



Standard Test Method for Total Nickel in Fresh Alumina-Base Catalysts¹

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1. Scope

1.1 This test method covers the determination of nickel in fresh alumina-base catalysts and has been tested at nickel concentrations from 2.5 to 60 weight %, expressed as nickel oxide (NiO).

1.2 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to its use.*

2. Referenced Documents

2.1 ASTM Standards:

D 1193 Specification for Reagent Water²

E 105 Practice for Probability Sampling of Materials³

E 177 Practice for Use of the Terms Precision and Bias in ASTM Test Methods³

E 456 Terminology Relating to Quality and Statistics³

E 691 Practice for Conducting an Interlaboratory Study to Determine Precision of a Test Method³

3. Summary of Test Method

3.1 The test specimen (as received) is treated with concentrated hydrochloric acid to solubilize the nickel. If necessary, nickel is recovered from any insoluble residue by potassium pyrosulfate fusion, after hydrofluoric-sulfuric acid treatment to remove silica. Ammonium citrate is added to complex the aluminum and buffer the solution. Nickel is precipitated as nickel dimethylglyoxime, Ni (C₄H₇O₂N₂)₂, at a weakly alkaline pH. The precipitate is washed and weighed as Ni (C₄H₇O₂N₂)₂ after drying at 120°C.

3.2 A separate test specimen is taken to determine loss on ignition (LOI) at 550°C. The value is used to calculate the nickel as percent nickel oxide (NiO) on a 550°C dry basis.

4. Significance and Use

4.1 This test method sets forth a procedure by which

catalyst samples can be compared either on an interlaboratory or intralaboratory basis. It is anticipated that catalyst producers and users will find this method of value.

5. Interferences

5.1 Cobalt, molybdenum, and aluminum do not interfere. Interferences by elements that precipitate as hydroxides, such as iron, chromium, aluminum, lead, tin, manganese, titanium, and zirconium, are avoided by the addition of ammonium citrate before making the solutions ammoniacal. Copper, present in the 2 to 10 % range, tends to be co-precipitated with the nickel dimethylglyoxime. The only other metal ions precipitated by dimethylglyoxime are palladium, gold, and bismuth.

6. Apparatus

6.1 *Beakers*, 600-mL, 150-mL.

6.2 *Hotplate*.

6.3 *Furnace*, electric muffle. Calibrated and capable of maintaining temperatures of 550 ± 25°C, and 950 ± 25°C.

6.4 *Platinum Dishes*, 100-mL³ capacity.

6.5 *Mortar and Pestle*, agate, or equivalent mechanical grinder.

6.6 *Crucibles*, sintered-glass, 30-mL, medium porosity frit.

6.7 *Fiber-Glass Filter*, 3.2 cm.

6.8 *Drying Oven* capable of maintaining a temperature of 120°C.

6.9 *Vacuum Filtering Flask*, 500-mL.

6.10 *Filter Holder* and *Filter Disk*, Millipore 0.65 μm-47-mm diameter.

6.11 *pH Paper* to detect a value of 9.

6.12 *Screen*, 250-μm openings, 60-mesh.

6.13 *Analytical Balance*, capable of weighing to nearest 0.1 mg.

6.14 *Ashless Filter Pulp*.

6.15 *Desiccator*.

7. Reagents

7.1 *Purity of Reagents*—Reagent grade chemicals shall be used in all tests. Unless otherwise indicated, it is intended that

¹ This test method is under the jurisdiction of Committee D-32 on Catalysts and is the direct responsibility of Subcommittee D32.03 on Chemical Analysis.

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² *Annual Book of ASTM Standards*, Vol 11.01

³ *Annual Book of ASTM Standards*, Vol 14.02.

all reagents shall conform to the specifications of the Committee on Analytical Reagents of the American Chemical Society, where such specifications are available.⁴ Other grades may be used, provided it is first ascertained that the reagent is of sufficiently high purity to permit its use without lessening the accuracy of the determination.

7.2 *Purity of Water*—Unless otherwise indicated, references to water shall be understood to mean type IV reagent water as defined in Specification D 1193.

7.3 *Ammonium citrate*, dibasic crystal, $(\text{NH}_4)_2\text{HC}_6\text{H}_5\text{O}_7$.

7.4 *Ammonium Hydroxide*, 10 and 25 % solutions.

7.5 *Hydrochloric acid*, concentrated 38 %.

