

A CATALYST AND METHOD OF STEAM REFORMING

5 RELATED APPLICATIONS

This application is a continuation-in-part of U.S. Patent Application Ser. Nos. 09/788,293 (filed Feb. 16, 2001), 09/930,040 (filed Aug. 14, 2001) which is a divisional of 09/375,615, filed Aug. 17, 1999, now U.S. Patent No. 6,284,217, 09/640,903 (filed 10 Aug. 16, 2000), and 09/375,614 (filed Aug. 17, 1999), all of which are incorporated herein as if reproduced in full below.

FIELD OF THE INVENTION

15 The present invention relates to catalysts and methods of steam reforming of a hydrocarbon.

BACKGROUND OF THE INVENTION

20 Steam reforming of hydrocarbons is commonly used for feedstock production for carbon-monoxide hydrogenation (Fischer-Tropsch synthesis), methanol synthesis and hydrogen production. Steam reforming is done commercially by flowing a mixture of steam and the hydrocarbon past a supported catalyst having an alumina support and a catalyst metal thereon, and reacting the mixture at a temperature from about 600 °C to 25 about 1000 °C, forming at least one product. Research has been done with the catalyst metal on many types of supports, including a spinel support. Residence times for conventional processes are typically on the order of seconds and steam to carbon ratio greater than about 2.5. For steam to carbon ratio less than 2.5, catalyst activity is generally degraded after hours to days due to coke formation and the supported catalyst 30 must be refreshed or replaced.

The rate of supported catalyst activity degradation has been reduced in conventional processes by use of excess steam (steam to carbon ratio greater than 2.5). Excess steam, however, requires excess thermal energy and may result in a large system pressure drop. Using less steam results in faster degradation of catalyst activity 35 because of coking from the hydrocarbon(s).

Hence, there is a need for a method of steam reforming of a hydrocarbon that provides greater product yield and permits using less steam and maintaining catalytic activity of the catalyst.

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SUMMARY OF THE INVENTION

The present invention provides a method of steam reforming in which steam and hydrocarbon are passed through a reaction chamber. The reaction chamber comprises a porous catalyst.

10 The invention further provides a method of steam reforming, comprising: passing steam and hydrocarbon through a reaction chamber, where the rate of said passing steam and hydrocarbon is controlled such that residence time in the reaction chamber is less than 0.1 seconds. The reaction chamber comprises a catalyst that has surface active sites comprising a material selected from the group consisting of rhodium, iridium,
15 nickel, palladium, platinum, ruthenium, carbide of group VIb and combinations thereof. At least 50% of the hydrocarbon has been converted to products after passing through the reaction chamber.

The invention also provides a method of steam reforming, comprising: passing steam and hydrocarbon through a reaction chamber; wherein the reaction
20 chamber comprises a spinel-containing catalyst that has surface active sites comprising a material selected from the group consisting of rhodium, iridium, nickel, palladium, platinum, ruthenium, carbide of group IVb and combinations thereof; wherein the rate of passing steam and hydrocarbon is controlled such that residence time in the reaction chamber is less than 0.1 seconds; wherein the temperature in the reaction chamber is in
25 the range of 500 °C to 1000 °C; and wherein, after passing through the reaction chamber, at least 60% of the hydrocarbon has been converted to products after passing through the reaction chamber. "Converted to products" simply means that the hydrocarbon has been reacted and changed its chemical formula (e.g., methane has been converted to CO and hydrogen).

30 The invention also provides a catalyst, that includes: (a) a first porous structure with a first pore surface area and a first pore size of at least about 0.1 μm ; (b) a porous interfacial layer that comprises a spinel with a second pore surface area and a second pore size less than said first pore size, said porous interfacial layer having a thickness less than 4 mm disposed upon said porous structure; and (c) a steam reforming catalyst
35 that contains rhodium, iridium, nickel, palladium, platinum, ruthenium, carbide of group IVb and/or combinations thereof disposed upon the second pore surface area.

The invention also provides a catalyst that includes: an alumina layer; a metal exposed on the surface of the catalyst; and a spinel layer disposed between the alumina layer and the metal. The spinel layer is in direct contact with the alumina layer, and the metal includes a metal selected from the group consisting of: rhodium, iridium, nickel,
5 platinum, palladium, and ruthenium. By "exposed on the surface" it is meant that the metal would be exposed to reactant gases that contact the catalyst; the metal can be located inside pores and crevices as well as the very exterior of the catalyst.

The subject matter of the present invention is particularly pointed out and distinctly claimed in the concluding portion of this specification. However, both the
10 organization and method of operation, together with further advantages and objects thereof, may best be understood by reference to the following description taken in connection with accompanying drawings wherein like reference characters refer to like elements.

