Visy Pulp and Paper Tumut CEMS - Exceedance Report

15/07/2026

Reporting Period: 1/07/2025 - 1/07/2026 **Environment Protection Licence No:** 10232

Main Stack 1

Monitoring Location No: 1
Monitoring Type Continuous
Sample Type: Air
Description: Exit point from Stack 1 to atmosphere

Opacity **Period:** 6 Minutes **Limit:** 20.00 %

Start Time	End Time	Cause	Operational State	Explanation	Corrective Action	Max Reading
02/07/25 02:12	02/07/25 02:18:	Power Boiler EP	Equipment Issue/Failure	ESP Field 2 offline with a potential dead short, this causes opacity to be exceeded at times when soot blowing the boiler.	Boiler will be shut for repairs in the ESP on July 7th	20.96
04/07/25 02:00	04/07/25 02:06:	Power Boiler EP	Equipment Issue/Failure	ESP Field 2 offline with a potential dead short, this causes opacity to be exceeded at times when soot blowing the boiler.	Boiler will be shut for repairs in the ESP on July 7th	20.92
06/07/25 13:54	06/07/25 14:00:	Power Boiler EP	Equipment Issue/Failure	ESP Field 2 offline with a potential dead short, this causes opacity to be exceeded at times when soot blowing the boiler.	Boiler will be shut for repairs in the ESP on July 7th	20.51
09/07/25 23:06	09/07/25 23:18:	Lime Kiln B ESP	Equipment Issue/Failure	Kiln B overflow chute blocked, clearing the blockage caused high CO in the Kiln that tripped the ESP's	Chute cleared and plant stabilized	60.20
06/08/25 04:36	06/08/25 04:42:	Power Boiler	Equipment Issue/Failure	Load burners tested and then while soot-blowing was done operator noticed very high load on boiler with opacity exceeded, it was then found that one of the gas burners air dampers was stuck in the open position causing the high load.	Gas burner air valve closed, and boiler load returned to normal bringing opacity back to normal	20.58
16/08/25 23:36	16/08/25 23:42:	Lime Kiln B ESP	Equipment Issue/Failure	CO Swing with CPR stopping and starting a few times causing the ESP to trip	CPR Stabilized and plant stabilized	57.65
29/08/25 20:30	29/08/25 20:42:	Lime Kiln B ESP	Equipment Issue/Failure	CO swing caused by CPR issues starting and stopping tripping the ESP	CPR stabilized and plant conditions improved, ESP restarted	31.82
26/09/25 16:06	26/09/25 16:18:	Power Boiler	Equipment Issue/Failure	Fuel Rotary feeder tripped, gas burner fired up and with extra air from the burner flue gas system was overloaded and caused the exceedance.	Rotary feeder blockage cleared and restarted, and gas burner removed, opacity back to normal.	26.83
26/10/25 18:06	26/10/25 19:24:	Power Boiler	Equipment Issue/Failure	Power boiler tripped due to high furnace pressure caused by a blocked fuel chute letting go of build-up and the sudden ignition of the large volume of fuel caused the high pressure trip.	Boiler restarted and stabilized	89.59
26/10/25 20:54	26/10/25 21:00:	Recovery Boiler A ESP2	Equipment Issue/Failure	Cross chain conveyor motor failed causing the ESP to trip	Motor replaced and ESP was restarted.	23.90

