Integration: Critical at the Start of the Chemical Industry, *Not So Much Now….*

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The Dow Chemical Company

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What I hope to leave you with

- Integration was crucial in the development of the chemical industry but has decreased in importance
- Inorganic chemistry created the chemical industry and remains important, but not particularly valued
- Scale remains the major source of competitive advantage in commodity chemicals

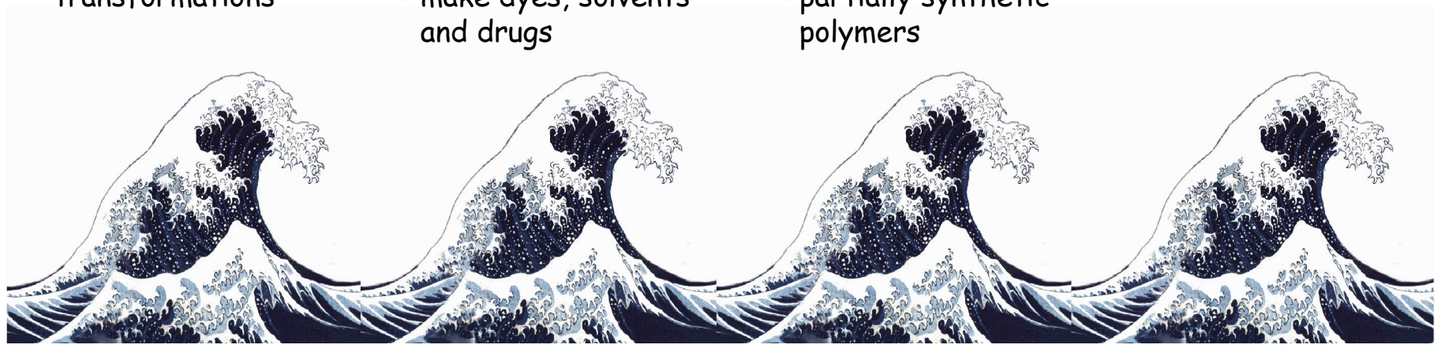
Chemical Industry Technology Waves

Inorganic
- mined materials
- electrochemical
- active reagents allow transformations

Functionalization
- use inorganics to transform organic substrates
- make dyes, solvents and drugs

Cellulosics
- use inorganics to transform natural materials
- partially synthetic polymers

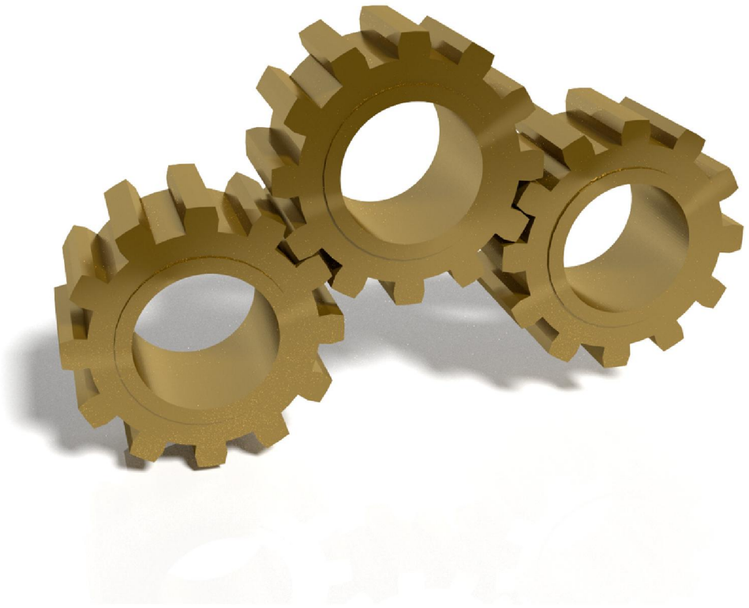
Polymers
- took off with synthetic rubber
- continues today



1760-1910	1870-1930	1895-1935	1925-present
rocks ⇨	coal ⇨	biomass ⇨	petroleum NGL

What is Integration?

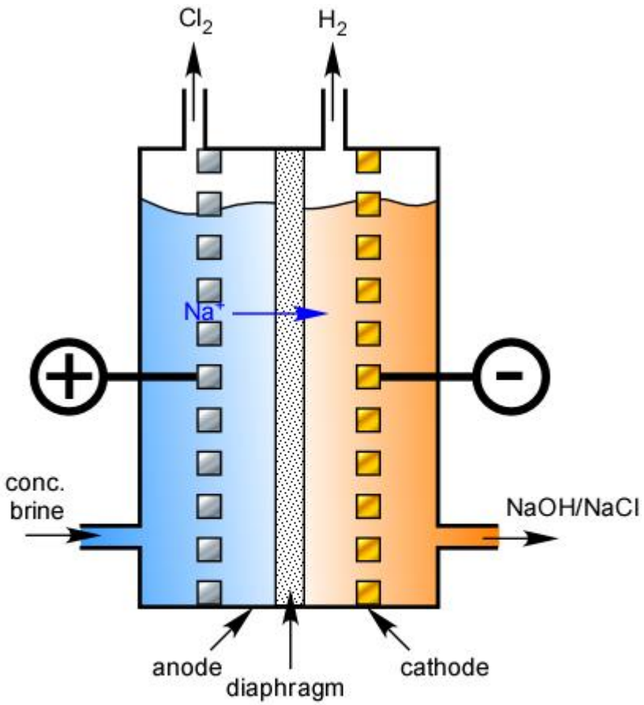
Integration



Linkage of mass and energy flows that create a significant advantage.


Cl
Cl

Chlor-Alkali



$$2\ Cl^- \longrightarrow Cl_2 + 2\ e^-$$

$$2\ H_2O + 2\ e^- \longrightarrow H_2 + 2\ OH^-$$

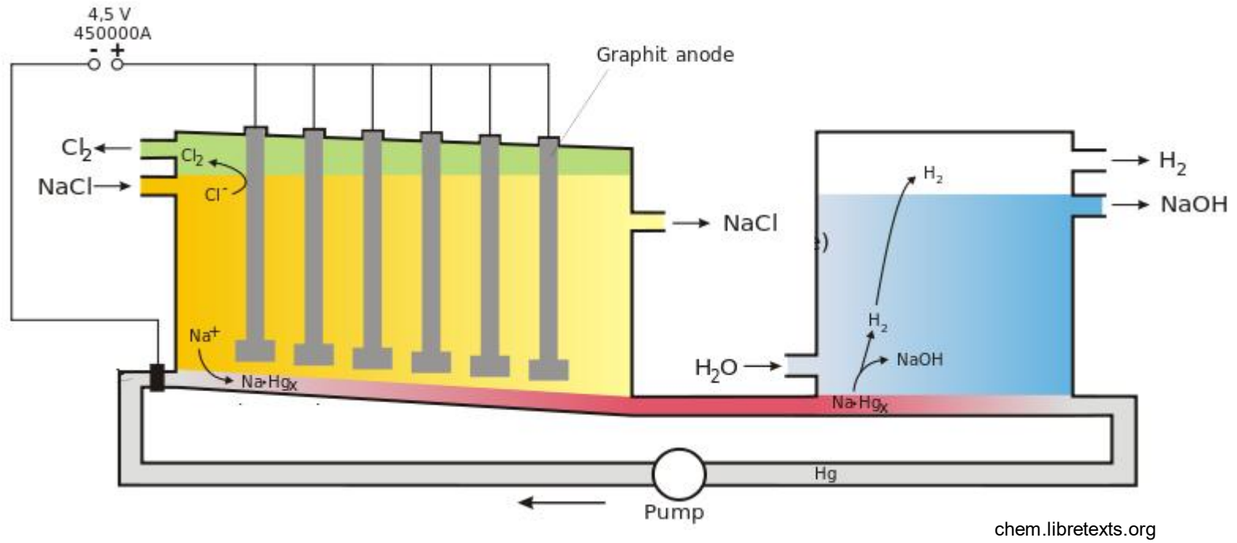
$$2\ NaCl + 2\ H_2O \longrightarrow 2\ NaOH + Cl_2 + H_2$$

Bleach was the Product

The oxidizing power of chlorine was what was desired.

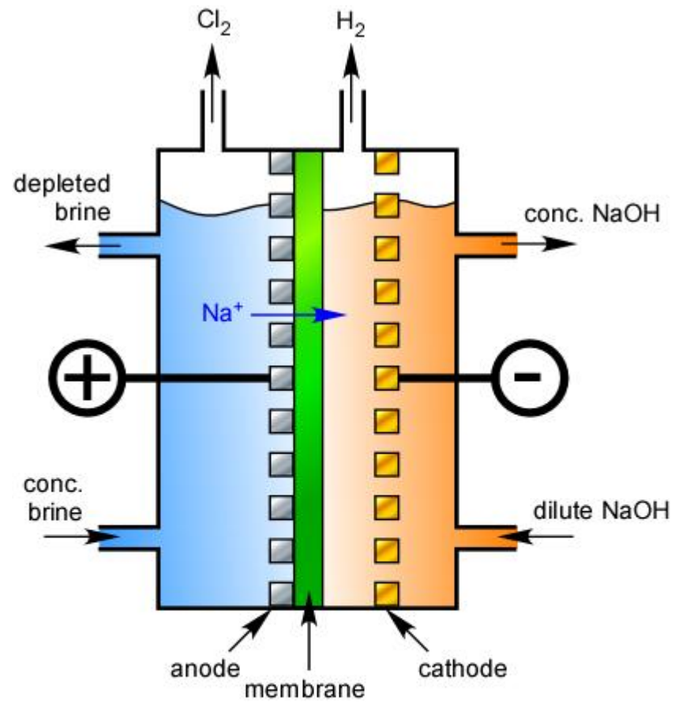
No net production of alkali

Mercury Cells



chem.libretexts.org

Membrane Cells



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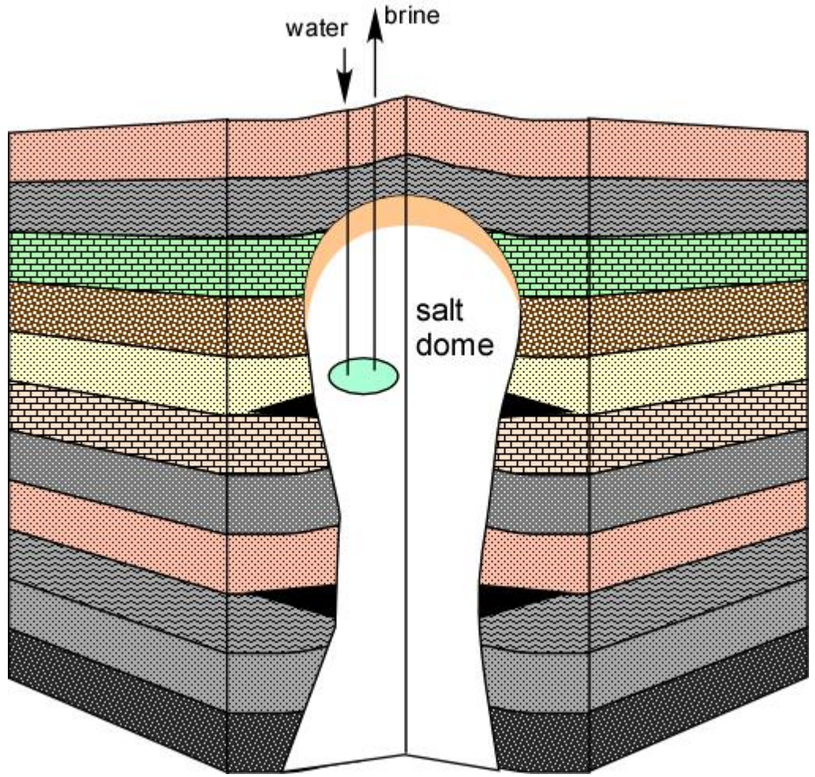
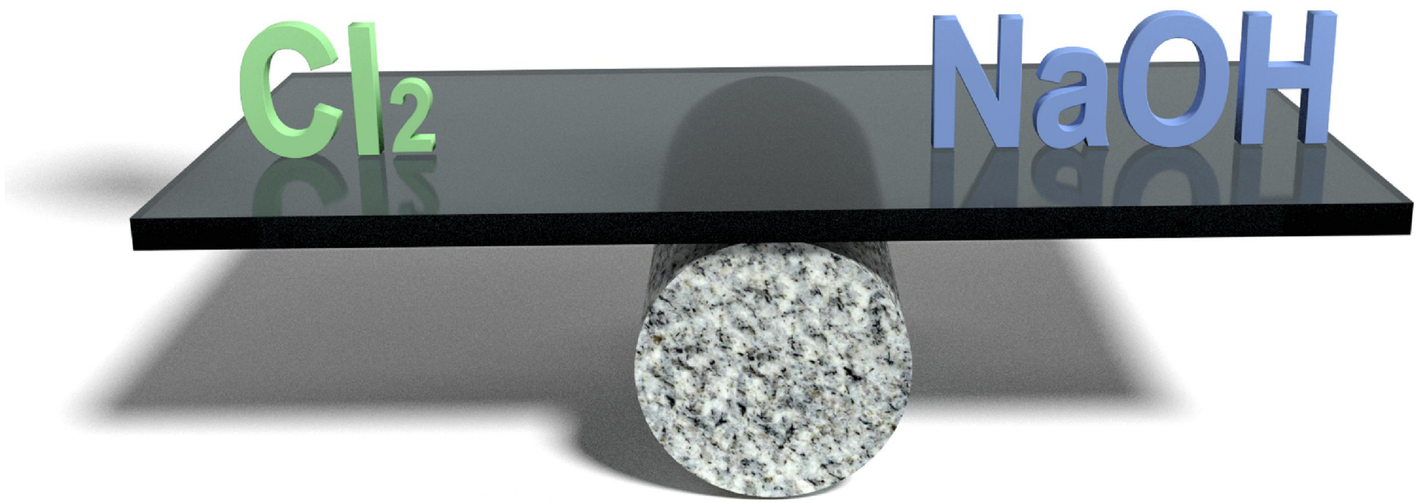
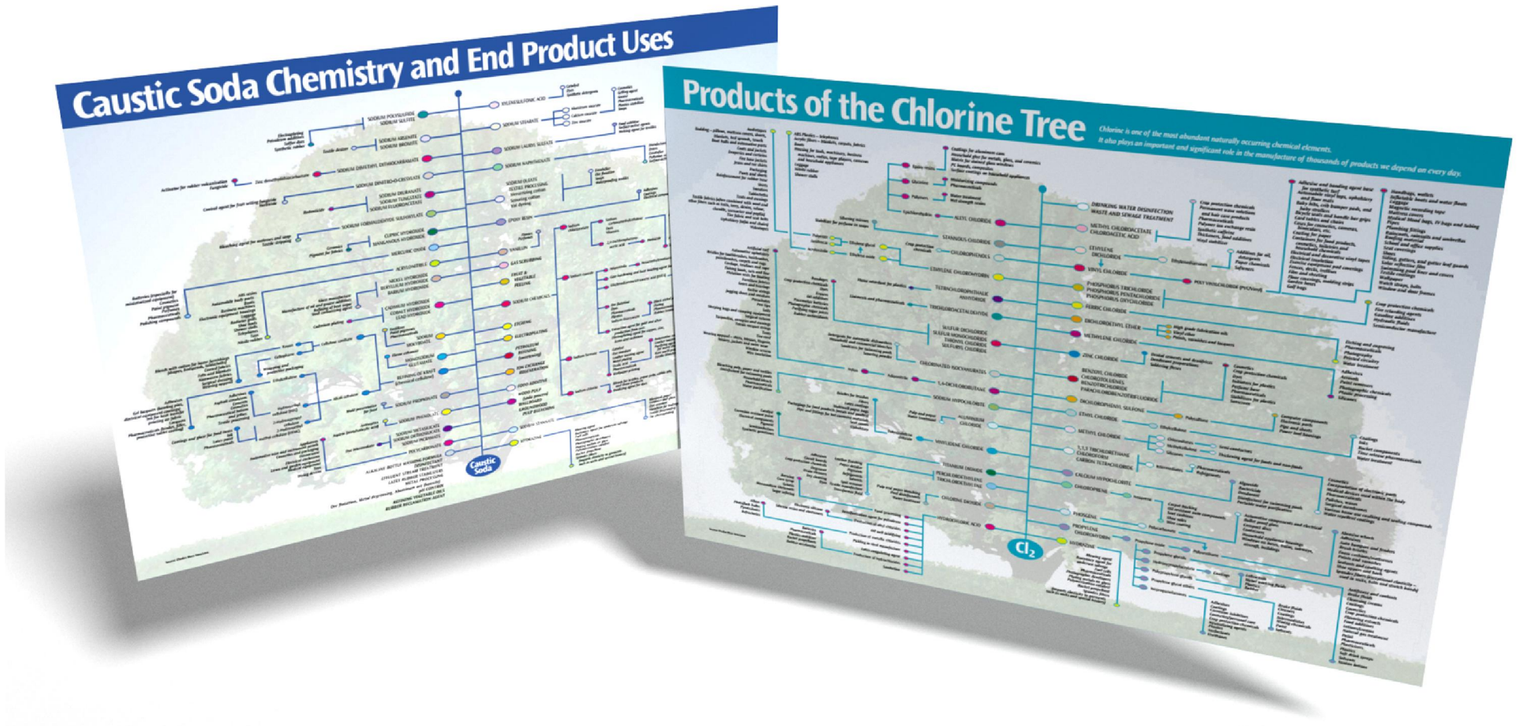
$$2\ NaCl + 2\ H_2O \longrightarrow 2\ NaOH + Cl_2 + H_2$$

