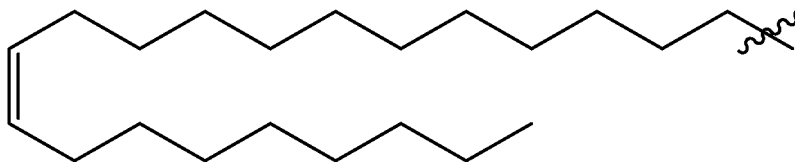


- 5 X is halide, R₁ is a saturated or unsaturated alkyl with 4 to 28 carbons, R₂ is alkyl, R₃ is methyl, and R₄ is selected from the group consisting of

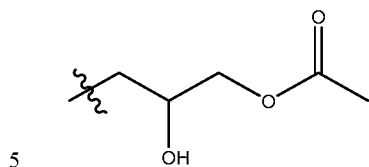


- 10 2. The compound of claim 1, wherein R₂ is propyl.
3. The compound of claim 1, wherein R₁ is a monounsaturated alkyl chain with 21 carbons.

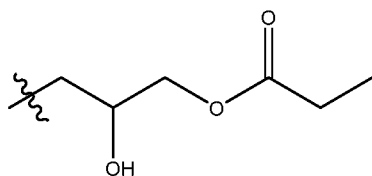
4. The compound of claim 3, wherein R₁ is



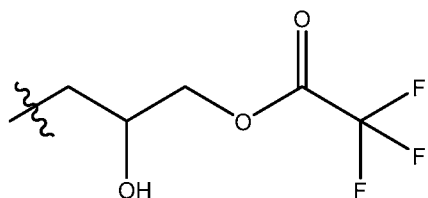
5. The compound of claim 1, wherein R₄ is



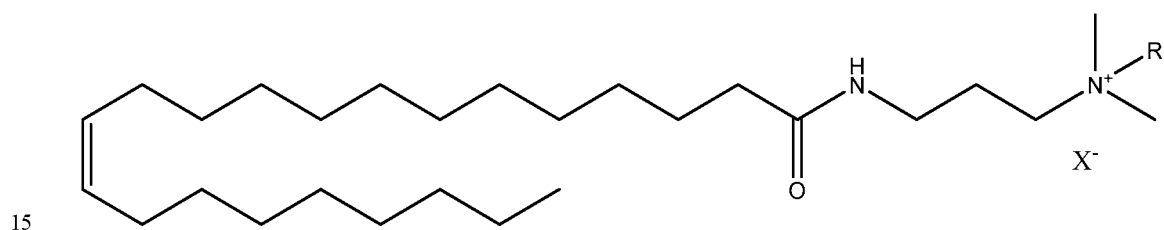
6. The compound of claim 1, wherein R₄ is



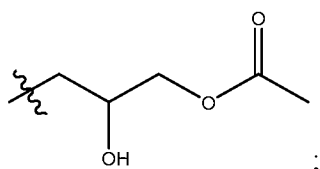
- 10 7. The compound of claim 1, wherein R₄ is



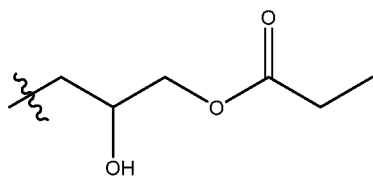
8. A compound of Formula II:



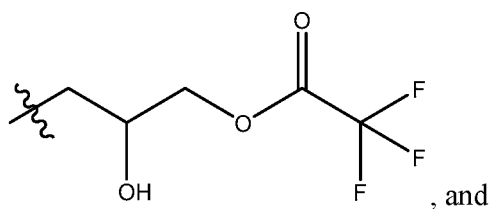
wherein R is selected from the group consisting of:



;



; and

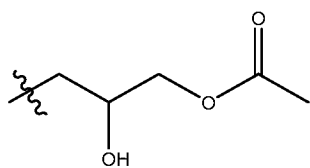


, and

wherein X is halide.

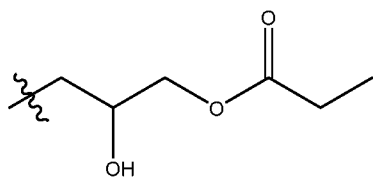
5

9. The compound of claim 8, wherein R is



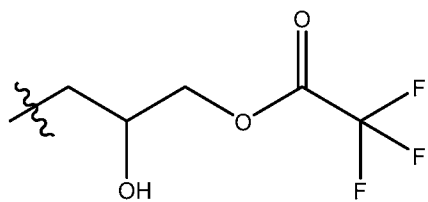
.

10. The compound of claim 8, wherein R is



10

11. The compound of claim 8, wherein R is



.

15

12. A process comprising reacting:

a fatty acid modified with an amino alkyl group; and
an epihalohydrin, in a presence of a base, to afford a cationic surfactant.

13. The process of claim 12, wherein reacting the fatty acid modified with
5 an amino alkyl group comprises reacting N, N-dimethyl-erucyl-1,3,-propylenediamine.

14. The process of claim 12, wherein reacting the epihalohydrin comprises
reacting epichlorohydrin.

10 15. The process of claim 12, wherein reacting in the presence of a base
comprises reacting in a presence of sodium hydroxide.

16. A process comprising reacting:
a fatty acid modified with an amino alkyl group;
15 an epihalohydrin; and
a carboxylic acid to afford a cationic surfactant.

17. The process of claim 16, wherein reacting a fatty acid modified with an
amino alkyl group comprises reacting N,N-dimethyl-erucyl-1,3,-propylenediamine.

20 18. The process of claim 16, wherein reacting an epihalohydrin comprises
reacting epichlorohydrin.

19. The process of claim 16, wherein reacting a carboxylic acid comprises
25 reacting a carboxylic acid selected from the group consisting of:
acetic acid;
propionic acid; and
trifluoroacetic acid.

30 20. The process of claim 16, wherein reacting a carboxylic acid comprises
reacting acetic acid.

21. The process of claim 16, wherein reacting a carboxylic acid comprises reacting propionic acid.

22. The process of claim 16, wherein reacting a carboxylic acid comprises
5 reacting trifluoroacetic acid.

23. A process, comprising:
reacting:
a carboxylic acid;
10 an epihalohydrin; and
a catalyst to afford a halo-substituted alkyl ester; and
reacting the halo-substituted alkyl ester with a fatty acid modified with
an amino alkyl group to afford a cationic surfactant.

24. The process of claim 23, wherein reacting a catalyst comprises reacting
15 tetrabutylammonium bromide.

25. The process of claim 23, wherein reacting an epihalohydrin comprises
reacting epichlorohydrin.
20

26. The process of claim 23, wherein reacting a carboxylic acid comprises
reacting a carboxylic acid selected from the group consisting of:
acetic acid;
propionic acid; and
25 trifluoroacetic acid.

27. The process of claim 23, wherein reacting a carboxylic acid comprises
reacting acetic acid.

28. The process of claim 23, wherein reacting a carboxylic acid comprises
30 reacting propionic acid.

29. The process of claim 23, wherein reacting a carboxylic acid comprises reacting trifluoroacetic acid.

30. The process of claim 23, wherein reacting a fatty acid modified with an
5 amino alkyl group comprises reacting N, N-dimethyl-erucyl-1,3,-propylenediamine.

