

report

report no. 3/15

Air pollutant emission estimation methods for E-PRTR reporting by refineries

2015 edition



ISBN 978-2-87567-046-5



9 782875 670465 >

Air pollutant emission estimation methods for E-PRTR reporting by refineries

2015 edition

Prepared by the Concaawe Air Quality Management Group's Special Task Force on Emission Reporting Methodologies (STF-69)

G. De Caluwé
A. Bakker
E. Benavente
B. Caamaño
E. Doyelle
O. Duclaux
D. Leventos
N. Ribeiro
B. Smithers

L. Gonzalez (Science Executive)
K. Vaskinen (Research Associate)

Reproduction permitted with due acknowledgement

© Concaawe
Brussels
April 2015

ABSTRACT

This report is an update of the Concaawe publication "*Air Pollutant Emission Estimation Methods for EPER and PRTR Reporting by Refineries*". It provides algorithms to permit emission estimates to be made by refineries to meet the reporting requirements of the European Pollutant Release and Transfer Register (E-PRTR) regarding pollutant emissions to air. This version contains some additional algorithms and new and updated emission factors and supersedes previous versions of the report listed below:

Concaawe Report 1/09
Concaawe Report 3/07
Concaawe Report 9/05R
Concaawe Report 9/05

The control copy of this report is posted as an electronic document on the Concaawe web-site (www.concaawe.org).

There are 60 air pollutants which must be reported under the E-PRTR requirements if their respective annual emission threshold values are exceeded at a facility. All 60 pollutants are listed in Appendix 1 of this report. Emission estimation methods are provided for 24 of those pollutants. New and updated information is summarised in Appendix 2.

KEYWORDS

Air pollution, refineries, E-PRTR, emission factors, sources.

INTERNET

The controlled version of this report is available as an Adobe pdf file on the Concaawe website (www.concaawe.org) and the latter should be checked for updates. New and updated information provided in this version is summarised in Appendix 2.

NOTE

Considerable efforts have been made to assure the accuracy and reliability of the information contained in this publication. However, neither Concaawe nor any company participating in Concaawe can accept liability for any loss, damage or injury whatsoever resulting from the use of this information.

This report does not necessarily represent the views of any company participating in Concaawe.

CONTENTS		Page
SUMMARY		X
1.	INTRODUCTION	1
2.	EMISSION ESTIMATION METHODOLOGIES	3
3.	POLLUTANTS	4
4.	EMISSION SOURCES	6
4.1.	REFINERIES	6
4.2.	GASOLINE MARKETING FACILITIES	6
5.	EMISSION ESTIMATION ALGORITHMS	8
5.1.	INTRODUCTION	8
5.2.	EMISSION FACTORS DERIVED FROM MEASUREMENTS WITH DATA BELOW THE LIMIT OF DETECTION	10
5.3.	TREATMENT OF DATA WHERE MEAN AND MEDIAN VALUES AVAILABLE	10
5.4.	OVERVIEW OF COMBUSTION ALGORITHMS	10
5.4.1.	Heating Values	11
6.	EMISSION CONTROLS	12
6.1.	OVERVIEW	12
6.2.	PARTICULATE EMISSIONS FROM CATALYTIC CRACKING UNITS	12
6.3.	EMISSIONS FROM CATALYTIC REFORMING UNITS	12
7.	METHANE (CH₄)	13
7.1.	COMBUSTION OF FUELS	13
7.1.1.	Other Fuels	14
7.2.	DESTRUCTION OF GASEOUS STREAMS	15
7.2.1.	Flares	15
7.2.1.1.	Flare Stream Details Known	15
7.2.1.2.	Flare Stream Details Unknown	15
7.2.2.	Incinerators	15
7.3.	FUEL GAS SYSTEMS	15
7.4.	UNCONTROLLED BLOWDOWN SYSTEMS	16
8.	CARBON MONOXIDE (CO)	17
8.1.	COMBUSTION OF FUELS	17
8.1.1.	Other Fuels	18
8.2.	DESTRUCTION OF GASEOUS STREAMS	19
8.2.1.	Flares	19
8.2.1.1.	Flare Stream Details Known	19
8.2.1.2.	Flare Stream Details Unknown	19
8.2.2.	Incinerators	19
8.3.	CATALYTIC CRACKING UNIT REGENERATORS	19
8.3.1.	Full Burn Regeneration	20
8.3.2.	Partial Burn with CO Boiler	20
8.3.3.	Partial Burn without CO Boiler	20
8.4.	CATALYTIC REFORMING UNITS	20

9.	CARBON DIOXIDE (CO₂)	21
9.1.	COMBUSTION	21
9.2.	DESTRUCTION OF GASEOUS STREAMS	21
9.2.1.	Flares	21
9.2.1.1.	Flare Stream Details Known	21
9.2.1.2.	Flare Stream Composition Unknown	22
9.2.1.3.	Flare Stream Details Unknown	22
9.2.2.	Incinerators	22
9.3.	CATALYTIC CRACKING UNIT REGENERATORS	22
9.3.1.	FCCU With CO Boiler	23
9.3.2.	FCCU Without CO Boiler	23
9.4.	OTHER CATALYST REGENERATION	23
9.4.1.	Flue Gas Flow and Composition Known	23
9.4.2.	Flue Gas Details Unknown	23
9.5.	COKERS	23
9.6.	HYDROGEN PLANTS	24
9.6.1.	Feed Composition Data Known	24
9.6.2.	Feed Composition Data Unknown	24
10.	HYDROFLUOROCARBONS (HFC)	25
11.	NITROUS OXIDE (N₂O)	26
11.1.	COMBUSTION OF FUELS	26
11.1.1.	Other Fuels	27
11.2.	DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS	27
12.	AMMONIA (NH₃)	28
12.1.	NO _x REDUCTION SYSTEMS	28
12.1.1.	SNCR	28
12.1.2.	SCR	28
12.2.	REFRIGERATION SYSTEMS	28
12.3.	CATALYTIC CRACKING UNIT REGENERATORS	29
12.3.1.	Full Burn Regeneration	29
12.3.2.	Partial Burn with CO Boiler	29
12.3.3.	Partial Burn without CO Boiler	29
13.	NON-METHANE VOLATILE ORGANIC COMPOUNDS (NMVOC)	30
13.1.	COMBUSTION OF FUELS	30
13.1.1.	Other Fuels	31
13.2.	DESTRUCTION OF GASEOUS STREAMS	32
13.2.1.	Flares	32
13.2.1.1.	Flare Stream Details Known	32
13.2.1.2.	Flare Stream Details Unknown	32
13.2.2.	Incinerators	32
13.3.	CATALYTIC CRACKING UNIT REGENERATORS	32
13.3.1.	Full Burn Regeneration	33
13.3.2.	Partial Burn with CO Boiler	33
13.3.3.	Partial Burn without CO Boiler	33
13.4.	FLUID COKERS	33
13.5.	FUGITIVE EMISSIONS FROM PRESSURISED COMPONENTS	33
13.5.1.	Leak Detection Surveys Undertaken	33
13.5.1.1.	Conventional Hydrocarbon Monitor	34

13.5.1.2.	Optical Gas Imaging Camera	34
13.5.2.	Leak Detection Surveys Not Undertaken	35
13.5.2.1.	Component Data Available	35
13.5.2.2.	No Component Data Available	37
13.6.	OILY-WATER COLLECTION AND TREATMENT SYSTEMS	37
13.6.1.	Emission Estimation Models For Entire System	37
13.6.2.	Process Drains	37
13.6.3.	Oil-Water Separators	38
13.6.3.1.	Gravity Separator - where separator inlet monitoring data available	38
13.6.3.2.	Simple Algorithms	38
13.7.	COOLING WATER TOWERS	41
13.8.	LOADING OF MOBILE CONTAINERS	41
13.8.1.	Uncontrolled Emissions	41
13.8.2.	Emissions Controlled with a Vapour Recovery Unit (VRU)	42
13.8.2.1.	VRU Fitted with a CEM	42
13.8.2.2.	VRU Efficiency Known	42
13.9.	STORAGE TANKS	42
13.9.1.	Floating Roof Tanks	43
13.9.2.	Vertical Fixed Roof Tanks (VFRT)	43
13.9.2.1.	VFRTs Connected to a Vapour Holding Tank (VHT)	43
13.9.3.	Aboveground Horizontal Tanks	43
13.9.4.	Underground Tanks	43
13.9.5.	Tank Cleaning	43
13.9.6.	Storage Tanks - General Comments	43
13.10.	UNCONTROLLED BLOWDOWN SYSTEMS	44
13.11.	UNCONTROLLED BITUMEN BLOWING	44
14.	NITROGEN OXIDES (NO_x)	45
14.1.	COMBUSTION IN BOILERS AND FURNACES	45
14.2.	GAS TURBINES	49
14.2.1.	Natural Gas Combustion	49
14.2.2.	Distillate Oil Combustion	49
14.3.	GAS ENGINES (4 STROKE, LEAN BURN)	49
14.4.	DIESEL ENGINES (LARGE, STATIONARY)	49
14.5.	COMBUSTION OF AUXILIARY AND PILOT FUELS	50
14.6.	DESTRUCTION OF GASEOUS STREAMS	50
14.6.1.	Flares	50
14.6.1.1.	Flare Stream Details Known	50
14.6.1.2.	Flare Stream Details Unknown	50
14.6.2.	Incinerators	51
14.7.	CATALYTIC CRACKING UNIT REGENERATORS	51
15.	SULPHUR HEXAFLUORIDE (SF₆)	52
16.	OXIDES OF SULPHUR (SO_x)	53
16.1.	COMBUSTION	53
16.2.	DESTRUCTION OF GASEOUS STREAMS	53
16.2.1.	Flares	53
16.2.1.1.	Flare Stream Details Known	53
16.2.1.2.	Flare Stream Details Unknown	54
16.2.2.	Incinerators	54
16.2.2.1.	Sulphur Plant Tail Gas Incinerator	54
16.3.	CATALYTIC CRACKING UNIT REGENERATORS	54

16.3.1.	Coke sulphur content known	54
16.3.2.	Coke sulphur content not known	55
16.4.	CATALYTIC REFORMING UNITS	55
17.	HYDROCHLOROFLUOROCARBONS (HCFC)	56
18.	ARSENIC (As)	57
18.1.	COMBUSTION OF FUELS	57
18.2.	DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS	58
18.3.	CATALYTIC CRACKING UNIT REGENERATORS	58
18.4.	FLUID COKERS	58
19.	CADMIUM (Cd)	59
19.1.	COMBUSTION OF FUELS	59
19.2.	DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS	60
19.3.	CATALYTIC CRACKING UNIT REGENERATORS	60
20.	CHROMIUM (Cr)	61
20.1.	COMBUSTION OF FUELS	61
20.2.	DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS	62
21.	COPPER (Cu)	63
21.1.	COMBUSTION OF FUELS	63
21.2.	DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS	64
21.3.	CATALYTIC CRACKING UNIT REGENERATORS	64
21.4.	FLUID COKERS	64
22.	MERCURY (Hg)	65
22.1.	COMBUSTION OF FUELS	65
22.2.	DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS	66
22.3.	CATALYTIC CRACKING UNIT REGENERATORS	66
22.4.	FLUID COKERS	66
23.	NICKEL (Ni)	67
23.1.	COMBUSTION OF FUELS	67
23.2.	DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS	68
23.3.	CATALYTIC CRACKING UNIT REGENERATORS	68
23.4.	FLUID COKERS	68
24.	LEAD (Pb)	69
24.1.	COMBUSTION OF FUELS	69
24.2.	DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS	70
24.3.	CATALYTIC CRACKING UNIT REGENERATORS	70
24.4.	FLUID COKERS	70
25.	ZINC (Zn)	71
25.1.	COMBUSTION OF FUELS	71

25.2.	DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS	72
25.3.	CATALYTIC CRACKING UNIT REGENERATORS	72
25.4.	FLUID COKERS	72
26.	DIOXINS AND FURANS (PCDD AND PCDF)	73
26.1.	COMBUSTION OF FUEL OIL	73
26.2.	CATALYTIC REFORMING UNIT REGENERATORS	74
27.	BENZENE (C₆H₆)	75
27.1.	SPECIATED FENCELINE NMVOC DATA AVAILABLE	75
27.2.	NO SPECIATED FENCELINE NMVOC DATA AVAILABLE	75
27.3.	ESTIMATION BY SOURCE	76
27.3.1.	Combustion of Fuels	76
27.3.2.	Destruction of Flare Streams	77
27.3.2.1.	Flare Stream Details Known	77
27.3.2.2.	Flare Stream Details Unknown	77
27.3.3.	Catalytic Cracking Unit Regenerators	77
27.3.3.1.	Full Burn Regeneration	77
27.3.3.2.	Partial Burn with CO Boiler	77
27.3.3.3.	Partial Burn without CO Boiler	78
27.3.4.	Fluid Cokers	78
27.3.4.1.	Emissions Controlled with CO or Fired Waste Heat Boiler	78
27.3.4.2.	Non-Controlled Emissions	78
27.3.5.	Uncontrolled Blowdown System	78
28.	POLYCYCLIC AROMATIC HYDROCARBONS (PAH)	79
28.1.	COMBUSTION OF FUELS	79
28.1.1.	Refinery Fuel Oil Combustion in Boilers and Furnaces	79
28.1.2.	Gas Combustion in Boilers and Furnaces	80
28.1.2.1.	Natural Gas	80
28.1.2.2.	Refinery Fuel Gas	80
28.1.3.	Gas Combustion in Gas Turbines	81
28.1.4.	Gas Combustion in Gas Engines	81
28.1.5.	Distillate Oil Combustion in Diesel Engines	82
28.1.6.	Incinerator Support Fuel and Flare Pilot Fuel	82
28.2.	DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS	82
28.3.	CATALYTIC CRACKING UNIT REGENERATORS	82
29.	CHLORINE AND INORGANIC CHLORINE COMPOUNDS	83
29.1.	CATALYTIC REFORMING UNITS	83
30.	PARTICULATE MATTER WITH DIAMETER <10 μM (PM₁₀)	84
30.1.	COMBUSTION OF FUELS	84
30.1.1.	Other Fuels	85
30.2.	DESTRUCTION OF GASEOUS STREAMS	86
30.2.1.	Flares	86
30.2.2.	Incinerators	86
30.3.	CATALYTIC CRACKING UNIT REGENERATORS	86
30.4.	FLUID COKERS	86

31.	REFERENCES	87
APPENDIX 1	E-PRTR AIR POLLUTANTS	91
APPENDIX 2	UPDATES IN EMISSION ALGORITHMS AND FACTORS	94
APPENDIX 3	ANTHRACENE AND NAPHTHALENE	97
A3.1	ANTHRACENE	97
A3.1.1	Combustion of Fuels	97
A3.1.2	Catalytic Cracking Unit Regenerator	98
A3.1.3	Emissions from a Very Large Refinery	98
A3.2	NAPHTHALENE	98
A3.2.1	Combustion of Fuels	98
A3.2.2	Catalytic Cracking Unit Regenerator	99
A3.2.3	Emissions from a Very Large Refinery	99
APPENDIX 4	NMVOC EMISSIONS FROM GASOLINE MARKETING FACILITIES	100
A 4.1	DISTRIBUTION TERMINALS	100
A 4.1.1	Storage Tanks	100
A 4.1.2	Loading of Mobile Containers	100
A 4.1.3	Fugitive Emissions from Components	100
A 4.1.4	Oil-Water Separators	100
A 4.2	SERVICE STATIONS	100
APPENDIX 5	CONVERSION FACTORS AND DEFAULT FUEL VALUES	103

SUMMARY

With the introduction of the public domain databases of pollutant releases - EPER (European Pollutant Emission Register) and its successor E-PRTR (European Pollutant Release and Transfer Register) - there is a need for reliable and consistent emissions data in the oil industry sector.

The E-PRTR Regulation requires that annual emissions of key species are reported where those emissions exceed a minimum threshold.

This Report provides the estimation algorithms and emission factors for uncontrolled releases of air pollutants from stationary sources at oil refineries which Concaawe recommends for E-PRTR reporting purposes, where measurements have not been undertaken. The emission estimation algorithms are fully referenced and the emission factors provided in a consistent metric unit base.

Concaawe has previously published Report No. 9/05 (and a revised version 9/05R) *Air Pollutant Emission Estimation Methods for EPER and PRTR Reporting by Refineries*.

Report No. 9/05R was submitted to the European Commission and the European Environment Agency and is referenced as a source of sector specific calculation methods in the EU (2006) *Guidance Document for the Implementation of the European PRTR*.

It was updated in 2007 by Report No. 3/07 *Air Pollutant Emission Estimation Methods for E-PRTR Reporting by Refineries*. This provided new and revised factors and algorithms and focused on the reporting requirements of the E-PRTR Regulations. A second updated edition of that report was published in 2009 (Report No. 1/09).

This current report is the third edition of Report No. 9/05R and contains some additional algorithms and new and updated emission factors. A change log is presented in **Appendix 2**.

It is expected that future refinements to the emission factor database will be made. This document is therefore a "snapshot" of the present knowledge. Before using this report, the version number should be compared with the control copy which is posted as an electronic document on the Concaawe web-site (www.concaawe.org).

1. INTRODUCTION

The European Directive 96/61/EC on integrated pollution prevention and control (IPPC) [1] mandated the publication of a regularly updated pollutant inventory. The European Pollutant Emission Register (EPER) required the reporting of a number of pollutants, both to air and water, from all facilities listed in Annex 1 of the IPPC Directive.

The EPER requirements were succeeded by those of the European Pollutant Release and Transfer Register (E-PRTR) Regulation [2]. This implements at EU level the UNECE PRTR Protocol which was signed in 2003 in Kiev [3]. The first report of the E-PRTR was for the year 2007 with annual reporting thereafter. The E-PRTR is more extensive than EPER in a number of respects. For example, the list of pollutants has been enlarged and the amount of information required to be reported concerning emissions and transfers of pollutants has increased. Guidance on the implementation of the E-PRTR has been provided by the European Commission [4]. The list of air pollutants and their threshold values above which emissions must be reported are given in **Appendix 1**.

With regard to the data submissions for these Registers, Concaawe identified three issues that require attention by the oil refining sector:

1. The data submitted should be reliable, in the sense that they represent as accurately as possible the actual pollutant emissions. Over-estimation of emissions is clearly to be avoided. Moreover, under-estimation can give a false impression of what pollution emissions levels can be reached under realistic circumstances.
2. Data should be consistent between comparable sources within the industry.
3. The sharing of best practices in terms of emission factors is important in order to improve the quality of the reporting.

To address these issues, the Concaawe Air Quality Management Group initiated a review of the published emission factors for those air pollutants which may be emitted in excess of the reporting threshold values from stationary sources found at the majority of European refineries.

It was noted that there were no emission estimation guidelines for each and every one of the pollutants to air from refineries which may possibly require reporting under the regulations. Although guidance is provided in the European Environment Agency Emission Inventory Guidebook [5] for the major air pollutants, it does not give estimation methodologies for all of the E-PRTR listed pollutants.

On the other hand, for some pollutants such as non-methane volatile organic compounds (NMVOCs) there are a number of different estimation methodologies being used by European refineries e.g. protocols produced by the US EPA [6] and a number of nationally agreed methods such as that published by the UK Energy Institute [7].

Concaawe, therefore, published Report No. 9/05 and its first revision No. 9/05R [8] which comprised a compendium of emission factors, with associated references, for the uncontrolled release of air pollutants. The compendium could not be fully comprehensive as emission factors are not available in the public domain for all

sources and/or pollutants. Concaawe, however, considered this to be the most appropriate set of emissions factors for the refining sector.

Report No. 9/05R was superseded by Report No. 3/07 [9], which focused on the requirements of the E-PRTR and contained additional algorithms and updated emission factors. The second updated edition of that report was published in 2009 (Report No. 1/09 [10]).

This current report is the third edition of Report No. 9/05R and supersedes Report 1/09. It provides the estimation algorithms which Concaawe recommends for E-PRTR reporting purposes where measurements have not been undertaken.

The report does not consider the estimation of accidental or non-routine (e.g. due to maintenance) releases to air. Guidance in reference [4] recommends that emissions from such releases should be estimated by sites on an ad-hoc basis using whatever data are available and the most appropriate methods considered for the circumstances. Nor does it provide guidance on estimating emissions from mobile sources.

The emission factors provided are for uncontrolled releases. Reported emissions must take account of any abatement equipment installed e.g. wet gas scrubbers, electrostatic precipitators, etc.

Where emission factors are available, algorithms are provided for sources found in the majority of European refineries. There are some emission sources for which estimation algorithms are not provided in this report e.g. coke calciners. Refineries should review all of the sources of air pollutants on-site and establish if there are any additional sources from those listed in this report which may require emission estimates to be made for E-PRTR reports.

Concaawe has previously published reports on non-methane volatile organic compound (NMVOC) emissions from refineries and other downstream oil industry sources. However Report No. 85/54 [11] which was widely used by Industry is now out of date and is no longer available. Although marketing terminals and service stations are not subject to E-PRTR reporting requirements, for completeness this current report provides NMVOC emission estimation algorithms which are applicable to gasoline storage and handling at these facilities.

A summary of the changes to the algorithms and emission factors given in Report No. 1/09 is provided in **Appendix 2**.

2. EMISSION ESTIMATION METHODOLOGIES

There are a number of sources of emission estimation methodologies:

- Oil industry associations e.g. Concaawe, API, etc.
- Oil companies that have published methods in the professional press
- National and international environmental authorities e.g. US EPA, European Environment Agency, etc.
- International organisations e.g. IPCC, etc.
- European Commission.

Methodologies published by the national and international organisations may be non-oil industry sector specific.

Only those estimation methods which are currently in the public domain were considered for inclusion in this report. The methodologies were considered in the following order of preference to determine those most representative for oil industry sources:

- Methods published by the oil industry
- Sector specific methods published by national and international authorities
- Non-sector specific methods.

