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# Green catalysis: Sustainable alternatives for Industrial Chemical Reactions

**Roli Agrawal**
Professor,
Department of Chemistry,
Sri Varshney College Aligarh,
Raja Mahendra Pratap Singh University Aligarh (U.P.)

## Abstract
Green catalysis has become a key strategy to achieve more sustainable industrial chemical processes by decreasing energy consumption, waste, the use of hazardous materials and environmental impact. In traditional industrial processes, toxic reagents, corrosive solvents, high reaction temperatures and non-renewable feedstocks are often used, which poses great environmental and economic concerns. Green catalytic technologies involve more efficient use of the reaction, and selective conversion of raw materials to valuable products under relatively mild operating conditions. In this paper, the role of green catalysis in the promotion of sustainable industrial chemical reactions is discussed, especially for heterogeneous catalysts, homogeneous catalysts, biocatalysts, photocatalysts and emerging nanostructured catalytic systems. It investigates how catalytic processes can increase atom economy, minimise unwanted by-products, increase selectivity and help to use renewable resources. The study also takes into account the utilization of Green Catalysis for Pharmaceuticals, Petrochemicals, Polymers, Conversion of biomass and Environmental remediation. Specific focus is on catalyst reusability, process intensification, choice of solvents, energy efficiency and minimisation of greenhouse-gas emissions. However, some challenges like stability of the catalyst, scalability, production cost, availability of the material and integration of the material in the industry are remaining challenges for the broader penetration. To accelerate the transition towards a cleaner chemical industry, the paper suggests a research approach that is interdisciplinary, innovative catalyst design and supportive industrial policies through life-cycle assessment are required. To sum up, green catalysis is a promising method for reaching the goals of sustainability of the industrial sector while paying special attention to environmental responsibility.

**Keywords:** Green catalysis, sustainable chemistry, industrial chemical reactions, catalytic processes, renewable feedstocks, energy efficiency, waste reduction, environmental sustainability.

## Introduction
Chemical industry is a basic component of the modern economic and technological development providing materials, pharmaceuticals, agrochemicals, polymers, fuels and many other products for everyday use. However, a number of conventional chemical reactions in industry require high temperature and pressure, toxic solvents, non-renewable raw materials, and stoichiometric reagents producing significant amounts of waste. These practices can lead to huge amounts of energy use, emissions, toxic pollutants and environmental pollution. This has led the researchers and industries to re-think their traditional methods of chemical synthesis and come up with more sustainable reaction processes.

One of the main ways to solve these problems is to use green catalysis in sustainable chemistry. Catalysts do not become a part of the product; they only increase the rate of chemical reactions, allowing them to take place at milder and more energy-efficient conditions. The design of selective, efficient and environmentally friendly catalytic systems in the field of green chemistry can minimize waste generation, maximize atom economy, reduce reliance on toxic chemicals and reduce overall environmental footprint in industry. Therefore, catalysis is now considered not only as a way to optimize the efficiency of reactions, but as a strategy to redesign chemical

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processes in a sustainability manner.

New catalytic technologies have been developed in recent years to be applied in industry. There are a variety of possibilities for improving reaction selectivity and resource efficiency through use of heterogeneous catalysts, homogeneous catalysts, biocatalysts, photocatalysts, electrocatalysts, and nanostructured catalytic materials. Enzyme-based catalysis, for instance, can be used to achieve highly selective transformations under relatively mild conditions, while photocatalysis and electrocatalysis can use light or electricity as alternative energy inputs. Thus, the design of catalysts has been progressing to allow the use of alternative non-toxic and non-abundant catalytic materials, which can be recycled.

The importance of green catalysis also goes beyond the scope of single reactions. Processes that contain catalytic elements can contribute to other objectives such as energy demand reduction in industry, reduction of carbon emissions, resource efficiency and material circularity. Catalyst recovery and reuse and catalytic conversion of biomass, waste derived feedstocks and carbon dioxide can provide additional methods for minimizing material use and operating costs, and may provide alternative sources to fossil fuels for chemical production. However, there are still several problems to be solved, such as catalyst stability, scalability, cost, selectivity, catalyst regeneration, availability of raw material and catalyst disposal, that need to be addressed.

Here, green catalysis can be used as an approach to replace the inefficient, uneconomical, and environmentally unfriendly conventional industrial chemical reactions with efficient, economical and green reactions. It is thus essential to understand the need to take sustainable catalytic alternatives into account when addressing environmental impact of the chemical industry with minimum loss in productivity and product quality. It is this research that is the focus here, highlighting new catalytic technologies, environmental and economic benefits, and limitations, as well as how this field can help realize more sustainable and cleaner chemical production.

