



03/HSE/ENV/202/04

10.06.2021

To

**The Additional Principal Chief conservator of Forests (C)**  
**Ministry of Environment, Forest & Climate Change**  
**4<sup>th</sup> Floor, E&F Wings, Kendriya sadan, Koramangala**  
**Bangalore-560 034**

Dear Sir,

**Sub: Submission of Half yearly compliance report on Environmental Clearance issued by the Ministry of Environment, Forests and Climate Change (MoEF & CC)**

**Ref: EC Nos.J-11011/341/2011-IA-II (I) dated 22.11.2012; and Amendment dated 23.05.2014 issued to the "Integrated Refinery Expansion Project (IREP) of M/s Bharat Petroleum Corporation Ltd, Kochi at Ambalamugal".**

Please find enclosed the compliance reports on the various conditions laid down by MoEF &CC, pertaining to the half year period from **1<sup>st</sup> October 2020 to 31<sup>st</sup> March 2021** for the said project.

Thanking you,

Very truly yours

For BPCL Kochi Refinery.

**Ramachandran. M.K**

**General Manager i/C (HSE)**

- Encl:
- |                                  |                                |
|----------------------------------|--------------------------------|
| 1. Six Monthly Compliance Report |                                |
| 2. Annexure - I                  | Emission Details               |
| 3. Annexure - II                 | Ambient Air Details            |
| 4. Annexure - III                | Quality of Effluent discharged |
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| 8. Annexure - VII                | CREP Compliance                |

CC:

1. The Member Secretary  
Central Pollution Control Board  
Parivesh Bhawan  
East Arjun Nagar, New Delhi- 110032

2. The Member Secretary  
Kerala State Pollution Control Board  
Plamoodu Junction  
Pattom Palace, Thiruvananthapuram - 695 004

पोस्ट बैग नं: 2, अम्बलमुगल - 682 302, एरणाकुलम ज़िला, केरल, दूरभाष: 0484 - 2722061 - 69 फैक्स: 0484 - 2720961 / 2721094  
पंजीकृत कार्यालय: भारत भवन, 4 & 6, कुरीम्भोय रोड, बेलार्ड इस्टेट, पी. बी. नं. 688 मुंबई - 400 001

**Compliance Status of Environmental Clearance conditions for installation of "Integrated Refinery Expansion Project (IREP) at BPCL – Kochi Refinery project accorded by J-11011/341/2011-IA-II (I) dated 22.11.2012; and Amendment dated 23.05.2014.**

<b>Status of the project: Project commissioned in 2016</b>		
	<b>COMMENTS</b>	<b>Compliance Status</b>
<b>SPECIFIC CONDITIONS:</b>		
i	Compliance to all the environmental conditions stipulated in the environmental clearance letter nos. J-11011/32/90-IA.II dated 20 <sup>th</sup> August, 1991 J-11011/78/1996-IA.II (I) dated 5 <sup>th</sup> March, 1997 and J-11011/238/2008-IA.II (I) dated 18 <sup>th</sup> February, 2009 shall be satisfactorily implemented and compliance reports submitted to the Ministry's Regional Office at Bangalore.	Complied.
ii	M/s BPCL shall comply with new standards/norms for Oil Refinery Industry notified under the Environment (Protection) Rules, 1986 vide G.S.R. 186 (E) dated 18 <sup>th</sup> March, 2008.	Complied.
iii	Adequate stack height shall be provided to heaters, furnaces, VGO, HSD and utility boilers as per CPCB/Kerala State Pollution Control Board (KSPCB) guidelines to disperse gases emissions into the atmosphere. Low NOx burners shall be provided to Heaters/furnaces with on-line analysers. Low sulphur fuel shall be used.	Complied.
iv	Continuous on-line stack monitoring for SO <sub>2</sub> , NOx and CO of all the stacks shall be carried out.	Complied.
v	The process emissions [SO <sub>2</sub> NOx, HC (Methane & Non-methane)] VOCs and Benzene from various units shall conform to the standards prescribed under the Environment (Protection) Act. At no time, the emission levels shall go beyond the stipulated standards.  In the event of failure of pollution control system(s) adopted by the unit, the unit shall be immediately put out of operation and shall not be restarted until the desired efficiency of the pollution control device has been achieved.	Complied.  Complied.
vi	Leak detection and repair program shall be prepared and implemented to control HC/VOC emissions. Focus shall be given to prevent fugitive emissions for which preventive maintenance of	Complied. 948 no of Hydrocarbon detectors are installed at different locations of refinery.



	pumps, valves, pipelines are required. Proper maintenance of mechanical seals of pumps and valves shall be given. A preventive maintenance schedule for each unit shall be prepared and adhered to. Fugitive emissions of HC from product storage tank yards etc. must be regularly monitored. Sensors for detecting HC leakage shall be provided at strategic locations.	
vii	SO <sub>2</sub> emissions after expansion from the plant shall not exceed 1518 kg/hr and further efforts shall be made for reduction of SO <sub>2</sub> load through use of low sulphur fuel. Sulphur recovery units shall be installed for control of H <sub>2</sub> S emissions. The overall sulphur recovery efficiency of Sulphur Recovery Unit with tail gas treating shall not be less than 99.9%. (The SO <sub>2</sub> emission was reduced from 1582 Kg/Hr. to 1518 Kg/Hr. based on the EC amendment dated 23.05.2014).	Complied.
viii	As proposed, record of Sulphur balance shall be maintained at the Refinery as part of the environmental data on regular basis. The basic component of sulphur balance include sulphur input through feed (sulphur content in crude oil), sulphur output from Refinery through products, by-product (elemental sulphur), atmospheric emissions etc.	Complied.
ix	Flare gas recovery system shall be installed.	Installed in February 2018.
x	Ambient air quality monitoring stations [PM <sub>10</sub> , PM <sub>2.5</sub> , SO <sub>2</sub> , NO <sub>x</sub> , H <sub>2</sub> S, Mercaptan, non-methane-HC and Benzene] shall be set up in the complex in consultation with Kerala State Pollution Control Board, based on occurrence of maximum ground level concentration and down-wind direction of wind. The monitoring network must be decided based on modeling exercise to represent short term GLCs.	Complied.
xi	Ambient air quality data shall be collected as per NAAQES standards notified by the Ministry on 16 <sup>th</sup> November, 2009 and trend analysis w.r.t. past monitoring results shall also be carried out. Adequate measures based on the trend analysis	Complied.

	shall be taken to improve the ambient air quality in the project area.	
xii	The gaseous emissions from DG set shall be dispersed through adequate stack height as per CPCB standards. Acoustic enclosure shall be provided to the DG sets to mitigate the noise pollution. Besides, acoustic enclosure/silencer shall be installed wherever noise levels exceed the limit.	Complied. DG set are used only in the extreme emergency(for lighting)
xiii	Total water requirement from River Periyar after expansion shall not exceed 3083.3 m <sup>3</sup> /hr. and prior permission shall be obtained from the competent authority.  Industrial effluent generation will be 1400 m <sup>3</sup> /hr and treated in the effluent treatment plant. Treated effluent shall be recycled/reused within the factory premises and remaining treated effluent shall be discharged into Chitrapuzha River after conforming to the standards prescribed for the effluent discharge and obtaining permission from the KSPCB, which shall not exceed 410 m <sup>3</sup> /hr. Domestic sewage shall be treated in sewage treatment plant (STP).	Complied.          Complied.
xiv	All the effluents after treatment shall be routed to a properly lined guard pond for equalization and final control. In the guard pond, automatic monitoring system for flow rate, pH and TOC shall be provided.	Complied.
xv	Oil catchers/oil traps shall be provided at all possible locations in rain/storm water drainage system inside the factory premises.	Provided.
xvi	A study shall be conducted to identify the source of odor and remedial measures to control the odor problem shall be taken. Study report shall be submitted to the Ministry's Regional office at Bangalore within 6 months from the date of issue of this letter.	Complied.
xvii	Improvement in the sludge handling area is required and scheme for final disposal of sludge shall be prepared and submitted to the Ministry's Regional office at Bangalore.	Sludge handling area housekeeping improved and Final sludge disposal scheme submitted.
xviii	Oily sludge shall be disposed-off into Coker.	Complied.



