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(57) Abstract: A process for producing a supported cobalt-based Fischer-Tropsch synthesis catalyst includes, in a first activation stage, treating a particulate catalyst precursor with a reducing gas, at a heating rate, HR1, until the precursor has reached a temperature, T₁, where 80°C ≤ T₁ ≤ 180°C, to obtain a partially treated precursor. In a second activation stage, the partially treated precursor is treated with a reducing gas, at a heating rate, HR2, where 0 ≤ HR2 < HR1, for a time, t₁, where t₁ is from 0.1 to 20 hours, to obtain a partially reduced precursor. Thereafter, in a third activation stage, the partially reduced precursor is treated with a reducing gas, at a heating rate, HR3, where HR3 > HR2 until the partially reduced precursor reaches a temperature, T₂. The partially reduced precursor is maintained at T₂ for a time, t₂, where t₂ is from 0 to 20 hours, to obtain an activated catalyst.

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CATALYSTS

THIS INVENTION relates to catalysts. In particular, the invention relates to a process for producing a supported cobalt-based Fischer-Tropsch synthesis catalyst.

As regards supported cobalt-based Fischer-Tropsch synthesis catalysts, it is well-known that precursors of such catalysts are prepared using a metal precursor and a particulate support. The catalyst precursor preparation involves a number of different catalyst preparation steps. The catalyst precursor is then, in an activation process or step, reduced by using a reducing gas such as hydrogen, to obtain an active Fischer-Tropsch synthesis catalyst.

In known activation processes, ie involving reduction of the catalyst precursor in a flowing hydrogen or hydrogen containing gas stream at elevated temperatures, for supported cobalt-based Fischer-Tropsch synthesis catalyst precursors that the Applicant is aware of, hydrogen reduction is carried out at a temperature in the range 250°C to 500°C, and preferably at low pressures and high linear gas velocities to minimize vapour pressure of any product water which enhances sintering of the reduced metal. It is well known that manipulation of the reduction of cobalt oxide to cobalt metal in different ways influences activity and selectivity of the resultant Fischer-Tropsch synthesis catalyst. In particular, US 4605679 discloses that the activity of a cobalt catalyst can be increased by reduction in hydrogen, then re-oxidising the catalyst followed by re-reduction in hydrogen. In US 5292705, it is shown that hydrogen reduction in the presence of hydrocarbon liquids enhances the initial Fischer-Tropsch synthesis performance of the catalyst. US 5585316 claims that the selectivity of heavier Fischer-Tropsch products is increased if the catalyst is first oxidised and then reduced with carbon monoxide. EP 1444040 discloses a two stage reduction step with pure hydrogen with a catalyst precursor in which all reducible cobalt oxide species combined can be described by the formula-unit CoO_aH_b (where: $a \geq 1.7$ and $b > 0$), resulting in a more economical reduction process without sacrificing Fischer-Tropsch synthesis catalyst activity.

Any discussion of the prior art throughout the specification should in no way be considered as an admission that such prior art is widely known or forms part of common general knowledge in the field.

- 5 It is an object of the present invention to overcome or ameliorate at least one of the disadvantages of the prior art, or to provide a useful alternative.

An object of a preferred form of the present invention is to provide a supported cobalt-based Fischer-Tropsch synthesis catalyst having a higher hydrocarbon
10 synthesis activity. Such a catalyst can be obtained with the process of the present invention.

According to the invention, there is provided a process for producing a supported cobalt-based Fischer-Tropsch synthesis catalyst, which process
15 includes

in a first activation stage, treating a particulate supported cobalt-based Fischer-Tropsch synthesis catalyst precursor comprising a catalyst support impregnated with cobalt and containing cobalt oxide, with a hydrogen-containing reducing gas or a nitrogen-containing gas, at a first heating rate, HR1, until the
20 precursor has reached a temperature, T_1 , where $80^{\circ}\text{C} \leq T_1 \leq 180^{\circ}\text{C}$, to obtain a partially treated catalyst precursor;

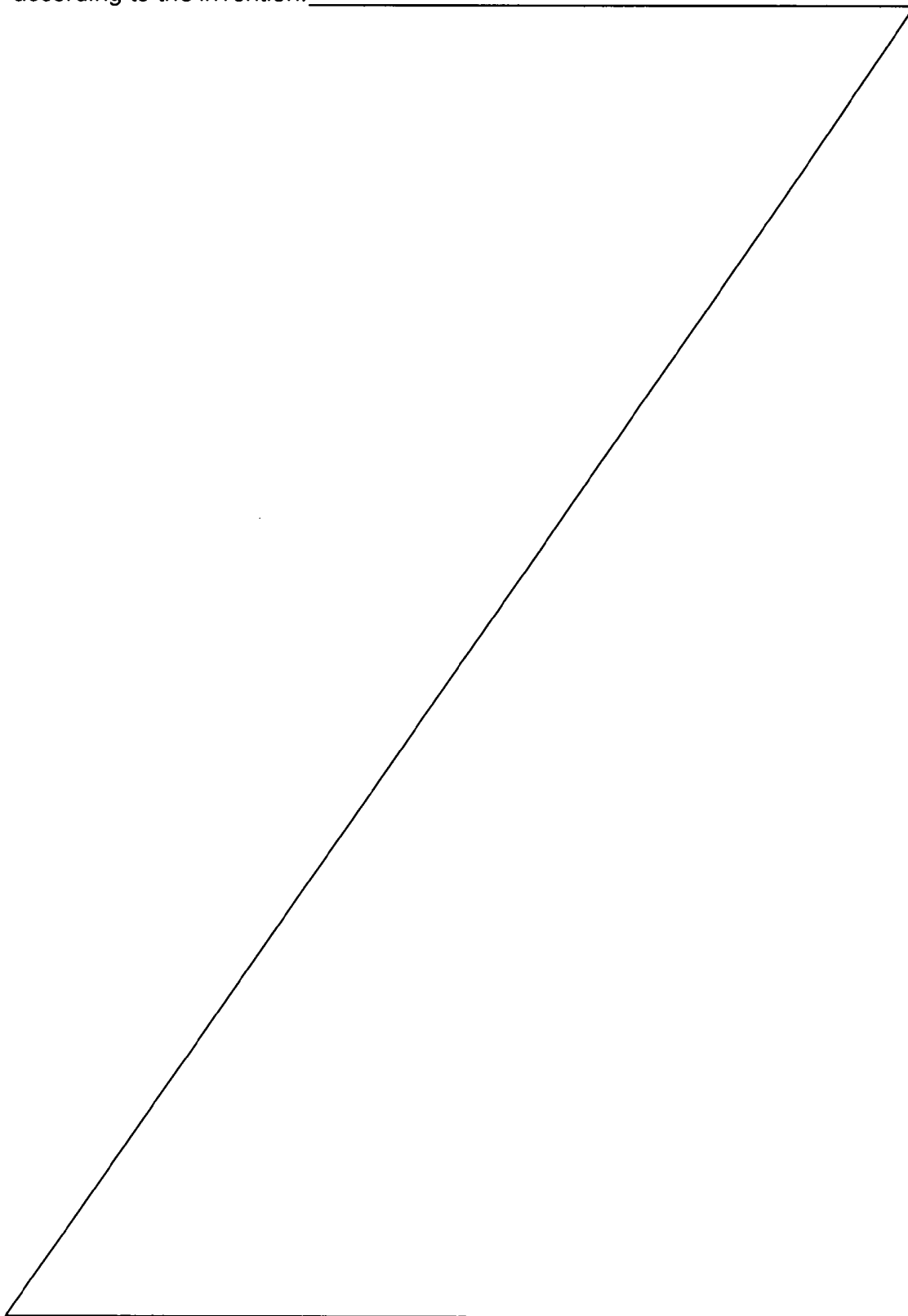
in a second activation stage, treating the partially treated catalyst precursor with a hydrogen-containing reducing gas, at a second heating rate, HR2, where $0 \leq \text{HR2} < \text{HR1}$, for a time, t_1 , where t_1 is from 0.1 to 20 hours, to
25 obtain a partially reduced catalyst precursor; and thereafter