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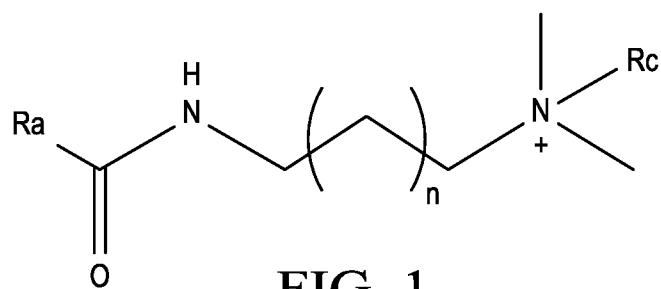


FIG. 1

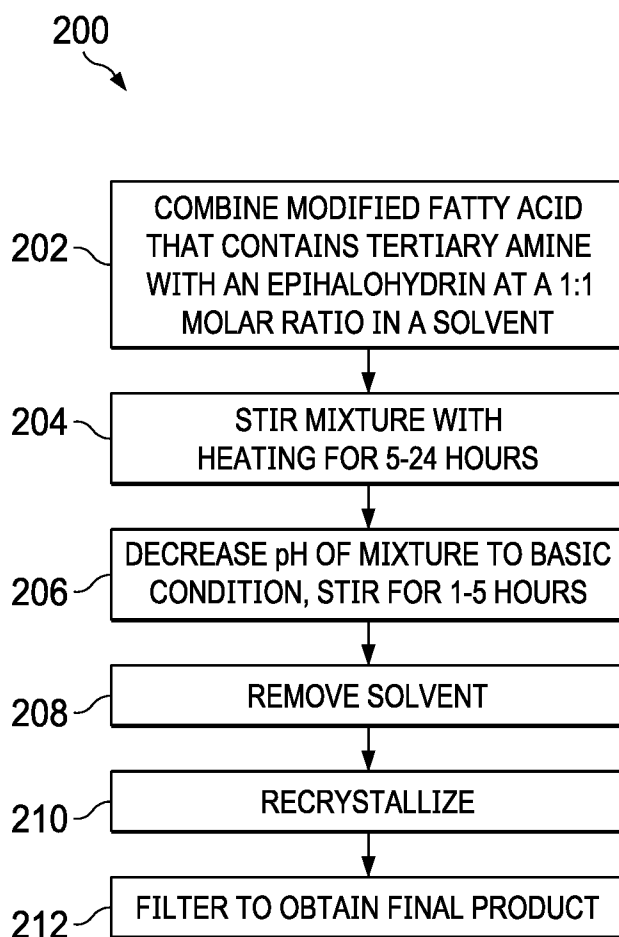


FIG. 2

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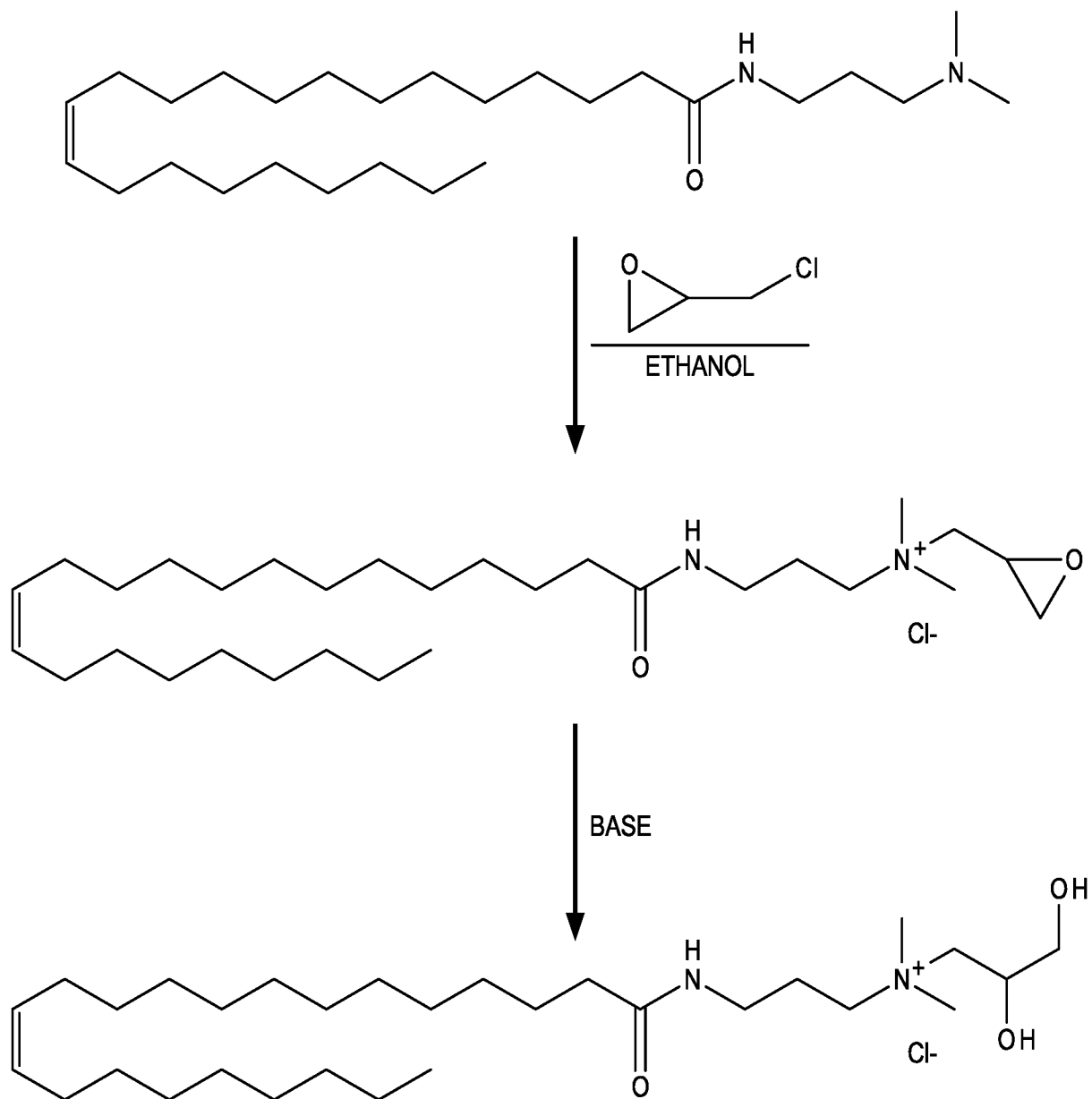