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BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a schematic drawing of catalyst testing apparatus.

20 FIG. 2 is a graph of conversion and selectivity versus furnace temperature for methane steam reforming over a spinel-supported powder catalyst at a 25 millisecond contact time.

FIG. 3 is a graph of conversion and selectivity versus time for methane steam reforming over a spinel-supported powder catalyst at a 25 millisecond contact time.

25 FIG. 4 is a graph of conversion and H₂ selectivity versus furnace temperature for butane steam reforming over a spinel-supported powder catalyst at 10 and 25 millisecond contact times.

FIG. 5 is a graph of conversion and CO selectivity versus steam to carbon ratio for methane steam reforming over a spinel-supported powder catalyst at a 6.35
30 millisecond residence (27 ms contact) time.

FIG. 6 is a graph of conversion versus pressure for methane steam reforming over a spinel-supported engineered catalyst at various contact times.

FIG. 7 is a graph of conversion and CO selectivity versus temperature comparing the engineered catalyst versus the same powder catalyst at the same conditions.

35 FIG. 8 is a graph of CO selectivity versus pressure for engineered catalysts at various contact times.

FIG. 9 is a graph of propane conversion versus temperature for propane steam reforming at 26, 63 and 133 ms contact times.

FIG. 10 is a graph of conversion versus time for steam reforming of JP-8 fuel.

FIG. 11 is a graph of conversion versus catalyst bed temperature for steam reforming of Fischer-Tropsch synthetic fuel through a catalyst powder at 50 and 100 ms contact times.

FIG. 12 is a histogram comparing conversion (lightly shaded blocks) and selectivity to hydrogen (darker shaded blocks) for (A) Rh/ZrO₂ and (B) Rh/spinel.

10 DESCRIPTION OF THE PREFERRED EMBODIMENT(S)

The catalyst requires catalytically active surface sites that reduce the kinetic barrier to the steam reforming reaction. Preferably the catalyst for surface-exposed sites comprise one or more of the following: ruthenium, rhodium, iridium, nickel, palladium, platinum, and carbide of group VIb. Rhodium is particularly preferred.

The catalyst also contains a support material, preferably a spinel. Spinel is a well-known class of hard, thermally stable materials. See, for example, the description of spinels in Wells, "Structural Inorganic Chemistry," 5th ed. 1987 pp. 592-596, 318.5. The spinel preferably has the formula $MgAl_2O_4$, although in practice it is expected that small (e.g., 5%) compositional differences may be present. The spinel, including the presence of catalytically active surface sites, as measured by BET, preferably has a volumetric average pore size of less than 0.1 micrometer (μm). The spinel, including the presence of catalytically active surface sites, as measured by BET, nitrogen physisorption, preferably has a surface area of more than 10 m^2/g , more preferably a surface area of 20 to 500 m^2/g . The spinel can be particles, preferably having diameters less than 4 μm , more preferably less than 1 μm , or, more preferably the spinel forms a layer (of agglomerated particles or a continuous film) having a thickness less than 4 μm , more preferably less than 1 μm , and still more preferably a thickness of less than 40 μm .

In preferred embodiments, the spinel layer is coated over, and preferably in direct contact with, a high surface area material such as alumina, preferably γ (gamma)-alumina. This configuration provides high surface area for good metal dispersion and/or high metal loadings and also provides a spinel layer for excellent stability and minimized surface acidity. The high surface area material is porous; thus, the meaning of a spinel "disposed over" or "coated over" a high surface area material means that the spinel may also coat crevices and cavities within the high surface area material (or the large pore size substrate where there is not an intervening layer).

The catalyst may take any conventional form such as a powder or pellet. In some preferred configurations, the catalyst includes an underlying large pore support. Examples of preferred large pore supports include commercially available metal foams and, more preferably, metal felts. Prior to depositing the alumina (if present), spinel and surface-exposed catalyst, the large pore support has a porosity of at least 5%, more preferably 30 to 99%, and still more preferably 70 to 98%. Preferably, the support has a volumetric average pore size, as measured by BET, of 0.1 μm or greater, more preferably between 1 and 500 μm . Preferred forms of porous supports are foams and felts and these are preferably made of a thermally stable and conductive material, preferably a metal such as stainless steel or FeCrAlY alloy. These porous supports are preferably thin, such as between 0.1 and 1 mm. Foams are continuous structures with continuous walls defining pores throughout the structure. Felts are fibers with interstitial spaces between fibers and includes tangled strands like steel wool. Felts are conventionally defined as being made of nonwoven fibers. Various supports and support configurations are described in U.S. Patent Applications Ser. No. 09/640,903 (filed Aug. 16, 2000), which is incorporated by reference.