	Annual Oily sludge generation and disposal data shall be submitted to the Ministry's Regional Office and CPCB.	Oily sludge is disposed in Delayed Coker Unit (DCU). Annual sludge generation and disposal data being submitted to Regional Office and CPCB.
xix	The Company should strictly comply with the rules and guidelines under Manufacture, Storage and Import of Hazardous Chemicals Rules, 1989 as amended in October, 1994 and January, 2000. Hazardous waste should be disposed of as per Hazardous Waste (Management, Handling and Trans-boundary Movement) Rules, 2008 and amended time to time.	Complied.
xx	The membership of common TSDF should be obtained for the disposal of hazardous waste. Copy of authorization or membership of TSDF should be submitted to Ministry's Regional Office at Bangalore. Chemical/inorganic sludge shall be sent to treatment storage disposal facility (TSDF) for hazardous waste. Spent catalyst shall be sent to authorize recyclers/re-processors.	BPCL-KR has entered into a waste disposal agreement with M/s Kerala Enviro Infrastructure Limited to dispose hazardous waste. Spent catalyst is being sent to authorized recyclers/re-processors / disposal agencies.
xxi	Proper oil spillage prevention management plan shall be prepared to avoid spillage/leakage of oil/petroleum products and ensure regular monitoring.	BPCL-KR is having an oil spillage contingency plan for SPM. Inside the refinery complex, adequate facilities are maintained to prevent and contain oil spillage.
xxii	The company shall strictly follow all the recommendation mentioned in the Charter on Corporate Responsibility for Environmental protection (CREP).	Complied.
xxiii	To prevent fire and explosion at oil and gas facility, potential ignition sources shall be kept to a minimum and adequate separation distance between potential ignition sources and flammable materials shall be in place.	Complied as per OISD guidelines.
xxiv	Green belt shall be developed at least in 33% of the plant area in and around the plant premises to mitigate the effects of fugitive emissions all around the plant as per the CPCB guidelines in consultation with DFO. Thick green belt with suitable plant species shall be developed around unit. Selection of plant species shall be as per the CPCB guidelines.	BPCL-KR is having a total area of 1344 acres of land (including the new projects MSBP / PDPP). In this, Plant area accounts (including offsite, Pipe rack, Buildings, Roads) for 909.01 acres. The statutory requirement of green belt as specified in Environmental Clearance is 33% of the plant area. Hence the green

		cover requirement is 300 acres. Based on latest survey done we are having a total green cover of 315 acres which is well above required 300 acres required as per EC conditions.
xxv	Company shall prepare project specific environmental manual and a copy shall be made available at the project site for the compliance.	Complied
xxvi	All the recommendations mentioned in the rapid risk assessment report, disaster management plan and safety guidelines shall be implemented.	Complied
xxvii	All the issues raised and commitment made during the public hearing/consultation meeting held on 14 <sup>th</sup> February 2012	All feasible and applicable concerns addressed.
xxviii	Company shall adopt Corporate Environment Policy as per the Ministry's O.M. No. J-11013/41/2006-IA.II (I) dated 26 <sup>th</sup> April, 2011 and implemented.	BPCL as a Corporation is having a Corporate HSSE Policy which includes Environment also.
xxix	Provision shall be made for the housing of construction labor within the site with all necessary infrastructure and facilities such as fuel for cooking, mobile toilets, Safe drinking water, medical health care, crèche etc. The housing may be in the form of temporary structures to be removed after the completion of the project.	Complied.

**GENERAL CONDITIONS:**

i	The project authorities must strictly adhere to the stipulations made by the State Pollution Control Board (SPCB), State Government and any other statutory authority.	BPCL-KR will adhere to the stipulations made by KSPCB, State Govt. and other statutory bodies.
ii	No further expansion or modification in the project shall be carried out without prior approval of the Ministry of Environment & Forests. In case of deviations or alterations in the project proposal from those submitted to this Ministry for clearance, a fresh reference shall be made to the Ministry to assess the adequacy of conditions imposed and to add additional environmental protection measures required, if any.	BPCL-KR had sought some amendments to the EC conditions from MoE&F. MoE&F has accorded the EC amendment on 23 <sup>rd</sup> May 2014.
iii	The project authorities must strictly comply with the rules and regulations under manufacture, Storage and import of Hazardous Chemical Rules,	BPCL-KR has obtained approvals from Chief Inspectorate of Factories, Chief Controller of Explosives, Fire Safety



	2000 as amended subsequently. Prior approvals from Chief Inspectorate of Factories, Chief Controller of Explosives, Fire Safety Inspectorate etc. must be obtained, wherever applicable.	Inspectorate etc. BPCL-KR complied the rules and regulations under manufacture, Storage and import of Hazardous Chemical Rules, 2000.
iv	The overall noise levels in and around the plant area shall be kept well within the standards by providing noise control measures including acoustic hoods, silencers, enclosures etc. on all sources of noise generation. The ambient noise levels shall conform to the standards prescribed under EPA Rules, 1989 viz. 75 dBA (day time) and 70 dBA (night time).	The overall noise level will be limited at the fence as prescribed under EPA rules
v	A separate Environmental Management Cell equipped with full-fledged laboratory facilities must be set up to carry out the environmental management and monitoring functions.	BPCL-KR is having a separate Environment Management cell to carry out environmental management and monitoring functions. We have well equipped Centralized Quality Control Laboratory also to support monitoring.
vi	Adequate funds shall be earmarked towards capital cost and recurring cost/annum for environment pollution control measures and shall be used to implement the conditions stipulated by the Ministry of Environment and Forests as well as the State Government along with the implementation schedule for all the conditions stipulated herein. The funds so provided shall not be diverted for any other purposes.	BPCL-KR has earmarked adequate funds for environment pollution control measures.
vii	The Regional Office of this Ministry/Central Pollution Control Board/State Pollution Control Board will monitor the stipulated conditions. A six monthly compliance report and the monitored data along with statistical interpretation shall be submitted to them regularly.	Six monthly compliance reports are being submitted by BPCL-KR as per the requirement.
viii	A copy of clearance letter shall be sent by the proponent to concerned Panchayat, Zila Parishad/Municipal Corporation, Urban Local Body and the local NGO, if any, from whom suggestions/representations, if any, were received while processing the proposal. The clearance letter shall also be put on the web site of the Company by the proponent.	BPCL-KR has complied with this condition.
ix	The project proponent shall upload the status of compliance of the stipulated environment	Six monthly compliance reports are being submitted by BPCL-KR after receipt of the

	clearance conditions, including results of monitored data on their website and shall update the same periodically. It shall simultaneously be sent to the Regional Office of the MOEF, the respective Zonal Office of CPCB and the SPCB. The criteria pollutant levels namely; PM10, PM2.5, SO2, NOx, HC (Methane of Non-methane), VOCs (ambient levels as well as stack emissions) or critical sectoral parameters, indicated for the projects shall be monitored and displayed at a convenient location near the main gate of the company in the public domain.	Environmental Clearance for the IREP project. The same will be sent to the Regional Office of MoEF and also uploaded in the website. The criteria pollutant levels namely; PM10, PM2.5, SO2, NOx, HC (Methane / Non-methane), VOCs (ambient levels as well as stack emissions) or critical sectoral parameters, indicated for the projects shall be monitored and displayed at a convenient location near the main gate of the company in the public domain.
x	The project proponent shall also submit six monthly reports on the status of the compliance of the stipulated environmental conditions including results of monitored data (both in hard copies as well as by e-mail) to the Regional Office of MOEF, the respective Zonal Office of CPCB and the SPCB. The Regional Office of this Ministry/CPCB/SPCB shall monitor the stipulated conditions.	Six monthly compliance reports are being submitted by BPCL-KR after receipt of the Environmental Clearance for the IREP project. The same will be sent to the Regional Office of MoEF and also uploaded in the website.
xi	The environmental statement for each financial year ending 31 <sup>st</sup> March in Form-V as is mandated to be submitted by the Project proponent to the concerned State Pollution Control Board as prescribed under the Environment (Protection) Rules, 1986, as amended subsequently, shall also be put on the website of the company along with the status of compliance of environmental conditions and shall also be sent to the respective Regional Offices of the MOEF by e-mail.	Complied.
xii	The project proponent shall inform the public that the project has been accorded environmental clearance by the Ministry and copies of the clearance letter are available with the SPCB and may also be seen at website of the Ministry of Environment and Forests at <a href="http://envfor.nic.in">http://envfor.nic.in</a> . This shall be advertised within seven days from the date of issue of the clearance letter, at least in two local newspapers that are widely circulated in the region of which one shall be in the vernacular language of the locality concerned and the copy of	BPCL-KR has complied with this condition.



	the same shall be forwarded to the Regional Office.	
xiii	Project authorities shall inform the Regional Office as well as the Ministry, the date of financial closure and final approval of the project by the concerned authorities and the date of commencing the land development work.	The Board approval for pre-project activities for the IREP project was obtained on 31.01.2011 and capital approval was obtained by the Board on 31.03.2012. Land development work commenced in line with the above approval.