Brine Mining

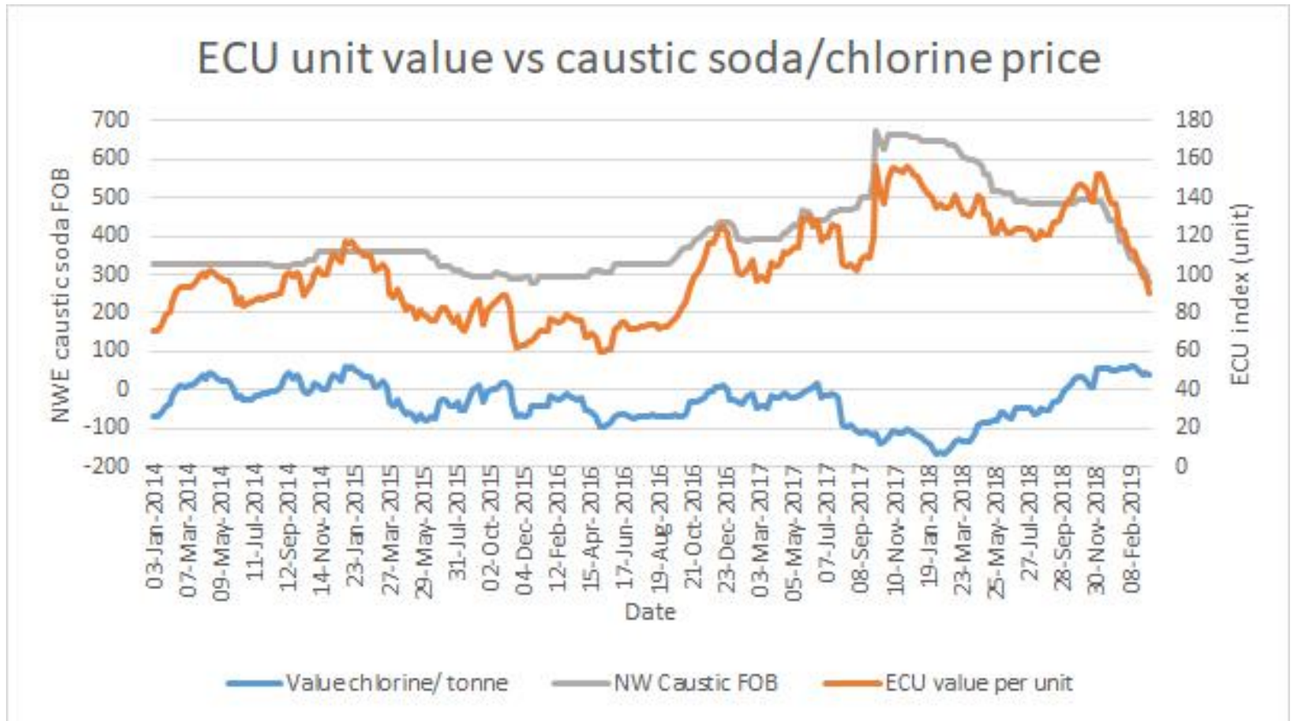


Balancing the ECU



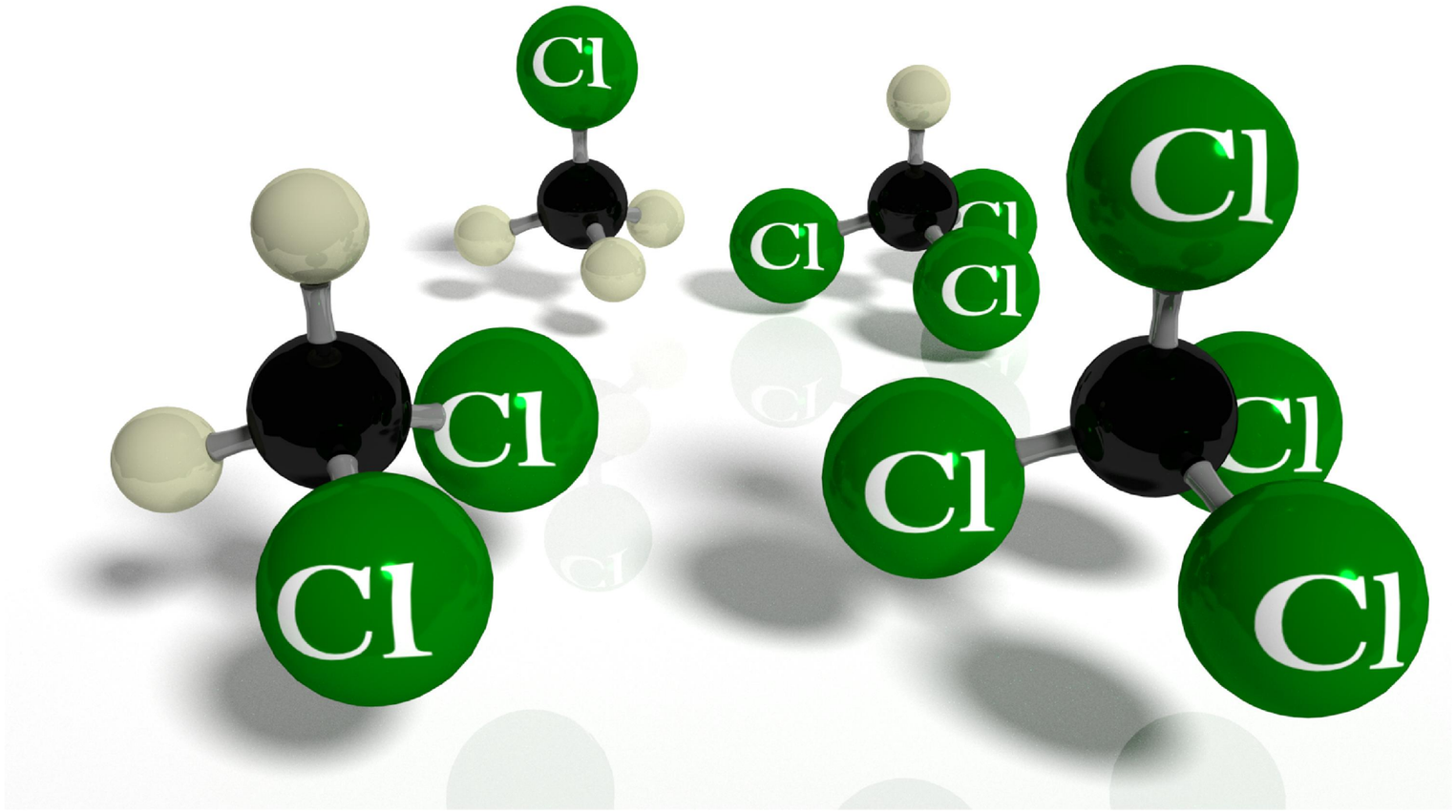

Caustic Soda Chemistry and End Product Uses
Products of the Chlorine Tree
Chlorine is one of the most abundant naturally occurring chemical elements.
It also plays an important and significant role in the manufacture of thousands of products we depend on every day.
Caustic Soda
Cl2

ECU Pricing



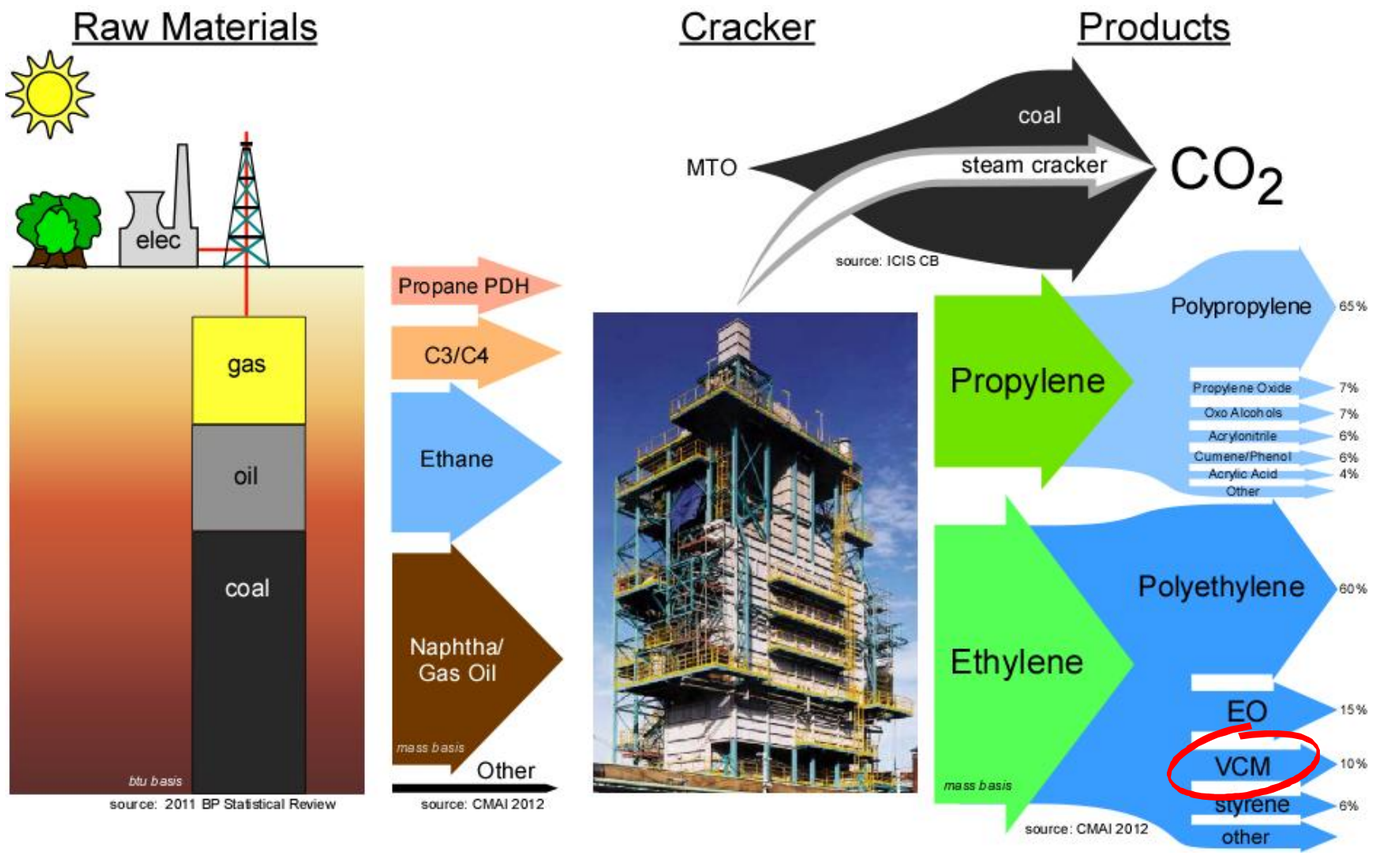
icis.com/explore/resources/news/2019/03/21/10336962/insight-european-ecu-values-fall-to-the-lowest-level-since-2016/

