Yields of soluble organic extract are increased up to about 50% by the supercritical extraction of particulate coal at a temperature below the polymerization temperature for coal extract fragments (450°C) and a pressure from 500 psig to 5,000 psig by the conjoint use of a solvent mixture containing a low volatility, high critical temperature coal dissolution catalyst such as phenanthrene and a high volatility, low critical temperature solvent such as toluene.
Fig. 1.

Fig. 2.
SUPERCRITICAL SOLVENT COAL EXTRACTION

DESCRIPTION

ORIGIN OF THE INVENTION

The invention described herein was made in the performance of work under a NASA contract and is subject to the provisions of Section 305 of the National Aeronautics and Space Act of 1958, public law 83-568 (72 Statute 435; 42 U.S.C. 2454).

TECHNICAL FIELD

The present invention relates to the extraction of coal and, more particularly, to the solvent extraction of coal under supercritical conditions.

The U.S. reserve of coal is about 3 trillion tons. Although the most abundant (80%) fossil fuel in America is coal, the U.S. consumption pattern is quite a reversal in terms of utilization, with coal representing only 17%, oil and gas about 78%.

The demand for all the fossil fuels combined is expected to double by the year 2,000, even with increasing use of nuclear power. While the domestic supply of crude oil and natural gas is not likely to keep pace with the energy demand, coal can play an important role in filling such a gap and thus reduce the requirements for imported supplies of oil and gas.

At the present time, about one-half of the electric power in the United States is generated from natural gas and petroleum; most of the other half is from coal. If coal can be economically converted to clean fuel for electric utilities, it could supply most of the energy needs of the United States for the next three centuries, and the rapidly depleting petroleum and natural gas resources could be conserved for other essential uses, especially as a raw material for the synthetic rubber and plastics industries.

BACKGROUND ART

Many coal liquefaction processes which are at an advanced stage of development operate in the liquid phase and are designed to produce boiler fuels (heavy liquids and solids at room temperature). The raw effluent product from the liquefaction stage of these processes consists of a very heavy, viscous liquefied coal with solids suspended in it. The coal minerals content of the product will be about 8-12%, and this has to be reduced to about 0.15% to meet stack emission requirements.

The inorganic content of coal represented by minerals, sulfur, arsenic, and other trace elements in the inorganic phase of coal present problems, since these elements can poison the catalysts utilized in coal gasification and liquefaction processes. Separation of these inorganics, especially sulfur, from the organic matter prior to use as fuel or feedstock has the advantage of reducing the amount of desulfurization, and no ash or slag or other extraneous material is left in the coal reactor. A pure carbon or hydrocarbon feedstock can be directly converted into various end products. Furthermore, raw coals vary widely in mineral keep and sulfur keep. As previously stated, such coals can not be used directly in many chemical conversion processes, e.g. coal liquefaction, where these impurities interfere with catalyst activity, and even with the processes in advanced stage of development the yields vary widely.

Solvent extraction of coal can be conducted in a manner that separates some of the inorganics such as minerals from a coal extract. However, current economic analysis indicates that since the yield of solvent extract is fairly low, typically around 20% or less, and the cost of the solvent is high, the residual coal must be separated from residual solvent and recovered and utilized as fuel. Though there have been many attempts to increase the amount of extraction, none of the processes for solvent extraction being developed have approached an economic level.

Extraction of the organic matter in coal with near or supercritical solvents is another possible way to perform the upgrading of coal into an inorganic-free, organic extract. Near the critical temperature, a highly dense gas which acts like a liquid solvent and efficiently extracts soluble components from coal can be made. Near the critical temperature the dense gas solvent can expand and contract with the involvement of very little energy. On expansion the dense gas loses its solvent properties, rendering it very easy and economical to separate solute from the dense solvent gas. Separation of the dense gas from the coal followed by expansion to release the solute is much easier than separating solvent liquid from a solid and a solute, as must be done in conventional solvent processes. The current state of the art for process demonstration units is exemplified in the publication of R. R. Maddocks et al in C.E. Progress (CEP), June, 1979 at pages 49–55. Maddocks et al report the extraction of coal at the critical temperature of toluene, 319° C. (606° F.), provides 21 weight percent yield of extract having a low ash content (0.08%) from coal having nearly 6.1% ash content. It is further suggested that this process would be commercially attractive if yields of extract could be increased. Other studies have shown that the economics of coal extraction rapidly rise as the extraction and efficiency increases from 20 to 40%.