7.6 *Hydrofluoric acid* concentrated 48 %.

7.7 *Methyl Red Indicator*—(o-Carboxy benzene azodimethylaniline). Dissolve 0.02 g in 60-mL reagent grade ethanol. Add 40.0 mL of distilled water.

7.8 *4A Molecular Sieve*, activated for 2 h at 275°C.

7.9 *Potassium Hydrogen Sulfate*, fused power-acid-flux grade.

7.10 *Sodium Dimethylglyoxime*, 8-Hydrate, crystal, $\text{CH}_3\text{C}:\text{NONaC}:\text{NONaCH}_3\cdot 8\text{H}_2\text{O}$. Prepare a 1 weight % per volume solution in water.

7.11 *Sulfuric Acid*, 10 and 50 % solutions.

NOTE 1—The sodium salt of dimethylglyoxime is recommended, rather than the organic reagent, dimethylglyoxime because the salt is water soluble. Large excesses added to precipitate the nickel do no harm as the excess dimethylglyoxime is eliminated during the filtration and washing part of the procedure. The organic reagent, dimethylglyoxime, is not very soluble in water and is often added as a 1 % solution in ethanol. When added in this way, some of the excess reagent may contaminate the precipitated nickel complex. For this reason an aqueous solution of the sodium salt is preferred. If the alcohol solution of dimethylglyoxime is to be used, add an amount so that the alcohol content of the sample solution does not exceed 50 % or some of the precipitated nickel dimethylglyoximate may dissolve.

8. Sampling

8.1 The selection of a representative analytical sample from the bulk material is outside the scope of the present test method. It is presumed that parties using this test method for comparison purposes will have agreed on the selection of an analytical sample. If a sampling procedure is desired, Practice E 105 is recommended.

8.2 Grind the sample to pass through a 60-mesh screen.

9. Procedure

9.1 Weigh three test specimens sufficient to yield 50 to 75 mg of NiO into 150-mL beakers. Record mass to the nearest 0.1 mg as G .

9.2 Weigh three 1-g test specimens into platinum dishes or porcelain crucibles. Record mass to the nearest 0.1 mg as G_1 . Calcine for 2 h in a 550°C muffle furnace. Transfer to a desiccator containing freshly activated 4A molecular sieve. Cool, weigh, record mass as G_2 , and calculate percent solids.

9.3 To test specimens from 9.1, add 20-mL of concentrated hydrochloric acid and heat gently on a hotplate until only a paste of solids is left. Do not boil the solution. Do not bake solids or subsequent re-solution will be difficult.

9.4 Add 20 mL of concentrated hydrochloric acid and warm on a hotplate 15 to 30 min to dissolve salts. Cool and dilute to about 100 mL with deionized water.

9.5 Filter solids on 0.45- μm filter, using a 500-mL filter flask as a receiver. Wash the beaker with four approximately 20-mL portions of deionized water, transferring the washes to the filter. Wash the solids on the filter with three more 20-mL portions of deionized water. Quantitatively transfer the filtrate plus washes to a 600-mL beaker. Keep the beaker covered until ready to precipitate nickel.

9.6 Put a filter disk into a platinum dish and cover with ashless filter pulp. Carefully char over a gas burner, then ignite at red heat until the carbon is essentially burned off. Put the dish in a muffle furnace at 960°C for 50 min.

9.7 To solids in the platinum dish, add 10 mL of 48 % hydrofluoric acid and 5 mL of 10 % sulfuric acid and evaporate carefully to dryness on a hotplate. Then, carefully bring to a red heat over a gas burner until the sulfur trioxide fumes cease. Cool and add 5 g of reagent potassium pyrosulfate and fuse over a gas burner until a clear melt is obtained. Cool, add 10 mL of 10 % sulfuric acid, 20 mL of deionized water, and heat gently on a hot plate until the melt dissolves.

9.8 Filter the solution (9.7) through a 0.45- μm filter, using a 500-mL filter flask as a receiver. Wash crucibles with four approximately 20-mL portions of deionized water. Combine filtrate with solution in beaker (see 9.5). Wash the filter flask with three approximately 20-mL portions of deionized water, adding washings to beaker.

9.9 Add 20 mL of ammonium citrate to solution. Heat to 70 to 80°C on a steam bath. Add 10 drops of methyl red indicator solution and adjust pH to the yellow color by careful addition of 25 % of ammonium hydroxide or 10 % of sulfuric acid.