in a third activation stage, treating the partially reduced catalyst precursor with a hydrogen-containing reducing gas, at a third heating rate, HR3, where $\text{HR3} > \text{HR2}$ until the partially reduced catalyst precursor reaches a temperature, T_2 , wherein $300^{\circ}\text{C} \leq T_2 \leq 600^{\circ}\text{C}$ and maintaining the partially reduced catalyst
30 precursor at T_2 for a time, t_2 , where $0 < t_2 \leq 20$ hours, to obtain an activated supported cobalt-based Fischer-Tropsch synthesis catalyst.

2a

According to a further aspect of the invention there is provided a support cobalt-based Fischer-Tropsch synthesis catalyst when produced by the process according to the invention.

5



It was surprisingly found that a supported cobalt-based Fischer-Tropsch synthesis catalyst having high intrinsic activity was obtained when the catalyst precursor was subjected to the reduction or activation procedure of the invention.

5

The treatments in the first, second and third activation stages may, at least in principle, be effected by using any suitable contacting configuration of the catalyst precursor with the reducing gas, such as a fluidized bed of the catalyst precursor particles, with the reducing gas acting as the fluidizing
10 medium; a fixed bed of the catalyst precursor particles through which the reducing gas passes; or the like. However, a fluidized bed configuration is preferred.

The first activation stage commences when the catalyst precursor is first
15 subjected to treatment with the hydrogen-containing reducing gas or the nitrogen-containing gas with the immediate application of the first heating rate HR1. The gas in the first activation stage will have a gas space velocity, SV1. Preferably, $1 \leq SV1 \leq 35 \text{ m}^3/\text{kg red. Co/h}$; more preferably, $3 \leq SV1 \leq 15 \text{ m}^3/\text{kg red. Co/h}$. By 'red.Co' or 'reducible cobalt' is meant the
20 cobalt that can be reduced during normal reduction, eg if the catalyst or catalyst precursor contains 20mass% cobalt and 50% of the cobalt can be reduced, then the amount of reducible cobalt is 0.1g/g catalyst or catalyst precursor. The first activation stage continues until the precursor attains the temperature T_1 .

25

Preferably, $0.5^\circ\text{C}/\text{min} \leq HR1 \leq 10^\circ\text{C}/\text{min}$; more preferably, $1^\circ\text{C}/\text{min} \leq HR1 \leq 2^\circ\text{C}/\text{min}$.

In the first activation stage, T_1 may be $\geq 90^\circ\text{C}$. In one embodiment of the
30 invention, $125^\circ\text{C} \leq T_1 \leq 150^\circ\text{C}$. This embodiment will typically apply to precursors obtained by forming a slurry of a particulate catalyst support, a cobalt compound as an active component precursor, and water; subjecting the catalyst support to impregnation with the cobalt compound; drying the impregnated catalyst support; and calcining the impregnated support, such as precursors B_3 - B_9 ,

hereinafter described in Example 2. In another embodiment of the invention, $80^{\circ}\text{C} \leq T_1 \leq 110^{\circ}\text{C}$, or even $90^{\circ}\text{C} \leq T_1 \leq 110^{\circ}\text{C}$. This embodiment will typically apply to precursors obtained using the above procedure, but including an organic modifier, such as maleic anhydride, during the impregnation step, such as precursors C₂-C₅, hereinafter described in Example 3.

The second activation stage thus commences when the precursor has attained the temperature T_1 , and endures for the time t_1 as hereinbefore described. As regards the second activation stage treatment time t_1 , more preferably $1 \leq t_1 \leq 10$ hours, typically $2 \leq t_1 \leq 6$ hours.

In one embodiment of the invention, in the second activation stage, the precursor may be maintained at the temperature T_1 , ie $HR_2=0$. Thus, the temperature T_1 then constitutes a holding temperature at which the precursor is held for the treatment time t_1 .

However, in another embodiment of the invention, in the second activation stage, the precursor may be heated from the temperature T_1 to a temperature T_H where $T_H > T_1$, ie $HR_2 > 0$, and $T_H < 200^{\circ}\text{C}$. The precursor can, if desired, be held for some time at the temperature T_1 before commencing heating thereof to the temperature T_H .

In the second activation stage, preferably $0.05^{\circ}\text{C}/\text{min} \leq HR_2 \leq 0.5^{\circ}\text{C}/\text{min}$; more preferably $0.1^{\circ}\text{C}/\text{min} \leq HR_2 \leq 0.2^{\circ}\text{C}/\text{min}$.

The third activation stage commences once the time t_1 has elapsed. The precursor thus, at the commencement of the third activation stage and in one embodiment of the invention, will still be at the temperature T_1 , ie at a temperature between 80°C and 180°C . However, in another embodiment of the invention, the precursor will, at the commencement of the third activation stage, be at the higher temperature, T_H . The third activation stage treatment is thus continued until the temperature in the third treatment stage, ie the temperature of the activated Fischer-Tropsch catalyst, reaches T_2 . More preferably, T_2 may

be in the range of 300°C to 500°C, with a typical value of T_2 being in the range of 300°C to 450°C. The catalyst is maintained at T_2 for the time t_2 where $0 < t_2 \leq 20$ hours, more preferably $1 \leq t_2 \leq 10$ hours, typically $2 \leq t_2 \leq 6$ hours.

- 5 The gas will also, in the second activation stage, have a space velocity, hereinafter referred to as SV2, and will also, in the third activation stage, have a space velocity, hereinafter referred to as SV3.

