

Article

RETRACTED: Transient Operation: A Catalytic Chemoselective Hydrogenation of 2-Methyl-3-Butyn-2-ol via a Cooperative Pd and Radiofrequency Heating Directed Kinetic Resolution

Duaa Raja ^{1,2}, Jabbar Gardy ¹, Ali Hassanpour ¹, Chun-Yu Ho ^{2,*} and Javier Fernandez Garcia ^{1,*}

¹ School of Chemical and Process Engineering, University of Leeds, Leeds LS2 9JT, UK; pmdraj@leeds.ac.uk (D.R.); j.gardy@leeds.ac.uk (J.G.); a.hassanpour@leeds.ac.uk (A.H.)

² Department of Chemistry, Shenzhen Grubbs Institute, Southern University of Science and Technology, Shenzhen 518055, China

* Correspondence: jasonhcy@sustc.edu.cn (C.-Y.H.); J.FernandezGarcia@leeds.ac.uk (J.F.G.)

Received: 22 February 2019; Accepted: 15 March 2019; Published: 20 March 2019



Abstract: The effect of periodic temperature oscillations has been studied for the hydrogenation of 2-methyl-3-butyn-2-ol over a Pd-based catalyst in a micro-trickle bed reactor. This hydrogenation was investigated using a radiofrequency heated reactor under transient conditions using temperature cycling. The dynamic operation using this configuration was found to increase both conversion and selectivity towards 2-methyl-3-buten-2-ol compared to the steady-state operation with an improvement of up to 24% for the selectivity being observed. The developments made here also result in a lower activation energy in comparison to previous data, providing a starting point for radiofrequency heating to enhance reaction rate through the exploitation of thermal cycling at production scale.

Keywords: transient operation; temperature oscillations; Pd catalyst; radiofrequency heating; hydrogenation

1. Introduction

Transient operation has been previously considered in many industrial processes where either heat recovery or production rate can be considerably improved compared to steady-state operation. For example, temperature oscillations during transient operation allows for a higher rate to be obtained in the oxidation of CO or propylene and 2-propanol dehydrogenation [1–9]. Furthermore, transient operation has been studied for temperature-swing regeneration in bio-oils fractionation [10]. The improved performance can also be in the form of stabilization of spontaneously oscillatory systems [11].

Normally, the principle in a catalytic process is to ensure a controllable and stable temperature profile that prevents side reactions and thermal runaway. In terms of dynamic conditions in industry, the temperature of a process may be gradually increased over a period of time in order to counteract the deactivation of the catalyst. However, in some cases, it has been found that controlled temperature oscillations may be favorable towards the performance of the process. In catalytic reactions, the improvements in many cases stemmed from a periodic removal of inhibiting species that were strongly adsorbed on the surface and accumulated on the active sites over time [12].

Thermal cycling has been previously documented in CSTR, fluidized beds as well as trickle bed reactors for the hydrogenation of α -methylstyrene using flow interruption [13]. The improvement

in the hydrogenation was attributed to the controlling runaway by changes in particle wetting, which influences the contribution of gas-phase diffusion. Oxidation reactions carried out in microstructured reactors have been widely studied due to the low thermal inertia present in these configurations leading to a considerable increase in selectivity.

Selective hydrogenation is an important transformation in the synthesis of fine chemicals and pharmaceutical industry. Specifically, 2-methyl-3-buten-2-ol (MBE) is a compound of interest as it is used as a starting material in the production of vitamins A and E as well as an intermediate chemical in fragrances and flavorings [14]. As shown in Figure 1, MBE is formed by partial hydrogenation of 2-methyl-3-butyn-2-ol (MBY). Full hydrogenation of MBY or further hydrogenation of MBE can take place to form 2-methyl-3-butan-2-ol (MBA) and C_{10} dimers of MBY may also be produced. Therefore, increasing the conversion of the raw materials and the selectivity towards the MBE are of significance to minimize the impact on the environment by avoiding energy intensive separation processes and waste formation. Even an improvement in selectivity as minor as 1% can contribute to several thousands of tons of the product leading to substantial profits especially in industries as large as pharmaceutical manufacturing, which is estimated to be worth £1.3 billion in 2018–2019 in the UK alone [15,16].