**Background of the study**

The chemical industry plays an important role in the current economic development process, which produces materials, pharmaceuticals, fertilizers, polymers, fuels, agrochemicals and many other products, essential to everyday life. In the past, however, industrial chemical manufacture has been dependent on reaction sequences which are energy intensive, generate large quantities of waste streams, or involve hazardous solvents, reagents or feedstocks. This has led to a growing awareness of issues concerning climate change, resource utilization, industrial pollution, as well as safety in the workplace and environment, and has spurred research and industry to rethink the traditional methods in chemical production. The move to more environmentally friendly chemical processes has been an important part of today's industrial development. Among the myriad of steps involved in this transition, catalysis is one of the most important and has the potential to affect the rate of chemical reactions and the reaction pathway, selectivity and/or operating conditions.

Some catalytic systems could require limited resources, toxic chemicals, separation processes that require resource-intensive efforts, or undesirable reaction environment. Currently, conventional catalysts have made significant contributions to refining the efficiency of industrial chemical production. These concerns have led to increased research into green catalysis, a field that aims to design catalytic processes with minimized environmental impact, but at the same time aiming to maintain or enhance the industrial efficiency and product quality. Green catalysis can be defined as using the principles of catalysis in the context of Green Chemistry. It goes beyond just making the rate of reaction faster. The sustainable catalytic systems are designed to reduce waste generation, optimize the atom use of products, reduce the energy consumption, eliminate the use of hazardous substances, increase the selectivity of products, and enable the use of renewable or less environmentally harmful raw materials. As a result, catalysts derived from abundant metals, biocatalysts, organocatalysts, heterogeneous

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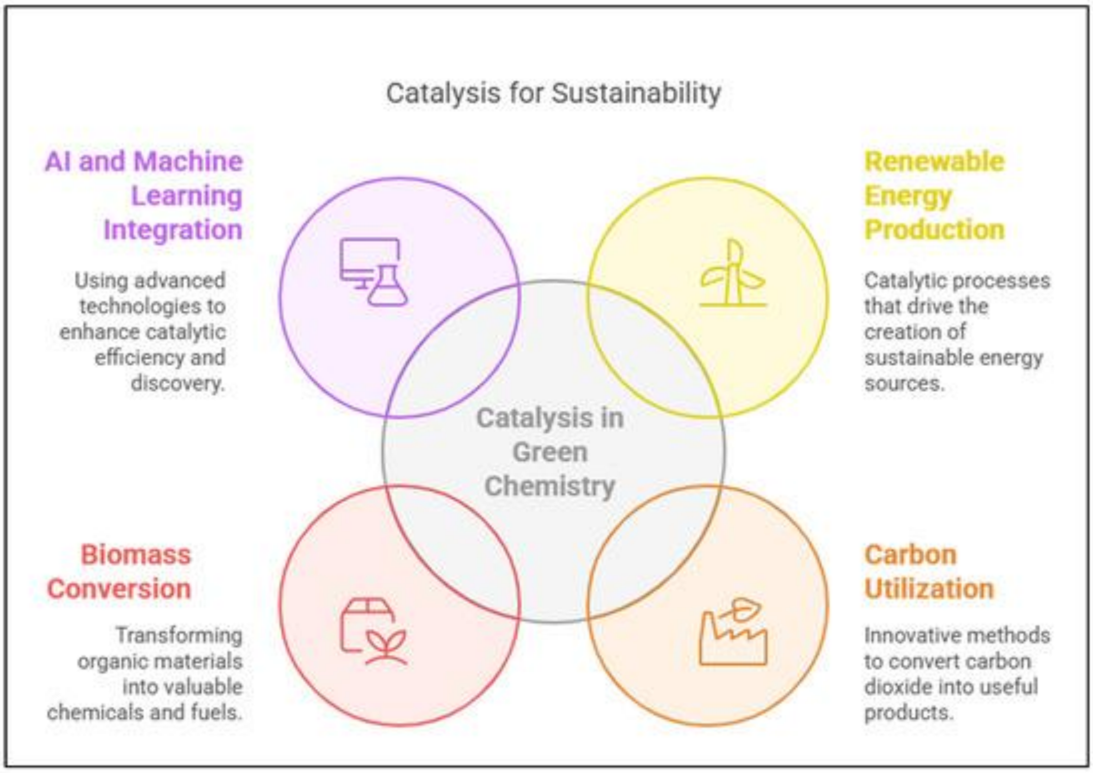
catalysts, photocatalysts, and other new catalytic platforms are also being pursued and gaining interest as alternatives to the conventional catalysts that are environmentally sensitive.