FIG. 3

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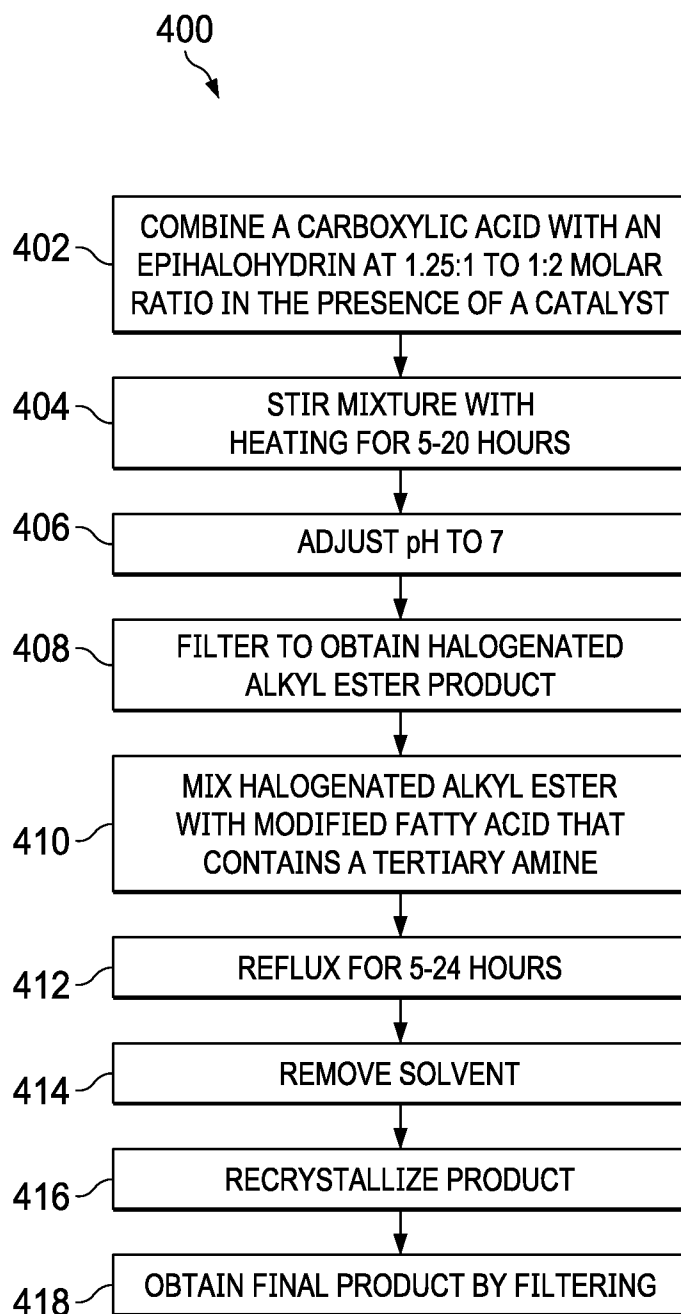


FIG. 4

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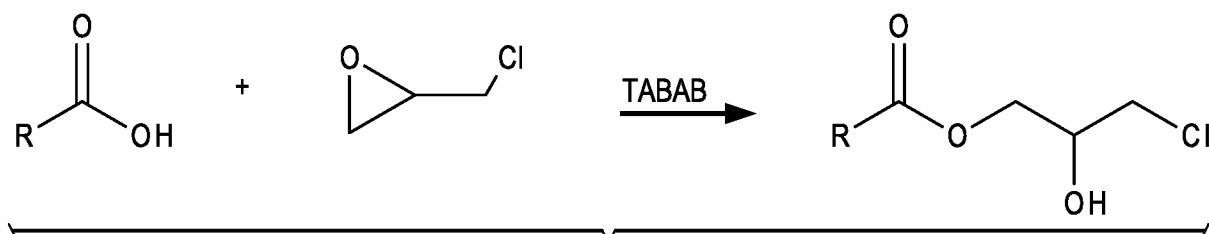