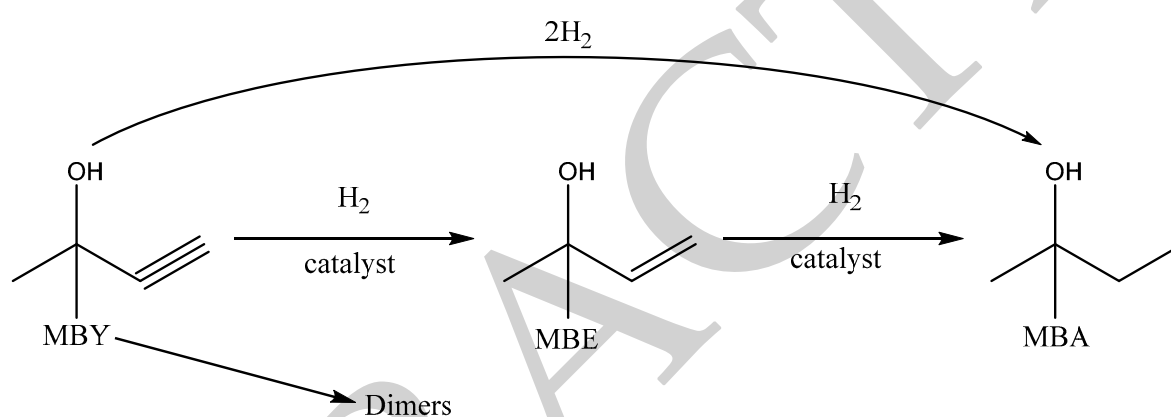


Figure 1. Reaction pathways for the hydrogenation of MBY.

The use of dynamic conditions is a well-developed research area especially for hydrogenation reactions (for instance, ammonia and methanol synthesis, NO_x reduction, hydrogenation of ethylene and aromatics) where the feed conditions such as flow rates, compositions of gaseous inlets as well as cycling between feeds are modulated [17].

Reactions of a similar nature that would benefit from dynamic conditions would be the selective hydrogenation of 2-hexyne to cis-2-hexene as well as the conversion of cinnamaldehyde to hydrocinnamaldehyde and cinnamyl alcohol, which are valuable intermediates used in the perfumery and pharmaceutical industries [18,19]. The hydrogenation of furfural is another complex sequence of reactions involving both series and parallel pathways that would be of interest for dynamic operation for producing value-added chemicals especially due to its biomass-derived origins [20].

A radiofrequency (RF) heated reactor employing a catalyst with magnetic properties has been shown to have the potential for the scaling up of a microreactor while addressing some of the drawbacks associated with the mass- and heat-transfer resistances present in conventional systems [21]. An application exploiting the precise temperature control of RF heating has been shown in adsorption and desorption cycles to enhance safety, even when rapid heating rates are applied allowing clean square wave modulation to be achieved [22,23]. Another usage of the quick heating rate and response time of RF heating is seen when dealing with renewable energy supplies which are prone to fluctuations [24]. Transient operation by switching the RF field on and off has been demonstrated previously for process intensification but also as an application for on-demand synthesis when the controlled release of a substance is required [25].

Many challenges exist that cause fast periodic operation to be a concept beyond reach in traditional systems, such as poor surface-to-volume ratios and large thermal masses which inhibits heat exchange between traditional reactors and the cooling/heating systems. Recently, much of the focus has been on developing microstructured reactors catering towards transient operation as the limitations associated with the thermal inertia of the vessel can only be overcome at the microscale. As radiofrequency heating has been previously shown to be feasible for scaling up, the developments made here may provide a starting point for radiofrequency heating to enhance reaction rate through the use of thermal cycling at production scale.

