

METHODS FOR PRODUCING PYROLYSIS PRODUCTS

[0001] This Application claims the benefit of U.S. Provisional Application No. 61/341,452, filed March 31, 2010, which is hereby incorporated by reference herein in its entirety.

FIELD OF THE INVENTION

[0002] The present invention relates to methods for producing pyrolysis products. In particular, the present invention relates to methods for producing alcohol-containing pyrolysis products.

BACKGROUND OF THE INVENTION

[0003] In general, pyrolysis is a thermal degradation process in which large molecules are broken or cracked into smaller molecules in the presence of little if any oxygen. A wide variety of hydrocarbon materials can be pyrolyzed to produce vapor, liquid and solid materials into more readily useable forms. Pyrolysis should not be confused with other processes that use both heat and additional chemical reactivity to alter molecular structure, which processes usually take place in reactive (non-inert) atmospheres, *e.g.*, hydroprocessing/hydrotreatment in the presence of hydrogen-containing gas, sulfiding in the presence of a sulfur-containing gas, and the like.

[0004] Pyrolysis has been used to produce high viscosity tars from biomass materials for centuries. More recently, pyrolysis technology has been developed to increase yield and quality of vapor and liquid products.

[0005] U.S. Patent Application Publication No. 2009/0151253 discloses methods and systems to convert carbonaceous materials (such as biomass) into synthesis gas and other downstream products (such as alcohols). In certain embodiments, pyrolysis is performed in the presence of a catalyst such as heterogeneous catalysts (such as $\text{SiO}_2\text{-Al}_2\text{O}_3$, $\text{Pt/SiO}_2\text{-Al}_2\text{O}_3$, WO_x/ZrO_2 , SO_x/ZrO_2), zeolites (such as HY-zeolite, alpha-zeolite, HZSM-5, ZSM-5, or clinoptilolite), acid catalysts, clay catalysts (*e.g.*, acidified or activated clay catalysts), Al-MCM-41 type mesoporous catalysts,

activated alumina, CoMo catalysts (such as Criterion-534), and Ni/Al co-precipitated catalysts. In some embodiments, a cation such as K^+ , Li^+ , or Ca^{2+} can be used to increase the selectivity and yield of char and/or to lower the selectivity and yield of tar during pyrolysis.

[0006] U.S. Patent Application Publication No. 2009/0165378 discloses processes for fractional catalytic pyrolysis of biomass materials. The processes involve the use of a suitable catalyst in a fluidized bed pyrolysis system. The catalyst is H-ZSM-5, an aluminosilicate zeolite catalyst. Super acid catalysts, such as sulfated zirconia super acid catalysts, can also be used.

[0007] In spite of the advances in pyrolysis production, problems still exist with product quality, such as stability of the products produced, particularly in the case of pyrolysis liquid products produced from significant quantities of biomass materials. Over time, the viscosity of pyrolysis liquid products tends to increase as a result of polymerization reactions taking place. Heating the liquids (*i.e.*, the condensed pyrolysis liquids) accelerates the polymerization reactions, in particular the reaction between formaldehyde and phenol, which are typically present in appreciable quantities. This instability makes transportation and long term storage of pyrolysis liquids a challenge.

SUMMARY OF THE INVENTION

[0008] The present invention produces higher quality liquid products and higher quality condensable vapor products from a pyrolyzed feedstock. The pyrolysis products can be relatively easily recovered and are appreciably stable over a greater period of time, relative to current pyrolysis products.

[0009] One aspect of the invention relates to a method of producing an alcohol-containing pyrolysis product, comprising pyrolyzing a hydrocarbon feedstock in the presence of a basic metal oxide catalyst to produce a pyrolysis product that contains at least one alcohol, wherein the metal oxide catalyst is comprised of at least one metal from Group 2, Group 3 including Lanthanides and Actinides, and Group 4 of the Periodic Table of Elements.

[0010] Another aspect of the invention relates to a method of producing a pyrolysis product, comprising pyrolyzing a hydrocarbon feedstock in the presence of a basic metal oxide catalyst to produce a pyrolysis product, wherein the basic metal oxide catalyst has an uptake of carbon dioxide at 100°C of at least 0.03 mg/m² of the basic metal oxide catalyst.

DETAILED DESCRIPTION OF THE EMBODIMENTS

Introduction

[0011] The present invention provides pyrolysis products that have greater stability than pyrolysis products obtained from conventional pyrolysis production processes. The pyrolysis products provided by the processes of the present invention are generally lower in aldehyde concentration and higher in alcohol than pyrolysis products provided from conventional processing. Having a pyrolysis product that has lower aldehyde content and greater alcohol content can advantageously provide additional stability to the product, and can enable a wider variety of end uses and higher quality products.

[0012] The invention involves pyrolyzing a hydrocarbon feedstock in the presence of a basic metal oxide catalyst to produce a pyrolysis product. The terms “pyrolyze” and “pyrolyzing” are considered to be the act of converting a compound by pyrolysis. Pyrolysis is considered to be a chemical process in which a feed material is converted to one or more products by heat. By this definition, reactions that occur by heating in the presence of substantially reactive compounds (*e.g.*, oxygen, hydrogen, sulfur-containing gases, and the like, but not including catalysts) to cause any significant degree of reaction involving (*e.g.*, oxidation of) the feed material, such as by side reactions, are substantially excluded. The terms “thermolysis” or “thermal reaction” are considered to be synonyms for the term pyrolysis. According to the present invention, the term “torrefaction” is also considered as being within the definition of pyrolysis.

Feedstock

[0013] A wide range of feedstocks of various types, sizes, and moisture contents can be processed according to the present invention. Feedstocks that can be used in the present invention can comprise any hydrocarbon that can be thermally decomposed and/or transformed. Preferably, the feedstock comprises biomass, particularly biomass not typically processed or easily processable through chemical reactions. Particularly preferred feedstocks can be comprised of at least 10 wt%, for example at least 30 wt%, at least 50 wt%, at least 70 wt%, or at least 90 wt% biomass, based on total weight of feedstock that is processed or supplied to the thermal or pyrolysis reactor.

[0014] The term “biomass,” for the purposes of the present invention, is considered any material not derived from fossil/mineral resources and comprising carbon, hydrogen, and oxygen. Examples of biomass can include, but are not limited to, plant and plant-derived material, algae and algae-derived material, vegetation, agricultural waste, forestry waste, wood waste, paper waste, animal-derived waste, poultry-derived waste, municipal solid waste, cellulose and cellulose derivatives, carbohydrates or derivatives thereof, charcoal, and the like, and combinations thereof. The feedstock can also comprise pyrolyzable components other than biomass, such as fossil/mineral fuels (*e.g.*, coal, crude or refined petroleum feedstocks, and the like, as well as combinations thereof).

