

 SOUTH COAST AIR QUALITY MANAGEMENT DISTRICT ENGINEERING & COMPLIANCE DIVISION	APPL. NO. 492088	DATE 12/10/10	PAGE 1 of 11
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PERMIT TO OPERATE

SUMMARY: Change of Condition for Boiler 10 (D429) to impose NOx limits from Consent Decree.

COMPANY INFORMATION

Company Name: ConocoPhillips Company, Facility ID No. 800362
Mailing Address: 1520 E. Sepulveda Blvd, Carson, CA 90745
Equipment Location: 1520 E. Sepulveda Blvd, Carson, CA 90745
Contact Person: Marshall G. Waller, (310) 522-8039

EQUIPMENT DESCRIPTION

Table 1 shows the proposed Section D permit description for Boiler 10 (D429) in Process 11, System 1. Additions to the description are noted in underlines and deletions are noted in ~~strikeouts~~.

Table 1. Permit Equipment Description

SECTION D: FACILITY DESCRIPTION AND EQUIPMENT SPECIFIC CONDITIONS

Equipment	ID No.	Connected To	RECLAIM Source Type/ Monitoring Unit	Emissions * And Requirements	Conditions
Process 11 : STEAM GENERATION					
System 1 : BOILERS					
BOILER, NO. 10, REFINERY/NATURAL GAS, WITH LOW NOX BURNER, FLUE GAS RECIRCULATION, 352 MMBTU/HR WITH A/N: <u>458829 492088</u> BURNER, 4 BURNERS, 88 MMBTU/HR EACH, REFINERY/NATURAL GAS, COEN COMPANY, MODEL DELTA POWER II-27	D429	C921	NOX: MAJOR SOURCE**; SOX: MAJOR SOURCE**	CO: 2000 PPMV (5)[RULE 407, 4-2-1982]; PM: (9) [RULE 404, 2-7-1986]; PM: 0.1 GRAINS/SCF (5) [RULE 409, 8-7-1981; <u>NOX: 0.015 LBS/MMBTU [CONSENT DECREE CIVIL NO. H-05-0258, 8-11-2008]</u>	<u>A63.5, A195.1</u> , A305.2, B61.1, C1.21, D12.5, D28.14, D90.6, D328.1, H23.6

COMPLIANCE RECORD REVIEW

A query of the AQMD Compliance Database for the past two years (12/1/08 to 12/10/10) identified 8 NOV's that were issued to the ConocoPhillips Carson Refinery (Facility ID 800362). None of these NOV's were related to this permit unit; thus the compliance database indicates that Boiler 10 (D429) is currently in compliance with applicable rules and regulations.

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FEE EVALUATION

The BCAT for Boiler No. 10 (D429) is 011605 [Boiler (>20-50 MMBtu/hr) Process Gas], Schedule E. Fees of \$3008.18 were paid when the application was submitted, but the fees due are \$4,416.74. The discrepancy in fees was due to a deficit in the fee submitted for A/N 491608 for TV facility permit revision (submitted at the same time.) Thus, an additional \$1,408.56 is due, and will be invoiced when this application is processed.

BACKGROUND/HISTORY

The ConocoPhillips Carson Refinery is a Title V facility, as well as a NO_x and SO_x RECLAIM facility. A summary of the permitting history for Boiler 10 (including the Boiler 10 SCR) is provided in **Table 2**

ConocoPhillips entered into a consent decree filed 1/27/05 that included requirements specific to the Carson Refinery as well as other ConocoPhillips refineries. The Consent Decree has since had two amendments [Consent Decree Civil No. H-05-0258, 8-11-2008]. Boiler 10 is impacted by requirements in Section F (NO_x Emissions Reductions from Combustion Units).

Paragraph 112 (NSPS Applicability of Heaters and Boilers at the LAR Carson and Wilmington Plants) requires that all heaters and boilers at the Carson and Wilmington refineries be affected facilities subject to the requirements of NSPS Subpart J (40CFR60, Subpart J). A/N's 445833 was submitted to request that NSPS J applicability and emission limits be imposed in the permit. A/N 445833 was consolidated with A/N 458829, and the NSPS J requirements for Boiler 10 were added to the permit as part of the Statement of Basis applicability review for the initial Title V permit (12/5/07 permit revision). Conditions B61.1 D90.6 and H23.6 impose H₂S limits and require compliance with NSPS J for Boiler 10.