Herein, the effect of transient and steady state conditions on MBE production using an RF heated reactor and a Pd catalyst cooperation (on chemoselective hydrogenation) was investigated for the first time. To our delight, this new system solved the problems associated with conventional microreactors which usually require careful manufacture whereas in this system the frequency of oscillations is able to be controlled in a straightforward manner using RF heating.

2. Results and Discussion

The effect of temperature cycling was investigated by feeding 0.25 M MBY dissolved in xylene and 10 mL/min H₂ flow rate into the reactor system under atmospheric pressure at the constant temperature (30 °C) to demonstrate steady state. A variety of liquid reactant flows were employed to generate data to measure the extent of the reactant consumption and production of the desired molecules for different residence times. An amplitude (A) of 5 °C and a frequency or a period (τ) of 75 s were used to represent the transient-state operation.

Figure 2 displays a comparison of the conversion of MBY obtained during steady state and transient state. The difference in conversions obtained for transient and steady state become more apparent as residence time increases possibly as a result of the reactant becoming fully hydrogenated or forming dimers.

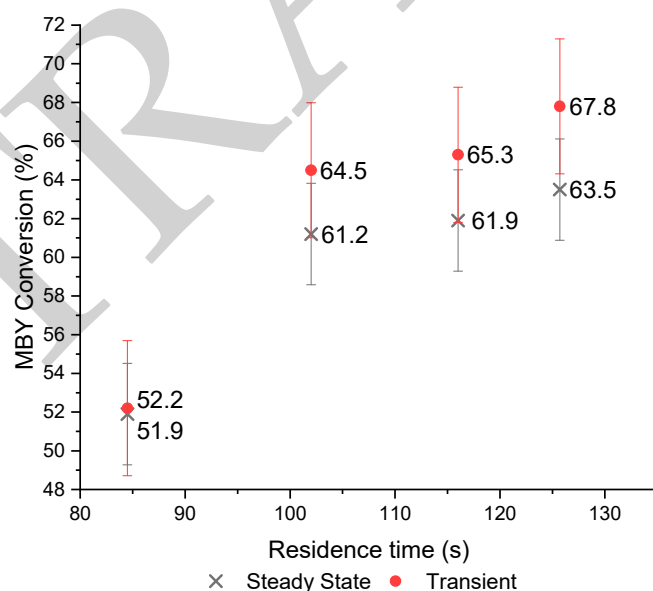


Figure 2. Conversion of MBY with residence time under steady-state and transient conditions where $A = 5\text{ }^{\circ}\text{C}$ and $\tau = 75\text{ s}$.

Figure 3 shows that for all of the residence times tested, an increase in selectivity is observed under transient operation. Shorter residence times result in a slightly higher selectivity towards MBE which is due to the insufficient time for the MBE to further transform into by-products. This is supported by the fact that the only overlap of the standard error bounds is seen at the longest residence time.

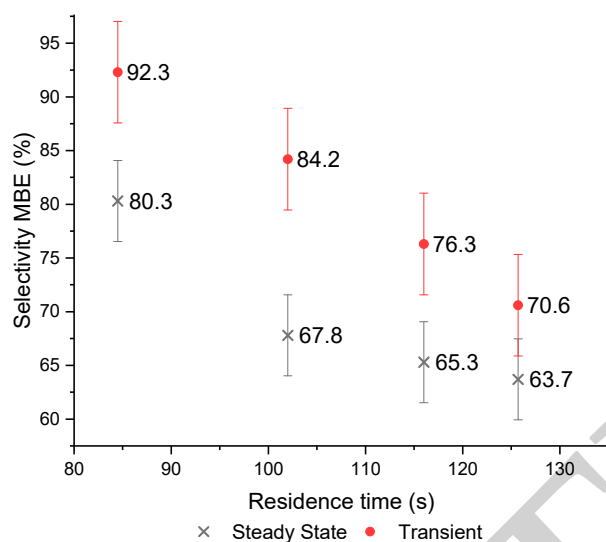


Figure 3. Selectivity towards MBE with residence time for steady state and transient conditions where $A = 5\text{ }^{\circ}\text{C}$ and $\tau = 75\text{ s}$.

