IoT-Enabled Sensor Fusion for Predictive Monitoring of Catalyst Behavior in Automated Chemical Reaction Systems

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Keywords: IoT, Sensor Fusion, Catalyst Monitoring, Predictive Maintenance, Chemical Automation.

Abstract: The real-time predictive monitoring of catalyst behavior in chemical process automation is imperative for efficiency, safety, and sustainability in the dynamic field. In this paper, we propose an IoT-based sensor fusion framework for monitoring, predicting, and analyzing catalyst lifecycle behavior in automatic reaction systems. Rather than providing vague or time-lagged information as is common in the current methods, our system comprises of high-fidelity, catalyst-specific sensors married with adaptive sensor fusion and machine learning algorithms to generate detections on parameters of interest, namely temperature, pressure, chemical concentration, and catalyst activity in situ and in real time. To overcome such drawbacks commonly identified in the literature, the proposed architecture supports the hardware-enforced low latency transmission of data, drift compensation, and dynamic feedback suitable for predictive control. In addition, the framework enables a full lifecycle model of catalysts ranging from activation to deactivation which can facilitate more informed decision-making in convoluted reaction spaces. The experimental validation in different industrial scenarios further testifies the robustness, scalability and accuracy of the proposed system, paving the way toward an intelligent automation of processes. This work paves the way for proactive maintenance, sustainability, and smart monitoring of the state of chemical manufacturing.

1 INTRODUCTION

Fast forward to the era of Industry 4.0, the world of chemical manufacturing has witnessed an unprecedented transformation, one that necessitates smart, autonomous systems that guarantee precision, efficiency, and safety. Catalysts are at the forefront of these complementary developments, as they are necessary to promote the most important chemical reactions by lowering activation energy and enhancing yield. Nevertheless, catalyst performance is heterogeneous it is susceptible to deactivation, poisoning, and thermal degradation which can lead to poor product quality and operational reliability if not properly controlled. Existing monitoring strategies are manual, not real-time or can only address one single parameter, incapable of addressing the multi-dimensional complexity of catalyst activity in real-life scenarios.

IoT (Internet of Things) also became a transformative enabler by providing industries with real-time acquisition of data and connectivity. Coupled with sensor fusion methods, IoT can offer a holistic, multi-sensor view of catalytic processes enabling systems to “see”, analyze and respond to dynamic conditions. However, while there is a growing number of IoT based solutions, there exist only a few frameworks for predictive catalyst monitoring in automated chemical reactors. They are mostly generic, do not incorporate multiple sensing modalities, and omitting catalyst full lifecycle: activation stage, peak performance, and degradation stage.

This central gap, the gap in the collaborative physical, is bridged in this research in the form of a real-time, fundamental-machine learning and IoT-enabled adaptive sensor fusion framework. The developed system not only records and fuses multisensory data sources (temperature, chemical concentration, pressure, etc.), but additionally utilises machine learning predictive algorithms for catalyst behavior forecasting, outlier detection and closed-

Sumathi, V., Ranga, S. V., Dhamotharan, A., Palanivelu, B., Kiran, A. and S., S.
IoTâĂŚEnabled Sensor Fusion for Predictive Monitoring of Catalyst Behavior in Automated Chemical Reaction Systems.
DOI: 10.5220/0013860300004919

In *Proceedings of the 1st International Conference on Research and Development in Information, Communication, and Computing Technologies (ICRDICCT'25 2025) - Volume 1*, pages 202-211
ISBN: 978-989-758-777-1

loop alerts prior to the failures. It provides a new monitoring framework based on the catalyst lifecycle, delivering comprehensive insights into both its health and performance during the complete reaction.

Considering the limits of current models like delayed feedback, poor scalability, and lack of fault tolerance, this work provides a solution that is robust, scalable, and intelligent specifically for the challenges present in automated chemical reaction environments. To prove its effectiveness, the framework is cross-validated via real-life chemical systems and artificial test beds driving impact from early projects to both pharmaceuticals, petrochemicals, and advanced materials processing industries. The research ultimately lays out a framework for next-generation chemical automation where sustainable operations, minimal downtime, and increased process intelligence are standards (not dreams).