10 In one embodiment of the invention, SV1, SV2 and/or SV3 may be constant during the treatments in their respective activation stages. For example, the relationship of the space velocities in the various stages may be $SV1=SV2=SV3$. However, in another embodiment of the invention, SV1, SV2 and SV3 may vary during the respective activation stages.

- 15 In the first activation stage, a hydrogen-containing reducing gas is preferably used, and the gas used in the three activation stages may have the same composition. By 'hydrogen-containing reducing gas' is meant a hydrogen containing gas mixture comprising $10\text{vol}\% < H_2 \leq 100\text{vol}\%$, more preferably $>90\text{vol}\% H_2$ and $<10 \text{ vol}\%$ inerts, most preferably $>97 \text{ vol}\% H_2$ and $<3\text{vol}\%$
20 inerts. The inerts could be any combination of Ar, He, NH_3 and H_2O , with the preferred dew point of the hydrogen-containing reducing gas being $\leq 4^\circ C$, more preferably $\leq -30^\circ C$.

In the first activation stage, a nitrogen-containing gas can instead be used. By
25 'nitrogen-containing gas' is meant a gas mixture comprising $>90\text{vol}\% N_2$ and $<10\text{vol}\%$ other components, with the other components being any combination of Ar, He, and H_2O . The preferred dew point of the nitrogen-containing gas is $\leq 4^\circ C$, more preferably $\leq -30^\circ C$. This nitrogen containing gas does not contain any hydrogen (ie hydrogen=0vol%).

30

The treatments in the first, second and third activation stages may be effected at the same or different pressures, and may each be effected at about atmospheric pressure, preferably at between 0.6 and 1.3 bar(a).

The particulate supported cobalt-based Fischer-Tropsch synthesis ('FTS') catalyst precursor may be any suitable catalyst precursor requiring activation or reduction to obtain an active Fischer-Tropsch catalyst, and may be that obtained during preparation of a fresh catalyst or from a regenerated catalyst.

5

Thus, it may be that obtained during preparation of a fresh catalyst, ie obtained by forming a slurry of a particulate catalyst support, a cobalt compound as an active component precursor, and water; subjecting the catalyst support to impregnation with the cobalt compound; drying the
10 impregnated catalyst support; and calcining the impregnated support, to obtain the catalyst precursor, which contains cobalt oxide. The catalyst precursor thus obtained must, however, then still be activated or reduced prior to using it for catalyzing a Fischer-Tropsch reaction, and this reduction or activation is effected in accordance with the method of the present invention.
15 The resultant catalyst is thus a fresh activated Fischer-Tropsch catalyst.

Instead, the fresh catalyst precursor can be that obtained using the above procedure, but including an organic modifier, such as maleic anhydride, during the impregnation step.

20

The regenerated catalyst precursor can be that obtained by regenerating a spent cobalt Fischer-Tropsch catalyst, that was used in a FTS process for a period of time, by means of any suitable regeneration process, which results in an oxidized catalyst precursor containing supported cobalt oxide.

25

Any commercially available pre-shaped porous oxide catalyst support, such as alumina (Al_2O_3), silica (SiO_2), titania (TiO_2), magnesia (MgO), $\text{SiO}_2\text{-Al}_2\text{O}_3$ and zinc oxide (ZnO), may be used. The support preferably has an average pore diameter between 8 and 50 nanometers, more preferably between 10
30 and 15 nanometers. The support pore volume may be between 0.1 and 1.5ml/g, preferably between 0.3 and 0.9ml/g.

The support may be a protected modified catalyst support, containing, for example, silicon as modifying component, as generally described in EP

Application No. 99906328.2 (European Publication No. 1058580), which is hence incorporated herein by reference.

5 More specifically, the protected modified catalyst support may be that obtained by contacting a silicon precursor, eg an organic silicon compound such as tetra ethoxy silane ('TEOS') or tetra methoxy silane ('TMOS'), with the catalyst support, eg by means of impregnation, precipitation or chemical vapour deposition, to obtain a silicon-containing modified catalyst support; and
10 calcining the silicon-containing modified catalyst support, eg in a rotary calciner, at a temperature from 100°C to 800°C, preferably from 450°C to 550°C, and for a period of from 1 minute to 12 hours, preferably from 0.5 hour to 4 hours.

The cobalt loading can be between 5gCo/100g support and 70gCo/100g
15 support, preferably between 20gCo/100g support and 55gCo/100g support.

The cobalt salt may, in particular, be cobalt nitrate, $\text{Co}(\text{NO}_3)_2 \cdot 6\text{H}_2\text{O}$.

The impregnation of the catalyst support may, in principle, be effected by any
20 known method or procedure such as incipient wetness impregnation or slurry impregnation. Thus, the impregnation may generally be effected in the manner described in US 6455462 or in US 5733839, and which are thus incorporated herein by reference thereto.

25 More specifically, impregnation may be effected by subjecting, at elevated temperature, a slurry comprising the particulate catalyst support, water, and the cobalt salt to a sub-atmospheric pressure environment, which may be down to 5kPa(a), preferably between atmospheric pressure and 10kPa(a); drying the impregnated carrier at elevated temperature and under a sub-
30 atmospheric pressure environment, which may be as hereinbefore described. Still more specifically, the impregnation may be effected by subjecting the slurry, in an initial treatment stage, to treatment at elevated temperature and under a sub-atmospheric pressure environment as hereinbefore described to impregnate the support with the cobalt salt and to dry the impregnated support

partially, and thereafter, in a subsequent treatment stage, subjecting the partially dried impregnated support to treatment of elevated temperature and under a sub-atmospheric pressure environment as hereinbefore described, such that the temperature in the subsequent treatment stage exceeds that in
5 the initial treatment stage and/or the sub-atmospheric pressure in the subsequent treatment stage is lower than that in the initial treatment stage, thereby to obtain more vigorous drying of the impregnated support in the subsequent treatment stage than in the initial treatment stage, to obtain a dried impregnated support.

10

The impregnation may include subjecting the support to two or more impregnation steps, to obtain a desired cobalt loading. Each impregnation step may then include an initial and a subsequent treatment stage as hereinbefore described.

15

The process may then include, in each of the impregnation steps, controlling the drying rate of the slurry to a specified drying profile.

The support impregnation may thus involve a 2-step slurry phase
20 impregnation process, which is dependent on a desired cobalt loading requirement and the pore volume of the catalyst support.

25

The support impregnation and drying may typically be effected in a conical vacuum drier with a rotating screw or in a tumbling vacuum drier.

During the cobalt impregnation steps, a water soluble precursor salt of platinum (Pt), palladium (Pd), ruthenium (Ru), rhenium (Re) or mixtures thereof, may be added, as a dopant capable of enhancing the reducibility of the active component.