While the conversions for both cases is very similar especially at shorter residence times, some of the most significant improvements in selectivity are seen here. An average increase of 16% of the selectivity towards MBE with the highest being 24% is observed suggesting that there is an improvement in the reaction rate as a result of temperature cycling.

The kinetics of the hydrogenation of MBY and MBE over Pd/TiO₂ were studied under steady state in the temperature range of 20–35 °C, atmospheric pressure and H₂ flow rate of 10 mL/min (Figure 4a,b), and apparent activation energies were calculated based on Arrhenius plots as shown in Figure 4c,d. The apparent activation energy of 12 kJ/mol was obtained for the hydrogenation of MBY over Pd/TiO₂, which is lower than the previously reported value of 64 kJ/mol [26]. The activation energy obtained for the hydrogenation of MBE to the fully hydrogenated product MBA was 9 kJ/mol. Low activation energy obtained for both MBY and MBE hydrogenations corroborates with experimental observation of virtually same conversion and no apparent rate enhancement of MBY hydrogenation in the transient reactor operation when compared to steady state. Improvement of the selectivity towards the partially hydrogenated product MBE mainly arises due to the temperature dependency of the rate of adsorption of MBY and desorption of MBE from the catalyst surface and relative surface coverage of the reactant and product species onto the catalyst.

Besides the non-linear effect of temperature on Langmuir-Hinshelwood kinetics contributing to an increase the rate of reaction as well and the selectivity obtained [27], another reason for the improvement in selectivity in heterogeneously catalyzed reactions has been postulated in previous studies to be a result of more preferential surface coverage induced by the transient operation. Favorable adsorption of the reactant as the product is desorbed with more ease prevents further reaction towards MBA and dimers in comparison to steady-state operation. Products that inhibit the catalytic activity are also able to be desorbed without the commitment of constant high-temperature operation which would simultaneously prevent adsorption of reactant molecules [2].

Another proposal is that different adsorbed species also tend to form islands with the reaction commencing on the perimeter. A study carried out on a palladium catalyst proposed that oscillations of temperature lead to adsorption-desorption cycles that are either shorter or comparable to the rate of island formation. The islands decreased in size and became more numerous leading to a larger perimeter, and therefore faster rate of reaction. The change of concentration of adsorbates induced surface restructuring of the catalyst, which could enhance oscillations through the generation of new frequencies [1].

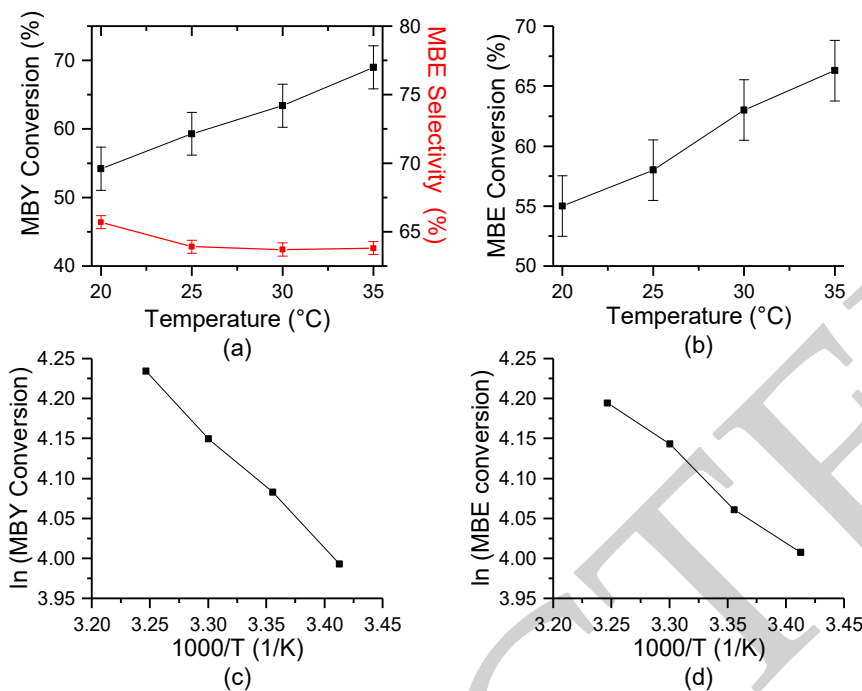


Figure 4. (a) Conversion of MBY and MBE with temperature; (b) conversion of MBE with temperature; (c) Arrhenius plot for MBY conversion; (d) Arrhenius plot for MBE conversion.

