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A PROCESS AND REACTOR FOR CONVERTING CARBON DIOXIDE
INTO CARBON MONOXIDE, INVOLVING A CATALYST

FIELD OF THE INVENTION

The present invention relates to a process involving a catalyst for converting carbon dioxide and hydrogen into a product stream comprising carbon monoxide, water and hydrogen. Further, the present invention relates to a catalytic reverse water-gas shift process unit, suitable for use in said process.

The process and process unit are useful in reducing the carbon footprint of certain industrial technologies. Further, the process and process unit are useful in the production of synthesis gas.

BACKGROUND OF THE INVENTION

The increased demand for energy resulting from worldwide economic growth and development have contributed to the release of greenhouse gases into the atmosphere. The increase in concentration of greenhouse gases, especially carbon dioxide has resulted in global warming. It is imperative to reduce the global carbon footprint to mitigate global warming and this has been regarded as one of the most important challenges facing mankind in the 21st century. The capacity of the earth system to absorb greenhouse gas emissions is already exhausted, and under the Paris climate agreement, current emissions must be fully stopped until around 2070. To realize these reductions, the energy scenario of the world must evolve to move away from conventional carbon-based fossil fuel energy carriers and also decrease the carbon dioxide concentration in the atmosphere. A timely implementation of the energy transition requires multiple

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approaches in parallel. For example, energy conservation, improvements in energy efficiency and electrification play a role, but also efforts to use carbon dioxide to produce other compounds plays an important role as a substitute for fossil fuel-based feedstock. For example, synthesis gas (i.e. a mixture of hydrogen and carbon monoxide) may be produced from carbon dioxide. Synthesis gas is a building block to produce several useful chemicals and fuels.

Historically, synthesis gas is usually produced from steam reforming using for example natural gas as feedstock or partial oxidation of coal or heavy oil residue feedstock. All these processes involve the production of carbon dioxide as a by-product of the steam reforming reactions or partial oxidation reactions. In order to truly decrease the carbon dioxide concentrations, utilization of fossil fuel-based feedstock is not a viable solution. As an alternative, the reverse water gas shift (RWGS) reaction may be used to prepare syngas, using carbon dioxide as a starting material. However, the reaction of carbon dioxide with hydrogen via the RWGS reaction to produce carbon monoxide and water is endothermic in nature. Sufficient thermal energy must be supplied to the reactants (i.e. carbon dioxide and hydrogen) to facilitate the endothermic RWGS reaction. Substantial carbon monoxide is produced from carbon dioxide at temperatures beyond 600°C reaching a maximum at temperatures around 1200°C. RWGS reaction at lower temperatures at around 700-1000°C require catalysts to enable the conversion of carbon dioxide to carbon monoxide. These catalysts must be able to withstand high temperatures as well as be resistant to catalyst poisons such as compounds containing sulphur.

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Currently, the status of RWGS developments have been on lab scale (Catalyst Screening and Kinetic Modeling for CO Production by High Pressure and Temperature Reverse Water Gas Shift for Fischer-Tropsch Applications, Francisco Vidal Vázquez, Peter Pfeifer, Juha Lehtonen, Paolo Piermartini, Pekka Simell and Ville Alopaeus, Ind. Eng. Chem. Res. 2017, 56, 13262-13272; Kinetic study of the reverse water gas shift reaction in high-temperature, high pressure homogeneous systems, Felipe Bustamantel, Robert Enick, Kurt Rothenberger, Bret Howard, Anthony Cugini, Michael Ciocco and Bryan Morreale, Fuel Chemistry Division Preprints 2002, 47(2), 663).

US20150336795 discloses a process for the parallel preparation of hydrogen, carbon monoxide and a carbon-comprising product, wherein one or more hydrocarbons are thermally decomposed and at least part of the hydrogen-comprising gas mixture formed is taken off from the reaction zone of the decomposition reactor at a temperature of from 800 to 1400°C and reacted with carbon dioxide to form a gas mixture comprising carbon monoxide and hydrogen.