The catalyst with a large pore support (and including the spinel-supported catalyst) preferably has a pore volume of 5 to 98%, more preferably 30 to 95% of the total porous material's volume. Preferably, at least 20% (more preferably at least 50%) of the material's pore volume is composed of pores in the size (diameter) range of 0.1 to 300 microns, more preferably 0.3 to 200 microns, and still more preferably 1 to 100 microns. Pore volume and pore size distribution are measured by mercury porosimetry (assuming cylindrical geometry of the pores) and nitrogen adsorption. As is known, mercury porosimetry and nitrogen adsorption are complementary techniques with mercury porosimetry being more accurate for measuring large pore sizes (larger than 30 nm) and nitrogen adsorption more accurate for small pores (less than 50 nm). Pore sizes in the range of about 0.1 to 300 microns enable molecules to diffuse molecularly through the materials under most gas phase catalysis conditions.

In one embodiment, the large-pore substrate has a corrugated shape that could be placed in a reaction chamber (preferably a small channel) of a steam reformer.

The catalysts are stable and resistant to coke formation. In preferred embodiments, the catalyst has less than a 5% decline in hydrocarbon conversion after 40 hours of methane steam reforming at a steam to carbon ratio of 1, a contact time of 27 msec, less than 1 psig, and 900°C. In another preferred embodiment, the catalyst does not show reduced hydrocarbon conversion after 1000 hours of steam reforming at

a steam to carbon ratio of 3, a contact time of 20 msec, 120 psig, and 850°C.

Preferably, no coke formation is observed under the same conditions.

In one method of making a catalyst, a high surface area powder, such as alumina, is impregnated with a soluble magnesium solution. The resulting material is dried and calcined. In some preferred embodiments, either (1) less than 0.5 mole Mg is added per mole of Al, or (2) the calcinations treatment is sufficiently low temperature or short such that not all of the alumina is converted to spinel. In the second method, a layer of magnesia will remain over the spinel. Following spinel formation, a catalytically active material is deposited, dried, calcined and activated.

When an underlying, large-pore substrate is used, the above-described powder could be slurry coated over the substrate at any stage in the preparative process. For example, the particles, after calcinations to form the spinel, could be slurry coated onto the substrate followed by depositing, drying and activating a metal via the impregnation method. Alternatively, a vapor coat or soluble form of alumina (or other high surface area material) could be applied onto the substrate prior to spinel formation. Although solution or slurry coating is typically less expensive, vapor coating of the various materials could also be employed.

The present invention also provides methods of steam reforming in which a hydrocarbon is reacted with water vapor at short residence (short contact) times over a spinel-containing catalyst such as the catalysts described above. The residence time is preferably less than 0.1 s. Short contact times are preferably 5-100 milliseconds (msec), more preferably 10-25 msec.

Hydrocarbons are: alkanes, alkenes, alkynes, aromatics, and combinations thereof including fuels such as gasoline, kerosine, diesel, JP-8. Preferably, the hydrocarbon is an alkane or a fuel. Preferred alkanes are C₁ - C₁₀ alkanes, such as methane, ethane, propane, butane, and isooctane.

The steam reforming reaction is preferably carried out at more than 400 °C, more preferably 500-1000°C, and still more preferably 650-900°C. The reaction can be run over a broad pressure range from sub-ambient to very high. A methane steam reforming reaction run over the inventive catalyst at 120 psi, H₂O/C ratio of 1, 25 ms contact time, and 900 °C, showed no coke formation and no change in CO selectivity after 7 hours of continuous reaction.

Certain aspects of the invention can best be described in terms of properties such as conversion and selectivity. In preferred embodiments, the catalyst, when tested at short contact (or residence) times in the apparatus schematically illustrated in Fig. 1, or equivalent apparatus, shows good hydrocarbon conversions and good selectivities.

Both the catalysts and methods can be characterized by hydrocarbon conversions and selectivities. Hydrocarbon conversion is preferably at least 50%, more preferably at least 90% and still more preferably at least 95%. Hydrogen selectivity, defined as moles H atoms in H₂ in the product gas divided by moles H in all product gases, is preferably at least 50%, more preferably at least 60%, still more preferably at least 85%, and yet still more preferably at least 95%. For some embodiments, carbon monoxide selectivity is preferably less than 65%, more preferably less than 40%. The foregoing conversion values can be either absolute or equilibrium conversions. If not specified, it is conventional to consider conversion values to be absolute conversions.

Under conditions where conversion approaches 100%, absolute and equilibrium conversion is the same. "Equilibrium conversion" is defined in the classical manner, where the maximum attainable conversion is a function of the reactor temperature, pressure, and feed composition. For the case of hydrocarbon steam reforming reactions, the equilibrium conversion increases with increasing temperature and decreases with increasing pressure.