The Boiler 10 SCR was installed to comply with paragraph 95 of the Consent Decree [Consent Decree Civil No. H-05-0258, 8-11-2008], which required that Qualifying Controls to reduce NO_x emissions be installed by December 31, 2012. The SCR did not initially perform as expected, and was temporarily taken out of service 2 ½ months after it was put online. A/N 458829 was submitted to request an extension on the time limit for required source testing due to the delays in achieving full operability. The facility was ultimately able to make the changes necessary to allow its effective operation. Condition A305.2 allows operational flexibility in the operation of both the SCR and the FGR for Boiler 10.

This change of condition application (A/N 492088) is to add device conditions to Boiler 10 (D429) as required by the Consent Decree H-05-0258 between the United States Environmental Protection Agency and ConocoPhillips Company (COP). The conditions are required to ensure that NO_x emission reductions from combustion units meet the requirements in paragraphs 95 and 98 of the Consent Decree. The required limits to be imposed on Boiler 10 are a maximum NO_x limit of 0.015 lb NO_x/MMBtu (HHV) on a 365 day rolling average and a maximum annual limit

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of 23.2 tons NOx per calendar year. The limits are imposed in the Emissions and Requirements Column of the permit description and in Conditions A63.5 and A195.1.

Table 2. Permitting History for Boiler 10 (D429) and Boiler 10 SCR (C921) (P11S1)

A/N {permit#}	Facility ID	Type	Status	Permit issued	Description
BOILER 10					
492088	800362	60	20	-	Change of condition to impose Consent Decree NOx limits
458829	800362	60	31	12/15/10	Change of condition to add consent decree requirements for NSPS J applicability and extend source testing requirement deadline
445833	800362	60	52	-	Change of condition to add consent decree requirements; NSPS J applicability (cancelled, consolidated with A/N 458829)
<i>5/19/04 rebuilt (post-explosion) boiler started up (rebuild was not reconstruction)</i>					
429262	800362	50	52	9/1/04	Modification to add SCR to boiler
<i>7/23/03 explosion damaged boiler; boiler shut down and rental boiler (A/N 374098) used in the interim</i>					
405224	800362	50	52	3/19/03	Modification to install low-NOx burners and allow optional use of FGR
390144	800362	50	52	9/28/01	Modification to operate boiler with temporary R&D project AquaNOx scrubbing system
325705 {F6561-active}	800362	40	31	4/17/97	Change of ownership from Unocal to Tosco/ConocoPhillips
323855 {F5249}	89814	50	31	2/6/97	Modification to remove fuel oil as permitted fuel
310441 {F00144}	89788	60	31	6/18/96	Change of condition to update permit NOx limits
297529 {D89294}	89788	50	31	3/20/95	Modification to remove SCR from equipment description
257920	88892	10	50	12/11/91	Change of ownership from Shell to Unocal
211789	17186	19	50	9/18/90	Modification to install SCR (A/N 211790) (cancelled; not completed)
140033	17186	10	50	5/5/86	Modification to add Low-NOx burners and FGR for Rule 1109 compliance
A56204 {P46169}	17186	0	31	9/29/71	New construction of Boiler 10
SCR - BOILER 10					
458831	800362	60	31	12/15/10	Change of condition for Boiler 10 SCR (C921) to allow additional time for initial source testing due to operational problems.

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A/N {permit#}	Facility ID	Type	Status	Permit issued	Description
426494	800362	10	52	9/1/04	New construction of SCR for Boiler 10 (installed and operated for 2.5 months, but taken out of service 4/24/06—did not achieve expected NOx reductions and restricted boiler firing rate due to high pressure drop across SCR catalyst.)

The facility requested changes to Condition A305.2 to clarify the requirement to operate within the range of the RECLAIM CEMS analyzer. During boiler startup and shutdown, it may not be feasible for the SCR and FGR to operate, yet it is possible for the emissions to exceed the range of the certified CEMS at these times. Thus, it is not a violation of this permit condition if the range is exceeded during startup or shutdown, and language is being added to clarify this issue. The RECLAIM rules include procedures for estimating emissions during startup and shutdown when CEMS data is not available, thus no change in emissions is allowed or implied as a result of this change of condition.