For large scale conversion of carbon dioxide there is a need to be able to more efficiently and economically carry out the RWGS reaction. Achieving high conversion of carbon dioxide selectively to carbon monoxide and avoiding by-products like methane and carbon formation requires high temperatures of around 1200°C which necessitates heat from external furnaces which pose considerable engineering challenges while scaling up to large scales. It is therefore imperative that a novel RWGS process is required to efficiently convert carbon dioxide to carbon monoxide at high temperatures at a large scale.

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The process of the present disclosure provides a solution to said need.

SUMMARY OF THE INVENTION

5 Accordingly, the present disclosure relates to a process for converting carbon dioxide and hydrogen by performing a reverse water gas shift reaction at elevated temperature, the process comprising introducing carbon dioxide, hydrogen and oxygen into a reaction vessel
10 having an inlet and an outlet, and wherein the reverse water gas shift reaction takes place in two different zones of the reaction vessel, being a top zone (z1) adjacent to a bottom zone (z2), wherein
 (a) no catalyst is present in the top zone (z1) of the
15 reaction vessel, and
 (b) at least a gas stream comprising carbon dioxide, a hydrogen rich gas stream and an oxygen rich gas stream are introduced into the inlet at the top zone (z1) of the reaction vessel in separate feed streams, wherein the
20 hydrogen rich gas stream is introduced into the reaction vessel at a temperature between 15 and 450°C, and
 (c) the hydrogen rich gas stream and oxygen rich gas stream being introduced in close vicinity of each other, wherein at least the hydrogen rich gas stream and the
25 oxygen rich gas stream are introduced into the reaction vessel via a burner comprising coaxial channels for the separate introduction of the different gas streams, the burner being located at the top of the reaction vessel, wherein the hydrogen and oxygen in the hydrogen rich gas
30 stream and oxygen rich gas stream undergo a combustion reaction upon entering the reaction vessel, thereby providing the heating energy required for the reverse water-gas shift reaction; and

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(d) the temperature in the top zone (z1) of the reaction vessel is maintained in the range of 700 to 1200°C, preferably in the range of 700°C to 900°C, by varying the flow of any of the gas streams which are introduced into the reaction vessel; and

(e) the bottom zone (z2) of the reaction vessel is provided with a catalyst bed comprising a reverse water gas shift catalyst, the top of the catalyst bed being placed at a distance from the burner in the top zone (z1) sufficient to prevent damage from flame impingement on the catalyst bed;

(f) wherein in the bottom zone (z2) of the reaction vessel a catalytic reverse water gas shift reaction takes place at elevated temperatures, thereby converting unconverted carbon dioxide and hydrogen; to produce a product stream comprising mainly carbon monoxide, hydrogen and water;

wherein in step (c) the hydrogen rich gas stream and oxygen rich gas stream are introduced into the reaction vessel in close vicinity of but not next to each other; and

wherein part of the gas stream containing carbon dioxide is introduced via a channel in between the hydrogen rich gas stream and the oxygen rich gas stream.

Advantageously, in the present process, the heat required for the reverse water gas shift reaction in top zone (z1) and the catalytic reverse water gas shift reaction in bottom zone (z2) is provided by the combustion of oxygen and hydrogen inside the top zone (z1) of the reactor.

Further, the present disclosure relates to a reverse water-gas shift process unit comprising at least one reaction vessel provided with a burner at the top of the

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top zone (z1) of the vessel, and a catalyst bed in the bottom zone (z2) of the vessel, operatively connected to a cooling unit, and further comprising at least one gas introduction line connected to a water splitter unit.

5 According to the present disclosure, the hydrogen and/or oxygen used in the RWGS process may be provided from a water splitting unit, which advantageously may be powered by renewable power sources.

10 DETAILED DESCRIPTION OF THE DISCLOSURE

 The present disclosure relates to a (partially) catalytic RWGS process for converting a gas stream comprising carbon dioxide into products. According to the present disclosure, the feed streams to the reverse water
15 gas shift reaction vessel comprise several gas streams: at least a gas stream comprising carbon dioxide, a hydrogen rich gas stream and an oxygen rich gas stream. Optionally, additional gas streams may be introduced into the reaction vessel as co-feed or pre-mixed gas streams
20 (i.e. pre-mixed with any of the other gas streams), such as, but not limited to, streams comprising off-gases or natural gas.