The benefits of green catalysis is that it can enhance the overall efficiency of industrial chemical reactions. A highly selective catalyst will limit the generation of unwanted side products and will thus minimise the need for purification and loss of material. Catalytic reactions can also run under relatively mild conditions of temperature and pressure, which can lead to reduced energy consumption. Moreover, recyclable and heterogeneous catalytic system can facilitate the recovery and reuse of catalyst, which can decrease the cost of operation and environmental impact. These attributes are not only for the purpose of environmental sustainability but for industrial competitiveness as well.




***Source:*** ***https://www.mdpi.com/2073-4344/15/6/511***

Green catalytic technologies constitute another important field of research that is closely interconnected with that of the circular economy. The line of typical industrial chemical production involves mining raw materials, chemical processing, and the final disposal of waste materials. Green catalysis can contribute to the more circular production model by enabling to convert renewable resources, compounds from biomass, carbon dioxide and waste materials/alternative feedstocks to useful chemical products. The following are some ideas to maximise the use of materials which may otherwise be wasted, and reduce the need for finite fossil fuels.

But, the industrial application of green catalysis faces some technological and economical problems. Creating a catalyst that works well in the lab doesn't necessarily mean it will work well on a large scale. The industrial feasibility can be influenced by catalyst stability, activity, selectivity, regeneration, raw material availability, process integration, process scalability and process costs. In addition, some materials already exist and are already used for catalysis but need more complicated preparation methods or materials that are essential for the environment or the economy, thereby potentially creating new environmental or economic problems. Therefore, effect of sustainability of catalytic systems should be assessable not only in terms of catalytic performance, but overall life cycle sustainability.

This change in direction has introduced a new challenge to develop catalytic systems that take

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into account the chemical efficiency, economical production cost and environmental impact. Researchers are trying to discover new ways using biocatalysis, nanostructured catalysts, metal-free catalysts, photocatalysis, electrocatalysis, catalysts from renewable sources, and from waste materials. These advances present opportunities to redesign industrial chemical reactions to make them more sustainable, rather than just tacking sustainability on as a post-manufacturing concern.

The background in which this problem arises makes the study of green catalysis a relevant field of research which encompasses chemistry, environmental sustainability, materials science and industrial engineering. Investigating the potential of sustainable alternatives to the industrial chemical reaction can provide clues to the catalytic technology that can decrease the amount of waste, energy consumption, hazardous inputs and dependence on non-renewable resources. Thus, the search for more sustainable and environmentally friendly routes to chemical manufacturing is of importance for the discovery of green catalysis, and for the overall transition towards sustainable industrial production.

**Justification**

Chemical industry plays a key role in the economic development of our days, delivering materials, pharmaceuticals, agrochemicals, polymers, fuels and numerous other compounds that are essential for society. But, for many conventional industrial chemical reactions, they rely on energy intensive processes, hazardous reagents, toxic solvents, and non-renewable resources. These practices can produce large amounts of wastes and hazardous emissions that can pose environmental and occupational problems. It has therefore become a great incentive to explore the potential for more environmentally friendly methods of industrial synthesis.

These problems are significant as one of the key solutions is green catalysis, which can improve the efficiency and selectivity of a chemical reaction, reduce the energy consumption and the amount of by-products produced. The design of environmentally friendly catalysts like heterogeneous, biocatalysts, nanocatalysts, photocatalysts and catalysts based on renewable or waste products offers a chance to redesign industrial reactions following the principles of green chemistry. These can be used to minimize waste production, reduce the use of hazardous materials, make better use of resources, and enable reactions to take place under relatively milder conditions.

The study is very relevant as industries are being increasingly called upon to balance out economic productivity and environmental responsibility. Sustainable catalytic technologies can be developed that can be cleaner and higher in efficiency without compromising the reactions quality, product quality or Scale-Up of the reactions. Understanding the performance, benefits and drawbacks of the different green catalytic systems can help identify other viable reaction pathways and help the transition towards a greener manufacturing process that is more resource efficient.

In addition, although many green catalytic technologies have been developed a lot of issues remain with regard to catalyst stability, cost, availability of raw materials, recovery/reuse, scalability and industrial implementation. For this reason, a systematic study of these is needed to be able to distinguish innovations with the possibility of being developed in the lab from those with real possibilities of being developed in industry.

Hence, the investigation of the potential of green catalysis as an industrially viable and environment friendly process alternative to the conventional chemical processes is valuable, in this regard. The study can contribute to the overall objective of designing cleaner chemical processes that reduce environmental impacts, increase energy and material utilisation efficiency and contribute to a sustainable future of the chemical industry.