Reported E-PRTR emission data must include a code to identify the type of estimation methodology used. The classification codes are simple letters:

Class M: emission data are based on measurements. Additional calculations are needed to convert the results of measurements into annual emission data. Emissions can be derived from continuous or discontinuous measurements of pollutant concentrations. Alternatively, they can be determined based on the results of short term or spot measurements.

Class C: emission data are based on calculations using activity data (e.g. fuel used, production rate) and emission factors or mass balances.

Class E: emission data are based on non-standardised estimations derived from best assumptions or expert guesses that are not based on publicly available references or good practice guidelines.

Where data are measured or calculated, the method of measurement and/or the calculation method must also be provided in the E-PRTR data submission.

The EU Guidance document [4] provides a list of the internationally approved or “equivalent” methodologies that should be used and the method names to be included in the E-PRTR submission. One of the accepted equivalent methodologies is a “European-wide sector specific calculation method, developed by industry experts, which has been delivered to the European Commission, to the European Environment Agency and the relevant international organisations”. The EU Guidance document [4] references Concaawe Report No. 9/05R [8] which had been submitted to the EC and EEA. This current report is a replacement for Report No. 9/05R and hence use of the algorithms in this report can be considered to be an approved calculation methodology: data could then be reported using the letters “C” and method name acronym “SSC” (sector specific calculation).

3. POLLUTANTS

There are sixty air pollutants which must be reported under the E-PRTR requirements if their respective annual emission threshold values are exceeded at a facility. All of these are shown in **Appendix 1**, with their threshold values.

The EU Guidance Document on E-PRTR Implementation [4] provides indicative lists of the pollutants likely to be emitted on a sector specific “activity” basis. In addition to having its own specific sectoral activity of “mineral oil and gas refineries”, the Oil Industry also uses combustion units with ratings in excess of 50 MW. These are included in the sectoral activity classified within the PRTR Regulation [2] as “thermal power stations and other combustion installations”.

Those pollutants on the sector specific indicative lists within the EU Guidance Document for these two activities are listed in **Appendix 1**.

Information was requested from the Concaawe member companies in 2002 concerning the emissions of air pollutants from refineries reported either internally or externally. **Appendix 1** lists those pollutants which had been estimated, by at least one of the nine companies who responded, to exceed the E-PRTR reporting thresholds.

Appendix 1 indicates that the pollutants included on the two EU indicative lists are almost identical to those on the oil industry list. The difference is the addition of two pollutants on the indicative list for combustion installations: dioxins/furans and trichloroethylene.

Trichloroethylene (TRI) is not a product of combustion; its major use is as an organic solvent for industrial degreasing. The inclusion of this pollutant on the sector specific indicative list for combustion installations appears to be due to an anomaly in the EPER database. Only one facility classified as "Combustion installation > 50 MW" reported emissions of TRI, but these would appear to be from the process of manufacturing rubber tyres and tubing at the site and not as a by-product of combustion. This report, therefore, does not consider this pollutant further.

This report provides algorithms to estimate the emissions of all of the other pollutants on the indicative lists in the EU Guidance for refineries and combustion installations rated in excess of 50 MW.

Anthracene and naphthalene are two pollutants that are known to be emitted by refineries, but are not on the sector specific indicative lists. A review of the emissions of these pollutants is provided in **Appendix 3**. It is shown that, even for the largest refineries, neither anthracene nor naphthalene emissions are likely to exceed their E-PRTR reporting threshold values.

Hydrogen cyanide (HCN) is not listed in the refining sector specific indicative list. Information available from the US-EPA (Environmental Protection Agency) [12] indicates that annual emissions from some fluid catalytic cracking units could exceed the yearly E-PRTR reporting threshold. Concaawe will be reviewing both the available emission data and the HCN formation processes to assess the possibility to develop industry-applicable emission factors for the EU. Should HCN emissions need to be determined, the recommended approach is stack concentration measurements using

appropriate sampling and analytical methods. The recommended methods are EPA Method 320 [13] or Method OTM-29 [14]¹.

Sites should review their processes and emission sources to establish if there is the potential for any of the other E-PRTR air pollutants to be released in excess of their reporting thresholds.

¹ EPA Method-320 is based on FTIR technique while OTM-29 is a wet chemistry method. Both methods have specific measurement details that must be carefully implemented to obtain reliable results in the typical FCC flue gas environment.

4. EMISSION SOURCES

4.1. REFINERIES

This report divides the sources found within the majority of refineries, for which emission factors are available in the public domain, into the following categories:

- Combustion
- Process vents
- Storage
- Loading
- Miscellaneous

Combustion sources considered comprise:

- Boilers
- Furnaces
- Fired waste heat boilers
- CO boilers
- Gas turbines
- Gas engines
- Diesel engines
- Incinerators
- Flares

Process sources included are:

- Hydrogen plants
- Fluid coking units
- Fluidised catalytic cracking units
- Catalytic reforming units

Miscellaneous sources included are:

- Process drains
- Oil-water separators
- Fugitive emissions from pressurised pipe work and components
- Refrigeration systems
- Use of SF₆

There are some sources which are only found in a limited number of refineries for which algorithms are not given in this report. One example for which emission factors are available [15] is coke calcining.

4.2. GASOLINE MARKETING FACILITIES

Neither marketing distribution terminals nor service stations are regulated under the terms of the IPPC Directive [1] and hence are not required to submit E-PRTR reports.

Emission estimates for distribution terminals and service stations may, however, be made by oil companies for their own environmental reporting purposes.

Emissions from distribution terminals are primarily NMVOCs due to the storage and loading of refined products, in particular gasolines. Emission estimation methods for sources of NMVOCs at terminals are provided in **Appendix 4.1**.

Some terminals have small steam raising boilers e.g. to heat heavy oil storage tanks. The algorithms provided in this report can be used to estimate combustion emissions from these facilities.

Unlike refineries and terminals, storage at service stations is in underground horizontal tanks. Emissions occur from these due to the displacement of vapours during filling and the evaporation of the stored gasoline. Emissions also occur due to the filling of automobile fuel tanks and from minor drips and spills during those operations. Estimation methods for NMVOC emissions from these sources are provided in **Appendix 4.2**.

5. EMISSION ESTIMATION ALGORITHMS

5.1. INTRODUCTION

Algorithms are provided for the E-PRTR air pollutants which may exceed their emissions reporting thresholds. The level of emissions depends upon the refinery crude throughput, the process units installed, fuels consumed, type of equipment in use, procedures in place, etc.

Algorithms are given on a pollutant by pollutant basis in **Sections 7 - 30**, in the order of the pollutant list in **Appendix 1**.

Algorithms are also provided in **Appendix 3** for two additional pollutants (anthracene and naphthalene). It is demonstrated that the emissions of neither of these pollutants are likely to exceed their E-PRTR reporting thresholds.

Estimation algorithms are given for the sources of each pollutant. A reference is provided for each method, with additional details where considered appropriate.

If no pollutant algorithm is provided for a source, it is because:

- emissions of the pollutant do not occur from that source;
- emissions are considered negligible; or
- no published algorithm has been found or considered appropriate for sources at refineries.

Table 1 indicates those sources for which pollutant algorithms are provided in this report.

Emission factors are given in scientific units to 3 significant figures i.e. 5.67E+03 is equivalent to 5670.

It should be noted that data submitted in E-PRTR reports should be expressed in kg/year and with three significant digits, e.g. 123 000, 17.9, 2.10.

Table 1 Sources for which pollutant emission estimation methodologies are provided in this report

	CH ₄	CO	CO ₂	HFC	N ₂ O	NH ₃	NMVOC	NO _x	SF ₆	SO _x	HCFC	As	Cd	Cr	Cu	Hg	Ni	Pb	Zn	Dioxins	C ₆ H ₆	PAH	Cl	PM ₁₀
Boiler	x	x	x		x		x	x		x		x	x	x	x	x	x	x	x	x	x	x		x
Furnace	x	x	x		x		x	x		x		x	x	x	x	x	x	x	x	x	x	x		x
Gas turbine	x	x	x		x		x	x		x		x	x	x	x	x	x	x	x		x	x		x
Gas engine	x	x	x		x		x	x		x											x	x		x
Diesel engine	x	x	x		x		x	x		x											x	x		x
Pilot or support fuel	x	x	x		x		x	x		x		x	x	x	x	x	x	x	x		x	x		x
Incinerator	x	x	x		x		x	x		x		x	x	x	x	x	x	x	x		x	x		x
Flare	x	x	x				x	x		x											x			x
Hydrogen plant			x																					
Fluid coking unit			x				x					x			x	x	x	x	x		x			x
Catalytic cracking unit		x	x			x	x	x		x		x	x		x	x	x	x	x		x	x		x
Catalytic reforming unit		x	x							x											x			x
Process drainage							x																	
Oil-water separator							x																	
Process fugitives	x						x																	x
Loading							x																	
Storage							x																	
SCR/SNCR						x																		
Refrigeration				x		x					x													
Lab/test/HV switch gear										x														

5.2. EMISSION FACTORS DERIVED FROM MEASUREMENTS WITH DATA BELOW THE LIMIT OF DETECTION

A few emission factors were originally derived from measurements where, if the values measured were all below the limit of detection, those data points were set at the limit of detection level. Where possible, in this report these factors have been identified and the following rule used to adjust them:

- Where all data points were below the measurement detection limit, the emissions factor has been set to zero (i.e. it is considered that the source is not proven).

Where both the averages of data points above and below the limit of detection (the 'detect' and 'non-detect' values) are provided in a reference, along with the number of data points used to derive these, a weighted value as calculated below has been used in this report.

- Weighted factor = [(average detect value × number of detect samples) + (average non-detect value × number of non-detect samples × detect ratio)] / total number of samples

where detect ratio = number of detect samples / total number of samples.

Reference: [16], Section 7.4.7

Where only the average of the detect and non-detect values and the detect ratio is provided in a reference, a weighted value as calculated below has been used in this report.

- Weighted factor = [(average value × detect ratio) + {(average value / 2) × (1 - detect ratio)}]

All algorithms where these adjustments have been made are identified in the text.

5.3. TREATMENT OF DATA WHERE MEAN AND MEDIAN VALUES AVAILABLE

In references [15], [17] and [18], both the mean and median values of pollutant emission data sets are provided. A small number of the data sets used to determine emission factors are highly skewed, resulting in mean values dominated by a few very high values that are not representative of the majority of readings. Where the mean value exceeds the median value by more than a factor of ten, the median has been considered a more realistic value and has been used in this report. In all other cases the mean value has been used.

All algorithms where the median value has been used are identified in the text.

5.4. OVERVIEW OF COMBUSTION ALGORITHMS

For many of the pollutants arising from combustion sources the published emission factors are one of the following types:

- a) Mass per unit volume combusted (EF_{VOL})
- b) Mass per energy consumed (EF_{NCV})

To provide a consistent approach within this report, algorithms using emissions factors based on EF_{NCV} are provided. This type of factor enables emissions to be calculated for fuels which are widely different in composition to those for which EF_{VOL} was originally determined. Where published factors are only in the form of EF_{VOL} , the values of EF_{NCV} have been calculated using default values for the fuels. Where appropriate, this is noted within the text. Details, along with the default fuel heating values used in this report, are provided in **Appendix 5**.

5.4.1. Heating Values

In the USA, the norm is to use Higher Heating Value (HHV) (or Gross Calorific Value) for a fuel, whilst in Europe the Net Calorific Value (NCV) (or Lower Heating Value - LHV) is usually quoted. In this report all heating values quoted are NCVs and all emission factors involving heat energy require the use of the corresponding fuel NCV, unless otherwise quoted.

$NCV = HHV \times \text{Correction Factor for heat of vapourisation of water in the fuel}$

For liquid fuels:

$$NCV = HHV \times 0.95$$

For gaseous fuels:

$$NCV = HHV \times 0.9$$

Reference: [19], Section 4.2.

6. EMISSION CONTROLS

6.1. OVERVIEW

The algorithms provided in this report (with the exceptions identified in **Sections 6.2** and **6.3**) assume that no emission reduction control equipment (e.g. flue gas desulphurisation system, vapour recovery unit, etc.) is installed in vent lines, stacks or flues.

Calculated emissions must, therefore, take account of any emission controls. The algorithm to be used is:

$$\text{Emissions reported} = \text{Uncontrolled emissions} \times (1 - [\text{EFF} \times \text{ONTIME}] / 10\,000)$$

where:

EFF = Average percentage efficiency of emission reduction control equipment over reporting period.

ONTIME = Percentage of the time that the emission reduction equipment is operational when required during the reporting period.

Where there are two or more emission control devices in series impacting a particular pollutant (e.g. for particulates: cyclone plus electrostatic precipitator) then the effect of each device on the pollutant emissions must be taken into account. For example, if two devices are installed, with respective efficiencies of EFF₁ and EFF₂ and operating times of ONTIME₁ and ONTIME₂, then the algorithm is:

$$\text{Emissions reported} = \text{Uncontrolled emissions} \times \{(1 - [\text{EFF}_1 \times \text{ONTIME}_1] / 10\,000) \times (1 - [\text{EFF}_2 \times \text{ONTIME}_2] / 10\,000)\}$$

For vapour recovery units (VRUs) designed to reduce NMVOC emissions from loading operations, algorithms are also provided where the average vent emission concentration is known but not the overall VRU efficiency.

6.2. PARTICULATE EMISSIONS FROM CATALYTIC CRACKING UNITS

The algorithms for particulate (PM₁₀) and metals emissions from these units assume that there are cyclone systems installed inside the regenerator vessel to separate the catalyst particles from the hydrocarbon vapours. If additional cyclones or other emission abatement devices such as electrostatic precipitators are installed external to the regenerator then the effect of these additional controls to reduce emissions must be taken into account in the reported emission level.

6.3. EMISSIONS FROM CATALYTIC REFORMING UNITS

There are limited references to emissions from catalytic reforming units (CRUs). The emission factors quoted in this report for CO and SO_x are from reference [18]. This paper uses combined emissions data from a number of units. As some of these units may have emission abatement controls installed, the factors may not truly represent uncontrolled emissions.

A review of the emissions for particulates and metals using the factors in reference [18] for a very high throughput CRU indicated that the estimated emissions were very small relative to other sources of these pollutants in a large refinery. No factors for these pollutants have therefore been provided.

7. METHANE (CH₄)

Estimation methods are provided for emissions due to:

- Combustion of fuels
- Destruction of gaseous streams in incinerators and flares
- Venting to atmosphere of uncontrolled blowdown systems

7.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 2**.

Table 2 CH₄ Emission Factors for Combustion Sources

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces < 10 MW (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	6.98E-01	[19] Section 4, Table 4-7
	Refinery Fuel Oil	1.43E+00	[19] Section 4, Table 4-7
	LPG	9.63E-01	[19] Section 4, Table 4-7
	Natural Gas	1.08E+00	[19] Section 4, Table 4-7
	Refinery Fuel Gas - hydrogen gas content < 65% v/v	3.26E-01	[19] Section 4, Table 4-7
	Refinery Fuel Gas - hydrogen gas content ≥ 65% v/v	2.39E-01	[19] Section 4, Table 4-7
Boilers and Furnaces 10 MW to 100 MW	Distillate (gas oil)	1.68E-01	[19] Section 4, Table 4-7
	Refinery Fuel Oil	3.02E+00	[19] Section 4, Table 4-7
	LPG	9.63E-01	[19] Section 4, Table 4-7
	Natural Gas	1.08E+00	[19] Section 4, Table 4-7

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces 10 MW to 100 MW	Refinery Fuel Gas - hydrogen gas content < 65% v/v	3.26E-01	[19] Section 4, Table 4-7
	Refinery Fuel Gas - hydrogen gas content ≥ 65% v/v	2.39E-01	[19] Section 4, Table 4-7
Boilers and Furnaces > 100 MW	Distillate (gas oil)	9.05E-01	[19] Section 4, Table 4-7
	Refinery Fuel Oil	8.45E-01	[19] Section 4, Table 4-7
	Natural Gas	1.08E+00	[19] Section 4, Table 4-7
	Refinery Fuel Gas - hydrogen gas content < 65% v/v	3.26E-01	[19] Section 4, Table 4-7
	Refinery Fuel Gas - hydrogen gas content ≥ 65% v/v	2.39E-01	[19] Section 4, Table 4-7
Gas Turbine ¹	Natural Gas	4.11E+00	[19] Section 4, Table 4-9
Gas Engine 4-stroke, Lean Burn	Natural Gas	5.97E+02	[19] Section 4, Table 4-9
Diesel Engine ² Large, Stationary	Diesel Fuel	3.67E+00	[19] Section 4, Table 4-9
Incinerator Support Fuel or Flare Pilot Fuel	LPG	9.63E-01	[19] Section 4, Table 4-7
	Natural Gas	1.08E+00	[19] Section 4, Table 4-7
	Refinery Fuel Gas - hydrogen gas content < 65% v/v	3.26E-01	[19] Section 4, Table 4-7
	Refinery Fuel Gas - hydrogen gas content ≥ 65% v/v	2.39E-01	[19] Section 4, Table 4-7

Notes:

1. Factor derived from turbines operating at high (≥ 80%) loads.
2. Factor is derived from data from one engine with 9% CH₄ by weight in the exhaust gas.

7.1.1. Other Fuels

In the absence of specific emission factors for other gaseous fuels (e.g. low joule gas) it is recommended to use the value of EF_{NCV} for natural gas from **Table 2**.

7.2. DESTRUCTION OF GASEOUS STREAMS

7.2.1. Flares

The following algorithms are for emissions from the combustion of the flare gas. For emissions from the combustion of the pilot gas fuel used to initiate flare combustion, use the algorithms in **Section 7.1**.

7.2.1.1. Flare Stream Details Known

If the mass and composition of the flare stream are known:

$$\text{Mass emitted (kg)} = 5.00\text{E-}00 \times M \times \text{MF}_{\text{CH}_4}$$

where:

M = total mass of gas flared (in tonnes)

MF_{CH₄} = mass fraction of methane in gas flared

This algorithm assumes that 0.5% of the hydrocarbons remain unburned in “well designed and operated flares, such as in refineries”.

Reference: [19], Section 4.6, Figure 4-2.

7.2.1.2. Flare Stream Details Unknown

If the mass and composition are not known and a flare gas recovery system is not installed, a conservative factor based on refinery feed can be used:

$$\text{Mass emitted (kg)} = 2.28\text{E-}05 \times \text{Refinery Feed (in m}^3\text{)}$$

Reference: [19], Section 4.6, Table 4-11.

If a flare gas recovery system is installed it can be considered to be an emissions control device. The equation in **Section 6.1** can be used (with EFF = flare gas recovery system efficiency) to adjust the emissions estimate obtained from the algorithm above.

7.2.2. Incinerators

For all incinerator gas streams, use the algorithm in **Section 7.1** with an emission factor EF_{NCV} equal to that for natural gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 7.1**.

7.3. FUEL GAS SYSTEMS

Fugitive emissions can occur from the components e.g. valves, flanges, etc., in fuel gas lines containing methane. Emissions may be determined from leak monitoring surveys where CH₄ concentrations are measured, or calculated using equipment component counts (see **Section 13.5**). Where neither of these is available, a conservative emissions estimate can be obtained from:

$$\text{Mass emitted (kg)} = 3.00\text{E-}01 \times M \times \text{MF}_{\text{CH}_4}$$

where:

M = total mass of fuel gas combusted (in tonnes)

MF_{CH₄} = mass fraction of methane in fuel gas

Reference: [20], Appendix E.

7.4. UNCONTROLLED BLOWDOWN SYSTEMS

The gaseous emissions from blowdown systems in EU refineries are recovered and/or flared.

If these controls are not operational and all of the emissions are released to atmosphere, the total hydrocarbons emissions can be conservatively estimated using the factor provided in reference [6], Table 5.1-1. This reference states that methane comprises less than 1% by mass of the total hydrocarbon emissions.

8. CARBON MONOXIDE (CO)

Estimation methods are provided for emissions due to:

- Combustion of fuels
- Destruction of gaseous streams in incinerators and flares
- Partial burn regeneration of fluidised catalytic cracking units (FCCUs)
- Regeneration of catalytic reforming units

8.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 3**.

Table 3 CO Emission Factors for Combustion Sources

SOURCE	FUEL	EF_{NCV} g/GJ	REF
Boilers and Furnaces < 10 MW (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil) ¹	1.62E+01	[21] Section 1.3, Table 1.3-1
	Refinery Fuel Oil ^{1,2}	6.00E+00	[22] Section 3.10.3.1
	LPG ³	3.71E+01	[21] Section 1.5, Table 1.5-1
	Natural Gas	3.93E+01	[21] Section 1.4, Table 1.4-1
	Refinery Fuel Gas ⁴	1.21E+01	[22] Section 3.10.3.1
Boilers and Furnaces 10 MW to 100 MW	Distillate (gas oil) ¹	1.62E+01	[21] Section 1.3, Table 1.3-1
	Refinery Fuel Oil ^{1,2}	6.00E+00	[22] Section 3.10.3.1
	LPG ³	3.71E+01	[21] Section 1.5, Table 1.5-1
	Natural Gas	3.93E+01	[21] Section 1.4, Table 1.4-1
	Refinery Fuel Gas ⁴	1.21E+01	[22] Section 3.10.3.1

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces > 100 MW	Distillate (gas oil) ¹	1.62E+01	[21] Section 1.3, Table 1.3-1
	Refinery Fuel Oil ^{1,2}	6.00E+00	[22] Section 3.10.3.1
	LPG ³	3.47E+01	[23] SCC 10101002
	Natural Gas	3.93E+01	[21] Section 1.4, Table 1.4-1
	Refinery Fuel Gas ⁴	1.21E+01	[22] Section 3.10.3.1
Gas Turbine ⁵	Distillate (gas oil) ⁶	1.49E+00	[24] Section 3.1, Table 3.1-1
	Natural Gas	4.80E+00	[5] Section 1.A.1, Table 3-17
Gas Engine ⁷ 4-stroke, Lean Burn	Natural Gas	2.66E+02	[24] Section 3.2, Table 3.2-2
Diesel Engine Large, Stationary	Diesel Fuel	3.85E+02	[24] Section 3.4, Table 3.4-1
Incinerator Support Fuel or Flare Pilot Fuel	LPG ³	3.71E+01	[21] Section 1.5, Table 1.5-1
	Natural Gas	3.93E+01	[21] Section 1.4, Table 1.4-1
	Refinery Fuel Gas ⁴	1.21E+01	[22] Section 3.10.3.1

Notes:

- Reference [21], Table 1.3-1, note e states that CO emissions may increase by factors of 10 to 100 if the unit is improperly operated or not well maintained.
- Factor derived using NCV of 40 MJ/kg from reference [22], Table 3.54.
- Factor is for propane combustion.
- Factor derived using NCV of 48.07 MJ/kg from [22], table in Annex 8.6.2, Section B.2.3.
- Factor derived from turbines operating at high (≥ 80%) loads.
- Factor provided in reference [24] was derived using HHV of 139 MBtu/10³ US gal.
- Factor derived from engines operating at < 90% load.