 A gas stream comprising carbon dioxide herein means a gas stream comprising from 1% to 100% carbon dioxide by
25 volume. Sources of the carbon dioxide may be diverse, such as for example, but not limited to carbon dioxide captured from air or from flue gases, off-gases, and the like. The gas stream comprising carbon dioxide comprises carbon dioxide and may also comprise other gases, for
30 example, hydrocarbons such as methane, ethane, propane, butane, pentane, inert gases such as argon, other gases such as nitrogen, oxygen, traces of hydrogen, carbon monoxide or combinations of all the mentioned gases

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thereof. Preferably, the gas stream comprising carbon dioxide contains carbon dioxide in the range of 30 to 100 volume %, and even more preferred 50 to 100 volume %.

5 The hydrogen rich gas stream comprises hydrogen as a main component, suitably at least 35 volume % of hydrogen, and may optionally comprise other components, such as oxygen, nitrogen, water or combinations thereof. Preferably, the hydrogen rich gas stream comprises high purity hydrogen typically of 50 % and higher by volume, particularly 65 % and higher by volume, and especially 95 % and higher by volume.

10 The oxygen rich gas stream comprises oxygen, and may optionally comprise other components, such as nitrogen, hydrogen, water or combinations thereof. Preferably, the oxygen rich gas stream comprises of high purity oxygen typically of 70 % and higher by volume, particularly 80 % and higher by volume, and specifically 90 % and higher by volume.

15 According to the present disclosure, the reverse water gas shift reaction in the reaction vessel takes place at elevated temperature which is needed to sufficiently activate the catalytic conversion of carbon dioxide and hydrogen into carbon monoxide and water in the bottom zone (z2). The temperature in the top zone (z1) is maintained in the range 700 to 1200°C, and preferably, the temperature in the top zone (z1) is maintained in the range of 800 to 1100°C. The pressure maintained in the reactor vessel is the range of 1 bar to 80 bar. Preferably, the pressure in the reaction vessel is from 5 to 70 bar.

20 In the process according to the present disclosure, the hydrogen rich gas stream is introduced into the reaction vessel at a temperature between 15 and 450°C, in

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particular between 100 and 300°C, more particularly between 150 and 250°C, and especially between 220 and 240°C.

5 According to the present disclosure, the oxygen rich gas stream is introduced into the reaction vessel at room temperature or at a slightly elevated temperature. Preferably, the oxygen rich gas stream is introduced into the reaction vessel at a temperature between 15 and 300°C, in particular between 100 and 280°C, more
10 particularly between 120 and 260°C, and especially between 220 and 260°C.

According to the present disclosure, the gas stream comprising carbon dioxide is introduced into the reaction vessel at room temperature or at a slightly elevated
15 temperature. Preferably, the gas stream comprising carbon dioxide is introduced into the reaction vessel at a temperature between 15 and 700°C, in particular between 50 and 600°C, more particularly between 150 and 500°C, and especially between 200 and 450°C.

20 According to the present disclosure, any optional additional gas stream that is introduced into the reaction vessel as co-feed or pre-mixed gas stream, is introduced at room temperature or at a slightly elevated temperature. Preferably, the optional additional gas
25 stream is introduced into the reaction vessel at a temperature between 15 and 500°C, in particular between 50 and 450°C.

In the process according to the present disclosure, the feed streams to the reverse water gas shift reaction
30 vessel, at least the hydrogen rich gas stream and the oxygen rich gas stream are introduced into the reaction vessel via a burner comprising coaxial channels, which may have different slit widths, for the separate

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introduction of the different gas streams, potentially at different velocities, the velocities of the gases in the channels being preferably between 1-200 m/s, more preferably between 3-120 m/s. These velocity ranges vary depending on the feed stream. Burner construction may require providing an angle to burner tips to accommodate them within a target burner mouth opening. Preferably, the angle of a burner tip end is between 5-90 degrees, preferably between 20-65 degrees, for each of the coaxial channels. See for example Figures 9 and 10. Burners suitable for this purpose are known in the art, such as described in WO2015011114. In the process according to the present disclosure, the burner is located at the top of the reaction vessel.