FIG. 5A

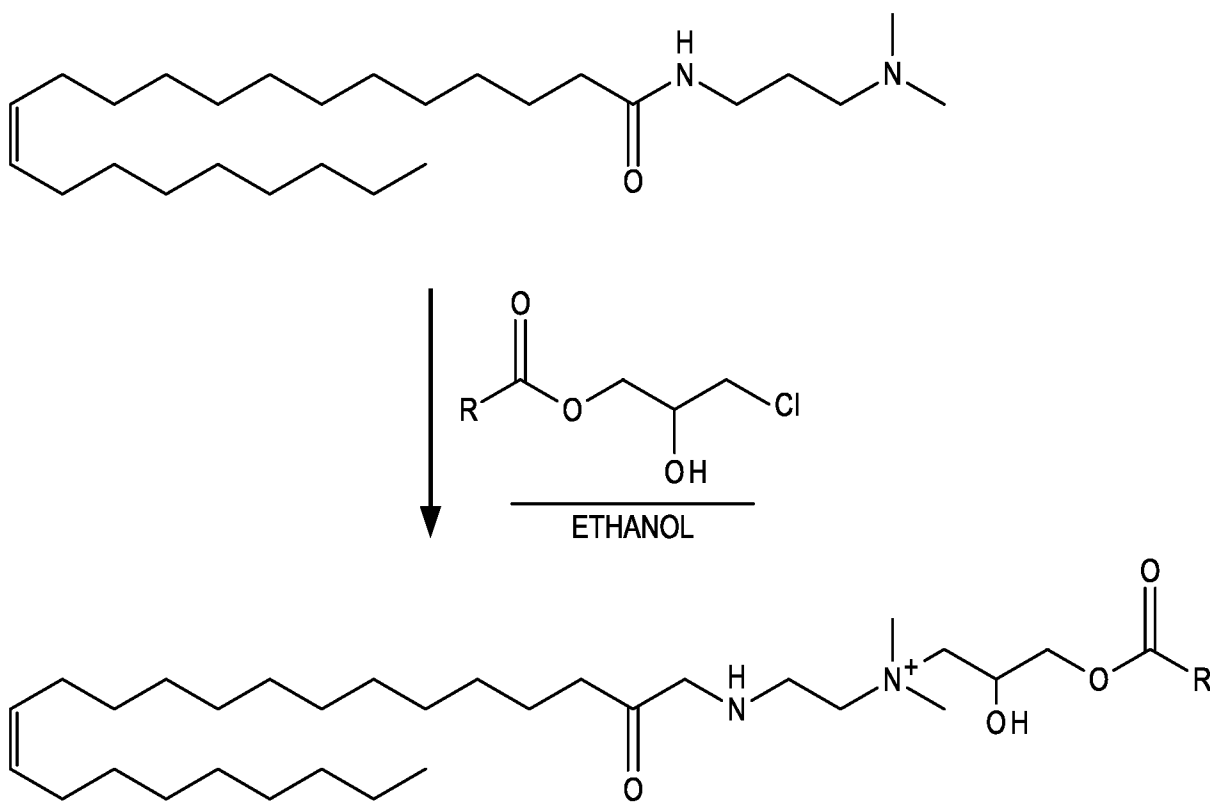


FIG. 5B

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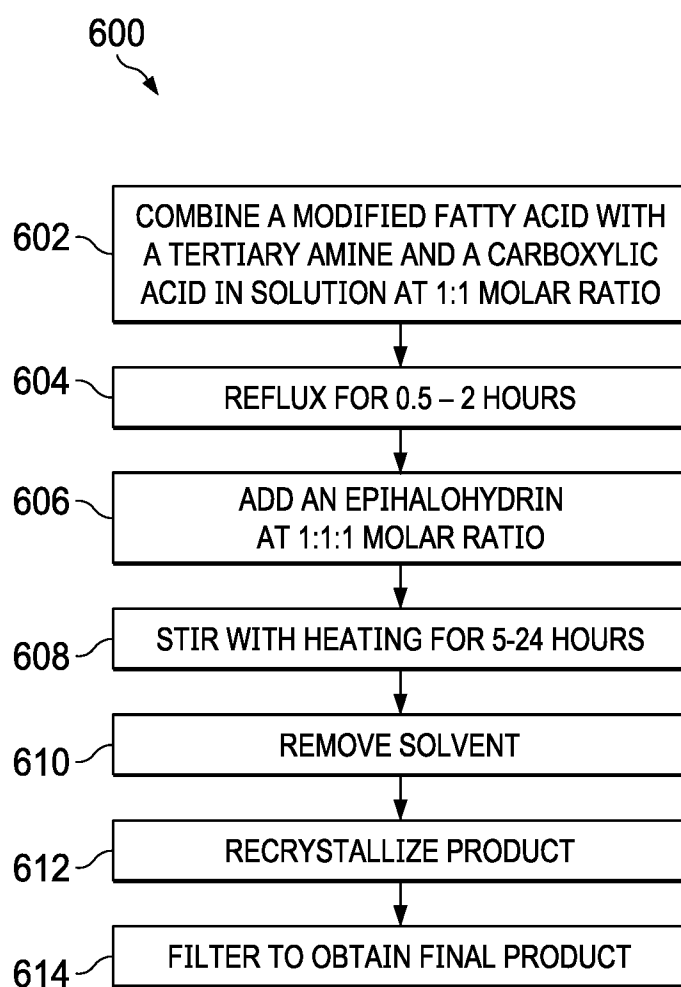


FIG. 6

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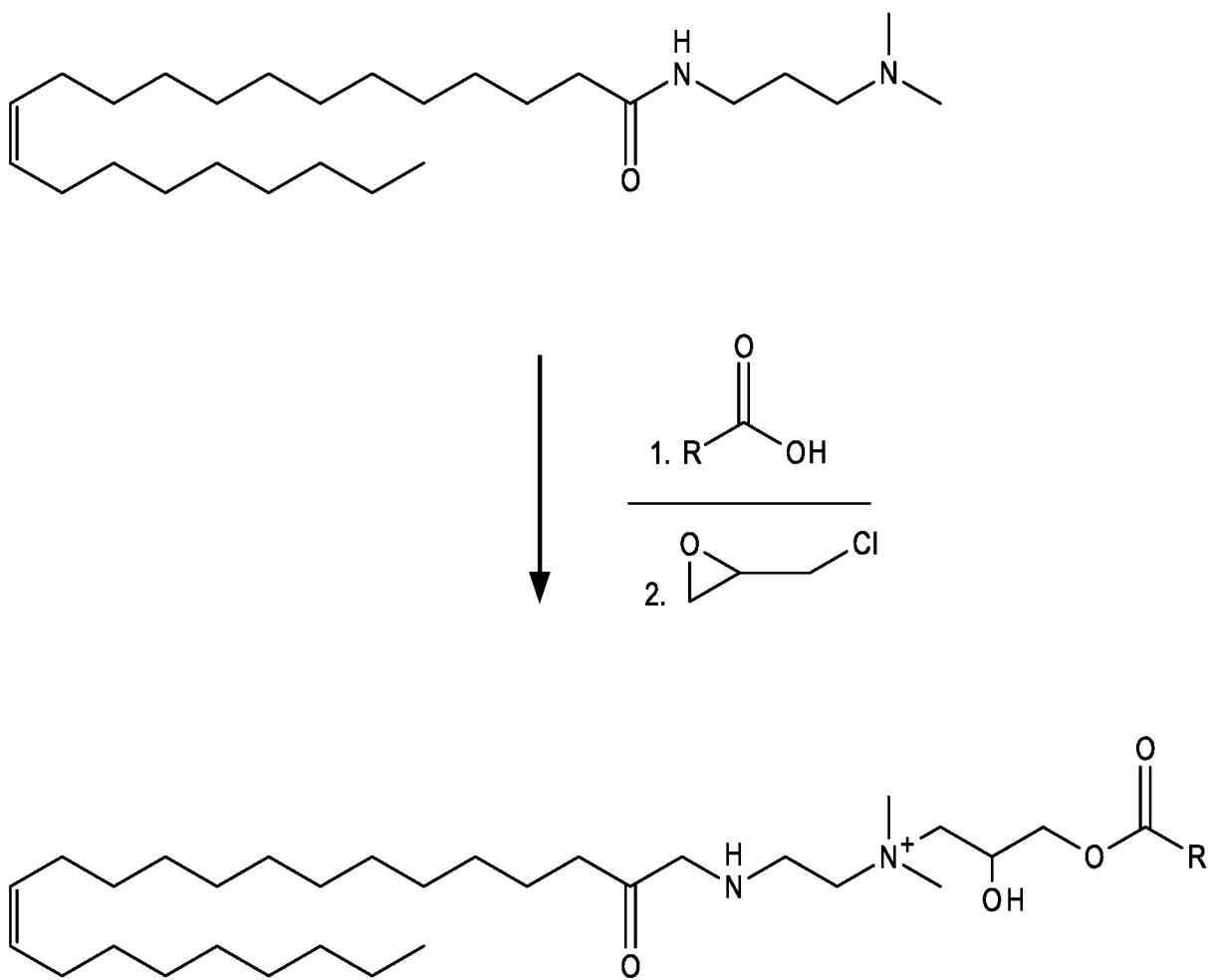