EMISSIONS

This change of condition imposes new limits on NOx emissions. No other changes to emissions are included in this permit application. NOx emissions were previously estimated as 8.55 lb/hr. With the new limits, NOx emissions are limited to 5.3 lb/hr.

RULES EVALUATION

PART 1: SCAQMD REGULATIONS

- Rule 212 Standards for Approving and Issuing Public Notice (Amended 11/14/97)**
 Rule 212 requires public notice for any new or modified permit unit, RECLAIM source or Title V equipment that increases emissions of toxic air contaminants and increases health risk as specified in 212(c)(1) - (c)(3). This change of condition does not include any increases in emissions or health risk; thus, public notice is not required.
- Rule 401 Visible Emissions (Amended 11/09/01)**
 Operation of this permit unit is not expected to result in visible emissions. The facility is currently in compliance with this rule and is expected to continue to operate in compliance with this rule.
- Rule 402 Nuisance (Adopted 05/07/76)**
 Operation of this permit unit is not expected to result in a public nuisance. The facility is currently in compliance with this rule and is expected to continue to operate in compliance with this rule.
- Rule 404 Particulate Matter - Concentration (Amended 02/07/86)**
 Rule 404 limits the particulate concentration that can be discharged from these permit units. This emission limit is referenced in the Emissions and Requirements column of the facility permit. For a 352 MMBtu/hr capacity heater (Boiler 10) with exhaust flow rates

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of 51,099 dscfm, the corresponding allowable PM limit is 0.04309 grains/cubic foot. The calculated particulate matter concentration for this device is .005741 grains/scf, using a PM emission factor of 7.5 lb/MMscf and assuming natural gas properties. This concentration is significantly lower than the limit for this device; thus, the facility is currently in compliance with this rule and is expected to continue to operate in compliance with this rule.

- Rule 407 Liquid and Gaseous Air Contaminants (Amended 04/02/82)**
This rule imposes a 2000 ppmv limit on CO emissions. This emission limit is referenced in the Emissions and Requirements column of the facility permit. Compliance with this rule is monitored by Condition D328.1 for Boiler 10. The facility is currently in compliance with this rule and is expected to continue to operate in compliance with this rule.
- Rule 409 Combustion Contaminants (Amended 08/07/81)**
This rule limits combustion emissions to less than 0.1 grain per ft³ of gas. This emission limit is referenced in the Emissions and Requirements column of the facility permit. As described in the Rule 404 section of this evaluation, the calculated particulate matter concentration for Boiler 10 is 0.0057 grains/scf. Thus, the facility is currently in compliance with this rule and is expected to continue to operate in compliance with this rule.
- Rule 1109 Emissions of Oxides of Nitrogen from Boilers and Process Heaters in Petroleum Refineries (Amended 08/05/88)**
According to Table 1 of Rule 2001(j), RECLAIM facilities are exempt from the NOx emission requirements of Rule 1109. There are no other applicable requirements in this rule.
- Rule 1146 Emissions of Oxides of Nitrogen from Industrial, Institutional and Commercial Boilers, Steam Generators, and Process Heaters (Amended 11/17/00)**
Rule 1146(a)(2) states that refinery boilers and process heaters with a rated heat input capacity >40 MMBtu/hr are not subject to Rule 1146 requirements. Table 1 of Rule 2001(j) additionally states that RECLAIM facilities are exempt from the NOx emission requirements of Rule 1146. Thus, Boiler 10 is not subject to Rule 1146 requirements.
- Reg XIII New Source Review (Amended 12/06/02)**
Rule 1303 Requirements (Amended 12/6/02)
New Source Review requirements apply to new, modified or relocated sources. According to Table 1 of Rule 2001(j), RECLAIM facilities are exempt from the requirements of Regulation XIII with regard to NOx and SOx emissions. New Source Review requirements apply to new, modified or relocated sources. This change of condition is not a physical modification and does not result in increased emissions. Thus, no additional requirements of this regulation apply. The facility is currently in compliance with this rule and is expected to continue to operate in compliance with this rule.
- Reg XIV Toxics and Other Non-Criteria Pollutants**
Rule 1401: New Source Review of Toxic Air Contaminants (Amended 03/04/05)
Rule 1401 applies to new, modified or relocated permit units that emit Toxic Air Contaminants (TAC). This change of condition application does not involve any increase

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in emissions; thus, no additional requirements apply. The facility is currently in compliance with this rule and is expected to continue to operate in compliance with this rule.