According to the present disclosure, the hydrogen rich gas stream and the oxygen rich gas stream advantageously undergo an exothermic reaction in front of the tip of the burner in top zone (z1) providing the heat energy required for the catalytic endothermic reverse water gas shift reaction in the bottom zone (z2) to occur. Since this combustion reaction in top zone (z1) is exothermic, the excessive heat energy may cause damage to the burner. In order to prevent the hydrogen rich gas stream and the oxygen rich gas stream from reacting in close vicinity of the burner outlet, part of the gas stream containing carbon dioxide is introduced via a channel in between the hydrogen rich gas stream and the oxygen rich gas stream. Preferably, in addition, the oxygen rich gas stream is introduced via the inner channel(s) of the burner, and the remaining part of the gas stream containing carbon dioxide is introduced in an outer channel of the burner, being outside of the channels for the hydrogen rich gas stream and oxygen rich

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gas stream, to prevent overheating of the burner due to high heat energy caused by the reaction of the hydrogen rich gas stream and the oxygen rich gas stream inside the reaction vessel. As described above, the temperature in the top zone (z1) is maintained in the range 700 to 1200°C, and preferably, the temperature in the top zone (z1) is maintained in the range of 800 to 1100°C. The temperature in the reaction vessel is maintained by adjusting the flow of any of the gas streams which are introduced into the reaction vessel, usually the flow of oxygen rich gas. Adjustment of flows of carbon dioxide and/or hydrogen also may result in changes to the reactor temperature and therefore may also be used as means of temperature control.

According to the present disclosure, the catalyst used can be any catalyst suitable for use in the reverse water gas shift process. For example, catalyst compositions suitable for catalyzing reverse water gas shift reaction include metal, metal oxides, or any combinations thereof. The catalytically active material is optionally supported on a catalyst support material. Such catalyst is preferably characterized by a low selectivity for the formation of methane. Further, suitable catalysts should display a sufficient high stability, for instance in terms of thermal stability but also in terms resistance against coke formation on the catalyst. The catalyst material is formed into shaped bodies according to process requirements and as known to persons skilled in the art. Particular body shapes may be required to fulfill criteria regarding heat transfer, pressure drop etc. Catalysts for use in reverse water gas shift reactions are known in the art, see for example US20100190874, WO2013135664, US2015307352, US2016296916,

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US2016332874, US2017197829, Catalyst Screening and Kinetic Modeling for CO Production by High Pressure and Temperature Reverse Water Gas Shift for Fischer-Tropsch Applications, Francisco Vidal Vázquez, Peter Pfeifer, 5 Juha Lehtonen, Paolo Piermartini, Pekka Simell, and Ville Alopaeus, Ind. Eng. Chem. Res. 2017, 56, 13262-13272; and the like.

In the process according to the present disclosure, the catalyst bed is placed at a distance from the reactor inlet that is sufficient to avoid damage at the top of 10 the catalyst bed by the flame produced by the burner. Particularly, the catalyst bed is placed above the reactor outlet located at the bottom of the reaction vessel, while minimizing the free space between the catalyst bed and the reactor outlet. The size of the 15 catalyst bed can range between 0.2-4 times the inner diameter of the reactor.

In a preferred embodiment, a solids bed comprising refractory oxide material capable of retaining majority 20 of soot particles is positioned on top of the catalyst bed. The solids bed protects the catalyst bed from fouling by soot particles by capturing a majority of them upstream of the catalyst bed and providing them sufficient time to convert mainly to carbon monoxide. 25 Suitable refractory materials are selected from ceramic materials known in the state of art. The solids bed could be mounted inside the reactor by means known in the art, for example, as described in US2009/0224209A1. The size of the solids bed can range between 0-2 times the inner 30 diameter of the reactor.