[0015] Additional or alternate examples of biomass that can be included as feedstock components include, but are not limited to, timber harvesting residues, softwood chips, hardwood chips, tree branches, tree stumps, leaves, bark, sawdust, off-spec paper pulp, corn, corn cob, corn stover, wheat straw, rice straw, sugarcane, bagasse, switchgrass, miscanthus, animal manure, municipal garbage, municipal sewage, commercial waste, grape pumice, almond shells, pecan shells, coconut shells, coffee grounds, grass pellets, hay pellets, wood pellets, cardboard, paper, plastic, cloth, and combinations thereof.

[0016] The biomass to be pyrolyzed may be ground prior to pyrolyzing. For example, the biomass can be ground in a mill until a desired particle size is achieved.

In one embodiment, the particle size of the biomass to be pyrolyzed can be sufficient (with or without grinding) to pass through a 30 mm screen, for example a 20 mm screen, a 10 mm screen, a 5 mm screen, or a 1 mm screen.

Catalyst

[0017] The catalyst of the present invention comprises, consists essentially of, or is a basic metal oxide catalyst. The basic metal oxide catalyst according to the present invention is an active metal oxide catalyst that includes at least one oxide of at least one metal that provides a metal oxide catalyst having a measurable uptake of carbon dioxide upon heating. The basic metal oxide catalyst of the present invention is particularly advantageous, in that it can be used in the production of a pyrolysis product that is higher in quality and more highly stable than typical pyrolysis products.

[0018] In one embodiment of the invention, the basic metal oxide catalyst has an uptake of carbon dioxide at 100°C of at least 0.03 mg/m² of the metal oxide catalyst, for example at least 0.04 mg/m², at least 0.05 mg/m², at least 0.06 mg/m², or at least 0.08 mg/m². Although the upper limit on the carbon dioxide uptake is not critical, in general the metal oxide catalysts useful herein will have a carbon dioxide uptake at 100°C of not greater than 10 mg/m² of the metal oxide catalyst, for example not greater than 5 mg/m², not greater than 3 mg/m², not greater than 2 mg/m², or not greater than 1 mg/m². Typically, the metal oxide catalysts useful herein have a carbon dioxide uptake from 0.05 mg/m² to 1 mg/m² of the metal oxide catalyst. The metal oxide catalysts can have a particular benefit in ultimately providing relatively high quality liquid pyrolysis products or pyrolysis oils, particularly liquid products having a substantial quantity of alcohol components (*e.g.*, at a level relatively higher than conventional pyrolysis products/oils).

[0019] In order to determine the carbon dioxide uptake of a metal oxide catalyst according to the present invention, the following procedure is to be followed. A sample of the metal oxide catalyst is dehydrated by heating the sample to about 200°C to about 500°C in flowing air until a constant weight, the “dry weight,” is obtained.

The temperature of the sample is then reduced to about 100°C, and carbon dioxide is passed over the sample, either continuously or in pulses, again until constant weight is obtained. The increase in weight of the sample in terms of mg/mg of the sample based on the dry weight of the sample is the amount of adsorbed carbon dioxide.

[0020] The carbon dioxide adsorption can be measured using a Mettler TGA/SDTA 851 thermogravimetric analysis system under ambient pressure. The metal oxide catalyst sample can be dehydrated in flowing air to about 500°C for about one hour. The temperature of the sample can then be reduced in flowing inert gas (*e.g.*, helium) to the desired adsorption temperature, *e.g.*, in this case about 100°C. After the sample has equilibrated at the desired adsorption temperature in the inert gas, the sample can be subjected to about 20 separate pulses (*e.g.*, about 12 seconds per pulse) of a gaseous mixture comprising CO₂ (*e.g.*, the gaseous mixture can comprise about 10 wt% carbon dioxide with the remainder being an inert gas such as helium). After each pulse of the adsorbing gas, the metal oxide catalyst sample can be flushed with flowing inert gas (*e.g.*, helium) for about 3 minutes. The increase in weight of the sample in terms of mg/mg adsorbent based on the adsorbent weight after treatment at about 500°C represents the amount of adsorbed carbon dioxide. The surface area of the sample can be measured in accordance with the method of Brunauer, Emmett, and Teller (BET), published as ASTM D 3663, to provide the carbon dioxide uptake in terms of mg carbon dioxide/m² of the metal oxide catalyst. Specific examples of how to determine carbon dioxide adsorption, including a further description of certain preferred catalysts useful according to the present invention, are further described, *e.g.*, in U.S. Patent Nos. 6,844,291 and 6,995,111, the contents of each of which are incorporated herein by reference.

[0021] The basic metal oxide catalyst can be comprised of oxides of at least one metal from Group 2, Group 3 (including Lanthanides and Actinides), and Group 4 of the Periodic Table of Elements (New IUPAC Notation). In one embodiment, the basic metal oxide catalyst includes at least one Group 2 metal. In another embodiment, the basic metal oxide catalyst includes at least one Group 3 metal. In another embodiment, the basic metal oxide catalyst includes at least one Group 4

metal. In another embodiment, the basic metal oxide catalyst includes at least one Lanthanide. In another embodiment, the basic metal oxide catalyst includes at least one Actinide.

[0022] The basic metal oxide catalyst can also be comprised of more than one oxide of different metal components. Examples of more than one oxide of different metal components can include, but are not limited to, oxides of at least one Group 2 metal and at least one Group 3 metal (including Lanthanides and Actinides); oxides of at least one Group 3 metal (including Lanthanides and Actinides), and at least one Group 4 metal; and oxides of at least one Group 2 metal and at least one Group 4 metal.

[0023] A basic metal oxide catalyst according to the present invention can preferably be comprised of, or can consist essentially of (with a non-catalytic binder, such as silica and/or alumina or the like, being the remainder of the composition), about 1 wt% to 100 wt%, based on total weight of the catalyst, of an oxide of at least one metal that provides a metal oxide catalyst having a measurable uptake of carbon dioxide upon heating. In a particular embodiment, the basic metal oxide catalyst according to the present invention can be comprised of or can consist essentially of 1 wt% to 90 wt%, for example 1 wt% to 70 wt%, 1 wt% to 50 wt%, or 1 wt% to 30 wt% of an oxide of the at least one metal, based on total weight of the catalyst, such that the catalyst has a measurable uptake of carbon dioxide upon heating. In this embodiment, the remainder of the composition can be comprised of a binder that is non-catalytic for the pyrolysis process, which can include, but is not necessarily limited to, silica, alumina, silica-alumina, molecular sieves, small-pore zeolites, or the like, or a combination thereof.

[0024] The basic metal oxide catalyst is preferably in particle form and can preferably have an average particle diameter from 0.01 μm to 500 μm , for example from 0.05 μm to 300 μm or from 0.1 μm to 100 μm .

