INCH

Rite in the Rain®
ALL-WEATHER WRITING PAPER

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6/10/15

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Project Puget Sound Refinery
Shell Oil Products US
EPA Facility ID: 1000099252
Inspection Date: August 10-14, 2015

USEPA REG
0000477

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Rite in the Rain®

ALL-WEATHER

JOURNAL

№ 391

8/10/15

Sign in gate @ 8:30 AM

Met 3 shell reps pres credentials

Steve Willian
Nate
Adam

80% by shuff (oil tanker)
20% by oil pipeline

Ada Cuadrado, Technology Manager
Kim Ort, Manager ↓
HSSE RMP

Juan Soto - Health Safety
WSU Safety orientation
Coordinator @ 10 AM

- Goal Zero
- 12 Life Savings Rules (card)
- SPSR ~~Alarm~~ Emergency Alarms
  - Card

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Opening Conference - Trent, Head
Fairey Insp.

13 PSR reps

Rite in the Rain

Coke
units
Barge/trucks

8/10/15 7

Tour @ 12:31 PM

ESCORTS - Scott M. / Shawn C.

① Fire hall - full staffed

② VPS Unit / GOS - flash drum - 2 desalters
↳ gas oil system

③ DCU Unit - Heavies separated
16 hr - 24 hr cycle time

④ HTU 1 Unit - treats jet unit
(jet fuel) from crude low sulfur

- Heaters / Reformer reactor not in service

⑤ ISOM Unit

⑥ HTU 2 Unit - treats ~~diel~~ diesel
- - 3 reactors Ultra Low Sulfur
main frac / lean amine

⑦ CRU 2 Unit - add octane
to gasoline

⑧ HTU 3 Unit - take sulfur out
of gasoline
Dibut Naptha

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(9) DCH / DEBUT Units

(10) SRU/TGTU Units
SRU 4

(11) Alky 2 Unit - Alkylades produce propolyer/butylene
isobutylene - Tanks rail car

(12) Alky 1 Unit - runs in parrallel w/ unit 12

(13) Poly Unit - LPGs, poly gas from CAT unit

(14) ECCU / GRU Unit - main producer of gasoline
wastewater strippers - sour water

(15) BOHO / COGEN - 3 units
45 MW
2 Boiler - fire side
#37 Tank DCU - not in service

(16) NH_3 Storage Tank

(17) Tank Farm
Butane storage spheres for Alky unit
- 7 Crude tanks (1-6, 19)

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- ANS - AK North slope crude

Chemtrade - produce Sulfuric acid for refinery

(18)

(2) Two water reservoirs
- supplied by City of Anacortes
- boiler house
- effluent plant

Kept 3.5-4 mil gal./day to bay

(19) LPG storage tanks

(20) Final Blending of gasoline before shipping

(21) TTLR Unit - Shell Dist. owned
LPG / Gas trucks

(22) Effluent Unit
2 Bio reactors
- Tank 74
- open tank
use ~~sol~~ Na Hypochlorite

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(23) TCLR unit - unload/load tanker railcars
- LPG
- isobutane
- diesel pipeline truck only

(24) Control Bldg
- RPS not here @ blending unit

- Operator bldgs @ units only monitoring

Linde & Air Liquide
- supply pure H_2

Tour end 2:06 PM

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8/10/15

Process Description Overview
- Speaker SPSR - Archer

VPS - Vacuum Pipe System
ARU - Amine Regeneration Unit

BOHO/COGEN supply steam to units

3 Flares - N/S/E
- not part of RMP

- Flare; flare recovery unit
- strip amines / H_2S from gas before being mixed w/ LPG flame

- Maintenance
  - Shell employees $> \simeq 250$
  - Brinderson Inc.

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8/4/15

Doc Review

Incident Investigation
- Procedure
  Plant Standing Instruction (PSI)
  ~~PSI~~ A.120.3, Rev 12, pg 1-15
PSIA061
  - does not ref. RMP 68.79
- Ref. A080.4 - Notification of Air Releases, Unit Upsets / Outside Complaints
- Use Fountain Incident Management (FIM) to doc. reports
- Category of Incident
  - Process Safety
  - Environment
  - Near Miss
  - Reliability
- DCS-0525001-ST, ~~Risk Analysis~~ Jan
- Track findings in FIM ~~for~~ reporting only to upper management
  - TOP Rep responsible
  - Procedure PSIA 083, Tracking Auditor / AIs

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- Brian Ricks
USW Process Safety Rep