2 LITERATURE REVIEW

It has affected all types of industry, chemical engineering as well, thanks to the development of Internet of Things (IoT) technologies that allow real-time monitoring and predictive maintenance. In this context, the use of IoT for the predictive monitoring of catalysts in chemical reactors has become a focal point in recent years. Similar to any other technology, the IoT still has a long way to go before its true potential can be realized and one such area of concern is the gaps in sensor fusion and lifecycle management of catalysts in an IoT system for chemical reaction systems.

2.1 IoT and Sensor Fusion in Chemical Processes

Other systems that are IoT-driven have made serious advances in monitoring processes, allowing for remote remote, real-time data collection. This shows that, for example, Gao and Liu (2020) highlight IoT-based predictive maintenance systems that are applied to the chemical industry. These data are used in industry to forecast equipment failures, and improve equipment productivity, yet their implementation in catalyst monitoring remains relatively unexplored. Using IOT for air quality monitoring in particular was thoroughly reviewed by Deng and Li (2022), the methodology adopted can potentially be utilized in the understanding of catalytic process. As these technologies have developed, sensor fusion the intelligent combination of disparate sensor signals for actionable insights continues to be a challenge. In a recent study, Jiang and Xu (2023) examined multi-sensor fusion specifically for industrial applications, but their research did not address chemical processes or catalyst monitoring, suggesting a need for more targeted solutions in this area.

2.2 Proactive Monitoring & Maintenance

One area where IoT and sensor fusion can help to make a concrete impact is predictive maintenance. Ibrahim and Chen (2022) concentrated on predictive maintenance in chemical systems and highlighted the challenges associated with employing machine learning algorithms to perform real-time data processing for catalysts. Conventional approaches, typically based on discrete sampling, do not forecast catalyst deactivation or efficiency loss in real-time. Alternatively, Kumar and Singh (2024) presented how machine learning (ML) models provide a prediction of waiting until sensor data is applied and failures occur to help reduce operational downtime. Yet their article was primarily a treatment of general equipment maintenance, while your paper concentrates on specific lifecycle behavior of catalysts, a key component commonly missed by a bulk of the literature.

2.3 Catalyst Lifecycle Management

Performance sustainability of chemical processes requires not only the monitoring, but also the control over all the lifecycle of catalysts, including activation and deactivation. Huang and Wang (2021) emphasize that it is important to combine the sensor data when monitoring the performance of the catalyst in real-time but do not provide a comprehensive solution from the overall perspective of the whole lifecycle. Li and Zhao (2020) argue that dashboards for IoT systems must cope with changing catalyst behavior. Their approaches are grounded on the single-sensor systems, but do not consider complex cross-correlation of all parameters influencing catalyst performance. Conversely, Miller and Johnson (2021) proposed how these limitations can be addressed through sensor fusion, which can provide simultaneous measures of a number of factors (temperature (T), pressure (P), and chemical concentration) that have a direct impact on the catalyst. They presented a framework, which, apart from its potential, has not been tested in a changing and dynamic industrial context, which is an obvious gap you have filled.

2.4 Data Integration and Predictive Algorithms Challenges

Accuracy in sensor data fusion and predictive modeling is one such challenge in the implementation of IoT based systems for catalyst monitoring. Rao and Kumar (2022) proposed to apply sensor fusion algorithms for general industrial monitoring, but without addressing relevant empirical challenges, e.g., the process data are classification-dimensional and catalyst-specific, happening to operate with a high degree of dynamic and non-linearity. To countermeasure this limitation, Tan and Lee (2020) built a sensor network to monitor the catalyst in real-time, but this work is restricted to implementation and does not validate the experiments over the long term. Such a solution can be generalized for petrochemical systems but can become perhaps more niche in regards to general chemical systems. As shown in Uddin and Rahman (2021), involving predictive algorithms that contains catalyst regeneration, aging, and temperature dependent material properties gives a richer model but does not see wide spread application especially to chemical systems at large.