Organochlorides

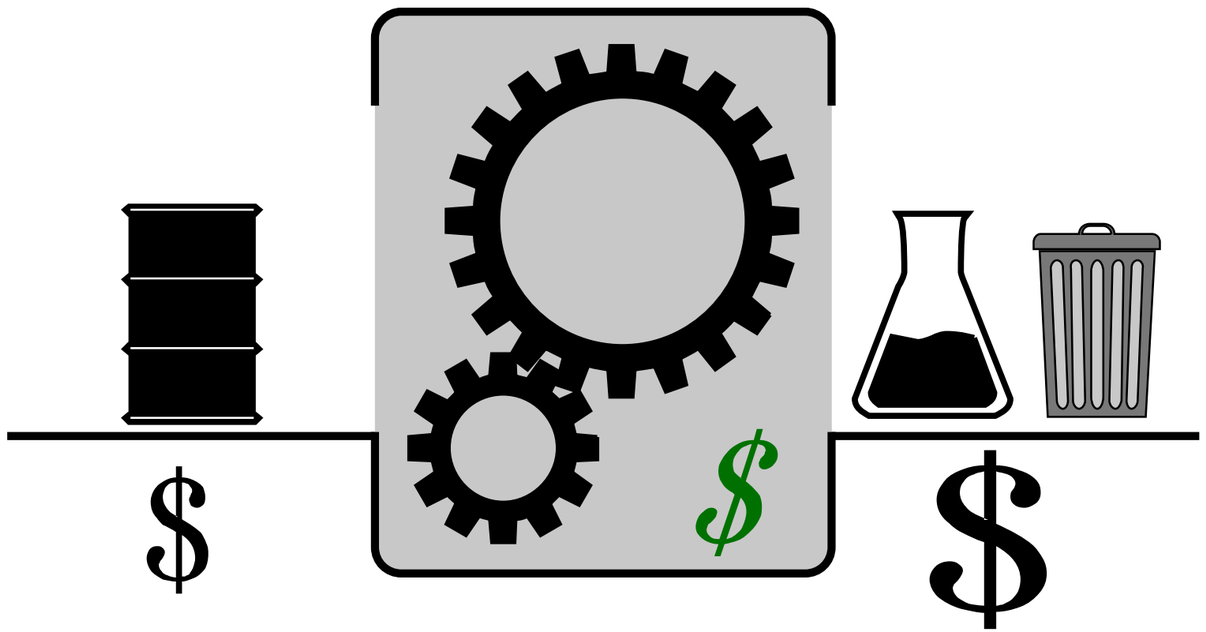



Pyrene
TO OPERATE
WORK LIKE A PUM

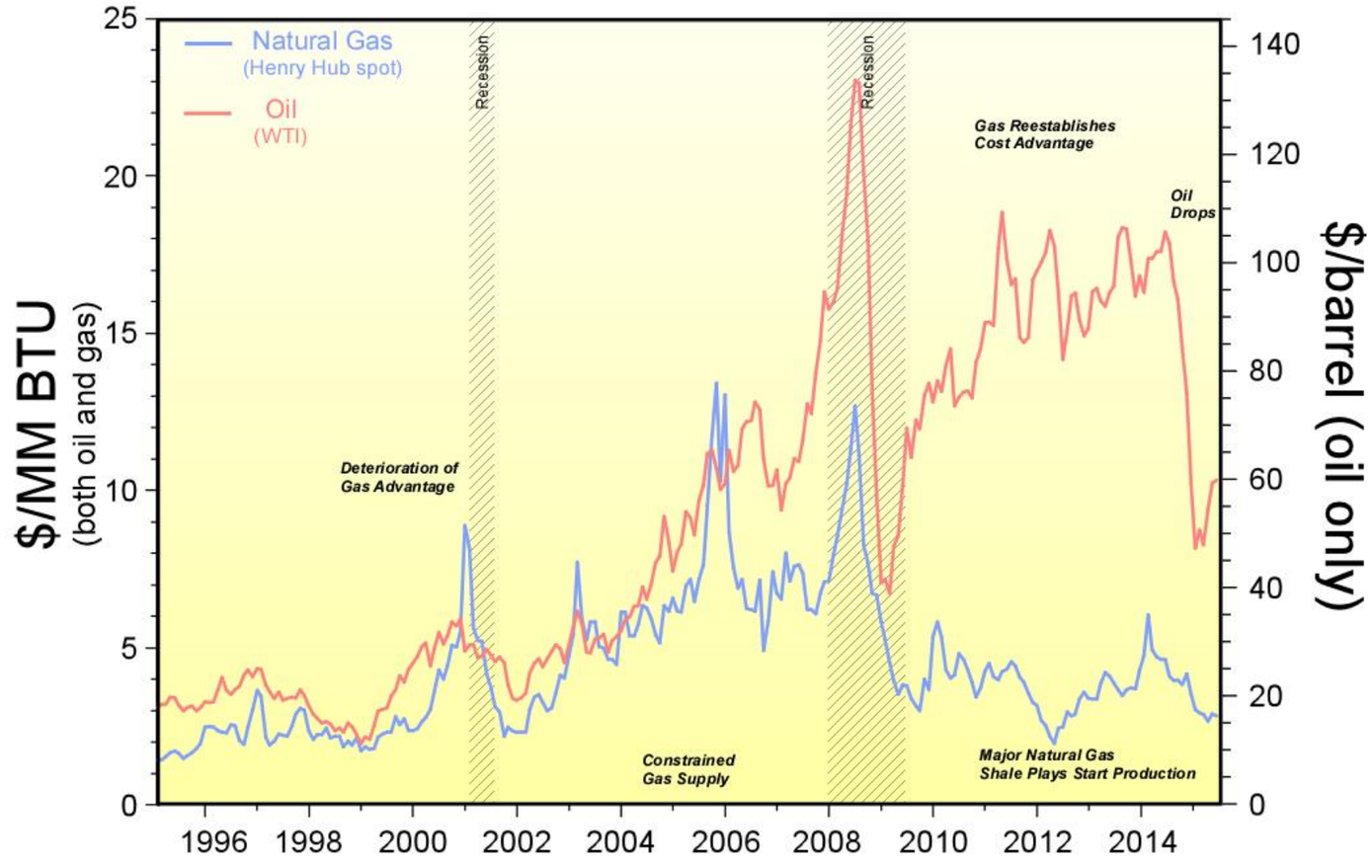
Chemical Industry Snapshot



Simplified Chemical Industry

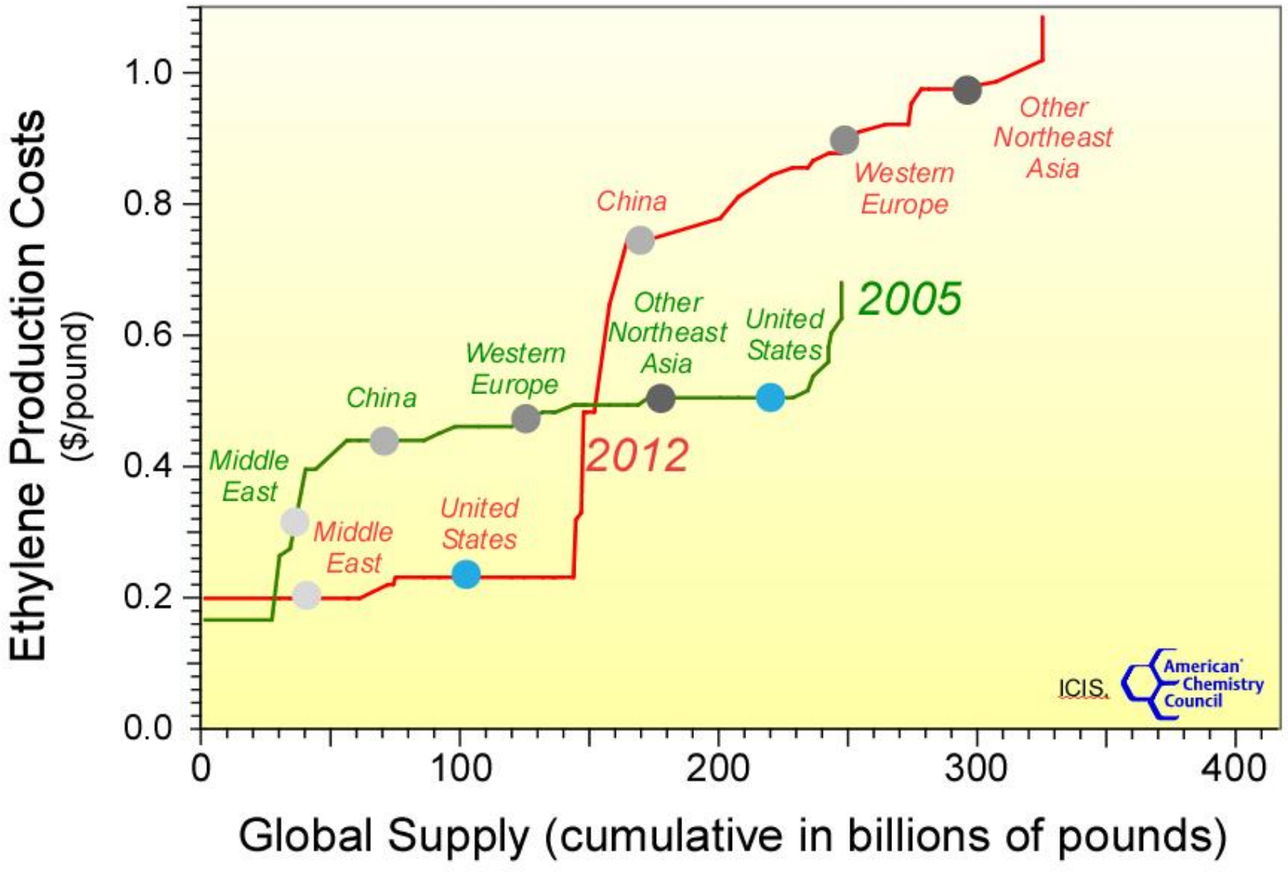


Recent Industry History



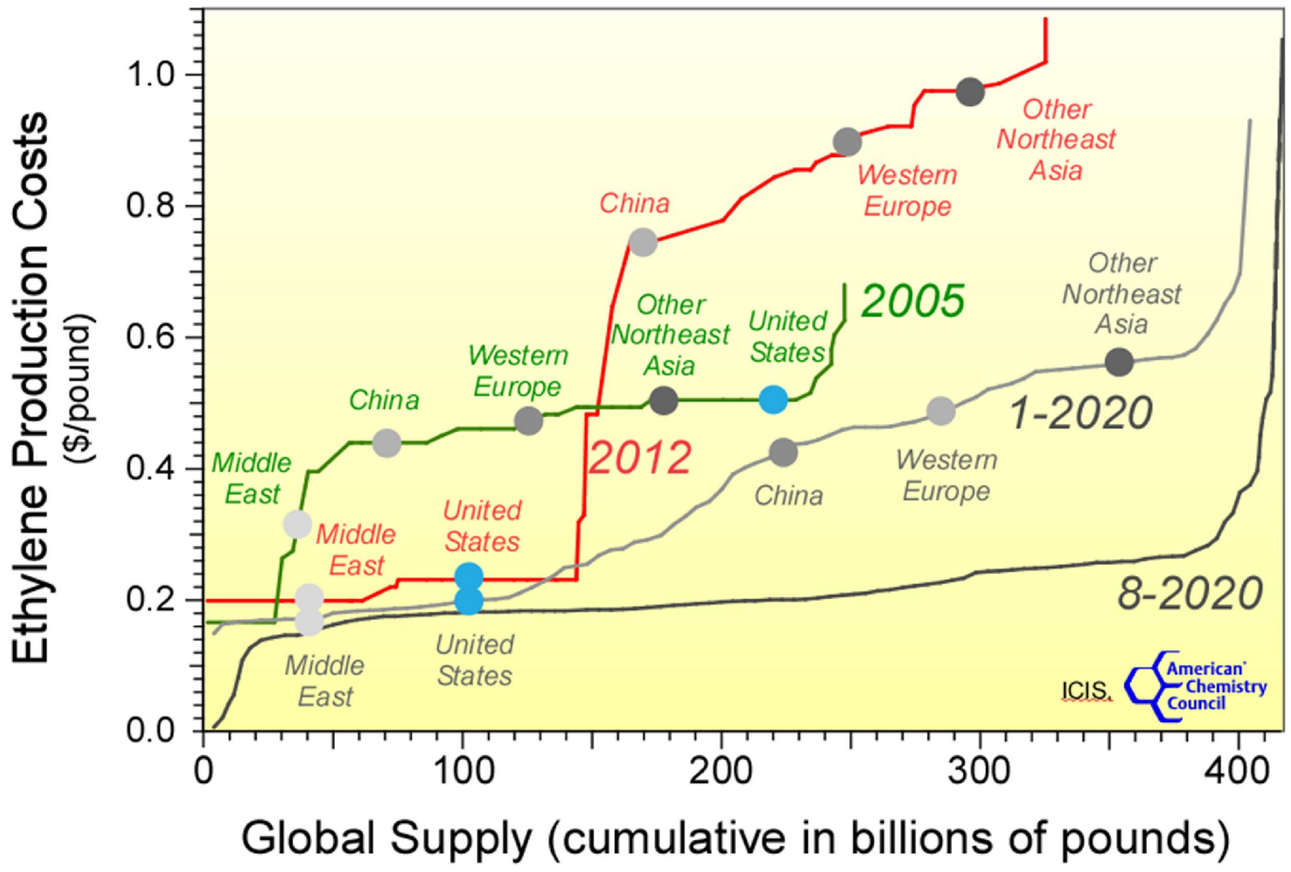
Ethane Price Now Tracks Gas

Impact of Low Gas Prices

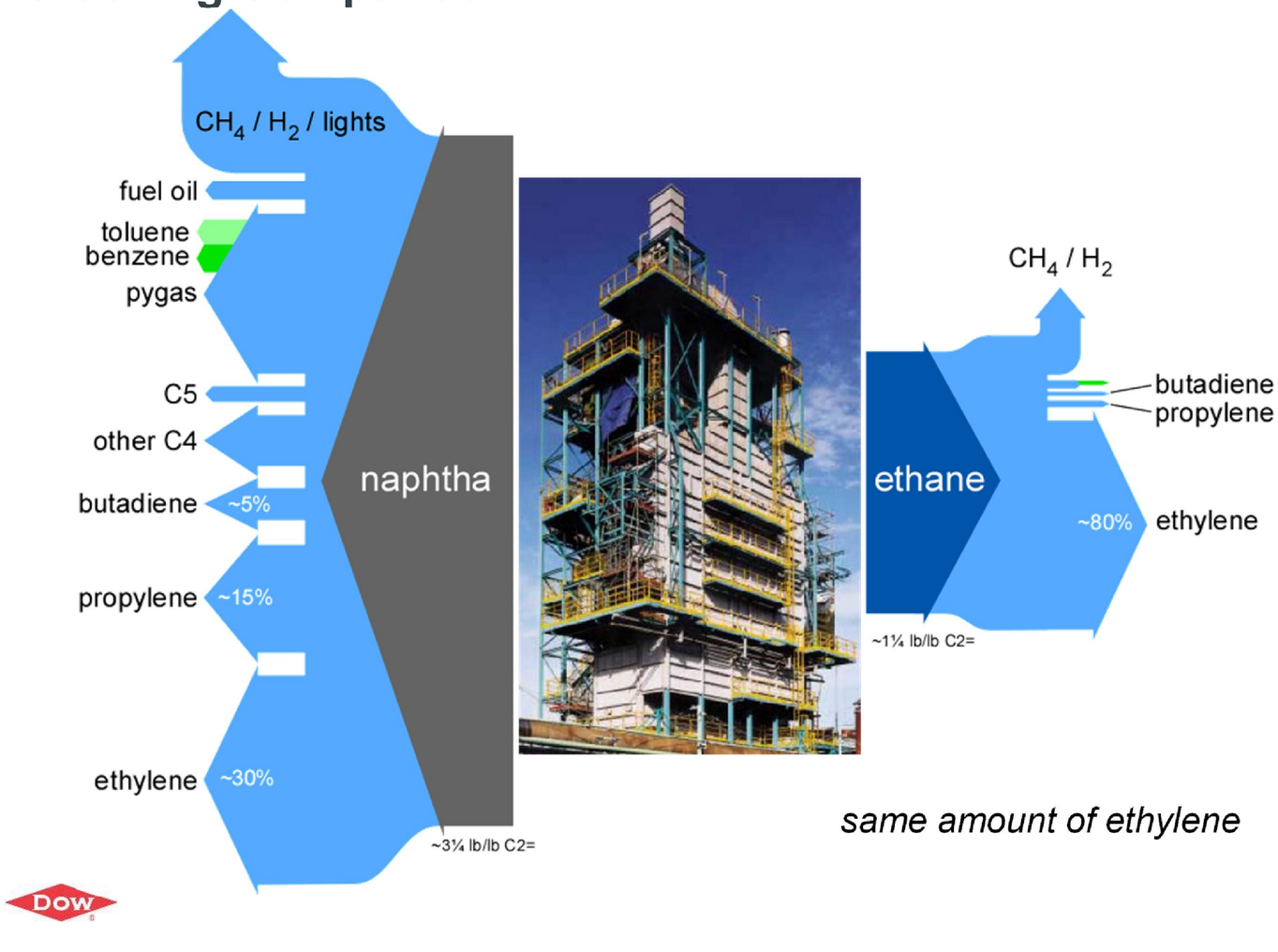


DOW

Impact of Low Gas Prices

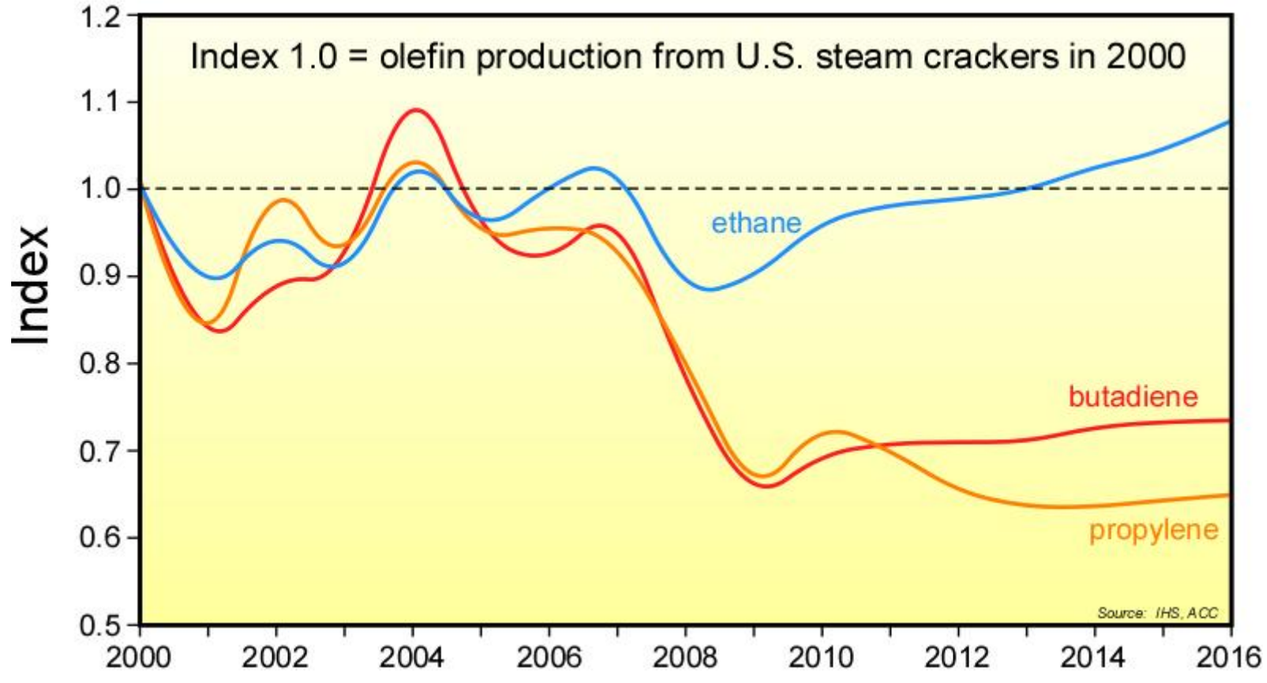


Cracking Comparison

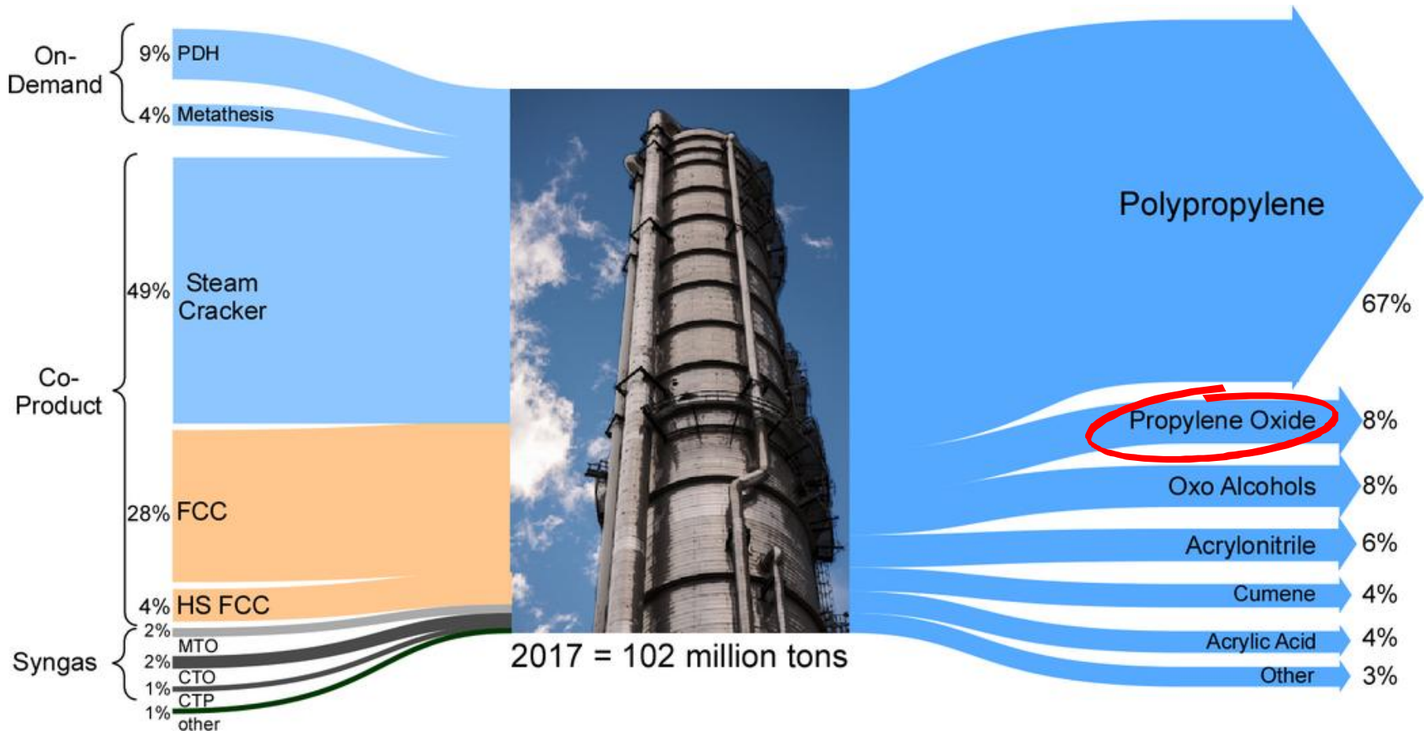


same amount of ethylene

Production of C3/C4 Dropped

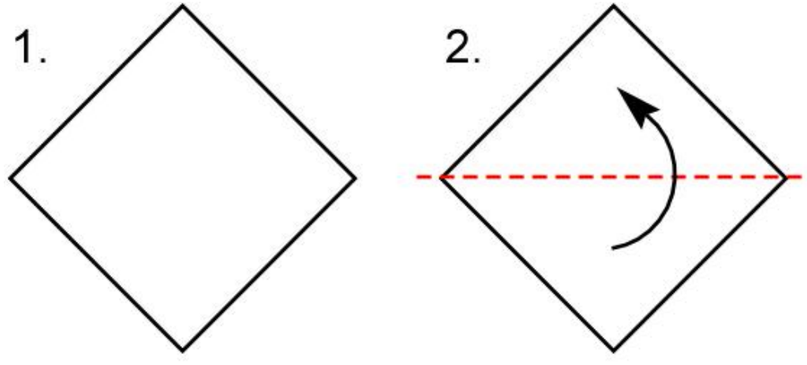


World Propylene

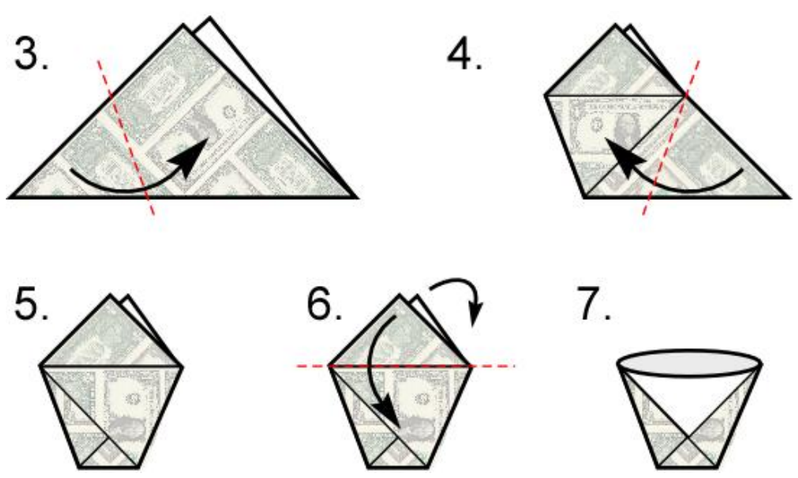


Scale Is Important

Scale Demo



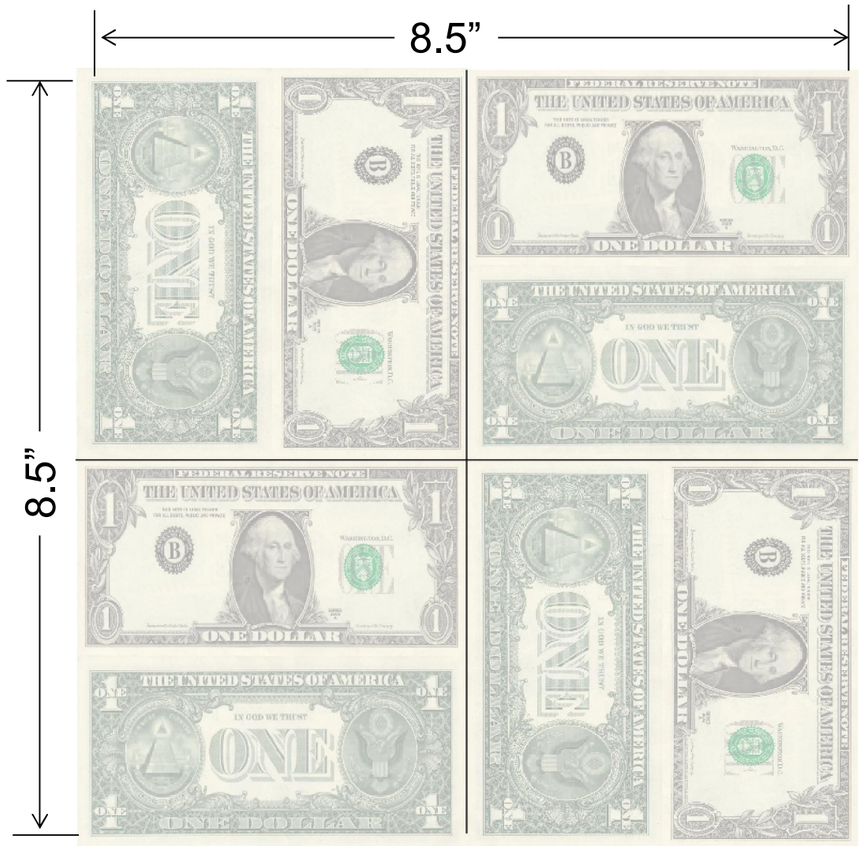
Make a cup with an 8½” square and another with a 4¼” square