DATA ON STACK EMISSIONS FROM BPCL KOCHI REFINERY (IREP Units)														
PERIOD - 1 <sup>st</sup> Oct. 2020 to 31 <sup>st</sup> March 2021.														
Sl.no.	STACK / UNIT	No. of samples analysed	Permitted emission Nm3/hr.	Sulphur dioxide mg/Nm3			Emission rate Nm3/hr.			Particulate matter mg/Nm3			Percentage compliance	
				min	max	Avg.	min	max	Avg.	min	max	Avg.	SPC B	MoEF
1	CDU III	5	254000	351.6	383.78	307.7	230459	252031	203641.3	13.23	28.9	18.3	100	100
2	DHDT	4	59000	84.08	96.01	60.3	56921	58643	38588.0	0	24.13	10.8	100	100
3	VGO HDT	5	55000	20.15	28.95	19.9	52380	54764	44866.0	21.56	27.92	20.8	100	100
4	PFCCU HEATER	4	22400	26.37	40.03	22.7	20872	22178	14356.8	11.27	29.94	13.6	100	100
5	PFCCU REGENR.	3	235250	24.29	67.32	21.3	131901	176646	76824.7	14.21	24.27	9.6	100	100
6	DCU-1	3	80000	20.57	23.8	10.8	77402	78195	38860.2	3.12	4.25	1.9	100	100
7	DCU-2	3	80000	29.92	38.6	16.6	76862	79487	39087.5	2.56	4.23	1.7	100	100
8	SRU III Tr. A	6	92500	400.09	424.73	411.0	89040	92352	91474.8	N.A.	0	0.0	100	100
9	SRU III Tr. B	6	92500	433.48	484.35	460.0	86201	92323	90758.2	N.A.	0	0.0	100	100
10	UB 12	2		33.77	36.48	11.7	100201	121434	36939.2	11.47	18.4	5.0	100	100
11	UB 13	3		36	45.34	26.3	104714	138011	62547.2	9.62	18.71	7.3	100	100
12	HRSG-3	4	1095907	85.78	98.75	92.5	128822	155335	92261.2	12.47	20.58	11.2	100	100
13	HRSG-4	5	1095907	269.86	286.34	233.5	127017	161643	116430.5	15.66	28.14	19.1	100	100
14	HRSG-5	2	1095907	129.43	132.38	43.6	0	155509	48778.5	19.84	23.97	7.3	100	100



**AMBIENT AIRQUALITY DATA FOR THE HALF YEAR PERIOD**  
**1<sup>st</sup> Oct. 2020 to 31<sup>st</sup> March 2021.**

MARKETING							
Parameter	unit	Oct. 20	Nov.20	Dec. 20	Jan.21	Feb.21	Mar.21
SO <sub>2</sub>	µg/m <sup>3</sup>	4.4	8.05	17.4	20.8	29.3	32.6
NO <sub>x</sub>	µg/m <sup>3</sup>	6.46	4.44	6.03	5.7	6.2	5.7
NH <sub>3</sub>	ug/m <sup>3</sup>	0.13	0.27	0.91	0.42	1.1	0.8
CO	mg/m <sup>3</sup>	0.77	0.98	1.17	1.21	0.77	0.75
Benzene	µg/m <sup>3</sup>	0.17	0.176	0.16	0.19	0.18	0.16
Methane	ppm	0	0	BDL	BDL	BDL	BDL
NMHC	ppm	0	0	BDL	BDL	BDL	BDL
PM 10	µg/m <sup>3</sup>	43	77.4	90.06	78.2	102.1	85.1
PM 2.5	µg/m <sup>3</sup>	25	47.05	56.21	46.2	61.5	46.3
COLONY							
Parameter	unit	Oct. 20	Nov.20	Dec. 20	Jan.21	Feb.21	Mar.21
SO <sub>2</sub>	µg/m <sup>3</sup>	5.42	5.7	6.41	3.16	5.8	6.8
NO <sub>x</sub>	µg/m <sup>3</sup>	17.54	21.03	23.3	22.08	28.8	7.6
NH <sub>3</sub>	ug/m <sup>3</sup>	4.83	22.56	25.05	14.7	11.2	3.8
CO	mg/m <sup>3</sup>	0.57	0.63	0.98	0.67	0.83	0.40
Benzene	µg/m <sup>3</sup>	0.29	0.32	0.26	0.95	1.1	1.4
Methane	ppm	0.08	0	BDL	BDL	BDL	0.0013
NMHC	ppm	BDL	0.0017	BDL	0.00013	BDL	BDL
PM 10	µg/m <sup>3</sup>	39.9	61.98	72.5	65.1	90.3	67.5
PM 2.5	µg/m <sup>3</sup>	20.47	40.44	49.1	41.3	57.8	44.5

DHDS							
Parameter	unit	Oct. 20	Nov.20	Dec. 20	Jan.21	Feb.21	Mar.21
SO <sub>2</sub>	µg/m <sup>3</sup>	21.8	50.42	33.7	42.3	49.9	35.1
NO <sub>x</sub>	µg/m <sup>3</sup>	22.9	26.71	27.4	18.9	11.6	7.5
NH <sub>3</sub>	ug/m <sup>3</sup>	0.12	0.08	0.03	2.3	6.3	6.8
CO	mg/m <sup>3</sup>	0.67	0.38	0.98	1.56	1.1	1.06
Benzene	µg/m <sup>3</sup>	BDL	BDL	BDL	BDL	BDL	BDL
Methane	ppm	2.3	2.24	2.3	1.82	2.08	1.9
NMHC	ppm	0.02	0.062	0.24	0.109	0.035	0.015
PM 10	µg/m <sup>3</sup>	43.9	70.2	79.2	69.9	93.5	78.2
PM 2.5	µg/m <sup>3</sup>	22.2	43.12	53.3	45.4	58.06	43.8

CISF Township							
Parameter	unit	Oct. 20	Nov.20	Dec. 20	Jan.21	Feb.21	Mar.21
SO2	µg/m3	7.84	8.3	8.08	6.3	10.4	9.42
NOx	µg/m3	12.8	11.4	15.2	8.65	8.55	5.74
NH3	ug/m3	11.07	2.5	3.9	3.48	3.3	4.6
CO	mg/m3	0.68	1.05	0.94	0.92	0.99	0.88
Benzene	µg/m3	0.06	0.028	0.05	0.04	0.03	0.88
Methane	ppm	BDL	BDL	BDL	BDL	BDL	1.57
NMHC	ppm	0.004	BDL	BDL	BDL	BDL	0.067
PM 10	µg/m3	47.2	75.8	93.9	79.5	106.1	79.1
PM 2.5	µg/m3	22.1	40.6	54.7	48.7	63.3	42.6

NHT CCR							
Parameter	unit	Oct. 20	Nov.20	Dec. 20	Jan.21	Feb.21	Mar.21
SO2	µg/m3	4.4	3.5	5.79	4.7	3.66	3.46
NOx	µg/m3	6.4	6.57	6.78	6.95	7.36	7.17
NH3	ug/m3	BDL	BDL	BDL	BDL	BDL	BDL
CO	mg/m3	2.5	1.54	0.8	0.47	0.55	0.47
Benzene	µg/m3	BDL	BDL	BDL	BDL	BDL	BDL
Methane	ppm	BDL	BDL	BDL	BDL	BDL	BDL
NMHC	ppm	BDL	BDL	0.10	0.1	0.1	0.10
PM 10	µg/m3	54	77	51	41	37	38
PM 2.5	µg/m3	2	2	3	3	4	5



Annexure - III

**TREATED EFFLUENT QUALITY DATA FOR THE HALF YEAR PERIOD**

**1<sup>st</sup> Oct. 2020 to 31<sup>st</sup> March 2021.**

<b>Effluent _ Outlet - A (monthly average value)</b>								
<b>Parameter</b>	<b>limit</b>	<b>unit</b>	<b>Oct. 20</b>	<b>Nov. 20</b>	<b>Dec. 20</b>	<b>Jan. 21</b>	<b>Feb. 21</b>	<b>Mar. 21</b>
pH	6 - 8.5		7.2	7.6	7.1	7.3	7.2	7.1
TSS	100	ppm	12	14	11	10	11	15
Oil & Grease	5	ppm	3.5	3.8	3.1	3.6	3.3	3.9
BOD (3 day @27 C.)	15	ppm	11	12	12	8	10	12
Phenol	0.35	ppm	0.12	0.11	0.16	0.08	0.17	0.15
Sulphides	0.5	ppm	0.4	0.4	0.4	0.4	0.4	0.4
COD	125	ppm	40	49	47	20	45	52
<b>Effluent _ Outlet - B (monthly average value)</b>								
<b>Parameter</b>	<b>limit</b>	<b>unit</b>	<b>Oct. 20</b>	<b>Nov. 20</b>	<b>Dec. 20</b>	<b>Jan. 21</b>	<b>Feb. 21</b>	<b>Mar. 21</b>
pH	6 - 8.5		7.1	7.3	7.0	7.2	7.0	7.2
TSS	100	ppm	14	15.5	12	14.5	17	16
Oil & Grease	5	ppm	<4	<4	<4	<4	<4	<4
BOD (3 day @27 C.)	30	ppm	12.5	12	11.8	11	16	12