To summarize, transient operation through temperature cycling has been demonstrated to aid in maximizing the conversion and selectivity of the hydrogenation of MBY to MBE as a result of the surface coverage of the adsorbing species influenced by the rapid changes in temperature through integration of the radiofrequency heating system. To elaborate on this further, a detailed study of the influence of amplitude and oscillation period may be worthwhile.

Besides hydrogenation, there are other relevant reactant and product inhibited reactions where intermediate products are required such as oligomerization reactions involving ethylene or glycerol [28,29]. Product distribution control, which is possible through control of the reaction temperature and the catalyst, is susceptible to coking. Therefore, complex reaction systems of this kind would have the potential to be enhanced under transient operation. The remarkable improvement brought by this novel cooperation is particularly important in upscaling and green chemistry development. Many other relevant systems [18–20,28,29] are expected to be benefitted by this advance, and further exploration along these lines are now underway.

3. Materials and Methods

Figure 5 displays the dynamic operation of the reaction system where the amplitude represents the temperature increase and decrease from the initial point which was achieved by variation of the intensity of the magnetic field. The period of the function represents the time in which a complete cycle is completed. In our system, the steady-state experiments were carried out at 30 °C, and the transient experiments consisted of a 5 °C amplitude and a frequency of 75 s. It must be noted that the frequency should be high enough to avoid quasi-steady state while low enough to avoid a relaxed steady state or steady state. Operation within this window only would lead to an improvement in performance.

The set up consisted of a packed bed with a general structure consisting of various heating and catalytic zones. The design and characteristics of such micro- and milli-reactors have been described in detail elsewhere [30–32]. Comprehensive methods for catalyst synthesis may also be found here [21,31]. The set-up of the reactor is presented in Figure 6. The configuration of the reactor consisted of catalytic and heating zones composed of 150–300 μm of catalyst pellets, 106–120 μm ferrite particles and 100–150 μm glass beads. The initial concentration of MBY in xylene was 0.25 M, and liquid flows of 0.07, 0.1,

0.2 and 0.3 mL/min were used. The gas flow rate was 10 mL/min, and the reaction was conducted at atmospheric pressure. The products were analyzed using an offline gas chromatography equipped with a flame ionization detector.

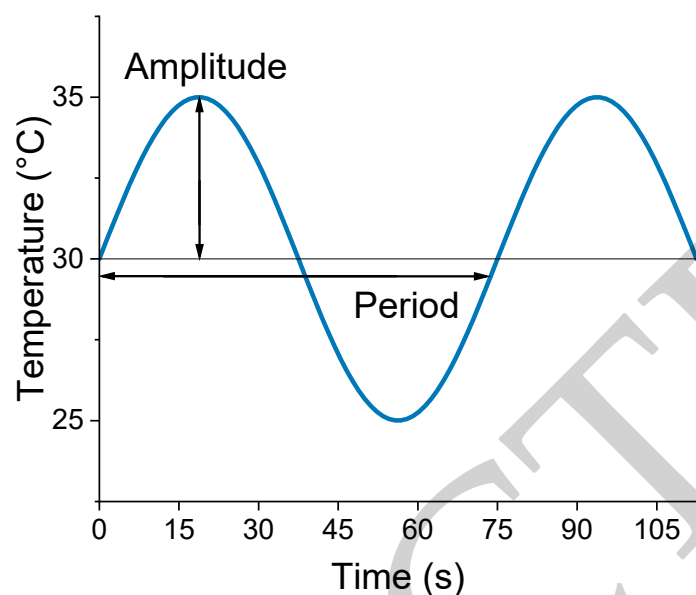


Figure 5. Dynamic operation representing temperature variation with time.