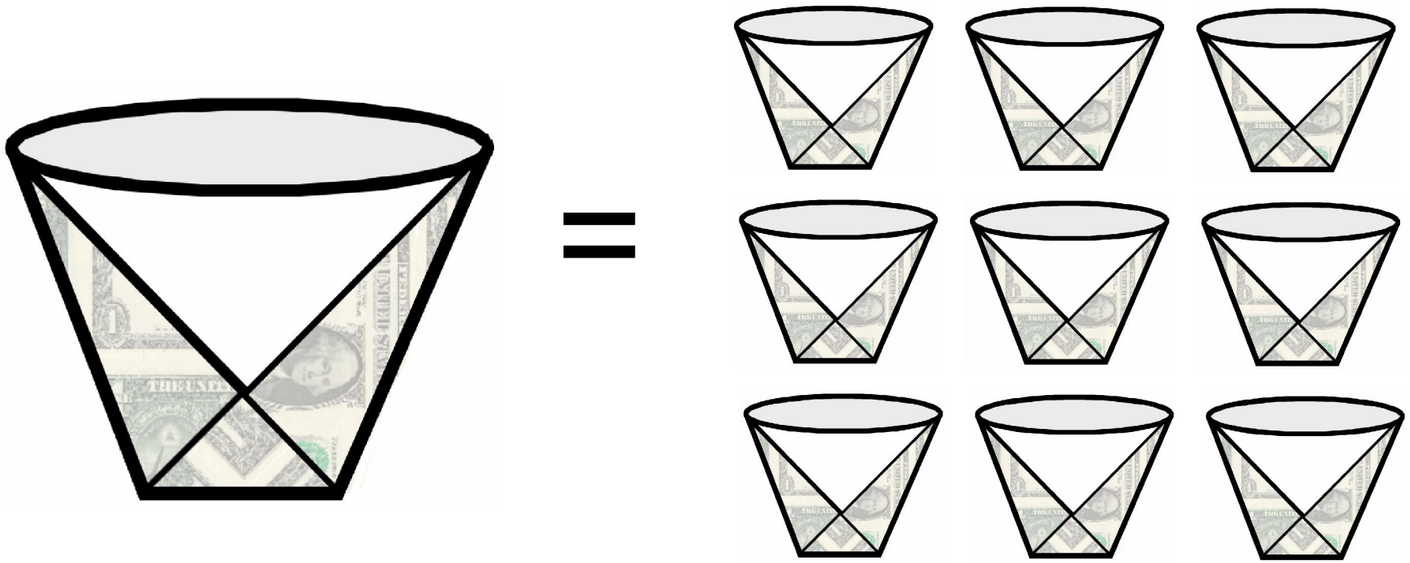
Show Video

https://www.mjphd.net/OrigamiDemo.html

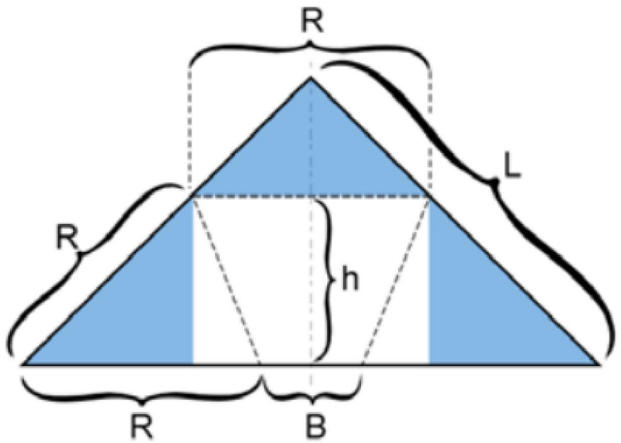
Video Demo



Scale Wins



Demo Math



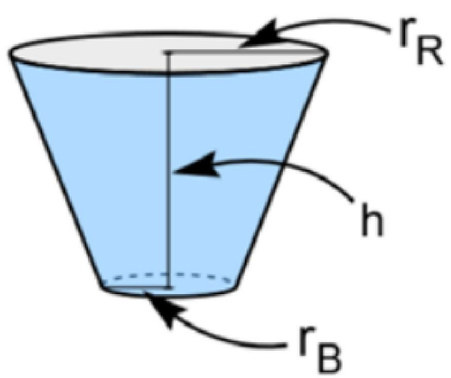
$$A = L^2$$

$$h = \frac{L}{1+\sqrt{2}}$$

$$R = \frac{\sqrt{2}\ L}{1+\sqrt{2}}$$

$$B = \frac{L\,(2-\sqrt{2}\,)}{1+\sqrt{2}}$$

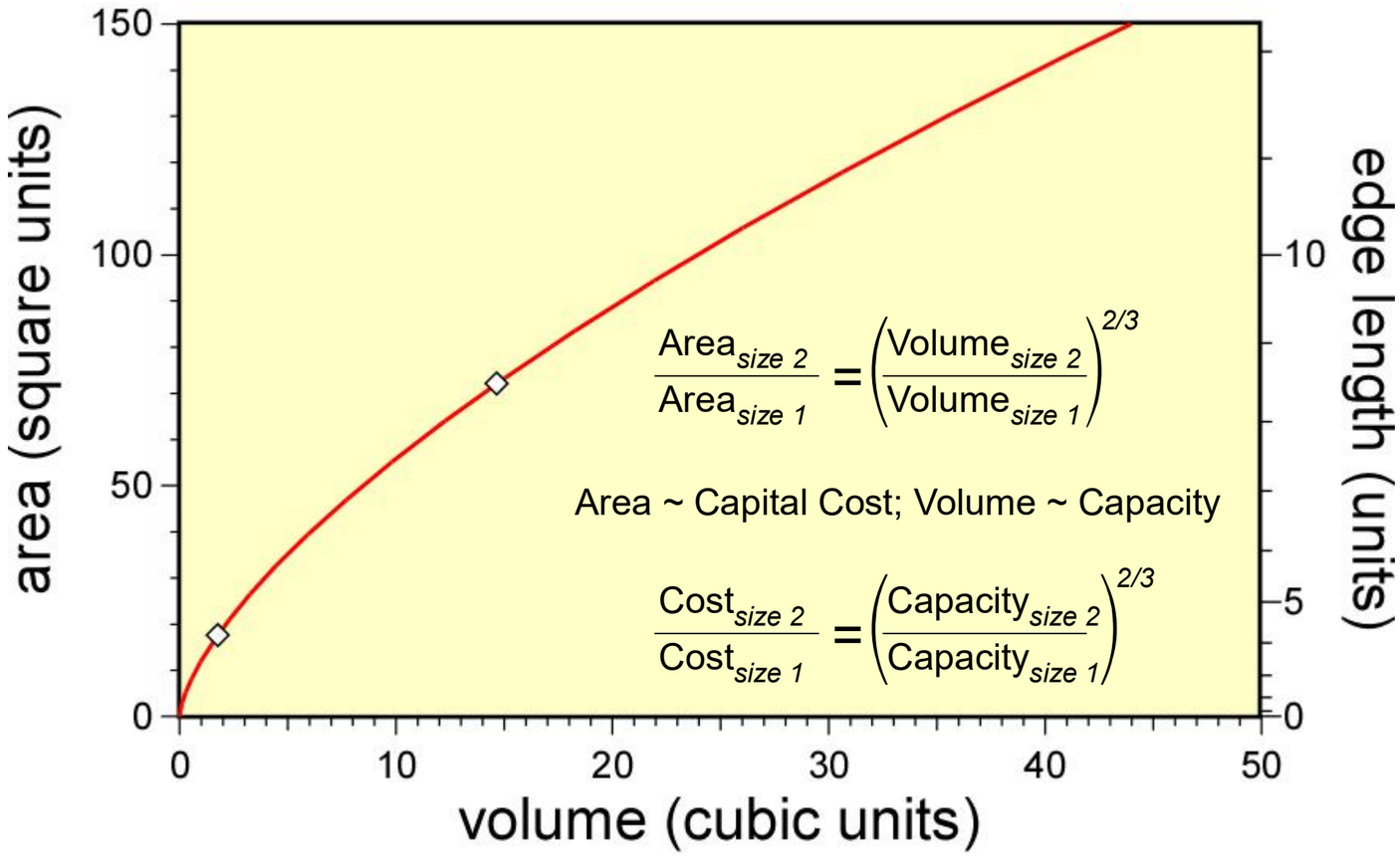
$$\frac{V_L}{V_{L/2}} = 8$$



$$r_B = \frac{B}{\pi} = \frac{L\,(2-\sqrt{2}\,)}{\pi\,(1+\sqrt{2}\,)}$$

$$r_R = \frac{R}{\pi} = \frac{\sqrt{2}\ L}{\pi\,(1+\sqrt{2}\,)}$$

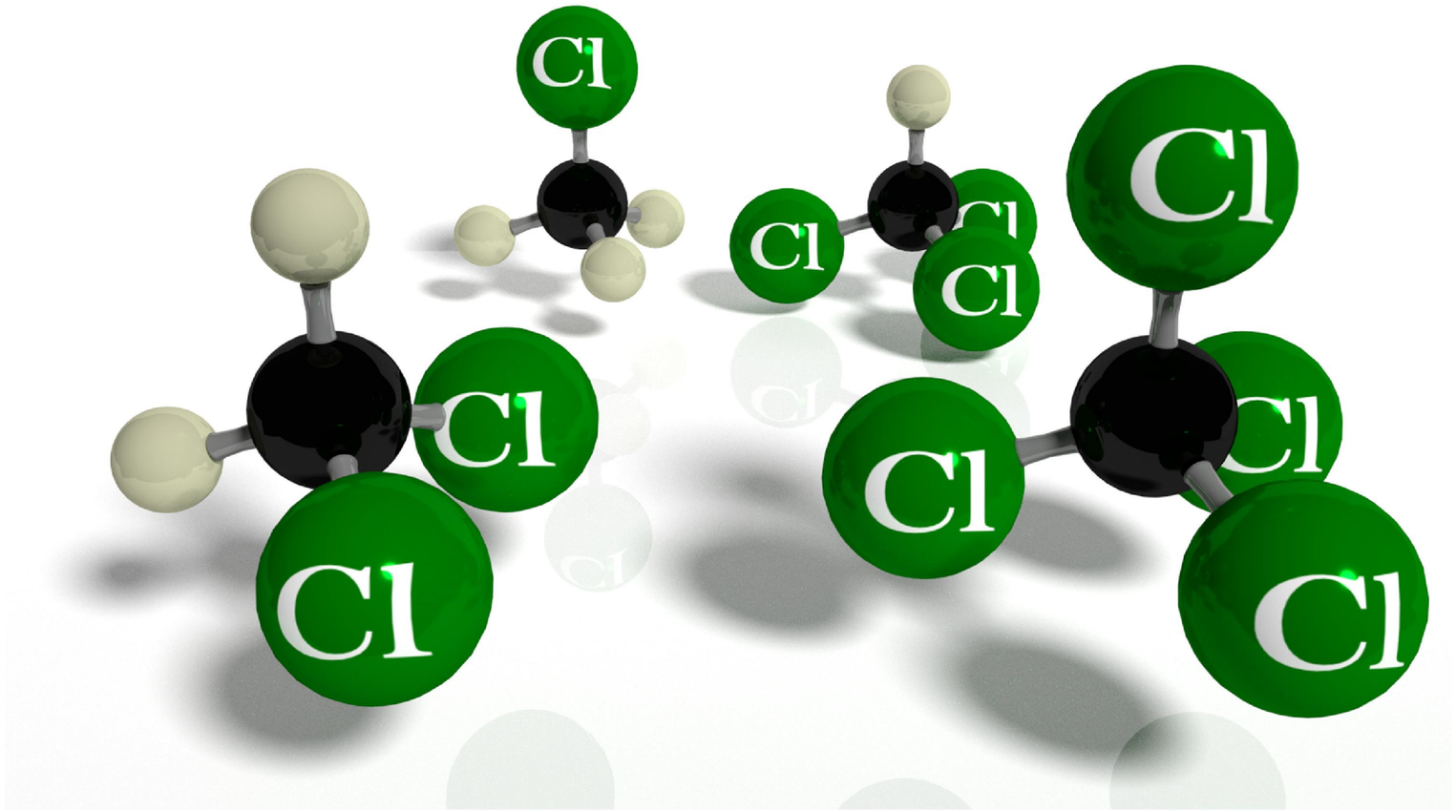
Power Law


150
100
50
0
0
10
20
30
40
50
volume (cubic units)
area (square units)
edge length (units)
10
5
0
$\frac{\text{Area}_{size\ 2}}{\text{Area}_{size\ 1}} = \left(\frac{\text{Volume}_{size\ 2}}{\text{Volume}_{size\ 1}}\right)^{2/3}$
Area ~ Capital Cost; Volume ~ Capacity
$\frac{\text{Cost}_{size\ 2}}{\text{Cost}_{size\ 1}} = \left(\frac{\text{Capacity}_{size\ 2}}{\text{Capacity}_{size\ 1}}\right)^{2/3}$

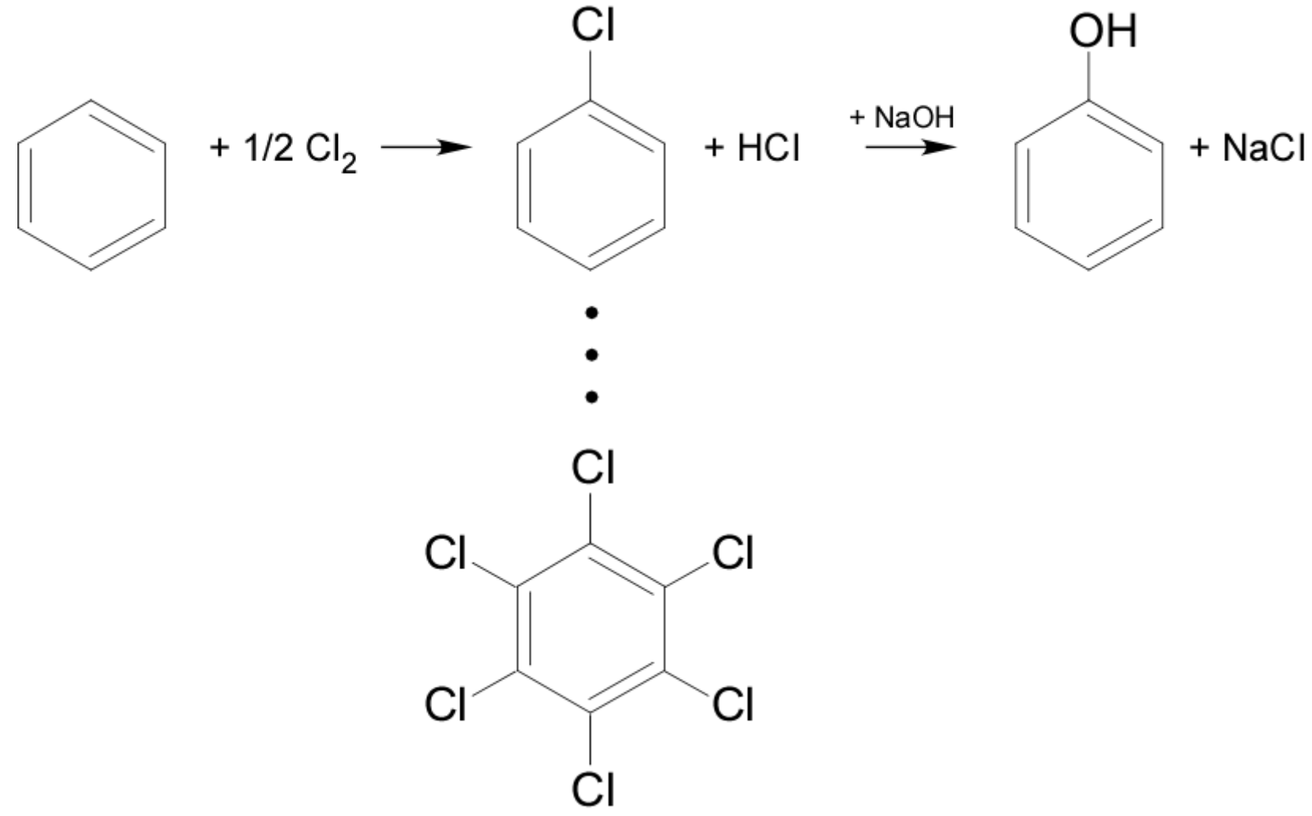
Scale Always Wins

If you are moving mass around, scale reduces cost faster than experience.