Reg XX Regional Clean Air Incentives Market (RECLAIM)

Rule 2004: Requirements (Amended 04/06/07)

Rule 2004 includes provisions relating to permits, allocations, reporting, variances, and breakdowns. These include the requirement to certify facility-wide emissions on a quarterly basis and not to exceed the facility's annual emissions allocation. In addition, breakdowns are required to be reported to the District within one hour of the breakdown and a follow-up breakdown report is required within 7 days after the breakdown has been corrected. Boiler 10 is currently in compliance with this rule and is expected to continue to comply with the requirements of this rule.

Rule 2005: New Source Review for RECLAIM (Amended 05/06/05)

Rule 2005 applies to NOx and/or SOx RECLAIM facilities and requires BACT and modeling for modifications that result in an emissions increase [2005(c)(1)]. An emission increase is defined as an increase in the maximum hourly potential to emit [2005(d)]. This change in condition does not cause or allow an emission increase. Thus, no additional requirements apply.

Rule 2011: Requirements for Monitoring, Reporting, and Recordkeeping for Oxides of Sulfur (SOx) Emissions (Amended 05/06/05)

Due to the use of refinery gas fuel, Boiler 10 (D429) is classified as RECLAIM Major SOx source [2011(c)(1)(D)], and is thus subject to the monitoring, reporting and recordkeeping requirements of Rule 2011(c)(2). For major SOx sources, a continuous emission monitoring system (CEMS) is required. This boiler complies with RECLAIM by electronically transmitting CEMS SOx emissions data on a daily basis, and also submitting a Monthly Emissions Report, summarizing the SOx emissions on a monthly basis. Boiler 10 is currently in compliance and is expected to continue to comply with all applicable RECLAIM requirements.

Rule 2012: Requirements for Monitoring, Reporting, and Recordkeeping for Oxides of Nitrogen (NOx) Emissions (Amended 05/06/05)

Boiler 10 (D429) is classified as a RECLAIM Major NOx source [2012(c)(1)], and is thus subject to the monitoring, reporting and recordkeeping requirements of Rule 2012(c)(2) and (c)(3). For major NOx sources, a continuous emission monitoring system (CEMS) is required. Boiler 10 complies with RECLAIM by electronically transmitting CEMS NOx emissions data on a daily basis, and also submitting a Monthly Emissions Report, summarizing the NOx emissions on a monthly basis. Boiler 10 is currently in compliance and is expected to continue to comply with all applicable RECLAIM requirements.

Reg XXX Title V Permits

Rule 3002 Requirements (Amended 11/14/97) This application is classified as an minor permit revision as defined in 3000(b)(12)(A). Minor permit revisions are exempt from public participation per 3006(b) but are required to be submitted to the EPA per 3003(j)(1)(A).

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PART II: STATE REGULATIONS

CEQA **California Environmental Quality Act (Amended 01/01/05)**
The requirements of CEQA were imposed when the permits to construct were issued. No additional requirements apply.

PART III: FEDERAL REGULATIONS

40CFR60 **Subpart Db Standards of Performance for Industrial-Commercial-Institutional Steam Generating Units (Amended 01/28/2009)**

Subpart Db requirements apply to steam generating units constructed, modified or reconstructed after 6/19/84 rated for >100MMBtu/hr. Per 40CFR60 Subpart A definitions, Modification means a physical change that results in an emission increase, and Reconstruction means the replacement of components such that the cost of the new components exceeds 50% of the cost of a comparable new facility.

Boiler 10 is a steam generating unit with a rated capacity of 352 MMBtu/hr. The boiler was rebuilt after it sustained damages in a 7/23/03 explosion. The boiler was rebuilt to the condition it was in before the failure with no increase in maximum design capacity and no change in emissions profile. Based on correspondence with the facility (email from Marshall Waller to Pang Mueller dated 1/22/04), and as reviewed by AQMD staff (email from Tran Vo to Marshall Waller dated 2/27/04), the rebuild of the boiler was not considered reconstruction as defined in 40CFR60 Subpart A, Section 60.15. The cost to rebuild the boiler was less than 50% of the cost of a comparable new boiler.