[0025] In one embodiment, the basic metal oxide catalyst can have a BET surface area of greater than 10 m^2/g , such as from above 10 m^2/g to about 300 m^2/g . Additionally or alternately, the basic metal oxide catalyst can have a BET surface area

greater than 20 m²/g, such as from above 20 m²/g to 250 m²/g. Further additionally or alternately, the basic metal oxide catalyst can have a BET surface area greater than 25 m²/g, such as from above 25 m²/g to 200 m²/g.

[0026] Group 2 metals that can be included as an oxide component in the catalyst of the present invention are beryllium, magnesium, calcium, strontium, barium, radium, and combinations thereof. Examples of preferred oxides containing at least one Group 2 metal include, but are not limited to, one or more of magnesium oxides, calcium oxides, and hydrotalcite (Mg₆Al₂(CO₃)(OH)₁₆•4H₂O), which can, in one embodiment, be calcined to form a basic magnesium aluminum oxide catalyst, representing a Group 2 metal oxide catalyst of the present invention.

[0027] Group 3 metals (including Lanthanides and Actinides) that are naturally occurring and can be included as an oxide component in the catalyst of the present invention are scandium, yttrium, lanthanum, actinium, cerium, praseodymium, neodymium, samarium, europium, gadolinium, terbium, dysprosium, holmium, erbium, thulium, ytterbium, lutetium, thorium, protactinium, and uranium. Examples of preferred Group 3 metals include, but are not limited to, yttrium, cerium, praseodymium, and combinations thereof.

[0028] Group 4 metals that can be included as an oxide component in the catalyst of the present invention are titanium, zirconium, and hafnium. One example of a preferred Group 4 metal includes zirconium.

[0029] The basic metal oxide catalyst can be prepared using a variety of methods. The basic metal oxide catalyst can be made from active metal oxide precursors, such as metal salts or preferably Group 2, Group 3, and/or Group 4 metal salts/precursors. Other suitable sources of the metal oxide(s) can include compounds that form these metal oxides during calcination, *e.g.*, oxychlorides, nitrates, and the like. A further suitable source of the basic metal oxides can include salts containing a cation of the Group 2, Group 3 or Group 4 metal(s), *e.g.*, metal halides, oxyhalides, nitrates, sulfates, alkoxides, acetates, and the like. *See, e.g.*, U.S. Patent Nos. 6,844,291; 6,995,111; 7,199,278; and 7,411,106, the contents of which are hereby incorporated by reference.

[0030] In one embodiment, the basic or active metal oxide can be hydrothermally treated under conditions that include a temperature of at least 80°C, preferably at least 100°C. The hydrothermal treatment may take place in a sealed vessel at greater than atmospheric pressure. However, a preferred mode of treatment involves the use of an open vessel under reflux conditions. Without being bound by theory, it is believed that agitation of the metal oxide in a liquid medium, for example, by the action of refluxing liquid and/or stirring, can promote effective interaction of the oxide with the liquid medium. The duration of the contact of the oxide with the liquid medium (*i.e.*, in batch processes) can preferably be at least 1 hour, for example at least 8 hours. The liquid medium for this treatment can have a pH of about 6 or greater, preferably about 7 or greater, *e.g.*, about 8 or greater. Non-limiting examples of suitable liquid media include water, hydroxide solutions (including hydroxides of NH_4^+ , Na^+ , K^+ , Mg^{2+} , Ca^{2+} , and the like, and combinations thereof), carbonate and/or bicarbonate solutions (including carbonates and/or bicarbonates of NH_4^+ , Na^+ , K^+ , Mg^{2+} , Ca^{2+} , and the like, and combinations thereof), pyridine and its derivatives, alkyl/hydroxyl amines, and the like, and combinations thereof.

[0031] In another embodiment, the basic or active metal oxide can be prepared by subjecting a liquid solution, such as an aqueous solution, comprising a source of ions of the metal, such as a metal salt, to conditions sufficient to cause precipitation of a hydrated precursor to the solid oxide material, such as by the addition of a precipitating reagent to the solution. Conveniently, the precipitation can be conducted at a pH above 7. For example, the precipitating agent can be a base such as sodium hydroxide or ammonium hydroxide.

[0032] The temperature at which the liquid medium is maintained during the precipitation can generally be less than about 200°C, for example in the range from about 0°C to about 200°C or from about 20°C to about 100°C. The resulting gel can then be hydrothermally treated at temperatures of at least 80°C, preferably at least 100°C. The hydrothermal treatment can typically take place in a vessel at atmospheric pressure. The gel, in one embodiment, can be hydrothermally treated for up to 10 days, for example up to 5 days or up to 3 days.

[0033] The hydrated precursor to the basic or active metal oxide can then be recovered, for example by filtration or centrifugation, and washed and dried. The resulting material can preferably be calcined, for instance in an oxidizing atmosphere at a temperature of at least 400°C, for example of at least 500°C, from about 600°C to about 900°C, or from about 650°C to about 800°C, to form a solid oxide material. The calcination time can typically be up to 48 hours, for example from about 0.5 hours to about 24 hours or from about 1 hour to about 10 hours. In a particular embodiment, batch-wise calcination can be carried out at a temperature of about 700°C for about 1 hour to about 3 hours.

[0034] In one method, the basic or active metal oxide can be prepared by the thermal decomposition of metal-containing compounds at relatively high temperatures. Non-limiting examples of such metal-containing compounds can include magnesium and/or barium oxalates, which can be thermally decomposed at temperatures of up to 600°C in flowing air. Thus, prepared metal oxides can usually have relatively lower BET surface area, *e.g.*, less than 30 m²/g.

[0035] In another method, the basic or active metal oxide can be prepared by hydrolysis of metal-containing compounds followed by dehydration and calcination. As a non-limiting or preferred example, MgO can be hydroxylated by mixing with deionized water, thus forming a white slurry. The slurry can slowly be heated to dryness on a heating plate to form a white powder. The white powder can further be dried in a vacuum oven at about 100°C for at least 4 hours, for example up to 12 hours. The dried white powder can then be calcined (*e.g.*, in air) at a temperature of at least 400°C, for example up to 550°C or up to 500°C. Thus-prepared active metal oxides can generally exhibit higher BET surface area (*e.g.*, from about 30 m²/g to about 300 m²/g) than those prepared by thermal decomposition of the active metal oxide precursors.