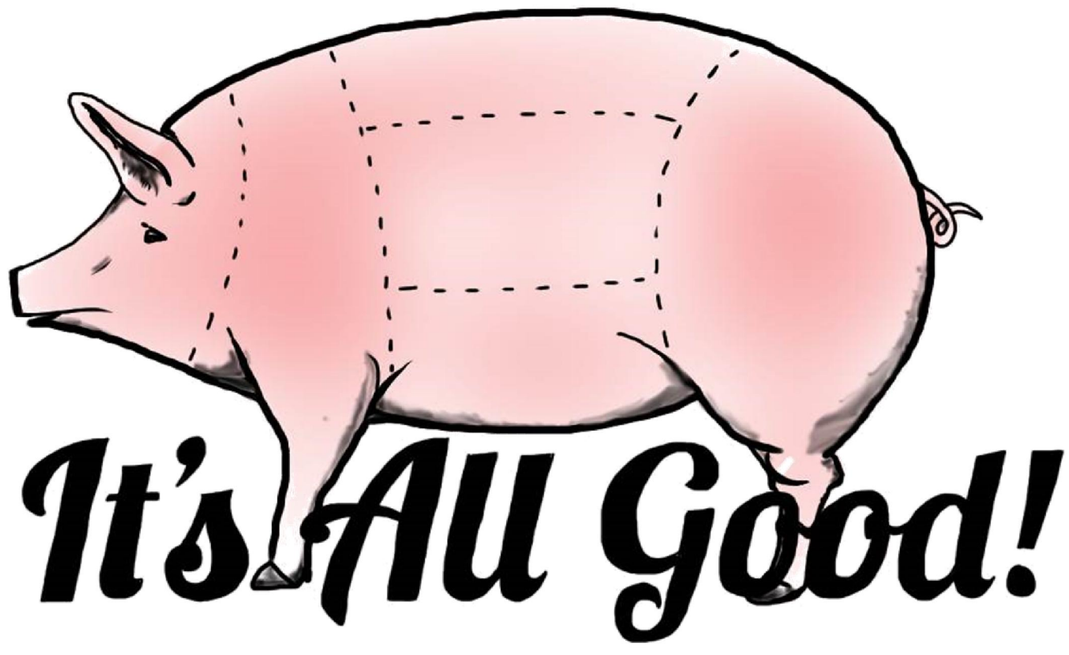
Organochlorides



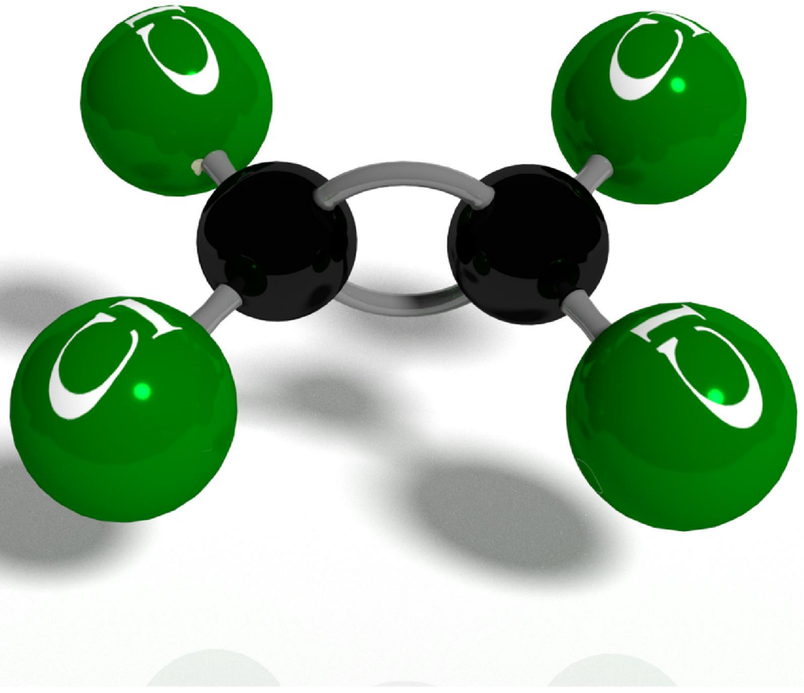
Chlorine as an Oxidant



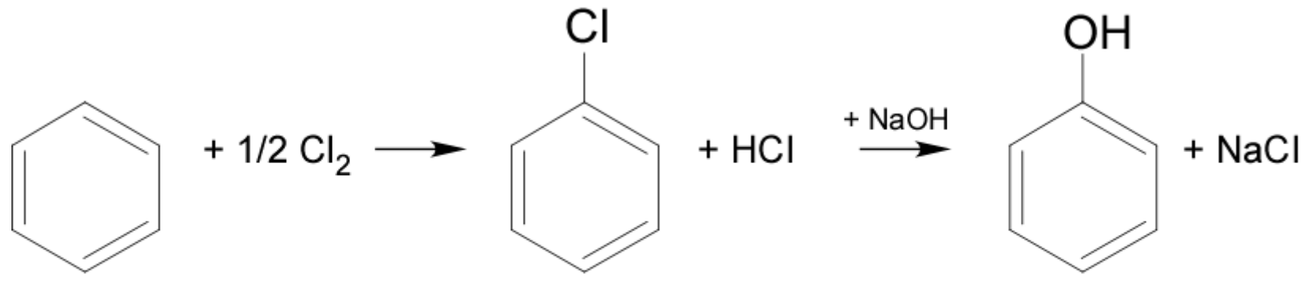
All Reaction Products Find Uses



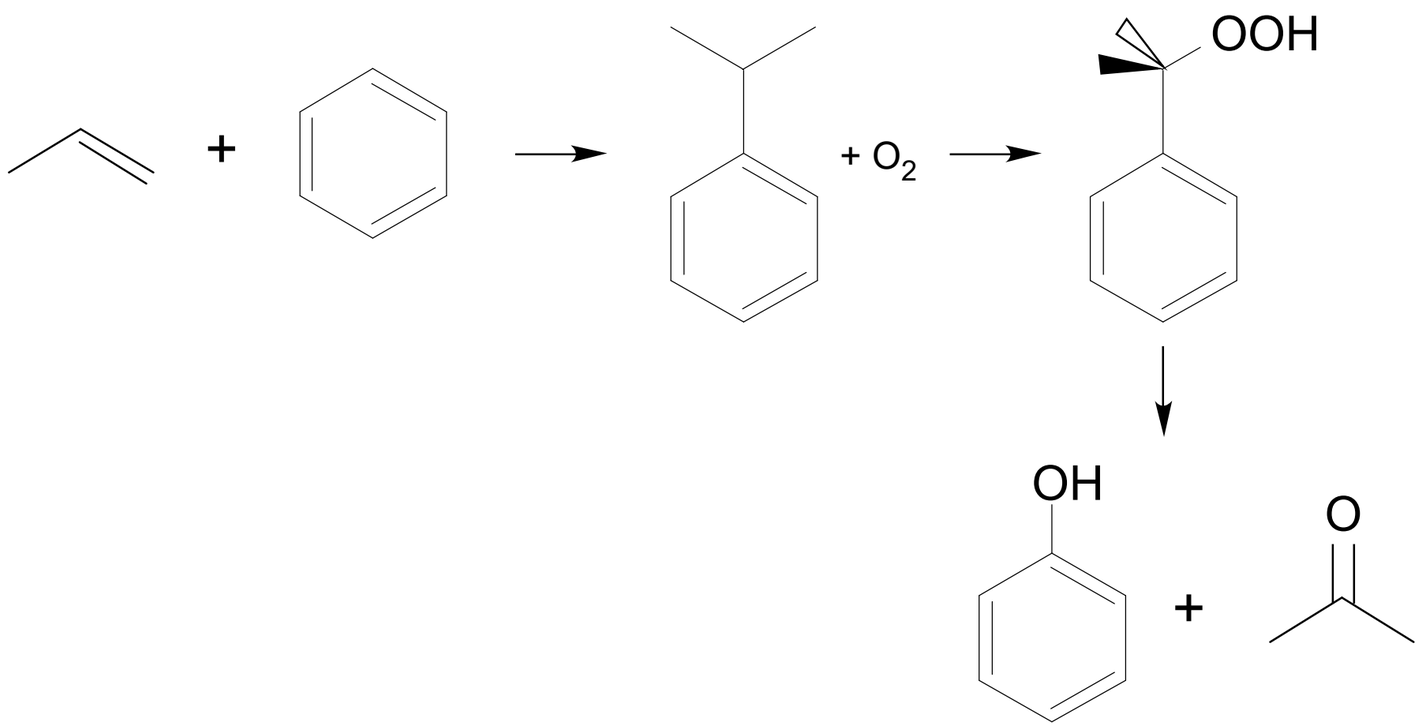
Perchloroethylene



Chlorine as an Oxidant



Phenol Today

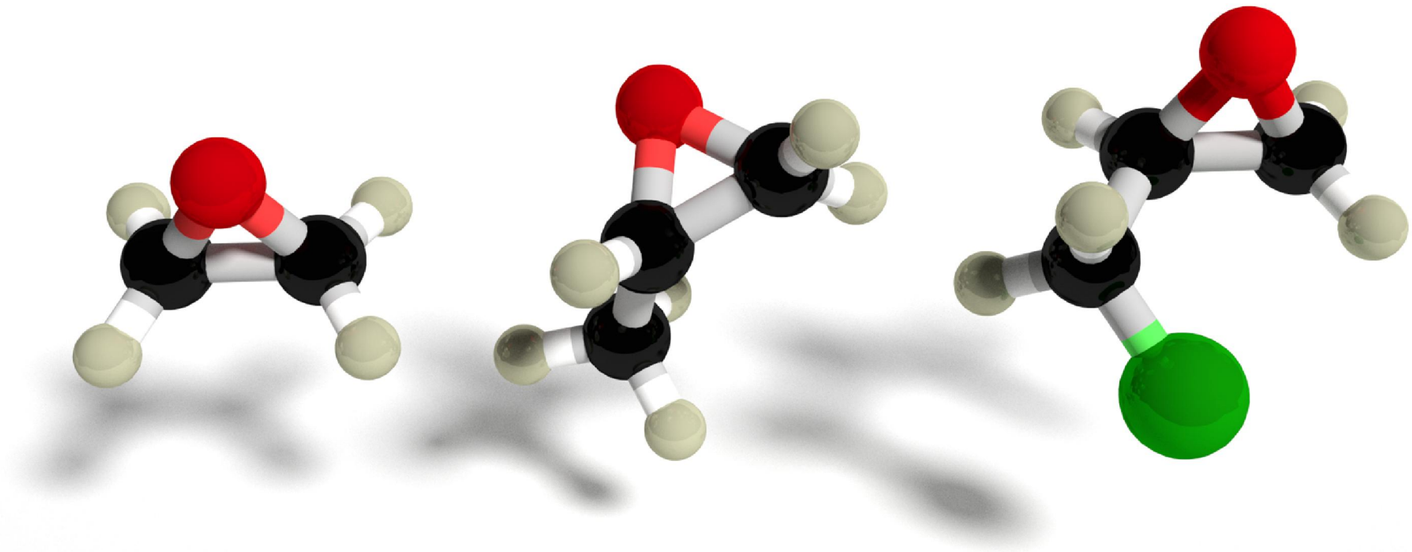


Epoxides

EO
ethylene oxide

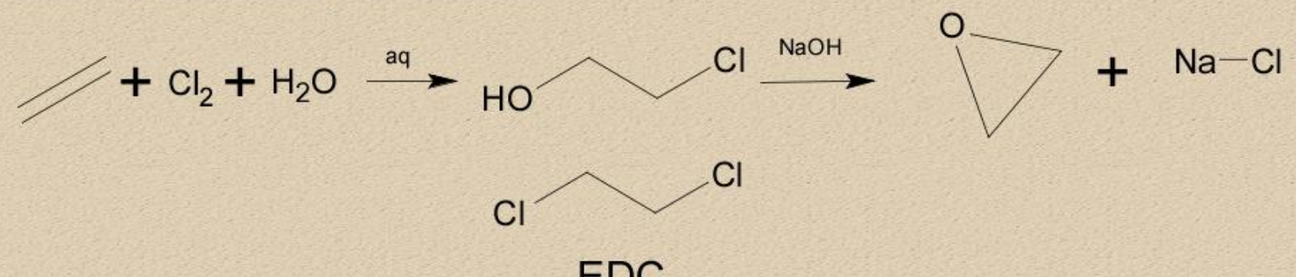
PO
propylene oxide

EPI
epichlorohydrin



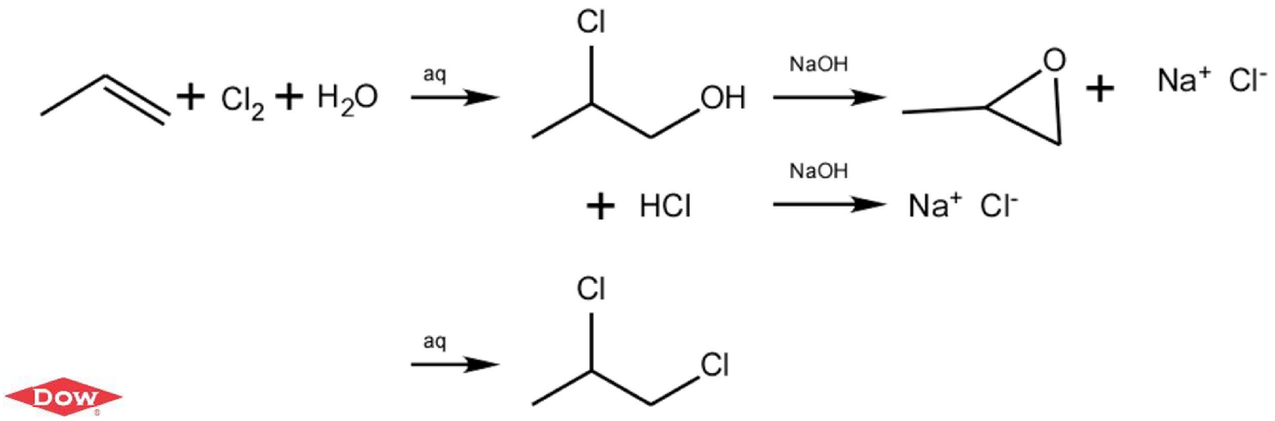
Chlorohydrin Chemistry

Clorohydrin Ethylene Oxide



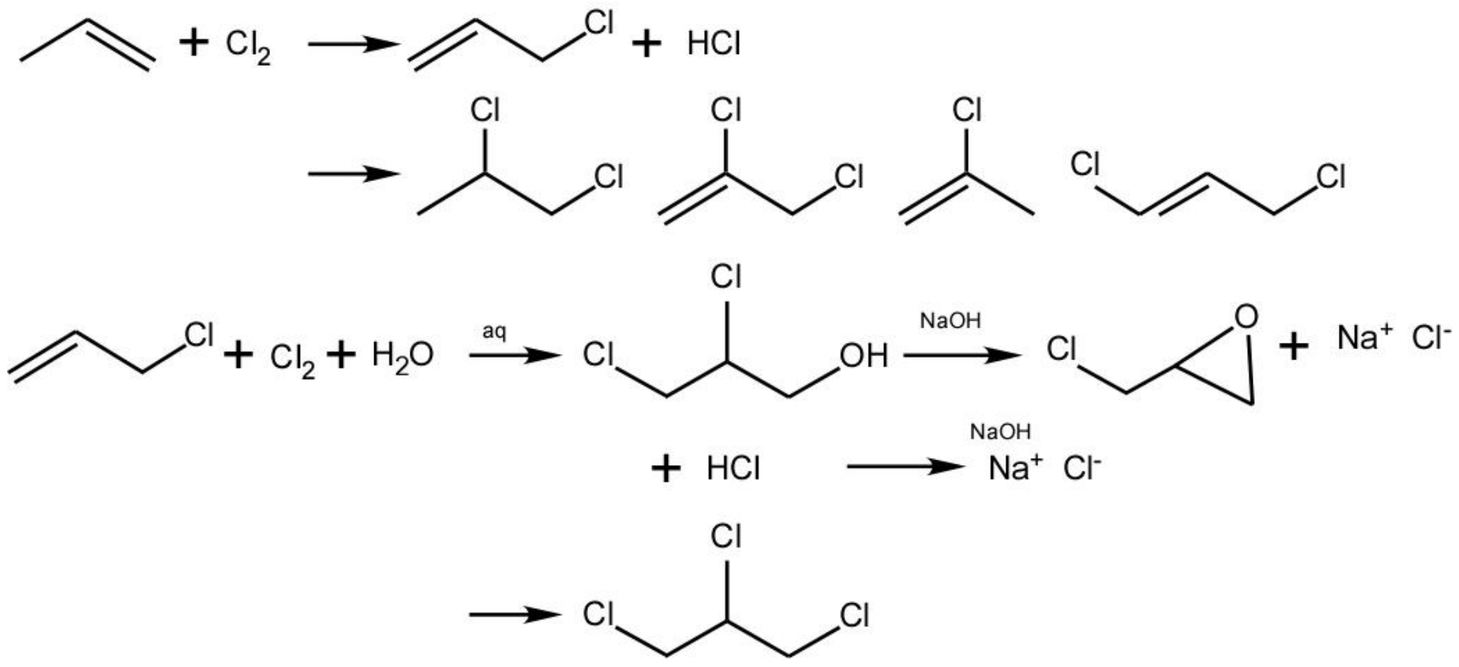
1915-1975

Chlorohydrin Propylene Oxide

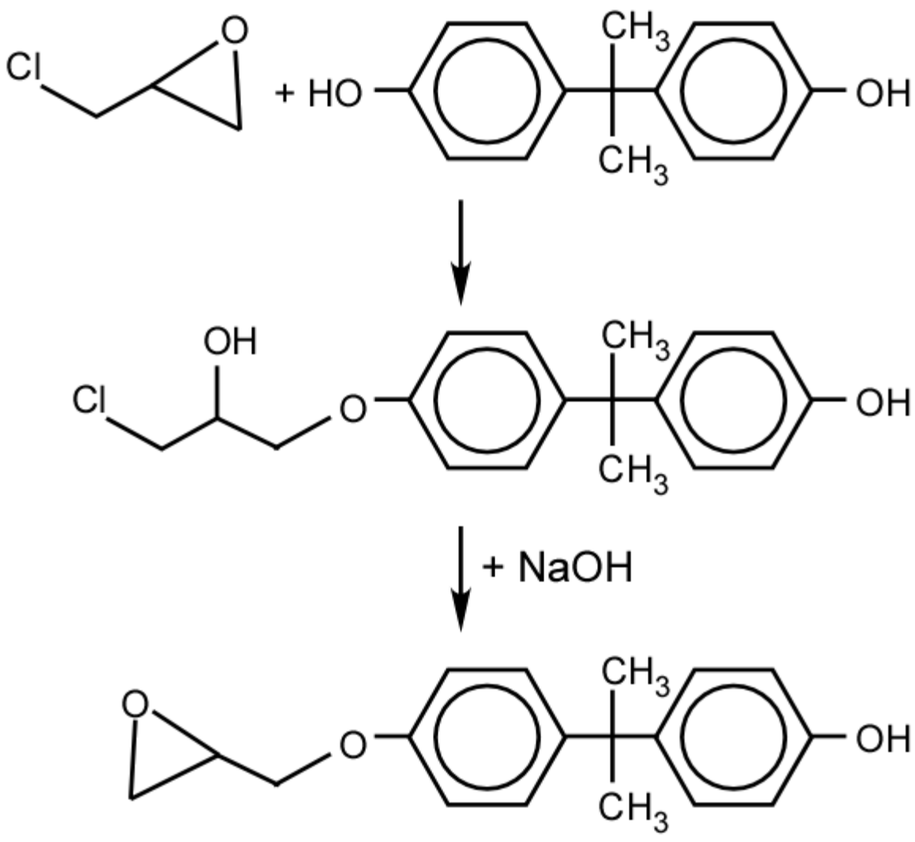


More Chlorohydrin Chemistry

Chlorohydrin Epichlorohydrin

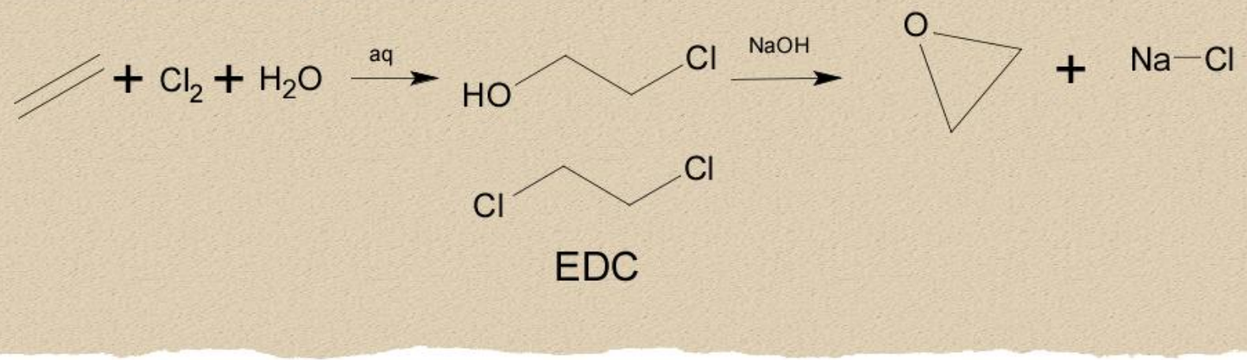


Epoxy Resins



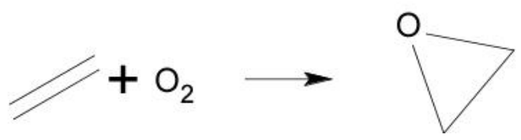
Direct Oxidation

Clorohydrin Ethylene Oxide

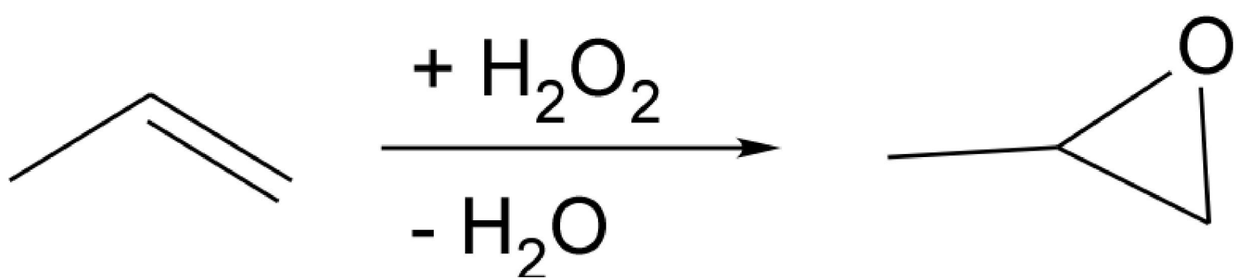


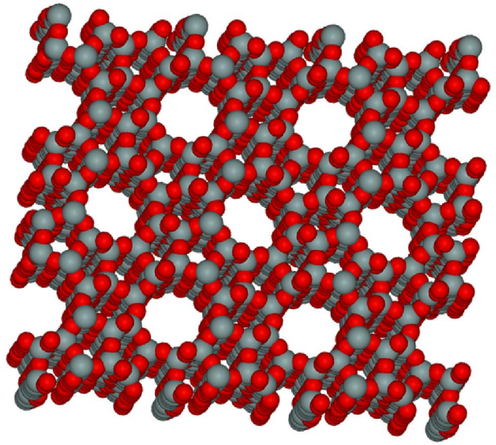
EDC

Direct Oxidation Ethylene Oxide



Hydroperoxidation



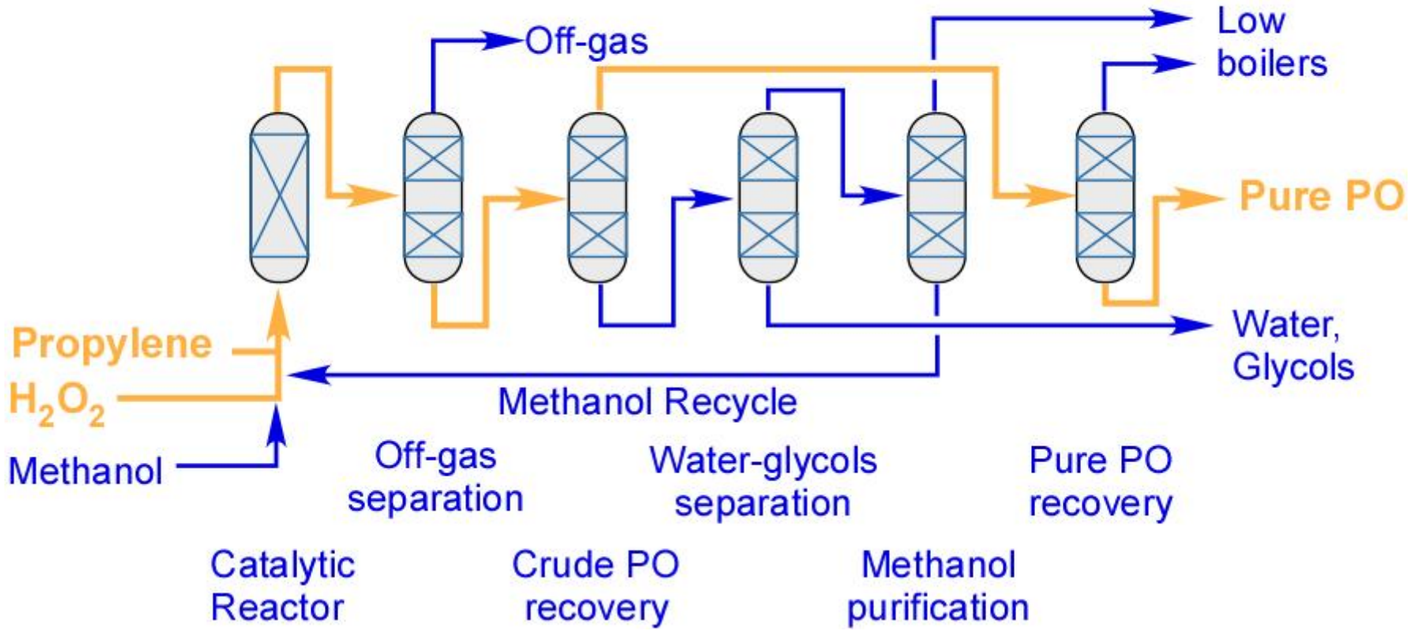


titanium silicate catalyst

0.5 nm pores

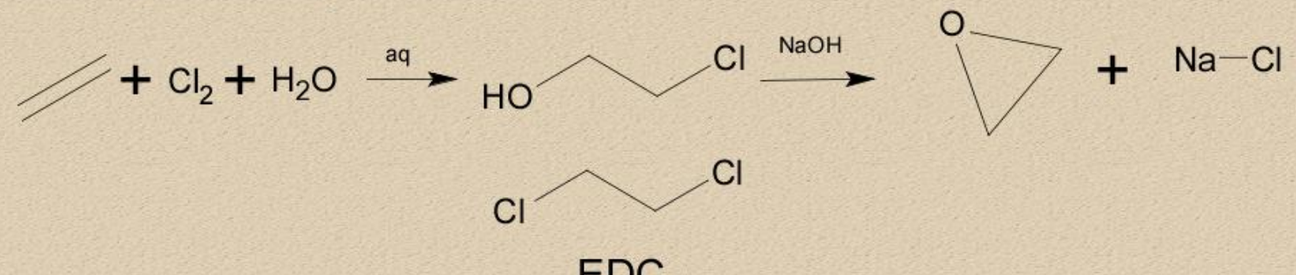
suitable for packed bed reactor