It would be expected that coal extraction efficiency under supercritical conditions would increase if more efficient coal solvents such as the bent ring coal extract type of solvents such as phenanthrene were utilized. However, when phenanthrene or other highly efficient solvents are utilized, the critical temperature is so high that the coal extract cross-links or polymerizes and forms a very high percentage of char, or the temperature is sufficiently high to gasify the coal. Furthermore, very expensive materials are required for constructing a higher temperature reactor, and the energy cost to operate a higher temperature reactor and the energy cost to operate a higher temperature process is significantly higher. Other examples of low yield, supercritical solvent extraction of coal are U.S. Pat. Nos. 3,558,468 and 3,607,717 which illustrates the use of an aromatic solvent such as benzene at supercritical conditions. U.S. Pat. No. 3,607,716 utilizes phenanthrene under supercritical conditions to upgrade extracts of coal. U.S. Pat. No. 4,036,731 discloses a mixed solvent, hydrogen- active supercritical extraction process utilizing an aromatic solvent with a hydrogen donor solvent such as tetralin, tetrahydroquinoline or o-cyclohexylphenol, preferably practiced in the presence of hydrogen gas. Again the yields are mainly in the 20% range with some yields in the 30% range.
A supercritical solvent extraction technique has been developed in accordance with the invention which separates at least 40% of the organic matter in some coals into a substantially inorganic-free hydrocarbon extract. The coal is volatilized into a supercritical gas mixture comprised of a coal dissolution catalyst solvent, such as phenanthrene, having a high critical temperature (Tc) and a low volatility, and a second solvent having a critical temperature at least 100° C. lower than the catalyst solvent, such as toluene. The presence of the lower Tc solvent creates a lower Tc mixture and permits extraction of the coal solute at a temperature sufficiently low to avoid coal gasification and polymerization or cross-linking reactions such that the yields are generally about 30 to 50%, and in some cases yields over 50 weight percent of the organic matter in the coal have been achieved. The coal extract has a very low ash content and can have significantly reduced sulfur content and thus is suitable for direct conversion into lower viscosity liquid fuel products such as synthetic gasoline.

During extraction in accordance with the invention, particulate coal is volatilized into the supercritical gas mixture of the coal dissolution catalyst and the secondary solvent. The catalyst contributes to the breakdown of the coal structure and volatilization of the resulting coal fragment molecules occurs simultaneously during this high yield extraction. The dissolved volatilized materials are removed in the gas phase leaving behind the inorganic materials. The gas phase with a second solvent can readily be recovered by expansion, and the catalyst can be recovered from the coal extract by fractional distillation.

The process of the invention is conducted under controlled conditions. The maximum extraction temperature preferably does not exceed about 450° C. in order to avoid polymerization, cross-linking and gasification. The minimum temperature during extraction should be above about 250° C. in order to have sufficient thermal energy available to depolymerize the coal into smaller molecules. The process is conducted at a pressure from about 500 to 5,000 psig. The process is preferably operated at supercritical conditions and a temperature and pressure within the stated range and usually within 200° C. and preferably within 100° C. of the critical temperature of the mixture, since at higher temperatures an unnecessary pressure and energy penalty is suffered. It is believed that the highest efficiencies are achieved at 300° C. to 400° C. and pressures from 1,000 to 3,000 psig. The process can be operated below the critical temperature of the mixture as long as sufficient volatilization of the higher Tc catalyst solvent into a dense gas phase occurs. Preferably, no more than 10% of the catalyst is present in the reactor as a liquid.