[0036] In yet another method, the basic or active metal oxide can be prepared by the so-called aerogel method (*see* Koper, O. B., Lagadic, I., Volodin, A. and Klabunde, K., *J. Chem. Mater.*, 1997, 9, 2468-2480). As one example of this method, Mg powder can be reacted under inert (nitrogen) purge with anhydrous methanol to

form $\text{Mg}(\text{OCH}_3)_2$ solution in methanol. The resultant $\text{Mg}(\text{OCH}_3)_2$ solution can be added to toluene. Water can then be added dropwise to the $\text{Mg}(\text{OH})_2$ solution in methanol-toluene, *e.g.*, under vigorous stirring. The resultant colloidal suspension of $\text{Mg}(\text{OH})_2$ can be placed in an autoclave, *e.g.*, pressurized to about 100 psig (about 690 kPag) with dry nitrogen, and can be heated slowly to a final pressure of about 1000 psig (about 6.9 MPag). The (supercritical) solvent can be vented to produce a fine white powder of substantially $\text{Mg}(\text{OH})_2$. Nanocrystalline MgO can be obtained by heating the fine white powder at about 400°C under vacuum. Active metal oxides prepared by this method can tend to have the highest BET surface area, generally at least about $300 \text{ m}^2/\text{g}$.

[0037] In one embodiment, where the basic or active metal oxide(s) used herein can comprise, or can consist essentially of, two or more oxides selected from Groups 2, 3, and 4 (*i.e.*, a mixed metal oxide, or MMO), the mixed metal oxide may be prepared by impregnation of a precursor to a second oxide onto a preformed oxide. In an alternate embodiment, the first formed oxide may be hydrothermally treated prior to impregnation. For example, a Group 3/Group 4 mixed metal oxide can be prepared by impregnating a hydrothermally treated hydrated oxide of the Group 4 metal with an aqueous solution containing an ion of the Group 3 metal, followed by drying. The resulting material can then be calcined, preferably in an oxidizing atmosphere, *e.g.*, at a temperature of at least about 400°C , for example at least about 500°C , from about 600°C to about 900°C , or from about 650°C to about 800°C . The calcination time may be up to 48 hours, for example from about 0.5 hours to about 24 hours or from about 1 hour to about 10 hours. In a particular embodiment, batch-wise calcination can be carried out at a temperature of about 700°C for about 1 hour to about 3 hours.

[0038] In yet another embodiment, where the basic or active metal oxide(s) used herein can comprise, or can consist essentially of, a mixed metal oxide, it may be prepared by combining a first liquid solution comprising a source of at least one of the Group 2, 3, or 4 metals with a second liquid solution comprising a source of an ion of at least one other Group 2, 3, or 4 metal. This combination of two solutions can take place under conditions sufficient to cause co-precipitation of a hydrated precursor to

the mixed oxide material as a solid from the liquid medium. Alternately, the sources of the all the anions of the Group 2, 3, and/or 4 metal oxides may be combined in a single solution. This solution may then be subjected to conditions sufficient to cause co-precipitation of the hydrated precursor to the solid mixed oxide material, such as by the addition of a precipitating reagent to the solution. For example, the precipitating agent(s) can preferably comprise (or be) a base, such as sodium or ammonium hydroxide. Water is typically a preferred solvent for these solutions.

[0039] The temperature at which the liquid medium(s) is maintained during the precipitation or co-precipitation can typically be less than about 200°C, for example from about 0°C to about 200°C. A particular range of temperatures for co-precipitation can be from about 20°C to about 100°C. The resulting gel can preferably then be hydrothermally treated at a temperature of at least about 80°C, for example at least about 100°C. The hydrothermal treatment can typically take place in a sealed vessel, *e.g.*, at greater than atmospheric pressure. The gel, in one embodiment, can be hydrothermally treated for up to about 10 days, for example up to about 5 days or up to about 3 days.

[0040] The hydrated precursor to the basic metal oxide(s) can then be recovered, for example by filtration or centrifugation, and washed and dried. The resulting material can preferably be calcined, for instance in an oxidizing atmosphere at a temperature of at least 400°C, for example of at least 500°C, from about 600°C to about 900°C, or from about 650°C to about 800°C, to form a solid oxide material. The calcination time can typically be up to 48 hours, for example from about 0.5 hours to about 24 hours or from about 1 hour to about 10 hours. In a particular embodiment, batch-wise calcination can be carried out at a temperature of about 700°C for about 1 hour to about 3 hours.

[0041] In one embodiment of the invention, the basic metal oxide catalyst can be comprised of hydrotalcite or a calcined hydrotalcite. The hydrotalcite can be a naturally occurring hydrotalcite or a synthetically produced hydrotalcite, such as described in U.S. Patent No. 6,951,830.

[0042] Naturally occurring hydrotalcite is a mineral found in relatively small quantities in a limited number of geographical areas, principally in Norway and in the Ural Mountains. Natural hydrotalcite has a variable composition depending on the location of the source. Natural hydrotalcite is a hydrated magnesium-, aluminum-, and carbonate- containing composition, which has been found to have a representative composition of $(\text{Mg}_6\text{Al}_2(\text{CO}_3)(\text{OH})_{16} \bullet 4\text{H}_2\text{O})$. Natural hydrotalcite deposits are generally found intermeshed with spinel and other minerals, such as penninite and/or muscovite, from which it is difficult to separate the natural hydrotalcite.

[0043] Synthetically produced hydrotalcite can be made to have the same composition as natural hydrotalcite, or, due to flexibility in the synthesis, it can be made to have a different composition by replacing the carbonate anion with other anions, *e.g.*, a phosphate ion. In addition, the Mg/Al ratio can be varied to control the basic properties of the hydrotalcite.

[0044] A phosphate-modified synthetic hydrotalcite can also be used. Methods of making such compositions are described in U.S. Patent No. 4,883,533. Other types of hydrotalcites can also be used, such as those described in U.S. Patent Nos. 3,539,306; 4,656,156; and 4,904,457.

[0045] Hydrotalcite compositions containing pillaring organic, inorganic, and mixed organic/inorganic anions can also be used. Such materials are described in greater details in U.S. Patent No. 4,774,212. The compositions are anionic magnesium/aluminum hydrotalcite clays having large inorganic and/or organic anions located interstitially between positively charged layers of metal hydroxides of the general formula $[\text{Mg}_{2x}\text{Al}_2(\text{OH})_{4x+4}]\text{Y}_{2/n}^n \bullet \text{ZH}_2\text{O}$, where Y can be a relatively large organic anion, *e.g.*, selected from the group consisting of lauryl sulfate, p-toluenesulfonate, terephthalate, 2,5-dihydroxy-1,4-benzenedisulfonate, and 1,5-naphthalenedisulfonate, or where Y can be an anionic polyoxometalate of vanadium, tungsten, or molybdenum. In the above cases, x can be from 1.5 to 2.5, n can be 1 or 2, and Z can be from 0 to 3, except that, when Y is the polyoxometalate, n can be 6.

[0046] An aggregated synthetic hydrotalcite can also be used. Preferably, the aggregated synthetic hydrotalcite can have a substantially spheroidal shape and an

average spherical diameter of up to about 60 μm . Such a composition is described in greater detail in U.S. Patent No. 5,364,828. This form of hydrotalcite can preferably be prepared from aqueous solutions of soluble magnesium and aluminum salts, which can be mixed in a molar ratio from about 2.5:1 to about 4:1, together with a basic solution containing at least a two-fold excess of carbonate and a sufficient amount of a base to maintain a pH of the reaction mixture in the range from about 8.5 to about 9.5.