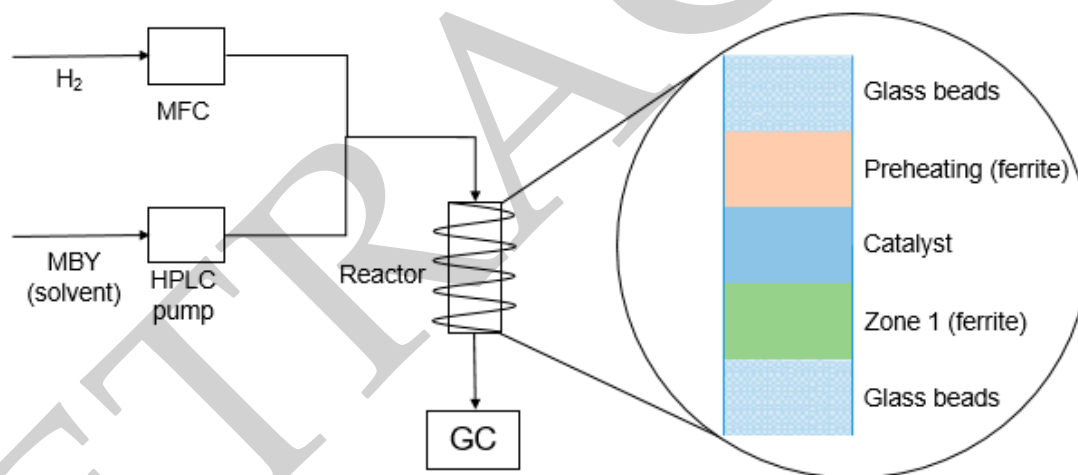


Figure 6. Set up of system to carry out MBY hydrogenation using a radiofrequency heated reactor.

Author Contributions: Conceptualization, J.F.G.; methodology, J.F.G. and D.R.; software, J.F.G.; validation, J.F.G. and D.R.; formal analysis, D.R., J.F.G., J.G., A.H. and C.-Y.H.; investigation, D.R., J.F.G., C.-Y.H., A.H. and J.G.; resources, D.R., J.F.G., C.-Y.H. and J.G.; data curation, J.F.G., J.G., A.H., C.-Y.H. and D.R.; writing—original draft preparation, D.R., J.F.G. and C.-Y.H.; writing—review and editing, D.R., J.F.G., C.-Y.H., J.G. and A.H.; visualization, J.F.G. and C.-Y.H.; supervision, J.F.G., J.G., A.H. and C.-Y.H.; project administration, J.F.G.; funding acquisition, J.F.G. and C.-Y.H.

Funding: This research was funded by Shenzhen Nobel Prize Scientists Laboratory Project (C17213101), SZ basic research fund (JCYJ 20170817105041557) and Ph.D. scholarship through SUSTech-Leeds Agreement.

Conflicts of Interest: The authors declare no conflict of interest.

