A Kinetic Model for the Hydroformylation of 1-Octene in Supercritical CO2

Constantin Maniut, Thomas N. Otto and Stephan Pitter*

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Introduction
The hydroformylation of olefins is one of the industrially most important homogeneously catalyzed reactions. Since early 90th, supercritical carbon dioxide (scCO2) has been investigated as an alternative medium replacing conventional organic solvents in hydroformylation. The physical-chemical properties of scCO2 are between those of liquids and gases. In catalysis applications, the tuneable solvent properties of scCO2 can result in a variety of effects, such as affecting kinetic rates by both temperature and pressure, shifting equilibrium constants in favour of the desired products, and increasing selectivity and yields. One particular benefit of scCO2 is that interface diffusion does not take place.

In this work we present our recent studies on Co2(CO)8 catalyzed hydroformylation of 1-octene in scCO2.

Experimental
Experiments were carried out in a parallel six-reactor system allowing for faster exploration of process parameters up to 350 bar pressure. Automation of reactant dosing, experiments and data recording was performed using a programmable controller. Samples for kinetic analyses were quantitatively analyzed by GC.

Kinetics and Formal Kinetics
An activation enthalpy of 117 kJ mol−1 for 1-octene hydroformylation was determined in the range between 90 and 150°C. Experiment series at various concentrations of each 1-octene, CO, H2 and Co2(CO)8 were performed, with 1-octene conversion expressing the rate of hydroformylation. Initial reaction rates and concentrations were determined at 120°C.

The following equation (1) was used to describe the reaction rate.

\[
f_{\text{model}} = \frac{k \cdot \text{c_{1-octene}} \cdot \text{c_{CO}}^{0.68} \cdot \text{c_{H2}}^{0.88} \cdot \text{c_{Co}}^{0.56}}{(1 + K_{\text{CO}} \cdot \text{c_{CO}})^{1.68} \cdot (1 + K_{\text{H2}} \cdot \text{c_{H2}})^{0.88} \cdot (1 + K_{\text{Co}} \cdot \text{c_{Co}})^{0.56}}
\]

(1)

Constants in Eq. (1) were fitted to k = 13, K_{\text{CO}} = 0.2 and K_{\text{Co}} = 0.3.

As most of the variable influences studied are well expressed by this model, influence of low CO partial pressure (Fig. Right) is not described satisfyingly. Formal kinetics can also not describe regioselectivity.

Microkinetics
Kinetic parameters for the formation of n- and i-nonanal from 1-octene were determined from the reaction mechanism established by DFT calculations.

For both pathways oxidative addition of H2 through transition states TS7 (finally yielding the linear product) and TS8 (yielding the branched product) is energetically the rate-limiting step.

From thermodynamical values calculated for all intermediates, the product (finally yielding the linear product) and TS8 (yielding the branched product) is energetically the rate-limiting step.

The non-linear microkinetic model for the hydroformylation pathways was constructed using the SIMULINK toolbox integrated in Matlab®. Visualization of concentrations as function of reaction time took place by utilization of programmable S-function modules in SIMULINK.

Regioselectivity in aldehyde formation is explained from the difference in activation enthalpy through transition states TS5 and TS6, respectively. The microkinetic model quantitatively describes the concentration profiles of the corresponding products in the catalytic cycle, (Co(CO)2H), G1 and G2 (here in dependence from initial 1-octene concentration), in a stirred tank-reactor.

In contrast to formal kinetics the microkinetic model is able to reproduce also the rate a low CO partial pressure (Fig. Left) and to describe regioselectivity on a high level of accuracy.

Additionally it allows for the extrapolation outside the experimental range.