Preferred embodiments of the inventive catalysts and methods may also be described in terms of their exceptionally high hydrogen productivity per catalyst volume. Preferably, the catalyst (per cubic centimeter of volume) has a hydrogen productivity of at least 0.7 mmol·s⁻¹·cm⁻³ when run at the above-described short contact times. In some embodiments, the catalysts and methods have a productivity of between 0.5 and 2 mmol·s⁻¹·cm⁻³ at short contact times.

Example 1

The supported catalyst was spinel of a gamma-alumina (γ -Al₂O₃) support with a magnesia (MgO) passivation layer and rhodium oxide (Rh₂O₃). The approximate composition was about 15 wt% Rh₂O₃, about 5 wt% MgO, and about 80 wt% γ -Al₂O₃. The supported catalyst was prepared by (1) calcining a high surface area γ -Al₂O₃ at 500 °C for 5 hours; (2) impregnating the γ -Al₂O₃ with MgO using the incipient wetness technique with a solution of magnesium nitrate; and obtaining an MgO modified γ -Al₂O₃ support; (3) drying the modified support at 110 °C for 4 hours followed by (4) a second calcination at 900 °C for 2 hours; (5) impregnating the modified support with Rh₂O₃ with the incipient wetness technique from a rhodium nitrate solution; (6) followed by a final drying 110 °C for 4 hours and a (7) a final calcination at 500 °C for 3 hours to obtain a powder of the supported catalyst.

A microreactor was constructed of a quartz tube with 4mm inner diameter (ID) and 6.35 mm outer diameter (OD). About 0.2 g of powder of supported catalyst (70-100mesh) was placed in the microreactor in a packed bed arrangement. Prior to catalyst evaluation, catalyst was activated in 10% H₂/N₂ (100cc(STP)/min) at 110C for
 5 four hours.

A series of tests were run for various hydrocarbons over the catalyst described above. The hydrocarbons included methane, butane, isooctane, synthetic crude, gasoline, diesel, and JP-8. Conversions of 60% or greater were observed in each case.

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Results and conditions are tabulated below.

Hydro-carbon	Furnace T (°C)	P (atm)	contact time (s)	residence time (s)	conv. (%)	select H ₂ (%)	select CO (%)	H ₂ prod. (mmol/s/cc)
methane	885	1	0.025	0.025	99	100	62	1.33
butane	600	1	0.025	0.011	100	61	11	0.75
isooctane	650	1	0.025	0.011	100	87	40	1.06
syn crude	575	1	0.05	0.024	100	88	27	0.53
gasoline	650	1	0.025	0.011	60	100	21	0.73
diesel	650	1	0.025	0.011	93	100	36	1.12
JP-8	650	1	0.025	0.011	95	78	28	0.90

Results are shown in **FIG. 2** for a steam to carbon ratio of 3 and a contact time of
 15 25 msec with conversion ranging from about 52% to 95% with increasing temperature and CO selectivity ranging from 22% to 70%.

Results in **FIG. 3** are for a steam to carbon ratio of 1 and a contact time of 25 msec for a methane steam reforming reaction run at 900 °C over 40 hours. No degradation of the supported catalyst was observed. Electron microscopic examination
 20 after testing revealed no coke deposition and BET measurements detected no significant loss in surface area. Similar testing with a contact time of 27 msec and steam to carbon ratios varying from 3:1 to 1:1 also showed no catalyst degradation after 42 hours and 9 thermal cycles.

A test over the above-described catalyst was conducted for a steam to carbon
 25 ratio of 3 and a contact time of 20 msec for a methane steam reforming reaction run at 850 °C and 120 psig (pounds per square inch gauge) over 1000 hours. Initial methane conversion was 87% and final methane conversion was 92% with initial CO selectivity of

60% and final CO selectivity of 70%. Thus, there was excellent catalyst stability (no degradation of conversion %) even after 1000 hours operation at a steam-to-carbon ratio of 3.

5 The results of steam reforming of butane at 10 and 25 msec over the catalyst of this Example are shown in Fig. 4. The lower sets of curves are for the 10 msec contact times. As can be seen from the figure, the invention can achieve near maximum butane conversion with about 95% conversion or greater at temperatures near 700 °C. Hydrogen selectivity is also good with greater than 50 to 100% selectivity occurring at temperatures near 700 °C.

10 As shown in Fig. 5, for methane steam reforming, increasing steam to carbon ratio increases conversion and decreases CO selectivity.