QUALITY CONTROL DEPARTMENT  
BPCL-KOCHI REFINERY, AMBALAMUGAL

**BOREWELL WATER TEST REPORT**

Bore well No. 50

Date of Sample: 22.10.2020

Date of Testing: 22.10.2020

KR.TECH.QC.26.DRINK.WATR

Sl No:	Test Parameters	Unit	Method	Result	Acceptable limit
5	pH	-	IS 3025 (P:11)	7.2	6.5 – 8.5
15	Oil	mg/L	IS 3025 (P:39)	nil	nil
<b>Metals</b>					
16	Silver (as Ag)	mg/L	IS13428 Annexe J	BDL (MDL=0.005)	0.1 (Max)
17	Aluminium (as Al)	mg/L	IS 3025 (P:55)	BDL(MDL=0.002)	0.03 (Max)
18	Boron (as B)	mg/L	IS 3025 (P:57)	BDL(MDL=0.01)	0.5 (Max)
19	Barium (as Ba)	mg/L	IS13428 Annexe F	BDL(MDL=0.01)	0.7 (Max)
20	Calcium (as Ca)	mg/L	IS 3025 (P:40)	38	75 (Max)
21	Cadmium (as Cd)	mg/L	IS 3025 (P:41)	BDL(MDL=0.001)	0.003 (Max)
22	Chromium (as Cr)	mg/L	IS 3025 (P:52)	BDL(MDL=0.01)	0.05 (Max)
23	Copper (as Cu)	mg/L	IS 3025 (P:42)	BDL(MDL=0.01)	0.05 (Max)
24	Iron (as Fe)	mg/L	IS 3025 (P:53)	0.11	0.3 (Max)
25	Magnesium (as Mg)	mg/L	IS 3025 (P:46)	1.6	30 (Max)
26	Manganese (as Mn)	mg/L	IS 3025 (P:59)	BDL(MDL=0.01)	0.1 (Max)
27	Nickel (as Ni)	mg/L	IS 3025 (P:54)	BDL(MDL=0.01)	0.02 (Max)
28	Molybdenum (as Mo)	mg/L	IS 3025 (P:02)	BDL(MDL=0.002)	0.07 (Max)
29	Lead (as Pb)	mg/L	IS 3025 (P:47)	BDL(MDL=0.01)	0.01 (Max)
30	Zinc (as Zn)	mg/L	IS 3025 (P:49)	0.3	5 (Max)
31	Arsenic (as As)	mg/L	IS 3025 (P:37)	BDL(MDL0.005)	0.01 (Max)
32	Mercury (as Hg)	mg/L	IS 3025 (P:48)	BDL(MDL0.0001)	0.001(Max)
33	Selenium (as Se)	mg/L	IS 3025 (P:56)	BDL(MDL=0.001)	0.1 (Max)
34	Antimony (as Sb)	mg/L	APHA:3113B	BDL(MDL=0.001)	Max0.1

BDL: Below Detection Limit

MDL: Minimum Detection Limit

Adalazhagan K  
Chief Manager (Quality Control)





QUALITY CONTROL DEPARTMENT  
BPCL-KOCHI REFINERY, AMBALAMUGAL

**BOREWELL WATER TEST REPORT**

Bore well No. 34

Date of Sample: 14.11.2020

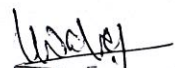
Date of Testing: 14.11.2020

KR.TECH.QC.26.DRINK.WATR

Sl No:	Test Parameters	Unit	Method	Result	Acceptable limit
5	pH	-	IS 3025 (P:11)	7.2	6.5 – 8.5
15	Oil	mg/L	IS 3025 (P:39)	nil	nil
<b>Metals</b>					
16	Silver (as Ag)	mg/L	IS13428 Annexe J	BDL (MDL=0.005)	0.1 (Max)
17	Aluminium (as Al)	mg/L	IS 3025 (P:55)	BDL(MDL=0.002)	0.03 (Max)
18	Boron (as B)	mg/L	IS 3025 (P:57)	BDL(MDL=0.01)	0.5 (Max)
19	Barium (as Ba)	mg/L	IS13428 Annexe F	BDL(MDL=0.01)	0.7 (Max)
20	Calcium (as Ca)	mg/L	IS 3025 (P:40)	38	75 (Max)
21	Cadmium (as Cd)	mg/L	IS 3025 (P:41)	BDL(MDL=0.001)	0.003 (Max)
22	Chromium (as Cr)	mg/L	IS 3025 (P:52)	BDL(MDL=0.01)	0.05 (Max)
23	Copper (as Cu)	mg/L	IS 3025 (P:42)	BDL(MDL=0.01)	0.05 (Max)
24	Iron (as Fe)	mg/L	IS 3025 (P:53)	0.06	0.3 (Max)
25	Magnesium (as Mg)	mg/L	IS 3025 (P:46)	1.7	30 (Max)
26	Manganese (as Mn)	mg/L	IS 3025 (P:59)	BDL(MDL=0.01)	0.1 (Max)
27	Nickel (as Ni)	mg/L	IS 3025 (P:54)	BDL(MDL=0.01)	0.02 (Max)
28	Molybdenum (as Mo)	mg/L	IS 3025 (P:02)	BDL(MDL=0.002)	0.07 (Max)
29	Lead (as Pb)	mg/L	IS 3025 (P:47)	BDL(MDL=0.01)	0.01 (Max)
30	Zinc (as Zn)	mg/L	IS 3025 (P:49)	0.28	5 (Max)
31	Arsenic (as As)	mg/L	IS 3025 (P:37)	BDL(MDL=0.005)	0.01 (Max)
32	Mercury (as Hg)	mg/L	IS 3025 (P:48)	BDL(MDL=0.0001)	0.001(Max)
33	Selenium (as Se)	mg/L	IS 3025 (P:56)	BDL(MDL=0.001)	0.1 (Max)
34	Antimony (as Sb)	mg/L	APHA:3113B	BDL(MDL=0.001)	Max0.1

BDL: Below Detection Limit

MDL: Minimum Detection Limit

  
Adalazhagan K  
Chief Manager (Quality Control)





QUALITY CONTROL DEPARTMENT  
BPCL-KOCHI REFINERY, AMBALAMUGAL

**BOREWELL WATER TEST REPORT**

Bore well No. 18

Date of Sample: 18.12.2020

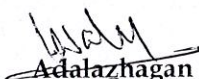
Date of Testing: 20.12.2020

KR.TECH.QC.26.DRINK.WATR

Sl No:	Test Parameters	Unit	Method	Result	Acceptable limit
5	pH	-	IS 3025 (P:11)	7.1	6.5 – 8.5
15	Oil	mg/L	IS 3025 (P:39)	nil	nil
<b>Metals</b>					
16	Silver (as Ag)	mg/L	IS13428 Annexe J	BDL (MDL=0.005)	0.1 (Max)
17	Aluminium (as Al)	mg/L	IS 3025 (P:55)	BDL(MDL=0.002)	0.03 (Max)
18	Boron (as B)	mg/L	IS 3025 (P:57)	BDL(MDL=0.01)	0.5 (Max)
19	Barium (as Ba)	mg/L	IS13428 Annexe F	BDL(MDL=0.01)	0.7 (Max)
20	Calcium (as Ca)	mg/L	IS 3025 (P:40)	35	75 (Max)
21	Cadmium (as Cd)	mg/L	IS 3025 (P:41)	BDL(MDL=0.001)	0.003 (Max)
22	Chromium (as Cr)	mg/L	IS 3025 (P:52)	BDL(MDL=0.01)	0.05 (Max)
23	Copper (as Cu)	mg/L	IS 3025 (P:42)	BDL(MDL=0.01)	0.05 (Max)
24	Iron (as Fe)	mg/L	IS 3025 (P:53)	0.05	0.3 (Max)
25	Magnesium (as Mg)	mg/L	IS 3025 (P:46)	1.6	30 (Max)
26	Manganese (as Mn)	mg/L	IS 3025 (P:59)	BDL(MDL=0.01)	0.1 (Max)
27	Nickel (as Ni)	mg/L	IS 3025 (P:54)	BDL(MDL=0.01)	0.02 (Max)
28	Molybdenum (as Mo)	mg/L	IS 3025 (P:02)	BDL(MDL=0.002)	0.07 (Max)
29	Lead (as Pb)	mg/L	IS 3025 (P:47)	BDL(MDL=0.01)	0.01 (Max)
30	Zinc (as Zn)	mg/L	IS 3025 (P:49)	0.35	5 (Max)
31	Arsenic (as As)	mg/L	IS 3025 (P:37)	BDL(MDL=0.005)	0.01 (Max)
32	Mercury (as Hg)	mg/L	IS 3025 (P:48)	BDL(MDL=0.0001)	0.001(Max)
33	Selenium (as Se)	mg/L	IS 3025 (P:56)	BDL(MDL=0.001)	0.1 (Max)
34	Antimony (as Sb)	mg/L	APHA:3113B	BDL(MDL=0.001)	Max0.1

