Claims

1. An additive composition comprising:

a C_8-C_{24} primary amine;

a tertiary cycloalkylamine comprising di(ethanol)cyclopentylamine, di(ethanol)cyclohexylamine, di(ethanol)cycloheptylamine, dicyclopentyl(ethanol)amine, or dicyclohexyl(ethanol)amine; and

an amino acid comprising alanine, arginine, asparagine, aspartic acid, cysteine, glutamine, glutamic acid, glycine, histidine, isoleucine, leucine, lysine, methionine, phenyalanine, proline, serine, threonine, tryptophan, tyrosine, or valine;

wherein the additive composition does not contain boron or a secondary amine.

2. A processing fluid comprising:

a petroleum-based or non-petroleum-based oil;

water;

a C_8-C_{24} primary amine;

a tertiary cycloalkylamine comprising di(ethanol)cyclopentylamine, di(ethanol)cyclohexylamine, di(ethanol)cycloheptylamine, dicyclopentyl(ethanol)amine, or dicyclohexyl(ethanol)amine; and

an amino acid comprising alanine, arginine, asparagine, aspartic acid, cysteine, glutamine, glutamic acid, glycine, histidine, isoleucine, leucine, lysine, methionine, phenyalanine, proline, serine, threonine, tryptophan, tyrosine, or valine;

wherein the processing fluid does not contain boron or a secondary amine.

3. The processing fluid of Claim 2, wherein the C_8-C_{24} primary amine comprises octylamine, nonylamine, decylamine, undecylamine, dodecylamine, tridecylamine, tetradecylamine, pentadecylamine, hexadecylamine, heptadecylamine, or octadecylamine.

4. The processing fluid of Claim 2 further comprising an alkanolamine comprising methanolamine, ethanolamine, propanolamine, trimethanolamine, triethanolamine,

tripropanolamine, methyldimethanolamine, ethyldimethanolamine, propyldimethanolamine, cyclohexyldimethanolamine, methyldiethanolamine, ethyldiethanolamine, or propyldiethanolamine.

5. The processing fluid of Claim 2 further comprising a polymerized fatty acid which is a polymerized ricinoleic acid derived from castor oil, or a polymerized fatty acid derived from soy bean oil, or a linseed oil.

6. The processing fluid of Claim 2 comprising the petroleum-based oil.

7. The processing fluid of Claim 2 comprising the non-petroleum-based oil.

8. The processing fluid of Claim 2 further comprising a phosphate ester and/or an ethoxylated fatty amine.

9. The processing fluid of Claim 2, wherein the water is present from about 1 wt% to about 50 wt%.

10. The processing fluid of Claim 2 further comprising a hydrocarbyl succinimide.

11. The processing fluid of Claim 2 further comprising a sulfur-containing compound.

12. The processing fluid of Claim 2 comprising a sulfur-containing compound and a phosphate ester, wherein the weight ratio of the phosphate ester to the sulfur in the sulfur-containing compound is from about 25:1 to about 1:1.

13. The processing fluid of Claim 2 further comprising an aliphatic carboxylic acid or an aliphatic dicarboxylic acid.

14. The processing fluid of Claim 2 further comprising an additive comprising a defoaming agent, a corrosion inhibitor, or an olfactory agent.

15. The processing fluid of Claim 2 having a pH of at least 9.