Example 2: Engineered Catalysts

Porous engineered catalysts were prepared to contain a catalyst of 13.8%-
15 Rh/6%-MgO/Al₂O₃ on a metal felt of FeCrAlY alloy (the alloy was obtained from Technetics, Deland, Florida). 13.8wt%Rh6wt%MgO/Al₂O₃ powdered catalyst was prepared by 1) calcining a high surface area gamma-alumina at 500 °C for 5 hours; 2) impregnating the gamma alumina with MgO using the incipient wetness method with an aqueous solution of magnesium nitrate; and obtaining an MgO modified gamma alumina
20 support; 3) drying the modified support at 110 °C for 4 hours followed by 4) a second calcination at 900 °C for 2 hours; 5) impregnating the modified support with Rh₂O₃ with the incipient wetness method from a rhodium nitrate solution; 6) followed by a final drying at 110 °C for 4 hours and a 7) final calcinations at 500 °C for 3 hours to obtain a powder of the supported catalyst. The powdered catalyst was ball-milled overnight and
25 slurry dip-coated on the FeCrAlY felt until the desired loading is achieved. The coated catalyst was dried at 90 °C overnight and calcined at 350 °C for four hours. Prior to the catalyst evaluation, catalyst was reduced in 10%H₂/N₂ (100cc(STP)/min) at 110 °C for four hours.

All experiments were conducted to demonstrate the present invention using 1
30 microchannel for methane steam reforming. The microchannel was placed within a tube furnace to provide the required endothermic reaction heat. The catalyst "DF" consists of two single felts. Both felt catalysts have the identical dimensions (0.01"x0.35"x2"), and were evaluated in a single channel device (0.03"x 0.35"x 2" / 0.075 cm x 0.88 cm x 5.0 cm). Two felts with a gap of about 0.01" were placed in the single channel device so
35 that both felts were in close contact with the walls. The catalyst chamber volume is defined as the single channel volume (0.03"x 0.35"x 2" / 0.075 cm x 0.88 cm x 5.0 cm).

The catalyst "C" was configured as follows. Felt with a thickness of 0.01" (0.025 cm) was crimped into a corrugated form, and is called a ruffle. Ruffles studied in this work have a fixed wavelength of 0.117" (0.295 cm) and a fixed amplitude of 0.05" (0.127 cm). The dimensions of ruffle are 0.35" (0.88 cm) in width and 2" (8.0 cm) length.

5 Reactants flow in the direction perpendicular to the waves. A single ruffle was snug-fitted into a single channel device (0.05"x0.35"x2" / 0.13 cm x 0.88 cm x 5.0 cm), which confines the catalyst chamber volume. The catalyst "DC" has a double ruffle configuration, which is designed by stacking two identical ruffles with a shim (0.01"x 0.35"x 2" / 0.025 cm x 0.88 cm x 5.0 cm) in between. The double ruffle was evaluated in
10 a wider single channel device (0.11"x 0.35"x 2" / 0.28 cm x 0.88 cm x 5.0 cm), which confines the catalyst chamber volume.

Results of steam reforming using the engineered catalysts is shown in Figs. 6-8. The corrugated forms converted less methane, perhaps because of poorer heat transfer and/or less amount of catalyst within a fixed catalyst bed. Poorer heat transfer can result
15 in relatively lower average catalyst temperature which results in lower CO selectivity as confirmed by the fact that the corrugated forms exhibited a lower CO selectivity. As can be seen in the figures, the catalyst supported on the large pore support (i.e., the engineered catalyst) exhibited the best performance (highest conversion). This surprising superiority of the engineered catalyst over the powder form could not have
20 been predicted based on the published literature.

Example 1

Steam reforming of propane was conducted to demonstrate the present invention using 1 microchannel for methane steam reforming, and the results are shown in Figure 9.
25 The microchannel was placed within a tube furnace to provide the required endothermic reaction heat. The microchannel was 2.54 cm long and 0.95-cm high. The width (or opening) of the microchannel was 0.0762-cm or 762-microns. The 0.0762-cm width included two porous structures that covered opposite walls and each had a width of 254-microns leaving a bulk flow path between the two porous structures of 254 microns. The
30 porous structure contained a catalyst of 13.8%-Rh/6%-MgO/Al₂O₃ on a metal felt of FeCrAlY alloy obtained from Technetics, Deland, Florida. 13.8wt%Rh6wt%MgO/Al₂O₃ powdered catalyst was prepared by 1) calcining a high surface area gamma-alumina at 500°C for 5 hours; 2) impregnating the gamma alumina with MgO using the incipient wetness method with an aqueous solution of magnesium nitrate; and obtaining an MgO
35 modified gamma alumina support; 3) drying the modified support at 110°C for 4 hours