The product stream at the outlet of the reverse water gas shift reaction vessel comprises of carbon monoxide,

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hydrogen, water, unconverted carbon dioxide, some methane or combinations thereof.

5 Different downstream applications require different ratio of hydrogen to carbon monoxide in the product stream. The ratio of hydrogen to carbon monoxide by volume at the outlet of the reverse water gas shift reaction vessel is in the range of 0.5 to 5, preferably in the range of 1 to 2. The ratio of the hydrogen to carbon dioxide by volume at the inlet of the reverse
10 water gas shift reaction vessel varies from 1 to 5, preferably between 2 and 3.5. The ratio of hydrogen to carbon dioxide is adjusted such that the required hydrogen to carbon monoxide ratio in the product stream is obtained.

15 According to the present disclosure, the reverse water gas shift reaction vessel is preferably preheated, in particular in the range from 25°C up to 1100°C, to initiate the reverse water gas shift reaction. The preheating of the reaction vessel may be performed by
20 passing through the reaction vessel a mixture of hot gases resulting, for example, from the combustion of natural gas and air. Alternatively, other options for preheating may be used, like electrically heating. In the process according to the present disclosure, the
25 product stream exiting the reaction vessel is cooled in a water-cooled heat exchanger. Alternatively, the product stream is cooled directly with water. In both cases, a cooled product mixture comprising carbon monoxide, hydrogen, steam and unconverted carbon dioxide is
30 produced. The cooling process making use of the special heat exchanger advantageously transfers heat energy from the product stream to cooling water to produce steam. The product stream or steam produced is used to

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advantageously preheat one or more of the feed streams selected from the gas stream comprising carbon dioxide, hydrogen rich gas stream and oxygen rich gas stream, and optionally additional gas streams introduced into the
5 reaction vessel as co-feed or pre-mixed gas streams that enter the reaction vessel. Alternatively, one or more of the feed streams selected from the gas stream comprising carbon dioxide, hydrogen rich gas stream and oxygen rich gas stream, and optionally additional gas streams can be
10 preheated externally by other forms of heating including electrical heaters. Preheating one or more of these feed streams increases the efficiency of the reverse water gas shift process.

According to the present disclosure, a water splitter
15 can be used to produce at least a part of the hydrogen rich gas stream and the oxygen rich gas stream. A water splitter is a device that splits water into hydrogen and oxygen. Such a water splitter may be, among others, electrolysis of water using electrical energy, photo
20 electrochemical water splitting, photocatalytic water splitting, thermal decomposition of water and other known in the art methods of water splitting. A preferred water splitter is an electrolyzer. Energy sources for the water splitting will advantageously be provided by renewable
25 power sources, such as solar and/or wind energy.

According to the present disclosure, the oxygen rich gas stream from the water splitter can be advantageously liquified, optionally stored, and re-gasified before use as feed.

30 According to the present disclosure, the cooled product stream comprising carbon monoxide, hydrogen, steam and unconverted carbon dioxide is subjected to further cooling at least to, and beyond, the dew point to

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provide a gas stream comprising of carbon monoxide, hydrogen, unconverted carbon dioxide and liquid water which can then be separated from the product gas stream. Separators suitable for this purpose are known to people skilled in the art. The liquid water stream thus separated is then recycled back to the water splitter after treating. As long as the product stream exiting the separator, comprising carbon monoxide and hydrogen produced by the process described above, still comprises unconverted carbon dioxide, the product stream exiting the separator advantageously may be repeatedly subjected to said process steps to convert further carbon dioxide present. In the process according to the present disclosure, multiple stages for the reverse water gas shift process are required if further conversion of the unconverted carbon dioxide in the product stream is required. The multiple stages are a repeat of the entire reverse water gas shift process explained above. The cooled product gas stream comprising of carbon monoxide, hydrogen, unconverted carbon dioxide, thus obtained from the first reaction vessel after being subjected to cooling and separation of liquid water, is the feed to a second reverse water gas shift reaction vessel along with one or more feed streams selected from hydrogen rich gas stream and the oxygen rich gas streams from the water splitter. The product stream comprising carbon monoxide, hydrogen, water, unconverted carbon dioxide or combinations thereof, from the second reaction vessel is subjected to further cooling and separation of the liquid water from the cooled product gas stream comprising carbon monoxide, hydrogen and unconverted carbon dioxide. One or more of the feed streams for the second reaction vessel selected from the product gas stream comprising