FIG. 7

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FIG. 8

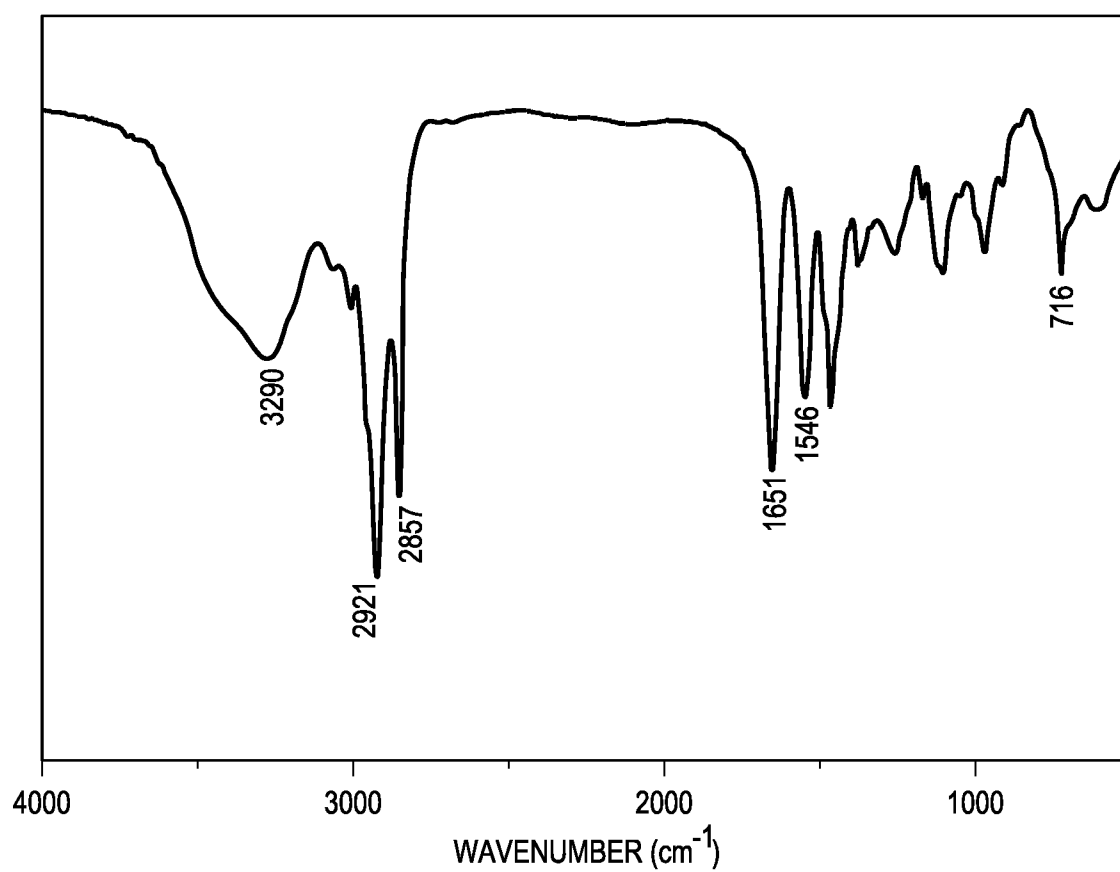
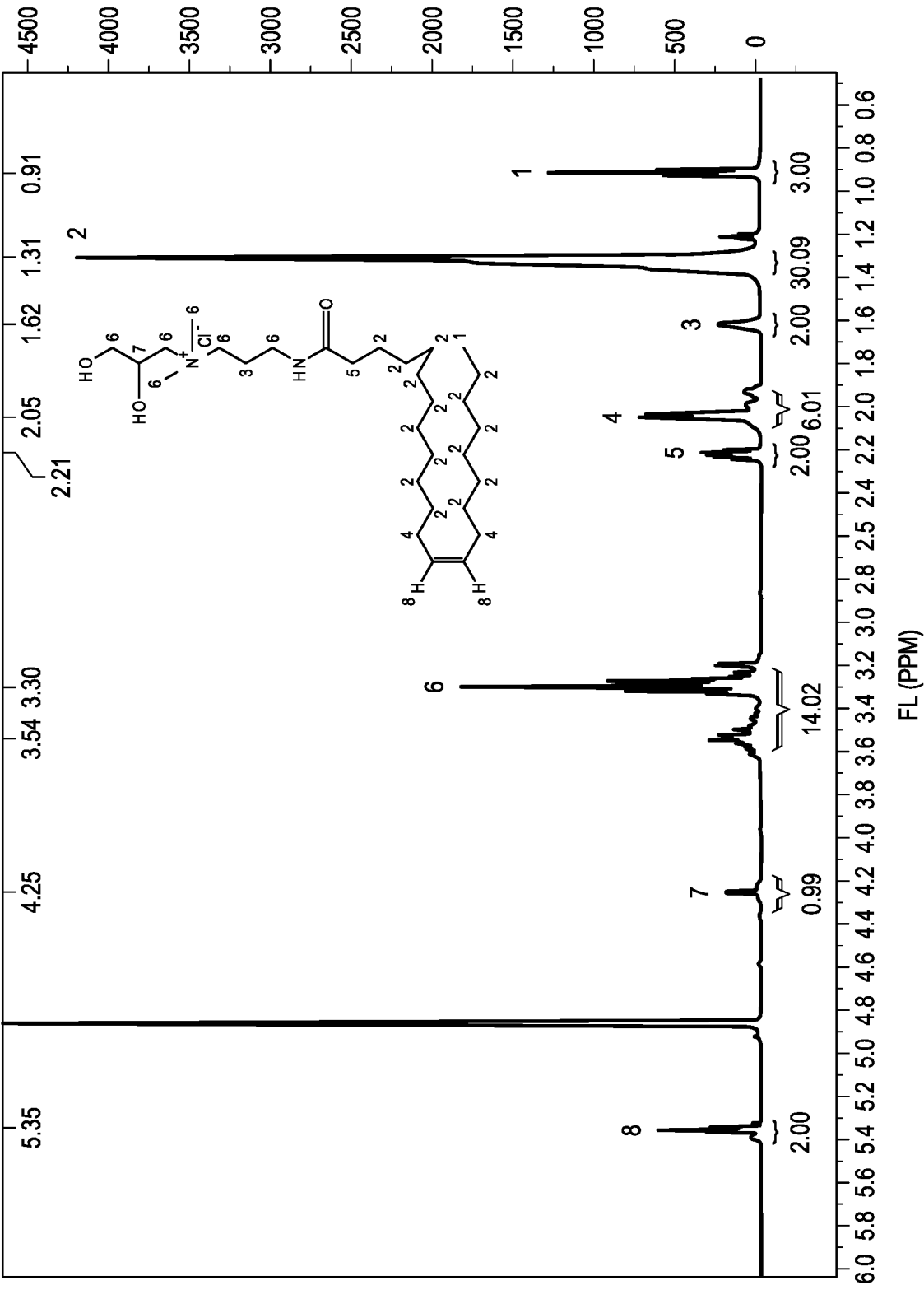
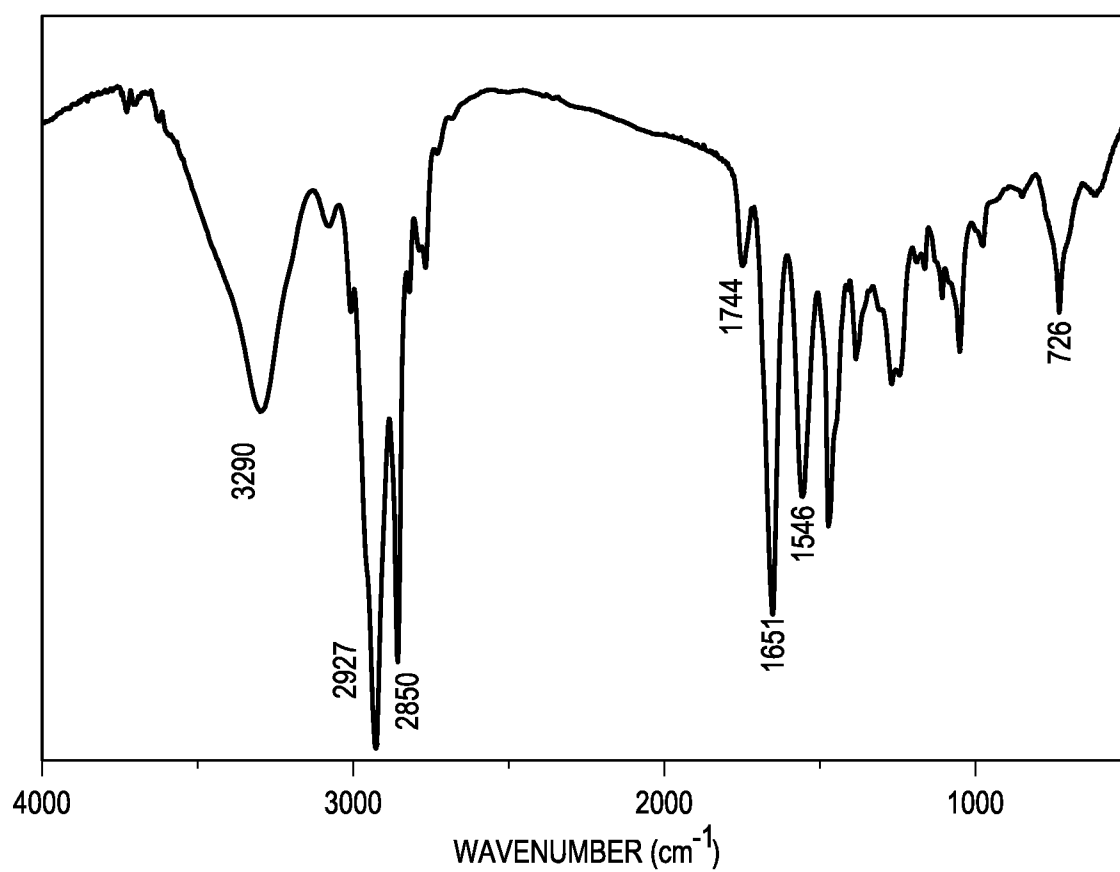


