



Application Summary

Analyte	Detection Technology	Process Stream	Typical Range
H ₂ S (hydrogen sulfide)	OMA-300 H₂S Analyzer	hydrogen	0 - 100 ppm

Introduction

In one part of the petroleum refining process, low-octane naphtha is converted to high-octane 'reformates,' which can then be used to increase the octane of fuel blends. This process occurs in the Catalytic Reforming Unit, where various reactions consume the naphtha feedstock and produce more complex hydrocarbons including aromatics.

These reactions remove hydrogen atoms from the hydrocarbon molecules, thus producing large amounts of H₂ gas which gets stripped out of the reformates stream in a hydrogen separator. The recovered 'hydrogen recycle gas' is a valuable utility for many processes, including mixing back into the naphtha feedstock to the Catalytic Reforming Unit. (While hydrogen is a byproduct of the catalytic reforming reactions, it is also necessary in the feed to hydrocrack paraffins and protect the catalyst from polymer formation.)

Use of the H₂ recycle gas is complicated by the formation of H₂S in the reformer if the naphtha feedstock is not completely desulfurized. Catalysts are poisoned by exposure to H₂S, especially the platinum- and rhenium-containing catalysts commonly used in the Catalytic Reforming Unit. To protect the catalysts and reduce reforming inefficiency, a method of monitoring the H₂S in the hydrogen recycle gas is required.

The OMA H₂S Analyzer uses a high-resolution UV-Vis spectrophotometer to measure real-time H₂S concentration in the hydrogen recycle gas stream. This measurement is an ideal application for the OMA because the hydrogen background has no absorbance in the UV wavelength domain. Additionally, the OMA is built for direct measurement of the hot, high-pressure sample in the rugged optical flow cell, allowing for a simpler sample handling system.

H₂S Absorbance Curve

Any single photodiode measurement is vulnerable to noise, signal saturation, or unexpected interference. This susceptibility to error makes a lone photodiode data point an unreliable indicator of one chemical's absorbance.

As accepted in the lab community for decades, the best way to neutralize this type of error is to use collateral data in the form of 'confirmation wavelengths,' i.e. many data points at many wavelengths instead of a single wavelength:

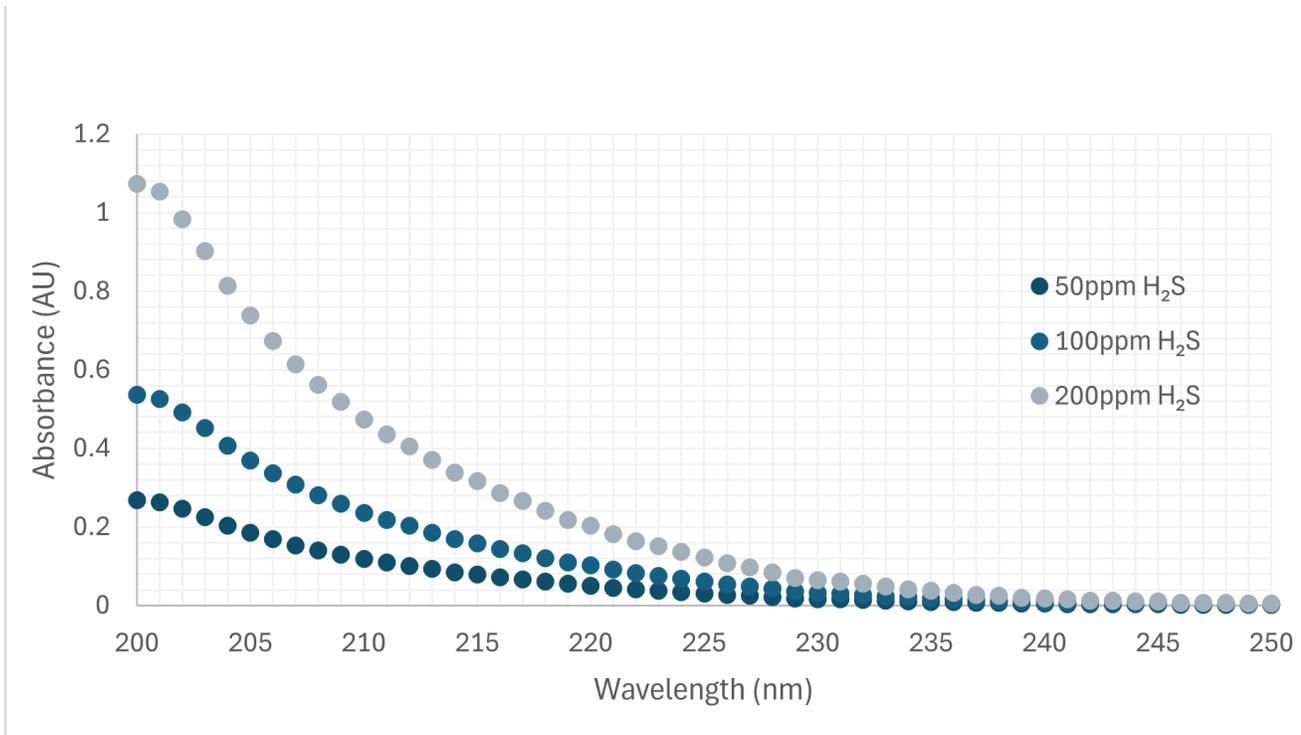


Figure 01: Graph of absorbance versus wavelength for 50ppm, 100ppm, and 200ppm concentrations of H₂S

In the figures above, each dot represents a single photodiode and data point. The Nova II spectrometer registers absorbance at each integer wavelength within the 210-250 nm measurement range and produces an H₂S absorbance curve. After being calibrated on a known concentration of H₂S gas, the OMA knows the absorbance-concentration correlation for each measurement wavelength; the system can average the modeled concentration value from each wavelength to completely eradicate the effect of noise at any single photodiode.

The OMA visualizes the H₂S absorbance curve in this manner and knows the expected relation of each data point to the others in terms of the curve's structure. This curve analysis enables the OMA to automatically detect erroneous results at specific wavelengths, such as when a single photodiode is saturated with light. The normal photometer, with a single data point, is completely incapable of internally verifying its measurement.

The specifications below represent performance of the OMA-300 Process Analyzer in a typical hydrogen application.

For technical details about the OMA-300 Process Analyzer, see the data sheet:

https://aai.solutions/documents/AA_DS001A_OMA300.pdf

All performance specifications are subject to the assumption that the sample conditioning system and unit installation are approved by Applied Analytics. For any other arrangement, please inquire directly with Sales.

Application Data		
Performance Specifications		
Accuracy	Custom measurement ranges available; example ranges below.	
	H₂S	0-100 ppm: ±1% full scale or 1 ppm* 0-10,000 ppm: ±1% full scale
	*Whichever is larger.	

*Subject to modifications. Specified product characteristics and technical data do not serve as guarantee declarations.

Further Reading

Subject	Type
OMA-300 H₂S Analyzer	Brochure
OMA-300 Process Analyzer	Data sheet
Advantage of Collateral Data	Technical Note

For more information, reach out to an Applied Analytics representative and let us provide you with a window into your process.

Headquarters and Manufacturing

Applied Analytics, Inc.
Burlington, MA | sales@a-a-inc.com

North America Sales

Applied Analytics North America, Ltd.
Houston, TX | sales@appliedanalytics.us

Europe Sales

Applied Analytics Europe, SpA
Milan, Italy | sales@appliedanalytics.eu

Asia Pacific Sales

Applied Analytics Asia Pte. Ltd.
Singapore | sales@appliedanalytics.com.sg

Middle East Sales

Applied Analytics Middle East (FZE)
Sharjah, UAE | sales@appliedanalytics.ae

Brazil Sales

Applied Analytics do Brasil
Rio de Janeiro, Brazil | sales@aadbl.com.br

India Sales

Applied Analytics (India) Pte. Ltd.
Mumbai, India | sales@appliedanalytics.in

CONTACT US



www.aai.solutions
(888) 461-0080

www.linkedin.com/company/applied-analytics-inc-
sales@aai.solutions

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