- TOP Rep gives access to employees using inv. register (TOP web page)

- Level 2 investigations for Process Safety

- The OP Rep manages the "Near Miss" list for tracking

- Talk to Steve Williams, Safety Manager

- 2011/2012 Near Miss
  1. 2011-13, H_2S release, HTU/CRU2
  2. 2011-34, PRV Blocked, Alky/Poly
  3. 2011-39, PRV lift on LP Seperator, HTU2
  4. 2011-42, DCS went into Reset on UPS
  5. 2012-12, Poly PRVs lift do to FCCU SU
  6. 2012-17, Unit running over HAZOP unit, HTU 2
  7. 2012-21, PRV release, HTU/CRU2

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open —

open —

open —

8/12/15

- 2013/2014 Near Miss List
  1. 2013-1, PRV reverse inst'l, PEI
  2. 2013-2, PRV lineup, OPS, TOP/CL 329541
  3. 2013-16, Flare flang flash fire, Alky 2 TOP/CL 330733
  4. 2013-45, MOC Issue, Benzene
  5. 2013-92, Flash Fire, ~~HTU3~~ HTU2
  6. 2014-7, MOC Issue, OPS
  7. 2014-9, Isobutane release
  8. 2014-10, MOC Issue
  9. 2014-12, MOC Issue
  10. 2014-16 MOC Issue
  11. 2014-29, -30, MOC Issue
  12. 2014-TA-26, PRV replacement, OPS
  13. 2014-TA-55, MOC Issue
- 2015 Near Miss List
  1. 2015-13 (1402966), MOC Issue
  2. 2015-24 (1385539), MOC Issue
  3. 2015-7 (1340348), PRV Tank 18

Rite in the Rain

8/11/13

DCS Tour @ 10:30 AM
- Brian Rides / Carlos Alonso
  - escorts

Operator - Robin Fakkema
HTU2 / HTU3 / H2 System
CRU2 / Benzene units (DEBUT)
SUPS - HTU2 Emergency Shutdown
- on line

Backup Power - Generator / Battery

Operator @ DCS station
- 3 to 4 deep

end 10:59 AM

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Followup →

8/11/15

Doc Review

Compliance Audit

- - Need corporate / policy

- PSM/RMP Audit Compliance Report No. 2011-11

- A/Is tracked in Fountain
  - 3 findings - 2011
    MI, Hot Work, Incident Investigation
  - 1 finding - 2014
    Incident Investigation

- PSIA053, PSM Compliance Audit A.120.10

"Reopened yn" field means an audit was done to verify completion of an A/I - can be reopened to add information on action taken.

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Get example

Doc Review 8/11/15
Employee Participation

Procedure PSIA054
- Process Safety Management Employee Participation Program A.120.11, 5/19/15, Rev 4, pg 1-6

- PHA - have an Operator w/ experience/knowledge specific to process participate; review PHA w/ affected employees
- PSM Training - various training materials, computer based, refresher training

- PSM/RMP docs accessible thru plant intranet such as ESP Portal - Universal Tag Locator, Edocs, KMS, ProSteward, etc.

- Safety Meeting weekly

- Joint Health & Safety Committee Meeting Minutes

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5/11/15

Interview

- Brian Ricks, USW Process Safety Rep
  - Incident Investigation
  - Employee Participation / Access

- Fountain Tracking System
  - Employee Demonstration

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8:00 AM 8/12/15

Brian Rick, Process Safety Rep

2010 ~~2010~~ Investigation started Carlos Alonso

Union program.

Causal Learning program taken f

over TOP program

become non corp based

2 Team based - TOP

Salary / hrly

not aware of near miss invest.

- Fountain

- paper

Ross Wilson May 2015 took over

TOP rep ⇒ Fountain

near miss

not sure about how closed

5 why may be done

Turn over in Causal Learning

3 times TOP Rep

last one - one pager on resolution

Feb 2015 have to know how to

have not get report

seen since

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Geno Stemme
~~Jean~~ ~~Gstemme~~
prior HS Rep

little training
access to Fountain
request
report
end of
month
no time frame
look for long
term resolution

Brian 8/12/15

35 yrs - labor, pipe fitter, operations
HT in #2 / #3 operator
6 yrs HS Rep / 5 yrs TOP
per

Carlos Alonso, HSS Rep
22 yrs - Operator Boiler House
new HS Rep

— Audit Fountain w/ HS Rep
- closed items
Adam ~~to~~ Filbey
- difficult to closed items from
Corp w/ union

