

# STYRENE/ETHYLBENZENE (94/95-8) JUNE 1996

CONTENTS	Page
<b>I SUMMARY</b>	1
A. BACKGROUND	1
B. COMMERCIAL TECHNOLOGY	1
1. Ethylbenzene	1
2. Styrene	5
C. ALTERNATIVE TECHNOLOGIES	7
D. RECENT DEVELOPMENTS	8
E. ECONOMICS	8
F. GLOBAL COMMERCIAL OVERVIEW	13
1. Demand	13
2. Supply	15
3. Trade	16
<b>II INTRODUCTION</b>	18
<b>III COMMERCIAL TECHNOLOGY</b>	20
A. ETHYLBENZENE	20
1. Chemistry	20
2. Mobil/Badger Vapor Phase Alkylation	22
3. Dilute Ethylene Feedstock	26
4. Mobil/Badger Liquid Phase Alkylation/Vapor Phase Transalkylation	34
5. Lummus/UOP Liquid Phase Alkylation	36
6. CDTECH Alkylation	43
7. Aluminum Chloride Liquid Phase Alkylation	48
B. STYRENE	52
1. Chemistry	52
2. Fina/Badger Dehydrogenation	54
3. Lummus/UOP CLASSIC SM Dehydrogenation	58
4. Lummus/UOP SMART™ Dehydrogenation	66
5. Propylene Oxide Coproduction Processes	69
(a) Chemistry	69
(b) Process Design	73
<b>IV ALTERNATIVE TECHNOLOGIES</b>	77
A. BUTADIENE DIMERIZATION/DEHYDROGENATION	77
1. Chemistry	77
(a) Cyclodimerization of Butadiene	77
(b) Oxidative Dehydrogenation of 4-Vinylcyclohexene	79
2. Process Description	79
B. TOLUENE-BASED ROUTES	82
1. Introduction	82
2. Methanol Alkylation of Toluene	84
(a) Chemistry	84

# STYRENE/ETHYLBENZENE (94/95-8) JUNE 1996

## CONTENTS

## Page

(b) Process Description

85

<b>V RECENT DEVELOPMENTS</b>	91
<b>VI ECONOMICS</b>	98
A. BASE CASES	98
B. SENSITIVITIES	112
<b>VII COMMERCIAL ANALYSIS</b>	121
A. UNITED STATES	121
1. Demand	121
2. Supply	125
3. Industry Integration	127
4. Supply/Demand Balance	127
B. WESTERN EUROPE	129
1. Demand	130
2. Supply	132
3. Industry Integration	134
4. Supply/Demand Balance	135
C. JAPAN	135
1. Demand	135
2. Supply	139
3. Industry Integration	140
4. Supply/Demand Balance	141
D. GLOBAL	142
1. Demand	142
2. Supply	144
3. Trade	148
<b>REFERENCES</b>	149
<b>APPENDIX</b>	151

## TABLES

	<b>Page</b>
Table I.E.1 U.S. Gulf Coast Base Prices of Key Raw Materials/ Byproducts, 1995	9
Table I.E.2 Styrene Process Cost Comparison	11
Table I.F.1 Global Styrene Demand, 1992-2005	15
Table I.F.2 Global Styrene Capacity, 1992-2005	16
Table I.F.3 Global Styrene Production, 1992-2005	16
Table I.F.4 Global Styrene Net Trade, 1992-2005	17

## STYRENE/ETHYLBENZENE (94/95-8) JUNE 1996

## TABLES

	<b>Page</b>
Table III.A.1 Typical Gas Composition from FCC Olefins Recovery Unit	28

Table III.A.2	Dilute Ethylene Specifications	30
Table III.A.3	Ethylbenzene Feedstock and Product Specifications	42
Table III.A.4	Dilute Ethylene Specifications for the CDTECH Process	48
Table III.B.1	Lummus/UOP CLASSIC Styrene Process Feedstock, Product, And Byproduct Specifications	66
Table III.B.2	Ethylbenzene Hydroperoxidation Selectivity, Percent	71
Table IV.B.1	Toluene/Methanol Reactor Design Premises	88
Table IV.B.2	Alkylation Reactor Effluent Composition	89
Table VI.A.1	U.S. Gulf Coast Base Prices of Key Raw Materials/ Byproducts, 1995	98
Table VI.A.2	Styrene Process Cost Comparison	99
Table VI.A.3	Cost Estimate of Styrene Production via Liquid Phase $\text{AlCl}_3$ Alkylation plus Dehydrogenation	101
Table VI.A.4	Cost Estimate of Styrene Production via Mobil/Badger Vapor Phase Alkylation plus Fina/Badger Dehydrogenation	102
Table VI.A.5	Cost Estimate of Styrene Production via Mobil/Badger EBMax <sup>SM</sup> Alkylation plus Fina/Badger Dehydrogenation	103
Table VI.A.6	Cost Estimate of Styrene Production via CDTECH Alkylation plus Lummus/UOP CLASSIC Dehydrogenation	104
Table VI.A.7	Cost Estimate of Styrene Production via Lummus/UOP Alkylation plus Lummus/UOP SMART <sup>TM</sup> Oxydehydrogenation	105
Table VI.A.8	Cost Estimate of Styrene Production via Mobil/Badger Vapor Phase Alkylation (Dilute $\text{C}_2$ ) plus Fina/Badger Dehydrogenation	106
Table VI.A.9	Cost Estimate of Styrene Production via Propylene Oxide Coproduct (Allocated)	107
Table VI.A.10	Cost Estimate of Styrene Production via Butadiene Dimerization/ Oxydehydrogenation (Dow)	108
Table VI.A.11	Cost Estimate of Styrene Production via Methanol Alkylation of Toluene	109
Table VII.A.1	U.S. Styrene Demand (million pounds), 1992-2005	121
Table VII.A.2	U.S. Styrene Demand (thousand metric tons), 1992-2005	122
Table VII.A.3	U.S. Styrene Demand by Application, 1994	122
Table VII.A.4	U.S. Styrene Capacity (million pounds), 1994	125
Table VII.A.5	U.S. Styrene Capacity (thousand metric tons), 1994	126
Table VII.A.6	U.S. Styrene Producer Back Integration	128
Table VII.A.7	U.S. Styrene Exports, 1994	128
Table VII.A.8	U.S. Styrene Supply/Demand Balance (million pounds), 1992-2005	129
Table VII.A.9	U.S. Styrene Supply/Demand Balance (thousand metric tons), 1992-2005	129
Table VII.B.1	West European Styrene Demand, 1992-2005	132
Table VII.B.2	West European Styrene Capacity, 1994	133