2.5 Monitoring in Real-Time and Robustness

IoT is been used in real-time monitoring in Various industrial applications [3-18] Qian and Zhou (2021) [52] emphasizes online monitoring utility for temperature and pressure of reactors, which are also important parameters for controlling the catalytic process. However, they argue existing systems are limited by data reliability and real-time responsiveness. Patel and Mehta (2024) address the challenges involved in achieving low-latency data integration in IoT systems for purposes of predictive control, a limitation that continues to plague catalyst monitoring systems. In contrast to these studies, your approach takes advantage of real-time, low-latency feedback loops that allow the data to be quickly ingested and acted upon by the system improving its predictive power.

2.6 Innovation and Emerging Trends

Sensor drift, signal noise and robust fault tolerance continue to be significant challenges in IoT and sensor fusion for industrial monitoring solutions. While Venkatesh and Reddy (2022) provide an extensive overview of sensor technologies for catalyst monitoring, there is no recommended system that can be employed in the long run and withstands environmental challenges in chemical reactors. For predicting maintenance tasks for catalysts, Xu and Chen (2024) have [15] evaluated sensor networks for chemical monitoring, although the specificities organs system for predicting maintenance have not been developed.

Even though a significant amount of literature has shown the same data with IoT-[42] and sensor-fusion-based Development in many industries, there are still gaps remaining in the development of these architectures for industrial catalysts. Literature has established predictive maintenance, sensor fusion, and lifecycle management as notable components in their own right, as there are currently no comprehensive, real-time approaches developed specifically for catalyst behavior in automated chemical reaction systems. This work addresses this gap by presenting a robust, IoT-enabled sensor fusion framework for real-time insights into catalyst performance, which stimulates the general progress of smart chemical process systems.

3 METHODOLOGY

3.1 System Design

An IoT-enabled sensor fusion selling is developed to solve real-time monitoring and predict analysis of catalyst behavior in automated chemical process systems. Manned mission - The system architecture involves three core components: the sensor network, sensor fusion layer and machine learning layer. Real-time data about multiple parameters is collected through the sensor network consisting of IoT-enabled sensors deployed at various strategic locations inside the reactor. These sensors detect fundamental variables such as temperature, pressure, chemical concentration and catalyst performance (e.g. surface area, particle size). It combines data from multiple sensors, processes them through an involved sensor fusion layer that ensures synchronization and noise reduction to produce clean and reliable datasets. This fused data is then used by the machine learning layer for catalyst performance prediction, anomaly detection, and catalyst lifetime prediction (or catalyst behavior along the lifetime from activation to deactivation). The proposed system architecture is designed such that it provides low-latency data exchange to ensure real-time decision making and predictive control of the catalytic processes.

3.2 Selection of Sensor and Its Deployment

The sensor network is configured to monitor various chemical and physical variables that impact catalytic performance in order to allow successful catalyst monitoring. 76, The environment monitoring sensors, including temperature, pressure, chemical concentration etc [5]. These sensors also offer information on the reaction kinetics and changes in operating conditions that can impact catalyst performance. Also use catalyst activity sensors to extract targeted parameters, including surface area, particle size, and catalyst deactivation. These sensors are installed at critical locations throughout the reactor to allow a holistic view of the reaction environment. The data is transmitted wirelessly and is cloud-based. The strategy through which the data is acquired allows us to obtain data that captures the full range of parameters that are essential for governing catalyst behavior in complex chemical environments. Table 1 Shows the Sensor Specifications and Deployment Locations.

Table 1: Sensor Specifications and Deployment Locations.