Fountain => FIM / FAM
~~re~~ ↑ A/I
report

Flare - A/I to put signs instead
of a fence line
need ~~plant mo~~ VP ?
if deviating from A/I

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Turnaround

Employee Participation 8/12/15

good involvement for training

ER not good - changed training for general employees HAZWOPER SPLIT SCBA fire ext. face to face

investigation good

Shutdown - employee involvement in planning for unit
work, decon

Employee deciding on training
no input on changes

Safety Audit - employee involved in selecting contractors

others now
Training changing to Computer based training (CBT)
in the day

Safety Manager - Dan Peek
changed training to CBT

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8/12/15

Access good

PHA recommendation - hard copy
MOC

Investigative Reports
PSI

Equipment memo history - PEI
insp. - can be difficult

CA — not provided / may be

Each Dept has own web page
- to many links - not working
E docs - dwg, procedures, policy

8:40 AM

Solomon
Joe ~~Sutton~~, Fire Chief, prior
TOP rep to Ross Wilson

8/12/15

~~Fountain Tracking System~~

PSR Home page 9:00 AM

EDocs - Access by employee
procedures managing control of docs

PSR website => Process Safety
link to access
PHA

New Employee Orientation
Teri Murder Maker, LDM

EDOC drawings - PID for units

Adam Filby, provided demon-
stration 10 AM

Fountain Tracking System
FIM / FAM
incidents / audits

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Doc Review 8/12/15

Employee Participation

New Employee Orientation (NEO)
- sample training for Operator Edward Castleberry 2008
- provide 1 hr PSM Overview presentation

- JHSC Meeting Minutes 7/7/15
  - provide PSM Rep Report out 7-17-15

- FST Minutes Alky 2 SRU:
  Op Orders Alky 2-SRU, 6/8/15, day shift, Operator Michael Osborne
  and 7/20/15

- 1/8/15 Training Sign In Sheet for PSM / MOC Training. NEO
  - Trained 5 Operators / 1 Maint. Manager

8/12/15

Fountain Tracking System

1:00 PM

Tony Martin, Steve Williams

2012 implemented @ PSR
- globally used by Shell

FIM - Gen. - 1mt Corrective Action used

LFI - Learning from incident

end 2:00 PM

Tone Martin, Data Manager
Coordinator - manager Fountain and coordinates w/ employees on status of action items

Pulled Reports on the following (FIM)
- 2013-2 (329541) - 1344349
- 2013-16 (330733)

Pulled reports on the following (FAM)
- 546764

Any employee can enter incidents into FIM

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8/13/15

Doc Review

Compliance Audit

- PSM/RMP Compliance Audit Certification statement for 2011

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1:00 PM 8/13/15

Met/talked w/ Jim Caddell, Alky Operator and Brian Ricks on issues w/ ① Sulfuric (spent acid) tank process for Alky

- has concerns

② process water separator discharging to sewer system creating high VOC environment.

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TACOMA, WA

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Yes, Rite in the Rain

is a wood-based & recyclable paper, but unlike plain paper...

it won't turn to mush when exposed to:

rain storms | *heavy sweat* | *oil & grease* | *mud & grime* | *laundry mishap*

ALL-WEATHER TOUGH!

USE WET OR DRY

most pens stop writing when wet

- ALL PENCILS
- *RITE IN THE RAIN PENS*
- WAX MARKERS
- CRAYONS
- OIL PASTELS / PAINT

WHEN DRY ONLY

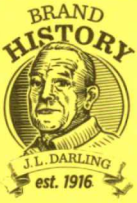
what you write won't wash off

- PERMANENT MARKERS
- STANDARD BALLPOINTS

WON'T WORK

water-based inks bead off sheet

- GEL PENS
- MOST HIGHLIGHTERS
- FOUNTAIN PENS
- WATER COLORS
- ACRYLIC PAINT



The *Rite in the Rain* story began nearly a century ago in the forests of the Great Northwest. Entrepreneur, Jerry Darling, recognized the logging industry's need for a durable material that could be written on and survive in poor weather conditions. Jerry developed a special coating that created a unique moisture shield on the hand-dipped sheets of paper that he and his wife, Mary, processed at their home. From humble beginnings our first all-weather paper was born! Over the many years we've perfected and patented our environmentally responsible coating process. Still located in Tacoma, our continued mission is to provide innovative products for professionals and enthusiasts who brave the outdoors

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other product styles available

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