9.10 Add 60 mL of 1 % dimethylglyoxime solution. Immediately add concentrated ammonium hydroxide dropwise until the precipitation takes place. Continue dropwise addition until the solution reads pH 9 with pH paper. Cover the beaker. Place the beaker on a steam bath and heat for 30 min to coagulate the precipitate. Remove from the steam bath, allow to cool to room temperature, and check the pH. If pH is not 9 by pH paper, adjust to that pH.

9.11 Allow the precipitate to settle at least 10 h. Test for complete precipitation by adjusting pH to 9 if necessary and adding an additional 3 mL of 1 % dimethylglyoxime solution. If precipitation is incomplete, add an additional 5 mL of 1 % dimethylglyoxime solution and return to steam bath for 30 min. Allow to cool and check again for completion. If precipitation is still incomplete, discard sample. Recheck calculation of the test specimen size.

9.12 Dry and weigh a sintered glass crucible containing a 3.2-cm fiber-glass filter. Record the weight at G_0 .

NOTE 2—The use of a 3.2-cm fiber glass filter facilitates filtering and minimized clogging of the pores of the sintered glass frit of the crucible. This makes it easier to clean crucibles for re-use. Weigh the dry crucible

⁴ *Reagent Chemicals, American Chemical Society Specifications*, American Chemical Society, Washington, DC. For suggestions on the testing of reagents not listed by the American Chemical Society, see *Analar Standards for Laboratory Chemicals*, BDH Ltd., Poole, Dorset, U.K., and the *United States Pharmacopeia and National Formulary*, U.S. Pharmacopeial Convention, Inc. (USPC), Rockville, MD.

plus the fiber glass filter prior to the filtration of nickel dimethylglyoximate.

9.13 Filter the mixture from 9.11, using a gentle suction, through the crucible and filter as prepared in 9.12. Wash the precipitate in the crucible five times with water. Dry the crucible for 2 h at 120°C, allow to cool in a desiccator containing activated 4A molecular sieve and weigh the crucible, plus precipitate. Record the weight to nearest 0.1 mg as G_3 . Return to an oven for 30 min, cool, and weigh again. Repeat until successive weights agree to 0.1 mg.

10. Calculations

10.1 Calculate the percent solids, B , using the following equation:

$$B = \frac{G_2}{G_1} \times 100 \quad (1)$$

where:

G_1 = weight of test specimen before calcination and

G_2 = weight of calcined test specimen

10.2 Calculate the amount of nickel oxide, using the following equation:

$$\text{Nickel as \% NiO} = \frac{(G_3 - G_0) \times 2587}{B \times G} \quad (2)$$

where:

G_3 = weight of crucible with precipitate, expressed to nearest 0.1 mg,

G_0 = weight of crucible plus fiber glass filter, expressed to nearest 0.1 mg,

G = weight of the test specimen, and

B = percent solids, expressed as number between 0 to 100 to two decimal places.

11. Precision and Bias ⁵

11.1 *Test Program*—An interlaboratory study was conducted in which the named property was measured in three separate test materials in five separate laboratories. Practice E 691, modified for non-uniform data sets, was followed for the data reduction. Analysis details are in the research report.⁵

11.2 *Precision*—Pairs of test results obtained by a procedure similar to that described in the study are expected to differ in absolute value by less than $2.772 \cdot S$, where $2.772 \cdot S$ is the 95 % probability interval limit on the difference between two test results, and S is the appropriate estimate of standard deviation. Definitions and usage are given in Terminology E 456 and Practice E 177, respectively.

Test Result	95 % Repeatability Interval	95 % Reproducibility Interval
(Consensus Mean)	(Within Laboratory)	(Between Laboratories)
54.974 Wt. %	0.543 Wt. % (0.99 % of mean)	2.467 Wt. % (4.49 % of mean)
14.373 Wt. %	0.272 Wt. % (1.89 % of mean)	1.323 Wt. % (9.20 % of mean)
2.916 Wt. %	0.028 Wt. % (0.97 % of mean)	0.065 Wt. % (2.24 % of mean)

11.3 *Bias*—The test method described is without known bias since there are no reference standards available for comparison.

⁵ Statistical data calculated in accordance with this procedure are presented in Research Report D32-1014, available from ASTM.

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