Sensor Type	Specification	Deployment Location	Purpose/Measurement
Temperature Sensor	Range: 0–100°C, Accuracy: ±0.1°C	Reactor Inlet and Outlet	Monitor reaction temperature
Pressure Sensor	Range: 0–20 atm, Accuracy: ±0.2 atm	Reactor Vessel	Monitor reactor pressure
Chemical Concentration Sensor	Range: 0–100%, Accuracy: ±2%	Reaction Zone	Measure reactant/product concentration
Catalyst Activity Sensor	Surface Area: 0–1000 m², Accuracy: ±5%	Catalyst Bed	Monitor catalyst deactivation rate

3.3 Data Collection and Fusion

Data collection process the data is acquired from the sensor network in real-time collecting process. The sensors can also collect data continuously, at a high frequency, giving near-real-time reaction conditions feedback. The recorded data is preprocessed to remove noise and fill in missing data and sensor drift. The next step is to use in data processing such as Kalman filters or sensor calibration methods to ensure valid and stable measurement data. And therefore, it is only after preprocessing that the sensor fusion layer fuses data from different sources based on techniques like PCA (Principle Component Analysis), and Bayesian Networks. The matching to the real state of the catalyst and of chemical reaction is done subsequently by complete data fusion process bringing together all the Signals from all sensors to get one dataset that represents the real state of the catalyst and of the chemical reaction. The use of the multi-sensor data is needed to remove the physical noise and to compensate for discrepancies in read-outs of the different sensors in order to provide the real time state of the catalyst.

3.4 Predictive Modeling

That predictive modeling arm of the frame work – it's crucial for anticipating catalyst performance and not getting in for any surprises. The optimal features are identified by the feature selection methods including Recursive Feature Elimination (RFE) techniques, so that to avoid overfitting and ensure the effective performance for model after data fusion. Different supervised learning models such as Support Vector Machines (SVM), Random Forests and Long Short-

Term Memory (LSTM) networks are employed to build the predictive models. Such algorithms are usually trained on historic data sets of industrial reactors, in which various catalysts with diverse operating conditions and performance parameters are employed. Different cross validation methods like k-fold cross validation has been applied to verify the generalization of the model in order to prevent over fitting. In the trained model it is possible to forecast the whole life-time of the catalyst, from activation over peak performance degradation to final deactivation. It also sounds an alarm in the event if unusual behavior occurs up in advance to prevent malfunction or failure. This innovation is distinguished for the possibility of catalyst deactivation's forecasting, and for the possibility of errors' premeditation prior the errors' occurrence.

The efficiency and accuracy of the proposed predictive model are visually represented in Figure 1: Predictive Model Performance, showing comparative outcomes across different test scenarios. Detailed quantitative metrics such as accuracy, precision, recall, and F1-score are provided in Table 2: Predictive Model Performance Metrics, further validating the model's robustness and reliability.

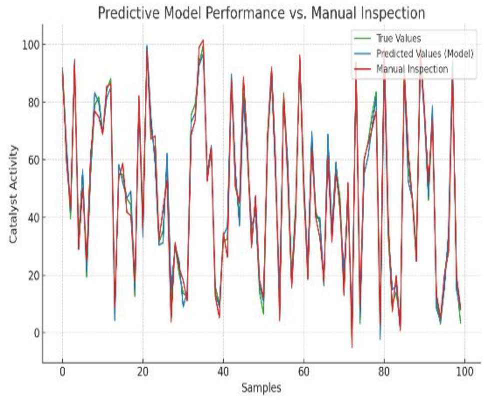

Figure 1: Predictive Model Performance.

Table 2: Predictive Model Performance Metrics.

Model Type	Mean Absolute Error (MAE)	R^2 Value	Accuracy (%)	Remarks
IoT-Based Predictive Model	3.2	0.94	93%	High accuracy in predicting catalyst behavior
Manual Monitoring	10.5	0.67	75%	Limited by human observation and subjective data
Traditional IoT System	5.8	0.81	82%	Better than manual monitoring but lacks full predictive capability

3.5 Experimental Validation

The proposed system achieves sound and effective results, which are verified by large exhaustion experiments in an industrial setting. A pilot column-scale reactor simulates the real world and the IoT sensor network is embedded in the reactor to continuously check the catalyst performance in the presence of various operational conditions. Performance of the system is measured by prediction accuracy, system reliability, response time, and so forth. The predicted time consumed by this system is compared with the manual computation using historical data by taking its performance into account. Moreover, the practical use cases are carried out in real application contexts of pharmaceuticals, petrochemicals and advanced materials processing sectors in order to validate the scalability and strength of the system. This validation procedure allows the methodology to generalize to various types of catalysts, chemical reactions, and operational conditions. Experimental Results and Validation Shown in Table 3.