[0047] Some synthetic hydrotalcites are commercially available, for example from Sasol North America Inc., such as under the tradename Condea Pural MG70.

[0048] Prior to use according to the process of the invention, it may be desirable to calcine the hydrotalcite to remove at least a portion of the water inherently contained in the material. Suitable calcination conditions can include, but are not limited to, a temperature from about 300°C to about 800°C, for example from about 400°C to about 600°C, for a calcination time from about 1 hour to about 16 hours, for example from about 3 hours to about 8 hours.

[0049] According to the present invention, the production of pyrolysis products can be achieved in the presence of the basic metal oxide catalyst of the present invention. The basic metal oxide catalyst can optionally act to absorb heat, as well as carry out catalytic activity. Additional heat absorbing material can be used, if desired, along with the basic metal oxide catalyst in the pyrolysis process. For example, solid heat absorbing material can be added to a pyrolysis reactor along with the basic metal oxide catalyst. The solid heat absorbing material can be any solid capable of absorbing heat and does not adversely affect the ability of the basic metal oxide to catalyze conversion, *e.g.*, of aldehydes to alcohols. Examples of solid heat absorbing material that can be used along with the basic metal oxide can include, but are not limited to, inert clays, glass materials, sand, char, and the like, and combinations thereof.

[0050] In one embodiment of the invention, solid heat absorbing material used in the pyrolysis reactor to carry out the pyrolysis process can be solely (about 100 wt% of) the basic metal oxide catalyst. In another embodiment, pyrolysis product can be produced by pyrolyzing feedstock in the presence of solid heat absorbing material

containing from 1 wt% to below 100 wt% basic metal oxide, based on total weight of solid heat absorbing material provided to the pyrolysis reactor in which the pyrolysis process is carried out. In this embodiment, pyrolysis product can be produced by pyrolyzing feedstock in the presence of solid heat absorbing material containing from 1 wt% to 99 wt%, for example from 1 wt% to 90 wt%, from 1 wt% to 70 wt%, from 1 wt% to 50 wt%, from 1 wt% to 30 wt%, or from 1 wt% to 20 wt%, of basic metal oxide, based on total weight of solid heat absorbing material provided to the pyrolysis reactor in which the pyrolysis process is carried out.

[0051] In a particular embodiment of the invention, the total amount of solid heat absorbing material used in the pyrolysis reactor to carry out the pyrolysis process can contain not greater than 99 wt% of solid heat absorbing material other than the basic metal oxide catalyst, with the remainder being the basic metal oxide catalyst. In another embodiment, the total amount of solid heat absorbing material used in the pyrolysis reactor to carry out the pyrolysis process can contain not greater than 95 wt%, for example not greater than 90 wt%, not greater than 80 wt%, not greater than 70 wt %, not greater than 60 wt%, or not greater than 50 wt%, of solid heat absorbing material other than the basic metal oxide catalyst, with the remainder being the basic metal oxide catalyst.

Process Conditions

[0052] Pyrolysis can preferably be carried out in the presence of little to no oxygen. If oxygen is present, it should be present in an amount less than the stoichiometric amount required for complete combustion. Preferably, pyrolysis can be carried out in an environment (*e.g.*, in the pyrolysis reactor) having an oxygen content of less than 40%, for example less than 30%, less than 20%, less than 10%, less than 5%, less than 1%, less than 0.5%, or less than 0.01% of the stoichiometric amount of oxygen required for complete combustion of the feedstock. In another preferred embodiment, pyrolysis can be carried out in the absence of any added oxygen (in which case oxygen may be present in trace amounts, but no oxygen is deliberately added).

[0053] Preferred pyrolysis conditions are typically those that minimize non-condensable gas formation and solid or char formation. Preferred conditions are also typically those that lead to condensable gas and liquid formation. *See, e.g.*, Czernik and Bridgwater, *Energy & Fuels*, 18:590-598, 2004; *see also* Mohan et al., *Energy & Fuels*, 20:848-889, 2006).

[0054] In one embodiment, pyrolyzed product can exit the pyrolysis reactor in the vapor phase. Preferably, the vapor phase can be passed through a filter to separate any solids from the more desirable product. The filtered vapors can then be condensed to form one or more liquid products.

[0055] Condensation can be carried out using any equipment suitable for such purpose. For example, condensation can be carried out using a condensation train to collect the desired products. The condensation train can comprise at least one chilled water condenser, at least one electrostatic precipitator, or at least one coalescence filter, as well as combinations thereof.

[0056] The pyrolysis temperature should be sufficiently high to convert a sufficient quantity of feed to desired product, but not so high to produce undesired quantities of non-condensable gas or undesired solid. Preferably, feed can be pyrolyzed at a temperature from 200°C to 600°C, for example from 300°C to 600°C or from 400°C to 500°C.

[0057] The pyrolysis pressure should be within a range that minimizes formation of non-condensable gas and solid product. The pressure can range from about 0 psig (about 0 kPag) to about 1000 psig (about 6.9 MPag), preferably from about 5 psig (about 35 kPag) to about 500 psig (about 3.5 MPag) or from about 10 psig (about 69 kPag) to about 200 psig (about 1.4 MPag).

[0058] Pyrolysis should generally be carried out for a time that enables a substantial quantity of feed to be converted into condensable vapor and/or liquid products. This can range over a wide period of time, depending upon pressure, temperature, and type of reactor used, *inter alia*. For example, pyrolysis can be carried out for a time from 0.1 second to 48 hours, for example from 0.1 second to 24 hours or from 0.1 second to 1 hour. Shorter times are generally more preferred, such

as from 0.1 second to 1 minute or from 0.1 second to 10 seconds. Thus, in some embodiments, fast pyrolysis can be used. Fast pyrolysis is a high-temperature process in which feedstock is rapidly heated. In some embodiments, the feedstock can be heated in the absence of oxygen. The feedstock can advantageously decompose to generate predominantly vapor and solid (char) products/by-products. The vapor product can preferably be cooled and condensed to form one or more liquid products. Multiple steps of heating and cooling can be carried out to produce intermediate pyrolysis liquid products. Fast pyrolysis processes can typically produce from about 60 wt% to about 75 wt% condensable gas and liquid products, from about 15 wt% to about 25 wt% solid char, and from about 10 wt% to about 20 wt% non-condensable gas products, but these relative numbers can depend heavily on the particular feedstock composition.

[0059] Slow pyrolysis can also be used. In slow pyrolysis, the feedstock can preferably be heated to not greater than about 600°C for a time period ranging from 1 minute to 24 hours, preferably from 1 minute to 1 hour. Vapor product typically does not escape as rapidly in slow pyrolysis as in fast pyrolysis. Thus, vapor products may react with each other as solid char and liquid are being formed. Rates of heating in slow pyrolysis can typically be slower than in fast pyrolysis. A feedstock can be held at constant temperature or slowly heated. Vapors can be continuously removed as they are formed.