**Objectives of the Study**

1. To discuss the fundamental principles and concepts of green catalysis and its importance

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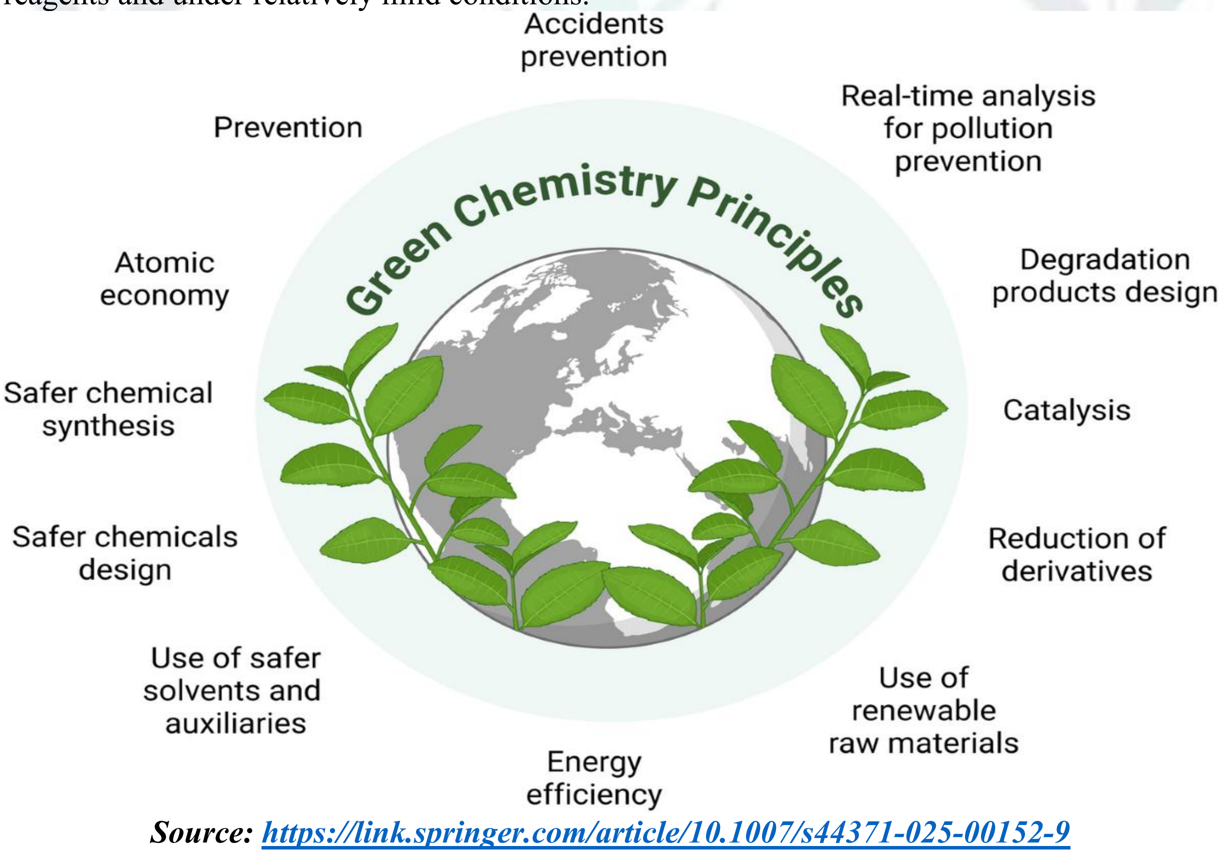
in sustainable industrial chemical process.
2. To assess how catalysts can help to make industrial chemical reactions more efficient and selective in order to minimize the environmental impact.
3. Different Catalysts of sustainable chemical production such as Biocatalysts, Heterogeneous Catalysts, Homogeneous Catalysts, Nanocatalysts and Recyclable Catalysts are analysed.
4. To evaluate the efficiency of green catalytic processes for waste minimization, generation of hazardous by-products and consumption of hazardous chemical substances.
5. To explore how green catalysis can help to conserve energy by facilitating chemical reactions at lower temperature and pressure.

**Literature Review**

The concept of Green catalysis has become an important one for converting the traditional chemical production into more environmentally friendly and sustainable industrial processes. The traditional chemical reactions consume huge amount of energy, have toxic solvents, hazardous reactants, poor selectivity, and a lot of waste generation. Green catalysis which takes into account the above concerns, aims to develop catalytic systems that improve the efficiency of reactions while minimising the environmental and health impacts of the process. The idea is tightly linked to the principles of green chemistry proposed by Anastas and Warner (1998), which include prevention of waste, atom economy, energy efficiency, safer chemical synthesis, renewable feedstocks and catalysis. Catalysis is singled out as one of the twelve principles because catalytic processes can enable chemical transformations by replacing stoichiometric reagents and under relatively mild conditions.