8.1.1. Other Fuels

In the absence of specific emission factors for other gaseous fuels (e.g. low joule gas) it is recommended to use the value of EF_{NCV} for refinery fuel gas from **Table 3**.

8.2. DESTRUCTION OF GASEOUS STREAMS

8.2.1. Flares

The following algorithms are for emissions from the combustion of the flare gas. For emissions from the combustion of the pilot gas fuel used to initiate flare combustion, use the algorithms in **Section 8.1**.

8.2.1.1. Flare Stream Details Known

If the mass and composition of the flare stream are known:

$$\text{Mass emitted (kg)} = 1.77\text{E-01} \times M \times \text{NCV}$$

where:

M = mass of flare gas combusted (in tonnes)

NCV = net calorific value of the flare gas combusted (in MJ/kg)

Reference: [25], Section 4.2.1, Table 8.

8.2.1.2. Flare Stream Details Unknown

If the mass and composition are not known and a flare gas recovery system is not installed, a conservative factor based on refinery feed can be used:

$$\text{Mass emitted (kg)} = 1.20\text{E-02} \times \text{Refinery Feed (in m}^3\text{)}$$

Reference: [26], Activity 090203, Section 8, Table 2.

If a flare gas recovery system is installed it can be considered to be an emissions control device. The equation in **Section 6.1** can be used (with EFF = flare gas recovery system efficiency) to adjust the emissions estimate obtained from the algorithm above.

8.2.2. Incinerators

For all incinerator gas streams, use the algorithm in **Section 8.1** with an emission factor EF_{NCV} equal to that for natural gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 8.1**.

8.3. CATALYTIC CRACKING UNIT REGENERATORS

CO is produced during the regeneration process and depends upon its severity. Emissions from partial burn regeneration are normally controlled with a CO boiler.

It is anticipated that EU refineries will estimate CO₂ emissions from FCCUs using the algorithm in **Section 9.3**. In this case, the CO emissions will be determined from measurements of flue gas flow and CO concentration.

Where the method in **Section 9.3** is not used, CO emissions can be estimated using the following:

8.3.1. Full Burn Regeneration

CO emissions are deemed to be negligible.

8.3.2. Partial Burn with CO Boiler

CO emissions are deemed to be negligible.

Reference: [6], Table 5.1-1.

8.3.3. Partial Burn without CO Boiler

If there is no CO boiler in operation:

Mass emitted (kg) = 3.92E+01 × Volume of fresh feed to unit (in m³)

Reference: [6], Table 5.1-1.

8.4. CATALYTIC REFORMING UNITS

Mass emitted (kg) = 4.16E-02 × Volume of feed to unit (in m³)

Reference: [18], Table 1. This reference uses data from a number of units with varying degrees of abatement equipment installed – see **Section 6.3**. It also provides data on the number of data points both above and below the limit of detection. The emission factor is a weighted value using both sets of data – see **Section 5.2** of this report.

9. CARBON DIOXIDE (CO₂)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators and flares
- Catalytic cracking unit regenerators
- Other catalyst regeneration e.g. in catalytic reforming units
- Fluid and Flexi-cokers
- Hydrogen plants

European refineries must estimate their CO₂ emissions under the terms of the EU greenhouse gas emission allowance trading scheme [27]. Reference [28] sets out detailed guidelines for the monitoring and reporting of CO₂ emissions.

9.1. COMBUSTION

Reference [28] specifies that CO₂ emissions from combustion installations be calculated by multiplying the energy content of each fuel used by an emission factor and an oxidation factor (default value equal to one). This requires the NCV of each fuel to be determined along with activity-specific emission factors.

The algorithm provided below applies the fundamental principle of complete stoichiometric combustion using the value of carbon content of the fuel. This approach reduces the emission calculation uncertainty as only carbon content has to be determined instead of values for both NCV and emission factor,

$$\text{Mass emitted (kg)} = 1000 \times M \times \text{MF}_{\text{CARBON}} \times \text{CFC}_{\text{MW}}$$

where:

M = mass of fuel burnt (in tonnes)

MF_{CARBON} = mass fraction of carbon in fuel

CFC_{MW} = Molecular weight conversion from C to CO₂ = (44.01/12.01) = 3.664

Thus for refinery oil and gaseous fuels:

$$\text{Mass emitted (kg)} = 3.664\text{E}+03 \times M \times \text{MF}_{\text{CARBON}}$$

9.2. DESTRUCTION OF GASEOUS STREAMS

9.2.1. Flares

The following algorithms are for emissions from the combustion of the flare gas. For emissions from the combustion of the pilot gas fuel used to initiate flare combustion, use the algorithm in **Section 9.1**.

9.2.1.1. Flare Stream Details Known

If the mass and composition of the flare stream are known, use algorithm in **Section 9.1**, where:

M = mass of flare gas burnt (in tonnes)

MF_{CARBON} = mass fraction of carbon in flare gas

[28] specifies this methodology for CO₂ reporting purposes by European refineries.

9.2.1.2. Flare Stream Composition Unknown

If the composition of the flare gas stream is not known, a conservative factor based on the combustion of ethane can be used:

$$\text{Mass emitted (kg)} = 3.93\text{E}+00 \times \text{Volume of gas flared (in m}^3\text{)}$$

Reference: [28], Annex II, Section 2.1.1.3 (b).

9.2.1.3. Flare Stream Details Unknown

If both the mass and the composition of the flare gas stream are not known and a flare gas recovery system is not installed, a conservative factor based on refinery feed can be used:

$$\text{Mass emitted (kg)} = 3.14\text{E}+00 \times \text{Refinery Feed (in tonne)}$$

Reference: [29], Section 3, Table 5.

If a flare gas recovery system is installed it can be considered to be an emissions control device. The equation in **Section 6.1** can be used (with EFF = flare gas recovery system efficiency) to adjust the emissions estimate obtained from the algorithm above.

9.2.2. Incinerators

Use algorithm in **Section 9.1**, where:

M = mass of gas incinerated (in tonnes)

MF_{CARBON} = mass fraction of carbon in gas incinerated

9.3. CATALYTIC CRACKING UNIT REGENERATORS

Reference [28] requires that emissions shall be calculated by a material balance approach, taking into account the state of the input air and the flue gas. Note that for CO₂ reporting, all CO in the flue gas shall be reported as CO₂.

Reference [30] provides the following algorithm:

$$\text{Mass emitted (kg)} = (\text{AR} + \text{SR}) \times (\text{VF}_{\text{CO}_2} + \text{VF}_{\text{CO}}) \times \text{CON}_{\text{VOL}} \times \text{TIME}$$

where:

AR = Air blower capacity (in m³/minute)

SR = Supplemental oxygen addition rate (in m³/minute)

VF_{CO₂} = Volume fraction of CO₂ in flue gas

VF_{CO} = Volume fraction of CO in flue gas (prior to CO boiler if installed)

CON_{VOL} = Volume conversion factor at 15 C = 44 / MCF

MCF = Molar conversion factor at 15 C = (22.4 × 288 / 273) = 23.631 m³/kgmole

TIME = time blower operated (in minutes)

Thus:

$$\text{Mass emitted (kg)} = 1.86\text{E}+00 \times (\text{AR} + \text{SR}) \times (\text{VF}_{\text{CO}_2} + \text{VF}_{\text{CO}}) \times \text{TIME}$$

Reference: [19], Section 5.2.1, equation 5-6.

9.3.1. FCCU With CO Boiler

$$\text{Mass emitted (kg)} = 1.86\text{E}+00 \times (\text{AR} + \text{SR}) \times (\text{VF}_{\text{CO}_2} + \text{VF}_{\text{CO}}) \times \text{TIME}$$

9.3.2. FCCU Without CO Boiler

$$\text{Mass emitted (kg)} = 1.86\text{E}+00 \times (\text{AR} + \text{SR}) \times \text{VF}_{\text{CO}_2} \times \text{TIME}$$

9.4. OTHER CATALYST REGENERATION

CO₂ is produced during the catalyst regeneration in reforming and hydro-processing units.

9.4.1. Flue Gas Flow and Composition Known

Reference [28] specifies that the method provided in **Section 9.3** should be used.

9.4.2. Flue Gas Details Unknown

The following algorithm conservatively assumes complete stoichiometric combustion of the carbon in the coke deposited on the catalyst. In practice there will be small emissions of CO (see **Section 8.4**).

$$\text{Mass emitted (in kg)} = 3.66\text{E}+03 \times \text{CR} \times \text{MF}_{\text{CARB}} \times \text{Feed}$$

where:

CR = Mass ratio of coke produced per feed

MF_{CARB} = Mass fraction of carbon in coke

Feed = Feed to unit (in tonnes)

Reference: [19], Section 5.2.4.

9.5. COKERS

There are several varieties of cokers in use in refineries, including delayed cokers, fluid cokers, and flexi-cokers.

Delayed cokers will not have CO₂ emissions, other than from their process heaters [19]. These should be calculated using the fuel combustion algorithm in **Section 9.1**.

Fluid cokers and flexi-cokers may have a CO₂ vent resulting from the coke burner.

Reference [28] specifies that the method provided in **Section 9.3** should be used for flexi-cokers.

For cokers where flue gas flow and composition are unknown:

$$\text{Mass emitted (in kg)} = 3.66\text{E}+03 \times \text{CR} \times \text{MF}_{\text{CARB}} \times \text{Feed}$$

where:

CR = Mass ratio of coke produced per feed

MF_{CARB} = Mass fraction of carbon in coke

Feed = Feed to unit (in tonnes)

Reference: [19], Section 5.2.3.

If the burner off-gas is burned as a low joule gas fuel, the subsequent emissions should be calculated using the fuel combustion algorithm in **Section 9.1**.

9.6. HYDROGEN PLANTS

CO₂ is produced during the hydrogen production process.

9.6.1. Feed Composition Data Known

Reference [28] specifies that emissions should be calculated from the carbon content of the feed gas.

$$\text{Mass emitted (kg)} = 3.66\text{E}+03 \times \text{MF}_{\text{CARB}} \times \text{Feed}$$

where:

MF_{CARB} = mass fraction of carbon in feed gas

Feed = Feed to unit (in tonnes)

9.6.2. Feed Composition Data Unknown

If the composition of the feed gas is not known, a conservative factor based on an ethane feed can be used:

$$\text{Mass emitted (kg)} = 2.90\text{E}+03 \times \text{Feed to unit (in tonnes)}$$

Reference: [28], Annex III, Section 2.1.2.2 (b).

10. HYDROFLUOROCARBONS (HFC)

Hydrofluorocarbons (HFCs) may be used as refrigerants in refinery thermal exchange equipment.

Emissions are assumed to equal the amount used during the reporting period to top-up systems to replenish losses due to uncontrolled leakage.

Mass emitted (kg) = Mass used to top-up refrigerant systems (in kg)

Usage where the systems have been fully or partially drained and refrigerants collected for recycling or destruction should not be reported.

11. NITROUS OXIDE (N₂O)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators

11.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 4**.

Table 4 N₂O Emission Factors for Combustion Sources

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	8.40E-01	[19] Section 4, Table 4-7
	Refinery Fuel Oil	1.60E+00	[19] Section 4, Table 4-7
	LPG	4.33E+00	[19] Section 4, Table 4-7
	Natural Gas	1.03E+00	[19] Section 4, Table 4-7
	Natural Gas (where low NO _x burners fitted)	3.00E-01	[19] Section 4, Table 4-7
	Refinery Fuel Gas	3.89E-02	[19] Section 4 Table 4-7
Gas Turbine ¹	Natural Gas	1.43E+00	[19] Section 4, Table 4-9
Gas Engine 4-stroke, Lean Burn	Natural Gas	1.00E-01	[19] Section 4, Table 4-5
Diesel Engine Large, Stationary	Diesel Fuel	6.00E-01	[19] Section 4, Table 4-5
Incinerator Support Fuel or Flare Pilot Fuel	LPG	4.33E+00	[19] Section 4, Table 4-7
	Natural Gas	1.03E+00	[19] Section 4, Table 4-7

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Incinerator Support Fuel or Flare Pilot Fuel	Refinery Fuel Gas	3.89E-02	[19] Section 4 Table 4-7

Notes:

- Factor based on limited source tests on a single turbine with water-steam injection and operating at high ($\geq 80\%$) loads.

11.1.1. Other Fuels

In the absence of specific emission factors for other gaseous fuels (e.g. low joule gas) it is recommended to use the value of EF_{NCV} for refinery fuel gas from **Table 4**.

11.2. DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS

For all incinerator gas streams, use the algorithm in **Section 11.1** with an emission factor EF_{NCV} equal to that for natural gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 11.1**.

12. AMMONIA (NH₃)

Estimation methods are provided for emissions from:

- Selective Non-Catalytic NO_x Reduction (SNCR) systems
- Selective Catalytic NO_x Reduction (SCR) systems
- Refrigeration systems
- Catalytic Cracking Unit Regenerators

12.1. NO_x REDUCTION SYSTEMS

Ammonia is produced as a by-product by SCR and SNCR systems installed in flues to reduce NO_x emissions.

12.1.1. SNCR

The emission algorithms are:

$$\text{Mass emitted (kg)} = 3.50\text{E-}01 \times V_{\text{OIL}}$$

or

$$\text{Mass emitted (kg)} = 2.88\text{E+}02 \times V_{\text{GAS}}$$

where:

V_{OIL} = Volume of oil combusted in device connected to SNCR (in m³)

V_{GAS} = Volume of gas combusted in device connected to SNCR (in million m³)

Reference: [31], Section 5.4, Table 5-5.

12.1.2. SCR

The emission algorithms are:

$$\text{Mass emitted (kg)} = 1.70\text{E-}01 \times V_{\text{OIL}}$$

or

$$\text{Mass emitted (kg)} = 1.46\text{E+}02 \times V_{\text{GAS}}$$

where:

V_{OIL} = Volume of oil combusted in device connected to SCR (in m³)

V_{GAS} = Volume of gas combusted in device connected to SCR (in million m³)

Reference: [31], Section 5.4, Table 5-5.

12.2. REFRIGERATION SYSTEMS

Ammonia may be used as a refrigerant in refinery thermal exchange equipment.

Emissions are assumed to equal the amount used during the reporting period to top-up systems to replenish losses due to uncontrolled leakage.

$$\text{Mass emitted (kg)} = \text{Mass used to top-up refrigerant systems (in kg)}$$

Usage where the systems have been fully or partially drained and refrigerants collected for recycling or destruction should not be reported.

12.3. CATALYTIC CRACKING UNIT REGENERATORS

NH₃ is produced during the regeneration process and depends upon its severity. Emissions from partial burn regeneration are normally controlled by a CO boiler.

12.3.1. Full Burn Regeneration

Emissions are deemed to be negligible

Reference: [32], Section 9.3.4.

12.3.2. Partial Burn with CO Boiler

Emissions are deemed to be negligible

Reference: [32], Section 9.3.4.

12.3.3. Partial Burn without CO Boiler

If there is no CO boiler in operation:

Mass emitted (kg) = 1.55E-01 × Volume of fresh feed to unit (in m³)

Reference: [31], Section 4, Table 4.1.

13. NON-METHANE VOLATILE ORGANIC COMPOUNDS (NMVOC)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators and flares
- Catalytic cracking unit regenerators
- Fluid cokers
- Components under pressure e.g. pumps and valves (“fugitives”)
- Process drains
- Oil-water separators
- Loading of mobile containers (rail-cars, road tankers, ships and barges)
- Storage tanks
- Venting to atmosphere of uncontrolled blowdown systems
- Uncontrolled bitumen blowing

The driver for reporting VOC emissions is photochemical production of ozone. Methane has a negligible photochemical reactivity. In Europe this compound is therefore excluded from the “basket” of reactive VOCs which are collectively referred to as non-methane volatile organic compounds (NMVOC). The US EPA also considers ethane to have a significantly low reactivity. A number of emission factors developed by the EPA, therefore, are for non-(methane and ethane) VOCs. Those NMVOC emission factors provided in this section which exclude ethane emissions are identified.

13.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 5**.

Table 5 NMVOC Emission Factors for Combustion Sources

SOURCE	FUEL	EF_{NCV} g/GJ	REF
Boilers and Furnaces < 10 MW (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	1.10E+00	[21] Section 1.3, Table 1.3-3
	Refinery Fuel Oil	3.41E+00	[21] Section 1.3, Table 1.3-3
	LPG ¹	3.96E+00	[21] Section 1.5, Table 1.5-1
	Natural Gas ²	2.58E+00	[21] Section 1.4, Table 1.4-2

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces 10 MW to 100 MW	Distillate (gas oil)	6.47E-01	[21] Section 1.3, Table 1.3-3
	Refinery Fuel Oil	8.45E-01	[21] Section 1.3, Table 1.3-3
	LPG ¹	3.96E+00	[21] Section 1.5, Table 1.5-1
	Natural Gas ²	2.58E+00	[21] Section 1.4, Table 1.4-2
Boilers and Furnaces > 100 MW	Distillate (gas oil)	2.46E+00	[21] Section 1.3, Table 1.3-3
	Refinery Fuel Oil	2.29E+00	[21] Section 1.3, Table 1.3-3
	LPG ²	2.27E+00	[23] SCC 10101002
	Natural Gas ²	2.58E+00	[21] Section 1.4, Table 1.4-2
Gas Turbine	Distillate (gas oil) ^{2,3,4}	1.86E-01	[24] Section 3.1, Table 3.1-2a
	Natural Gas	1.60E+00	[5] Section 1.A.1, Table 3-17
Gas Engine ² 4-stroke, Lean Burn	Natural Gas	5.64E+01	[24] Section 3.2, Table 3.2-2
Diesel Engine ⁵ Large, Stationary	Diesel Fuel	3.71E+01	[24] Section 3.4, Table 3.4-1
Incinerator Support Fuel or Flare Pilot Fuel	LPG ¹	3.96E+00	[21] Section 1.5, Table 1.5-1
	Natural Gas ²	2.58E+00	[21] Section 1.4, Table 1.4-2

Notes:

1. Factor is for propane combustion. Derived by subtracting the emissions factor for methane from that for total organic compounds.
2. Factor excludes ethane emissions.
3. Factor derived from turbines operating at high (≥ 80%) loads
4. Factor provided in reference [24] was derived using HHV of 139 MBtu/10³ US gal.
5. Based on data from one engine with exhaust gas TOC composition by weight of 91% NMVOCs.

13.1.1. Other Fuels

In the absence of specific emission factors for other gaseous fuels (e.g. refinery fuel gas, low joule gas) it is recommended to use the value of EF_{NCV} for natural gas from Table 5.

13.2. DESTRUCTION OF GASEOUS STREAMS

13.2.1. Flares

The following algorithms are for emissions from the combustion of the flare gas. For emissions from the combustion of the pilot gas fuel used to initiate flare combustion, use the algorithm in **Section 13.1**.

13.2.1.1. Flare Stream Details Known

If the mass and composition of the flare stream are known:

$$\text{Mass emitted (kg)} = 5.00\text{E-}00 \times M \times \text{MF}_{\text{NMVOC}}$$

where:

M = total mass of gas flared (in tonnes)

MF_{NMVOC} = mass fraction of NMVOC in gas flared

This algorithm assumes that 0.5% of the hydrocarbons remain unburned in “well designed and operated flares, such as in refineries”.

Reference: [19], Section 4.6.

13.2.1.2. Flare Stream Details Unknown

If the mass and composition are not known and a flare gas recovery system is not installed, a conservative factor based on refinery feed can be used:

$$\text{Mass emitted (kg)} = 2.00\text{E-}03 \times \text{Refinery Feed (in m}^3\text{)}$$

This factor is for total unburned hydrocarbons. Comparison with the emission factor for methane (**Section 7.2.1.2**) indicates that methane is assumed to constitute about 1% by mass of the total unburned hydrocarbons.

Reference: [26], Activity 090203, Section 8, Table 2.

If a flare gas recovery system is installed it can be considered to be an emissions control device. The equation in **Section 6.1** can be used (with EFF = flare gas recovery system efficiency) to adjust the emissions estimate obtained from the algorithm above.

13.2.2. Incinerators

For all incinerator gas streams, use the algorithm in **Section 13.1** with an emission factor EF_{NCV} equal to that for natural gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 13.1**.

13.3. CATALYTIC CRACKING UNIT REGENERATORS

NMVOCs are produced during the regeneration process. Emissions from units operating with partial burn regeneration are normally controlled with a CO boiler.

13.3.1. Full Burn Regeneration

Emissions are deemed to be negligible

13.3.2. Partial Burn with CO Boiler

Emissions are deemed to be negligible

Reference: [6], Table 5.1-1.

13.3.3. Partial Burn without CO Boiler

If there is no CO boiler in operation:

Mass emitted (kg) = 6.30E-01 × Volume of fresh feed to unit (in m³)

This factor is for total hydrocarbons (THC). Reference [6] states that, overall, less than 1% by mass of THC emissions is methane.

Reference: [6], Table 5.1-1.