[0060] Vacuum pyrolysis can additionally or alternately be used. In vacuum pyrolysis, the feedstock is maintained at less than atmospheric pressure (*i.e.*, below 0 psig or 0 kPag, but above 0 psia or 0 kPaa). Vacuum conditions can be used to decrease the boiling point, to avoid adverse chemical reactions, and to reduce the heating duty by using relatively lower temperatures.

[0061] Pyrolysis product can contain water. As an example, condensed pyrolysis product can contain from 10 wt% to 30 wt% water. If desired, the water can be removed using any appropriate means, such as by flashing, decanting, distillation, membrane separation, or the like, or any combination thereof.

Reactor Type

[0062] Any reactor suitable for pyrolyzing feedstock can be used in the process of the present invention. Examples of reactors can include, but are not limited to, auger reactors, ablative reactors, rotating cones, fluidized-bed reactors (*e.g.*, circulating fluidized-bed reactors), entrained-flow reactors, vacuum moving-bed reactors, transport-bed reactors, fixed-bed reactors, microwave-assisted pyrolysis reactors, and the like, and combinations thereof in series and/or in parallel.

[0063] In auger type reactors, feedstock and heat absorbing material (*i.e.*, basic metal oxide, including any other solid heat absorbing material that may be used) can be fed at one end of a screw. The screw can mix the heat absorbing material and feedstock for conveying them through the reactor.

[0064] In an ablative process, feedstock can be contacted against a heated metal surface. In general, the metal surface can spin at a relatively high speed within a bed of feedstock, which can prevent dilution of the products. As an alternative, the feedstock particles may be suspended in a carrier gas and introduced at a relatively high speed, *e.g.*, through a cyclone. In one such embodiment, the walls of the cyclone can be heated. Also in such embodiment, the products are typically diluted with the carrier gas.

[0065] In a rotating cone reactor, feed and solid heat absorbing material (*e.g.*, basic metal oxide catalyst, optionally including sand) can be introduced into a rotating cone. As the cone is rotated, the solid heat absorbing material can be transported across the cone surface by centrifugal force. Like other shallow transport bed reactors, relatively fine particles can be used to obtain greater liquid yield.

[0066] In fluidized bed reactors, feedstock can be introduced into a bed of solid heat absorbing material (*e.g.*, basic metal oxide catalyst, optionally including sand) by a gas, which can usually comprise a recirculated product gas. High heat transfer rates from the fluidized, solid heat absorbing material can result in relatively rapid heating of the feedstock.

[0067] In circulating fluidized bed reactors, feedstock can be introduced into the reactor to contact a circulating fluidized bed of solid heat absorbing material (*e.g.*,

basic metal oxide catalyst, optionally including sand). Gas, solid heat absorbing material, and feedstock typically all move together. Examples of transport gases can include, but are not limited to, recirculated product gases, combustion gases, relatively inert gases, and the like, and combinations thereof. High heat-transfer rates from the solid heat absorbing material can ensure relatively rapid heating of the feedstock. A separator system can separate product vapor from the solid heat absorbing material and any remaining char particles. The solid heat absorbing particles can preferably be reheated in a fluidized burner vessel and recycled to the reactor.

Product and Use

[0068] As pyrolysis products leave the reactor, they can be in the form of vapor, liquid, and/or solid. A substantial portion of the vapor can preferably be a condensable vapor, *e.g.*, a condensable C_3^+ hydrocarbon. In a preferred embodiment, a substantial portion of the vapor exiting the reactor can be condensed to form a fuel or pyrolysis oil. These various products can be isolated by way of a condenser system. The products can be used as fuels and/or as a variety of chemicals.

[0069] The pyrolysis product of the present invention can be particularly higher in alcohol content than the product produced from the same feedstock pyrolyzed in the absence of a basic metal oxide of the present invention. The total alcohol content can be heavily dependent on the feedstock used and the pyrolyzing conditions employed. In one embodiment, the pyrolysis product can be comprised of at least 1 wt% more alcohol, preferably at least 2 wt% more alcohol, for example at least 4 wt% more alcohol or at least 6 wt% more alcohol, based on total weight of pyrolysis product, than the product produced from the same feedstock pyrolyzed in the absence of a basic metal oxide as described herein.

[0070] The pyrolysis product according to the invention can be particularly high in alcohol content. In one embodiment, the pyrolysis product can be comprised of at least 2 wt% alcohol, preferably at least 4 wt%, for example at least 6 wt% alcohol or at least 8 wt % alcohol, based on total weight of pyrolysis product.

[0071] In a preferred embodiment, the pyrolysis product can comprise from 1 wt% to 50 wt% alcohol, for example from 2 wt% to 25 wt% alcohol or from 5 wt% to 20 wt% alcohol, based on total weight of pyrolysis product produced.

[0072] The pyrolysis product according to the invention can include any one or more of a wide variety of alcohols. In general, the pyrolysis product can comprise at least one C₁-C₁₀ alcohol. Exemplary alcohols can include aliphatic, unsaturated, aromatic, linear, branched, and/or cyclic mono-alcohols, diols, triols, and the like, and combinations thereof. Examples of mono-alcohols can include, but are not necessarily limited to, methanol, ethanol, n-propanol, isopropanol, n-butanol, tert-butanol, isobutanol, and the like, and combinations thereof. Examples of diols can include, but are not necessarily limited to, ethylene diol, 1,3-propylene diol, 1,2-propylene diol, 1,4-butanediol, and the like, and combinations thereof. Examples of triols can include, but are not necessarily limited to, glycerol and the like.

[0073] The pyrolysis product can also advantageously be relatively low in aldehyde content. Preferably, the pyrolysis product can comprise not greater than 20 wt%, for example not greater than 15 wt%, not greater than 10 wt%, or not greater than 5 wt% aldehyde, based on total weight of pyrolysis product.

[0074] Preferably, at least a portion of the pyrolysis product produced according to the present invention can be condensed to form a liquid product. The liquid product can advantageously be relatively low in moisture content, relatively low in viscosity, and/or less acidic and corrosive than conventional liquid pyrolysis products.

[0075] Any number of chemical compounds can be included in the liquid portion of the recovered pyrolysis product. Typically, this recovered liquid product is called a pyrolysis oil. The oil can include one or more of various phenols, cresols, catechols, guaiacol, methyl-substituted phenols, indene, substituted naphthalene, and/or other aromatics.

[0076] Char or coke type solids can remain in the reactor or can be filtered from recovered vapor and liquid pyrolysis product portions. In one embodiment, a substantial portion of the products can be steam reformed or partially oxidized to form a synthesis gas or a hydrogen-rich gas.