***Source:* *https://link.springer.com/article/10.1007/s44371-025-00152-9***

The conceptual underpinning of green chemistry was laid by Anastas and Warner (1998) who proposed that environmental issues should be built into the design of chemical products and processes, not tackled after the pollution has occurred. They created a framework in which

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catalysis can be seen as a preventative action to reduce waste and improve chemical transformations. This is particularly important in the industrial chemistry industry since it can affect associated raw-material consumption, energy requirements, by-product production and downstream purification. It is also seen that catalytic technologies have been an important aspect in the process of eliminating pollution and making chemicals safer for the environment.

Sheldon (1992) was a significant player in the discussion of environmentally responsible chemical synthesis with the introduction of the concept of the E-factor, the number of moles of waste produced per mole of desired product. The idea proved helpful to industry in determining an acceptable comparison of the various manufacturing processes and also highlighted the importance of waste minimization at source. Catalytic reactions can help to decrease the stoichiometric waste and increase the selectivity, which thus can lead to lower E-factors. This is particularly important when large quantities of chemicals and drugs are produced, since small improvements in the efficiency of chemical reactions can lead to substantial reductions in materials used and waste generated.

Clark (1999) pointed out that green chemistry should go beyond the reduction of pollution to redesigning chemical processes and products. Catalysis is therefore an enabling technology from this point of view as catalysts may promote reactions with better selectivity and lower energy consumption. The development of the heterogeneous catalysts, supported catalysts, and catalytic processes using renewable resources has since broadened the scope of sustainable alternatives in industrial chemistry.

Much attention has been focused on heterogeneous catalysis because the solid catalysts are much easier to separate from reaction mixtures than the homogeneous catalysts. This can help to recover and recycle catalysts, which can enhance process economics and minimize catalyst-related waste. Lakhani, Bhanderi, and Modi's recent work (2024) is particularly significant in the field of sustainable heterogeneous catalysis, where the interaction between the catalyst and its support plays a crucial role. They show in their review that support materials may affect catalytic activity and selectivity, catalyst stability and reusability, and overall sustainability of catalytic processes.

Sharma, Gallou and Handa (2024) studied the advancement of sustainable organic chemistry and emphasized the need for integration of greener reaction conditions with the enhancement of catalyst design. The environmental benefits of hazardous organics reduction and using substitutes like water and other sustainable reaction media are emphasized by their review. They also explain the difference between homogeneous and heterogeneous catalytic systems and recognise that heterogeneous systems can have advantages in catalyst separation and recycling and homogeneous systems can have advantages in terms of high activity and molecular-level control.

Another big avenue of green catalysis is biocatalysis. Enzymes exhibit high chemo-, regio, and stereoselectivity and will catalyse reactions under relatively mild temperature and pressure conditions. O'Connell et al. (2024) provided a detailed overview of the key advancements in the field of biocatalysis and highlighted the wide-ranging possibilities for enzyme utilization in chemical synthesis, fueled by enzyme engineering, molecular biology, and computational tools. They conclude that modern biocatalysis is becoming more and more able to provide the required transformations for industries with high selectivity and relatively low environmental impact.

Likewise, recent research of Lozano and García-Verdugo (2023) has linked biocatalysis with the shift from green chemistry to circular chemistry. They believe that the transition to sustainable catalytic transformations is to be viewed in addition to the use of renewable feedstocks, efficient separation processes, reduction of waste and safer products. Biocatalysis is especially relevant to circular production systems as biological catalysts can be used to convert and valorize renewable and waste materials to useful chemical products.

Advancements in protein engineering, metagenomics, bioinformatics, enzyme immobilization and continuous flow processing have extended the industrial applications of biocatalysis.

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Immobilized enzymes and continuous packed-bed reactors are highlighted by the authors as key technological advancements that will advance the practical and economical use of enzymes in manufacture. Waste valorization and the development of circular bio-based production systems are also becoming more and more linked to biocatalysis.

Catalysis also increasingly goes hand in hand with energy-efficient chemical synthesis, and in this respect, green catalysis is an emerging hallmark of energy-efficient chemical synthesis. Normal industrial reactions can need high temperatures and pressures, leading to high energy usage. Osman et al. (2024) summarized recent advances in low energy catalytic processes and highlighted the importance of catalytic technologies for decreasing the energy consumption of chemical production. The applications that are covered in their review include hydrogen production, biodiesel production, carbon dioxide conversion, water treatment, and organic synthesis. The developments illustrate that designing catalysts can help not only to reduce waste, but also decarbonize industry in general.

Photocatalysis and electrocatalysis are shown as potential alternatives to the dependence on the traditional thermal reaction conditions. These can include using light or electricity as energy inputs, and can be integrated with renewable energy systems. In recent reviews of sustainable catalysis, a number of technologies have been recognized as some of the very important routes to cleaner pathways, including photocatalysis and electrocatalysis. In addition, these systems can be used to carry out chemical changes with less severity and can also offer the chance of combining generation of renewable electricity with the production of chemicals.