30

Calcination of the impregnated and dried material may be done using any method, known to those skilled in the art, for example in a fluidized bed, or a rotary kiln, calciner at 200-400°C. It may, in particular, be effected as

described in PCT Patent Application WO 01/39882, which is thus also incorporated herein by reference.

The invention extends also to an activated Fischer-Tropsch catalyst, when
5 obtained by the process of the invention.

The activated Fischer-Tropsch catalyst can be used in a process for producing hydrocarbons, which includes contacting a synthesis gas comprising hydrogen (H₂) and carbon monoxide (CO) at an elevated temperature between 180°C and
10 250°C and an elevated pressure between 10 and 40 bar with an activated Fischer-Tropsch catalyst as hereinbefore described, using a Fischer-Tropsch reaction of the hydrogen with the carbon monoxide.

The invention will now be described in more detail with reference to the following
15 non-limiting examples:

EXAMPLE 1

A particulate supported cobalt-based Fischer-Tropsch synthesis catalyst precursor, which, on activation, produces a 30g Co/0.075Pt/1.5Si/100g Al₂O₃
20 proprietary slurry phase Fischer-Tropsch synthesis catalyst of the Applicant, and which is fully described in WO 01/39882, was investigated.

A representative batch of this pre-reduced catalyst precursor was specifically prepared as follows: Puralox SCCa 2/150, pore volume of 0.48ml/g, from
25 SASOL Germany GmbH of Uberseering 40, 22297 Hamburg, Germany was modified with silicon such that the final silicon level was 2.5 Si atoms/nm² of support. TEOS (tetra ethoxy silane) was added to ethanol, alumina (1l ethanol/kg alumina) was added to this solution, and the resultant mixture stirred at 60 °C for 30 minutes. Subsequently the solvent was removed under vacuum
30 with a jacket temperature of the drier equipment of 95 °C. The dried modified support was then calcined at 500 °C for 2 hours. A solution of 17.4kg of Co(NO₃)₂·6H₂O, 9.6g of (NH₃)₄Pt(NO₃)₂, and 11kg of distilled water was mixed with 20.0kg of the above mentioned silica modified gamma alumina

support by adding the support to the solution. The slurry was added to a conical vacuum drier and continuously mixed. The temperature of this slurry was increased to 60°C after which a pressure of 20kPa(a) was applied. During the first 3 hours of the drying step, the temperature was increased slowly and reached 95°C after 3 hours. After 3 hours the pressure was decreased to 3-15kPa(a), and a drying rate of 2.5m%/h at the point of incipient wetness was used. The complete impregnation and drying step took 9 hours, after which the impregnated and dried catalyst support was immediately and directly loaded into a fluidised bed calciner. The temperature of the dried impregnated catalyst support was about 75°C at the time of loading into the calciner. The loading took about 1 to 2 minutes, and the temperature inside the calciner remained at its set point of about 75°C. The dried impregnated catalyst support was heated from 75°C to 250°C, using a heating rate of 0.5°C/min and an air space velocity of 1.0 m³/kg Co(NO₃)₂.6H₂O/h, and kept at 250°C for 6 hours. To obtain a catalyst with a cobalt loading of 30gCo/100gAl₂O₃, a second impregnation/drying/calcination step was performed. A solution of 9.4kg of Co(NO₃)₂.6H₂O, 15.7g of (NH₃)₄Pt(NO₃)₂, and 15.1kg of distilled water was mixed with 20.0kg of the catalyst precursor from the first impregnation and calcination, by adding the catalyst precursor to the solution. The slurry was added to a conical vacuum drier and continuously mixed. The temperature of this slurry was increased to 60°C after which a pressure of 20kPa(a) was applied. During the first 3 hours of the drying step, the temperature was increased slowly and reached 95°C after 3 hours. After 3 hours the pressure was decreased to 3-15kPa(a), and a drying rate of 2.5m%/h at the point of incipient wetness was used. The complete impregnation and drying step took 9 hours, after which the treated catalyst support was immediately and directly loaded into the fluidised bed calciner. The temperature of the dried impregnated catalyst support was about 75°C at the time of loading into the calciner. The loading took about 1 to 2 minutes, and the temperature inside the calciner remained at its set point of about 75°C. The dried impregnated catalyst was heated from 75°C to 250°C, using a heating rate of 0.5°C/min and an air space velocity of 1.0 m³/kg Co(NO₃)₂.6H₂O/h, and kept at 250°C for 6 hours. A supported cobalt catalyst precursor on an alumina support was thus obtained.

One sample of this precursor, identified as Precursor A1, was subjected to a standard one-step reduction or activation procedure as follows:

In a fluidized bed (20mm internal diameter) reduction unit, the catalyst precursor A1 was reduced, at atmospheric pressure, utilizing an undiluted H₂ reducing gas (ie 100vol% H₂) as total feed gas at a space velocity of 13.7 m³_n per kilogram reducible cobalt per hour, whilst applying the following temperature program: heat from 25°C to 425°C at 1°C/min, and hold isothermally at 425°C for 16 hours.

Precursor A1 was thus thereby transformed into comparative Catalysts A1.

Another sample of the precursor, identified as Catalyst precursor A2, was reduced in the same manner as catalyst precursor A1, with the only difference being the isothermal hold at 425°C which was 4 hours for precursor A2.

One further sample of this precursor, identified as Precursor B1, was subjected to the following 3-stage reduction procedure

(i) in a first activation stage, the sample was heated from 25°C to 140°C at a first heating rate of 1°C/min;

(ii) in a second activation stage, the sample was held at the same space velocity as was used in the first activation stage, and at the temperature of 140°C, for 3 hours;

(iii) in a third activation stage, the sample was heated from 140°C to 425°C at a heating rate of 1°C/min and using the same space velocity as in the first and second activation stages; the temperature was held at 425°C for 16 hours.

This reduction procedure was also carried out in the fluidized bed reduction unit hereinbefore described, and the same undiluted H₂ reducing gas (ie 100vol% H₂) was used in all three activation stages. During all three stages a space velocity of 13.7m³_n/kg reducible cobalt/hour was used.

Thus, Precursor B1 was subjected to a 3-stage reduction/activation procedure in accordance with the invention, to obtain Catalyst B1 which is thus in accordance with the invention.

- 5 During reduction, precursors A1, A2 and B1 were thus transformed into Fischer-Tropsch synthesis ('FTS') Catalysts A1, A2 and B1 respectively. These catalysts were evaluated in a laboratory scale reactor under realistic FTS conditions (230°C, between 16,2-16,4 bar of H₂ and CO pressure in inlet gas mixture, H₂:CO inlet ratio of 1.9:1 achieving synthesis gas conversions of
10 60 ± 5%).