Simplified Process Flowsheet

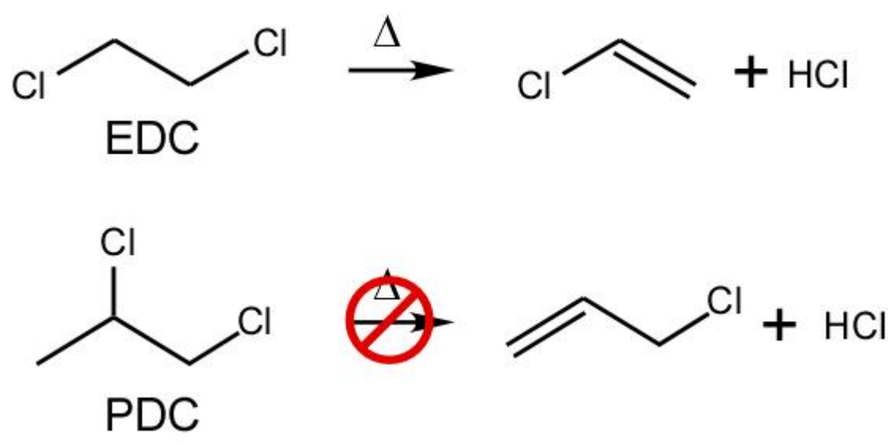


Chlorohydrin Chemistry

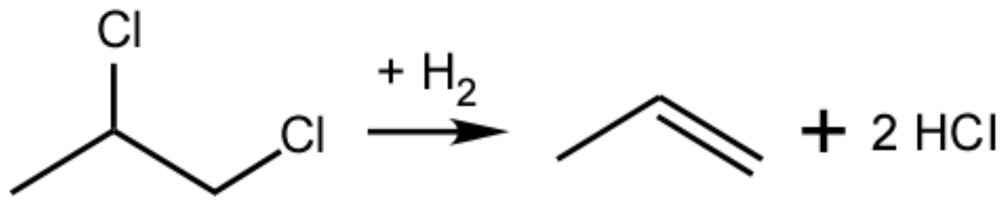
Clorohydrin Ethylene Oxide



1915-1975

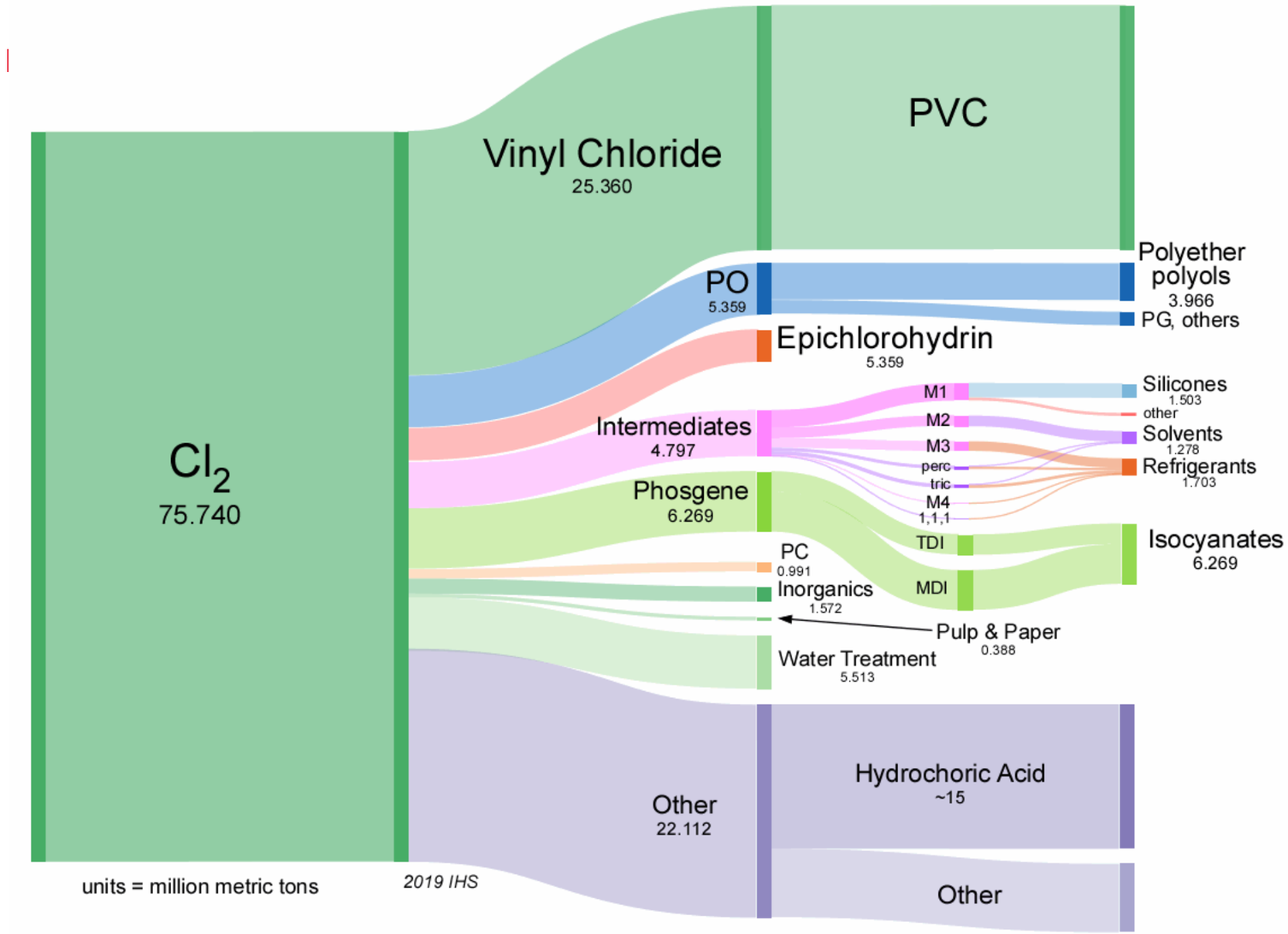


PDC Hydro

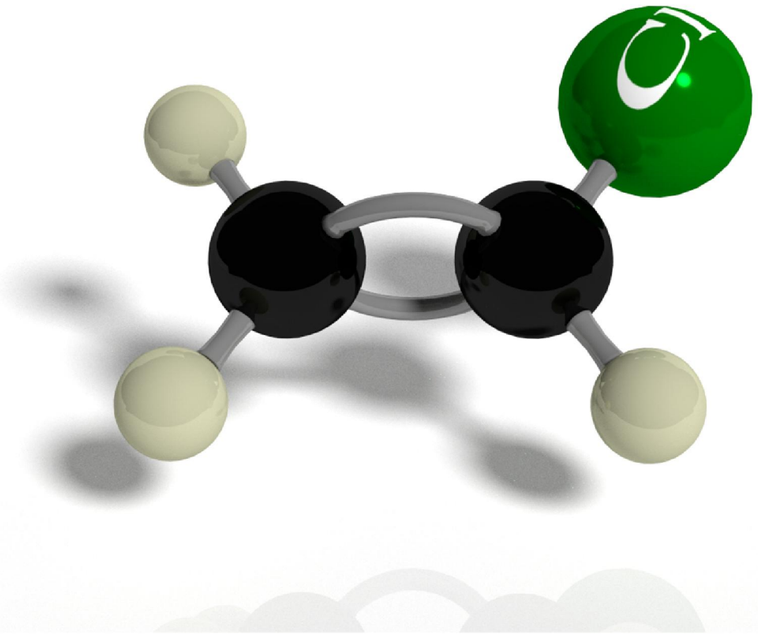


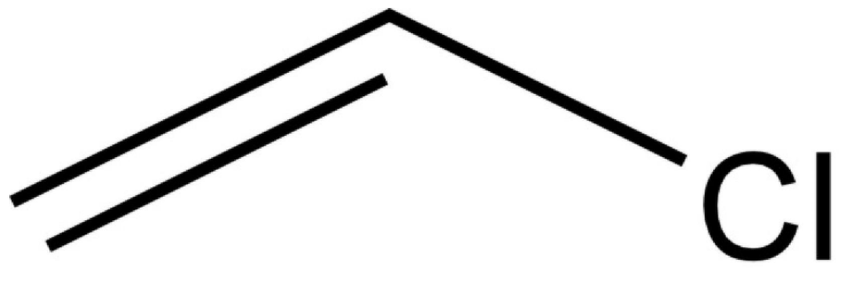
PtCu catalyst developed by Larry Ito

Carbon supported


Cl2
75.740
Vinyl Chloride
25.360
PVC
PO
5.359
Epichlorohydrin
5.359
Polyether polyols
3.966
PG, others
Intermediates
4.797
Phosgene
6.269
PC
0.991
Inorganics
1.572
Pulp & Paper
0.388
Water Treatment
5.513
Other
22.112
M1
M2
M3
perc
tric
M4
1,1,1
Silicones
1.503
other
Solvents
1.278
Refrigerants
1.703
TDI
MDI
Isocyanates
6.269
Hydrochoric Acid
~15
Other
units = million metric tons
2019 IHS

Vinyl Chloride



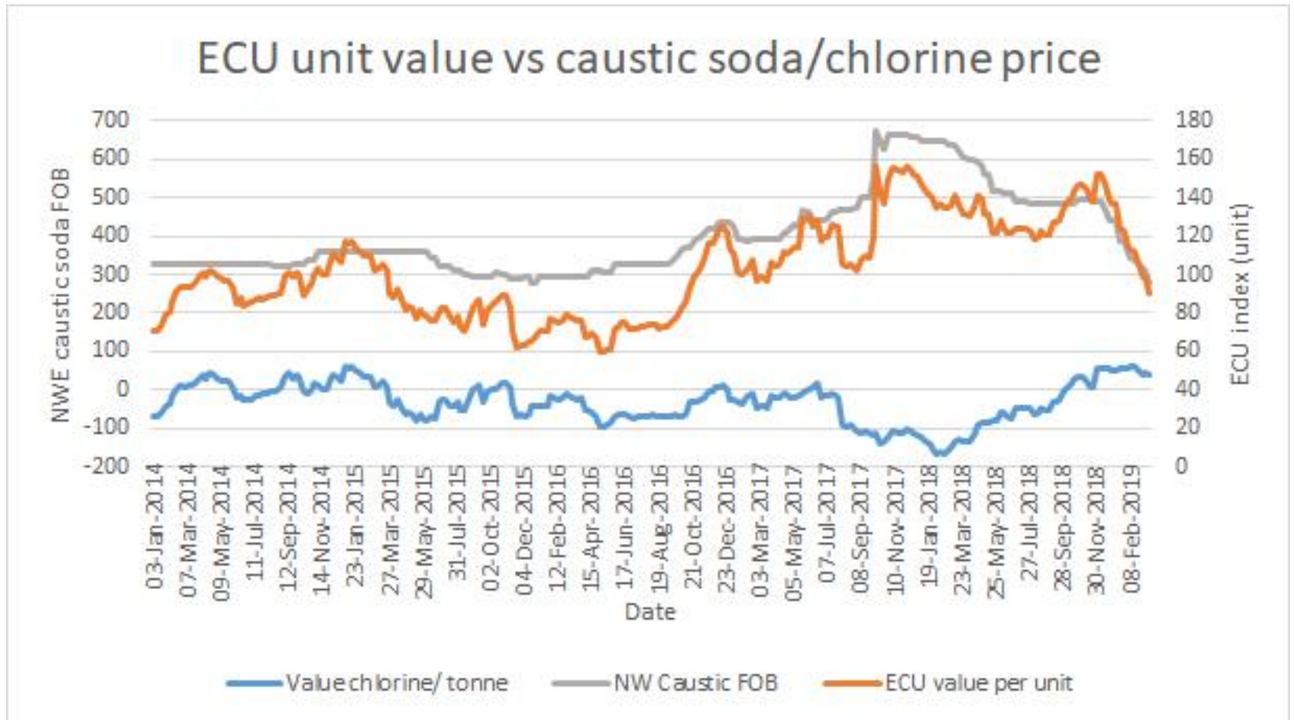


Vinyl Chloride Monomer(VCM)

Dow produced ~5 billion pounds/year
World demand is 49 billion pounds
Growth averages 4-5%

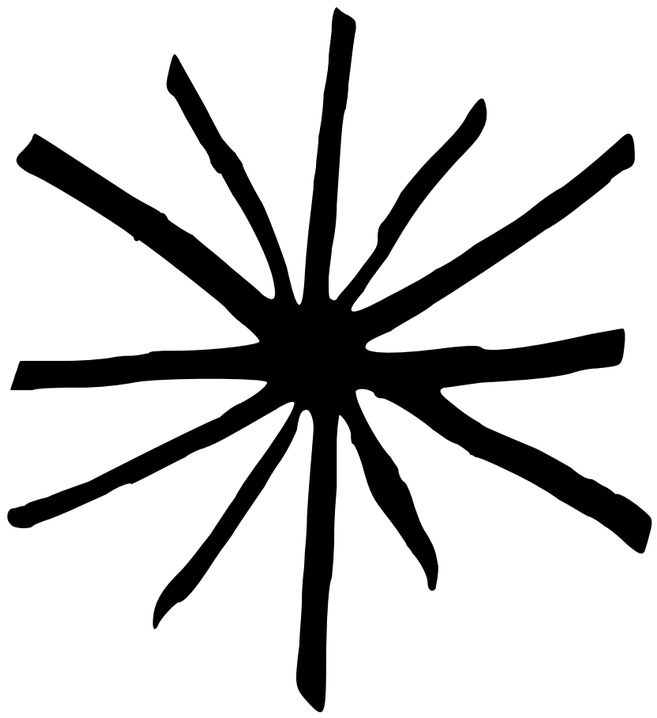
Source: Chemical Week product focus

ECU Pricing



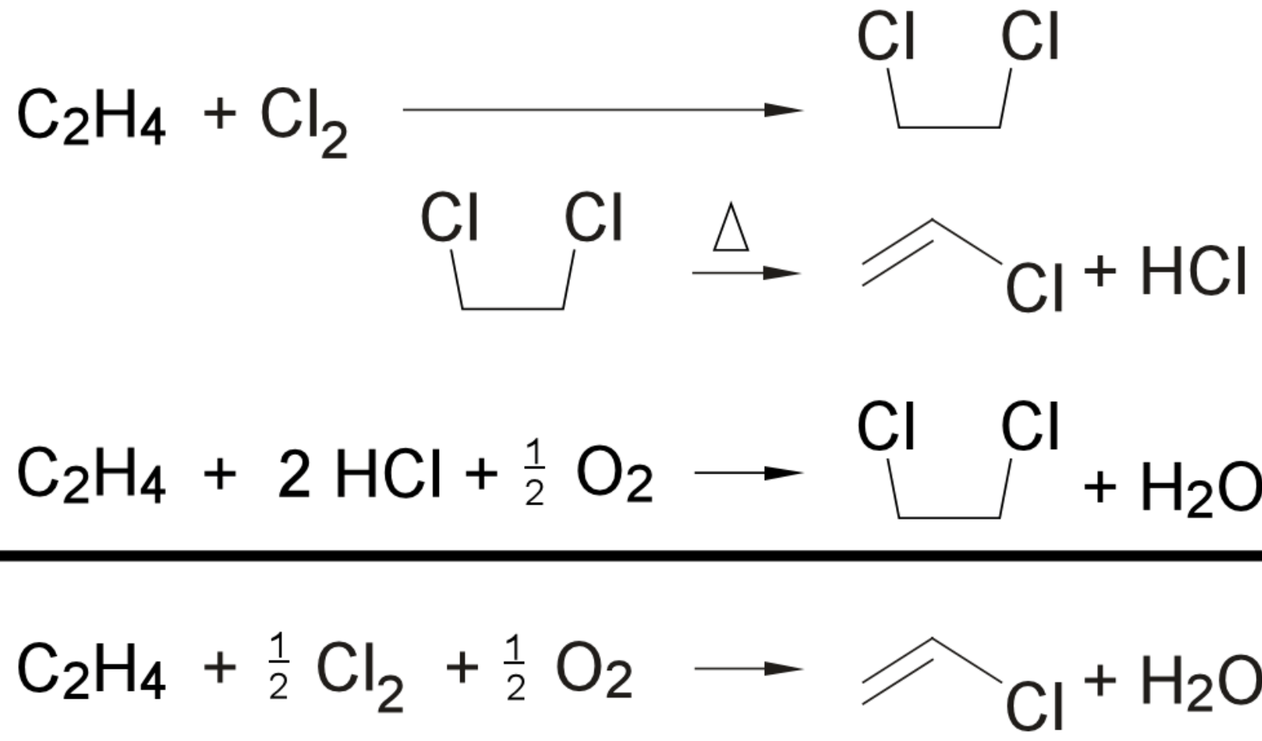
icis.com/explore/resources/news/2019/03/21/10336962/insight-european-ecu-values-fall-to-the-lowest-level-since-2016/