FIG. 9

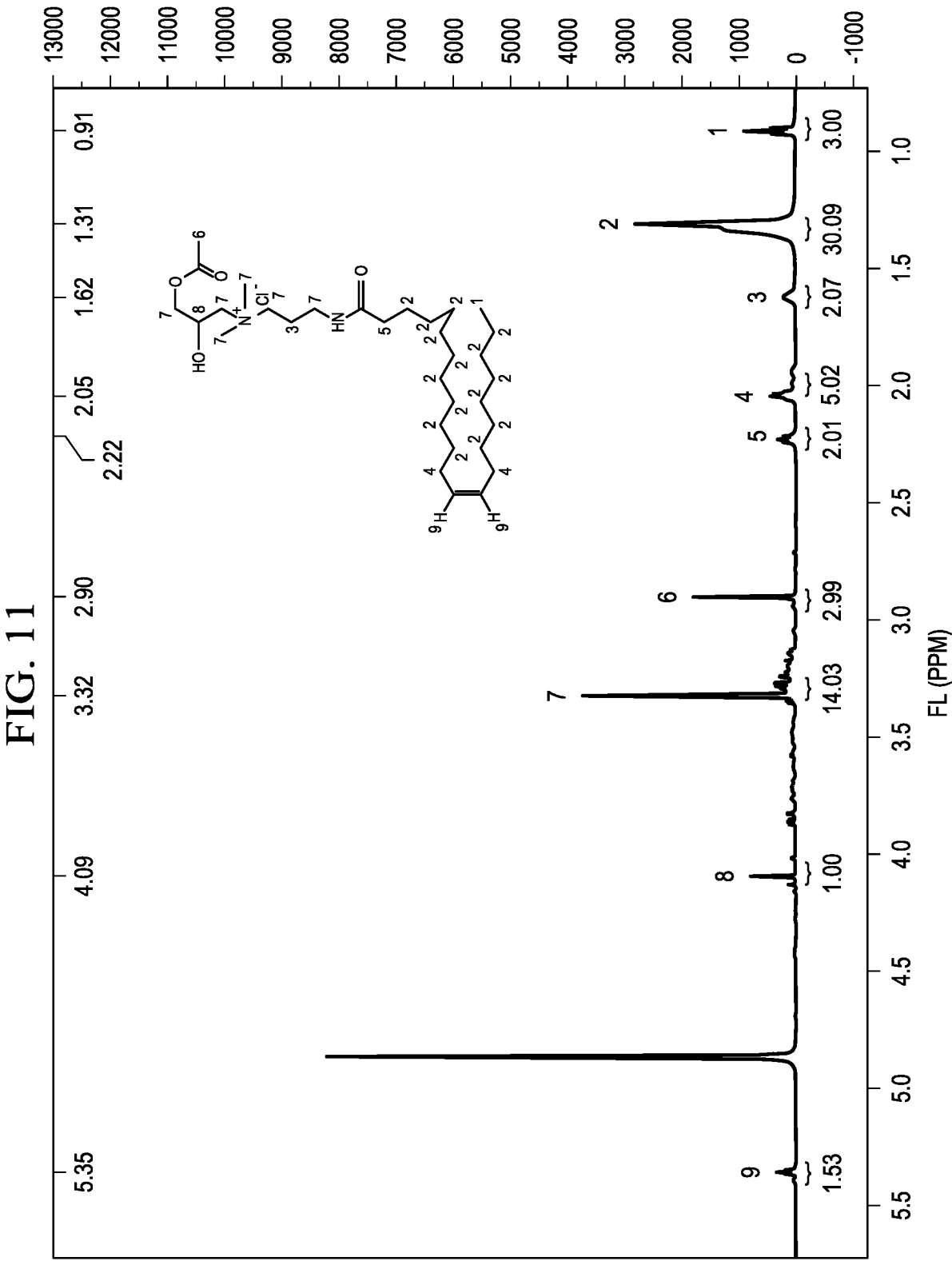


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FIG. 10

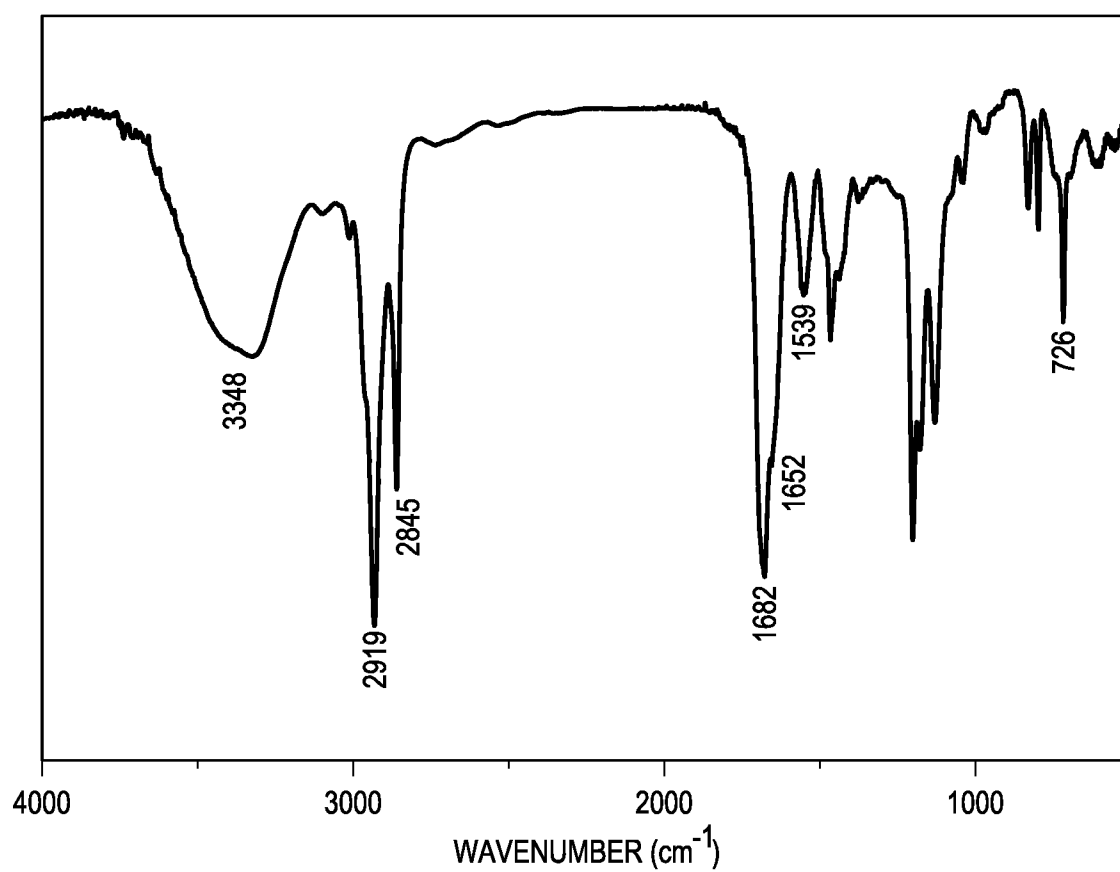


