

# INEOS Oligomers

## 1-Dodecene (Alpha Olefin C12)

1-Dodecene, a clear water-white, mobile liquid, is produced by Ineos Oligomers by using a modified Ziegler ethylene chain growth technology. The product is 99+% olefinic.

### Applications

1-Dodecene enters into all reactions typical of alpha olefins.

1-Dodecene can be used in the production of alkylated aromatics, amines and amine oxides, mercaptans, oxo alcohols, epoxides, and synthetic fatty acids.

### Typical Properties<sup>1</sup>

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#### Carbon Number, wt% (by GC)

C <sub>10</sub>	0.6
C <sub>12</sub>	98.5
C <sub>14</sub>	0.9
C <sub>16</sub>	<0.2
	<u>100.0</u>

#### Hydrocarbon Type, wt% (by GC)

Monoolefin	99.8
Paraffin	<u>0.2</u>
	100.0

#### Other Properties

Color, APHA	5
Density at 20 °C, g/mL	0.760
Density at 68 °F, lbs/gal	6.34
Pour Point, °C	-36
Flash Point, °C, (ASTM D 56)	77
Boiling Range, °C, (5%-95%)	213-216

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<sup>1</sup>Typical properties will vary within specification limits.

### Transportation Mode

1-Dodecene is stored under a nitrogen blanket. It is not corrosive to steel or aluminum. Contact with air, water or oxygen should be avoided because alpha olefins are sensitive to moisture and auto-oxidation which form impurities that can interface with subsequent reactions. Alpha olefins should be handled under a dry, inert gas atmosphere. As with all hydrocarbons, alpha olefins can form explosive mixtures with air or oxygen in certain concentrations.

1-Dodecene is available in rail tank cars, tank trailers, marine vessels and isotanks. 1-Dodecene is available in drums on special order.

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