13.4. FLUID COKERS

If the off-gas is not fed to a CO boiler, or it is not in operation:

Mass emitted (kg) = 4.60E-02 × Feed to unit (in m³)

Reference: [25], Section 4.2.1, Table 8.

13.5. FUGITIVE EMISSIONS FROM PRESSURISED COMPONENTS

Emissions can occur due to leakage past seals on components installed in pressurised pipework or process plant e.g. valves, pumps, flanges, etc.

Emission estimates can be made by:

- Measuring the VOC concentration adjacent to potential leak points and estimating the emission flux using correlation equations or emission factors.
- Detecting leaks using optical gas imaging.
- Using average emission factors for individual types of components and their process service, where the number of components is known.
- Using a conservative overall emission factor based on refinery throughput.

Note that this section does not deal with emissions from low pressure equipment such as drains, oil-water separators, loading systems and product storage tanks. Emission estimation methodologies for these sources are provided separately – see **Sections 13.6, 13.8 and 13.9.**

13.5.1. Leak Detection Surveys Undertaken

Leaking components can be identified either using a conventional hydrocarbon monitor to measure the VOC concentration adjacent to potential leak points or an optical gas imaging (OGI) camera can be used to visualise gas leaks remotely..

This report does not provide details of the measurement methods. A Concaawe Report [33] provides a comparative review of conventional and OGI techniques for leak detection.

13.5.1.1. Conventional Hydrocarbon Monitor

This method requires the “screening” of leak sources by measuring the concentration of VOCs at the surface of each potential source using a conventional hydrocarbon monitor. The local VOC concentration (“screening value”) at the surface of a leak source is converted into an emission flux using a correlation equation or emission factors.

Details of the methodologies and the calculation of emissions are provided by the US EPA [34] and in the European CEN Standard on fugitive emission estimation [35].

13.5.1.2. Optical Gas Imaging Camera

In this method emissions are estimated using a “leak” / “no-leak” criterion where the emission factor used depends on the “leak” detection sensitivity of the camera. The emission factors for each equipment type for specified camera detection limits are provided in **Table 6**.

The emissions can be calculated for each equipment type and service using:

$$\text{Mass emitted (kg)} = [(F_{\text{LEAK}} \times N_{\text{LEAK}}) + (F_{\text{NO-LEAK}} \times N_{\text{NO-LEAK}})] \times \text{TIME}$$

where:

F_{LEAK} = Emission factor for leaking components according to the detection limit of the camera

N_{LEAK} = Number of components identified as leaking

$F_{\text{NO-LEAK}}$ = Emission factor for non-leaking components according to the detection limit of the camera

$N_{\text{NO-LEAK}}$ = Number of components identified as not leaking

TIME = Time that the equipment is in operation and pressurised (in hours).

Details of the methodology and the calculation of emissions are provided in Concaawe Report 6/08 [33] and in reference [36].

Table 6 Leak/No-Leak Emission Factors where optical gas imaging (OGI) is used to detect leaks

Equipment Type	Factor Type	Emission Factor for Specified OGI Leak Definition for different camera sensitivity settings kg/hr/source			
		3 g/hr	6 g/hr	30 g/hr	60 g/hr
Valves	Leak	5.50E-02	7.30E-02	1.40E-01	2.00E-01
	No-Leak	1.90E-05	4.30E-05	1.70E-04	2.70E-04
Pumps	Leak	1.40E-01	1.60E-01	3.10E-01	3.50E-01
	No-Leak	9.60E-05	1.30E-04	5.90E-04	7.50E-04
Flanges	Leak	2.90E-02	4.50E-02	8.80E-02	1.20E-01
	No-Leak	2.60E-06	4.10E-06	1.00E-05	1.40E-05
All other components	Leak	5.60E-02	7.50E-02	1.50E-01	2.10E-01
	No-Leak	7.00E-06	1.40E-05	5.10E-05	8.10E-05

Reference: [36]

Definitions of “Service”

Reference [35] provides the following definitions for “service”:

- Gas service: equipment which in use contains process fluid that is in the gaseous state at operating conditions.
- Light liquid service: equipment which in use contains hydrocarbon streams of which at least 20% wt has a vapour pressure in excess of 0.3 kPa at 20°C. For example, this includes automotive and aviation gasolines and crude oil. It excludes products such as kerosenes and gasoils.

13.5.2. Leak Detection Surveys Not Undertaken

13.5.2.1. Component Data Available

Where no monitoring (or only a partial survey) has been undertaken, the emissions from un-surveyed equipment can be calculated using:

$$\text{Mass emitted (kg)} = F_{\text{COMP}} \times N \times \text{TIME}$$

where:

F_{COMP} = Average emission factor for the particular equipment type as in **Table 7**.

N = Number of pieces of equipment grouped in the relevant category according to the equipment type, service and operation.

TIME = Time that the equipment group is in operation and pressurised (in hours).

This algorithm is conservatively high as it assumes that the product contained within the equipment components wholly comprises NMVOCs i.e. it does not account for non-NMVOC components contained within the fugitive emission. However, the non-NMVOC emissions will mainly be methane e.g. from fuel gas, and this has the lowest

density of the hydrocarbons emitted. For fuel gas systems this can be compensated for; see **Section 7.3** for methane emission estimation. Moreover, the number of equipment components in pipelines containing low concentration NMVOC streams (e.g. low joule gas) is generally a very small percentage of the total components on a refinery.

Table 7 Average Emission Factors for Components

Equipment Type	Service	Emission Factor kg/hr/source
Valves	Gas	2.68E-02
	Light Liquid	1.09E-02
Pump seals	Light Liquid	1.14E-01
Compressor seals	Gas	6.36E-01
Pressure relief valves	Gas	1.60E-01
Flanges and non-flanged connectors	All	2.50E-04
Open-ended lines	All	2.30E-03
Sampling connections	All	1.50E-02

Reference: [35]

Component counts

The count can be based on up-to-date piping and instrumentation diagrams, equipment lists, operating manuals or physical component counts. The count should include spare components if these are filled with process fluid and are pressurised.

If actual counts are not available, an extrapolation can be made from published information. Reference [37] cites an example of a US refinery of 52 500 m³/day capacity having 11 500 valves, 46 500 flanges, 350 pump seals, 70 compressor seals and 100 relief valves.

Alternatively, reference [32], Section 3.4.1, Table 3-1, provides the following “average” refinery data:

Emission Source Component	Gas	Liquid
Valves per pump or compressor	133	41
Flanges per valve	4.1	4.1
Mixer seals per mixer	-	1
Pump seals per pump	-	1.35
Compressor seals per compressor	2	-

13.5.2.2. No Component Data Available

A conservative emission factor can be used if no data on components are available:

$$\text{Mass emitted (kg)} = 2.00\text{E-}01 \times \text{Refinery feed (in tonnes)}$$

Reference: [5], Chapter 1.B.2.a.iv, Table 3-6.

13.6. OILY-WATER COLLECTION AND TREATMENT SYSTEMS

Contaminated waste water systems principally comprise process drains and a water treatment facility, such as a gravity separator. The emissions from oily-water systems vary significantly with time, depending, for example, on the amount and volatility of the entrained oil, waste water temperature, flow, etc.

Emissions can be estimated for the entire system using complex models available as software packages (see **Section 13.6.1**).

Alternatively, the emissions from the process drains and the separator systems can be estimated separately (see **Sections 13.6.2** and **13.6.3**).

13.6.1. Emission Estimation Models For Entire System

There are a number of complex estimation models available to calculate emissions from waste water systems. They aim to estimate average emission rates of individual species for each of the system components, collectively permitting the determination of the overall emissions from a refinery wastewater collection and treatment system.

The US EPA has developed a freely available computer program model called WATER9 [38]. This is Windows based and consists of analytical expressions for estimating air emissions of individual waste constituents in waste water collection, storage, treatment, and disposal facilities. Reference [39] provides the mathematical equations used in this model.

It should be noted that the input data demands of the model are large and require considerable sampling and analyses to be undertaken. However, it is likely that the increased level of characterisation of the hydrocarbons present in the refinery's waste water will lead to more accurate estimation of emissions than the more simple emission factor approach.

13.6.2. Process Drains

The following algorithm provides an estimate for emissions from the entire refinery process drain system in oily-water service. Note that drain systems on clean water (with minimal potential for contact with oil) and storm water are excluded.

Process drains and junction boxes are normally fitted with an emission control device such as a water seal or sealed cover. An assessment needs to be made to establish how many of the drain covers are unsealed and vent directly to atmosphere.

$$\text{Mass emitted (kg)} = 3.20\text{E-}02 \times N \times \text{TIME}$$

where:

N = number of unsealed drain openings in the refinery process drain system.

TIME = period of emission estimate in hours (for E-PRTR annual reports = 8760)

This factor excludes ethane emissions.

Reference: [32], Section 7.5, Table 7-3.

13.6.3. Oil-Water Separators

Emissions from separators can be determined using simple emission factors which are known to give conservatively high estimates. Alternatively, an algorithm can be used for uncovered gravity separators which requires, as a minimum, data on separator inlet flow and entrained oil concentration. Sampling and analysis thus have to be undertaken and due to the temporal variability of the input parameters the estimation accuracy will depend on the frequency of testing. A decision tree for supporting the selection of the methodology used by refineries in their estimation of annual VOC emissions from uncovered primary oil-water separator systems based on the results of the field campaigns reported in reference [40] is provided in **Figure 1**.

13.6.3.1. Gravity Separator - where separator inlet monitoring data available

An estimate for the emissions from uncovered API type separators is provided by:

$$\text{Mass emitted (kg)} = 1.00\text{E-}04 \times D \times V \times (5.74 \times T_{\text{AMB}} - 5.15 \times T_{\text{DP}} + 38.6 \times T_{\text{WW}} + 33.6) \times \text{TIME}$$

where:

D = liquid density of evaporated hydrocarbons (kg/m³). If unknown, [40] provides a default average value of 745 kg/m³

V = flow rate of hydrocarbons entering the separator (m³/h). Calculated from data on waste water flow and concentration of hydrocarbons in the waste water.

T_{AMB} = ambient water temperature (°C)

T_{DP} = 10% distillation point (°C). If unknown, [42] provides a default average value of 150°C

T_{WW} = Waste water temperature (°C)

TIME = period of emission estimate in hours (for E-PRTR annual reports = 8760)

Reference: [41], developed in reference [42], Section 5.2.

Where a cover is fitted to a gravity separator, the emissions abatement efficiency can be assumed to be 97% [32].

13.6.3.2. Simple Algorithms

a) *Where the quantity of water treated is unknown*

$$\text{Mass emitted (kg)} = 2.00\text{E-}02 \times A \times \text{TIME}$$

where:

A = exposed water area of separator (m²)

TIME = period of emission estimate in hours (for E-PRTR annual reports = 8760)

b) Where the quantity of water treated is known

Mass emitted (kg) = EF_{SEP} × VOL_{WATER}

where:

EF_{SEP} = Emission factor for the type of separator given in **Table 8**.

VOL_{WATER} = Volume of waste water treated by the separator (in m³).

Table 8 Emission Factors for Oil-Water Separators

SEPARATOR TYPE	EMISSION FACTOR (EF _{SEP}) ¹ kg/m ³ waste water treated
Gravity type – uncovered	
Oil in water concentration <880 mg/l	2.25E-02
Oil in water concentration 880 - 3500 mg/l	1.11E-01
Oil in water concentration >3500 mg/l	6.00E-01
Gravity type – covered ²	
Oil in water concentration <880 mg/l	6.75E-04
Oil in water concentration 880 - 3500 mg/l	3.30E-03
Oil in water concentration >3500 mg/l	1.80E-02
Gravity type – covered and connected to flare	0
DAF ³ or IAF ⁴ – uncovered ⁵	4.00E-03
DAF or IAF – covered ⁵	1.20E-04
DAF or IAF – covered and connected to flare	0

Notes:

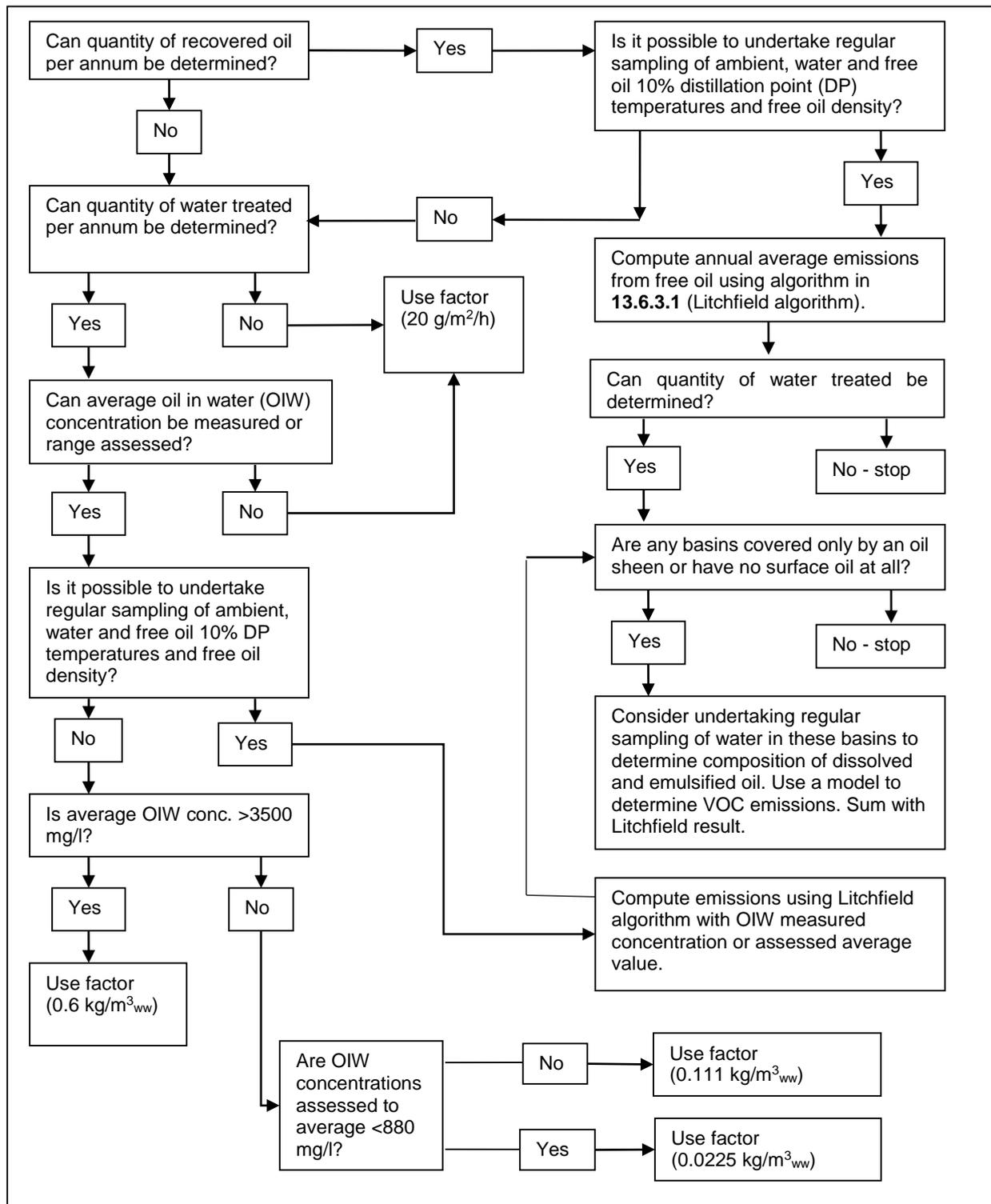
1. These factors exclude ethane emissions
2. Where the complete system has a tightly sealed cover installed with an assumed vapour retention efficiency of 97%. For other types of cover an efficiency of 90% can be assumed. For partly covered systems guidance is provided in reference [40].
3. DAF = Dissolved air floatation type
4. IAF = Induced air floatation type
5. The emission factors for these types of separator apply where they are installed as secondary treatment systems.

Reference: [40], Section 6.5

Emissions from basins and ponds that handle clean water or storm water are considered negligible.

For ponds temporarily storing oily-water, use the emission factor for an uncovered, gravity type separator from **Table 8**.

Figure 1 Decision tree for guidance in determining emissions from uncovered systems



13.7. COOLING WATER TOWERS

Emissions from cooling water towers are considered negligible as sound refinery engineering practice ensures that oil is prevented from entering these systems.

Guidance on estimating emissions if a heat exchanger oil leak has occurred and monitoring data are unavailable is provided in reference [32], Section 7.9.5.

13.8. LOADING OF MOBILE CONTAINERS

Emissions from the loading of mobile containers (i.e. road tankers, rail tank cars, barges and marine tankers) depend upon the type of container being loaded and the degree of saturation of the vapour in the cargo tank. For example, uncontrolled emissions from road tankers depend upon the mode of loading (i.e. top loading with a drop pipe through an open hatch or bottom loading through pipework connected on the tanker) and if the tanker delivers product to a facility with a “vapour balancing” system installed. In this type of system, the vapours displaced from the storage tank being filled by the tanker are fed back into the tanker compartment to “balance” the off-loaded product. The tanker thus returns to the loading facility with the compartments filled with vapour.

Emissions from loading can be controlled with a vapour recovery unit (VRU) or thermal oxidiser. Algorithms for VRUs are given below. Emissions from thermal oxidisers can be calculated using the algorithms listed in this report for incinerators.

13.8.1. Uncontrolled Emissions

$$\text{Mass emitted (kg)} = EF_{\text{LOAD}} \times VOL_{\text{LOAD}} \times TVP$$

where:

EF_{LOAD} = Emission Factor from **Table 9**, depending on loading mode.

VOL_{LOAD} = Volume of product loaded (in m³).

TVP = True Vapour Pressure of product at loading temperature (in kPa).

Reference: [7], Section 2.

For gasolines, TVP can be calculated from:

$$TVP = RVP \times 10^{[(7.047E-06 \times RVP + 1.392E-02) \times TEMP + (2.311E-04 \times RVP - 5.236E-01)]}$$

where:

RVP = Reid Vapour Pressure (in kPa)

TEMP = product loading temperature (in degrees Centigrade)

Reference: [7], Annex 1.

Table 9 NMVOC Emission Factors for Loading of Mobile Containers

LOADING MODE	EMISSION FACTOR EF _{LOAD} kg/m ³ /kPa
Road Tanker, Bottom Loading No Vapour Balancing during Previous Off-Loading	8.60E-03
Road Tanker, Top Loading No Vapour Balancing during Previous Off-Loading	9.40E-03
Road Tanker, Bottom or Top Loading Vapour Balancing during Previous Off-Loading	2.28E-02
Rail Tanker, Top Loading	1.08E-02
Rail Tanker, Bottom Loading ¹	1.05E-02
Marine tanker - typical cargo tank condition ²	3.91E-03
Barge - typical cargo tank condition ²	7.45E-03

Notes:

1. During the top loading of rail tankers emissions occur from the open loading hatch both before and after loading [7]. As there is no open hatch during bottom loading of a rail tanker, this factor assumes no pre- or post-loading emissions.
2. These factors are for typical cargo tank vapour conditions. For other situations (e.g. tank gas freed or ballasted, previous cargo non-volatile, etc.) specific emission factors are provided in reference [6], Table 5.2-2 for the loading of gasoline with a TVP of 55 kPa. These factors should be pro-rated for the value of the TVP of the product loaded.

13.8.2. Emissions Controlled with a Vapour Recovery Unit (VRU)

VRUs may be fitted with a continuous emissions monitor (CEM) or the recovery efficiency may be known from tests.

13.8.2.1. VRU Fitted with a CEM

$$\text{Mass emitted (kg)} = 1.00\text{E-}03 \times \text{MEAS}_{\text{CONC}} \times \text{VOL}_{\text{LOAD}} \times (1 - \text{TVP} / 100)$$

where:

MEAS_{CONC} = Measured VRU vent concentration (in g/m³)

VOL_{LOAD} = Volume of product loaded (in m³)

TVP = True Vapour Pressure of product at loading temperature (in kPa)

Reference: [7], Section 2.2.

13.8.2.2. VRU Efficiency Known

Emissions should be calculated using the algorithm in **Section 6.1**.

13.9. STORAGE TANKS

Emissions from storage tanks comprise two components:

- Working loss; emissions due to the tank being filled (displacing vapours above the product stored) or emptied (evaporation of product “clingage” on tank internal walls)

- Standing losses: emissions due to the expansion of the vapour space in fixed roof tanks due to vapour temperature or pressure changes and leakage past equipment (e.g. seals, still wells, etc.) fitted to floating roofs.

13.9.1. Floating Roof Tanks

Floating roof tanks can be of the following types:

- External floating roof (EFR)
- EFR fitted with domed cover
- Internal floating roof (IFR)
 - fitted with open vents in the fixed roof
 - fitted with vents in the fixed roof which can be closed e.g. pressure/vacuum valves, connected to a vapour recovery unit, etc.

For all of these tank types except IFR tanks which are not freely vented, use the latest edition of reference [43]. For IFR tanks fitted with vents which can be closed, guidance is provided in reference [44] which shows that emissions from closed-vent internal floating roof tanks are approximately 5% less than emissions from internal floating roof tanks with open vents determined in accordance with [43].

Methodologies to estimate the emissions when the roof has landed on its legs and is no longer floating on the product are provided in reference [45].

13.9.2. Vertical Fixed Roof Tanks (VFRT)

For these tanks in normal service, use the latest edition of reference [46].

13.9.2.1. VFRTs Connected to a Vapour Holding Tank (VHT)

A vapour holding tank comprises a fixed roof tank containing a flexible diaphragm. Where connected to a storage tank, a correctly sized VHT stores any emissions from the tank due to the rise in vapour temperature during the day, and then releases these vapours back to the tank as it cools at night. The VHT, therefore, controls the “standing losses”.

Emissions, therefore, can be assumed to equal only the “working losses”.

13.9.3. Aboveground Horizontal Tanks

For these tanks, use the latest edition of reference [47], Section 7.1.3.1.

13.9.4. Underground Tanks

Use the algorithms for service station storage tanks provided in **Appendix 4.2**.

