Phillips 66
Bayway Refinery
P.O. Box 222
1400 Park Avenue
Linden, New Jersey 07036

Certified Mail - RRR
7010 1870 0000 6671 2354

February 28, 2013

US Environmental Protection Agency
Ariel Rios Building
Mail Code 2254A
1200 Pennsylvania Avenue, NW,
Washington, DC 20460
Attn: Robert G. Heiss, Director
International Compliance Assurance Division

2012 Annual Export Report
NJD 986 645 984

Dear Mr. Heiss:

As required by Section 3017 of the Resource Conservation and Recovery Act and under Federal regulations 40 CFR Sections 262.56 and 262.87(a), I submit the "Annual Report of Hazardous Waste Exports for 2012" and waste minimization statements for the Phillips 66 (Formerly ConocoPhillips) owned and operated Bayway Refinery.

Contact me at (908) 523-6022 if you need additional information.

Sincerely,

Anthony Leake
Waste Compliance Engineer

received
SDM 3/5/2013

ANNUAL REPORT OF HAZARDOUS WASTE EXPORTS FOR 2012

1. **PRIMARY EXPORTER** (Consignor)

Name: ConocoPhillips Company / Bayway Refinery
EPA ID No. NJD 986645984
Mailing Address: P.O. Box 222
City: Linden State: New Jersey Zip: 07036

2. **CONSIGNEE**

Name: STABLEX Canada, Inc.
Address 760 Industrial Blvd.
Blainville, Quebec Canada J7C3V4
EPA ID No.: NYD 980756415

3. **TRANSPORTER No. 1:** Name: Freehold Cartage Inc.
EPA ID No.: NJD 054126164

TRANSPORTER No. 2: Name:
EPA ID No.:

TRANSPORTER No. 3: Name:
EPA ID No.:

4. **WASTE INFORMATION**

Description of Waste: Spent Sandblast Abrasives

EPA Waste Numbers: D008

DOT Proper Shipping Name: RQ Waste Environmentally Hazardous Substance, Solid, n.o.s.,(D008), III, RQ-10 (Lead)

DOT Hazard Class: 9 DOT ID Code (UN/NA): UN 3077

5. **SHIPPING INFORMATION**

Number of Shipments during the Calendar Year: 1
Total Volume of this Waste Shipped: 12.34 tons

6. **WASTE MINIMIZATION STATEMENT**

____ Not Required (See Instructions)

____ Submitted with EPA Biennial Report

x Attached

7. **CERTIFICATION**

I certify under penalty of law that I have personally examined and am familiar with the information submitted in this and all attached documents, and that based on my inquiry of those individuals immediately responsible for obtaining the information, I believe that the submitted information is true, accurate, and complete. I am aware that there are significant penalties for submitting false information including the possibility of fine and imprisonment.

Name of Responsible Official: Anthony Leake **Title:** Waste Compliance Engineer

Signed: Anthony J Leake **Date:** 2/27/13

ANNUAL REPORT OF HAZARDOUS WASTE EXPORTS FOR 2012

1. **PRIMARY EXPORTER** (Consignor)

Name: ConocoPhillips Company / Bayway Refinery
EPA ID No. NJD 986645984
Mailing Address: P.O. Box 222
City: Linden State: New Jersey Zip: 07036

2. **CONSIGNEE**

Name: Clean Harbors Canada Inc.
Address RR#1, 4090 Telfer Side Road
Corunna, Ontario, Canada N0N 1G0
EPA ID No.: MIR 000035204

3. **TRANSPORTER No. 1:** Name: Horowith Trucks, Inc.
EPA ID No.: PAD 146714878

TRANSPORTER No. 2: Name:
EPA ID No.:

TRANSPORTER No. 3: Name:
EPA ID No.:

4. **WASTE INFORMATION**

Description of Waste: Abrasives

EPA Waste Numbers: D018

DOT Proper Shipping Name: Hazardous Waste, Solid, n.o.s.,(Benzene), III, RQ-10 (Benzene)

DOT Hazard Class: 9 DOT ID Code (UN/NA): NA 3077

5. **SHIPPING INFORMATION**

Number of Shipments during the Calendar Year: 1
Total Volume of this Waste Shipped: 23.18 tons

6. **WASTE MINIMIZATION STATEMENT**

____ Not Required (See Instructions)

____ Submitted with EPA Biennial Report

x Attached

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Name of Responsible Official: Anthony Leake **Title:** Waste Compliance Engineer

Signed: Anthony Leake **Date:** 2/27/13

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ANNUAL REPORT OF HAZARDOUS WASTE EXPORTS FOR 2012

1. **PRIMARY EXPORTER** (Consignor)

Name: ConocoPhillips Company / Bayway Refinery
EPA ID No. NJD 986645984
Mailing Address: P.O. Box 222
City: Linden State: New Jersey Zip: 07036

2. **CONSIGNEE**

Name: Clean Harbors Canada Inc.
Address RR#1, 4090 Telfer Side Road
Corunna, Ontario, Canada N0N 1G0
EPA ID No.: MIR 000035204

3. **TRANSPORTER No. 1:** Name: Freehold Cartage Inc.
EPA ID No.: NJD 054126164

TRANSPORTER No. 2: Name:
EPA ID No.:

4. **WASTE INFORMATION**

Description of Waste: Processed federal listed hazardous clarified slurry oil sediment

EPA Waste Numbers: K170

DOT Proper Shipping Name: Waste Environmentally Hazardous Substances, Liquid, n.o.s.,(K170),PG III, RQ-1

DOT Hazard Class: 9 DOT ID Code (UN/NA): UN 3082

5. **SHIPPING INFORMATION**

Number of Shipments during the Calendar Year: 4
Total Volume of this Waste Shipped: 81.13 tons

6. **WASTE MINIMIZATION STATEMENT**

____ Not Required (See Instructions)

____ Submitted with EPA Biennial Report

x Attached

7. **CERTIFICATION**

I certify under penalty of law that I have personally examined and am familiar with the information submitted in this and all attached documents, and that based on my inquiry of those individuals immediately responsible for obtaining the information, I believe that the submitted information is true, accurate, and complete. I am aware that there are significant penalties for submitting false information including the possibility of fine and imprisonment.