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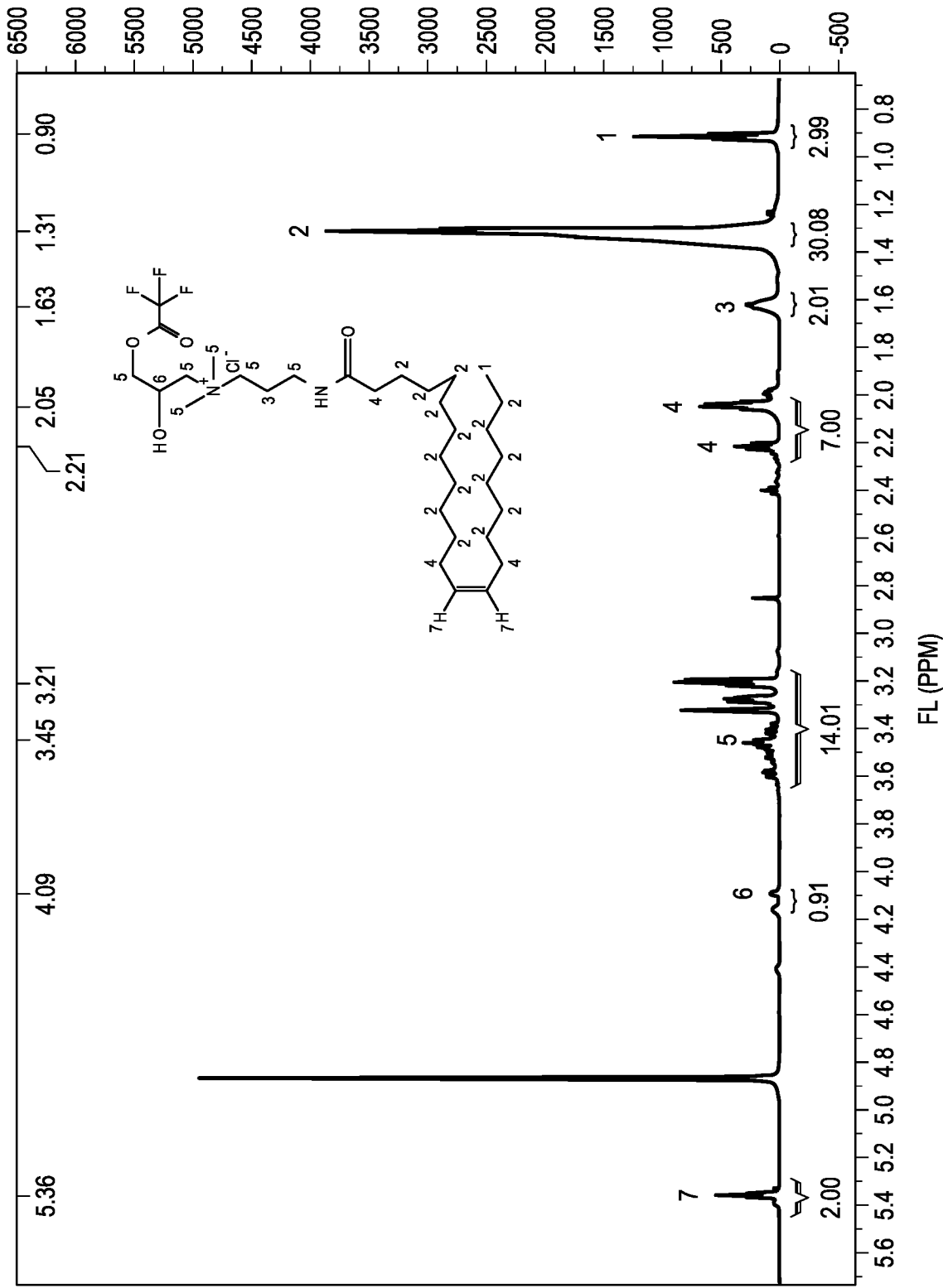
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FIG. 12