13.9.5. Tank Cleaning

Guidance on the estimation of evaporative emissions during tank cleaning is provided in reference [48].

13.9.6. Storage Tanks - General Comments

Reference [47] normally contains the latest versions of references [43], [45] and [46]. Emission calculation software utilising the algorithms in reference [47] is available

from the US EPA via their website, <http://www.epa.gov>, but this software is now outdated and is not reliably functional on computers using modern operating systems.

It should be noted that some options are provided in the algorithms in references [43] to [47] to cover the state of equipment; e.g. degrees of rust on tank internal shells, tightness of floating roof seals, etc. Users of the algorithms, therefore, must ensure that the factors utilised to derive emissions for a particular tank are appropriate. In particular, the API states that the algorithms are only 'applicable to properly maintained equipment under normal working conditions'

13.10. UNCONTROLLED BLOWDOWN SYSTEMS

The gaseous emissions from blowdown systems in EU refineries are recovered and/or flared.

If these controls are not operational and all of the emissions are released to atmosphere, the total hydrocarbons emissions can be conservatively estimated using the factor provided in reference [6], Table 5.1-1.

13.11. UNCONTROLLED BITUMEN BLOWING

The gaseous emissions from bitumen blowing in EU refineries are controlled, for example using scrubbers and incinerators.

Where these controls are not operational and all of the emissions are emitted to atmosphere, the emissions can be estimated using the factor in reference [26], Activities 040101 & 040102, Section 8.2.1, Table 8.2.

14. NITROGEN OXIDES (NO_x)

Estimation methods are provided for emissions of NO_x from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators and flares
- Catalytic cracking unit regenerators

14.1. COMBUSTION IN BOILERS AND FURNACES

NO_x emissions from combustion comprise two components:

- Thermal NO_x; this is the thermal fixation of molecular nitrogen and is generally a function of flame temperature, residence time and oxygen concentration in the flame zone
- Fuel NO_x; this is the result of the direct oxidation of the nitrogen in liquid fuels or the non-inert nitrogen containing species in gaseous fuels.

The following methodology is outlined in more detail, with an example, in reference [49].

Total NO_x Emissions = Thermal NO_x + Fuel NO_x

Thermal NO_x

Thermal NO_x Mass emitted (kg) = 1.00E-03 × TNF × M × HHV

where:

TNF = Thermal NO_x factor (in g/GJ)

M = Mass of fuel combusted (in tonnes)

HHV = Higher heating value of the fuel combusted (in MJ/kg)

For liquid fuels

$$\text{HHV} = 1.05 \times \text{NCV}$$

For gaseous fuels

$$\text{HHV} = 1.11 \times \text{NCV}$$

where NCV = Net calorific value (in MJ/kg)

TNF = F_{BASE} × F_{H2} × F_{CONTROL} × F_{PREHEAT} × F_{H2O} × F_{LOAD} × F_{BURN}

F_{BASE} is the base fuel factor. This accounts for differences in flame temperature due to fuel composition and is therefore dependent on the type of fuel burnt. Values for different fuels are given in **Table 10**.

Table 10 Values for F_{BASE}

FUEL	F _{BASE} (g/GJ) (HHV)
Methane, Natural Gas, LPG	56
Refinery Fuel Gas	69
Low Joule Gas	30
Refinery Fuel Oil, Distillates	56

F_{H_2} is the adjustment factor for the amount of hydrogen gas in the fuel.

For all liquid fuels, methane, natural gas and LPG: $F_{H_2} = 1.0$

For other refinery gaseous fuels, values for F_{H_2} are given for some hydrogen concentrations in **Table 11**. These can be used to extrapolate for other compositions.

Table 11 Values for F_{H_2}

FUEL	H ₂ CONCENTRATION % v/v	F _{H₂}
Refinery Fuel Gas	0 - 23	1.00
	33	1.04
	43	1.09
	63	1.25
	83	1.46
Low Joule Gas	0 - 14.7	1.00
	24.7	1.04
	34.7	1.09
	54.7	1.25
	74.7	1.46

$F_{CONTROL}$ is the adjustment factor for at-the-source control technologies, including burner type. Values are given in **Table 12**.

Table 12 Values for $F_{CONTROL}$

CONTROL TECHNOLOGY	F _{CONTROL}	
None	1.00	
Low NOx burner, staged fuel	0.33	
Low NOx burner, staged air	0.60	
Ultra-low NOx burner	0.30	
Flue Gas Recirculation	0%	1.00
	5%	0.60
	10%	0.40
	15%	0.30
	20%	0.20

$F_{PREHEAT}$ is the adjustment factor for the average air preheat temperature. Values are given in **Table 13**.

Table 13 Values of $F_{PREHEAT}$

AIR PREHEAT TEMPERATURE Degrees C	$F_{PREHEAT}$
< 38	1.00
38	1.00
93	1.10
149	1.32
204	1.60
260	1.86

F_{H_2O} is the adjustment factor for the moisture content of the combustion air. Values are given in **Table 14**.

Table 14 Values of F_{H_2O}

MOISTURE CONTENT kg H ₂ O / kg dry air	F_{H_2O}
0	1.00
0.01	0.79
0.02	0.67
0.03	0.53
0.04	0.41
0.05	0.29

F_{LOAD} is the adjustment factor for the loading of the combustion unit. For dual fuel firing, the load is calculated using the total thermal input. Values are given in **Table 15**.

Table 15 Values of F_{LOAD}

LOAD (% of design)	F_{LOAD}
40	0.55
60	0.70
80	0.85
100	1.00

F_{BURN} is the adjustment factor for the burner intensity, a measure of the heat release per volume of burner space. There is no precise measure for burner intensity. Where no combustion unit information on intensity is available, in general high intensity burners are used for packaged boilers and pyrolysis furnaces and low intensity burners are used for all other fired heaters and boilers. Where furnace (radiant cell) volume is known, then the classification can be ascertained from:

- High intensity is > 700 KW/m³
- Low intensity is < 30 kW/m³

Values for F_{BURN} are given in **Table 16**.

Table 16 Values for F_{BURN}

BURNER INTENSITY	F_{BURN}
High	1.8
Low	1.0

Fuel NOx

Fuel NOx Mass emitted (kg) = $1.00E-03 \times FNF \times M \times HHV$

where:

FNF = Fuel NOx factor (in g/GJ)

M = Mass of fuel combusted (in tonnes)

HHV = Higher Heating Value of the fuel combusted (in MJ/kg)

$FNF = (1.00E+04 \times MP_{NITROGEN} \times CFN_{MW} \times F_{N2CONTENT}) / HHV$

where:

$MP_{NITROGEN}$ = Mass Percentage of Nitrogen in the fuel combusted

CFN_{MW} = Molecular weight conversion from N to NO₂ = 46 / 14 = 3.286

$F_{N2CONTENT}$ = Adjustment factor for nitrogen content. Values are given in **Table 17**.

Table 17 Values for $F_{N2CONTENT}$

FUEL NITROGEN % m/m	$F_{N2CONTENT}$	
	Uncontrolled Burner	Low-NOx burner with staged air
< 0.05	1.00	1.00
0.05	0.87	0.86
0.1	0.78	0.75
0.3	0.53	0.43
0.5	0.38	0.30
1.0	0.32	0.25 ¹

Notes:

1. Reference: [50] - value corrected from that published in reference [49].

Combining the above equations:

$$\text{Fuel NOx Mass emitted (kg)} = 32.86 \times \text{MP}_{\text{NITROGEN}} \times \text{F}_{\text{N2CONTENT}} \times \text{M}$$

where:

$\text{MP}_{\text{NITROGEN}}$ = Mass Percentage of Nitrogen in the fuel combusted (see note below).

$\text{F}_{\text{N2CONTENT}}$ = Adjustment factor for nitrogen content. Values are given in **Table 17**.

M = Mass of fuel combusted (in tonnes)

Note: the mass percentage of nitrogen in gaseous fuels only relates to the nitrogen bound in the combustible components in the fuel (e.g. ammonia) and does not apply to molecular nitrogen (N_2) where present as a gaseous fuel component.

Reference: [49].

14.2. GAS TURBINES

14.2.1. Natural Gas Combustion

$$\text{Mass emitted (kg)} = 1.53\text{E-}01 \times \text{M} \times \text{NCV}$$

where:

M = mass of fuel gas burnt (in tonnes)

NCV = net calorific value of the fuel burnt (in MJ/kg)

Reference: [24], Table 3.1-1. Factor derived from turbines operating at high loads ($\geq 80\%$).

14.2.2. Distillate Oil Combustion

$$\text{Mass emitted (kg)} = 3.98\text{E-}01 \times \text{M} \times \text{NCV}$$

where:

M = mass of distillate oil burnt (in tonnes)

NCV = net calorific value of the fuel burnt (in MJ/kg)

Reference: [24], Table 3.1-1. Factor derived from turbines operating at high loads ($\geq 80\%$).

14.3. GAS ENGINES (4 STROKE, LEAN BURN)

$$\text{Mass emitted (kg)} = 4.05\text{E-}01 \times \text{M} \times \text{NCV}$$

where:

M = mass of fuel gas burnt (in tonnes)

NCV = net calorific value of the fuel burnt (in MJ/kg)

Reference: [24], Table 3.2-2. Factor derived from engines operating at $< 90\%$ load.

14.4. DIESEL ENGINES (LARGE, STATIONARY)

$$\text{Mass emitted (kg)} = 1.45\text{E+}00 \times \text{M} \times \text{NCV}$$

where:

M = mass of diesel fuel burnt (in tonnes)

NCV = net calorific value of the fuel burnt (in MJ/kg)

Reference: [24], Table 3.4-1.

14.5. COMBUSTION OF AUXILIARY AND PILOT FUELS

Auxiliary fuels are used to support combustion in, for example, CO boilers and incinerators. Pilots are used to initiate combustion in flares.

$$\text{Mass emitted (kg)} = 6.22\text{E-}02 \times M \times \text{NCV}$$

where:

M = mass of auxiliary/pilot fuel burnt (in tonnes)

NCV = net calorific value of the fuel burnt (in MJ/kg)

This assumes emissions are equivalent to burning natural gas with dry combustion air in an uncontrolled furnace – see **Section 14.1**.

Reference: [49].

14.6. DESTRUCTION OF GASEOUS STREAMS

14.6.1. Flares

The following algorithms are for emissions from the combustion of the flare gas. For emissions from the combustion of the pilot gas fuel used to initiate flare combustion, use the algorithm in **Section 14.5**.

14.6.1.1. Flare Stream Details Known

If the mass and composition of the flare stream are known:

$$\text{Mass emitted (kg)} = 3.22\text{E-}02 \times M \times \text{NCV}$$

where:

M = mass of flare gas burnt (in tonnes)

NCV = net calorific value of the flare gas burnt (in MJ/kg)

Reference: [25], Section 4.2.1, Table 8.

14.6.1.2. Flare Stream Details Unknown

If the mass and composition are not known and a flare gas recovery system is not installed, a conservative factor based on refinery feed can be used:

$$\text{Mass emitted (kg)} = 5.40\text{E-}02 \times \text{Refinery Feed (in m}^3\text{)}$$

Reference: [26], Activity 090203, Section 8, Table 2.

If a flare gas recovery system is installed it can be considered to be an emissions control device. The equation in **Section 6.1** can be used (with EFF = flare gas

recovery system efficiency) to adjust the emissions estimate obtained from the algorithm above.

14.6.2. Incinerators

For all incinerator streams use the algorithms in **Section 14.1**, assuming that the 'fuel' is low joule gas and that F_{CONTROL} , F_{PREHEAT} , F_{LOAD} and F_{BURN} all have a value of 1.0.

For emissions from the combustion of the auxiliary gas fuel used to support incinerator combustion, use the algorithm in **Section 14.5**.

14.7. CATALYTIC CRACKING UNIT REGENERATORS

For CCU regenerators, both with and without CO boilers:

Mass emitted (kg) = 2.04E-01 × Volume of fresh feed to unit (in m³)

Reference: [6], Section 5.1, Table 5.1-1.

15. SULPHUR HEXAFLUORIDE (SF₆)

Emissions of sulphur hexafluoride (SF₆) may occur due to its use as a tracer gas or from leaks from high voltage electrical equipment where this gas is used as an insulator.

Emissions are assumed to equal the amount used and not recovered during test procedures and/or the mass used to top-up or refill equipment.

Mass emitted (kg) = Mass used (in kg)

16. OXIDES OF SULPHUR (SO_x)

The E-PRTR requires estimates of the total oxides of sulphur (SO₂ and SO₃) reported as SO₂.

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators and flares
- Catalytic cracking unit regenerators
- Catalytic reforming units

16.1. COMBUSTION

For all fuel combustion, the following algorithm applies:

$$\text{Mass emitted (kg)} = 1000 \times M \times MF_S \times SF_{MW}$$

where:

M = mass of fuel burnt (in tonnes)

MF_S = mass fraction of sulphur in fuel

SF_{MW} = Molecular weight conversion from S to SO₂ = 64/32

This assumes that all the sulphur in the fuel is converted to SO₂.

For refinery oil and gaseous fuels:

$$\text{Mass emitted (kg)} = 2.00E+03 \times M \times MF_S$$

Reference: [25], Section 4.1.1.1.

16.2. DESTRUCTION OF GASEOUS STREAMS

16.2.1. Flares

The following algorithms are for emissions from the combustion of the flare gas. For emissions from the combustion of the pilot gas fuel used to initiate flare combustion, use the algorithm in **Section 16.1**.

16.2.1.1. Flare Stream Details Known

If the mass and composition of the flare stream are known, use algorithm in **Section 16.1**, where:

M = mass of flare gas burnt (in tonnes)

MF_S = mass fraction of sulphur in flare gas

16.2.1.2. Flare Stream Details Unknown

If the mass and composition are not known, a conservative factor based on refinery feed can be used. This assumes that a flare gas recovery system is not installed:

$$\text{Mass emitted (kg)} = 7.70\text{E-}02 \times \text{Refinery Feed (in m}^3\text{)}$$

Reference: [26], Activity 090203, Section 8, Table 2.

If a flare gas recovery system is installed it can be considered to be an emissions control device. The equation in **Section 6.1** can be used (with EFF = flare gas recovery system efficiency) to adjust the emissions estimate obtained from the algorithm above.

16.2.2. Incinerators

For all incinerator gas streams, including that from a sulphur plant if the gas composition is known, use the algorithm in **Section 16.1**, where:

M = mass of gas incinerated

MF_S = mass fraction of sulphur in gas incinerated

For emissions from the combustion of the auxiliary gas fuel used to support incinerator combustion, also use the algorithm in **Section 16.1**.

16.2.2.1. Sulphur Plant Tail Gas Incinerator

For a sulphur plant, if the composition of the gas stream is unknown, emissions can be determined from the sulphur balance across the plant.

$$\text{Mass emitted (kg)} = [(100 - \text{ERC}_{\text{EFF}}) / \text{ERC}_{\text{EFF}}] \times \text{PROD} \times \text{SF}_{\text{MW}} \times 1000$$

where:

ERC_{EFF} = recovery efficiency (in %)

PROD = sulphur production (in tonnes)

SF_{MW} = Molecular weight conversion from S to SO₂ = 64/32

Reference: [51], Section 8.13, Table 8.13-1.

16.3. CATALYTIC CRACKING UNIT REGENERATORS

For CCU regenerators, the emissions can be determined using coke sulphur content data. If these are not available, a less accurate emission factor can be used.

Where DeSO_x catalyst additive is used, the abatement effect of this on the emissions should be taken into account using the algorithm in **Section 6.1** with the value of EFF being the SO_x percentage removal efficiency.

The following emission estimation algorithms are applicable both with and without CO boilers.

16.3.1. Coke sulphur content known

$$\text{Mass emitted (kg)} = 2.00\text{E+}03 \times M \times \text{MF}_{\text{SFEED}} \times \text{MF}_{\text{SCOKE}}$$

where:

M = mass of feed to unit (in tonnes)

MF_{FEED} = mass fraction of sulphur in feed

MF_{COKE} = mass fraction of sulphur in coke

Reference: [32], Section 15.3.1.4.

16.3.2. **Coke sulphur content not known**

Mass emitted (kg) = 1.41E+00 × Volume of fresh feed to unit (in m³)

Reference: [6], Section 5.1, Table 5.1-1.

16.4. **CATALYTIC REFORMING UNITS**

Mass emitted (kg) = 3.63E-03 × Volume of feed to unit (in m³)

Reference: [18], Table 1. This reference uses data from a number of units with varying degrees of abatement equipment installed – see **Section 6.3**.

17. HYDROCHLOROFLUOROCARBONS (HCFC)

Hydrochlorofluorocarbons (HCFCs) may be used as refrigerants in refinery thermal exchange equipment.

Emissions are assumed to equal the amount used during the reporting period to top-up systems to replenish losses due to uncontrolled leakage.

Mass emitted (kg) = Mass used to top-up refrigerant systems (in kg)

Usage where the systems have been fully or partially drained and refrigerants collected for recycling or destruction should not be reported.

18. ARSENIC (As)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators
- Catalytic cracking unit regenerators
- Fluid cokers

18.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 18**.

Table 18 As Emission Factors for Combustion Sources

SOURCE	FUEL	EF_{NCV} g/GJ	REF
Boilers and Furnaces (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	1.81E-03	[21] Section 1.3, Table 1.3-10
	Refinery Fuel Oil ¹	3.98E-03	[21] Section 1.3, Table 1.3-11
	Natural Gas	1.20E-04	[5] Section 1.A.1, Table 4-6
	Refinery Fuel Gas	3.43E-04	[15], [52] ²
Gas Turbine	Distillate (gas oil)	2.30E-06	[5] Section 1.A.1 Table 3.18
	Natural Gas	1.20E-04	[5] Section 1.A.1 Table 3.17
Gas Engine 4-stroke, Lean Burn	Natural Gas	5.00E-05	[5] Section 1.A.1 Table 4-7
Incinerator Support Fuel or Flare Pilot Fuel	Natural Gas	1.20E-04	[5] Section 1.A.1, Table 4-6

Notes:

1. It is recommended that, where available, the arsenic content of the fuel oil is used to estimate emissions, making the assumption that all of the arsenic is emitted to atmosphere.
2. Reference [15] is base document, but reference [52] provides the same emission factors to more significant figures.

18.2. DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS

For all incinerator gas streams, use the algorithm in **Section 18.1** with an emission factor EF_{NCV} equal to that for fuel gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 18.1**.

18.3. CATALYTIC CRACKING UNIT REGENERATORS

Mass emitted (kg) = $1.39E-05 \times$ Volume of fresh feed to unit (in m^3)

This algorithm has been derived from speciation data for total particulate matter in CCU vents. It is for a unit with cyclone systems installed inside the regenerator vessel – see **Section 6.2**.

Reference: [25], Section 4.2.3, Tables 10 and 11.

18.4. FLUID COKERS

Mass emitted (kg) = $2.16E-03 \times$ Volume of fresh feed to unit (in m^3)

This algorithm has been derived from speciation data for total particulate matter in fluid coker vents.

Reference: [25], Section 4.2.3, Tables 10 and 11.

19. CADMIUM (Cd)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators
- Catalytic cracking unit regenerators

19.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 19**.

Table 19 Cd Emission Factors for Combustion Sources

SOURCE	FUEL	EF_{NCV} g/GJ	REF
Boilers and Furnaces (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	1.36E-03	[21] Section 1.3, Table 1.3-10
	Refinery Fuel Oil ¹	1.20E-03	[21] Section 1.3, Table 1.3-11
	Natural Gas	2.50E-07	[5] Section 1.A.1, Table 4-6
	Refinery Fuel Gas	7.12E-04	[15], [52] ²
Gas Turbine	Distillate (gas oil)	1.20E-06	[5] Section 1.A.1 Table 3.18
	Natural Gas	2.50E-07	[5] Section 1.A.1 Table 3.17
	Refinery Fuel Gas ³	2.52E-03	[15], [52] ²
Gas Engine 4-stroke, Lean Burn	Natural Gas	3.00E-06	[5] Section 1.A.1 Table 4-7
Incinerator Support Fuel or Flare Pilot Fuel	Natural Gas	2.50E-07	[5] Section 1.A.1, Table 4-6

Notes:

1. It is recommended that, where available, the cadmium content of the fuel oil is used to estimate emissions, making the assumption that all of the cadmium is emitted to atmosphere.
2. Reference [15] is base document, but reference [52] provides the same emission factors to more significant figures.
3. Factor derived from gas turbines without duct burners.

19.2. DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS

For all incinerator gas streams, use the algorithm in **Section 19.1**, with an emission factor EF_{NCV} equal to that for fuel gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 19.1**.

19.3. CATALYTIC CRACKING UNIT REGENERATORS

Mass emitted (kg) = $6.25\text{E-}05 \times \text{Volume of fresh feed to unit (in m}^3\text{)}$

This algorithm has been derived from speciation data for total particulate matter in CCU vents. It is for a unit with cyclone systems installed inside the regenerator vessel – see **Section 6.2**.

Reference: [25], Section 4.2.3, Tables 10 and 11.

20. CHROMIUM (Cr)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators

20.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 20**.

Table 20 Cr Emission Factors for Combustion Sources

SOURCE	FUEL	EF_{NCV} g/GJ	REF
Boilers and Furnaces (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	1.36E-03	[21] Section 1.3, Table 1.3-10
	Refinery Fuel Oil ¹	1.48E-02	[15], [52] ²
	Natural Gas	7.60E-07	[5] Section 1.A.1, Table 4-6
	Refinery Fuel Gas	2.74E-03	[15], [52] ^{2,3}
Gas Turbine	Distillate (gas oil)	2.80E-04	[5] Section 1.A.1 Table 3-18
	Natural Gas	7.60E-07	[5] Section 1.A.1 Table 3-17
	Refinery Fuel Gas ⁴	6.26E-03	[15], [52] ^{2,3}
Gas Engine 4-stroke, Lean Burn	Natural Gas	5.00E-05	[5] Section 1.A.1 Table 4-7
Incinerator Support Fuel or Flare Pilot Fuel	Natural Gas	7.60E-07	[5] Section 1.A.1, Table 4-6

Notes:

1. It is recommended that, where available, the chromium content of the fuel oil is used to estimate emissions, making the assumption that all of the chromium is emitted to atmosphere.
2. Reference [15] is base document, but reference [52] provides the same emission factors to more significant figures.
3. The detect ratio reported in [15] is < 1.0. This emission factor is a weighted value using the value of the detect ratio – see **Section 5.2** of this report.
4. Factor derived from gas turbines without duct burners.