References

1. Hansen, H.A.; Olsen, J.L.; Jensen, S.; Hansen, O.; Quaade, U.J. Rate enhancement in microfabricated chemical reactors under fast forced temperature oscillations. *Catal. Commun.* **2006**, *7*, 272–275. [[CrossRef](#)]
2. Brandner, J.J.; Emig, G.; Liauw, M.A.; Schubert, K. Fast temperature cycling in microstructure devices. *Chem. Eng. J.* **2004**, *101*, 217–224. [[CrossRef](#)]
3. Jensen, S.; Olsesn, J.L.; Thorsteinsson, S.; Hansen, O.; Quaade, U.J. Forced thermal cycling of catalytic reactions: Experiments and modelling. *Catal. Commun.* **2007**, *8*, 1985–1990. [[CrossRef](#)]
4. Luther, M.; Brandner, J.J.; Kiwi-Minsker, L.; Renken, A.; Schubert, K. Forced periodic temperature cycling of chemical reactions in microstructure devices. *Chem. Eng. Sci.* **2008**, *63*, 4955–4961. [[CrossRef](#)]
5. Luther, M.; Brandner, J.J.; Schubert, K.; Renken, A.; Kiwi-Minsker, L. Novel design of a microstructured reactor allowing fast temperature oscillations. *Chem. Eng. J.* **2008**, *135*, S254–S258. [[CrossRef](#)]
6. Sotowa, K.-I.; Shiraishi, N.; Iguchi, Y.; Sugiyama, S. Forced temperature cycling of a catalyst layer and its application to propylene oxidation. *Chem. Eng. Sci.* **2008**, *63*, 2690–2695. [[CrossRef](#)]
7. Nakano, T.; Sakurai, M.; Kameyama, H. Operating temperature conditions for periodic temperature cycling in a microreactor. *J. Chem. Eng. Jpn.* **2012**, *45*, 89–93. [[CrossRef](#)]
8. Stolte, J.; Özkan, L.; Thüne, P.C.; Niemantsverdriet, J.W.; Backx, A.C.P.M. Pulsed activation in heterogeneous catalysis. *Appl. Therm. Eng.* **2013**, *57*, 180–187. [[CrossRef](#)]
9. Sakurai, M.; Oku, H.; Kameyama, H. Parametric study of periodic temperature cycling using microreactor. *J. Chem. Eng. Jpn.* **2014**, *47*, 207–211. [[CrossRef](#)]
10. Kumar, S.; Lange, J.-P.; Van Rossum, G.; Kersten, S.R.A. Bio-oil fractionation by temperature-swing extraction: Principle and application. *Biomass Bioenergy* **2015**, *83*, 96–104. [[CrossRef](#)]
11. Ajbar, A.; Elnashaie, S.S.E.H. Controlling chaos by periodic perturbations in nonisothermal fluidized-bed reactor. *AIChE J.* **1996**, *42*, 3008–3019. [[CrossRef](#)]
12. Silveston, P.L.; Hudgins, R.R. Periodic temperature forcing of catalytic reactions. *Chem. Eng. Sci.* **2004**, *59*, 4043–4053. [[CrossRef](#)]
13. Brandner, J.J.; Silveston, P.L.; Hudgins, R.R. Chapter 16—Temperature modulation. In *Periodic Operation of Chemical Reactors*; Silveston, P.L., Hudgins, R.R., Eds.; Butterworth-Heinemann: Oxford, UK, 2013; pp. 435–462.
14. Bonrath, W.; Medlock, J.; Schutz, J.; Wustenberg, B.; Netscher, T. Hydrogenation in the vitamins and fine chemicals industry—An overview. *Hydrogenation* **2012**, *76*. [[CrossRef](#)]
15. Yilmaz, B.; Müller, U. Catalytic applications of zeolites in chemical industry. *Top. Catal.* **2009**, *52*, 888–895. [[CrossRef](#)]
16. IBISWorld. *Basic Pharmaceutical Product Manufacturing in the UK*; IBISWorld: Los Angeles, CA, USA, 2018.
17. Hudgins, R.R.; Silveston, P.L. Chapter 2—Hydrogenation processes. In *Periodic Operation of Chemical Reactors*; Silveston, P.L., Hudgins, R.R., Eds.; Butterworth-Heinemann: Oxford, UK, 2013; pp. 23–47.
18. Liprandi, D.A.; Cagnola, E.A.; Quiroga, M.E.; L'Argentière, P.C. Influence of the reaction temperature on the 3-hexyne semi-hydrogenation catalyzed by a palladium(ii) complex. *Catal. Lett.* **2009**, *128*, 423–433. [[CrossRef](#)]
19. Cattaneo, S.; Freakley, S.J.; Morgan, D.J.; Sankar, M.; Dimitratos, N.; Hutchings, G.J. Cinnamaldehyde hydrogenation using au–pd catalysts prepared by sol immobilisation. *Catal. Sci. Technol.* **2018**, *8*, 1677–1685. [[CrossRef](#)]
20. Bhogeswararao, S.; Srinivas, D. Catalytic conversion of furfural to industrial chemicals over supported pt and pd catalysts. *J. Catal.* **2015**, *327*, 65–77. [[CrossRef](#)]
21. Fernández, J.; Chatterjee, S.; Degirmenci, V.; Rebrov Evgeny, V. Scale-up of an rf heated micro trickle bed reactor to a kg/day production scale. *Green Process.Synth.* **2015**, *4*, 343–353. [[CrossRef](#)]
22. Fernández, J.; Sotenko, M.; Derevschikov, V.; Lysikov, A.; Rebrov, E.V. A radiofrequency heated reactor system for post-combustion carbon capture. *Chem. Eng. Process. Process Intensif.* **2016**, *108*, 17–26. [[CrossRef](#)]
23. Sotenko, M.; Fernández, J.; Hu, G.; Derevschikov, V.; Lysikov, A.; Parkhomchuk, E.; Semeykina, V.; Okunev, A.; Rebrov, E.V. Performance of novel cao-based sorbents in high temperature co2 capture under rf heating. *Chem. Eng. Process. Process Intensif.* **2017**, *122*, 487–492. [[CrossRef](#)]
24. Pérez-Camacho, M.N.; Abu-Dahrieh, J.; Rooney, D.; Sun, K. Biogas reforming using renewable wind energy and induction heating. *Catal. Today* **2015**, *242*, 129–138. [[CrossRef](#)]