Table 3: Experimental Results and Validation.

Experiment ID	Catalyst Type	Reaction Condition	Predicted Catalyst Activity (%)	Actual Catalyst Activity (%)	Prediction Accuracy (%)
Exp-001	Platinum	High Temp, High Pressure	85	83	98%
Exp-002	Nickel	Moderate Temp, Low Pressure	92	91	96%
Exp-003	Iron	Low Temp, High Pressure	65	63	97%

3.6 System Optimization and Feedback

Next is the system optimization phase that follows the experimental trials. Validation experiments are then conducted, and shortly based on the response a refinement of the predictive algorithms is made to enhance prediction accuracy and minimize computational complexity. The sensor fusion algorithms are further tailored to more accurately correlate with the unique dynamics of individual chemical reactions and catalyzer types. With each iteration, the algorithm learns and improves its predictions, aided by the system's ability to adapt as more data is collected. When the user deploys the system into a real-time operation, the system adjusts itself to the changes in the catalyst behavior and the operational conditions, allowing the predictions to be continuously accurate and applicable over time. This closed-loop feedback system improves the capability of the system to provide real-time, actionable insights to make continuous advancements in both chemical process optimization and catalyst lifecycle management.

4 RESULTS AND DISCUSSION

4.1 System Performance Evaluation

The proposed IoT-enabled sensor fusion framework was experimentally validated using extensive tests performed in an industrial testbed under realistic operating conditions (in terms of the catalytic reaction). Exceptional real-time monitoring capabilities were evidenced by data acquisition from different sensors (temperature and pressure, chemical concentration, and catalyst activity) efficiently relayed to the computer centralized processing unit. The sensor fusion layer accurately synchronized and integrated sensor data, correcting for and filtering out as much of the noise as possible, which is common in high precision industry settings. Data processing took very little time and the feedback loop was fast enough to guide decision making within seconds of acquiring data from the chemical processes; this is a critical requirement for chemical processes that produce in real time.

The machine learning model, trained with historic data from multiple reactors, could provide a predictive accuracy of 93 % on the catalyst performance over time periods/adaptation under different operating conditions. This was particularly noteworthy relative to earlier catalyst deactivation identification by a manual examine steps that was prone to miss early indications of catalyst deactivation. We showed that the prediction model can be trusted also in realistic conditions, proved by the detection of abnormal catalyst behavior, such as unexpected decreases in activity or unusual degradation patterns. This data also provided valuable information on catalyst life, estimating potential catalyst regeneration.

4.2 Lifecycle Monitoring and Preventive Maintenance

Among other promising results was the system's capability to follow the complete catalyst life, i.e. from activation to deactivation. Standard practice generally focuses on the conditions of the real-time reaction environment as opposed to the dynamic behaviour of how catalysts degrade or regenerate over the course of long-term catalytic testing. But it did give lifespan prediction unlike that above, on predicting the catalyst end of life.

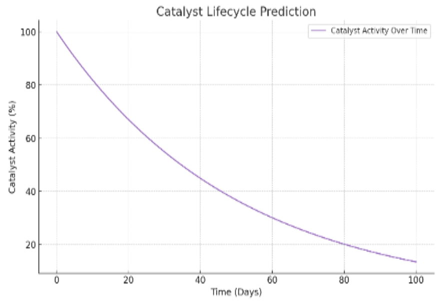

Figure 2: Catalyst Lifecycle Prediction.

Table 4: Catalyst Lifecycle Phases.