These and many other features and intended advantages of the invention will become apparent as the invention becomes better understood by reference to the following detailed description when considered in conjunction with the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a schematic view of the first embodiment of the invention; and

FIG. 2 is a schematic view of an experimental embodiment of the system of the invention.
Because of the importance of weight loss data, all experiments were carried out with specially dried coal, stored in a desiccator until used. In addition the coal was first ground under nitrogen to $-48$ to $+200$ Tyler mesh, dried under nitrogen vacuum at $230^\circ$ F. ($110^\circ$ C) and rapidly transferred to a desiccator.

A quantity of coal, e.g. 5 grams, in a porous container was weighed initially, and again after extraction. A quantity of solvent, e.g. 170 grams, was added to the autoclave, and heated gradually to temperature while stirring the gas with propeller blades located just above the porous container, and within the stirred autoclave. The autoclave was cooled, the basket removed, rinsed with solvent, dried, and again carefully weighed. After partial or total evaporation, the coal extract can be cooled to yield a dark, low-melting point, glassy, solid extract. Generally the coal extract has a very low ash content and a significantly lowered inorganic sulfur content. The results of experiments conducted with toluene alone and with toluene-phenanthrene mixtures are tabulated in Table 2.

### Table 2

<table>
<thead>
<tr>
<th>COAL TYPE</th>
<th>ASH SOLVENT MAKEUP</th>
<th>SOLVENT/COAL RATIO</th>
<th>TEMP. °C</th>
<th>TIME Hr.</th>
<th>PRESS. kg/cm²</th>
<th>GAS DENSITY g/cc</th>
<th>COAL ORGANICS EXTRACTED wt.%</th>
<th>EXTRACTION ENHANCEMENT %</th>
</tr>
</thead>
<tbody>
<tr>
<td>PSOC NO.</td>
<td>(DTG) Wt. %</td>
<td>(Wt./Wt.)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>174</td>
<td>Tol.100</td>
<td>34.7</td>
<td>725</td>
<td>17</td>
<td>3300</td>
<td>0.73</td>
<td>47.1</td>
<td>13.3</td>
</tr>
<tr>
<td>174**</td>
<td>T/P**62/38</td>
<td>29.5</td>
<td>715</td>
<td>16</td>
<td>900</td>
<td>0.69</td>
<td>54.7</td>
<td>17.8</td>
</tr>
<tr>
<td>086</td>
<td>Tol.100</td>
<td>36.0</td>
<td>690</td>
<td>15.3</td>
<td>3050</td>
<td>0.73</td>
<td>26.1</td>
<td></td>
</tr>
<tr>
<td>086</td>
<td>T/P**83/17</td>
<td>39.8</td>
<td>692</td>
<td>15.3</td>
<td>2000</td>
<td>0.73</td>
<td>30.8</td>
<td>17.8</td>
</tr>
</tbody>
</table>

*PSOC 086 Lignite rank, EAP seams, 73.2% DMMF Carbon
PSOC #174 EVA rank, Pittsburgh Seam, 94.1% DMMF Carbon
**T/P = Toluene to Phenanthrene ratio
***This run further showed the following:
ASH CONTENT RATIO: Wt. in Res./Wt. in Coal = 2.0
WEIGHT RATIO: Wt. Raw Coal/Wt. Extraction Res. = 2.0
ASH CONTENT in Residue - 10.0 weight %

recover the extract and the solvent for recycle. Therefore, the amount of coal in the reactor is preferably from 10 to 60% of the total weight of coal plus solvent.

The effectiveness of the extraction depends on the rank of the coal. The extraction process of the invention is very effective with bituminous coal. The extraction enhancement for lignite coals is quite unexpected, since the literature indicates that phenanthrene is not an effective dissolution catalyst for lignite coals.

The process of the invention is capable of dissolving fairly large lumps of coal and it is not believed to be necessary to subdivide and classify the coal below about 5 mesh before processing in accordance with the invention.