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FIG. 13



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FIG. 14

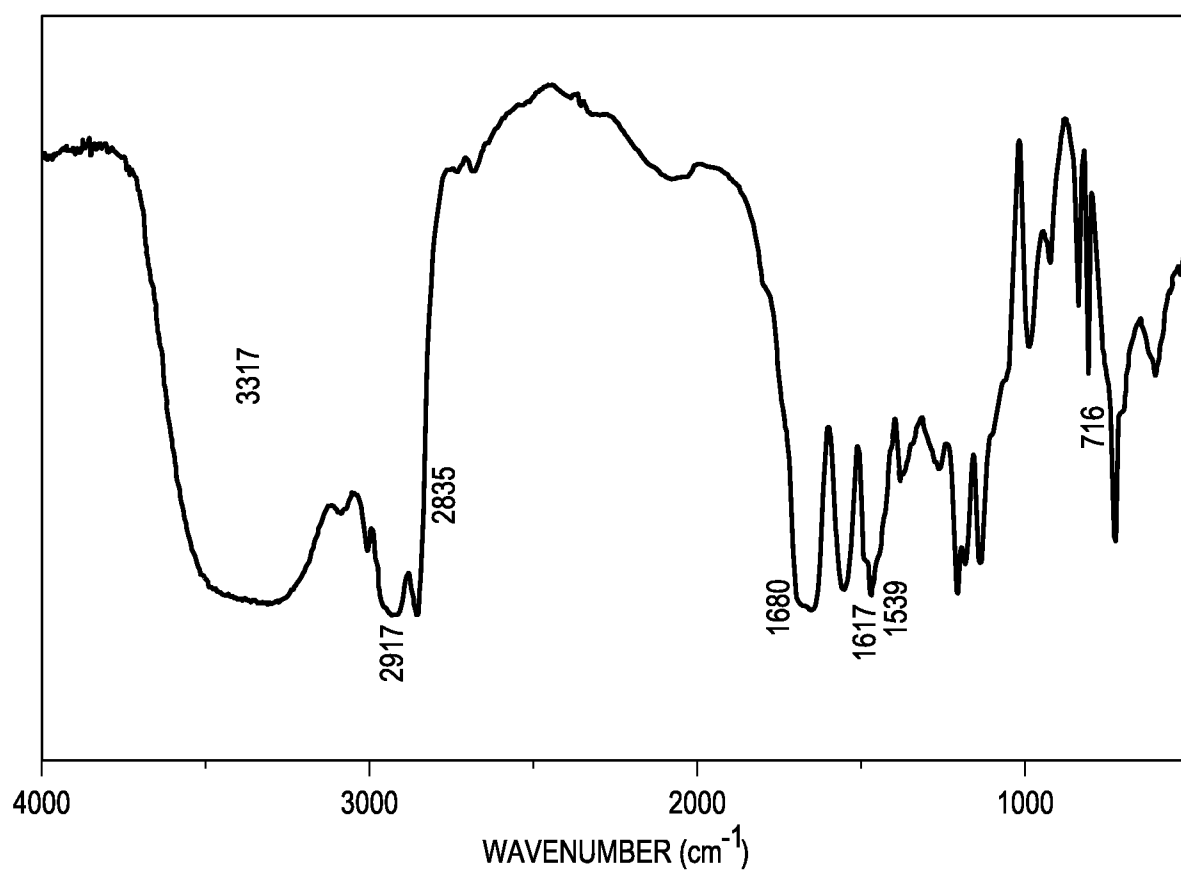
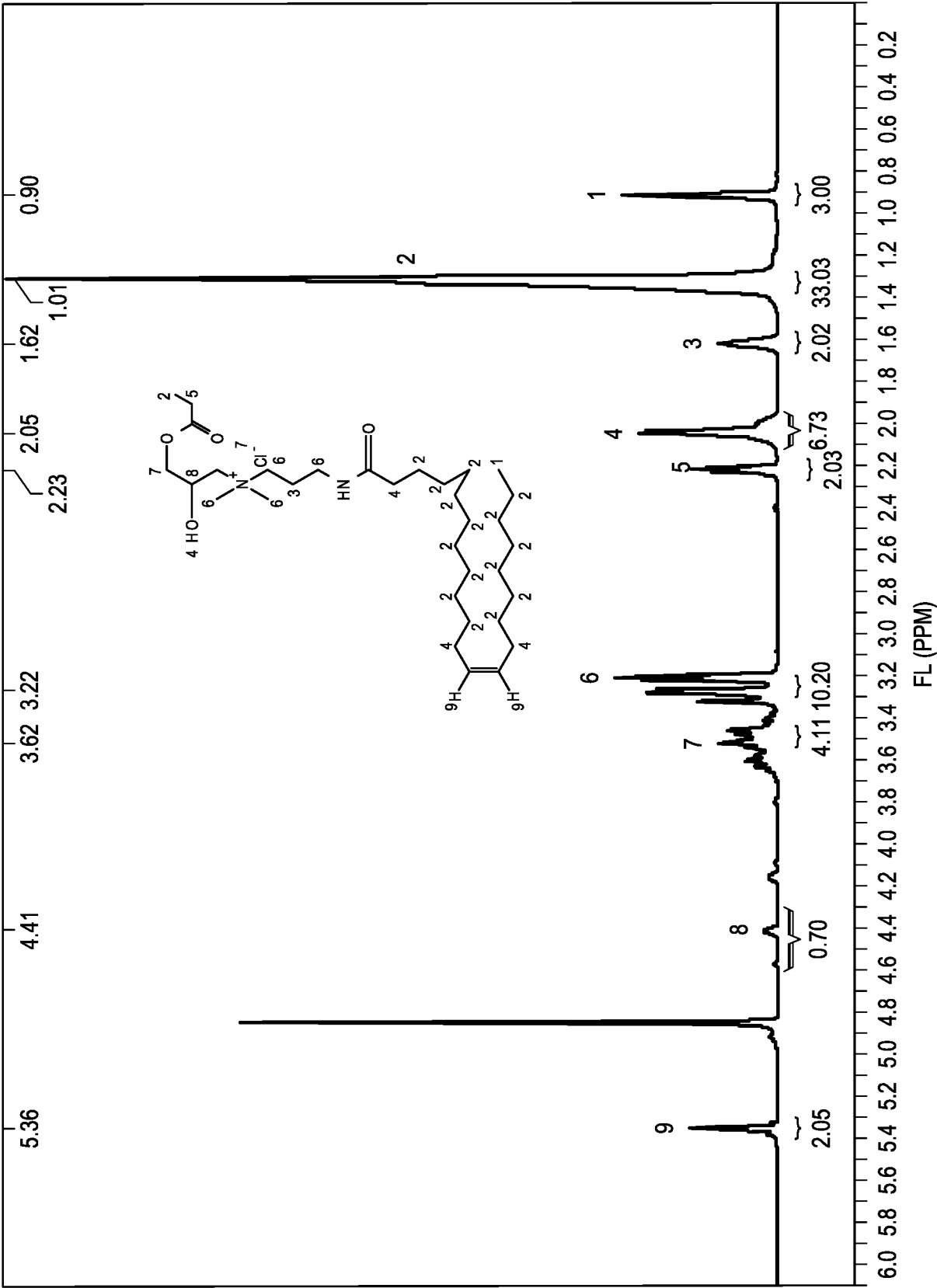


FIG. 15



INTERNATIONAL SEARCH REPORT

International application No
PCT/US2021/043630

A. CLASSIFICATION OF SUBJECT MATTER
INV. C07C231/12 C07C233/38
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
C07C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 2012/061098 A1 (STEPAN CO [US]; ALLEN DAVE R [US] ET AL.) 10 May 2012 (2012-05-10) pages 34, 37 and 45	12,14,15
X	CN 108 642 879 A (ZHEJIANG KEFENG NEW MAT CO LTD) 12 October 2018 (2018-10-12) abstract ----- -/--	16,18-20



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

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Date of the actual completion of the international search

12 November 2021

Date of mailing of the international search report

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Name and mailing address of the ISA/

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Authorized officer

Tabanella, Stefania

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2021/043630

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	YU ERLEI ET AL: "Synthesis of Novel Zwitterionic Heterogemini Surfactants Derived from Fatty Acid and Investigation of Their Behavior at the Air-Water Interface", LETTERS IN ORGANIC CHEMISTRY, vol. 12, no. 8, 26 August 2015 (2015-08-26), pages 590-597, XP55859309, NL ISSN: 1570-1786, DOI: 10.2174/1570178612666150629181035	23-29
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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

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