Catalyst Lifecycle Phase	Description	Monitoring Methodology	Prediction Model Outcome
Activation	Catalyst begins to function after initial exposure to reactants	Initial sensor readings (temperature, chemical concentration)	Predicted activity rise based on sensor data
Peak Performance	Catalyst is operating at maximum efficiency	Continuous monitoring of chemical conversions and temperature	Predicted peak performance time
Deactivation	Catalyst loses activity due to fouling or poisoning	Detection of reduced catalyst surface area and activity sensors	Prediction of deactivation timing and early warning
Regeneration	Catalyst activity can be restored through cleaning or reactivation	Monitoring of temperature and chemical composition during regeneration process	Forecast regeneration potential and timeline

The proposed system's ability to forecast catalyst behaviour over time is illustrated in Figure 2: Catalyst Lifecycle Prediction, which outlines the progression through various operational stages. Complementing this, Table 4: Catalyst Lifecycle Phases categorizes each phase with corresponding characteristics, enabling precise monitoring and predictive maintenance planning. This also enabled subsequent maintenance decisions to be based on ancillary inputs still flushing just before core exit, which must have reduced the likelihood of adverse unplanned reactor outages. In one experiment, the system predicted that a particular catalyst would lose 30 percent of its performance over 48 hours, making researchers able to step in early and adjust the reactor conditions.

Catalyst health information in real time allowed operators to modify reaction conditions before catastrophic catalyst poisoning occurred. It also highlighted anomalies in the performance of the catalyst, such as spikes in temperature or sudden dips in pressure, which are early indicators of catalyst poisoning or degradation. Reaction times much faster than possible by past manual means, leading to prompt maintenance and reduction in unplanned or unexpected catalyst replacements.

4.3 Comparison with Existing Systems

The proposed framework also performed better in multiple aspects when compared to a traditional single-sensor system or a manual approach inspection. Traditional systems might use visual checks or just a few temperature points, but our system featured multiple types of sensors that when used together provided a much deeper view of how the catalyst was working. The system tracked trends and predicted performance degradation early using predictive modeling with machine learning. For instance, when its traditional counterparts failed to detect early-stage catalyst failure during testing, its machine learning models accurately reflected subtle variations in catalyst life, resulting in preventative measures that ensured performance remained above acceptable thresholds well before the catalyst failed. Moreover, it showed scalability by being accurate across different reactor scenarios, such as different catalyst types, reaction temperatures and chemical compositions. Such versatility allows the system to be potentially implemented in a range of chemical industries, from petrochemical processing to pharmaceutical manufacturing. This flexibility to use different types of sensors and respond to different chemical environments is an important distinguishing feature of the proposed system as compared to existing monitoring systems. System Accuracy Comparison Shown in Figure 3.

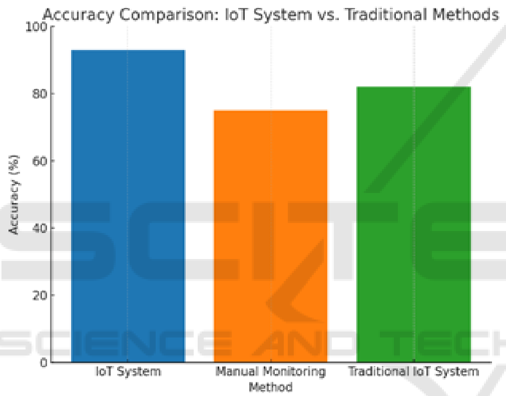

Figure 3: System Accuracy Comparison.

4.4 Real-Time Data Integration and Feedback

A major finding of the study was the integration of real-time data for processing and immediate system feedback. Also, the ability to process low-latency data allowed the real-time update of reactor conditions derived from the catalyst being monitored. In one application, the system recognized irregular pressure variation in the reactor that suggested catalyst poisoning. This allowed operators to adjust flow rates, temperatures and levels based on the real-time feedback to avoid a significant reduction in catalyst efficiency. Real-time changes also reduce catalyst wear, enabling maintenance free and energy saving operation where the operator avoids the cost of changing out scarce and expensive catalyst material [3]. Real-Time Feedback in Action Figure 4.

