



PHYSICAL CHEMISTRY 2018

14th International Conference
on Fundamental and Applied Aspects of
Physical Chemistry

Proceedings
Volume I

September 24-28, 2018
Belgrade, Serbia

ISBN 978-86-82475-36-1

Title: Physical Chemistry 2018 (Proceedings)

Editors: Željko Čupić and Slobodan Anić

Published by: Society of Physical Chemists of Serbia, Studentski Trg 12-16,
11158, Belgrade, Serbia

Publisher: Society of Physical Chemists of Serbia

For Publisher: S. Anić, President of Society of Physical Chemists of Serbia

Printed by: "Jovan", <Printing and Publishing Company, 200 Copies

Number of pages: 550+6, Format B5, printing finished in September 2018

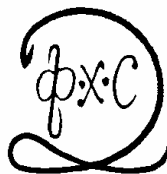
Text and Layout: "Jovan"

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*14th International Conference on
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Organized by

*The Society of Physical Chemists of
Serbia*

in co-operation with

Institute of Catalysis Bulgarian Academy of Sciences

and

*Boriskov Institute of Catalysis Siberian Branch of
Russian Academy of Sciences*

and

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SYNTHESIS OF CALCIUM OXIDE BASED CATALYSTS FOR BIODIESEL PRODUCTION

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ABSTRACT

In this work, synthesis of several types of calcium oxide based catalysts by mechanochemical treatment and subsequent calcination is presented. Prepared nanocomposite CaO·ZnO, calcium containing perovskites CaTiO₃, CaMnO₃, CaZrO₃ and Ca₂Fe₂O₅, a series of CaO·SiO₂ mixed oxides and calcium diglyceroxide (CaDG) were characterized and tested in the methanolysis of sunflower oil under different working conditions: catalyst amount, agitation speed, temperature and methanol to oil molar ratio.

INTRODUCTION

Biodiesel, a mixture of fatty acid methyl esters (FAME), due to its environmental benefits such as non-toxicity and biodegradability and the fact that it might be synthesized from renewable resources, has gained significant attention as a promising alternative substitute to diesel fuels. Commonly, biodiesel is produced by alcoholysis of different triacylglycerols in the presence of homogeneous or heterogeneous catalysts. Calcium oxide due to the high activity, availability and low cost is one of the most studied heterogeneous catalysts [1]. However, since leaching into the reaction medium was observed for this catalyst, it is important to improve CaO properties by supporting it on different carriers or mixing with other oxides. Mechanochemical synthesis is a simple and waste-free technique for the preparation of different materials, including catalysts.

Milling of CaO and ZnO with water was carried out to obtain calcium zinc hydroxide hydrate (CaZn₂(OH)₆·2H₂O), which was subsequently transformed to CaO·ZnO catalyst by calcination at 700 °C for 3h [2]. Calcium diglyceroxide (Ca(C₃H₇O₃)₂) was synthesized by mechanochemical treatment of CaO dispersed in glycerol [3]. Calcium-containing perovskites CaTiO₃, CaMnO₃, CaZrO₃ and Ca₂Fe₂O₅ were synthesized by calcination of mechanochemically treated stoichiometric mixtures of CaCO₃ and either TiO₂, MnO₂, ZrO₂ or Fe₂O₃ powders [4]. Mixtures of CaO and SiO₂ in a molar

ratio in the range of 1 to 3 with addition of water have been mechanochemically treated and calcined to prepare a series of $\text{CaO}\cdot\text{SiO}_2$ mixed oxides.

EXPERIMENTAL

Mechanochemical treatment of different starting materials was carried out in the planetary ball mill Fritsch Pulverisette 5, in air atmosphere. The prepared catalysts were characterized by XRD, TGA/DSC, FTIR, SEM/EDX, and base strength using Hammett indicator method. The detailed preparation of catalysts and the used instruments for their characterization are described elsewhere [2-4].

The methanolysis of sunflower was carried out in 300 cm^3 batch autoclave or in a 250 ml three-necked thermostated glass flask with a condenser and magnetic stirrer under different working conditions: catalyst amount, agitation speed, temperature and methanol to oil molar ratio.

RESULTS AND DISCUSSION

The X-ray diffraction patterns of prepared catalysts are shown in Fig. 1.

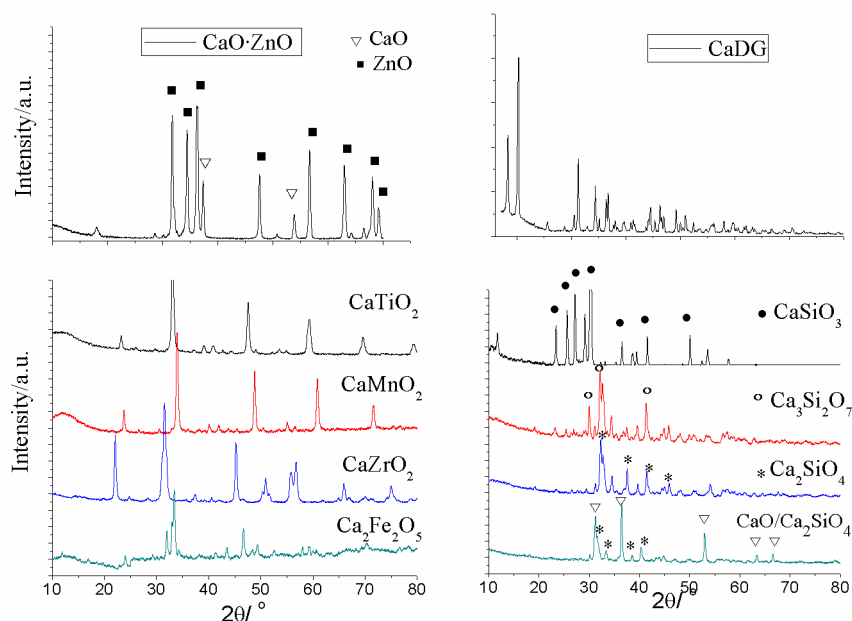


Figure 1. XRD patterns of synthesized catalysts

Mechanochemical treatment of CaO and ZnO powder mixture with water and subsequent calcination led to the formation of fine composite powder composed of CaO and ZnO . The formation of CaDG by mechanochemical