BDL: Below Detection Limit

MDL: Minimum Detection Limit

  
Adalazhagan K  
Chief Manager (Quality Control)



QUALITY CONTROL DEPARTMENT  
BPCL-KOCHI REFINERY, AMBALAMUGAL

BOREWELL WATER TEST REPORT

Bore well No. 5

Date of Sample: 07.01.2021

Date of Testing: 10.01.2021

KR.TECH.QC.26.DRINK.WATR

SI No:	Test Parameters	Unit	Method	Result	Acceptable limit
5	pH	-	IS 3025 (P:11)	7.5	6.5 – 8.5
15	Oil	mg/L	IS 3025 (P:39)	nil	nil
<b>Metals</b>					
16	Silver (as Ag)	mg/L	IS13428 Annexe J	BDL (MDL=0.005)	0.1 (Max)
17	Aluminium (as Al)	mg/L	IS 3025 (P:55)	BDL(MDL=0.002)	0.03 (Max)
18	Boron (as B)	mg/L	IS 3025 (P:57)	BDL(MDL=0.01)	0.5 (Max)
19	Barium (as Ba)	mg/L	IS13428 Annexe F	BDL(MDL=0.01)	0.7 (Max)
20	Calcium (as Ca)	mg/L	IS 3025 (P:40)	36	75 (Max)
21	Cadmium (as Cd)	mg/L	IS 3025 (P:41)	BDL(MDL=0.001)	0.003 (Max)
22	Chromium (as Cr)	mg/L	IS 3025 (P:52)	BDL(MDL=0.01)	0.05 (Max)
23	Copper (as Cu)	mg/L	IS 3025 (P:42)	BDL(MDL=0.01)	0.05 (Max)
24	Iron (as Fe)	mg/L	IS 3025 (P:53)	0.05	0.3 (Max)
25	Magnesium (as Mg)	mg/L	IS 3025 (P:46)	2.5	30 (Max)
26	Manganese (as Mn)	mg/L	IS 3025 (P:59)	BDL(MDL=0.01)	0.1 (Max)
27	Nickel (as Ni)	mg/L	IS 3025 (P:54)	BDL(MDL=0.01)	0.02 (Max)
28	Molybdenum (as Mo)	mg/L	IS 3025 (P:02)	BDL(MDL=0.002)	0.07 (Max)
29	Lead (as Pb)	mg/L	IS 3025 (P:47)	BDL(MDL=0.01)	0.01 (Max)
30	Zinc (as Zn)	mg/L	IS 3025 (P:49)	0.30	5 (Max)
31	Arsenic (as As)	mg/L	IS 3025 (P:37)	BDL(MDL=0.005)	0.01 (Max)
32	Mercury (as Hg)	mg/L	IS 3025 (P:48)	BDL(MDL=0.0001)	0.001(Max)
33	Selenium (as Se)	mg/L	IS 3025 (P:56)	BDL(MDL=0.001)	0.1 (Max)
34	Antimony (as Sb)	mg/L	APHA:3113B	BDL(MDL=0.001)	Max0.1

BDL: Below Detection Limit

MDL: Minimum Detection Limit

S. Mahamed Iqbal  
Manager (Quality Control)





QUALITY CONTROL DEPARTMENT  
BPCL-KOCHI REFINERY, AMBALAMUGAL

BOREWELL WATER TEST REPORT

Bore well No. 70

Date of Sample: 18.02.2021

Date of Testing: 20.02.2021

KR.TECH.QC.26.DRINK.WATR

SI No:	Test Parameters	Unit	Method	Result	Acceptable limit
5	pH	-	IS 3025 (P:11)	7.2	6.5 – 8.5
15	Oil	mg/L	IS 3025 (P:39)	nil	nil
<b>Metals</b>					
16	Silver (as Ag)	mg/L	IS13428 Annexe J	BDL (MDL=0.005)	0.1 (Max)
17	Aluminium (as Al)	mg/L	IS 3025 (P:55)	BDL(MDL=0.002)	0.03 (Max)
18	Boron (as B)	mg/L	IS 3025 (P:57)	BDL(MDL=0.01)	0.5 (Max)
19	Barium (as Ba)	mg/L	IS13428 Annexe F	BDL(MDL=0.01)	0.7 (Max)
20	Calcium (as Ca)	mg/L	IS 3025 (P:40)	32	75 (Max)
21	Cadmium (as Cd)	mg/L	IS 3025 (P:41)	BDL(MDL=0.001)	0.003 (Max)
22	Chromium (as Cr)	mg/L	IS 3025 (P:52)	BDL(MDL=0.01)	0.05 (Max)
23	Copper (as Cu)	mg/L	IS 3025 (P:42)	BDL(MDL=0.01)	0.05 (Max)
24	Iron (as Fe)	mg/L	IS 3025 (P:53)	0.05	0.3 (Max)
25	Magnesium (as Mg)	mg/L	IS 3025 (P:46)	3	30 (Max)
26	Manganese (as Mn)	mg/L	IS 3025 (P:59)	BDL(MDL=0.01)	0.1 (Max)
27	Nickel (as Ni)	mg/L	IS 3025 (P:54)	BDL(MDL=0.01)	0.02 (Max)
28	Molybdenum (as Mo)	mg/L	IS 3025 (P:02)	BDL(MDL=0.002)	0.07 (Max)
29	Lead (as Pb)	mg/L	IS 3025 (P:47)	BDL(MDL=0.01)	0.01 (Max)
30	Zinc (as Zn)	mg/L	IS 3025 (P:49)	0.36	5 (Max)
31	Arsenic (as As)	mg/L	IS 3025 (P:37)	BDL(MDL=0.005)	0.01 (Max)
32	Mercury (as Hg)	mg/L	IS 3025 (P:48)	BDL(MDL=0.0001)	0.001(Max)
33	Selenium (as Se)	mg/L	IS 3025 (P:56)	BDL(MDL=0.001)	0.1 (Max)
34	Antimony (as Sb)	mg/L	APHA:3113B	BDL(MDL=0.001)	Max0.1

BDL: Below Detection Limit

MDL: Minimum Detection Limit

S. Mahamed Iqbal  
Manager (Quality Control)



QUALITY CONTROL DEPARTMENT  
BPCL-KOCHI REFINERY, AMBALAMUGAL

BOREWELL WATER TEST REPORT

Bore well No. 5

Date of Sample: 03.03.2021


Date of Testing: 8.03.2021

KR.TECH.QC.26.DRINK.WATR

Sl No:	Test Parameters	Unit	Method	Result	Acceptable limit
5	pH	--	IS 3025 (P:11)	7.3	6.5 – 8.5
15	Oil	mg/L	IS 3025 (P:39)	nil	nil
<b>Metals</b>					
16	Silver (as Ag)	mg/L	IS13428 Annexe J	BDL (MDL=0.005)	0.1 (Max)
17	Aluminium (as Al)	mg/L	IS 3025 (P:55)	BDL(MDL=0.002)	0.03 (Max)
18	Boron (as B)	mg/L	IS 3025 (P:57)	BDL(MDL=0.01)	0.5 (Max)
19	Barium (as Ba)	mg/L	IS13428 Annexe F	BDL(MDL=0.01)	0.7 (Max)
20	Calcium (as Ca)	mg/L	IS 3025 (P:40)	39	75 (Max)
21	Cadmium (as Cd)	mg/L	IS 3025 (P:41)	BDL(MDL=0.001)	0.003 (Max)
22	Chromium (as Cr)	mg/L	IS 3025 (P:52)	BDL(MDL=0.01)	0.05 (Max)
23	Copper (as Cu)	mg/L	IS 3025 (P:42)	BDL(MDL=0.01)	0.05 (Max)
24	Iron (as Fe)	mg/L	IS 3025 (P:53)	0.05	0.3 (Max)
25	Magnesium (as Mg)	mg/L	IS 3025 (P:46)	4	30 (Max)
26	Manganese (as Mn)	mg/L	IS 3025 (P:59)	BDL(MDL=0.01)	0.1 (Max)
27	Nickel (as Ni)	mg/L	IS 3025 (P:54)	BDL(MDL=0.01)	0.02 (Max)
28	Molybdenum (as Mo)	mg/L	IS 3025 (P:02)	BDL(MDL=0.002)	0.07 (Max)
29	Lead (as Pb)	mg/L	IS 3025 (P:47)	BDL(MDL=0.01)	0.01 (Max)
30	Zinc (as Zn)	mg/L	IS 3025 (P:49)	0.4	5 (Max)
31	Arsenic (as As)	mg/L	IS 3025 (P:37)	BDL(MDL=0.005)	0.01 (Max)
32	Mercury (as Hg)	mg/L	IS 3025 (P:48)	BDL(MDL=0.0001)	0.001(Max)
33	Selenium (as Se)	mg/L	IS 3025 (P:56)	BDL(MDL=0.001)	0.1 (Max)
34	Antimony (as Sb)	mg/L	APHA:3113B	BDL(MDL=0.001)	Max0.1