followed by 4) a second calcination at 900°C for 2 hours; 5) impregnating the modified support with Rh₂O₃ with the incipient wetness method from a rhodium nitrate solution; 6) followed by a final drying at 110°C for 4 hours and a 7) final calcinations at 500°C for 3 hours to obtain a powder of the supported catalyst. The powdered catalyst was ball-milled overnight and slurry dip-coated on the FeCrAlY felt until the desired loading is achieved. Prior to the dip-coating, the FeCrAlY felt was heat treated in air at 900°C for two hours. The coated catalyst was dried at 90 °C overnight and calcined at 350°C for four hours. Prior to the catalyst evaluation, catalyst was reduced in 10%H₂/N₂ (100cc(STP)/min) at 110°C for four hours. The propane inlet flowrate and the water (liquid) flowrate were set such that a steam to carbon ratio of approximately 3:1 was achieved. The total feed flowrate corresponds to contact times ranging from 26 to 133ms. The propane and water were preheated to near the reaction temperature before entering the microchannel. As shown in Figure 9, >95% propane conversions and >90% hydrogen selectivity were achieved under the conditions studied (temperature ranging from 550 to 700°C, and contact time ranging from 26 to 133ms).

Example 4

The catalyst, 13.8%-Rh/6%-MgO/Al₂O₃, was also evaluated for steam reforming of sulfur containing fuel, JP-8. Here the catalyst preparation was similar to that described in the example 3. A microreactor was constructed of a quartz tube with 4mm inner diameter (ID) and 6.35 mm outer diameter (OD). About 0.2 g of powder of supported catalyst (70-100mesh) was placed in the microreactor in a packed bed arrangement. Prior to catalyst evaluation, catalyst was activated in 10%H₂/N₂ (100cc(STP)/min) at 110°C for four hours. The flowrates of JP-8 fuel and water were adjusted such that a molar ratio of steam-to-carbon of 3 is achieved. The total feed flowrate (STP) was equivalent to a contact time of 25ms. The JP-8 fuel and water were vaporized, mixed, and preheated to the reaction temperature of 650 °C. As shown in Figure 2, an initial activity of >90% JP-8 conversion was achieved under the conditions studied. The continuous deactivation was due to the sulfur poisoning of catalyst.

Example 5

The catalyst, 13.8%-Rh/6%-MgO/Al₂O₃, was further evaluated with the steam reforming of sulfur-free synthetic fuel (a product of Fischer-Tropsch synthesis). The catalyst was synthesized using the similar procedure described in example 3, and was evaluated in a powdered form as described in example 4. The synthetic fuel contains paraffins with carbon numbers ranging from 6 to 22. The flow rates of synthetic fuel and water were

adjusted such that a steam to carbon ratio of 3 is reached. The total flowrate was adjusted such that contact times ranging from 50 to 100ms were achieved. Figure 11 shows the synthetic fuel conversion as functions of contact time and catalyst bed temperature. Synthetic fuel conversion increases with contact time and catalyst bed temperature. >90% conversion was achieved at 480°C and a contact time of 100ms.

Example 6

The catalyst described in Example 5 was also evaluated for isooctane steam reforming in a powdered form (catalyst B), and was compared with a second catalyst (4.9wt%Rh/ZrO₂, catalyst A). The testing procedures were identical to example 4. Catalyst A was prepared as follows: (1) calcining a high surface area ZrO₂ (obtained from Engelhard with a surface area of 80m²/g) at 500 °C for 5 hours; (2) impregnating the ZrO₂ with Rh₂O₃ with the incipient wetness technique from a rhodium nitrate solution; (3) followed by a final drying 110 °C for 4 hours and a (4) a final calcination at 500 °C for 3 hours to obtain a powder of the supported catalyst. Figure 12 shows the comparison of both catalysts A and B at a contact time of 25ms, steam to carbon ratio of 2, atmospheric pressure, and a catalyst bed temperature of 700°C. Surprisingly, it was discovered that the zirconia-supported catalyst was more active than the spinel-supported catalyst.

CLOSURE

While preferred embodiments of the present invention have been described, it will be apparent to those skilled in the art that many changes and modifications may be made without departing from the invention in its broader aspects. The appended claims are therefore intended to cover all such changes and modifications as fall within the true spirit and scope of the invention.

CLAIMS

We claim:

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1. A method of steam reforming, comprising:
passing steam and hydrocarbon through a reaction chamber;
wherein the reaction chamber comprises a spinel-containing catalyst that has
surface active sites comprising a material selected from the group consisting of rhodium,
10 iridium, nickel, palladium, platinum, ruthenium, carbide of group IVb and combinations
thereof;
wherein the rate of said passing steam and hydrocarbon is controlled such that
residence time in the reaction chamber is less than 0.1 seconds;
wherein the temperature in the reaction chamber is in the range of 500 °C to
15 1000 °C;
wherein, after passing through the reaction chamber, at least 60% of said hydrocarbon
has been converted to products.