Table 1: Summary of the FTS runs of Example 1

Run	Catalyst	CH ₄ sel. (%) [*]	RIAF (relative to catalyst A1)	Time (hours)
198£	A1 (comparative)	6.4	1.00	15
CB036	A2 (comparative)	-	1.04	15
406\$	B1	6.8	1.25	21

15

RIAF = Relative Intrinsic Fischer-Tropsch synthesis Activity Eactor

From Table 1, it is evident that the 3-stage reduction in accordance with the
20 invention did not influence the selectivity of the catalyst towards methane formation.

From Table 1(RIAF data) it is clear that the activity of the 3-stage reduced catalyst B (run 406\$) is significantly higher than that of the standard reduced
25 catalyst A1 or A2 (run 198£ and CB036 respectively) after 1 day online.

The Relative Intrinsic Fischer-Tropsch synthesis Activity Eactor ('RIAF_x') of a supported cobalt slurry phase catalyst, of which the pre-reduction catalyst

precursor has been prepared in strict accordance with a prescribed catalyst preparation procedure X, ie catalyst precursor X, is defined as:

$$RIAF_x = [A_{xi}/A_x] \dots\dots\dots (1)$$

5 where:

- a) A_{xi} is the Arrhenius pre-exponential factor of catalyst precursor X, activated according to an arbitrary reduction procedure
- b) A_x is the Arrhenius pre-exponential factor of catalyst precursor X, estimated from the 15 hours on stream slurry-phase Continuous Stirred Tank Reactor (CSTR) Fischer-Tropsch synthesis performance under realistic conditions, and having utilized the standard one step reduction procedure:

10 Fluidized bed (20mm internal diameter) reduction of 15±5g catalyst precursor A (ie pre-reduction catalyst mass), at atmospheric pressure utilizing an undiluted H₂ reducing gas (purity of 5.0) as total feed at a space velocity of 13700mℓ_n per gram reducible cobalt per hour, whilst applying the following temperature program: heat from 25°C to 425°C at 1°C/min, and hold isothermally at 425°C for 16 hours.

- c) The pre-exponential factor A, ie applicable to both A_{xi} and A_x , is defined from the generally accepted cobalt-based Fischer-Tropsch empirical kinetic expression:

$$r_{FT} = [Ae^{(-Ea/RT)}P_{H_2}P_{CO}]/[1+KP_{CO}]^2 \dots\dots\dots (2)$$

Thus:

$$25 \quad A = [r_{FT} (1+KP_{CO})^2]/[e^{(-Ea/RT)}P_{H_2}P_{CO}] \dots\dots\dots (3)$$

where:

30 r_{FT} is expressed in terms of the number of moles of CO converted into Fischer-Tropsch synthesis products per unit time per unit mass of the catalyst precursor in its pre-reduction state.

- d) x is any catalyst precursor.

EXAMPLE 2

Catalyst precursors B_i ($i = 3$ to 9) are also particulate supported cobalt-based Fischer-Tropsch synthesis catalyst precursors, which, on activation, produce 30g Co/0.075Pt/1.5Si/100g Al_2O_3 proprietary slurry phase Fischer-Tropsch synthesis catalysts of the Applicant, and which are fully described in
5 WO 01/39882. They were produced in similar fashion to catalyst precursors A1, A2 and B1 described in Example 1.

Samples of this precursor, identified as Precursor B_i , were subjected to the
10 following 3-stage reduction procedure (Table 2):

- (i) in a first activation stage, the sample was heated from $25^\circ C$ to $X^\circ C$ at a first heating rate of $1^\circ C/min$ and using gas mixture Y;
- (ii) in a second activation stage, the sample was held at the same space velocity as was used in the first activation stage, and at the
15 temperature of $X^\circ C$, for 3 hours using gas mixture V;
- (iii) in a third activation stage, the sample was heated from $X^\circ C$ to $425^\circ C$ at a heating rate of $1^\circ C/min$ and using the same space velocity as in the first and second activation stages; the temperature was held at $425^\circ C$ for 4 hours.

20

This reduction procedure was also carried out in the fluidized bed reduction unit hereinbefore described. During all three stages, a total space velocity of $13.7m_n^3/kg$ reducible cobalt/hour was used.

25 Thus, precursors B_i were subjected to a 3-stage reduction/activation procedure in accordance with the invention, to obtain Catalysts B_i . Precursors B_3 - B_9 were subjected to the 3-stage reduction/activation procedure in accordance with the invention, and hence corresponding Catalysts B_3 - B_9 are also in accordance with the invention

30

During reduction, precursors B_i ($i = 3$ to 9) were thus transformed into Fischer-Tropsch synthesis ('FTS') Catalysts B_i ($i = 3$ to 9) respectively. These catalysts were evaluated in a laboratory scale reactor under realistic FTS conditions ($230^\circ C$, 17.5 bar_g pressure, $H_2:CO$ inlet ratio of 1.9:1, inlet gas contains 15%

inerts (hence 85% of inlet is H₂ and CO), and at synthesis gas conversions of between 50 and 65%).

Table 2: Summary of the FTS runs of Catalysts B_i

Catalysts	Temperature X°C	Gas mixture Y	Gas mixture V	Run	RIAF after 15 hours on line relative to sample A
Al (comp)	-	-	-	198E	1.00
A ₂ (comparative)	-	-	-	CB036	1.04
B ₃	125	100% H ₂	100% H ₂	CC037	1.12
B ₄	130	100% H ₂	100% H ₂	CC032	1.21
B ₅	135	100% H ₂	100% H ₂	CC033	1.27
B ₆	140	100% H ₂	100% H ₂	CC035	1.22
B ₇	145	100% H ₂	100% H ₂	CC041	1.21
B ₈	150	100% H ₂	100% H ₂	CC030	1.09
B ₉	140	N ₂	100% H ₂	CC036	1.22

5

It can be concluded from Table 2 that catalysts prepared according to the 3-stage reduction process of the invention, using the correct gas mixtures and temperatures, have increased catalyst activities.

10 EXAMPLE 3

A 30g Co/0.075g Pt/100g (1.5g Si/100g Puralox SCCa 2/150) slurry phase Fischer-Tropsch synthesis ("FTS") catalyst was prepared on a particulate modified 1.5g Si/100g Puralox SCCa 2/150 (trademark) pre-shaped support using aqueous slurry phase impregnation and drying, followed by direct
 15 fluidised bed calcination as disclosed generally in US 5733839, WO 99/42214 and WO 00/20116, which are hence incorporated herein by reference. Puralox SCCa 2/150 is a pure pre-shaped gamma-alumina particulate catalyst support, and is prepared by calcination of boehmite. However, in this case the support has been modified, during manufacture thereof, so that it contains
 20 1.5g Si/100g support. For this manufacture, the procedure used was as is described in WO 99/42214.