[0077] Overall, potential pyrolysis products may have applications as fuels, adhesives, synthesis gas, phenol formaldehyde resins, phosphate esters, magnetic wire, cleaning and disinfectant compounds, ore floatation, and other applications. The pyrolysis products produced according to the present invention can advantageously be suitable for use in other applications without the need for extensive secondary processing steps.

[0078] In one embodiment of the invention, at least a portion of the pyrolysis product can be hydroprocessed to provide various fuels and chemicals. Hydroprocessing refers to processes or treatments in which at least a portion of the pyrolysis product can be reacted with hydrogen, typically under pressure and in the presence of a hydroprocessing catalyst. Such processes can include, but are not limited to, hydrodeoxygenation, hydrodenitrogenation, hydrodesulfurization, hydrotreating, hydrocracking, hydroisomerization, hydrodewaxing, and the like. For examples of such processes, see U.S. Patent Nos. 7,513,989, 7,435,335, 7,288,182, 7,288,181, 7,244,352 and 7,220,352. Examples of hydroprocessing can include, but are not limited to, conversion of oxygen-containing hydrocarbons to paraffins.

[0079] Additionally or alternately, the present invention can further include the following embodiments.

[0080] Embodiment 1. A method of producing an alcohol-containing pyrolysis product, comprising pyrolyzing a hydrocarbon feedstock in the presence of a basic metal oxide catalyst to produce a pyrolysis product that contains at least one alcohol, wherein the metal oxide catalyst is comprised of at least one metal from Group 2, Group 3 including Lanthanides and Actinides, and Group 4 of the Periodic Table of Elements.

[0081] Embodiment 2. The method of embodiment 1, wherein the basic metal oxide catalyst has an uptake of carbon dioxide at 100°C of at least 0.03 mg/m² of the metal oxide catalyst.

[0082] Embodiment 3. A method of producing a pyrolysis product, comprising pyrolyzing a hydrocarbon feedstock in the presence of a basic metal oxide catalyst to

produce a pyrolysis product, wherein the basic metal oxide catalyst has an uptake of carbon dioxide at 100°C of at least 0.03 mg/m² of the basic metal oxide catalyst.

[0083] Embodiment 4. The method of embodiment 3, wherein the metal oxide catalyst is comprised of at least one metal from Group 2, Group 3 including Lanthanides and Actinides, and Group 4 of the Periodic Table of Elements.

[0084] Embodiment 5. The method of any one of the previous embodiments, wherein the feedstock comprises biomass material.

[0085] Embodiment 6. The method of any one of the previous embodiments, wherein the basic metal oxide catalyst comprises at least one Group 2 metal.

[0086] Embodiment 7. The method of any one of the previous embodiments, wherein the Group 2 metal comprises magnesium.

[0087] Embodiment 8. The method of any one of the previous embodiments, wherein the basic metal oxide catalyst comprises hydrotalcite.

[0088] Embodiment 9. The method of any one of the previous embodiments, wherein the basic metal oxide catalyst comprises at least one Group 3 metal, including Lanthanides and Actinides.

[0089] Embodiment 10. The method of any one of the previous embodiments, wherein the Group 3 metal comprises at least one of yttrium, cerium, and praseodymium.

[0090] Embodiment 11. The method of any one of the previous embodiments, wherein the basic metal oxide catalyst comprises at least one Group 4 metal.

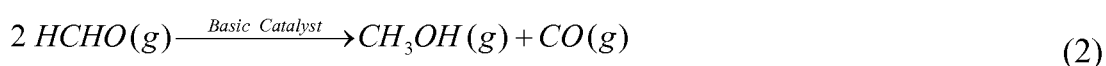
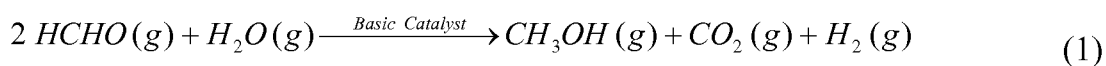
[0091] Embodiment 12. The method of any one of the previous embodiments, wherein the Group 4 metal comprises zirconium.

EXAMPLES

[0092] The invention was demonstrated using a variety of metal oxides as catalysts using a microflow reactor. The microflow reactor consisted of a stainless steel reactor (1/4" outer diameter) located in a furnace to which vaporized feed was introduced via a switching valve. The feed used in these experiments was ACS Reagent grade formaldehyde (~37% in water with ~12% methanol as inhibitor)

purchased from Sigma-Aldrich, and used as received. The feed was introduced into the vaporizer using a syringe pump. The flowrate of the feed to the reactor was about 25 $\mu\text{L}/\text{min}$ and the catalyst load was about 10 mg. The reactor was maintained at a temperature of about 500°C, and the pressure in the reactor was maintained at about 25 psig, conditions typical in a biomass pyrolyzer. Product gases exiting the reactor were collected using a multi-port sampling valve and analyzed using gas chromatography (HP6890 GC using 30 m PLOT-Q column). The FID-insensitive gases in the product (H_2 , CO, and CO_2) were analyzed using an Agilent 3000 Micro GC equipped with a TCD detector.

[0093] Analysis of formaldehyde conversion was determined indirectly by measuring the formation of methanol or CO, CO_2 , and H_2 via Equations (1) and (2):



[0094] A correlation of area counts for the methanol peak on the GC with the concentration of methanol in the sample was therefore used as a measure of the amount of methanol formed via the Cannizzaro reaction shown above.

Comparative Example 1

[0095] In this experiment, the reactor was loaded with about 100 mg of sand. This base case would be equivalent to a standard pyrolyzer in a biomass reactor where hot sand is circulated as the heat transfer medium. Analysis of the reactor effluent showed the methanol concentration to be essentially identical to that of the feed (formaldehyde feed contained ~12% methanol as an inhibitor). Analysis of the gases produced showed about 0.64% H_2 , about 0.23% CO, and about 0.41% CO_2 , attributable to decomposition reactions taking on the metal walls of the reactor.

Comparative Example 2

[0096] In this experiment, the reactor was loaded with about 90 mg of sand and about 10 mg of Ultrasil™ silica. The silica was anticipated to be inert for this

chemistry. Analysis of the reactor effluent showed the methanol concentration to be essentially identical to that of the feed. Analysis of the gases produced showed about 0.61% H₂, about 0.23% CO, and about 0.37% CO₂, attributable to decomposition reactions taking on the metal walls of the reactor.

Comparative Example 3

[0097] In this experiment, the reactor was loaded with about 90 mg of sand and about 10 mg of ~16% WO_x/ZrO₂, a catalyst known to be highly acidic, and therefore not believed to be suitable for the chemistry of the present invention. Analysis of the reactor effluent showed the methanol concentration to be only about 3% greater than that of the feed. Analysis of the gases produced showed about 0.78% H₂, about 0.75% CO, and about 0.54% CO₂, attributable to decomposition reactions taking on the metal walls of the reactor, as well as some very minor reaction catalyzed by the acidic metal oxide.