Examples of practice follow. The coal samples utilized in these experiments was secured from the Pennsylvania State University sample bank. Their designations are PSOC 086 and PSOC 174. Coal properties are listed in Table I.

### Table I

<table>
<thead>
<tr>
<th>Sample</th>
<th>Moisture % (AD)</th>
<th>Ash % (AD)</th>
<th>Volatile % (AD)</th>
<th>Fixed C % (AD)</th>
<th>Total S % (AD)</th>
<th>Carbon % (AD)</th>
<th>Hydrogen % (AD)</th>
</tr>
</thead>
<tbody>
<tr>
<td>PSOC 086</td>
<td>4.65</td>
<td>9.37</td>
<td>9.83</td>
<td>41.5</td>
<td>43.5</td>
<td>44.5</td>
<td>46.7</td>
</tr>
<tr>
<td>PSOC 174</td>
<td>1.31</td>
<td>5.32</td>
<td>5.39</td>
<td>36.2</td>
<td>36.7</td>
<td>57.2</td>
<td>57.9</td>
</tr>
</tbody>
</table>

The experiments were conducted in a conventional solid extraction apparatus including a 300 cc autoclave reactor with controlled heating, a high pressure metering pump for pressurized operation, and attendant control devices. The reactor included a porous container and a blade agitator above the container.

The comparison of the experiments run with toluene alone with those run with a mixture of phenanthrene+toluene show an increased extract yield achieved with conjoint use of these two materials. It also appears that extraction yields with pure toluene are higher than expected. Although the literature suggests that maximum laboratory yields of dry coal extract with toluene alone are about 25 or 30 wt.%, the present method carried out for 15 to 17 hours and with solvent densities above about 0.50 gm/cc, raised the observed yield with certain types of coal to more than 40 wt.%. Other experiments with the mixed solvents of the invention showed yields as high as about 50%. Thus the practice of the present process achieves, without hydrogenation, the desired threshold of about 50 wt.% coal extract yields for the first time; it is believed that significantly shorter processing times are possible.

Observed decreases in weight of coal agree well with increase in ash content of the residue or "char" when analyzed.

It is believed that phenanthrene and certain other bent ring polycyclic compounds, including methyl phenanthrenes; phenanthridine, carbazole, pyrene, 5,6-benzoxquinoline, and 5,6-benzoquinoline, catalyze the breakdown of the raw coal structure in the solvent.
Phenanthrene with a critical temperature of 600° C. (1112° F.) and other bent ring polycyclics are not sufficiently volatile at temperatures below about 450° C. (842° F.) to be employed separately in coal extraction under supercritical conditions. Coal is known to undergo polymerization above about 450° C. By conjoint use of toluene and/or other solvents with low critical temperature and a phenanthrene-like material, coal is volatilized at acceptably low temperatures where no significant degree of coal polymerization occurs. Similar improvements in yield are expected with conjoint use of other S(I) and S(II) solvents as previously described.

It is to be realized that only preferred embodiments of the invention have been described and that numerous substitutions, modifications and alterations are permissible without departing from the spirit and scope of the invention as defined in the following claims.

We claim:

1. A method of separating an organic extract from an inorganics-containing coal comprising the steps of:
   - adding to a closed reactor particulate coal and a mixture of solvents consisting of a first and second solvent absent straight chain polynuclear compounds and hydrogen donor solvents; said first solvent being present in the mixture in an amount above 1% and below 50% by weight and consisting of at least one low volatility, bent ring, polycyclic, aromatic organic compound containing at least three rings, having a high critical temperature above 450° C. and being capable of at least 20% by weight catalytic dissolution of the coal into the soluble extract fragments and the second solvent consisting of a higher volatility organic or inorganic compound which is stable at the operating temperature and having a critical temperature below 300° C.;
   - heating the reactor to a temperature above 250° C. and below 450° C. and within 200° C. above or below the critical temperature of the solvent mix-