Since the boiler has not been modified or reconstructed (per Subpart A definitions) since its original construction in 1969 (PO# P46169 issued in 1971), Boiler 10 is not subject to the requirements of NSPS Subpart Db.

40CFR60 **Subpart J Standards of Performance for Petroleum Refineries (Amended 06/24/2008)**

The requirements of Subpart J apply to fuel gas combustion devices at petroleum refineries (Condition H23.6). Boiler 10 is required to use fuel gases containing less than 160 ppmv H₂S (Condition B61.1), and is also required to continuously monitor either the fuel gas composition or the exhaust sulfur at the stack (Condition D90.6). The facility is currently in compliance with this regulation and is expected to continue to operate in compliance with this regulation.

40CFR61 **Subpart FF National Emission Standard for Benzene Waste Operations (Amended 12/4/03)**

The facility is required to identify benzene-containing streams and limit the amount of uncontrolled benzene emitted. The Consent Decree (Section H, Paragraph 212) requires that the facility sample End-of-Line streams and other streams with significant contributions to total annual benzene (TAB) in accordance with the "Benzene Waste Operations Revised Sampling Plan (6BQ Compliance Option)" dated 2/26/09. Sampling results were provided in the Consent Decree Semiannual Progress Report (July 2010).

The Benzene NESHAP Annual Report - 2009, dated 3/29/2010, indicates that the facility had a total annual benzene quantity (TAB) of 21.39 Mg/yr. Since the TAB is ≥ 10

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Mg/yr, the facility has chosen to comply with the requirements of 61.342(e), (the 6BQ option) which includes a limit for benzene in aqueous (>10 vol% water) waste streams of ≤ 6.0 Mg/yr [61.342(e)(2)(i)]. The Annual Report for 2009 noted that 3.06 Mg/yr is the portion of the TAB that applies to the 6.0 Mg/yr limit (described as “uncontrolled” benzene in the Annual Report).

The most recent quarterly BWON report, dated 7/16/10, indicates that the facility is projected to emit less than the 6 Mg/yr limit of uncontrolled benzene in 2010 and will comply with the 6BQ option. Thus, the facility is currently in compliance with this regulation and is expected to continue to operate in compliance with this regulation.

40CFR63 Subpart DDDDD National Emission Standards for Hazardous Air Pollutants for Industrial, Commercial, and Institutional Boilers and Process Heaters (Promulgated 12/6/06)

EPA promulgated NESHAPs for new and existing industrial/commercial/institutional boilers and process heaters on 9/13/04. The US Court of Appeals issued a decision vacating in its entirety and remanding Subpart DDDDD on June 8, 2007. A revised rule was proposed on 6/4/10, and hearings were held in June, 2010 in Arlington, Virginia; Houston, Texas; and Los Angeles, California. The most recent EPA action on this regulation was an extension of the comment period on the proposed rule until 8/23/10. The proposed rule states that existing process heaters will need to comply within 3 years after the final rule is published in the federal register. The facility is expected to operate in compliance with this regulation within 3 years of its finalization.

RECOMMENDATIONS

Based on the above evaluation, it is recommended that the permit to construct be converted to a permit to operate. It is recommended that a Permit to Operate be issued with the following conditions.

CONDITIONS

DEVICE CONDITIONS

A63.5 The operator shall limit emissions from this equipment as follows:

<u>Contaminant</u>	<u>Emissions Limit</u>
<u>NOx</u>	<u>Less than or equal to 23.2 tons in any calendar year</u>

[CONSENT DECREE CIVIL NO. H-05-0258, 8-11-2008]

[Devices subject to this condition: D429]

A195.1 The 0.015 lbs/MMBtu NOx emission limit(s) is averaged over 365 day rolling average.

[CONSENT DECREE CIVIL NO. H-05-0258, 8-11-2008]

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[Devices subject to this condition: D429]

A305.2 Whenever this equipment is in operation, the FGR and the SCR serving this equipment **during normal operation (excluding startups and shutdowns)** may be operated at any control efficiency provided that the emission concentrations being monitored by the certified CEMS serving this equipment is below the valid upper range specified in the approved CEMS plan.