20.2. DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS

For all incinerator gas streams, use the algorithm in **Section 20.1** with an emission factor EF_{NCV} equal to that for fuel gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 20.1**.

21. COPPER (Cu)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators
- Catalytic cracking unit regenerators
- Fluid cokers

21.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 21**.

Table 21 Cu Emission Factors for Combustion Sources

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	2.72E-03	[21] Section 1.3, Table 1.3-10
	Refinery Fuel Oil ¹	1.19E-02	[15], [52] ²
	Natural Gas	7.60E-08	[5] Section 1.A.1, Table 4-6
	Refinery Fuel Gas	2.22E-03	[15], [52] ²
Gas Turbine	Distillate (gas oil)	1.70E-04	[5] Section 1.A.1 Table 3-18
	Natural Gas	7.60E-08	[5] Section 1.A.1 Table 3-17
	Refinery Fuel Gas ³	1.97E-02	[15], [52] ²
Gas Engine 4-stroke, Lean Burn	Natural Gas	1.00E-05	[5] Section 1.A.1 Table 4-7
Incinerator Support Fuel or Flare Pilot Fuel	Natural Gas	7.60E-08	[5] Section 1.A.1, Table 4-6

Notes:

1. It is recommended that, where available, the copper content of the fuel oil is used to estimate emissions, making the assumption that all of the copper is emitted to atmosphere.
2. Reference [15] is base document, but reference [52] provides the same emission factors to more significant figures.
3. Factor derived from gas turbines without duct burners.

21.2. DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS

For all incinerator gas streams, use the algorithm in **Section 21.1** with an emission factor EF_{NCV} equal to that for fuel gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 21.1**.

21.3. CATALYTIC CRACKING UNIT REGENERATORS

Mass emitted (kg) = $1.39\text{E-}04 \times \text{Volume of fresh feed to unit (in m}^3\text{)}$

This algorithm has been derived from speciation data for total particulate matter in CCU vents. It is for a unit with cyclone systems installed inside the regenerator vessel – see **Section 6.2**.

Reference: [25], Section 4.2.3, Tables 10 and 11.

21.4. FLUID COKERS

Mass emitted (kg) = $1.50\text{E-}05 \times \text{Volume of fresh feed to unit (in m}^3\text{)}$

This algorithm has been derived from speciation data for total particulate matter in fluid coker vents.

Reference: [25], Section 4.2.3, Tables 10 and 11.

22. MERCURY (Hg)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators
- Catalytic cracking unit regenerators
- Fluid cokers

22.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 22**.

Table 22 Hg Emission Factors for Combustion Sources

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	1.36E-03	[21] Section 1.3, Table 1.3-10
	Refinery Fuel Oil	Not Detected ¹	[15], [52] ²
	Natural Gas	1.00E-04	[5] Section 1.A.1, Table 4-6
	Refinery Fuel Gas	8.60E-05	[15], [52] ^{2,3}
Gas Turbine	Distillate (gas oil)	5.30E-05	[5] Section 1.A.1 Table 3-18
	Natural Gas	1.00E-04	[5] Section 1.A.1 Table 3-17
	Refinery Fuel Gas ⁴	7.31E-03	[15], [52] ²
Gas Engine 4-stroke, Lean Burn	Natural Gas	1.00E-04	[5] Section 1.A.1 Table 4-7
Incinerator Support Fuel or Flare Pilot Fuel	Natural Gas	1.00E-04	[5] Section 1.A.1, Table 4-6

Notes:

1. Compound was not detected. Emission factor stated in reference [15] represents the detection limit. For the purposes of this report the emission factor is considered to be zero as the source is not proven (See **Section 5.2** of this report).
2. Reference [15] is base document, but reference [52] provides the same emission factors to more significant figures.
3. The detect ratio reported in reference [15] is < 1.0. This emission factor is a weighted value using the value of the detect ratio – see **Section 5.2** of this report.
4. Factor derived from gas turbines without duct burners

22.2. DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS

For all incinerator gas streams, use the algorithm in **Section 22.1** with an emission factor EF_{NCV} equal to that for fuel gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 22.1**.

22.3. CATALYTIC CRACKING UNIT REGENERATORS

Mass emitted (kg) = $6.95E-05 \times$ Volume of fresh feed to unit (in m^3)

This algorithm has been derived from speciation data for total particulate matter in CCU vents. It is for a unit with cyclone systems installed inside the regenerator vessel – see **Section 6.2**.

Reference: [25], Section 4.2.3, Tables 10 and 11.

22.4. FLUID COKERS

Mass emitted (kg) = $3.00E-05 \times$ Volume of fresh feed to unit (in m^3)

This algorithm has been derived from speciation data for total particulate matter in fluid coker vents.

Reference: [25], Section 4.2.3, Tables 10 and 11.

23. NICKEL (Ni)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators
- Catalytic cracking unit regenerators
- Fluid cokers

23.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 23**.

Table 23 Ni Emission Factors for Combustion Sources

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	1.36E-03	[21] Section 1.3, Table 1.3-10
	Refinery Fuel Oil ¹	1.03E+00	[15], [52] ²
	Natural Gas	5.10E-07	[5] Section 1.A.1, Table 4-6
	Refinery Fuel Gas	3.60E-03	[15], [52] ^{2,3}
Gas Turbine	Distillate (gas oil)	2.30E-06	[5] Section 1.A.1 Table 3-18
	Natural Gas	5.10E-07	[5] Section 1.A.1 Table 3-17
	Refinery Fuel Gas ⁴	7.93E-02	[15], [52] ²
Gas Engine 4-stroke, Lean Burn	Natural Gas	5.00E-05	[5] Section 1.A.1 Table 4-7
Incinerator Support Fuel or Flare Pilot Fuel	Natural Gas	5.10E-07	[5] Section 1.A.1, Table 4-6

Notes:

1. It is recommended that, where available, the nickel content of the fuel oil is used to estimate emissions, making the assumption that all of the nickel is emitted to atmosphere.
2. Reference [15] is base document, but reference [52] provides the same emission factors to more significant figures.
3. The detect ratio reported in [15] is < 1.0. This emission factor is a weighted value using the value of the detect ratio – see **Section 5.2** of this report.
4. Factor derived from gas turbines without duct burners.

23.2. DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS

For all incinerator gas streams, use the algorithm in **Section 23.1** with an emission factor EF_{NCV} equal to that for fuel gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 23.1**.

23.3. CATALYTIC CRACKING UNIT REGENERATORS

Mass emitted (kg) = $6.12E-04 \times$ Volume of fresh feed to unit (in m^3)

This algorithm has been derived from speciation data for total particulate matter in CCU vents. It is for a unit with cyclone systems installed inside the regenerator vessel – see **Section 6.2**.

Reference: [25], Section 4.2.3, Tables 10 and 11.

23.4. FLUID COKERS

Mass emitted (kg) = $5.70E-04 \times$ Volume of fresh feed to unit (in m^3)

This algorithm has been derived from speciation data for total particulate matter in fluid coker vents.

Reference: [25], Section 4.2.3, Tables 10 and 11.

24. LEAD (Pb)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators
- Catalytic cracking unit regenerators
- Fluid cokers

24.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 24**.

Table 24 Pb Emission Factors for Combustion Sources

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	4.07E-03	[21] Section 1.3, Table 1.3-10
	Refinery Fuel Oil ¹	4.56E-03	[21] Section 1.3, Table 1.3-11
	Natural Gas	1.50E-06	[5] Section 1.A.1, Table 4-6
	Refinery Fuel Gas	1.79E-03	[15], [52] ²
Gas Turbine	Distillate (gas oil)	6.90E-06	[5] Section 1.A.1 Table 3-18
	Natural Gas	1.50E-06	[5] Section 1.A.1 Table 3-17
	Refinery Fuel Gas ³	1.36E-02	[15], [52] ^{2,4}
Gas Engine 4-stroke, Lean Burn	Natural Gas	4.00E-05	[5] Section 1.A.1 Table 4-7
Incinerator Support Fuel or Flare Pilot Fuel	Natural Gas	1.50E-06	[5] Section 1.A.1, Table 4-6

Notes:

1. It is recommended that, where available, the lead content of the fuel oil is used to estimate emissions, making the assumption that all of the lead is emitted to atmosphere.
2. Reference [15] is base document, but reference [52] provides the same emission factors to more significant figures.
3. Factor derived from gas turbines without duct burners.
4. The detect ratio reported in [15] is < 1.0. This emission factor is a weighted value using the value of the detect ratio – see **Section 5.2** of this report.

24.2. DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS

For all incinerator gas streams, use the algorithm in **Section 24.1** with an emission factor EF_{NCV} equal to that for fuel gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 24.1**.

24.3. CATALYTIC CRACKING UNIT REGENERATORS

Mass emitted (kg) = $3.20E-04 \times$ Volume of fresh feed to unit (in m^3)

This algorithm has been derived from speciation data for total particulate matter in CCU vents. It is for a unit with cyclone systems installed inside the regenerator vessel – see **Section 6.2**.

Reference: [25], Section 4.2.3, Tables 10 and 11.

24.4. FLUID COKERS

Mass emitted (kg) = $4.50E-05 \times$ Volume of fresh feed to unit (in m^3)

This algorithm has been derived from speciation data for total particulate matter in fluid coker vents.

Reference: [25], Section 4.2.3, Tables 10 and 11.

25. ZINC (Zn)

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators
- Catalytic cracking unit regenerators
- Fluid cokers

25.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times M \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 25**.

Table 25 Zn Emission Factors for Combustion Sources

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	1.81E-03	[21] Section 1.3, Table 1.3-10
	Refinery Fuel Oil ¹	4.93E-02	[15], [52] ²
	Natural Gas	1.50E-06	[5] Section 1.A.1, Table 4-6
	Refinery Fuel Gas ³	2.55E-02	[15]
Gas Turbine	Distillate (gas oil)	4.40E-04	[5] Section 1.A.1 Table 3-18
	Natural Gas	1.50E-06	[5] Section 1.A.1 Table 3-17
	Refinery Fuel Gas ⁴	2.38E+00	[15], [52] ²
Gas Engine 4-stroke, Lean Burn	Natural Gas	2.91E-03	[5] Section 1.A.1 Table 4-7
Incinerator Support Fuel or Flare Pilot Fuel	Natural Gas	1.50E-06	[5] Section 1.A.1, Table 4-6

Notes:

1. It is recommended that, where available, the zinc content of the fuel oil is used to estimate emissions, making the assumption that all of the zinc is emitted to atmosphere.
2. Reference [15] is base document, but reference [52] provides the same emission factors to more significant figures.
3. Factor represents median value as the ratio of mean to median value > 10. See **Section 5.3**.
4. Factor derived from gas turbines without duct burners.

25.2. DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS

For all incinerator gas streams, use the algorithm in **Section 25.1** with an emission factor EF_{NCV} equal to that for fuel gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 25.1**.

25.3. CATALYTIC CRACKING UNIT REGENERATORS

Mass emitted (kg) = $1.18\text{E-}04 \times \text{Volume of fresh feed to unit (in m}^3\text{)}$

This algorithm has been derived from speciation data for total particulate matter in CCU vents. It is for a unit with cyclone systems installed inside the regenerator vessel – see **Section 6.2**.

Reference: [25], Section 4.2.3, Tables 10 and 11.

25.4. FLUID COKERS

Mass emitted (kg) = $4.50\text{E-}05 \times \text{Volume of fresh feed to unit (in m}^3\text{)}$

This algorithm has been derived from speciation data for total particulate matter in fluid coker vents.

Reference: [25], Section 4.2.3, Tables 10 and 11.

26. DIOXINS AND FURANS (PCDD AND PCDF)

Dioxins and furans are only produced during combustion processes under specific conditions and where chlorine is present. Estimation methods are provided for emissions from:

- Combustion of fuel oil
- Catalytic reforming units

The emission factors for each of the 17 isomers of PCDD and PCDF have been multiplied by the Toxic Equivalence Factor (TEF) in **Table 26** to give the emission factor in g I-TEQ (Toxic Equivalent to the most toxic isomer 2,3,7,8-CDD).

26.1. COMBUSTION OF FUEL OIL

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g I-TEQ/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 26**

Table 26 Emission Factors for PCDD and PCDF from Fuel Oil Combustion

ISOMER	I-TEF	Emission Factor lb/MMBtu (HHV)	Emission Factor g I-TEQ/GJ (NCV)
Dioxin 4D 2378	1	Not detected	0 ¹
Dioxin 5D 12378	0.5	Not detected	0 ¹
Dioxin 6D 123478	0.1	Not detected	0 ¹
Dioxin 6D 123678	0.1	2.50E-12	1.13E-10
Dioxin 6D 123789	0.1	2.50E-12	1.13E-10
Dioxin 7D 1234678	0.01	2.12E-11	9.59E-11
Dioxin 8D	0.001	5.10E-10	2.31E-10
Furan 4F 2378	0.1	5.54E-12	2.51E-10
Furan 5F 12378	0.05	Not detected	0 ¹
Furan 5F 23478	0.5	Not detected	0 ¹
Furan 6F 123478	0.1	2.48E-12	1.12E-10
Furan 6F 123678	0.1	1.86E-12	8.42E-11
Furan 6F 123789	0.1	Not detected	0 ¹
Furan 6F 234678	0.1	3.74E-12	1.69E-10
Furan 7F 1234678	0.01	9.79E-12	4.43E-11
Furan 7F 1234789	0.01	Not detected	0 ¹
Furan 8F	0.001	4.86E-11	2.20E-11
TOTAL			1.24E-09

Notes:

1. Compound was not detected. The emission factor stated in reference [15] is based on the detection limit. For the purposes of this report, the emission factor is considered to be zero as the source was not proven (See **Section 5.2** of this report).

Reference: [15].

26.2. CATALYTIC REFORMING UNIT REGENERATORS

There are very few data available for the emissions from these units. The US EPA [53] provides emission factors derived from tests on units with different modes of catalyst regeneration – continuous and semi-regenerative.

Continuous Regeneration Mode

Mass emitted (kg I-TEQ) = 1.91E-11 × Volume of feed to unit (in m³)

Semi-Regenerative Mode

Mass emitted (kg I-TEQ) = 6.35E-15 × Volume of feed to unit (in m³)

Reference: [53], Table 5-9.

27. BENZENE (C₆H₆)

Benzene is emitted as a constituent of VOC evaporative or leakage (fugitive) emissions and from the combustion of flare streams, fuels e.g. in boilers and furnaces, and coke in FCCU regenerators and cokers.

Combustion emissions are typically negligible compared to fugitive emissions.

Fugitive emissions are diffuse in a large facility like a refinery. Although those from pressurised equipment can be determined from speciation data for each stream in the refinery and leak monitoring surveys, this requires considerable effort and does not cover emissions from systems such as tanks, drains, oil-water separators, etc. One measurement technique is to monitor occasionally the composition of NMVOCs in the ambient air at the fence line to determine the average benzene mass fraction.

Where this technique is not undertaken, an estimation method for fugitives is provided using a default value for the mass fraction of benzene. For completeness, algorithms are also provided for the minor sources.

27.1. SPECIATED FENCELINE NMVOC DATA AVAILABLE

In general, VOC fugitive sources are numerous but individually small e.g. from valves, drain systems, etc. To determine the benzene emitted by a facility, one approach is to take occasional ambient air samples at regular points around the boundary fence and establish the average benzene mass fraction of the NMVOCs measured. Care must be taken in the positioning of the samplers to ensure that they are not located near to local emission sources that may skew the results. Full details of a methodology are given in reference [54].

The mass of benzene emitted by the facility is then calculated from:

$$\text{Mass emitted (kg)} = \text{SUMCALC}_{\text{NMVOC}} \times \text{MF}_{\text{BENZENE}}$$

where:

SUMCALC_{NMVOC} = sum of the individual calculated masses of NMVOCs emitted (in kg) within the facility, as per **Section 13**.

MF_{BENZENE} = Mass fraction of benzene (from fence line monitoring survey).

27.2. NO SPECIATED FENCELINE NMVOC DATA AVAILABLE

Where fence line monitoring is not undertaken, a value of MF_{BENZENE} = 1.72% mass can be used.

$$\text{Mass emitted (kg)} = 1.72\text{E-}02 \times \text{SUMCALC}_{\text{NMVOC}}$$

where:

SUMCALC_{NMVOC} = sum of the individual calculated masses of NMVOCs emitted (in kg) within the facility, as per **Section 13**.

Reference: [32], Section 15.5.3, Table 15-7.

27.3. ESTIMATION BY SOURCE

For completeness, algorithms are provided below for combustion sources and uncontrolled blowdown systems. The emission from the following combustion sources are typically negligible compared to fugitive sources:

- Combustion of fuels
- Destruction of gaseous streams in flares
- Catalytic cracking unit regenerators
- Fluid cokers

If some or all of the following algorithms are used, then the emissions are:

Mass emitted (kg) = Sum of emissions using algorithms below + Sum of emissions from all other sources using algorithms in Section 27.1 or 27.2

27.3.1. Combustion of Fuels

Mass emitted (kg) = (EF_{NCV} × M × NCV) / 1000

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 27**.

Table 27 Benzene Emission Factors for Combustion Sources

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Refinery Fuel Oil	6.47E-04	[21] Section 1.3, Table 1.3-9
	Natural Gas	9.84E-04	[21] Section 1.3, Table 1.3-9
	Refinery Fuel Gas	2.13E-03	[15] ^{1,2}
Gas Turbine ³	Distillate (Gas Oil) ⁴	2.49E-02	[24] Section 3.1, Table 3.1-4
	Natural Gas	5.73E-03	[24] Section 3.1, Table 3.1-3
Gas Engine 4-stroke, Lean Burn	Natural Gas	2.10E-01	[24] Section 3.2, Table 3.2-2
	Refinery Fuel Gas	6.21E-01	[15], [52] ⁵
Diesel Engine Large, Stationary	Distillate (Gas Oil)	3.22E-01	[15], [52] ⁵
Incinerator Support Fuel or Flare Pilot Fuel	Natural Gas	9.84E-04	[21] Section 1.3, Table 1.3-9

Notes:

1. Factor represents the median value as the ratio of mean to median value > 10. See **Section 5.3**.
2. The detect ratio reported in [15] is < 1.0. This emission factor is a weighted value using the value of the detect ratio – see **Section 5.2**.
3. Factor derived from turbines operating at high ($\geq 80\%$) loads.
4. Factor provided in reference [24] derived using HHV of 139 MBtu/10³ US gal.
5. Reference [15] is base document, but reference [52] provides the same emission factors to more significant figures

27.3.2. Destruction of Flare Streams

The following algorithms are for emissions from the combustion of the flare gas. For emissions from the combustion of the pilot gas fuel used to initiate flare combustion, use the algorithm in **Section 27.3.1**.

27.3.2.1. Flare Stream Details Known

If the mass and composition of the flare stream are known:

$$\text{Mass emitted (kg)} = 5.00\text{E-}00 \times M \times \text{MF}_{\text{BENZ}}$$

where:

M = total mass of gas flared (in tonnes)

MF_{BENZ} = mass fraction of benzene in gas flared

This algorithm assumes that 0.5% of the hydrocarbons remain unburned in “well designed and operated flares, such as in refineries”.

Reference: [19], Section 4.4.

27.3.2.2. Flare Stream Details Unknown

If the mass and composition are not known and a flare gas recovery system is not installed, a conservative factor based on refinery feed can be used:

$$\text{Mass emitted (kg)} = 1.66\text{E-}06 \times \text{Refinery Feed (in m}^3\text{)}$$

Reference: Emission factor derived from [26], Activity 090203, Section 8, Table 2, and [25], Section 4.22, Table 9.

If a flare gas recovery system is installed it can be considered to be an emissions control device. The equation in **Section 6.1** can be used (with EFF = flare gas recovery system efficiency) to adjust the emissions estimate obtained from the algorithm above.

27.3.3. Catalytic Cracking Unit Regenerators

27.3.3.1. Full Burn Regeneration

Emissions of NMVOCs, and hence benzene, are considered negligible.

27.3.3.2. Partial Burn with CO Boiler

Emissions of NMVOCs, and hence benzene, are considered negligible.

Reference: [6], Table 5.1-1.

27.3.3.3. Partial Burn without CO Boiler

If the off-gas is not fed to a CO boiler, or it is not in operation:

$$\text{Mass emitted (in kg)} = 8.04\text{E-}04 \times \text{Mass of coke burnt (in tonnes)}$$

Reference: [17], Table 1. This reference provides data on the number of data points both above and below the limit of detection. The emission factor is a weighted value using both sets of data – see **Section 5.2** of this report.

27.3.4. Fluid Cokers**27.3.4.1. Emissions Controlled with CO or Fired Waste Heat Boiler**

Emissions of NMVOCs, and hence benzene, are considered negligible.

Reference: [6], Table 5.1-1.

27.3.4.2. Non-Controlled Emissions

If the off-gas is not fed to a CO or fired waste heat boiler, or it is not in operation:

$$\text{Mass emitted (in kg)} = 1.75\text{E-}04 \times \text{Feed to unit (in m}^3\text{)}$$

This assumes that benzene makes up 0.38% by mass of the VOCs in the vented gas.

Reference: [25], Section 4.2.1, Table 8 and Section 4.2.2, Table 9.

27.3.5. Uncontrolled Blowdown System

The gaseous emissions from blowdown systems in EU refineries are recovered and/or flared.