BDL: Below Detection Limit

MDL: Minimum Detection Limit

  
S.Mahamed Iqbal  
Manager (Quality Control)





**Bharat  
Petroleum**

**BIHARAT PETROLEUM CORPORATION LIMITED  
KOCHI REFINERY**

**HSE DEPARTMENT**

KR.HSE.SAFE.05.SLMR.AGK

19.01.2021

**Sub: Noise level at Boundary Wall.**

Noise level at various locations near the boundary wall inside the refinery was measured on 19.01.2021 at Night time. The observed values are given below.

Sl. No.	Location	Sound level	Remarks
1.	South of tank YF-30 (Near to Parking)	63	
2.	Near T T gate (PDPP gate)	63	
3.	Drum Plant gate	60	
4.	Below Coke Conveyor area near railway gate- RLS-1	59	Conveyor Offline
5.	Below Coke Conveyor area near outlet A -RLS-2	55	Conveyor Offline
6.	Below Coke Conveyor area near railway gate(PWC 4)-offline	55	Conveyor Offline
7.	UB-12 Boundary area	62	
8.	K.R boundary at DCU. (Behind the EOT loading area, DCU)	62	
9.	North of VGO labour amenity building	59	
10.	Behind IREP site office	64	
11.	Near IREP gate	64	
12.	North of LNG skid (GT-2 Road end)	70	
13.	Between In plant training center and bottling plant boundary	55	
14.	Bottling plant entrance from refinery(IPTC Road)	60	
15.	Between Project warehouse and boundary wall	47	
16.	220 KV line crossing near rain water harvesting pond	52	
17.	West of tank YT-902(DHDS)	52	
18.	South of DHDS Flare	60	
19.	Near Chalikkara gate	60	
20.	Near NIT-CCR-AAQMS ( MSBP car parking area)	60	
21.	East of MS Block	63	
22.	Between boundary wall and DHDS fire station	55	
23.	DHDS, CISP Watchtower No- 1	60	
24.	Between boundary wall and TK-25	52	

*Alamgeer Khan K H*  
AM (Safety)

To: DGM (F&S) (r)

G.M (HSE) /C. (r)

CM (ENVIRONMENT)



**Bharat  
Petroleum**

**BIHARAT PETROLEUM CORPORATION LIMITED  
KOCCHI REFINERY**

**HSE DEPARTMENT**

KR.HSE.SAFE.05.SLMR.AGK

15.03.2021

**Sub: Noise level at Boundary Wall.**

Noise level at various locations near the boundary wall inside the refinery was measured on 15.03.2021 at day time. The observed values are given below.

Sl. No.	Location	Sound level	Remarks
1.	South of tank YF-30 (Near to Parking)	65	-
2.	Near I T gate (PDPP gate)	65	-
3.	Drum Plant gate	60	-
4.	Below Coke Conveyor area near railway gate- RLS-1	59	Conveyor Offline
5.	Below Coke Conveyor area near outlet A -RLS-2	56	Conveyor Offline
6.	Below Coke Conveyor area near railway gate(PWC 4)- offline	56	Conveyor Offline
7.	UB-12 Boundary area	62	-
8.	K.R boundary at DCU, (Behind the L&G loading area, DCU)	62	-
9.	North of VGO labour amenity building	59	-
10.	Behind IREP site office	64	-
11.	Near IREP gate	64	-
12.	North of L&G skid (GT-2 Road end)	70	-
13.	Between In plant training center and bottling plant boundary	55	-
14.	Bottling plant entrance from refinery(IPTC Road)	60	-
15.	Between Project warehouse and boundary wall	47	-
16.	220 KV line crossing near rain water harvesting pond	52	-
17.	West of tank YF-902(DIIDS)	55	-
18.	South of DIIDS Flare	60	-
19.	Near Chalikkara gate	60	-
20.	Near NHT-CCR-AAQMS ( MSBP car parking area)	60	-
21.	East of MS Block	65	-
22.	Between boundary wall and DIIDS fire station	59	-
23.	DIIDS, CISE Watchtower No- 1	62	-
24.	Between boundary wall and TK-25	54	-

To: DGM (F&S) (r)

GM (HSE) / C (r)

CM (ENVIRONMENT)

Alamgeer Khan K H  
AM (Safety)



## Annexure-VI

<b>Health Surveillance Data (01/04/2020 to 31/03/2021)</b>		
1	No of persons undergone comprehensive health check up	<b>Total:1333 Completed: 54</b>
2	No of Audiometry Test Conducted (%)	<b>Total: 409 We could not start statutory health check-up because of COVID pandemic</b>
3	No of people undergone comprehensive blood testing	<b>Total:1250 Completed:889</b>
4	No of employees undergone statutory eye check-up (%)	<b>We could not start statutory health check-up because of COVID pandemic</b>
5	No of employees who have done statutory urine phenol test.	<b>No. of samples:15 samples tested</b>
6	Number of Contract Employees covered under Statutory Health check-up Plan.	<b>Total: nil We could not start statutory health check-up because of COVID pandemic</b>
7	Number of Health Talks Conducted(Cumulative)	<b>11</b>
8	Injury on Duty Employees	<b>Total:25, Minor:5, FA:20</b>
9	Injury on Duty Contract Workers	<b>Total:27, Fatal:1,Minor:15,FA:11</b>
10	Diabetic Clinic	<b>We could not start diabetic clinic because of COVID pandemic</b>
11	Cardiac Clinic	<b>We could not start Cardiac clinic because of COVID pandemic</b>

**CORPORATE RESPONSIBILITY FOR ENVIRONMENTAL PROTECTION (CREP)****PROGRESS REPORT ON ACTION POIN**

Sl. No.	Task	Remarks/Status
1	All the refineries provide on line emission and effluent monitoring systems and give linkages to SPCB and CPCB server and detailed note shall be submitted by individual refineries indicating number of sensors, make and type etc.	Online connectivity of all five AAQMS given and intimated to CPCB/KSPCB. Total 926 No's of Hydrocarbon (HC) detectors, 267 No's of Hydrogen sulphide (H2S) detectors and 42 No's of Hydrogen (H2) detectors are installed at different locations of refinery including product loading, storage tank farms and process plants etc. Most of sensors are made up of M/s Honeywell. HC sensors belong to Infra-red type and H2S/H2 sensors belong to electrochemical type.
2	The refineries shall submit action plan to achieve zero discharge (except once through cooling water in coastal region) within three months.	As part of integrated Refinery cum expansion project (IREP), an integrated ETP has been setup and the treated effluent is routed to RO plant for further processing and recycling water as DM water
3	The HSE department of refineries shall co-ordinate with marketing divisions for submission of note on evaporation during loading, leakage possibilities, steps taken for fire safety, management of oily sludge	HSE department of BPCL has initiated coordination and various measures to control evaporation during loading, leakage, fire safety, management of oily sludge etc. It includes vapor recovery system, bottom loading, fugitive emission survey, LDAR etc. Separate scheme is adopted for the management of oily sludge which includes centrifuging, oil recovery and bio-remediation.
4	The refineries who have not completed the task of providing low NOx burners shall complete within six month and submit completion note without further delay.	All the heaters under CEMP phase-II/IREP have been provided with low NOx burners.