Breakfast of Champions



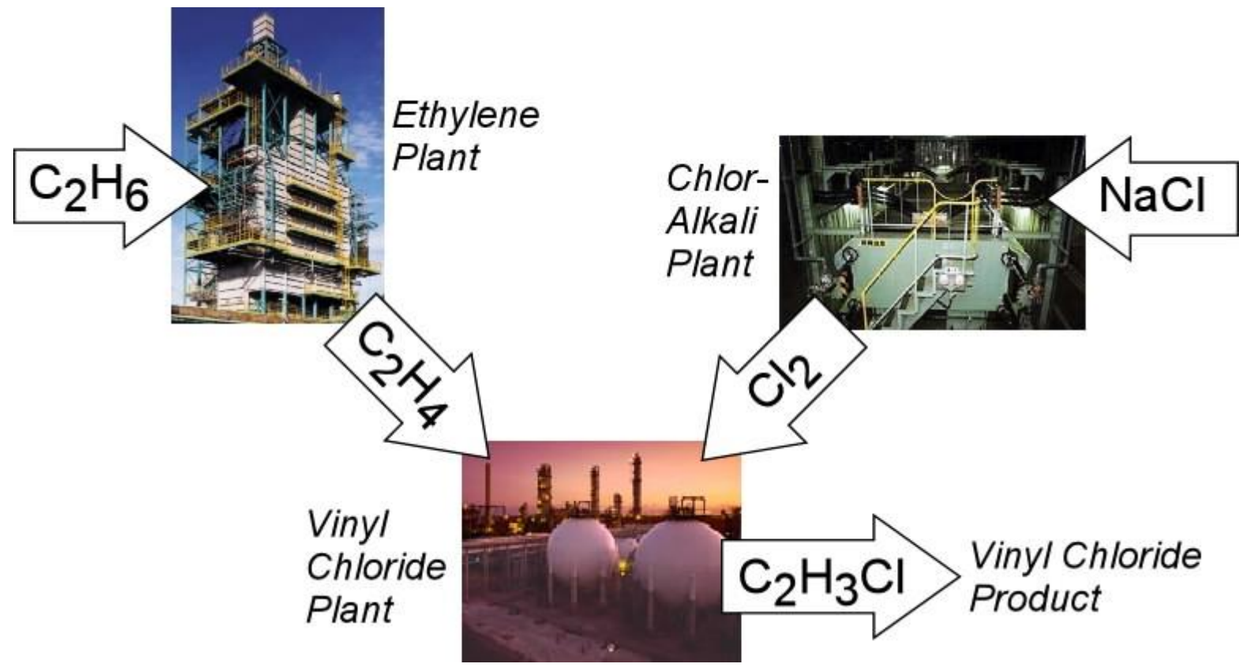
see Vonnegut's *Breakfast of Champions*

Conventional Production

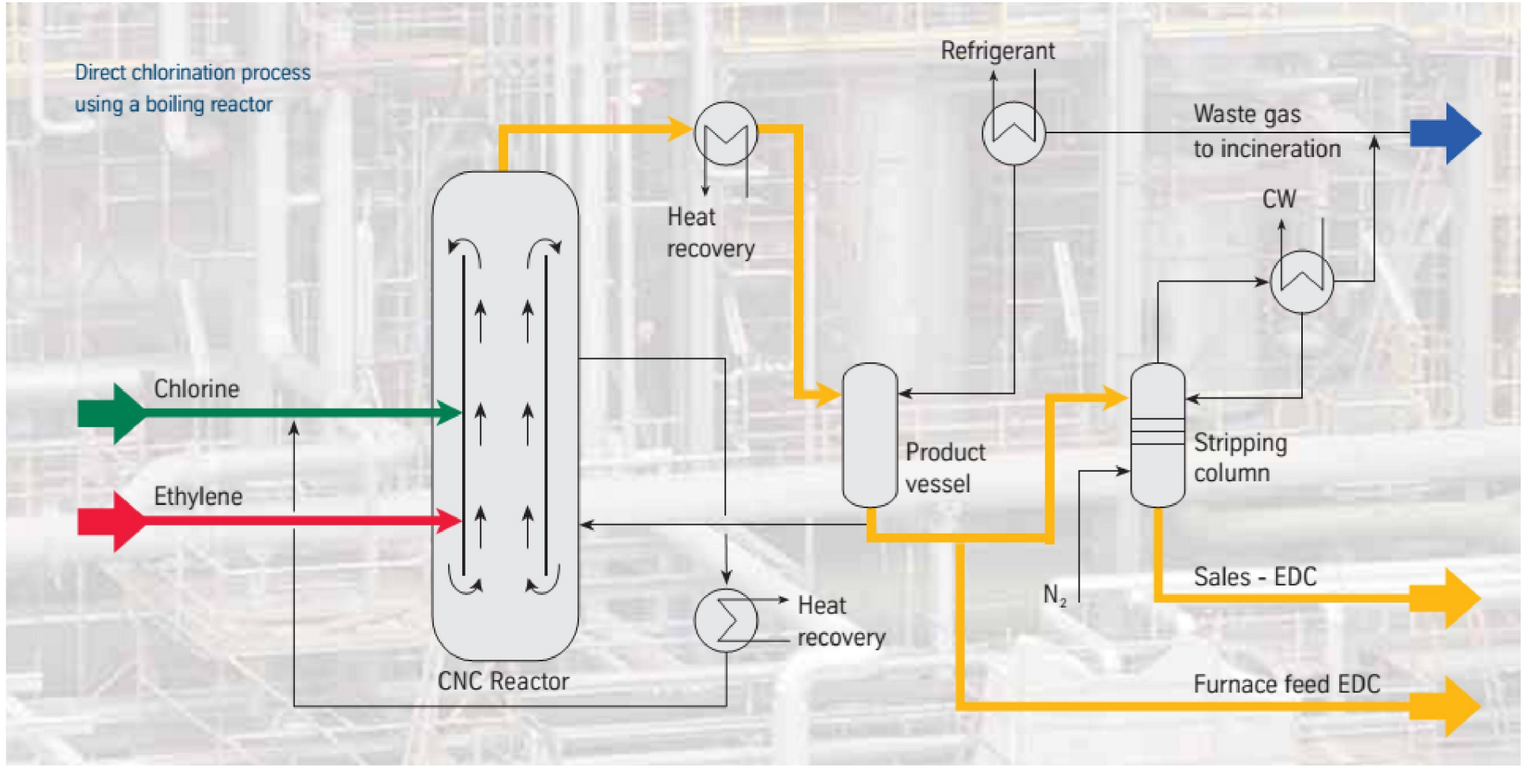


DOW

Conventional VCM



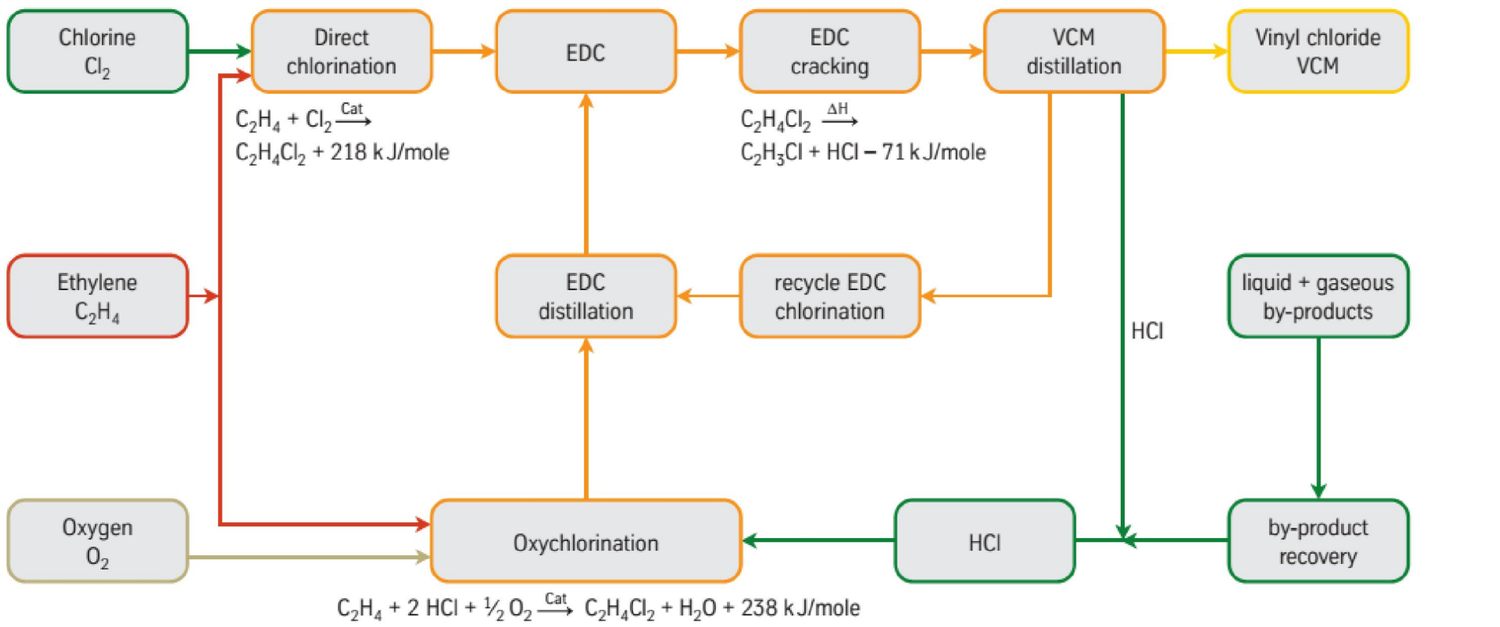
Direct Chlorination



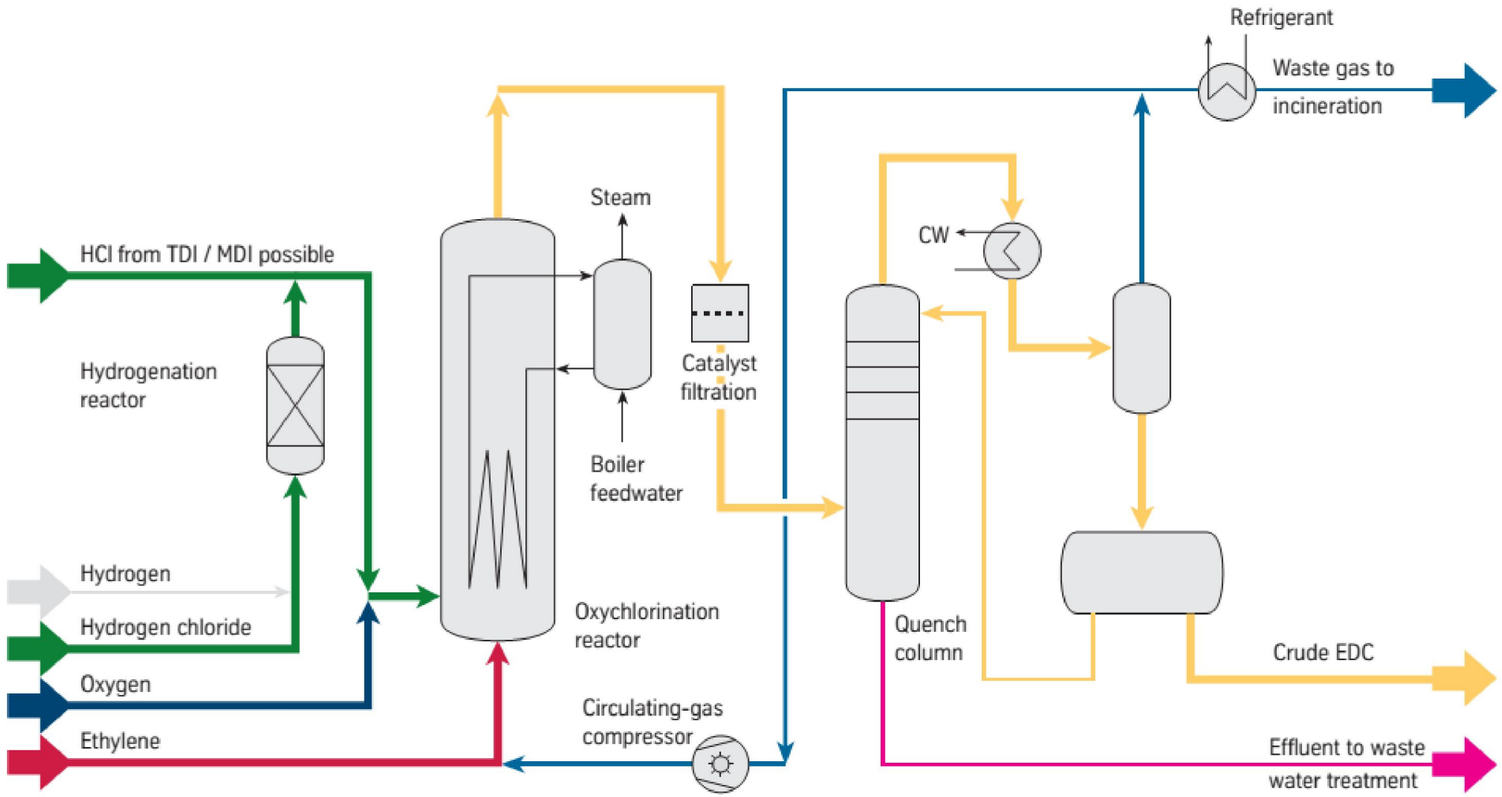
More Detail

VCM synthesis: $2\ C_2H_4 + Cl_2 + \frac{1}{2}\ O_2 \longrightarrow 2\ C_2H_3Cl + H_2O$

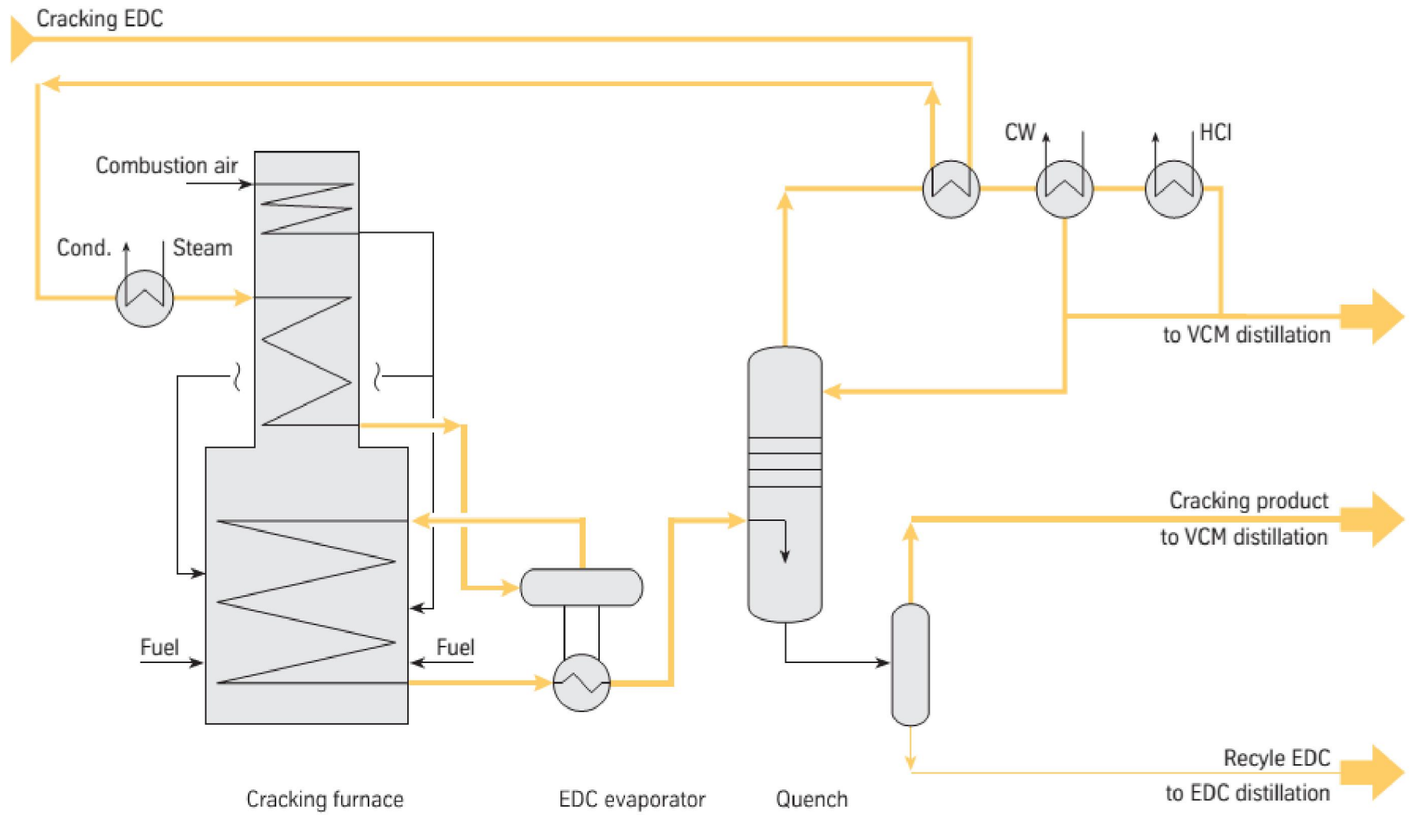
Schematic diagram of a VCM plant

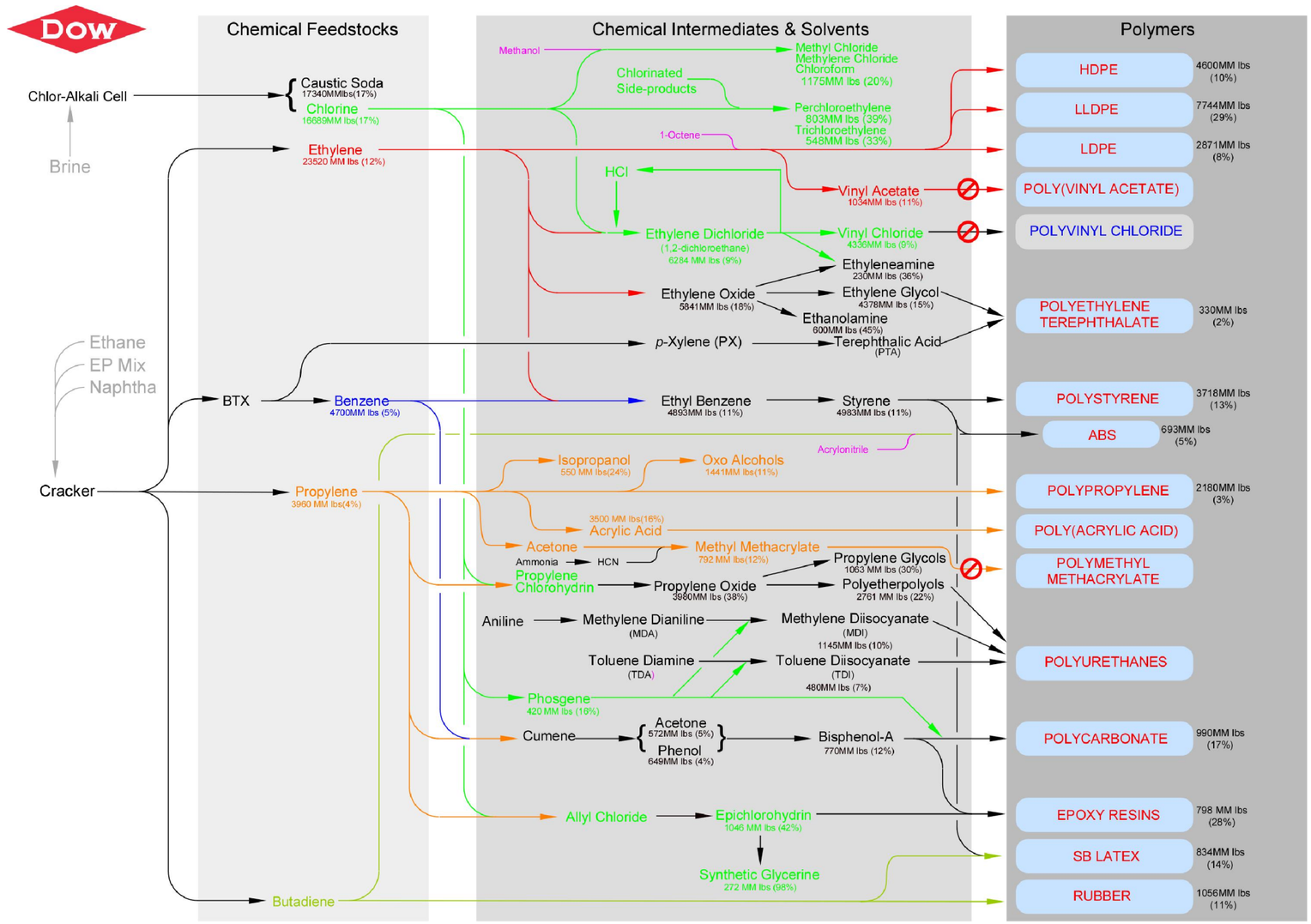


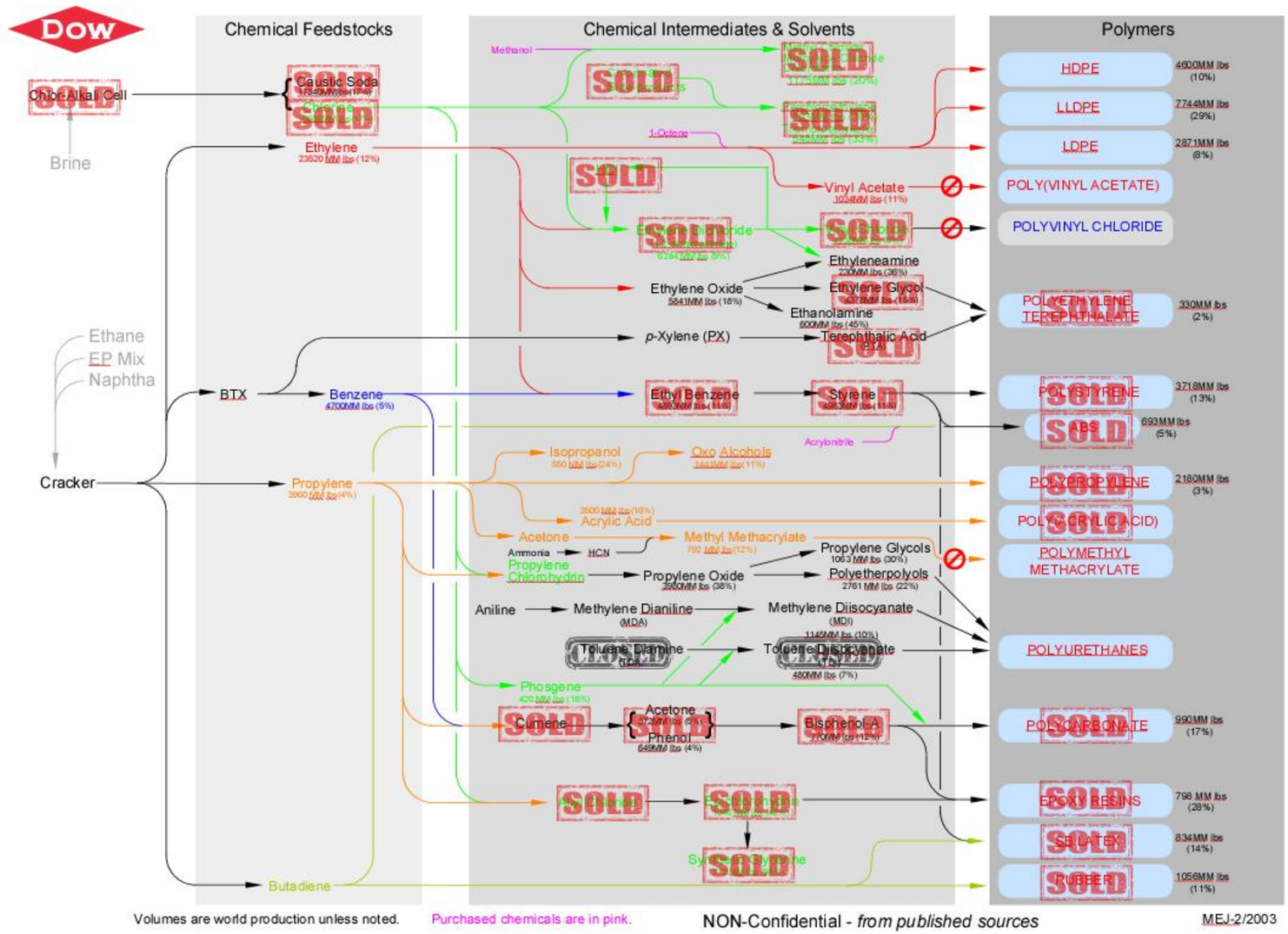
Oxychlorination



Cracking


Cracking EDC
Combustion air
Cond.
Steam
CW
HCl
to VCM distillation
Cracking product
to VCM distillation
Fuel
Fuel
Recyle EDC
to EDC distillation
Cracking furnace
EDC evaporator
Quench