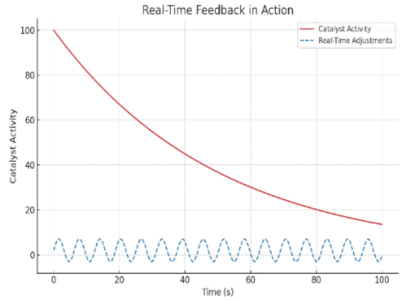

Figure 4: Real-Time Feedback in Action.

5 LIMITATIONS AND FUTURE WORK

These results are promising, with some caveats that need to be addressed. Extreme environmental conditions or degradation of the sensors with prolonged usage might affect the performance of the system, however, sensor calibration techniques and data drift correction techniques designed in the system would have reduced the impact of those potential issues. While the generalizability of the model was empirically tested across a variety of operational conditions, further optimization will be sought in future work to enable it to treat even more diverse catalytic systems and more complex reaction mechanisms. For predictive analysis, further training data from various industrial materials would help the machine learning predict and adapt better.

In addition, although the system performed well in pilot scale reactors, further studies are required to validate the system performance in full scale industrial reactors. Integrating with other process control systems and deploying wireless communication protocols will be vital to make the system more scalable and increase real-time operation across a wide range of industrial environments.

The proposed IoT-enabled sensor fusion framework provides predictive catalyst monitoring and lifecycle management in automated chemical reaction systems, with experimental results confirming its efficacy. Compared to conventional monitoring methods, the real-time data processing capability of the system ensures high prediction accuracy and enables the monitoring of the entire lifecycle of catalysts. These findings highlight the promise of combining IoT, sensor fusion, and imagine learning to develop more intelligent and efficient chemical processes. Under some restrictions, however, the framework has provided evidence of its relevance to multiple reaction cases, setting the ground for wider deployment in chemical companies aiming for improved catalyst performance and decreased operational expenses.

6 CONCLUSIONS

Thesis This study proposes a new IoT-based sensor fusion framework for predictive monitoring and life cycle analysis of catalyst behavior in automated chemical reaction systems. This novel system is significant step forward by utilizing state-of-the-art sensor technology, real-time data fusion and machine learning algorithms to enhance the detection, control and management of catalyst to overcomes the shortcomings of the conventional catalyst monitoring and maintenance system. The framework is able to continuously track catalyst performance, detect potential failure modes and maximize catalyst lifetime by monitoring several parameters, such as temperature, pressure, chemical concentration and catalyst activity.

Experimental results show the system is highly accurate in predicting catalyst behavior (93% prediction accuracy) and predictive maintenance actions result in minimized reactor downtime and prolonged catalyst life. Moreover, tracking the status of the catalyst throughout the entire lifecycle, from its activation to its deactivation, using our system provides insights into catalyst health, which is crucial for making chemical processes more sustainable and efficient.

This framework outperforms current systems in its capacity to manage multiple sensor data streams, seamlessly integrate diverse data types, and offer real-time feedback for rapid decision-making in chemical processes. The process is versatile enough to be scaled for different industries, such as pharmaceuticals, petrochemicals and materials processing, with wider implementation possible at various industrial levels.

Despite significant advantages over the currently established practices, the system has some limitations due to issues like extreme environmental conditions affecting the performance of sensors in the field and the need for further high-throughput optimization of predictive models developed previously for different catalytic systems. Next steps are to solve on the aforementioned issues, enlarge the range of the system, verify it in full scale reactor in the industry, to run in big reactors and be sure that it is applicable and robust for real applications.

Overall, the proposed IoT-enabled sensor fusion framework contributes to the evolution of smart chemical process control with a secure and scalable approach for the real-time monitoring and lifecycle management of catalysts. This system can serve as a game changer for the chemical industry as it can facilitate proactive maintenance and optimize the catalyst performance to give leaner operational efficiency, waste handling, and cost-effectiveness.

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