

RULE 4454 REFINERY PROCESS UNIT TURNAROUND (Adopted May 21, 1992, Amended December 17, 1992)

1.0 Purpose

The purpose of this rule is to limit VOC emissions resulting from the purging, repair, cleaning, or otherwise opening or releasing pressure from a refinery vessel during a process unit turnaround.

2.0 Applicability

The provisions of this rule shall apply to any refinery vessel containing VOCs unless exempted under Section 3.0.

3.0 Exemptions

This rule shall not apply to:

3.1 Any process vessel that has been depressurized to less than 1020 mm Hg (5 psig).

4.0 Requirements

A person shall depressurize any vessel containing VOCs unless the process unit turnaround is accomplished by employing one of the following operating procedures:

4.1 The organic vapors shall either be:

4.1.1 Recovered, added to the refinery fuel gas system and combusted; or

4.1.2 Controlled and piped to an appropriate firebox or incinerated for combustion; or

4.1.3 Flared, until the pressure within the process vessel is as close to atmospheric pressure as is possible.

4.2 All process vessels shall be depressurized into the control facilities to less than 1020 mm Hg (5 psig) before venting/opening to atmosphere.

4.3 All organic compounds which emerge from a refinery process vessel during the purging of said vessel and which otherwise would be emitted to the atmosphere shall be either directed to a flare or incinerator or shall be used for fuel until such disposition of emissions is not technically feasible or is less safe than atmospheric venting. Compliance with this section shall not be construed to require the installation, construction or structural modification of any equipment which is not

required for compliance with the above paragraph requiring controls during depressurization.