2. The method of claim 1 wherein the hydrogen has been produced with a
20 selectivity of at least 60%.

3. The method of claim 2 wherein the surface active sites comprise
rhodium.

- 25 4. The method of claim 2 wherein the method has a hydrogen productivity of
at least $0.7 \text{ mmol}\cdot\text{s}^{-1}\cdot\text{cm}^{-3}$.

5. The method of claim 2 having a contact time of 10 to 25 milliseconds.

- 30 6. The method of claim 5 wherein said hydrocarbon comprises a $\text{C}_1\text{-C}_{10}$
alkane.

7. The method of claim 5 wherein said hydrocarbon comprises methane,
and at least 95% of said methane is converted to products with a hydrogen selectivity of
35 at least 95%.

8. A catalyst, comprising:
- (a) a first porous structure with a first pore surface area and a first pore size of at least about 0.1 μm ;
 - (b) a porous interfacial layer that comprises a spinel with a second pore surface area and a second pore size less than said first pore size, said porous interfacial layer having a thickness less than 4 mm disposed upon said porous structure;
 - (c) a steam reforming catalyst selected from the group consisting of rhodium, iridium, nickel, palladium, platinum, ruthenium, carbide of group IVb and combinations thereof disposed upon the second pore surface area.
9. The catalyst as recited in claim 8, wherein said carbide is selected from the group of tungsten carbide, molybdenum carbide and combinations thereof.
10. The catalyst of claim 8 wherein the porous support comprises a metal foam or felt.
11. The catalyst of claim 10 wherein the catalyst has a pore volume of 30-95%, and wherein at least 50% of the pore volume is in the range of 0.3 to 200 microns.
12. A catalyst comprising:
- an alumina layer;
 - a metal exposed on the surface of the catalyst;
 - a spinel layer disposed between the alumina layer and the metal;
 - wherein the spinel layer is in direct contact with the alumina layer; and
 - wherein the metal comprises a metal selected from the group consisting of: rhodium, iridium, nickel, platinum, palladium, and ruthenium.
13. The catalyst of claim 12 wherein the alumina layer comprises an alumina coating on a porous metal substrate.
14. The catalyst of claim 12 wherein the spinel layer is disposed between a magnesia layer and the alumina layer and said metal is disposed on the magnesia layer.
15. The catalyst of claim 12 wherein the catalyst does not show reduced hydrocarbon conversion after 1000 hours of steam reforming at a steam to carbon ratio of 3, a contact time of 20 msec, 120 psig, and 850°C.

16. The catalyst of claim 12 wherein the spinel layer has a surface area of 20-500 m²/g.
- 5 17. The catalyst of claim 12 wherein the spinel has the formula MgAl₂O₄.
18. The catalyst of claim 12 wherein the spinel layer has a thickness of less than 40 microns.
- 10 19. A method of steam reforming, comprising:
passing steam and hydrocarbon through a reaction chamber;
wherein the reaction chamber comprises a spinel-containing catalyst that has surface active sites comprising a material selected from the group consisting of rhodium, iridium, nickel, palladium, platinum, ruthenium, carbide of group VIb and combinations
15 thereof;
wherein the rate of said passing steam and hydrocarbon is controlled such that residence time in the reaction chamber is less than 0.1 seconds;
wherein the temperature in the reaction chamber is in the range of 500 °C to 1000 °C;
20 and wherein at least 0.5 mmol of hydrogen gas is produced per second per cubic centimeter of reaction chamber volume.
20. The method of claim 19 wherein hydrocarbon conversion is at least 50%.
- 25 21. The method of claim 20 wherein hydrogen selectivity is at least 50%.
22. The method of claim 21 wherein at least 0.7 mmol of hydrogen gas is produced per second per cubic centimeter of reaction chamber volume.
- 30 23. The method of claim 22 run at a temperature of 650-900 C.
24. The method of claim 23 wherein the hydrocarbon consists essentially of methane and wherein hydrocarbon conversion is at least 90% of equilibrium conversion.
- 35 25. The method of claim 24 wherein the contact time is in the range of 5 to 100 milliseconds.

26. The method of claim 23 wherein the contact time is less than 25 milliseconds and wherein hydrogen selectivity is at least 85%.

5 27. The method of claim 26 wherein 0.5 to 2 mmol of hydrogen gas is produced per second per cubic centimeter of reaction chamber volume.

28. The method of claim 22 wherein hydrocarbon conversion is at least 90%.

10 29. The method of claim 28 wherein hydrogen selectivity is at least 85%, and wherein there is no change in CO selectivity after 7 hours of continuous reaction.