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carbon dioxide, hydrogen, water, unconverted carbon dioxide, optional additional gas streams introduced into the reaction vessel as co-feed or pre-mixed gas streams, hydrogen rich gas stream and oxygen rich gas stream may
5 be advantageously preheated using any of the preheating methods described above.

The process of this disclosure may advantageously be performed in a reverse water-gas shift process unit comprising at least one reaction vessel operatively
10 connected to a cooling unit, and further comprising a gas introduction line connected to a water splitter unit. The process unit, preferably is provided with a burner at the top of a top zone (z1) of the vessel, and a catalyst bed in a bottom zone (z2) of the vessel, operatively
15 connected to a cooling unit, and further comprising at least one gas introduction line connected to a water splitter unit. The reaction vessel is oriented in an advantageous manner, either horizontal or vertical, as required by the process. The length of top zone (z1) is
20 between 1-5 times the inner diameter of the reaction vessel and the length of the bottom zone (z2) is between 0.3-0.6 times the height of the reaction vessel. The outlet of the reaction vessel is placed in an advantageous manner, either at the bottom of the vessel
25 or at the side of the vessel below the catalyst bed. If the outlet is placed at the side of the vessel, there may exist some empty space between the bottom of the vessel and the outlet.

When multiple stages for the reverse water gas shift
30 process are required, if further conversion of the unconverted carbon dioxide in the product stream is required, this is preferably performed in a unit comprising at least two reaction vessels, each of which

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are operatively connected to a cooling unit, which are placed in consecutive order of a first reaction unit followed by a cooling unit and again followed by a reaction unit followed by a cooling unit, and the process unit further comprising at least one gas introduction line connected to a water splitter unit.

The process, or process steps thereof, and process unit(s) of the present invention may advantageously be integrated into processes requiring synthesis gas as a feedstock.

DESCRIPTION OF THE DRAWINGS

Legend: **P** refers to the (catalytic) reverse water gas shift process unit comprising a reaction vessel provided with a burner at the top of the top zone (z1) of the vessel, and a catalyst bed in the bottom zone (z2) of the vessel. **Q** refers to (a) process unit(s) that act as syngas cooler. **R** is/are (a) process unit(s) that act as a water splitter. **S** is/are (a) process unit(s) that act as syngas cooler and water separator. All the figures illustrated are possible schematic interpretations of the present disclosure.

Figure 1. illustrates an embodiment of the present disclosure of the catalytic reverse water gas shift process where the gas stream comprising carbon dioxide **1**, hydrogen rich gas stream **2** and oxygen rich gas stream **3** enter **P** via a burner to form a product gas stream **4** comprising carbon monoxide, hydrogen, water and likely some unconverted carbon dioxide. Optional additional gas streams are not shown in Figure 1.

Figure 2. Illustrates another embodiment of the present disclosure where the the gas stream comprising carbon dioxide **1**, hydrogen rich gas stream **2** and oxygen rich gas

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stream 3 enter P via a burner to form a product gas stream 4 comprising carbon monoxide, hydrogen, water and likely some unconverted carbon dioxide. The product stream 4 is cooled with water 5 in Q to make steam 6 and cooled product stream 4'.

Figure 3. Illustrates another embodiment of the present disclosure where a preheated gas stream containing carbon dioxide 10, preheated hydrogen rich gas stream 11 and preheated oxygen rich gas stream 12 enter P via a burner to form a product gas stream 4 comprising carbon monoxide, hydrogen, water and likely some unconverted carbon dioxide. The product stream 4 is cooled with water 5 in Q to make steam 6 and cooled product stream 4'. One or both of the streams selected from cooled product stream 4' and steam 6 may be used to preheat one or more of the feed streams selected from gas stream comprising carbon dioxide 1, hydrogen rich gas stream 2 and oxygen rich gas stream 3. In Figure 3, cooled product stream 4' is used to preheat the gas stream comprising carbon dioxide 1, and steam 6 is used to preheat hydrogen rich gas stream 2 and oxygen rich gas stream 3.