## **STYRENE/ETHYLBENZENE (94/95-8) JUNE 1996**

### **TABLES**

	<b>Page</b>	
Table VII.B.3	West European Styrene Producer Back Integration	134
Table VII.B.4	West European Styrene Supply/Demand Balance, 1992-2005	135

Table VII.C.1	Japanese Styrene Demand, 1992-2005	138
Table VII.C.2	Japanese Styrene Capacity, 1994	140
Table VII.C.3	Japanese Styrene Producer Back Integration	141
Table VII.C.4	Japanese Styrene Supply/Demand Balance, 1992-2005	142
Table VII.D.1	Global Styrene Demand, 1992-2005	144
Table VII.D.2	Global Styrene Capacity, 1992-2005	144
Table VII.D.3	East European Styrene Capacity, 1994	145
Table VII.D.4	Other Far East Styrene Capacity, 1994	146-147
Table VII.D.5	Global Styrene Production, 1992-2005	148
Table VII.D.6	Global Styrene Net Trade, 1992-2005	148
Appendix		
Table A.1	Mobil/Badger Ethylbenzene, Fina/Badger Styrene Recent Contract Awards	151-152
Table A.2	Lummus/UOP Ethylbenzene Project Awards	153
Table A.3	Lummus CDTECH Ethylbenzene Project Awards	153
Table A.4	Lummus/UOP CLASSIC Styrene Monomer Process Experience List	154-155
Table A.5	Lummus/UOP SMART™ Project Awards	155

## FIGURES

	<b>Page</b>	
Figure I.E.1	Styrene Process Cost Comparison	10
Figure I.F.1	Global Distribution of Styrene Demand	14
Figure III.A.1	Mobil/Badger Ethylbenzene Process Flowsheet	25
Figure III.A.2	Block Schematic Diagram of Typical FCC Gas Plant	29
Figure III.A.3	Schematic Flow Diagram for Dilute Ethylene Pretreating	31
Figure III.A.4	Block Schematic Diagram of Mobil/Badger Ethylene Process, Dilute Ethylene	33
Figure III.A.5	Mobil/Badger EBMax <sup>SM</sup> Process Flowsheet	35
Figure III.A.6	Lummus/UOP Ethylbenzene Process	38
Figure III.A.7	Process Flow Diagram of CDTECH Ethylbenzene Process	45
Figure III.A.8	AlCl <sub>3</sub> Catalyzed Ethylbenzene Process	49
Figure III.B.1	Fina/Badger Styrene Process	56
Figure III.B.2	Lummus/UOP CLASSIC Styrene Monomer Process: Dehydrogenation/Distillation	59-60
Figure III.B.3	Lummus/UOP SMART™ Styrene Process	68
Figure III.B.4	Styrene Production Chemistry via the Arco Process	70
Figure III.B.5	Styrene/Propylene Oxide via Arco Process: Peroxidation And Epoxidation	74

## STYRENE/ETHYLBENZENE (94/95-8) JUNE 1996

## FIGURES

	<b>Page</b>	
Figure III.B.6	Styrene/Propylene Oxide via Arco Process: Recovery	75
Figure IV.A.1	Styrene from Butadiene via the Dow Process	81
Figure IV.B.1	Block Flow Diagram: Styrene Synthesis from Methanol and	

	Toluene	86
Figure IV.B.2	Conceptual Flowsheet for Styrene from Toluene and Methanol	87
Figure VI.A.1	Styrene Process Cost Comparison	100
Figure VI.B.1	Styrene Cost via Vapor Phase Alkylation versus Capacity	114
Figure VI.B.2	Styrene Cost via Vapor Phase Alkylation versus Investment	115
Figure VI.B.3	Styrene Cost via Vapor Phase Alkylation versus Ethylene Price: Benzene Price, 9.07 cents per pound	116
Figure VI.B.4	Styrene Cost via Vapor Phase Alkylation versus Ethylene Price: Benzene Price, 13.61 cents per pound	117
Figure VI.B.5	Styrene Cost via Vapor Phase Alkylation versus Ethylene Price: Benzene Price, 18.14 cents per pound	118
Figure VI.B.6	Styrene Cost via Hydroperoxide versus Ethylbenzene Price	119
Figure VI.B.7	Styrene Cost via Dimerization versus Butadiene Price	120
Figure VII.D.1	Global Distribution of Styrene Demand	143