30. A method of steam reforming, comprising:
passing steam and hydrocarbon through a reaction chamber;
15 wherein the reaction chamber comprises a spinel-containing catalyst that has surface active sites comprising a material selected from the group consisting of rhodium, iridium, nickel, palladium, platinum, ruthenium, carbide of group VIb and combinations thereof;

wherein the rate of said passing steam and hydrocarbon is controlled such that
20 residence time in the reaction chamber is less than 0.1 seconds;

wherein the temperature in the reaction chamber is in the range of 500 °C to 1000 °C;

wherein, after passing through the reaction chamber, at least 50% of said hydrocarbon has been converted to products.

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31. A method of steam reforming, comprising:
passing steam and hydrocarbon through a reaction chamber;
wherein the reaction chamber comprises a catalyst that has surface active sites comprising a material selected from the group consisting of rhodium, iridium, nickel,
30 palladium, platinum, ruthenium, carbide of group VIb and combinations thereof;

wherein the rate of said passing steam and hydrocarbon is controlled such that residence time in the reaction chamber is less than about 0.1 seconds;

wherein, after passing through the reaction chamber, the hydrocarbon conversion has reached at least 50% of equilibrium conversion.

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32. The method of claim 31 wherein the reaction chamber comprises a catalyst that has surface active sites comprising a material selected from the group consisting of rhodium, iridium, nickel, palladium, platinum, and combinations thereof; and

5 wherein at least 50% of said hydrocarbon has been converted to products after passing through the reaction chamber.

33. The method of claim 32 wherein the temperature in the reaction chamber is in the range of 500 °C to 1000 °C;

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34. The method of claim 32 wherein the catalyst comprises a spinel support.

35. The method of claim 31 wherein the catalyst comprises a zirconia support.

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36. The method of claim 31 wherein the catalyst comprises:
a first porous structure with a first pore surface area and a first pore size of at least 0.1 μm ; and

20 a porous interfacial layer with a second pore surface area and a second pore size that is less than the first pore size.

37. The method of claim 36 wherein the porous interfacial layer comprises a spinel.

25 38. The method of claim 36 wherein the first porous structure comprises a metal foam or metal felt, and the porous interfacial layer comprises alumina.

39. The method of claim 32 wherein the catalyst has a pore volume of 30 to 95% and at least 50% of the catalyst's pore volume is composed of pores in the size
30 range of 0.3 to 200 microns.

40. The method of claim 33 wherein the hydrocarbon is converted to at least 90% of equilibrium conversion and hydrogen selectivity is at least 85%.

35 41. The method of claim 40 wherein the catalyst comprises surface active sites comprising Rh.

42. A method of steam reforming, comprising:
passing steam and hydrocarbon through a reaction chamber;
wherein the reaction chamber comprises a catalyst;
5 wherein the catalyst comprises:
a first porous structure with a first pore surface area and a first pore size of at
least 0.1 μm ;
a porous interfacial layer with a second pore surface area and a second pore
size that is less than the first pore size; and
10 a catalyst metal.

43. The method of claim 42 wherein the rate of said passing steam and
hydrocarbon is controlled such that residence time in the reaction chamber is less than
about 0.1 seconds;
15 wherein, after passing through the reaction chamber, the hydrocarbon
conversion has reached at least 50% of equilibrium conversion.

44. The method of claim 43 wherein the catalyst that has surface active sites
comprising a material selected from the group consisting of rhodium, iridium, nickel,
20 palladium, platinum, and combinations thereof.

45. The method of claim 43 wherein the porous interfacial layer comprises a
material selected from the group consisting of alumina, spinel and zirconia.

25 46. A method of steam reforming, comprising:
passing steam and hydrocarbon through a reaction chamber;
wherein the reaction chamber comprises a catalyst;
wherein the catalyst comprises:
catalyst has a pore volume of 30 to 95% and at least 50% of the catalyst's pore
30 volume is composed of pores in the size range of 0.3 to 200 microns; and
a catalyst metal.

47. The method of claim 42 wherein the rate of said passing steam and
hydrocarbon is controlled such that contact time in the reaction chamber is in the range
35 of 5 to 100 milliseconds; and

wherein, after passing through the reaction chamber, the hydrocarbon conversion has reached at least 50% of equilibrium conversion.

48. The method of claim 46 wherein the catalyst has a hydrogen productivity
5 of at least $0.7 \text{ mmol} \cdot \text{s}^{-1} \cdot \text{cm}^{-3}$.

49. The method of claim 31 having a hydrogen productivity of between 0.5
and $2 \text{ mmol} \cdot \text{s}^{-1} \cdot \text{cm}^{-3}$ at a contact time of 10 to 25 msec.

10 50. The method of claim 31 wherein the hydrocarbon comprises a synthetic
fuel made by the Fischer-Tropsch process and wherein, after passing through the
reaction chamber, the hydrocarbon conversion has reached at least 70% of equilibrium
conversion.

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