In particular, the catalyst was prepared as follows:

43.70g $\text{Co}(\text{NO}_3)_2 \cdot 6\text{H}_2\text{O}$ was dissolved in 40ml distilled water, and 0.024g of $\text{Pt}(\text{NH}_3)_4 \cdot (\text{NO}_3)_2$ (dissolved in 10ml distilled water) and 3.75 grams of maleic anhydride were added to this solution in a 500ml round ball flask in a
 5 rotorvapor at 60°C and atmospheric pressure, whereafter 50.0g of the 1.5g Si/100g Puralox SCCa 2/150 modified pre-shaped support was added to the solution. Aqueous slurry phase impregnation and vacuum drying was effected using the following procedure:

Temperature of oil bath (°C)	Rotorvapor pressure (mbar)(a)	Time (minutes)
60	Atmospheric	10
60	260	30
70	260	90
85	260	60
85	50	240

10

This vacuum dried intermediate was directly subjected to a fluidized bed calcination step, according to the following procedure:

- Continuous air flow of 1.7 dm^3/min
- Temperature program:

15

From 25°C to 250°C at 1°C/min and keeping it at 250°C for 6 hours

50.0g of this intermediate calcined material was subjected to the following 2nd cobalt/platinum impregnation and calcination step:

20 23.51g $\text{Co}(\text{NO}_3)_2 \cdot 6\text{H}_2\text{O}$ was dissolved in 40ml distilled water and 0.039g of $\text{Pt}(\text{NH}_3)_4 \cdot (\text{NO}_3)_2$ (dissolved in 10ml distilled water) was added to this solution in a 500ml round ball flask in a rotorvapor at 60°C and atmospheric pressure, and 50.0g of the ex 1st cobalt/platinum impregnated and calcined intermediate was added. Aqueous slurry phase impregnation and vacuum drying was
 25 effected via the following procedure:

Temperature of oil bath (°C)	Rotorvapor pressure (mbar)(a)	Time (minutes)
60	Atmospheric	10
60	260	30
70	260	90
85	260	60
85	50	240

This vacuum dried intermediate was directly subjected to a fluidized bed calcination step, according to the following procedure:

- Continuous air flow of 1.7 dm³_n/min
- Temperature program:
From 25°C to 250°C at 1°C/min and keeping it at 250°C for 6 hours

10 In preparation for laboratory scale slurry phase continuous stirred tank reactor ('CSTR') Fischer-Tropsch synthesis (FTS) runs, this calcined material was reduced in accordance with the following procedure, and wax coated:

15 Samples of this precursor, identified as Precursor C_i, were subjected to the following 3-stage reduction procedure (Table 3)

- (i) in a first activation stage, the sample was heated from 25°C to X°C at a first heating rate of 1°C/min and using pure 100% hydrogen;
- (ii) in a second activation stage, the sample was held at the same space velocity as was used in the first activation stage, and at the temperature of X°C, for 3 hours using pure 100% hydrogen;
- (iii) in a third activation stage, the sample was heated from X°C to 425°C at a heating rate of 1°C/min and using the same space velocity as in the first and second activation stages; the temperature was held at 425°C for 10 hours.

This reduction procedure was also carried out in the fluidized bed reduction unit hereinbefore described. During all three stages a total space velocity of $13.7\text{m}_n^3/\text{kg}$ reducible cobalt per hour was used.

- 5 Thus, precursors C_i ($i=2-5$) were subjected to a 3-stage reduction/activation procedure in accordance with the invention, to obtain Catalysts C_i ($i=2-5$) which were thus in accordance with the invention.

- 10 During reduction, precursors C_i ($i= 1$ to 5) were thus transformed into Fischer-Tropsch synthesis ('FTS') Catalysts C_i ($i=1$ to 5) respectively. These catalysts were evaluated in a laboratory scale reactor under realistic FTS conditions (230°C , 17.0 bar_g pressure, $\text{H}_2:\text{CO}$ inlet ratio of $1.6:1$, inlet contains 15% inerts (hence 85% of inlet is H_2 and CO), and at synthesis gas conversions of between 50 and 65%).

15

Table 3: Summary of the FTS runs of Catalysts C_i

Catalysts	Temperature $X^\circ\text{C}$	Run	RIAF _{1,6} after 15 hours on line relative to that of C_1
C_1 (comparitive)	70	BG009	1.00
C_2	80	BG010	1.09
C_3	90	BH008	1.14
C_4	100	BG007	1.10
C_5	110	BH007	1.17

- 20 It can be concluded from Table 3 that catalysts containing $30\text{gCo}/100\text{gAl}_2\text{O}_3$ and prepared by using organic modifiers (ie maleic anhydride) and reduced according to the 3-stage process of the invention, using the correct temperature during the first activation stage, have increased catalyst activities.

EXAMPLE 4

- 25 A particulate supported cobalt-based Fischer-Tropsch synthesis catalyst precursor, which, on activation, produces an $18\text{g Co}/0.15\text{g Pd}/1.5\text{g Si}/100\text{g}$

Al₂O₃ proprietary slurry phase Fischer-Tropsch synthesis catalyst of the Applicant, and which is fully described in WO 01/39882, was investigated.

A representative batch of this pre-reduced catalyst precursor was specifically prepared as follows: Puralox SCCa 2/150, pore volume of 0.48ml/g, from SASOL Germany GmbH of Uberseering 40, 22297 Hamburg, Germany was modified with silicon such that the final silicon level was 2.5 Si atoms/nm² of support. TEOS (tetra ethoxy silane) was added to ethanol, alumina (1l ethanol/kg alumina) was added to this solution, and the resultant mixture stirred at 60 °C for 30 minutes. Subsequently the solvent was removed under vacuum with a jacket temperature of the drier equipment of 95°C. The dried modified support was then calcined at 500°C for 2 hours. A solution of 88.89 g of Co(NO₃)₂·6H₂O, 2.297 g of a 6.53% (NH₃)₄Pd(NO₃)₂ aqueous solution, and 100 ml of distilled water was placed in a 1000 ml Büchi round bottom flask, connected in a Büchi evaporator and heated in an oil bath to 60°C. 100.0 g of the above mentioned silica modified gamma alumina support was added to the solution. The slurry was continuously mixed. After 10 minutes 200 mbar vacuum was drawn on the flask. The mixing was continued at the mentioned conditions. After 30 minutes the temperature was increased to 70°C. After 90 minutes the temperature was increased to 85°C. After 60 minutes the vacuum was increased to 50 mbar. Mixing was continued at these conditions for 240 minutes. The complete impregnation and drying step took 7 hours and 10 minutes, after which the impregnated and dried catalyst support was immediately and directly loaded into a fluidised bed calciner. The dried impregnated catalyst was heated from the catalyst temperature ±50°C to 290°C, using a heating rate of 1.0°C/min and an air space velocity of 1.0 m³_n/kg Co(NO₃)₂·6H₂O/h, and kept at 290°C for 6 hours. A supported cobalt catalyst precursor on an alumina support was thus obtained.