treatment of CaO and glycerol was confirmed with all the peaks well indexed to the calcium diglyceroxide phase $\text{Ca}(\text{C}_3\text{H}_7\text{O}_3)_2$. XRD patterns revealed that CaTiO_3 , CaMnO_3 , CaZrO_3 and $\text{Ca}_2\text{Fe}_2\text{O}_5$ perovskites consist dominantly of one phase. Milling of $\text{CaO} + \text{SiO}_2$ powder mixtures with molar ratio in the range of 1–2 followed by calcination at 900 °C for 48 h, produced single-phase calcium silicate compounds, while starting from the $3\text{CaO} + \text{SiO}_2$ powder mixture, two phase $\text{CaO}/\text{Ca}_2\text{SiO}_4$ was obtained.

Table 1. Catalytic activity of synthesized catalysts

Catalyst	Starting material and calcination temperature	Basic strength	Reaction conditions ^a	FAME yield, %
$\text{CaO}\cdot\text{ZnO}$	$\text{CaO} + \text{ZnO} + \text{H}_2\text{O}$ $T_{\text{calc}}=700\text{ °C}, 3\text{h}$	$11 < H_- < 18.4$	$T = 60\text{ °C};$ $\text{MR} = 10:1;$ $\text{Cat} = 2\%;$ $t = 4\text{h}$	98.2
$\text{Ca}(\text{C}_3\text{H}_7\text{O}_3)_2$ (CaDG)	$\text{CaO} + \text{Glycerol}$ /	$11 < H_- < 15.0$	$T = 60\text{ °C};$ $\text{MR} = 10:1;$ $\text{Cat} = 0.5\%;$ $t = 2\text{h}$	97.9
CaTiO_3	$\text{CaCO}_3 + \text{TiO}_2$	$6.8 < H_- < 9.3$		0.1
CaZrO_3	$\text{CaCO}_3 + \text{ZrO}_2$	$6.8 < H_- < 9.3$	$T = 60\text{ °C};$	0.0
CaMnO_3	$\text{CaCO}_3 + \text{MnO}_2$	$6.8 < H_- < 9.3$	$\text{MR} = 6:1;$	0.0
$\text{Ca}_2\text{Fe}_2\text{O}_5$	$\text{CaCO}_3 + \text{Fe}_2\text{O}_3$ $T_{\text{calc}}=700\text{ °C}; 24$	$6.8 < H_- < 9.3$	$\text{Cat} = 10\%;$ $t = 10\text{h}$	0.0
^b $\text{CaO}/\text{CaTiO}_3$	^b $\text{CaCO}_3 + \text{TiO}_2$ $T_{\text{calc}}=1050\text{ °C}, 2\text{ h}$	^b $9.3 < H_- < 10$		^b 98.1
CaSiO_3	$\text{CaO} + \text{SiO}_2$	$H_- < 9.3$	$T = 60\text{ °C};$	0.31
$\text{Ca}_3\text{Si}_2\text{O}_7$	$3\text{CaO} + 2\text{SiO}_2$	$H_- < 9.3$	$\text{MR} = 10:1;$	0.52
Ca_2SiO_4	$2\text{CaO} + \text{SiO}_2$	$H_- < 9.3$	$\text{Cat} = 2\%;$	0.81
$\text{CaO}/\text{Ca}_2\text{SiO}_4$	$3\text{CaO} + \text{SiO}_2$ $T_{\text{calc}} = 900\text{ °C}, 48\text{h}$	$11 < H_- < 15$	$t = 5\text{h}$	96.03

^a T = temperature; MR = molar ratio methanol to oil; Cat = catalyst loading; t = time.

^bMixed using agate mortar and pestle (but without subsequent mechanochemical treatment)

The results of catalytic activity of the prepared catalysts in methanolysis of sunflower oil, along with their basic strength (H_-), reaction conditions, and preparation procedure are given in Table 1.

The high FAME yields were achieved when CaO·ZnO and CaDG were used as catalysts, as well as two-phase samples containing CaO, while pure perovskites and calcium silicates showed no activity in methanolysis at 60 °C. High catalytic activity of prepared catalysts is related to high basic strength, which is considered as one of the most significant factor that affects the activity of different catalysts for biodiesel production. With the exception of CaDG, which has different structure, in all other cases the high basicity of samples, accompanied with their high catalytic activities, arises from the existence of CaO phase. The perovskites possess different structure compared to the rock salt structure of CaO and from that reason they are not active in transesterification of sunflower oil at lower temperature.

CONCLUSION

Mechanochemical treatment was successfully used for the synthesis of various CaO based heterogeneous catalysts. Prepared CaO·ZnO and CaDG showed a high catalytic activity in methanolysis of sunflower oil at 60 °C resulting in FAME yield over 96%. Under these conditions, pure perovskites (CaTiO₃, MnO₃, CaZrO₃ and Ca₂Fe₂O₅) and pure calcium silicates (CaSiO₃, Ca₃Si₂O₇ and Ca₂SiO₄) phases exhibited no catalytic activity, while two-phase samples containing CaO (CaTiO₃/CaO and Ca₂SiO₄/CaO) were active.

Acknowledgement

This work was financially supported by the Ministry of Education, Science and Technological Development of the Republic of Serbia (III 45001).

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