Figure 4. Illustrates another embodiment of the present disclosure where a preheated gas stream comprising carbon dioxide 10, preheated hydrogen rich gas stream 11 and preheated oxygen rich gas stream 12 enter P via a burner to form a product gas stream 4 comprising carbon monoxide, hydrogen, water and possibly unconverted carbon dioxide. The product stream 4 is cooled with water 5 in Q to make steam 6 and cooled product stream 4'. One or both of the streams selected from cooled product stream 4' and steam 6 may be used to preheat one or more of the feed streams selected from gas stream comprising carbon dioxide 1, hydrogen rich gas stream 2 and oxygen rich gas

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stream 3. In Figure 4, cooled product stream 4' is used to preheat the gas stream comprising carbon dioxide 1, and steam 6 is used to preheat hydrogen rich gas stream 2 and oxygen rich gas stream 3. Unit R is used to produce at least part of the hydrogen rich gas stream 2 and oxygen rich gas stream 3 from water 7 using an energy source 8. Excess oxygen rich gas stream 9 is taken out which can be utilized elsewhere or vented.

Figure 5. Illustrates another embodiment of the present disclosure where the preheated gas stream comprising carbon dioxide 10, preheated hydrogen rich gas stream 11 and preheated oxygen rich gas stream 12 enter P via a burner to form a product gas stream 4 comprising carbon monoxide, hydrogen, water and possibly unconverted carbon dioxide. The product stream 4 is cooled with water 5 in Q to make steam 6 and cooled product stream 4'. One or both of the streams selected from cooled product stream 4' and steam 6 may be used to preheat one or more of the feed streams selected from gas stream comprising carbon dioxide 1, hydrogen rich gas stream 2 and oxygen rich gas stream 3. In Figure 5, cooled product stream 4' is used to preheat the gas stream comprising carbon dioxide 1, and steam 6 is used to preheat hydrogen rich gas stream 2 and oxygen rich gas stream 3. R is used to produce at least part of the hydrogen rich gas stream 2 and oxygen rich gas stream 3 from water 7 using an energy source 8. The cooled product gas stream 4' is further cooled to dew point in S and liquid water 14 is separated from the cooled product gas stream 13 in S. Excess oxygen rich gas stream 9 is taken out which can be utilized or vented.

Figure 6. Illustrates another embodiment of the present disclosure where the preheated gas stream comprising carbon dioxide 10, preheated hydrogen rich gas stream 11

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and preheated oxygen rich gas stream **12** enter **P1** to form a product gas stream **4** comprising carbon monoxide, hydrogen, water and unconverted carbon dioxide. The product stream **4** is cooled with water **5** in **Q1** to make steam **6** and cooled product stream **4'**. One or both of the streams selected from the cooled product stream **4'** and steam **6** may be used to preheat one or more of the feed streams selected from gas stream containing carbon dioxide **1**, hydrogen rich gas stream **2** and oxygen rich gas stream **3**. **R** is used to produce at least part of the hydrogen rich gas stream **2** and oxygen rich gas stream **3** from water **7** using an energy source **8**. The cooled product gas stream **4'** is further cooled to dew point in **S** and liquid water **14** is separated from the cooled product gas stream **13** in **S**. Unconverted carbon dioxide in the product gas stream **13** is further converted to carbon monoxide by subjecting it to a second stage reverse water gas shift process. The product gas stream **13** along with a hydrogen rich gas stream **2** and oxygen rich gas stream **3** enter **P2** to form a product gas stream **15** comprising carbon monoxide, hydrogen, water and unconverted carbon dioxide. The product stream **15** is cooled with water **16** in **Q2** to make steam **17** and cooled product stream **15'**. Excess oxygen rich gas stream **9** is taken out which can be utilized or vented.