Name of Responsible Official: Anthony Leake **Title:** Waste Compliance Engineer

Signed: Anthony J Leake **Date:** 2/27/13

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Waste Minimization Statement for Hazardous Characteristic Contaminated Spent Sandblast Abrasives

The Phillips 66 Company owned and operated Bayway Refinery is committed to operating the refinery in an environmentally responsible manner. A source reduction program has been implemented and is continuously being improved.

The Bayway Refinery utilizes crude petroleum as feed stock to produce a complete line of fuel products as well as petrochemical feed stocks and specialty products. The facility does not purchase or produce lead or other hazardous characteristic containing products. The Bayway Refinery uses only environmentally friendly, non-lead based coatings on new and repaired equipment.

As part of the operations of the refinery, rust, scale and paint are removed from transfer lines, storage tanks and process equipment by sand blasting with abrasives in order to prepare surfaces for metal inspection, welding or repainting. Employees have been informed of the potential for lead based coatings at the refinery. They are trained to test dry paints and primers prior to removal and to segregate contaminated media from each job site regardless of generated volume.

Old protective coatings slated for removal are tested by analysis and/or lead stick for lead content. Rather than using a dry sandblast technique, lead based paint from transfer lines, storage tanks and process equipment in difficult to access areas is removed by scraping or by high pressure water and wet garnet blasting, whenever feasible.

Paint removal from tanks is accomplished by either pressure washing, or by utilizing the "Versa Blast" vertical blast cleaning system. The system cleans vertical surfaces by using steel split shot and a very small amount of grit as the blast cleaning media. A hoist system, which is mounted on a fixture at the top of the tank being cleaned, raises and lowers the blast module as the module moves along the surface horizontally. The system is capable of providing white metal finishes.

The horizontal speed, vertical speed, shot flow rate, and fixture movement are adjusted by remote control. The abrasive media are contained, circulated, and cleaned within the blast module. A cyclone separator on the ground separates the steel split shot from the media for re-use and deposits the paint and dust into plastic lined 55-gallon drums. The process reduces the volume of generated lead contaminated hazardous abrasives by up to 95%.

The Bayway Refinery has considered several waste management method alternatives. On-site remediation or fixation of the lead constituent contained in the waste is not feasible because of cost and the lack of treatment permits. Treatment of the low BTU waste by incineration does not reduce the lead hazard and would result in impermissible dilution of the lead component in the incinerator ash. *This minimization statement pertains to shipments of Hazardous Characteristic Contaminated Spent Sandblast Abrasives on pages 1 and 2 of the annual report.*

Waste Minimization Statement for Centrifuged Clarified Slurry Oil Sediment Generated by the Upgrading of "High Ash" Slurry Oil Product

The Phillips 66 Company owned and operated Bayway Refinery is committed to operating the refinery in an environmentally responsible manner. A source reduction program has been implemented and is continuously being improved.

The Bayway Refinery utilizes crude petroleum as feed stock to produce a complete line of fuel products as well as petrochemical feed stocks and specialty products. As part of the various operations at the refinery, clarified slurry oil product is stored in tanks for sale to customers. The product contains up to 0.6% Fluid Catalytic Cracking Catalyst.

The quality of clarified "high ash" slurry oil is upgraded by removing most of the remaining sediment from the product by mechanical means. The oil is heated to 300 degrees Fahrenheit and processed at high gravitational forces through vertical centrifuges. Phases are separated into 90% valuable clean product and 10% sediment laden centrate.

The Bayway Refinery is taking source reduction action to reduce the volume and the toxicity of generated slurry oil sediment cake by choosing experienced, competent and reliable contractors and employing specialized equipment, innovative processing methods, and best available technology. More than 99% clean valuable product is recovered.

The Bayway Refinery currently generates over 6000 tons of K170 listed slurry oil centrate per year. The Bayway Refinery has considered several waste management method alternatives including reuse of the material as an asphalt substitute, the material is currently sent to RCRA permitted cement kilns in the U.S. Mid-West for energy recovery. The waste stream as currently generated consists of 90% heavy fuel oil and 10% organic aluminum silica equilibrium catalyst fines. The fuel oil component heats the cement kiln and the alumina silicate catalyst is a co product used in the manufacture of Portland cement. Occasionally economic down turns and maintenance activities make the reuse option in the United States unavailable and a fraction of the waste material is exported to Canada for disposal. The material is almost completely destroyed during disposal and the small amount of ash left over is sent to landfill. The volume of waste landfilled after destruction exported represents 0.4% of the volume of this material that is otherwise used for energy recovery in the United States. The Bayway Refinery believes the present waste management method to be an environmentally sound method of disposal of material that we can not recycle.

This minimization statement pertains to shipments of Centrifuged Clarified Slurry Oil Sediment on page 3 of the annual report.

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UNITED STATES POSTAGE
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00031 51775 FE
MAILED FROM ZIP C

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1400 Park Avenue
Linden, New Jersey 07036

First Class Mail

First Class Mail

Route EPA Mail

To: Heiss,Robert

Mailstop ARIEL RIOS SOUTH

Department: 2254A

Certified

7010187000066712354

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Ariel Rios Building
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1200 Pennsylvania Ave, NW
Washington, DC 20460
Attn: R.G. Heiss, Director