DOW
Chemical Feedstocks
Chemical Intermediates & Solvents
Polymers
Chlor-Alkali Cell
Brine
Caustic Soda
17340MMlbs(17%)
Chlorine
16689MM lbs(17%)
Ethylene
23520 MM lbs (12%)
Ethane
EP Mix
Naphtha
Cracker
BTX
Benzene
4700MM lbs (5%)
Propylene
3960 MM lbs(4%)
Butadiene
Methanol
Methyl Chloride
Methylene Chloride
Chloroform
1175MM lbs (20%)
Chlorinated
Side-products
Perchloroethylene
803MM lbs (39%)
Trichloroethylene
548MM lbs (33%)
1-Octene
HCl
Vinyl Acetate
1034MM lbs (11%)
Ethylene Dichloride
(1,2-dichloroethane)
6284 MM lbs (9%)
Vinyl Chloride
4336MM lbs (9%)
Ethyleneamine
230MM lbs (36%)
Ethylene Oxide
5841MM lbs (18%)
Ethylene Glycol
4378MM lbs (15%)
Ethanolamine
600MM lbs (45%)
p-Xylene (PX)
Terephthalic Acid
(PTA)
Ethyl Benzene
4893MM lbs (11%)
Styrene
4983MM lbs (11%)
Acrylonitrile
Isopropanol
550 MM lbs(24%)
Oxo Alcohols
1441MM lbs(11%)
3500 MM lbs(16%)
Acrylic Acid
Acetone
Ammonia
HCN
Methyl Methacrylate
792 MM lbs(12%)
Propylene Glycols
1063 MM lbs (30%)
Propylene
Chlorohydrin
Propylene Oxide
3980MM lbs (38%)
Polyetherpolyols
2761 MM lbs (22%)
Aniline
Methylene Dianiline
(MDA)
Methylene Diisocyanate
(MDI)
1145MM lbs (10%)
Toluene Diamine
(TDA)
Toluene Diisocyanate
(TDI)
480MM lbs (7%)
Phosgene
420 MM lbs (16%)
Cumene
Acetone
572MM lbs (5%)
Phenol
649MM lbs (4%)
Bisphenol-A
770MM lbs (12%)
Allyl Chloride
Epichlorohydrin
1046 MM lbs (42%)
Synthetic Glycerine
272 MM lbs (98%)
HDPE
4600MM lbs
(10%)
LLDPE
7744MM lbs
(29%)
LDPE
2871MM lbs
(8%)
POLY(VINYL ACETATE)
POLYVINYL CHLORIDE
POLYETHYLENE
TEREPHTHALATE
330MM lbs
(2%)
POLYSTYRENE
3718MM lbs
(13%)
ABS
693MM lbs
(5%)
POLYPROPYLENE
2180MM lbs
(3%)
POLY(ACRYLIC ACID)
POLYMETHYL
METHACRYLATE
POLYURETHANES
POLYCARBONATE
990MM lbs
(17%)
EPOXY RESINS
798 MM lbs
(28%)
SB LATEX
834MM lbs
(14%)
RUBBER
1056MM lbs
(11%)
Volumes are world production unless noted.
Purchased chemicals are in pink.
NON-Confidential - from published sources
MEJ-2/2003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Chemical Intermediates & Solvents
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Methylene Diisocyanate
(MDI)
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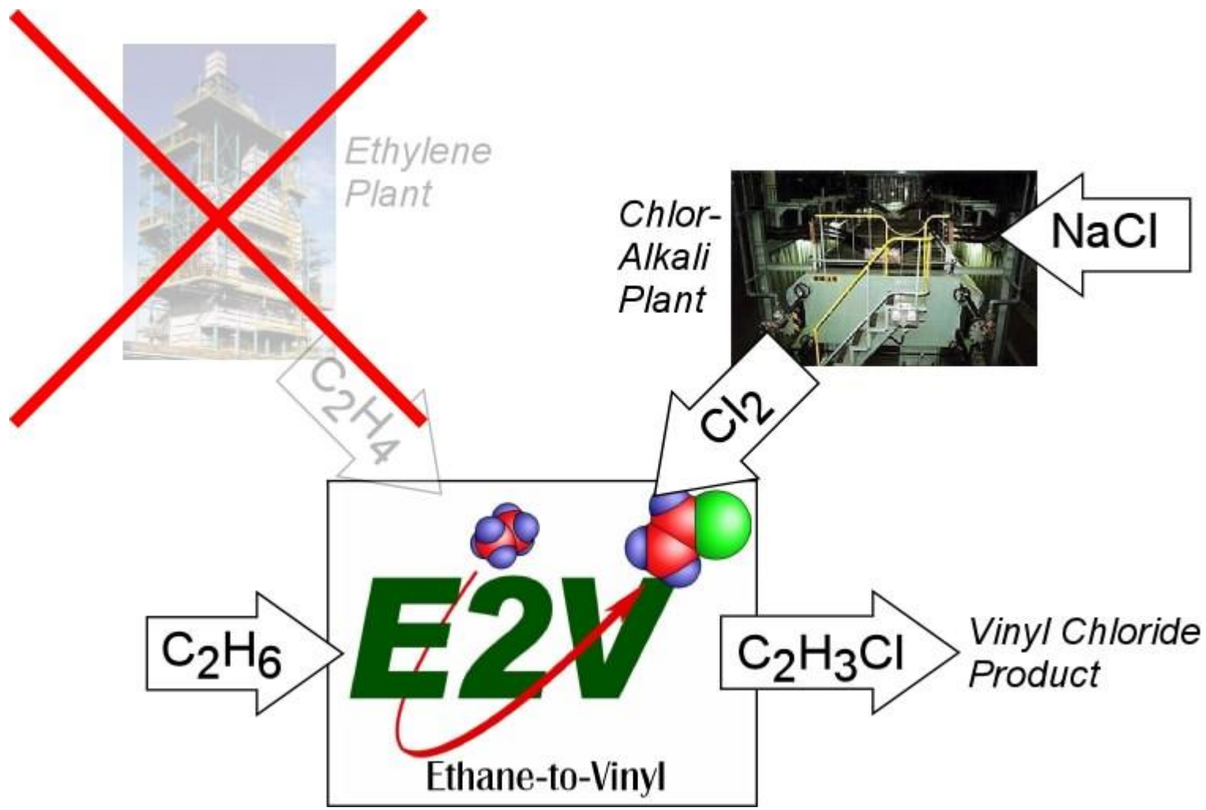
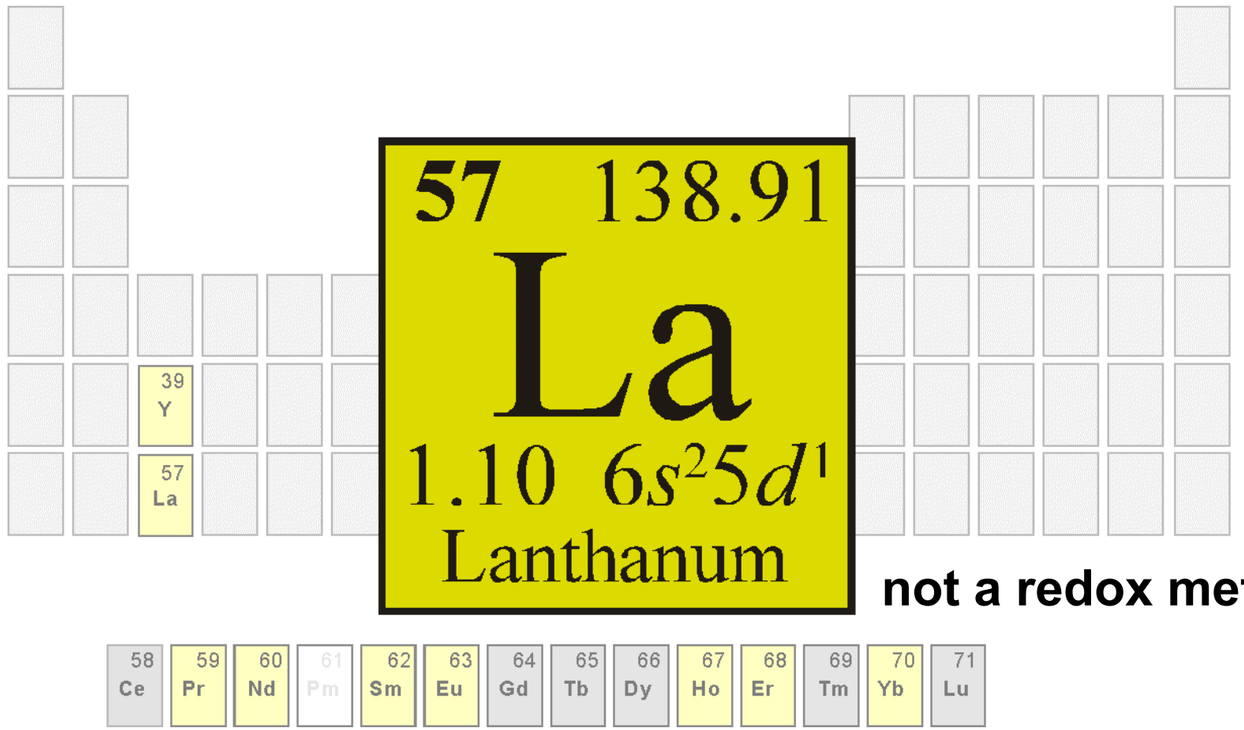
(TDA)
Toluene Diisocyanate
(TDI)
480MM lbs (7%)
Phosgene
420 MM lbs (16%)
Cumene
Phenol
645MM lbs (4%)
Bisphenol-A
Butadiene
Styrene-Butadiene
Synthetic Rubber
HDPE
4600MM lbs (10%)
LLDPE
7744MM lbs (29%)
LDPE
2871MM lbs (8%)
POLY(VINYL ACETATE)
POLYVINYL CHLORIDE
POLYETHYLENE TEREPHTHALATE
330MM lbs (2%)
POLYSTYRENE
3718MM lbs (13%)
ABS
693MM lbs (5%)
POLYPROPYLENE
2180MM lbs (3%)
POLY(ACRYLIC ACID)
POLYMETHYL METHACRYLATE
POLYURETHANES
POLYCARBONATE
990MM lbs (17%)
EPOXY RESINS
798 MM lbs (28%)
LATEX
834MM lbs (14%)
RUBBER
1056MM lbs (11%)
SOLD
Volumes are world production unless noted.
Purchased chemicals are in pink.
NON-Confidential - from published sources
MEJ-2/2003

E2V

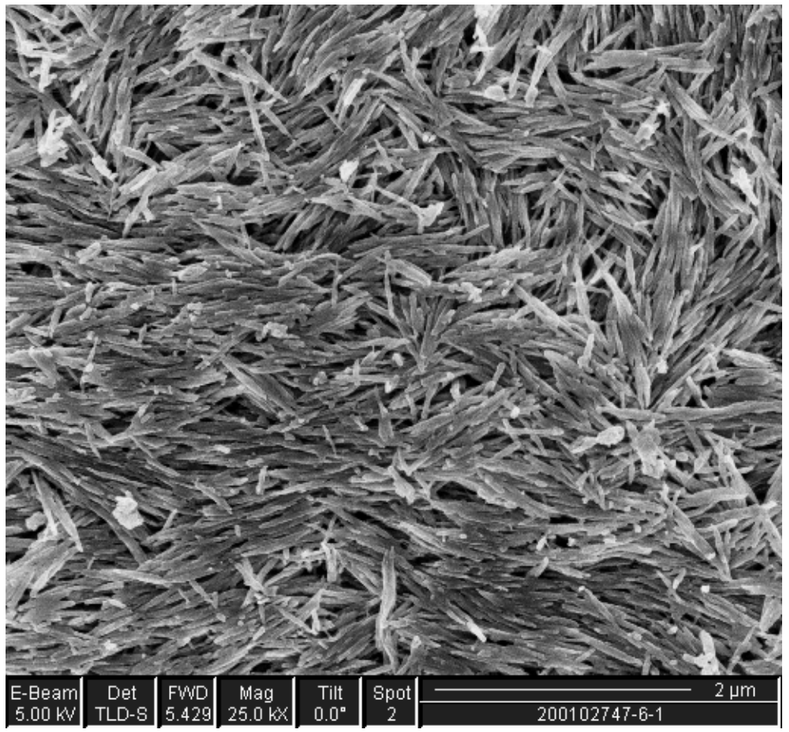

Ethylene Plant
C_2H_4
Chlor-Alkali Plant
NaCl
Cl_2
C_2H_6
E2V
Ethane-to-Vinyl
C_2H_3Cl
Vinyl Chloride Product

Lanthanide Catalyst



not a redox metal!

LaOCl

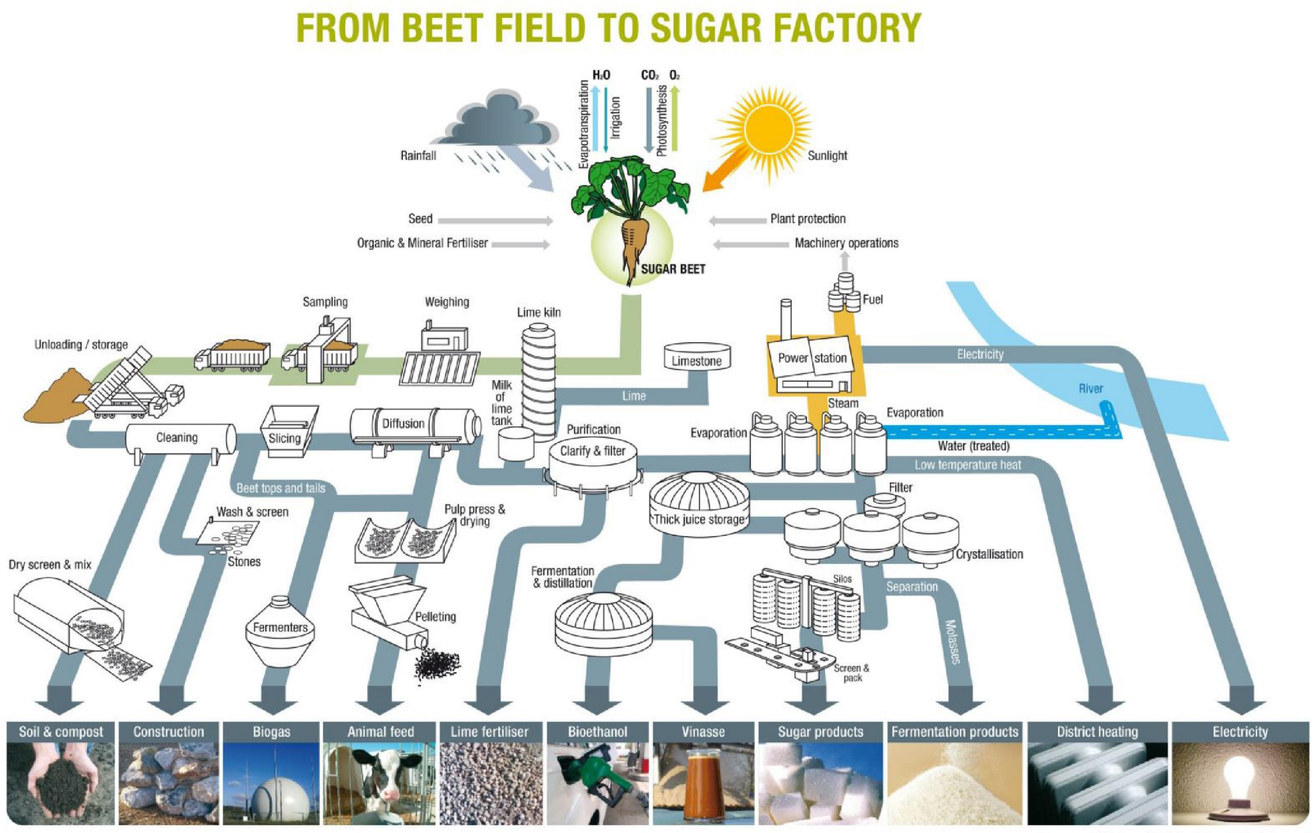

E-Beam
5.00 kV
Det
TLD-S
FWD
5.429
Mag
25.0 kX
Tilt
0.0°
Spot
2
2 µm
200102747-6-1

Fluidized Bed

What I hope to leave you with

- Integration was crucial in the development of the chemical industry but has decreased in importance
  chlorine has largely been replaced as an oxidant
- Inorganic chemistry created the chemical industry and remains important, but not particularly valued
  vinyl and caustic are critical, just not particularly profitable
- Scale remains the major source of competitive advantage in commodity chemicals
  for undifferentiated materials, production cost is king and scale lowers production cost

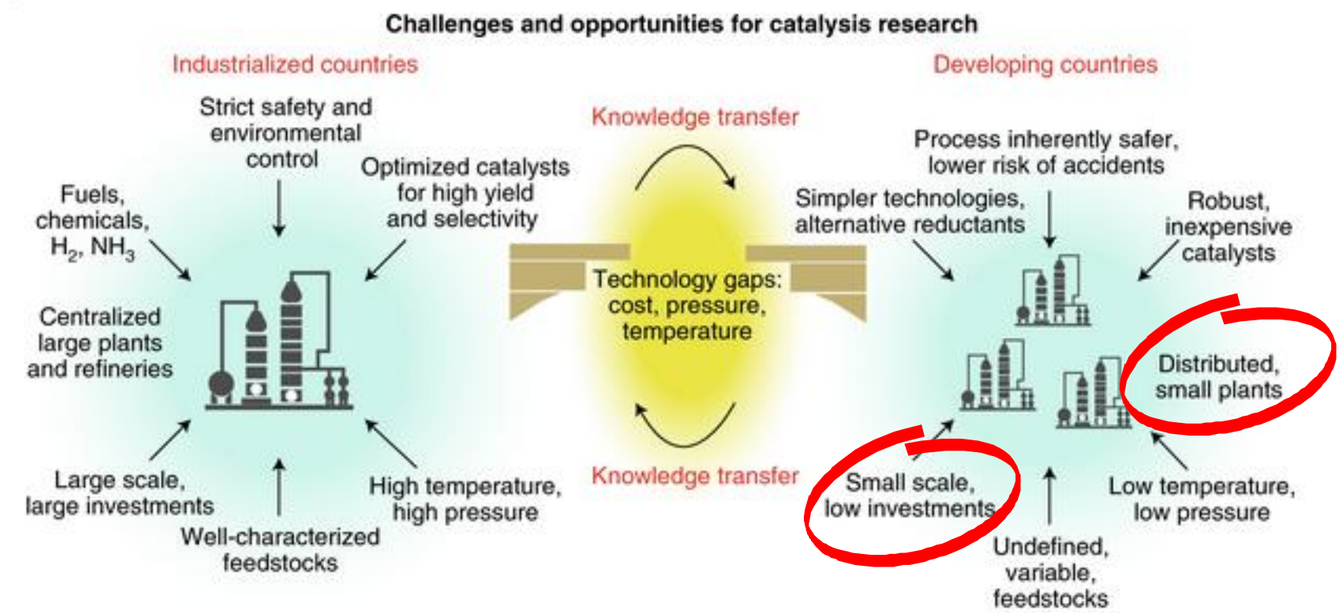
Integrated Biorefinery



Source: CIBE and CEFS (after British Sugar)

prokris.nl/production/

Distributed Manufacturing



Resasco DE, Wang B, Sabatini D. Distributed processes for biomass conversion could aid UN Sustainable Development Goals. Nature Catalysis. 2018 Oct;1(10):731.