One sample of this precursor, identified as Precursor **D**₁, was subjected to a standard reduction or activation procedure as follows:

In a fluidized bed (20mm internal diameter) reduction unit, the catalyst precursor **D**₁ was reduced, at atmospheric pressure, utilizing an undiluted H₂ reducing gas as total feed gas at a space velocity of 22.8 m³_n per kilogram

reducible cobalt per hour, whilst applying the following temperature program: heat from 25°C to 425°C at 1°C/min, and hold isothermally at 425°C for 4 hours. Precursor **D**₁, was thus thereby transformed into comparative Catalyst **D**₁.

5

Samples of this precursor, identified as Precursor **D**_{*i*} (*i*=2-4) were subjected to the following sequential reduction procedure (Table 4)

- (i) in a first activation stage, the sample was heated from 25°C to X°C at a first heating rate of 1°C/min and using pure 100% hydrogen;
- 10 (ii) in a second activation stage, the sample was held at the same space velocity as was used in the first activation stage, and at the temperature of X°C, for 3 hours using pure 100% hydrogen;
- (iii) in a third activation stage, the sample was heated from X°C to 425°C at a heating rate of 1°C/min and using the same space velocity as in the first and second activation stages; the temperature was held at 425°C
15 for 4 hours.

This reduction procedure was also carried out in the fluidized bed reduction unit hereinbefore described. During all three stages a total space velocity of
20 22.8 m_n³/kg reducible cobalt per hour was used.

Thus, Precursors **D**_{*i*} (*i*= 2 to 4) was subjected to a 3-stage reduction/activation procedure in accordance with the invention, to obtain Catalysts **D**_{*i*} which are thus in accordance with the invention.

25

During reduction, precursors **D**_{*i*} (*i*= 1 to 4) were thus transformed into Fischer-Tropsch synthesis ('FTS') Catalysts **D**_{*i*} (*i*=1 to 4) respectively. These catalysts were evaluated in a laboratory scale reactor under realistic FTS conditions (230°C, 17.0 bar_g pressure, H₂:CO inlet ratio of 1.6:1, inlet contains 15% inerts
30 (hence 85% of inlet is H₂ and CO), and at synthesis gas conversions of between 50 and 65%).

Table 4: Summary of the FTS runs of Catalysts D_i

Catalysts	Temperature X°C	Run	RIAF _{1.6} after 15 hours on line relative to that of D_1
D_1 (comparative)		BI015	1.00
D_2	110	BL017	1.08
D_3	120	BK019	1.12
D_4	130	BI014	1.15

It can be concluded from table 4 that the catalysts precursors containing 18gCo/100gAl₂O₃ and using Pd as a promoter that were reduced according to the 3-stage process, using the correct temperature during the 2-stage, results in catalysts with increased catalyst activities.

EXAMPLE 5

Catalyst precursor E is also particulate supported cobalt-based Fischer-Tropsch synthesis catalyst precursor, which, on activation, produces a 30g Co/0.075Pt/1.5Si/100g Al₂O₃ proprietary slurry phase Fischer-Tropsch synthesis catalyst of the Applicant, and which is fully described in WO 01/39882. It was produced in similar fashion to catalyst precursors A and B.

15

A sample of this precursor, identified as Precursor E, was subjected to the following 3 stage reduction procedure (Table 5):

- (i) in a first activation stage, the sample was heated from 25°C to 120°C at a first heating rate of 1°C/min using undiluted hydrogen;
- (ii) in a second activation stage, sample B was heated from 120°C to 140°C at a second heating rate of 0,11°C/minute at the same space velocity as was used in the first activation stage,
- (iii) in a third activation stage, the sample was heated from 140°C to 425°C at a heating rate of 1°C/min and using the same space velocity as in the first and second activation stages; the temperature was held at 425°C for 4 hours.

25

This reduction procedure was also carried out in the fluidized bed reduction unit hereinbefore described. During all three stages a total space velocity of $13.7\text{m}_n^3/\text{kg}$ reducible cobalt per hour was used.

- 5 Thus, Precursor E was subjected to a 3-stage reduction/activation procedure in accordance with the invention, to obtain Catalyst E which is thus in accordance with the invention.

- 10 During reduction, precursor E was thus transformed into Fischer-Tropsch synthesis ('FTS') Catalyst E. This catalyst was evaluated in a laboratory scale reactor under realistic FTS conditions (230°C , 17.5 bar_g pressure, $\text{H}_2:\text{CO}$ inlet ratio of 1.9:1, inlet contains 15% inerts (hence 85% of inlet is H_2 and CO), and at synthesis gas conversions of between 50 and 65%).

- 15 Table 5: Summary of the FTS runs of Catalysts A and E

Catalysts	Stage 2 conditions	Gas mixture	Run	RIAF after 15 hours on line relative to sample A
A		100% H_2	198£	1.00
E	Ramping from 120 to 140°C with a ramp rate of 0,11	100% H_2	CC042	1.20

- It can be concluded from Table 5 that the catalyst precursor that was reduced according to the 3-stage reduction process of the invention, using the correct slow heating rate during activation stage 2, results in a catalyst with increased catalyst activity.
- 20

EXAMPLE 6

A spent cobalt FTS catalyst sample containing 30gCo/100g support that was used during Fischer-Tropsch synthesis for a period of time was regenerated by means of the following procedure:

- 5 The wax coated spent catalyst was hydrogenated in hydrogen at 350°C and after cooling down passivated with dry ice (ie CO₂). The passivated catalyst sample was subsequently subjected to oxidation in a laboratory fluidized bed calcination unit using air. This regenerated catalyst precursor is catalyst precursor F.

10

Catalyst precursor F1 was reduced using the following standard one-step comparative procedure:

- The oxidized catalyst precursor was subjected to the following reduction procedure in a fluidized bed laboratory reduction unit: hydrogen space velocity of 1500mℓ_n/(g catalyst)/hr; heating rate of 1°C/min up to a temperature of 425°C; held at 425°C for 16 hours. After cooling down to room temperature under hydrogen, the reduced (activated) catalyst was unloaded into wax, prior to re-use.

- 20 Catalyst precursor F2 was reduced using the 3-stage reduction procedure of the invention:

The oxidized catalyst precursor was subsequently subjected to the following reduction procedure in a fluidized bed laboratory reduction unit, with hydrogen space velocity of 1500mℓ_n/(g catalyst)/hr:

- 25 (i) heating rate of 1°C/min up to a temperature of 90°C;
(ii) heating rate of 0.07°C/min from 90°C to 160°C and
(iii) a heating rate of 1°C/min from 160°C up to 425°C and held at 425°C for 16 hours. After cooling down to room temperature (±25°C) under hydrogen, the reduced (activated) catalyst wax unloaded into
30 wax, prior to re-use.