Example 4

[0098] In this experiment, the reactor was loaded with about 90 mg of sand and about 10 mg of ~12% CeO_x/ZrO₂, a catalyst known to be basic. Analysis of the reactor effluent showed the methanol concentration to be about 106% greater than that of the feed. Analysis of the gases produced showed about 8.04% H₂, about 8.25% CO, and about 2.38% CO₂. This experiment indicated that the basic mixed cerium oxide-zirconium oxide catalyst showed significant activity for the formaldehyde disproportionation reaction.

Example 5

[0099] In this experiment, the reactor was loaded with about 90 mg of sand and about 10 mg of hydrotalcite, a mineral with nominal composition Mg₆Al₂(CO₃)(OH)₁₆•4H₂O. Upon heating, the hydrotalcite undergoes dehydration and decarboxylation to produce a basic mixed magnesium aluminum oxide. Analysis of the reactor effluent showed the methanol concentration to be about 143% greater

than that of the feed. Analysis of the gases produced showed about 3.68% H₂, about 3.65% CO, and about 3.87% CO₂. This experiment indicated that the basic mixed cerium oxide-zirconium oxide catalyst showed significant activity for the formaldehyde disproportionation reaction.

Example 6

[00100] In this experiment, the reactor was loaded with about 90 mg of sand and about 10 mg of MgO. Analysis of the reactor effluent showed the methanol concentration to be about 182% greater than that of the feed. Analysis of the gases produced showed about 4.92% H₂, about 4.02% CO, and about 3.61% CO₂. This experiment indicated that the basic mixed cerium oxide-zirconium oxide catalyst showed significant activity for the formaldehyde disproportionation reaction.

Example 7

[00101] In this experiment, the reactor was loaded with about 90 mg of sand and about 10 mg of ZrO₂. Analysis of the reactor effluent showed the methanol concentration to be about 106% greater than that of the feed. Analysis of the gases produced showed about 9.69% H₂, about 9.18% CO, and about 2.23% CO₂. This experiment indicated that the basic mixed cerium oxide-zirconium oxide catalyst showed significant activity for the formaldehyde disproportionation reaction.

Example 8

[00102] In this experiment, the reactor was loaded with about 90 mg of sand and about 10 mg of Y₂O₃. Analysis of the reactor effluent showed the methanol concentration to be about 122% greater than that of the feed. Analysis of the gases produced showed about 8.12% H₂, about 7.59% CO, and about 2.85% CO₂. This experiment indicated that the basic mixed cerium oxide-zirconium oxide catalyst showed significant activity for the formaldehyde disproportionation reaction.

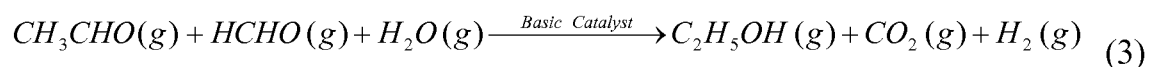
Example 9

[00103] In this experiment, the reactor was loaded with about 90 mg of sand and about 10 mg of Ce₂O₃. Analysis of the reactor effluent showed the methanol concentration to be about 76% greater than that of the feed. Analysis of the gases produced showed about 10.45% H₂, about 7.95% CO, and about 3.26% CO₂. This experiment indicated that the basic mixed cerium oxide-zirconium oxide catalyst showed significant activity for the formaldehyde disproportionation reaction.

Example 10

[00104] In this experiment, the reactor was loaded with about 90 mg of sand and about 10 mg of Pr₂O₃. Analysis of the reactor effluent showed the methanol concentration to be about 124% greater than that of the feed. Analysis of the gases produced showed about 11.17% H₂, about 5.23% CO, and about 5.52% CO₂. This experiment indicated that the basic mixed cerium oxide-zirconium oxide catalyst showed significant activity for the formaldehyde disproportionation reaction.

[00105] Examples 4-10 demonstrate that basic metal oxides exhibit significant activity for the removal of formaldehyde. However, this chemistry is not limited to formaldehyde only, and higher carbon number aldehydes are expected to be removed via crossed Cannizzaro reactions with formaldehyde. An example of this chemistry is shown in Equation (3) for acetaldehyde:



[00106] In this case, acetaldehyde reacts with formaldehyde to produce ethanol and a surface formate that undergoes decomposition to carbon dioxide and hydrogen. Similarly, propionaldehyde will undergo a crossed Cannizzaro reaction with formaldehyde to yield propanol and carbon dioxide and hydrogen. These experiments, therefore, demonstrate the pyrolysis product of the present invention can exhibit a relatively high alcohol content and a relatively low aldehyde content.

[00107] The foregoing disclosure provides illustrative embodiments of the invention and is not intended to be limiting. As understood by those of skill in the art, the overall invention, as defined by the claims, encompasses other preferred embodiments not specifically enumerated herein.

CLAIMS:

1. A method of producing an alcohol-containing pyrolysis product, comprising pyrolyzing a hydrocarbon feedstock in the presence of a basic metal oxide catalyst to produce a pyrolysis product that contains at least one alcohol, wherein the metal oxide catalyst is comprised of at least one metal from Group 2, Group 3 including Lanthanides and Actinides, and Group 4 of the Periodic Table of Elements.
2. The method of claim 1, wherein the basic metal oxide catalyst has an uptake of carbon dioxide at 100°C of at least 0.03 mg/m² of the metal oxide catalyst.
3. A method of producing a pyrolysis product, comprising pyrolyzing a hydrocarbon feedstock in the presence of a basic metal oxide catalyst to produce a pyrolysis product, wherein the basic metal oxide catalyst has an uptake of carbon dioxide at 100°C of at least 0.03 mg/m² of the basic metal oxide catalyst.
4. The method of claim 3, wherein the metal oxide catalyst is comprised of at least one metal from Group 2, Group 3 including Lanthanides and Actinides, and Group 4 of the Periodic Table of Elements.
5. The method of any one of the previous claims, wherein the feedstock comprises biomass material.
6. The method of any one of the previous claims, wherein the basic metal oxide catalyst comprises at least one Group 2 metal.
7. The method of any one of the previous claims, wherein the Group 2 metal comprises magnesium.
8. The method of any one of the previous claims, wherein the basic metal oxide catalyst comprises hydrotalcite.
9. The method of any one of the previous claims, wherein the basic metal oxide catalyst comprises at least one Group 3 metal, including Lanthanides and Actinides.

10. The method of any one of the previous claims, wherein the Group 3 metal comprises at least one of yttrium, cerium, and praseodymium.

11. The method of any one of the previous claims, wherein the basic metal oxide catalyst comprises at least one Group 4 metal.

12. The method of any one of the previous claims, wherein the Group 4 metal comprises zirconium.