Figure 7. Illustrates the total carbon dioxide conversion at different RWGS reactor temperatures for two different embodiments of the present disclosure as explained in Figure 1 and Figure 3.

Figure 8. Illustrates the total carbon monoxide production at different RWGS reactor temperatures for two different embodiments of the present disclosure as explained in Figure 1 and Figure 3.

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Figure 9. illustrates an embodiment of a burner that can be used in the process according to the present disclosure. The exemplified burner contains four coaxial channels **A**, **B**, **C** and **D**, but more channels may also be possible. Oxygen rich gas stream **3** or preheated oxygen rich gas stream **12** (i.e. gas stream **3/12**) enters the reaction vessel via channel **A** of the burner. A portion of the gas stream comprising carbon dioxide **1** or preheated gas stream comprising carbon dioxide **10** (i.e. gas stream **1/10**) advantageously enters the reaction vessel via channel **B** of the burner. Hydrogen rich gas stream **2** or preheated hydrogen rich gas stream **11** (i.e. gas stream **2/11**) enters the reaction vessel via channel **C** of the burner. Another portion of the gas stream comprising carbon dioxide **1** or preheated gas stream comprising carbon dioxide **10** (i.e. gas stream **1/10**) enters the reaction vessel via channel **D** of the burner.

Figure 10. illustrates another embodiment of a burner that can be used in the process according to the present disclosure. The burner contains five coaxial channels **A**, **B**, **C**, **D** and **E**. Oxygen rich gas stream **3** or preheated oxygen rich gas stream **12** (i.e. gas stream **3/12**) enters the reaction vessel via channels **A** and **B** of the burner. A portion of the gas stream comprising carbon dioxide **1** or preheated gas stream comprising carbon dioxide **10** (i.e. gas stream **1/10**) advantageously enters the reaction vessel via channel **C** of the burner. Hydrogen rich gas stream **2** or preheated hydrogen rich gas stream **11** (i.e. gas stream **2/11**) enters the reaction vessel via channel **D** of the burner. Another portion of the gas stream comprising carbon dioxide **1** or preheated gas stream comprising carbon dioxide **10** (i.e. gas stream **1/10**) enters the reaction vessel via channel **E** of the burner.

Hereinafter the invention will be further illustrated by the following non-limiting example.

5 EXAMPLE 1.

The following example refers to the processes as explained in the different embodiments of the present disclosure as described in Figure 1 and Figure 3. Table 1 illustrates the product stream (main product is synthesis gas) compositions at the outlet of catalytic reverse water gas shift reaction vessel for different reactor temperatures for two different cases: when the feed streams are not preheated (as illustrated in Figure 1) and when they are preheated (as illustrated in Figure 3). The feed H_2 to CO_2 ratio is constant for all cases. The catalytic reverse water gas shift reactor temperature is controlled by adjusting the flow of oxygen to the reactor. The synthesis gas composition results were obtained by assuming that the synthesis gas at the outlet of the catalytic reverse water gas shift reactor is at steady state thermodynamic equilibrium at the outlet of the reaction vessel.

Figure 7 and Figure 8 illustrate the total carbon dioxide conversion and total carbon monoxide produced for different RWGS reactor temperatures for two different cases: when the feed streams are not preheated (as illustrated in Figure 1) and when they are preheated (as illustrated in Figure 3).

Temp. (°C)	700	800	1000	1200	700	800	1000	1200
H ₂ /CO ₂	3	3	3	3	3	3	3	3
Feed Preheat	No	No	No	No	Yes	Yes	Yes	Yes
Product stream composition (mole %)								

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H ₂	46.1	47.1	42.3	37.7	47.8	49.6	45.0	40.6
CO	10.6	13.8	15.9	17.0	11.0	14.7	16.8	17.9
CO ₂	12.6	11.0	9.1	8.0	11.7	10.1	8.2	7.2
H ₂ O	27.0	27.7	32.7	37.3	24.9	25.1	30.0	34.4
CH ₄	3.7	0.4	0.0	0.0	4.7	0.6	0.0	0.0
Total	100	100	100	100	100	100	100	100