1. Air Pollution Management		
a)	All the Refineries located in the critically polluted areas, identified by CPCB, will submit an action plan for phase wise reduction of SO <sub>2</sub> emission from the present level:	<p>BPCL Kochi Refinery comes under severely polluted cluster. KR meets its total SO<sub>2</sub> norm of 552 kg/hr. from the complex.</p> <p>It contributes to net reduction in SO<sub>2</sub> emission by producing Euro- VI MS and Diesel.</p> <p>Following steps are taken to reduce SO<sub>2</sub> emissions from the refinery.</p> <ul style="list-style-type: none"> <li>• Modifications to plant fuel system to facilitate usage of low sulfur liquid fuel.</li> <li>• Amine treatment of fuel gas</li> <li>• Sulfur Recovery Units with 99.9% efficiency as part of IREP with inclusion of TGTU (Tail Gas Treating Unit)</li> <li>• Low Pressure Amine treatment of vacuum column vent.</li> <li>• Employing Biturox technology for Bitumen production, where off gas is incinerated and further treated.</li> </ul>
b)	Future Refineries will have sulphur recovery with minimum 99% efficiency	SRUs have more than 99% efficiency. New SRU have 99.9% efficiency.
c)	Road map to improve the efficiency of SRU:	BPCL Kochi refinery has been explored the possibility of Oxygen enrichment technology for enhancing the efficiency of SRU and the same commissioned.
d)	With regard to NO <sub>x</sub> emission, the new Refineries / process units will install low NO <sub>x</sub> burners. For retrofitting of low NO <sub>x</sub> burners in existing units the same expert committee will suggest the strategies and action plan within six months:	The expert committee, during their visit to Kochi Refinery, had suggested replacing the burners in heaters with more than 10 million Kcal/hr duty with low NO <sub>x</sub> type burners. We have installed low NO <sub>x</sub> burners for ten heaters in the existing Refinery. Moreover, all the new process heaters and steam boilers (total six numbers) installed as part of capacity expansion cum modernization project, CEMP - Phase II and all IREP units have been provided with low NO <sub>x</sub> burners.
e)	The Expert Committee will also suggest an action plan, within 6 months, for control and monitoring of hydrocarbon loss and VOC emissions, leak detection and repair (LDAR) program and vapor recovery systems (for loading and unloading operations within Refineries only):	<p>Following provisions exists for VOC control</p> <ul style="list-style-type: none"> <li>a) Provision of mechanical seals on pumps for leak free operation.</li> <li>b) Use of submerged filling in product loading gantries.</li> <li>c) Closed blow down system for process plants.</li> <li>d) Floating roof tanks for volatile product storage.</li> <li>e) Conversion of floating roof tanks to double seal arrangement.</li> <li>f) Closed loop sampling system in process plants.</li> <li>g) Covered facility for oily effluent storage.</li> </ul>

		<p>h) VOC control system is in place in new ETPs for treatment of VOCs generated during in the effluent treatment area.</p> <p>i) 926 No's of HC detectors, 267 No's of H<sub>2</sub>S detectors and 42 No's of H<sub>2</sub> detectors are installed at different locations of refinery including product loading, storage tank farms and process plants etc.</p> <p>j) Benzene monitoring is carried out using "dragger" chip technique in the aromatic recovery unit on a daily basis.</p> <p>k) Five ambient air quality monitoring stations (AAQMS) are working online to monitor the ambient air quality on continuous basis. They provide eleven ambient air quality parameters, including hydrocarbons and the data is transferred online to CPCB/KSPCB.</p> <p>l) Vapor recovery system is being implemented in ISOM Naphtha tank farm.</p> <p>m) New vapor recovery system is being implemented for Benzene &amp; Toluene truck loading area.</p>
f)	The flare losses to be minimized and monitored regularly	<p>Flare losses are monitored continuously through flare meters installed in the process units on a daily basis and are reviewed at the senior management level. Further, the fuel gas flow to the pilot burner is maintained at the minimum level required to sustain the pilot flame.</p> <p>Various process schemes implemented to reduce flaring.</p> <p>Advanced process control (APC) system was implemented in hydrogen network for decreasing hydrogen flaring.</p> <p>Flare Gas recovery system is installed as part of IREP project and commissioned in December 2017.</p>
g)	Refineries will install continuous emission monitoring systems for SO <sub>2</sub> and NO <sub>x</sub> in major stacks. Action plan for this will be submitted within six months	Kochi Refinery has provided continuous SO <sub>2</sub> and NO <sub>x</sub> analyzing system for all the heater/boiler stacks and is connected to the CPCB server system.
h)	Refineries will also monitor total HC and Benzene in the premises (particularly in loading / unloading operations and ETP). The status and action plan will be submitted within six months	<p>18 No's of HC detectors are installed in the truck loading/wagon loading area. 2 No's of HC detectors and 2 No's of H<sub>2</sub>S detectors are installed in ETP-V area.</p> <p>Benzene monitoring is carried out using "dragger" chip technique in the aromatic recovery unit on a daily basis.</p> <p>5 No's of ambient air quality monitoring stations (AAQMS) are installed at the peripheries of the refinery to enable close monitoring of ambient air quality near the refinery. The ambient air quality information is also communicated to general public through an electronic display board.</p>



<b>2. Waste Water Management:</b>		
a)	Refineries will prepare an action plan for conservation of water resources and maximizing reuse / recycle of treated effluent within six months. The treated effluent discharge quantity will be limited to 0.4 m <sup>3</sup> /tons (for 90% of time) except for the monsoon season:	<p>The discharge of treated water from Kochi refinery is 0.15 m<sup>3</sup> /MT of crude processed.</p> <p>Steam condensate in the process plants is being recycled back to the boilers as feed water for the steam generation, there by resulting in reduction in the fresh water consumption. Approximately 130-150 m<sup>3</sup>/hr. steam condensate is being recycled to steam boilers in the refinery.</p> <p>The stripped water from the stripped water units is recycled as make up water to the desalting process in the crude unit. 150 m<sup>3</sup>/hr. of liquid effluent generation is avoided by recycle.</p> <p>Treated effluent water from the wastewater treatment plants are recycled in RO plant</p>
3	Oil spill response facilities at Coastal Refineries will be in position within two years:	<p>Oil spill response (OSR) facility at Cochin port is already in place. Additionally, BPCL Kochi refinery has procured oil containment booms as part of SBM facilities commissioning to augment the capabilities of oil spill response related facilities. We have also conducted a mock drill to build confidence for the safe operation of SBM facilities with the help of port trust/coast guard personnel. It was decided to further strengthen the oil spill response facilities at Cochin port through purchase and installation of additional equipment and the major share of the investment was shouldered by BPCL Kochi refinery. Advance payment has been released to Cochin port trust for procurement of equipment.</p>
<b>3. Solid Waste Management:</b> Refineries will explore new technologies for reduction in the generation of oily sludge. Strategy and action plan for liquidation of existing sludge will be submitted within six months		
<p>To reduce the sludge generation, Kochi Refinery follows the following best practices:</p> <ul style="list-style-type: none"> <li>ETP oily sludge is processed continuously in DCU. The oily sludge generated from tank cleaning is also processed in DCU.</li> <li>Any excess sludge generated have the provision for oil recovery through centrifuging.</li> <li>Switching of service of storage tanks between different crude oils (high wax and low wax) ensures minimum formation of sludge at the bottom of storage tanks.</li> <li>Use side entry mixers in the crude oil tank for minimization of sludge accumulation.</li> </ul>		
<b>4. Refineries will carry out monitoring and survey to assess HC loss and concentration of VOC in Ambient Air / Waste Water Treatment Plant.</b>		

a) BPCL Kochi refinery has implemented leak detection and repair (LDAR) program using portable hydrocarbon detector instrument. These programs are carried out on continuous basis on a large number of valves, flanges etc. in all process units and offsite areas. The leaks identified are attended by maintenance crew immediately and are monitored on regular basis.

b) Secondary seals have been provided in 53 storage tanks storing volatile hydrocarbons to reduce fugitive hydrocarbon emissions.

c) HC detectors are installed in sufficient numbers at the storage tank farm areas, process plants, product loading areas and LPG bottling plants in order to identify any hydrocarbon leaks immediately.

d. Benzene monitoring is carried out using "dragger" chip technique in the aromatic recovery unit on daily basis.

e. Five ambient air quality monitoring stations (AAQMS) are working online to monitor the ambient air quality on continuous basis. The ambient air quality information is also communicated to public through an electronic display board.

f. Pressure relief valves for column and vessel are routed to flare to avoid fugitive emission during emergencies.

#### **5. Refineries will assess the quantity of flare gas (install the measurement system if the same is not possible)**

a. At BPCL Kochi refinery, flare losses are monitored continuously from different process units and are reviewed at the senior management level on a daily basis. Flare meters are installed in the process units for this purpose.