Another significant innovation is the use of green solvents and catalytic systems without the use of solvents. Solvents are frequently an important part of the chemicals used in manufacture and can be a major source of environmental and occupational problems. Therefore, reactions in water, supercritical fluids, ionic liquids or in the absence of conventional solvents have been of great interest. For sustainable organic synthesis, Sharma et al., (2024) have pointed out the importance of solvent choice in improving the environmental impact and safety of the synthesis. The synergy of green catalysts and greener reaction media for MCRs was discussed by Messire, Caillet and Berteina-Raboin (2024). They demonstrate that the design of a catalyst and choice of solvent can be synergistically combined to make the well-established synthetic procedures more environmentally efficient. They have come up with a way to study important multicomponent reactions and showed the continuous transition to catalytic reactions with less waste and higher reaction yield.

Recycling and recovery of catalysts are important in industrial applications. Although catalysts can accelerate the rate of reaction, recovering them may be impractical, they may require a lot of energy to be prepared, or they may need to use rare and toxic elements, which reduces their overall sustainability. Thus, modern green catalysis considers catalysts within a broader sustainability framework, such as their preparation, lifetime, recovery, regeneration and end-of-life considerations as well. Thus, the sustainable development of a catalyst requires a balance between catalytic activity and availability, toxicity, recyclability, and economic viability.

Using transition metals in catalysis opens up opportunities and poses challenges. The precious metals (palladium, platinum, rhodium and ruthenium) have high catalytic performance but they are expensive, rare and may not be sustainable. This has promoted the quest for earth abundant metal catalysts, metal-free catalysts, and organocatalysts, and supported nanocatalysts. Research and development of sustainable catalysis are currently increasingly focused on optimization of catalytic activity and reduction of the consumption of scarce and/or environmentally detrimental materials.

Preikschas (2024) also states that the future of sustainable chemical manufacture calls for more than just thinking about individual catalytic reactions; it's about thinking about integrated and coupled catalytic processes. Combining various catalytic reactions can result in more energy efficient chemical value chains and assist in converting renewable resources to value-added products. This is especially relevant to industrial sustainability as the environmental

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performance of a single reaction might not be a reliable indicator of the sustainability of the overall production chain.

Recent research has also evolved the idea of green catalysis to circular chemical production. Circular designs aim to recover, transform and reuse materials that would be waste streams had they not been recovered. Biological, carbon dioxide, plastics and other waste-based resources can be transformed into fuels, chemicals and materials with the help of catalytic technologies. Lozano and García-Verdugo (2023) state that it is essential to combine catalytic efficiency, renewable raw materials, safe generation and efficient separation technologies to move from green chemistry to circular chemistry.

The literature also suggests that green catalysis measures should take into account several criteria, not just catalytic activity. Other metrics includes atom economy, reaction yield, selectivity, the E-factor, process mass intensity, energy consumption, solvent intensity, catalyst loading, catalyst lifetime and recyclability. High yield reactions can be a bad environmental choice, if they use toxic solvents, large amounts of energy, scarce metals or complex purification steps. However, this implies a systems approach from the acquisition of raw materials to product recovery and waste management toward achieving sustainable industrial catalysis.

In general, the literature shows that green catalysis has gone from being a pollution prevention idea to a more comprehensive, technological approach to sustainable industrial chemistry. The seminal works of Anastas and Warner laid the basis for catalysis as an important paradigm of green chemistry and subsequent research has continued with the development of different types of catalysis including heterogeneous, biocatalytic, photocatalytic, electrocatalytic, organocatalytic, green solvents, continuous processing and circular chemistry. A number of recent studies have suggested that the most attractive industrial methods that are able to achieve all five of these are those that can increase selectivity as well as reduce energy and material usage, waste generation, catalyst losses, and the use of renewable or waste feedstocks.

There has been a significant improvement but there are key research gaps. There is still a need for more research to enhance catalyst stability, lessen reliance on critical raw materials, design scalable biocatalytic systems, overcome catalyst deactivation, increase the continuous flow implementation, and create consistent evaluation techniques that measure the entire life cycle sustainability of catalytic processes. Moving from laboratory-scale demonstrations to techno-economic assessment, life-cycle analysis, and/or industrial scaling and integration with renewable energy and circular production systems should therefore be investigated in future studies. This might lead to greener catalysis becoming a viable foundation of more environmentally friendly, safe and cost-effective industrial chemical manufacturing.

