WE CLAIM:

1. A method for making an epoxidation catalyst comprising a support, ~~at least one catalytic species~~silver, manganese and ~~at least one alkali metal and/or promoter~~greater than 35 ppm sodium, comprising:

~~I~~impregnating ~~at least a portion of the~~the support with manganese ~~in an impregnation step separate from the at least one alkali metal and/or promoter.~~prior to impregnating the support with sodium; and

~~I~~impregnating the support with silver prior to, at the same time as or after impregnation with manganese.

2. The method of claim 1, wherein the manganese is impregnated ~~with the at least one catalytic species~~into the support at the same time as at least a portion of the silver.

3. The method of claim 1, wherein the catalyst further comprises at least one alkali metal and/or promoter ~~comprises~~ in addition to sodium~~, cesium, lithium, sulfate or combinations of these~~ and manganese.

4. The method of claim ~~1~~3, wherein the at least one additional alkali metal and/or promoter comprises ~~sodium and is impregnated in a step separate from the manganese~~rhenium, cesium, sulfate or combinations thereof.

5. The method of claim 1, wherein the manganese comprises Mn-EDTA complex.

6. The method of claim ~~1~~4, wherein the at least one additional alkali metal and/or promoter comprises rhenium.

~~7. The method of claim 1, wherein the catalytic species comprises silver.~~

~~8. An epoxidation catalyst prepared according to the method of claim 1.~~

~~9. A method for the epoxidation of one or more alkylenes comprising contacting an oxygen source and an alkylene in the presence of an epoxidation catalyst prepared according to the method of claim 1.~~

~~10. The method of claim 8, wherein the alkylene comprises ethylene.~~

~~11. A method for making a 1,2-diol, a 1,2-diol ether, a 1,2-carbonate, or an alkanolamine comprising converting an alkylene oxide prepared according to the method of claim 6 into the 1,2-diol, a 1,2-diol ether, a 1,2-carbonate, or alkanolamine.~~

7. The method of claim 1, wherein the catalyst is exposed to an elevated temperature not exceeding 600°C between impregnating the support with manganese and impregnating the support with sodium.

8. The method of claim 7, wherein the elevated temperature does not exceed 400°C.

9. The method of claim 4, wherein the manganese and at least a portion of the silver are deposited in a first impregnation and the sodium, cesium, lithium, rhenium, sulfate and a second portion of silver are deposited in a second impregnation.

10. A method for making an epoxidation catalyst comprising a support, silver, manganese and greater than 35 ppm sodium, comprising:
impregnating the support with manganese separately from sodium and exposing the catalyst in between impregnations to an elevated temperature not exceeding 600°C.

11. The method of claim 10, wherein the elevated temperature does not exceed 400°C.

12. The method of claim 10, wherein the sodium is impregnated into the support at the same time as at least a portion of the silver prior to the impregnation of manganese.

13. The method of claim 12, wherein the sodium and silver are impregnated into the support at the same time as at least one other alkali metal and/or promoter.

14. The method of claim 10 or 13, wherein the manganese and at least a portion of the silver are impregnated into the support at the same time as at least one other alkali metal and/or promoter.

15. The method of claim 14, wherein the at least one other alkali metal and/or promoter comprises cesium, rhenium, sulfate or combinations thereof.