Further, the fuel gas flow to the pilot burner is maintained at the minimum level required to sustain the pilot flame.

Various process schemes implemented to reduce flaring

Advanced process control (APC) system was implemented in Hydrogen network for decreasing hydrogen flaring.

Flare gas recovery system is installed as part of IREP project and it can recover around **3.6 TPD** flare gas to fuel gas system.

#### **6. Assessment of Potential leakages from petroleum storage tanks**

Inspection of petroleum storage tanks is being carried out by following API 653 standard, OISD standard 129 and other relevant standards. Maintenance work is carried out as per the standard procedure when tank is taken for the outage.

**Total 63 No's of bore wells** have been constructed at various locations inside the refinery in order to monitor the ground water for any hydrocarbon leakages from the refinery storage tanks and processing plants. The ground water samples from the bore wells are tested periodically for presence of hydrocarbons. In addition, 14 piezometer wells have been installed for monitoring of ground water quality.

#### **7. Cleaner Technology options and information to be provided to CPCB**

Clean technologies adopted to combat Air Pollution includes:

1. BPCL Kochi refinery has consistently met all deadlines for up gradation of auto fuel quality, set by the Government of India. KR is producing MS and HSD of BS VI norms.



2. Hydro desulphurization of feed stock to fluid catalytic cracking unit (FCCU)
3. Modifications in plant fuel system facilitate to usage of low sulfur Bombay high vacuum residue as liquid fuel, to lower sulfur dioxide emissions during processing of crude.
4. Amine treatment of fuel gas for removal hydrogen sulfide to produce sweet fuel gas.
5. Installation five trains of sulfur recovery unit with more than 99.9% recovery.
6. Low pressure amine treatment of vacuum column vent gas. This is a unique environmental protection technology developed by BPCL KR for removing toxic hydrogen sulfide gas produced during vacuum distillation process. This technology has been developed exclusively with in-house expertise. The uniqueness of the technology lies in the fact that the process for hydrogen sulfide removal is carried out under extremely low pressure drop conditions.
7. Desulphurization of low pressure gas from crude unit overhead and kerosene unit fractionator utilizing amine absorption.
8. Reduction furnace for conversion of ammonia stream to nitrogen in order to reduce NOx emissions.
9. State of the art Biturox Technology has been adopted for production of Bitumen without any harmful emission. Unlike the traditional bitumen blowing technology, this technology helps for no odor or pollutants emissions. The off gases generated is subjected to incineration and caustic scrubbing in this technique. The waste water stream generated is also oxidized, thereby resulting in zero BOD for effluent. The fresh water consumption is also significantly reduced by the adoption of this technique.
10. An electrostatic precipitator has been installed downstream of CO boiler for minimizing particulate matter emission from FCCU regenerator flue gases. As part of PFCCU (part of IREP project) we have installed a tertiary cyclone separator and another ESP (Electrostatic precipitator) for particulate capture.
11. Closed loop sampling system in process plants.
12. Flare gas recovery system is installed as part of IREP project to recover around 3.63 TPD flare gas to fuel gas system

**b) Clean technologies adopted to improve effluent water quality:**

1. We have 4 effluent treatment plants catering to the different process units.
2. Installation of 5 numbers of sour water strippers and recycling of stripped water in process units.
3. Provision of two stage API oil separation system for effluent streams.
4. Spent caustic treatment utilizing H<sub>2</sub>O<sub>2</sub> and air oxidation methods for treatment in an environment friendly way.
5. Closed drainage system for tank farm drains.
6. Two stage biological treatment system for effluent streams including tricking filter and activated sludge process, automated Chemostat Treatment and sequential batch reactor.(SBR)

7. Hydrogen Peroxide is utilized in our ETP's instead of FeCl<sub>3</sub> to avoid chemical sludge formation.
8. Chemical de-contamination technique is being adopted at BPCL KR during turnarounds. The vessels, columns etc. are decontaminated using specially formulated chemical which is environment friendly, non-hazardous and fully biodegradable. The Hydrocarbons are recovered in the form of slop after de-emulsification process.

c) Clean technologies implemented for optimal solid waste management

Mechanical oil recovery system for oil recovery from oily sludge. Post IREP ETP sludge is processed in DCU.

1. In-situ recovery of oil from crude tank bottom sludge.
2. BPCL Kochi refinery constructed two secured landfills for the safe disposal of hazardous solid wastes as per the standard norms laid down by CPCB. The first landfill pit has a capacity of 590m<sup>3</sup> and is dedicated to the disposal of FCC catalyst fines and spent molecular sieves. The second land fill pit with a capacity of 390 m<sup>3</sup> is dedicated for the disposal of sludge from effluent treatment plants.
3. Installation of bio gas plant of capacity 1 T/day to convert canteen food waste into gas for use in canteen. The plant is developed based on the NISARGRUNA technology developed by Bhabha Atomic Research Centre. (BARC)
4. We have entered into an agreement with KEIL (Kerala Enviro Infrastructure Limited) for disposing solid hazardous wastes at their TSDF facility.
5. Wherever possible, spent catalyst containing recoverable metals are disposed /sold to authorized recyclers.
6. Paper waste recycling program to dispose old paper to get new printable A4 paper.
7. A centralized solid waste segregation and management facility is under development. This Facility will act as a single point for collection, storage, treatment and evacuation of all types of wastes generated inside BPCL KR in an ecofriendly manner.

### **GREEN COVER AT KOCHI REFINERY**

BPCL, Kochi Refinery has always given highest preference towards care for environment and their protection. The company has already incorporated pollution control measures in their design itself and has also grown an extensive Green cover on its periphery and within for which the refinery goes by the name **BPCL Green Kochi Refinery**. Recognizing the company's commitment towards environment care and protection, it has been certified for ISO 14001, which was first in the state of Kerala.

**Total green cover area at BPCL, Kochi Refinery is around 315 acres.**

Kochi Refinery maintains an Eco-park and many theme based parks such as Rainbow Park, Amrutha Sarass, Varshodyan, Kalpkodyan, Herbal Park, Bamboo Park, Miyawaki Forests etc. These were developed as a part of Greenbelt initiatives and they blend with the nature and is inhabited with diverse trees, flowering plants, herbal trees and fruit bearing trees. Three number of Butterfly parks were set up towards enhancement of Bio-diversity. As part of PDP Project green belt development, we have planted more than 20,000 saplings this year to make greenery in Petrochemical complex. A Mini Miyawaki forest was developed near coke dome and PDP Project area. Further, Kochi Refinery has other dense vegetation in the form of plantation and natural growth which constitutes to the



green cover. The diversified Green belt within the Refinery has drawn attention from even seasonal migratory birds.

**With the reference of Environmental clearance for the project of Integrated Refinery Expansion Project (IREP)), as committed in the EIA/EMP report, the BPCL – KR has done environmental protection measures and community development activities.**

**Environment Protection Measures:**

BPCL – KR has been spent huge amount on Environment management associated with CEMP-II and IREP as per commitment in Environment Management Plan (EMP) were:

- Waste water treatment system
- Tall Stacks for wide dispersion of pollutants
- A closed, automated coke transferring system aims for gains in environmental, economic and safety performance
- Stack gas monitoring (online facilities)
- Land acquisition for safety of the surrounding environment
- Green belt development

**Community Development Activates:**

The Various Community Development Activities associated with CEMP II were carried out under the following categories.

- **Education**
- **Water Supply for the nearby community**
- **Health Care**
- **Helping hand for Community Development activities**
- **Support for Development Programs in the nearby locality and Kochi City.**

**Some of the major activities carried out are as below:**

- a. Infrastructure support like Buildings, Electricity, Water and Uninterrupted supply of Medical Oxygen needed for setting up a temporary hospital to combat Covid -19 to State Government.
- b. Free Liquid Medical Oxygen Supply for Covid Care centers of State Government.
- c. Rejuvenation of neighboring Thanneerchal Lake in Tripunithura.
- d. Support for Gas Fired Crematoriums in Grama Panchayats.
- e. House for poor (Urban & Rural): Vadavucode Puthencruz & Thiruvaniyoor Grama Panchayats and Kochi Corporation.
- f. Construction/Renovation of Primary Health Centers and Anganwadis.
- g. Construction/renovation of class rooms in Govt. Schools and Support for Special Schools.
- h. Support for *Kudumbasree* Units – Building, vehicle for waste collection.
- i. Promotion of science education in Govt. Schools.
- j. Installation of Traffic Signal Systems and lighting at various junctions.
- k. Development/renovation/repair of rural roads and lighting projects
- l. Setting up and Up-keeping of public utilities, Public toilets & heritage monuments.

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