25. Zdražil, A.; Štěpánek, F. Remote control of reaction rate by radiofrequency heating of composite catalyst pellets. *Chem. Eng. Sci.* **2015**, *134*, 721–726. [[CrossRef](#)]
26. Rebrov, E.V.; Klinger, E.A.; Berenguer-Murcia, A.; Sulman, E.M.; Schouten, J.C. Selective hydrogenation of 2-methyl-3-butyne-2-ol in a wall-coated capillary microreactor with a pd₂₅zn₇₅/tio₂ catalyst. *Org. Process Res. Dev.* **2009**, *13*, 991–998. [[CrossRef](#)]
27. Kalz, K.F.; Kraehnert, R.; Dvoyashkin, M.; Dittmeyer, R.; Gläser, R.; Krewer, U.; Reuter, K.; Grunwaldt, J.-D. Future challenges in heterogeneous catalysis: Understanding catalysts under dynamic reaction conditions. *ChemCatChem* **2017**, *9*, 17–29. [[CrossRef](#)]
28. Finiels, A.; Fajula, F.; Hulea, V. Nickel-based solid catalysts for ethylene oligomerization—A review. *Catal. Sci. Technol.* **2014**, *4*, 2412–2426. [[CrossRef](#)]
29. Ardila-Suarez, C.; Rojas-Avellaneda, D.; Ramirez-Caballero, G.E. Effect of temperature and catalyst concentration on polyglycerol during synthesis. *Int. J. Polym. Sci.* **2015**, *2015*, 910249. [[CrossRef](#)]
30. Chatterjee, S.; Degirmenci, V.; Aiouache, F.; Rebrov, E.V. Design of a radio frequency heated isothermal micro-trickle bed reactor. *Chem. Eng. J.* **2014**, *243*, 225–233. [[CrossRef](#)]
31. Chatterjee, S.; Degirmenci, V.; Rebrov, E.V. Design and operation of a radio-frequency heated micro-trickle bed reactor for consecutive catalytic reactions. *Chem. Eng. J.* **2015**, *281*, 884–891. [[CrossRef](#)]
32. Chatterjee, S.; Houlding, T.K.; Doluda, V.Y.; Molchanov, V.P.; Matveeva, V.G.; Rebrov, E.V. Thermal behavior of a catalytic packed-bed milli-reactor operated under radio frequency heating. *Ind. Eng. Chem. Res.* **2017**, *56*, 13273–13280. [[CrossRef](#)]



© 2019 by the authors. Licensee MDPI, Basel, Switzerland. This article is an open access article distributed under the terms and conditions of the Creative Commons Attribution (CC BY) license (<http://creativecommons.org/licenses/by/4.0/>).