During startups and shutdowns of this equipment, the FGR and the SCR serving this equipment may be operated at any control efficiency.

[RULE 2012, 5-6-2005]

[Devices subject to this condition: D429]

This condition is being modified at the facility's request to clarify that the SCR and FGR are not required to be operated during startup and shutdown, and thus exceeding the CEMS range would not be a violation during startup and shutdown.

B61.1 The operator shall not use fuel gas containing the following specified compounds:

Compound	ppm by volume
H2S greater than	160

The H2S concentration limit shall be based on a rolling 3-hour averaging period.

[40CFR 60 Subpart J, 6-24-2008; CONSENT DECREE CIVIL NO. H-05-0258, 8-11-2008]

[Devices subject to this condition: D59, D210, D429, D430, C538]

C1.21 The operator shall limit the firing rate to no more than 352 MMBtu per hour.

To comply with this condition, the operator shall monitor and record the fuel rate and the high heating value of the refinery/natural gas. Such records shall be made available to the District personnel upon request.

[RULE 1301, 12-7-1995]

[Devices subject to this condition: D429, D430]

D12.5 The operator shall install and maintain a(n) fuel flow meter to accurately indicate the flue gas flow at the recirculation line.

The operator shall record the parameter being monitored once every 15 minute(s).

The operator shall record the parameter whenever the boiler is operating and the FGR is in use.

[RULE 1303(a)(1)-BACT, 5-10-1996, RULE 1303(a)(1)-BACT, 12-6-2002]

[Devices subject to this condition: D429, D430]

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D28.14 The operator shall conduct source test(s) in accordance with the following specifications:

The test shall be conducted at least annually to determine the emission rate of ammonia at the outlet of the SCR with the SCR in full use. Testing shall also be conducted at least once every three years for PM and PM10 at the outlet of the SCR with the SCR in full use.

The test shall be conducted with the boiler operating at least 80 percent of the permitted maximum capacity or within a capacity range approved by the District. The operator shall submit a test protocol to the District at least 60 days prior to the testing.

The test shall be conducted according to the approved test protocol. The District shall be notified of the date and time of the test at least 10 days prior to the test. Report of the test data, operating conditions of the equipment, and NH3 injection rate during the test shall be submitted to the District within 60 days after the test.

[RULE 1303(b)(2)-Offset, 5-10-1996, RULE 1303(b)(2)-Offset, 12-6-2002]

[Devices subject to this condition: D429, C921]

D90.6 The operator shall continuously monitor the H2S concentration in the fuel gases before being burned in this device according to the following specifications:

The operator shall use an NSPS Subpart J approved instrument meeting the requirements of 40CFR60 Subpart J to monitor the parameter.

The operator shall also install and maintain a device to continuously record the parameter being monitored.

The operator may monitor the H2S concentration at a single location for fuel combustion devices, if monitoring at this location accurately represents the concentration of H2S in the fuel gas being burned in this device.

[40CFR 60 Subpart J, 6-24-2008]

[Devices subject to this condition: D59, D210, D429, D430, C538]

D328.1 The operator shall determine compliance with the CO emission limit(s) either: (a) conducting a source test at least once every five years using AQMD Method 100.1 or 10.1; or (b) conducting a test at least annually using a portable analyzer and AQMD-approved test method. The test shall be conducted when the equipment is operating under normal conditions to demonstrate compliance with the CO emission limit(s). The operator shall comply with all general testing, reporting, and recordkeeping requirements in Sections E and K of this permit.

[RULE 3004(a)(4)-Periodic Monitoring, 12-12-1997; RULE 407, 4-2-1982]

[Devices subject to this condition: D59, D210, D429, D430]

H23.6 This equipment is subject to the applicable requirements of the following rules or regulations:



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Contaminant

Rule

Rule/Subpart

H2S

40CFR60, SUBPART

J

[40CFR 60 Subpart J, 6-24-2008; CONSENT DECREE CIVIL NO. H-05-0258, 8-11-2008]

[Devices subject to this condition: D59, D210, D429, D430]