If these controls are not operational and all of the emissions are released to atmosphere, the benzene emissions can be conservatively estimated using the factor provided in reference [6], Table 5.1-1 to determine total hydrocarbon (THC) emissions and assuming that benzene makes up 0.38% by mass of the THCs in the blowdown gas (reference [25], Section 4.2.2, Table 9).

28. POLYCYCLIC AROMATIC HYDROCARBONS (PAH)

The E-PRTR requires the total emissions of the four PAHs listed below:

- Benzo(a)pyrene
- Benzo(b)fluoranthene
- Benzo(k)fluoranthene
- Indeno(1,2,3-cd)pyrene

Estimation methods are provided for emissions from:

- Combustion of fuels
- Destruction of gaseous streams in incinerators
- Catalytic cracking unit regenerators

Speciated values are provided for the four individual PAHs in addition to the summation of the emission factors.

Emission factors for total PAH emissions are available for the combustion of distillate fuel in gas turbines (reference [24], Section 3.1, Table 3.1-15) and for flare gas (reference [25], Section 4.2.2, Table 9). These factors are not reproduced in this report as E-PRTR requires the emissions to be reported of only a limited number of the total PAH compounds.

28.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Sections 28.1.1 to 28.1.5**.

28.1.1. Refinery Fuel Oil Combustion in Boilers and Furnaces

Table 28 PAH Emission Factors for Fuel Oil Combustion

PAH	EF_{NCV} g/GJ
Benzo(a)pyrene	0 ¹
Benzo(b)fluoranthene	3.670E-06 ²
Benzo(k)fluoranthene	0 ¹
Indeno(1,2,3-cd)pyrene	0 ¹
Total	3.67E-06

Notes:

1. Compound was not detected. The emission factor stated in reference [15] represents the detection limit. The emission factor is thus considered to be zero as the source is not proven (see **Section 5.2**).

2. The detect ratio reported in [15] is < 1.0. This emission factor is a weighted value using the value of the detect ratio – see **Section 5.2**.

For CO boilers and fired waste heat boilers, the algorithm should only be applied to the support fuel fired.

Reference: [15], [52].

28.1.2. Gas Combustion in Boilers and Furnaces

28.1.2.1. Natural Gas

The emission factors for all four of the PAHs stated in reference [21], Table 1.4-3 represent detection limit values. The emission factors are thus considered to be zero as the source is not proven (See **Section 5.2** of this report).

28.1.2.2. Refinery Fuel Gas

Table 29 PAH Emission Factors for Refinery Fuel Gas Combustion in Boilers and Furnaces

PAH	EF _{NCV} g/GJ
Benzo(a)pyrene	6.688E-07 ^{1,2}
Benzo(b)fluoranthene	1.137E-06 ^{1,2}
Benzo(k)fluoranthene	6.306E-07 ^{1,2}
Indeno(1,2,3-cd)pyrene	6.306E-07 ^{1,2}
Total	3.07E-06

Notes:

1. Ratio of mean to median value > 10. Median value used. See **Section 5.3**.
2. The detect ratio reported in [15] is < 1.0. This emission factor is a weighted value using the value of the detect ratio – see **Section 5.2** of this report.

For CO boilers and fired waste heat boilers, the algorithm should only be applied to the support fuel fired.

Reference: [15], [52].

28.1.3. Gas Combustion in Gas Turbines

Table 30 PAH Emission Factors for Gas Combustion in Gas Turbines

PAH	EF _{NCV} g/GJ ¹
Benzo(a)pyrene	0 ²
Benzo(b)fluoranthene	1.576E-06 ³
Benzo(k)fluoranthene	1.113E-06 ³
Indeno(1,2,3-cd)pyrene	8.360E-07 ³
Total	3.53E-06

Notes:

1. Emission factors for gas turbine without duct burners.
2. No data available.
3. The detect ratio reported in [15] is < 1.0. This emission factor is a weighted value using the value of the detect ratio – see **Section 5.2** of this report.

Reference: [15], [52].

28.1.4. Gas Combustion in Gas Engines

Table 31 PAH Emission Factors for Gas Combustion in Gas Engines

PAH	EF _{NCV} g/GJ ¹
Benzo(a)pyrene	1.615E-05 ²
Benzo(b)fluoranthene	1.486E-04 ²
Benzo(k)fluoranthene	2.408E-04 ²
Indeno(1,2,3-cd)pyrene	5.446E-05
Total	4.60E-04

Notes:

1. Emission factors for 4-stroke, lean-burn gas engine.
2. The detect ratio reported in [15] is < 1.0. This emission factor is a weighted value using the value of the detect ratio – see **Section 5.2** of this report.

Reference: [15], [52].

28.1.5. Distillate Oil Combustion in Diesel Engines

Table 32 PAH Emission Factors for Distillate Oil Combustion in Diesel Engines

PAH	EF _{NCV} g/GJ ¹
Benzo(a)pyrene	1.127E-04 ²
Benzo(b)fluoranthene	4.888E-04 ²
Benzo(k)fluoranthene	9.640E-05 ²
Indeno(1,2,3-cd)pyrene	1.815E-04 ²
Total	8.79E-04

Notes:

1. Emission factors for large stationary engine with stack gas oxygen concentration < 13%.
2. The detect ratio reported in [15] is < 1.0. This emission factor is a weighted value using the value of the detect ratio – see **Section 5.2**.

Reference: [15], [52].

28.1.6. Incinerator Support Fuel and Flare Pilot Fuel

Use values of EF_{NCV} provided in **Section 28.1.2**.

28.2. DESTRUCTION OF GASEOUS STREAMS IN INCINERATORS

For all incinerator gas streams, use the algorithm in **Section 28.1**, with values of EF_{NCV} provided in **Section 28.1.2.2**.

28.3. CATALYTIC CRACKING UNIT REGENERATORS

Mass emitted (kg) = EF_{FCC} × Mass of coke burned (in tonnes)

where:

EF_{FCC} = emission factor from **Table 33**

Table 33 PAH Emission Factors for CCU Regenerators

PAH	EF _{FCC}
Benzo(a)pyrene	7.072E-07
Benzo(b)fluoranthene	1.223E-06
Benzo(k)fluoranthene	8.212E-07
Indeno(1,2,3-cd)pyrene	6.238E-07
Total	3.38E-06

Reference: [17], Table 1. This reference provides data on the number of data points both above and below the limit of detection. The emission factor is a weighted value using both sets of data – see **Section 5.2**.

29. CHLORINE AND INORGANIC CHLORINE COMPOUNDS

The E-PRTR requires estimates of the emissions of chlorine and inorganic chlorine compounds reported as HCl.

The major source of these pollutants is the catalytic reforming unit.

29.1. CATALYTIC REFORMING UNITS

The source of these compounds is the reactivation of the catalyst in the catalytic reforming unit. The catalyst is reactivated, following the burning off of coke deposits, using chlorine, chlorinated compounds or a chlorinated solvent. The emissions can be abated, for example using a caustic or water wash system, chloride trap or driers where HCl is present in water vapour.

A review of data from units without flue gas abatement systems installed indicate that for very high throughput units the emissions may be greater than the E-PRTR reporting threshold of 10 000 kg/year. For units with abatement systems the emissions were below the threshold value.

There are emission factors related to reformer feed rate for both chlorine and HCl available in reference [18], Table 1. This reference uses combined data from reformer units both with and without flue gas abatement systems installed. Due to the corresponding very wide scatter of emissions data, the emission factor for HCl has a variance between the median and average values of four orders of magnitude.

It is not possible, therefore, to provide reliable emission factors for uncontrolled emissions from the reformer catalyst reactivation process.

The uncontrolled emissions could be estimated from knowledge of the mass of chlorine or chlorinated compound injected, the efficiency of the reactivation process and any conversion of the compound that takes place during the activation process.

For reporting purposes, the calculated mass emitted needs to be converted to equivalent mass of HCl. This is obtained by multiplying the mass of chlorinated compound emitted by the ratio of the molecular weight of HCl to the molecular weight of the compound.

30. PARTICULATE MATTER WITH DIAMETER <10 µM (PM₁₀)

Estimation methods are provided for emissions of PM₁₀ due to:

- Combustion of fuels
- Destruction of gaseous streams in incinerators and flares
- Catalytic cracking unit regenerators
- Fluid cokers

PM₁₀ is defined by the UNECE Task Force on Emission Inventories and Projections as particulate matter which is measured after passing through a size selective inlet with a 50% efficiency cut-off at 10 µm aerodynamic diameter. Emission factors derived from US EPA reference sources are for 'filterable' particulate matter i.e. collected on or prior to a filter of an EPA Method 5 (or equivalent) sampling train.

30.1. COMBUSTION OF FUELS

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table 34**.

Table 34 PM₁₀ Emission Factors for Combustion Sources

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces < 10 MW (for CO Boilers and Fired Waste Heat Boilers only applies to the support fuel firing)	Distillate (gas oil)	3.49E+00	[21] Section 1.3, Table 1.3-7
	Refinery Fuel Oil	1.50E+01	[5] Section 1.A.1, Table 4-4
	LPG ¹	9.89E-01	[21] Section 1.5, Table 1.5-1
	Natural Gas	8.90E-01	[21] Section 1.4, Table 1.4-2
Boilers and Furnaces 10 MW to 100 MW	Distillate (gas oil)	3.23E+00	[21] Section 1.3, Table 1.3-6
	Refinery Fuel Oil	1.50E+01	[5] Section 1.A.1, Table 4-4
	LPG ¹	9.89E-01	[21] Section 1.5, Table 1.5-1
	Natural Gas	8.90E-01	[21] Section 1.4, Table 1.4-2

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Boilers and Furnaces > 100 MW	Distillate (gas oil)	3.23E+00	[23] SCC 10100501
	Refinery Fuel Oil	1.50E+01	[5] Section 1.A.1, Table 4-4
	LPG ²	7.84E-01	[23] SCC 10101002
	Natural Gas	8.90E-01	[21] Section 1.4, Table 1.4-2
Gas Turbine ³	Distillate (gas oil) ⁴	1.95E+00	[24] Section 3.1, Table 3.1-2a
	Natural Gas	2.00E-01	[5] Section 1.A.1, Table 3- 17
Gas Engine 4-stroke, Lean Burn	Natural Gas	3.68E-02	[24] Section 3.2, Table 3.2-2
Diesel Engine Large, Stationary	Diesel Fuel	2.24E+01	[24] Section 3.4, Table 3.4-2
Incinerator Support Fuel or Flare Pilot Fuel	LPG ¹	9.89E-01	[21] Section 1.5, Table 1.5-1
	Natural Gas	8.90E-01	[21] Section 1.4 Table 1.4-2

Notes:

1. Factor is for both butane and propane combustion
2. Factor is for propane combustion
3. Factors based on combustion turbines using water-steam injection.
4. Factor provided in reference [24] derived using HHV of 139 MBtu/10³ US gal.

Estimation of PM₁₀ emissions from measurement of ‘dust’ (total suspended particulates (TSP))

Where measurements of TSP are made for dual-fired combustion units, the mass of PM₁₀ can be derived from:

Mass emitted of PM₁₀ = 7.50E-01 × mass of TSP

based on an emission factor for TSP from RFO combustion of 20 g/GJ [5].

30.1.1. Other Fuels

In the absence of specific emission factors for other gaseous fuels (e.g. refinery fuel gas, low joule gas) it is recommended to use the value of EF_{NCV} for natural gas from **Table 34**.

30.2. DESTRUCTION OF GASEOUS STREAMS

30.2.1. Flares

For a non-smoking flare, the emissions of PM₁₀ can be assumed to be negligible.

Reference: [25], Section 4.2.1, Table 8.

30.2.2. Incinerators

For all incinerator gas streams, use the algorithm in **Section 30.1** with an emission factor EF_{NCV} equal to that for natural gas combustion in a furnace.

For emissions from the combustion of the auxiliary fuel used to support incineration, also use the algorithm in **Section 30.1**.

30.3. CATALYTIC CRACKING UNIT REGENERATORS

Mass emitted (in kg) = 5.49E-01 × Feed to unit (in m³)

Reference: [25], Section 4.2.1, Table 8.

This algorithm is for a unit with cyclone systems installed inside the regenerator vessel – see **Section 6.2**.

30.4. FLUID COKERS

Mass emitted (in kg) = 7.65E-01 × Feed to unit (in m³)

Reference: [25], Section 4.2.1, Table 8.

31. REFERENCES

1. EU (1996) Council Directive 96/61/EC of 24 September 1996 concerning integrated pollution prevention and control. Official Journal of the European Communities No. L257, 10.10.1996
2. EU (2006) Regulation (EC) No. 166/2006 of the European Parliament and of the Council of 18 January 2006 concerning the establishment of a European Pollutant Release and Transfer Register and amending Council Directives 91/689/EEC and 96/61/EC. Official Journal of the European Communities No. L33, 04.02.2006
3. UNECE (2003) Protocol on pollutant release and transfer register. Geneva: United Nations Economic Commission for Europe
4. EU (2006) Guidance Document for the implementation of the European PRTR. Brussels: European Commission, Directorate General for Environment (http://prtr.ec.europa.eu/eper/documents/EN_E-PRTR_Fin.pdf)
5. EEA (2013) EMEP/EEA emission inventory guidebook. Copenhagen: European Environment Agency
6. EPA (1995/2008) AP 42, fifth edition: Compilation of air pollutant emission factors. Vol. 1: Stationary point and area sources. Chapter 5: Petroleum industry. Research Triangle Park, NC: US Environmental Protection Agency (<http://www.epa.gov/ttn/chief/ap42/ch05/index.html>)
7. EI (2010) Protocol for the estimation of VOC emissions from petroleum refineries and gasoline marketing operations, 2nd edition. London: Energy Institute
8. CONCAWE (2006) Air pollutant emission estimation methods for EPER and PRTR reporting by refineries (revised). Report No. 9/05R. Brussels: CONCAWE
9. CONCAWE (2007) Air pollutant emission estimation methods for E- PRTR reporting by refineries. Report No. 3/07. Brussels: CONCAWE
10. CONCAWE (2009) Air pollutant emission estimation methods for E- PRTR reporting by refineries, 2009 edition. Report No. 1/09. Brussels: CONCAWE
11. CONCAWE (1985) Hydrocarbon emissions from gasoline storage and distribution systems. Report No. 85/54. Brussels: CONCAWE
12. EPA (2014) Comprehensive data collected from the petroleum refining sector. Technology transfer network - air toxics website. Research Triangle Park NC: US Environmental Protection Agency (<http://www.epa.gov/ttn/atw/petref/petrefpg/html>)
13. EPA (2014) Method 320 – Vapor phase organic and inorganic emissions by extractive FTIR. Research Triangle Park NC: US Environmental Protection Agency (<http://www.epa.gov/ttnemc01/methods/method320.html>)

14. EPA (2011) Other test method (OTM) 29 – Sampling and analysis for hydrogen cyanide emissions from stationary sources. Research Triangle Park NC: US Environmental Protection Agency (<http://www.epa.gov/ttnemc01/prelim/otm29.pdf>)
15. API (1998) Air toxics emission factors for combustion sources using petroleum-based fuels. Volume 1: Development of emission factors using API/WSPA approach. Publication No. 348. Washington DC: American Petroleum Institute
16. VROM (2003) Handreiking validatie milieujaarverslagen. The Hague: Ministerie van VROM
17. Bertrand, R.R. and Siegell, J.H. (2002) Emission of trace compounds from catalytic cracking regenerators. *Environmental Progress* 21, 3, 163-167
18. Bertrand, R.R. and Siegell, J.H. (2003) Emission of trace compounds from catalytic reforming units. *Environmental Progress* 22, 1, 74-77
19. API (2009) Compendium of greenhouse gas emissions methodologies for the oil and natural gas industry. Washington DC: American Petroleum Institute
20. SEPA (2004) Scottish pollutant release inventory reporting – petroleum activities guidance note. Edinburgh: Scottish Environment Protection Agency
21. EPA (1996/8/2008) AP 42, fifth edition: Compilation of air pollutant emission factors. Vol. 1: Stationary point and area sources. Chapter 1: External combustion sources. Research Triangle Park, NC: US Environmental Protection Agency (<http://www.epa.gov/ttn/chief/ap42/ch01/index.html>)
22. EC (2015) Best available techniques (BAT) reference document for the refining of mineral oil and gas. Report EUR 27140 EN. Seville: European Commission.
23. EPA (2014) Factor Information REtrieval (FIRE) software. Research Triangle Park NC: US Environmental Protection Agency (<http://www.epa.gov/ttn/chief/software/fire/index.html>)
24. EPA (1996/2000) AP 42, fifth edition: Compilation of air pollutant emission factors. Vol. 1: Stationary point and area sources. Chapter 3: Stationary internal combustion sources. Research Triangle Park NC: US Environmental Protection Agency (<http://www.epa.gov/ttn/chief/ap42/ch03/index.html>)
25. Environment Australia (1999) National pollutant inventory – emission estimation technique manual for petroleum refining. Canberra: Environment Australia (http://www.npi.gov.au/resource/emission_estimation_techniques_manual_petroleum_refining)
26. EEA (2005) EMEP/CORINAIR emission inventory guidebook – 2005, 3rd edition. Copenhagen: European Environment Agency
27. EU (2003) Directive 2003/87/EC of the European Parliament and of the Council of 13 October 2003 establishing a scheme for greenhouse gas emission allowance trading within the Community and amending Council Directive 96/61/EC. Official Journal of the European Communities No. L275, 25.10.2003

-
28. EU (2007) Commission decision of 18 July 2007 establishing guidelines for the monitoring and reporting of greenhouse gas emissions pursuant to Directive 2003/87/EC of the European Parliament and of the Council (2007/589/EC). Official Journal of the European Communities No. L229, 31.08.2007
 29. Martin, J. et al (2003) Testing flare emission factors for flaring in refineries. US EPA 12th International emissions inventory conference, San Diego, April 29 – May 1, 2003
 30. CONCAWE (2004) Guidance document for application of the EU Commission's guidelines for monitoring and reporting of GHG emissions. Report No. 10/04. Brussels: CONCAWE
 31. Battye, R. et al (1994) Development and selection of ammonia emission factors. Washington DC: US Environmental Protection Agency
 32. Canadian Fuels Association (2013) Code of practice for developing an emission inventory for refineries and terminals, Rev. 14. Ottawa: Canadian Fuels Association
 33. CONCAWE (2008) Optical methods for remote measurement of diffuse VOCs: their role in the quantification of annual refinery emissions. Report No. 6/08. Brussels: CONCAWE
 34. EPA (1995) Protocol for equipment leak emission estimates. Report No. EPA-453/R-95-017. Research Triangle Park NC: US Environmental Protection Agency
 35. CEN (2008) Fugitive and diffuse emissions of common concern to industry sectors – measurement of fugitive emission of vapours generating from equipment and piping leaks. Standard No. EN 15446: 2008. Brussels: Comité Européen de Normalisation
 36. Lev-On, M. et al (2007) Derivation of new emission factors for quantification of mass emissions when using optical gas imaging for detecting leaks. J Air Waste Manag Assoc 57, 9, 1061-1070
 37. EPA (1980) Assessment of atmospheric emissions from petroleum refining. Report No. EPA-600/2-80-075a. Washington DC: US Environmental Protection Agency
 38. EPA (2006) Emissions factors software and tools. WATER9 version 3.0. North Carolina: US Environmental Protection Agency
http://www.epa.gov/ttn/chief/software/water/water9_3/index.html
 39. EPA (1994) Air emissions models for waste and wastewater. Report EPA-453/R-94-080A. Triangle Park NC: US Environmental Protection Agency
 40. CONCAWE (2014) Methods for estimating VOC emissions from primary oil-water separator systems in refineries. Report 5/14. Brussels: CONCAWE
 41. Litchfield, D. K. (1971) Controlling odors and vapors from API separators. Oil and Gas Journal, November 1, 1971, 60-62
 42. RIVM/MNP (2004) Diffuse emissies en emissies bij op- en overslag. Handboek emissiefactoren. Rapportagereeks Milieu Monitor No.14. Bilthoven: Dutch National Institute for Public Health and the Environment

-
43. API (2012) Manual of petroleum measurement standards. Chapter 19 Evaporation loss measurement, Section 2: Evaporative loss from floating-roof tanks. 3rd edition. (Formerly, API Publications 2517 and 2519). Washington DC: American Petroleum Institute
 44. API (2008) Evaporative loss from closed-vent internal floating-roof storage tanks. Technical Report 2569. Washington DC: American Petroleum Institute
 45. API (2005) Evaporative loss from storage tank floating roof landings. Technical Report 2567. Washington DC: American Petroleum Institute
 46. API (2012) Manual of petroleum measurement standards. Chapter 19: Evaporation loss measurement, Section 1: Evaporative loss from fixed-roof tanks. 4th edition. Formerly, API Publication 2518. Washington DC: American Petroleum Institute
 47. EPA (2006) AP 42, fifth edition: Compilation of air pollutant emission factors. Vol. 1: Stationary point and area sources. Chapter 7: Liquid storage tanks. Research Triangle Park NC: US Environmental Protection Agency (<http://www.epa.gov/ttn/chief/ap42/ch07/index.html>)
 48. API (2007) Evaporative loss from the cleaning of storage tanks. Technical Report 2568. Washington DC: American Petroleum Institute
 49. Takacs, T. J. et al (2004) Method estimates NO_x from combustion equipment. *Oil & Gas Journal* 102, 23, 48-52
 50. ExxonMobil (2006) Private communication with the chairman of the CONCAWE Special Task Force STF-69
 51. EPA (1993) AP 42, fifth edition: Compilation of air pollutant emission factors. Vol. 1: Stationary point and area sources. Chapter 8: Inorganic chemical industry. Research Triangle Park NC: US Environmental Protection Agency (<http://www.epa.gov/ttn/chief/ap42/ch08/index.html>)
 52. API (2002) Comparison of API and EPA toxic air pollutant emission factors for combustion sources. Publication No. 4720. Washington DC: American Petroleum Institute
 53. EPA (2006) An inventory of sources and environmental releases of dioxin-like compounds in the United States for the years 1987, 1995 and 2000. Report EPA/600/P-3/002F. Research Triangle Park NC: US Environmental Protection Agency
 54. EI (2004) Protocol for the determination of the speciation of hydrocarbon emissions from oil refineries. London: Energy Institute
 55. EU (2000) Regulation (EC) No. 2037/2000 of the European Parliament and of the Council of 29 June 2000 on substances that deplete the ozone layer. Official Journal of the European Communities No. L244, 29.09.2000
 56. EPA (1985) AP 42, fifth edition: Compilation of air pollutant emission factors. Vol. 1: Stationary point and area sources. Appendix A: Miscellaneous data and conversion factors. Research Triangle Park NC: US Environmental Protection Agency (<http://www.epa.gov/ttn/chief/ap42/appendix/appa.pdf>)

APPENDIX 1 E-PRTR AIR POLLUTANTS

Table A1.1 lists the air pollutants that must be reported under the E-PRTR Regulation if annual emissions exceed the threshold values shown. It indicates those pollutants on the sector specific indicative lists in the EU Guidance Document [4] which are considered “likely” to be emitted by refineries and combustion installations (> 50 MW). It also shows those pollutants which have been estimated by at least one refinery to exceed the E-PRTR reporting threshold.