## Material and Methodology

In the present study, a systematic literature-based research method is employed to investigate the concept of green catalysis as a sustainable process alternative to the conventional catalytic processes in industrial chemical reactions. Secondary data relevant to the subject were gathered from peer-reviewed research articles, scientific journals, books, conference proceedings and authoritative reports related to green chemistry, heterogeneous and homogeneous catalysis, biocatalysis, photocatalysis, electrocatalysis, nanocatalysis, and recyclable catalyst systems. A literature review was conducted to identify advances in the efficiency of catalysts, the selectivity of the reactions, energy usage, waste generation, the use of solvents, the recovery of catalysts, and the environmental impact of the sustainable catalytic technologies and their applications in industry. Selected studies discussed were assessed in green chemistry terms, including resource efficiency, waste prevention, use of safer solvents and reaction conditions, energy efficiency, renewable feedstocks, and catalyst recyclability. Comparative analysis was used to assess traditional and green catalytic methods regarding reaction yield, selectivity, operating conditions, stability of the catalyst, environmental impact and applicability on large scale. Special focus was placed on catalytic systems which would help to reduce hazardous by-

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products, minimize energy demands and increase the utilization of raw materials. The collected data was themed and analysed by qualitative data analysis and some main conclusions were drawn regarding green catalysis technological developments, advantages, disadvantages and opportunities. The methodology is therefore suitable for assessing the feasibility of sustainable catalytic technologies for applications such as more resource efficient and environmentally friendly production methods in downstream industrial chemicals.

**Results and Discussion**

From this analysis, green catalysis looks promising to reduce the environmental footprint of the non-green industrial chemical reactions. The general benefits found with various catalytic systems are increased selectivity of the reactions, lower energy consumption, lower formation of unwanted by-products, and better use of raw materials. The use of enzymatic, heterogeneous, supported metal, organocatalysts and recently developed nanostructured catalysts has proven to be very promising for processes that are otherwise performed under harsh reaction conditions. The results show that the process of cleaner production is possible without compromising the efficiency of the reactions required in industrial processes by using catalyst-assisted processes.

One important result of the analysis is the importance of catalysts as a means of increasing the selectivity of a reaction. In normal chemical reactions, too many reagents or extreme temperature/pressure is required, thereby increasing chemical waste and operating expenses. Green catalytic processes should instead promote the change in the process while minimizing competing processes. The increased selectivity can help to lower the amount of purification and separation needed, which can lower material and energy consumption. This is especially important in the chemical production industry where even modest gains in selectivity can result in significant decreases in waste and resource consumption.

It also shows that one of the significant alternatives is biocatalysis which can be used in green catalysis. They can operate at relatively low temperatures (and under mild pH and salt conditions), and can exhibit high substrate / reaction specificity. They have found application in pharmaceutical synthesis, food processing, Fine Chemicals/biochemicals manufacturing and are highly promising for replacing some of the traditional catalytic routes. But the wider use of enzymes is hampered by issues like enzyme stability, working life, compatibility of substrates and the cost of enzyme production. Therefore, enzyme immobilization, enzyme engineering and improved reactor design have been identified as effective solutions to overcome these drawbacks.

Heterogeneous catalysis can also be seen as a particularly useful strategy for sustainable industrial chemistry as the solid catalyst can easily be removed from the reaction mixture, thus allowing for the reuse of the catalyst. Reusability can help lower catalyst usage and purification of the products can be easier. For this reason, metal oxides, zeolites, supported metals, porous materials and other solid catalysts have been gaining interest for use in oxidation, hydrogenation, condensation and other industrially relevant transformations. However, the sustainability of heterogeneous catalysts will not only rely on their catalytic activity, but also on the environmental and economic factors associated with the production, re-use, and eventual disposal of the catalysts.

Another significant discovery relates to the possible use of renewable and non-toxic catalyst systems. Older catalytic reactions could require rare or toxic metals and toxic solvents. The research on earth abundant metals, organocatalysts, ionic systems, recyclable catalysts and bio-derived catalytic materials offers the possibilities to mitigate the dependence on metal chemicals that are problematic. However, changing one catalyst to another does not ensure sustainability of the process automatically. The toxicity of the catalysts, availability of the resources, preparation of the catalyst, recyclability and end-of-life effects need to be considered together. The use of an energy intensive preparation or rare raw material to obtain a good catalyst can reduce the overall environmental benefit.

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The findings also indicated the connection between green catalysis and energy efficiency. Catalysts can reduce activation barriers and facilitate reactions to take place at lower temperatures and pressures. This reduces the amount of energy needed for industrial production and can help the reduction of GHG emissions if relying on fossil energy to provide that. The advantage is increased when catalytic processes are coupled with renewable electricity or low carbon energy sources. Therefore, the environmental performance of a catalytic reaction must be evaluated in combination with the energy source, the process design and the downstream purification needs, instead of evaluating the catalyst performance per se.

In the industrial context, the results indicate that process integration and catalyst reutilization are important factors for sustainability. A highly active catalyst may be of little practical use if it is easily deactivated, is not readily recovered, or causes separation problems. Green catalytic processes can be further enhanced in practice by the use of immobilized catalysts, membrane-assisted separation and integrated reaction–separation systems. These can also help maintain better process control and minimize solvent and material waste.