The samples regenerated using the standard reduction procedure (ie F1) and the 3-stage reduction procedure (ie F2) were tested for their Fischer-Tropsch synthesis performance in a laboratory micro slurry reactor (see Table 6).

Table 6: Summary of the FTS runs of Catalysts F_i

Catalysts	Run	RIAF _{1.6} after 15 hours on line relative to that of F ₁
F1 (comparative)	480Yen	1.00
F2	490Yen	1.13

It can be concluded from Table 6 that the regenerated catalyst precursor that
 5 is reduced according to the 3-stage process of the invention, result in a
 catalyst with increased catalyst activity.

EXAMPLE 7

Another spent cobalt FTS catalyst sample containing 30gCo/100g support that
 10 was used during Fischer-Tropsch synthesis for a period of time was
 regenerated by means of the following procedure:

The wax coated spent catalyst was hydrogenated in hydrogen at 350 °C and
 after cooling down passivated with dry ice (ie CO₂). The passivated catalyst
 sample was subsequently subjected to oxidation in a laboratory fluidized bed
 15 calcination unit using air. This regenerated catalyst precursor is catalyst
 precursor G.

Catalyst precursor G1 was reduced using the following standard one-step
 comparative procedure:

20 The oxidized catalyst precursor was subjected to the following reduction
 procedure in a fluidized bed laboratory reduction unit: hydrogen space velocity
 of 1500ml_n/(g catalyst)/hr; heating rate of 1°C/min up to a temperature of
 425°C; held at 425°C for 16 hours. After cooling down to room temperature
 under hydrogen, the reduced (activated) catalyst was unloaded into wax, prior
 25 to re-use.

Catalyst precursor G2 was reduced using the 3-stage procedure of the invention:

The oxidized catalyst precursor was subsequently subjected to the following reduction procedure in a fluidized bed laboratory reduction unit; with hydrogen

5 space velocity of 1500m³/(g catalyst)/hr;

(i) heating rate of 1°C/min up to a temperature of 130°C;

(ii) hold time of 3 hours at 130°C

(iii) a heating rate of 1°C/min from 130°C up to 425°C and held at 425°C
 10 for 16 hours. After cooling down to room temperature (±25°C) under hydrogen, the reduced (activated) catalyst was unloaded into wax, prior to re-use.

The samples regenerated using the standard reduction procedure (ie G1) and the 3-stage reduction procedure (ie G2) were tested for their Fischer-Tropsch
 15 synthesis performance in a laboratory micro slurry reactor (see Table 7).

Table 7: Summary of the FTS runs of Catalysts G_i

Catalysts	Run	RIAF _{1.6} after 15 hours on line relative to that of G1
G1 (comparative)	BF039	1.00
G2	BC084	1.17

20 It can be concluded from table 7 that regenerated catalysts precursor that was reduced according to the 3-stage process, result in a catalyst with increased catalyst activities.

THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:-

1. A process for producing a supported cobalt-based Fischer-Tropsch synthesis catalyst, which process includes

5 in a first activation stage, treating a particulate supported cobalt-based Fischer-Tropsch synthesis catalyst precursor comprising a catalyst support impregnated with cobalt and containing cobalt oxide, with a hydrogen-containing reducing gas or a nitrogen-containing gas, at a first heating rate, HR1, until the precursor has reached a temperature, T_1 , where $80^{\circ}\text{C} \leq T_1 \leq 180^{\circ}\text{C}$, to obtain a partially treated catalyst precursor;

10 in a second activation stage, treating the partially treated catalyst precursor with a hydrogen-containing reducing gas, at a second heating rate, HR2, where $0 \leq \text{HR2} < \text{HR1}$, for a time, t_1 , where t_1 is from 0.1 to 20 hours, to obtain a partially reduced catalyst precursor; and thereafter

15 in a third activation stage, treating the partially reduced catalyst precursor with a hydrogen-containing reducing gas, at a third heating rate, HR3, where $\text{HR3} > \text{HR2}$ until the partially reduced catalyst precursor reaches a temperature, T_2 , where $300^{\circ}\text{C} \leq T_2 \leq 600^{\circ}\text{C}$ and maintaining the partially reduced catalyst precursor at T_2 for a time, t_2 , where $0 < t_2 \leq 20$ hours, to obtain an activated supported cobalt-based Fischer-Tropsch synthesis catalyst.

20

2. A process according to Claim 1 wherein, in the first activation stage, $0.5^{\circ}\text{C}/\text{min} \leq \text{HR1} \leq 10^{\circ}\text{C}/\text{min}$.

25 3. A process according to Claim 1 wherein, in the first activation stage, $1^{\circ}\text{C}/\text{min} \leq \text{HR1} \leq 2^{\circ}\text{C}/\text{min}$.

4. A process according to any one of Claims 1 to 3 wherein, in the second activation stage, $1 \leq t_1 \leq 10$ hours.

30 5. A process according to Claim 4 wherein, in the second activation stage, $2 \leq t_1 \leq 6$ hours.

6. A process according to any one of Claims 1 to 5 wherein, in the second activation stage, the precursor is maintained at the temperature T_1 .
7. A process according to any one of Claims 1 to 6 wherein, in the second
5 activation stage, $0.05^\circ\text{C}/\text{min} \leq \text{HR2} \leq 0.5^\circ\text{C}/\text{min}$.
8. A process according to Claim 7 wherein, in the second activation stage
 $0.1^\circ\text{C}/\text{min} \leq \text{HR2} \leq 0.2^\circ\text{C}/\text{min}$.
- 10 9. A process according to any one of Claims 1 to 8 wherein, in the third
activation stage, $1 \leq t_2 \leq 10$ hours.
10. A process according to any one of Claims 1 to 9, wherein the space
velocity of the gas is constant during the treatments in the first, second and third
15 stages.
11. A process according to any one of Claims 1 to 10, wherein the treatments
in the first, second and third activation stages are each effected at a pressure
between 0.6 and 1.3 bar(a).
- 20 12. A process according to any one of Claims 1 to 11, wherein a hydrogen-
containing reducing gas is used in the first activation stage, with the hydrogen-
containing reducing gas in each of the activation stages comprising $>90\text{vol}\% \text{H}_2$
and $<10\text{vol}\%$ inerts.
- 25 13. A process according to Claim 12, wherein the hydrogen-containing gas in
each of the activation stages comprises $>97\text{vol}\% \text{H}_2$ and $<3\text{vol}\%$ inerts.
14. A support cobalt-based Fischer-Tropsch synthesis catalyst when
30 produced by the process according to any one of claims 1 to 13.
15. A process for producing a supported cobalt-based Fischer-Tropsch
synthesis catalyst or a supported cobalt-based Fischer-Tropsch synthesis

catalyst when produced by the method substantially as herein described with reference to any one of the embodiments of the invention illustrated in the accompanying drawings and/or examples.