Table A1.1 List of E-PRTR Air Pollutants

POLLUTANT	REPORTING THRESHOLD kg/year	POLLUTANT ON INDICATIVE LIST Ref [4], Appendix 5		POLLUTANTS ESTIMATED BY OIL INDUSTRY THAT MAY EXCEED PRTR THRESHOLDS
		Mineral Oil and Gas Refineries	Combustion Installations (> 50 MW)	
Methane (CH ₄)	100 000	X	X	X
Carbon monoxide (CO)	500 000	X	X	X
Carbon dioxide (CO ₂)	100 000 000	X	X	X
Hydrofluorocarbons (HFCs)	100	X	X	X
Nitrous oxide (N ₂ O)	10 000	X	X	X
Ammonia (NH ₃)	10 000	X	X	X
Non-methane volatile organic compounds (NMVOCs)	100 000	X	X	X
Nitrogen oxides (NO _x)	100 000	X	X	X
Perfluorocarbons (PFCs)	100	-	-	-
Sulphur hexafluoride (SF ₆)	50	-	X	X
Sulphur oxides (SO _x)	150 000	X	X	X
Hydrochlorofluorocarbons (HCFCs)	1	X	X	X
Chlorofluorocarbons (CFCs)	1	-	-	- ¹
Halons	1	-	-	- ¹
Arsenic + compounds	20	X	X	X
Cadmium + compounds	10	X	X	X
Chromium + compounds	100	X	X	X
Copper + compounds	100	X	X	X
Mercury + compounds	10	X	X	X
Nickel + compounds	50	X	X	X
Lead + compounds	200	X	X	X
Zinc + compounds	200	X	X	X

POLLUTANT	REPORTING THRESHOLD kg/year	POLLUTANT ON INDICATIVE LIST Ref [4], Appendix 5		POLLUTANTS ESTIMATED BY OIL INDUSTRY THAT MAY EXCEED PRTR THRESHOLDS
		Mineral Oil and Gas Refineries	Combustion Installations (> 50 MW)	
Aldrin	1	-	-	-
Chlordane	1	-	-	-
Chlordecone	1	-	-	-
DDT	1	-	-	-
1,2-dichloroethane	1000	-	-	-
Dichloromethane	1000	-	-	-
Dieldrin	1	-	-	-
Endrin	1	-	-	-
Heptachlor	1	-	-	-
Hexachlorobenzene	10	-	-	-
1,2,3,4,5,6-hexachlorocyclohexane	10	-	-	-
Lindane	1	-	-	-
Mirex	1	-	-	-
PCDD + PCDF (dioxins and furans) (as TEQ)	0.0001	-	X	-
Pentachlorobenzene	1	-	-	-
Pentachlorophenol	10	-	-	-
Polychlorinated biphenyls (PCBs)	0.1	-	-	-
Tetrachloroethylene	2000	-	-	-
Tetrachloromethane	100	-	-	-
Trichlorobenzenes	10	-	-	-
1,1,1-trichloroethane	100	-	-	-
1,1,2,2-tetrachloroethane	50	-	-	-
Trichloroethylene	2000	-	X ²	-
Trichloromethane	500	-	-	-
Toxaphene	1	-	-	-
Vinyl chloride	1000	-	-	-
Anthracene	50	-	-	- ³
Benzene	1000	X	X	X
Ethylene oxide	1000	-	-	-
Naphthalene	100	-	-	- ³

POLLUTANT	REPORTING THRESHOLD kg/year	POLLUTANT ON INDICATIVE LIST Ref [4], Appendix 5		POLLUTANTS ESTIMATED BY OIL INDUSTRY THAT MAY EXCEED PRTR THRESHOLDS
		Mineral Oil and Gas Refineries	Combustion Installations (> 50 MW)	
Di-(2-ethyl hexyl) phthalate	10	-	-	-
Polycyclic aromatic hydrocarbons (PAHs) ⁴	50	X	X	X
Chlorine + inorganic compounds (as HCl)	10 000	X	X	X
Asbestos	1	-	-	-
Fluorine + inorganic compounds (as HF)	5000	-	-	-
Hydrogen cyanide (HCN)	200	-	-	-
Particulate matter < 10 micron diameter (PM ₁₀)	50 000	X	X	X
Hexabromobiphenyl	0.1	-	-	-
<i>TOTALS of 60 E-PRTR air pollutants</i>		22	25	23

Notes:

1. These halocarbons have been banned under EU Regulations [55] and would not be used to top-up existing equipment.
2. Trichloroethylene is not a product of combustion. The inclusion of this pollutant in the indicative sector specific list of air pollutants for thermal power stations and other combustion installations in reference [4] appears to be due to an anomaly in the EPER database.
3. The possible magnitude of emissions of anthracene and naphthalene are reviewed in **Appendix 3**.
4. Benzo(a)pyrene, benzo(b)fluoranthene, benzo(k)fluoranthene and indeno(1,2,3-cd)pyrene.

APPENDIX 2 UPDATES IN EMISSION ALGORITHMS AND FACTORS

The following changes in emission algorithms and factors have been made from the predecessor CONCAWE report No. 1/09 [10].

Carbon Monoxide

Updated emission factor for:
- RFO combustion.

New emission factor for:
- RFG combustion.

Nitrous Oxide

Updated emission factor for:
- Natural gas combustion in gas engines.
- Natural gas combustion in turbines.
- Gas oil combustion in diesel engines.

New emission factor for:
- RFG combustion.

Non-Methane Volatile Organic Compounds

New emission factor for:
- Emissions from oil water separator systems

Updated emission factor for:
- Natural gas combustion in turbines.

Updated default value for:
- Liquid density of evaporated hydrocarbons (kg/m³).

Updated emission factor for:
- Refuelling emissions where Stage II is installed (Appendix 4).

Arsenic

Updated emission factor for:
- Natural gas combustion in all sizes of boilers and furnaces.

New emission factor for:
- Gas oil combustion in gas turbines.
- Natural gas combustion in gas turbines.
- Natural gas combustion in gas engines.

Cadmium

Updated emission factor for:
- Natural gas combustion in all sizes of boilers and furnaces.
- Gas oil combustion in gas turbines.
- Natural gas combustion in gas turbines.

New emission factor for:

- Natural gas combustion in gas engines.

Chromium

Updated emission factor for:

- Natural gas combustion in all sizes of boilers and furnaces.
- Gas oil combustion in gas turbines.- Natural gas combustion in gas turbines.

New emission factor for:

- Natural gas combustion in gas engines.

Copper

Updated emission factor for:

- Natural gas combustion in all sizes of boilers and furnaces.
- Natural gas combustion in gas turbines.

New emission factor for:

- Gas oil combustion in gas turbines.
- Natural gas combustion in gas engines.

Mercury

Updated emission factor for:

- Natural gas combustion in all sizes of boilers and furnaces.
- Gas oil combustion in gas turbines.
- Natural gas combustion in gas turbines.

New emission factor for:

- Natural gas combustion in gas engines.

Nickel

Updated emission factor for:

- Natural gas combustion in all sizes of boilers and furnaces.
- Gas oil combustion in gas turbines.
- Natural gas combustion in gas turbines.

New emission factor for:

- Natural gas combustion in gas engines.

Lead

Updated emission factor for:

- Natural gas combustion in all sizes of boilers and furnaces.
- Gas oil combustion in gas turbines.

New emission factor for:

- Natural gas combustion in turbines.
- Natural gas combustion in gas engines.

Zinc

Updated emission factor:

- Natural gas combustion in all sizes of boilers and furnaces.

New emission factor for:

- Natural gas combustion in turbines.
- Gas oil combustion in turbines.
- Natural gas combustion in gas engines.

Particulate Matter

New emission factor for:

- RFO combustion in all sizes of boilers and furnaces.
- Natural gas combustion in turbines.

APPENDIX 3 ANTHRACENE AND NAPHTHALENE

Anthracene and naphthalene are pollutants known to be emitted by refineries, but neither is included on the sector specific indicative lists in the EU E-PRTR Guidance [4]. Emission estimation methods for these two pollutants are provided in this Appendix. It is demonstrated that emissions of neither pollutant are likely to exceed their respective E-PRTR reporting threshold, even at the largest of refineries.

A3.1 ANTHRACENE

Estimation methods are provided for emissions from:

- Combustion of fuels
- Fluidised catalytic cracking units

A3.1.1 Combustion of Fuels

$$\text{Mass emitted (kg)} = (\text{EF}_{\text{NCV}} \times \text{M} \times \text{NCV}) / 1000$$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table A3.1**.

Reference: [15].

Table A3.1 Anthracene Emission Factors for Combustion Sources

SOURCE	FUEL	EF_{NCV} g/GJ	REF
Furnaces and Boilers	Refinery Fuel Oil	9.37E-07	[15], [52] ¹
	Gas	2.26E-06	[15], [52] ¹
Gas Turbine ²	Gas	1.64E-05	[15], [52] ¹
Gas Engine 4-Stroke, Lean-Burn	Refinery Fuel Gas	1.17E-04	[15], [52] ¹
Diesel Engine Large, Stationary ³	Distillate (Gas Oil)	5.43E-04	[15], [52] ¹

Notes:

1. Reference [15] is base document, but reference [52] provides emission factors to more significant figures.
2. Factor derived from gas turbines without duct burners.
3. Factor for stack oxygen concentration < 13%

A3.1.2 Catalytic Cracking Unit Regenerator

Mass emitted (kg) = $3.06E-06 \times$ Mass of coke burned (in tonnes)

Reference: [17], Table 1. This reference provides data on the number of data points both above and below the limit of detection. The emission factor is a weighted value using both sets of data – see **Section 5.2** of this report.

A3.1.3 Emissions from a Very Large Refinery

To establish if anthracene could be emitted in excess of the E-PRTR reporting threshold, emissions have been calculated for a very large refinery. The fuel consumed at the refinery is assumed to be $8.4E+07$ GJ/year, of which $3.6E+07$ GJ is due to fuel oil use. The same refinery has a FCCU with a capacity of $2.9E+06$ m³/year, with a resultant coke burn of about 140 000 t/year.

- Fuel oil combusted = $3.6E+07$ GJ/year
- Fuel gas combusted = $4.8E+07$ GJ/year
- FCCU coke combusted = $1.4E+05$ tonnes/year

The emissions from this very large refinery would be:

$$\begin{aligned} &\text{Emissions from oil and gas combustion} \\ &= [(9.37E-07 \times 3.6E+07) + (2.26E-06 \times 4.8E+07)] \times 1.0E-03 = 1.42E-01 \text{ kg} \\ &\text{Emissions from coke burn} = 3.06E-06 \times 1.4E+05 = 4.28E-01 \text{ kg} \end{aligned}$$

Total emissions = 0.57 kg/year

These emissions are significantly less than the E-PRTR reporting threshold of 50 kg/year.

A3.2 NAPHTHALENE

Estimation methods are provided for emissions from:

- Combustion of fuels
- Fluidised catalytic cracking units

A3.2.1 Combustion of Fuels

Mass emitted (kg) = $(EF_{\text{NCV}} \times M \times \text{NCV}) / 1000$

where:

EF_{NCV} = Emission factor (in g/GJ)

M = mass of fuel combusted (in tonnes)

NCV = net calorific value of the fuel combusted (in MJ/kg)

Values for the emission factor EF_{NCV} are provided in **Table A3.2**.

Reference: [15].

Table A3.2 Naphthalene Emission Factors for Combustion Sources

SOURCE	FUEL	EF _{NCV} g/GJ	REF
Furnaces and Boilers	Refinery Fuel Oil	1.83E-04	[15], [52] ¹
	Gas	1.86E-04	[15], [52] ¹
Gas Turbine	Distillate (Gas Oil) ²	1.58E-02	[24], Section 3.1, Table 3.1-4
	Gas ³	3.48E-04	[15], [52] ¹
Gas Engine 4-Stroke, Lean-Burn	Refinery Fuel Gas	5.54E-02	[15], [52] ¹
Diesel Engine Large, Stationary ⁴	Distillate (Gas Oil)	5.75E-02	[15], [52] ¹

Notes:

- Reference [15] is base document, but reference [52] provides emission factors to more significant figures.
- Factor derived from turbines operating at high ($\geq 80\%$) loads.
Factor provided in reference [24] derived using HHV of 139 MBtu/10³ US gal.
- Factor derived from gas turbines without duct burners.
- Factor for stack oxygen concentration < 13%

A3.2.2 Catalytic Cracking Unit Regenerator

Mass emitted (kg) = 5.59E-05 × Mass of coke burned (in tonnes)

Reference: [17], Table 1. This reference provides data on the number of data points both above and below the limit of detection. The emission factor is a weighted value using both sets of data – see **Section 5.2** of this report.

A3.2.3 Emissions from a Very Large Refinery

To establish if naphthalene could be emitted in excess of the E-PRTR reporting threshold, emissions have been estimated for the very large refinery described in **Section A3.1.3**.

- Fuel oil combusted = 3.6E+07 GJ/year
- Fuel gas combusted = 4.8E+07 GJ/year
- FCCU coke combusted = 1.4E+05 tonnes/year

The emissions from this refinery would be:

Emissions from combustion
 = [(1.83E-04 × 3.6E+07) + (1.86E-04 × 4.8E+07)] × 1.0E-03 = 1.55E+01 kg
 Emissions from FCCU coke burn = 5.59E-05 × 1.4E+05 = 7.83E+00 kg

Total emissions = 23.3 kg/year

These emissions are less than the E-PRTR reporting threshold of 100 kg/year.

APPENDIX 4 NMVOC EMISSIONS FROM GASOLINE MARKETING FACILITIES

Neither marketing distribution terminals (i.e. road tanker gasoline loading facilities which are not located on a refinery site) nor service stations are regulated under the terms of the IPPC Directive [1] and hence are not required to submit data for the E-PRTR.

Algorithms are provided in this Appendix, however, as emission estimates for distribution terminals and service stations may be made by oil companies for their own environmental reporting purposes.

A 4.1 DISTRIBUTION TERMINALS

The major sources of emissions at terminals are the storage and loading of gasolines. As there is negligible methane in refined transport fuels, it can be assumed that there are no emissions of CH₄.

A 4.1.1 Storage Tanks

Use the methodologies provided in **Section 13.9**.

A 4.1.2 Loading of Mobile Containers

Use the methodologies provided in **Section 13.8**.

A 4.1.3 Fugitive Emissions from Components

Emissions can occur due to leakage past seals, flanges, etc., on components installed in product pipelines and loading systems e.g. pump seals, connectors.

The emissions from fugitives at terminals are very much lower than at refineries because the systems do not operate at such high pressures. The emission factors provided in **Section 13.5**, which were derived from measurements on refinery process plants, should not be used to estimate fugitive emissions at distribution terminals. Equivalent emission factors for terminal equipment are provided in reference [34], Table 2-3. Emissions from this source are typically less than 1 tonne/year for high throughput terminals.

A 4.1.4 Oil-Water Separators

The emission factors provided in **Section 13.6** have been derived from measurements on oil-water separators at refineries and are not appropriate for facilities at distribution terminals due to the differences in inlet conditions.

Emissions can be considered to be negligible if good maintenance and operating procedures are in place.

A 4.2 SERVICE STATIONS

Algorithms are provided for the following sources:

- Storage tanks
- Automobile refuelling

Gasoline vapour emissions at service stations can be controlled using “vapour balancing” techniques:-

Storage tank filling: When the storage tank is filled the vapours normally vented to atmosphere can be fed back into the tanker cargo tank (compartment) from which the gasoline is being off-loaded. This technique is called “Stage 1b” vapour balancing.

Automobile Refuelling: When an automobile is being refuelled, the vapours normally vented to atmosphere from the fuel tank can be fed back to the service station storage tank from which the gasoline was dispensed. This technique has been mandated in the majority of EU countries and is called “Stage 2” vapour balancing. An alternative, which has been mandated in the USA, is to enlarge the carbon canister fitted on the automobile to control fuel system hot-soak emissions so that refuelling emissions can also be captured.

Other emissions comprise storage tank “breathing” due to evaporation of the gasoline in the tank, and drips and minor spillage during automobile refuelling.

The emissions can be estimated from:

$$\text{Mass emitted (kg)} = \text{EF} \times \text{VOL}_{\text{DISP}} \times \text{TVP}$$

where:

EF = Emission Factor from **Table A4.3** depending on source and activity.

VOL_{DISP} = Volume of gasoline dispensed (in m³).

TVP = True Vapour Pressure of gasoline at storage temperature (in kPa).

Reference: [7], Section 3.

Table A4.3 NMVOC Emission Factors for Service Stations

SOURCE / ACTIVITY		EMISSION FACTOR (EF) kg/m ³ /kPa
Storage Tank	Filling without Stage 1b	2.44E-02
	Filling with Stage 1b in operation	1.10E-03
	Breathing	3.30E-03
Automobile Refuelling	Refuelling with no emission controls in operation	3.67E-02
	Refuelling with Stage 2 in operation	5.50E-03
	Drips and minor spillage	2.20E-03

Gasoline TVP can be calculated from:

$$\mathbf{TVP = RVP \times 10^{(7.047E-06 \times RVP + 1.392E-02) \times TEMP + (2.311E-04 \times RVP - 5.236E-01)}}$$

where:

RVP = Reid Vapour Pressure (in kPa)

TEMP = Gasoline storage temperature (in degrees Centigrade)

If the storage tank temperature is unknown, for the estimation of annual emissions TEMP can be assumed to equal the average annual ambient temperature.

Reference: [7], Annex 1.

APPENDIX 5 CONVERSION FACTORS AND DEFAULT FUEL VALUES

To convert from Higher Heating Value (HHV) to Net Calorific Value (NCV), the following approach, as used in reference [19], was taken.

$$\text{NCV} = \text{HHV} \times \text{Correction Factor for heat of vaporisation of water in the fuel (CF}_{\text{H}_2\text{O}})$$

For Liquid Fuels, Correction Factor (CF_{H₂O}) = 0.95

For Gaseous Fuels, Correction Factor (CF_{H₂O}) = 0.9

Reference: [19], Section 4.2.

To convert Emission Factor from lb/MBtu_(HHV) to g/GJ_(NCV)

$$\text{EF g/GJ}_{(\text{NCV})} = (\text{EF lb/MBtu}_{(\text{HHV})} / \text{CF}_{\text{H}_2\text{O}}) \times (\text{g / lb}) \times (\text{MBtu / GJ})$$

To convert Emission Factor from lb/10³ gal to g/GJ_(NCV)

$$\text{EF g/GJ}_{(\text{NCV})} = \text{EF lb/10}^3 \text{ gal} \times (10^3 \text{ gal / MBtu}_{(\text{NCV})}) \times (\text{g / lb}) \times (\text{MBtu / GJ})$$

To convert Emission Factor from lb/10⁶ scf to g/GJ_(NCV)

$$\text{EF g/GJ}_{(\text{NCV})} = \text{EF lb/10}^6 \text{ scf} \times (10^6 \text{ scf / MBtu}_{(\text{NCV})}) \times (\text{g / lb}) \times (\text{MBtu / GJ})$$

Unless otherwise stated, emission factors were calculated using the following heating values expressed in their original units.

FUEL	HIGHER HEATING VALUE (HHV)	REFERENCE
Distillate (gas oil)	140 MBtu / 10 ³ gal	[56]
Diesel Fuel	137 MBtu / 10 ³ gal	[56]
Refinery Fuel Oil	150 MBtu / 10 ³ gal	[56]
LPG	94 MBtu / 10 ³ gal	[56]
Propane	91.5 MBtu / 10 ³ gal	[21] Section 1.5.3.1
Natural Gas	1020 MBtu / 10 ⁶ scf	[21] Section 1.4.1

Some useful conversion factors

Refinery Fuel Oil

$$1 \text{ lb/10}^3 \text{ US gal} = 3.017 \text{ g/GJ}_{(\text{NCV})}$$

$$1 \text{ lb/10}^6 \text{ Btu}_{(\text{HHV})} = 453 \text{ g/GJ}_{(\text{NCV})}$$

Distillate (Gas Oil)

1 lb/10³ US gal = 3.233 g/GJ_(NCV)

1 lb/10⁶ Btu_(HHV) = 453 g/GJ_(NCV)

LPG

1 lb/10³ US gal = 4.815 g/GJ_(NCV)

Propane

1 lb/10³ US gal = 4.946 g/GJ_(NCV)

Natural Gas

1 lb/10⁶ scf = 0.468 g/GJ_(NCV)

1 lb/10⁶ Btu_(HHV) = 478 g/GJ_(NCV)

Concauwe
Boulevard du Souverain 165
B-1160 Brussels
Belgium

Tel: +32-2-566 91 60
Fax: +32-2-566 91 81
e-mail: info@concauwe.org
website: <http://www.concauwe.org>

ISBN 978-2-87567-046-5



9 782875 670465 >