The benefits of green catalytic technologies are still present, but a number of obstacles must be overcome before it can be widely used. Industrial applications may be limited by catalyst deactivation, sensitivity to impurities, scalability, high development cost, and the inability of the catalyst to maintain performance over extended operating times. Furthermore, laboratory-scale demonstrations can also not be directly applied to industry without careful attention to the economic and environmental advantages and disadvantages. Thus, a comprehensive assessment in future should be a combination of catalytic performance indicators, life cycle assessment, techno-economic analysis, resource-efficiency indicators and waste-reduction indicators.

As a whole, the discussion shows that green catalysis could be one of the important bases of more sustainable industrial chemical production. It is not just about replacing traditional catalysts, it is about rethinking chemical processes with regard to their efficiency, selectivity, use of scarce resources, the safety of materials used, recovery of the catalyst and minimizing the impact on the environment. The shift to sustainable industrial chemistry will thus require the involvement of catalyst researchers, chemical engineers, process designers, along with industry practitioners. Green catalysis is most effective if viewed not in isolation, but as part of a broader system of sustainable production.

**Limitations of the study**

The study of green catalysis and its possible application as a sustainable alternative in industrial chemical reactions has some shortcomings. Conclusions are drawn from the existing scientific literature, published research findings and reported industrial applications which may restrict generalisation of the results to different types of industry and different operating conditions. A direct comparison of the performance of different green catalytic systems is difficult because of the wide range of reaction conditions they employ, including reaction temperature, pressure, catalyst composition, quality of feedstocks, choice of solvent and process design. Furthermore, there is not much industrial data available about the life-time stability, reusability, scalability and economic viability of some emerging catalysts and catalytic technologies. While environmental advantages like reduced waste generation, lower energy usage and more efficient use of resources have a large role to play, detailed life cycle assessment data is not always available for each catalytic technology. The large-scale production of products from the laboratory studies may also present technical, infrastructural, and economic issues, which cannot be completely captured in the experimental studies. Moreover, the accessibility and price of raw materials, catalyst components and particular equipment needed for green catalytic processes can affect the feasibility of their use in the developing and developed industrial economies differently. Thus, the conclusions should be drawn based on the available information and more pilot scale studies, long term industrial testing, techno-economic studies, and life cycle analysis are needed to assess the potential of green catalysis on broader scales and

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its sustainability.

**Future Scope**

The potential applications of green catalysis are vast, especially in the context of industries looking for environmentally friendly, sustainable, and efficient alternatives to traditional catalytic methods. More studies could be conducted on the synthesis of highly selective catalysts that would function under mild reaction conditions, with minimal energy usage, wastes, and use of hazardous solvents and reagents. Bio-based catalysts, enzymes, heterogeneous catalysts, nanocatalysts, photocatalysts, electrocatalysts, renewable- and waste-based catalysts can be focused. The future studies could also focus on the integration of artificial intelligence, machine learning, and computational modelling, which could help speed up the discovery of new catalysts, predict their catalytic performance, and optimize reaction conditions. The scale up of lab innovations to commercial industrial processes is an important research challenge which involves the evaluation of catalyst stability, recyclability, cost, environmental impact and long-term performance. Life-cycle Assessment and techno-economic analysis can also help in deriving the real sustainability of new catalytic technologies. Moreover, future studies can be focused on integration of green catalysis in the circular economy, where industrial wastes, biomass, and CO2 can be utilized to generate valuable chemicals and fuels. The synergy of chemists, chemical engineers, environmental scientists, materials researchers and industrial parties will be vital in bringing developments in green catalysis to fruition in industry and aiding the shift toward more sustainable chemical production.

**Conclusion**

Green catalysis is an important route for achieving more sustainable, efficient and environmentally friendly industrial chemical reactions. Green catalytic technologies can solve some of the environmental problems of traditional chemical processing by increasing reaction selectivity, decreasing energy consumption, reducing waste and harmful material input. The use of catalysts prepared from renewable resources, biocatalysts, heterogeneous catalysts and sophisticated catalytic materials is another example of the ability to marry industrial productivity with environmental protection. Despite these obstacles like high costs of catalysts, scalability, stability, recovery and technological integration, which are still being addressed by some industries, the research and innovation efforts constantly enhance the industrial feasibility of these. More interaction between the research and chemical industries, the government and technology developers can lead to a faster shift from traditional process to a cleaner catalytic process. Green catalysis should be considered as one of the tools to consider for achieving sustainability in industry and should be evaluated as part of sustainable industrial development, in terms of resource efficiency, pollution prevention, competitiveness and long-term transition towards a circular and low carbon chemical industry.

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