				to trip.		
06/11/25 16:18	06/11/25 16:30:	Recovery Boiler A ESP1/ESP2	Equipment Issue/Failure	RBA Tripped on low drum level caused by Mill upset, ESP's offline	Boiler restarted and stabilized.	45.94
11/11/25 14:30	11/11/25 14:48:	Power Boiler	Equipment Issue/Failure	Power Boiler tripped due to drive issue causing ID Fan to trip	Boiler restarted and stabilized	27.28
05/12/25 08:48	05/12/25 08:54:	Recovery Boiler A ESP2	Equipment Issue/Failure	EP 2 field 1 stopped - Restarted same - DCS checked as no alarms active on DCS and found temp drop on Insulator heater that's why Field dropped out - W/O in for investigation	Field 2 back online with no trips after insulator temperature was restored.	27.42
09/12/25 15:30	09/12/25 15:36:	Lime Kiln A ESP	Equipment Issue/Failure	Shear pin broke on Ash drag chain conveyor tripping the Kiln the pin was replaced and Kiln started, during the Purge cycle the opacity was exceeded.	Plant started and stabilized.	23.09
14/12/25 23:06	14/12/25 23:18:	Recovery Boiler A ESP2	Equipment Issue/Failure	The field 1 insulator temperature readings drops out and fails to zero, causing the Precipitator to trip on low insulator temperature (< 85'C)	After testing - suspect the temperature transmitter is faulty - replaced the transmitter on 15 Dec	38.45
15/12/25 09:54	15/12/25 10:06:	Recovery Boiler A ESP2	Equipment Issue/Failure	The field 1 insulator temperature tripped on low temperature after the transmitter was replaced.	The reading was real as the heater was offline during the replacement of the transmitter and the temperature dropped below 85'C	36.63
19/12/25 13:06	19/12/25 13:12:	Lime Kiln A	Equipment Issue/Failure	High CO spike from lime kiln tripped the main flame. Opened smoke box big rock/build up.	Used ring blaster to break down rock. Restart kiln and ESP	46.33
20/12/25 05:30	20/12/25 05:36:	Lime Kiln B	Equipment Issue/Failure	Lime kiln flame out, most likely due to dust. Opacity exceedance due to purge for a restart.	Purge and restart, ESP back online. Continue investigation on reason for flame out.	21.10
29/12/25 19:12	29/12/25 19:24:	Lime Kiln B	Equipment Issue/Failure	Lime kiln B flame tripped on low flue gas flow, EMD investigating. Replaced transmitter but cable also faulty still working on issue. (18H19)	Kiln exceeded on Opacity while purging for startup after repairs to flue gas flow transmitter	40.85
09/01/26 14:24	09/01/26 14:30:	Lime Kiln B ESP	Equipment Issue/Failure	Ops cleaned Lime mud Disc Filter, causing the exceedance.	Filter cleaned and conditions returned to normal.	21.23
20/01/26 01:42	20/01/26 02:42:	Recovery Boiler A ESP1/ESP2	Equipment Issue/Failure	Lost Mixing tank agitator on low tank level causing All ash conveyors to stop and also tripped out both ESP 1 & 2	Equipment restarted but had some issues with ash overloading causing delays in getting all equipment online.	89.57
23/01/26 04:42	23/01/26 04:48:	Power Boiler	Equipment Issue/Failure	ESP Field 2 tripped	Electrical department had a look but nothing out of the ordinary was found, Field 2 restarted and back online	20.46
13/02/26 16:06	13/02/26 16:12:	Lime Kiln A	Equipment Issue/Failure	Lime Kiln A tripped out on a High CO spike.	Kiln A restarted and stabilized.	36.83
16/02/26 08:12	16/02/26 08:24:	Recovery Boiler A ESP2	Equipment Issue/Failure	ESP 2 Field 3 voltage dropping off	No reason found, will do internal inspection during next outage	20.53
16/02/26 08:30	16/02/26 08:42:	Recovery Boiler A ESP2	Equipment Issue/Failure	ESP 2 Field 3 voltage dropping off	No reason found, will do internal inspection during next outage	21.43
17/02/26 13:18	17/02/26 13:36:	Recovery Boiler A ESP2	Equipment Issue/Failure	RBA EP # 2 field # 3 underperformed (low voltage) causing opacity. E&I inspected, found nothing, Ops added bias to EP # 1, and voltage came good to normal values.	Further Investigation required. Ongoing monitoring	64.63

18/02/26 01:00	18/02/26 01:24:	Recovery Boiler A ESP2	Equipment Issue/Failure	01:03-01:25-Opacity exceedance, EP#2 Field#2 tripped, Shift Electrician could not open panel door of field 2 to do the reset, we had to stop field #3 to access field 2 panel door from field 3 to open the door of field #2 and do the reset.	Panel door lock latch repaired, Cause of the trip could not be determined.	72.96
23/02/26 22:12	23/02/26 22:18:	Recovery Boiler A ESP2	Equipment Issue/Failure	EP2 field 3 voltage and milli amps are dropping away continuously. E&I tried to put into continuous rap on MCC panel but was unsuccessful. Had to manually activate the contactor. That did not help either.	Will investigate external sources and also plan for internal inspections with the next Planned shut.	20.25
19/03/26 00:36	19/03/26 00:42:	Power Boiler EP	Equipment Issue/Failure	There was a blockage in fuel rotary feeder 2, when it was cleared the chute emptied into the furnace which led to the CO spike tripping the ESP.	Fuel was allowed to burn off before starting the ESP and the fuel feed to the boiler.	25.42
21/03/26 19:24	21/03/26 19:36:	Recovery Boiler A ESP1/ESP2	Equipment Issue/Failure	Power Surge during storm tripped both ESP 1 / 2 causing exceedance	Both ESPs restarted and back to normal operation.	46.11
02/04/26 10:30	02/04/26 10:36:	Lime Kiln B ESP	Equipment Issue/Failure	Kiln B Tripped due to the Gas Generator oil pump tripping taking the plant out on Interlock, Opacity was during the Pre-Start Purging	Plant restarted and stabilized	23.27
05/04/26 05:48	05/04/26 06:00:	Lime Kiln B ESP	Equipment Issue/Failure	Kiln ESP Tripped due to a high CO spike causing the exceedance.	Plant Stabilized and ESP restarted.	34.06
16/04/26 05:54	16/04/26 06:00:	Lime Kiln B	Equipment Issue/Failure	Cleaning the backend dislodged a buildup and overloaded the 1st and 2nd fields of the ESP, causing the exceedance.	Chute cleaned and opacity returned to normal.	22.16
08/05/26 10:00	08/05/26 10:06:	Lime Kiln B	Equipment Issue/Failure	Swapping of lube oil filters on the Gas generator oil system tripped the Kiln Main Flame, Opacity was exceeded during the Purge cycle.	Kiln re-started and stabilized.	25.78
19/05/26 02:30	19/05/26 02:36:	Lime Kiln B	Equipment Issue/Failure	Plant was running normal and we got a spike on opacity on LKB and MSA. It recovered within minutes on its own.	Likely a bit of build-up that came loose. Plant was stable since.	20.34
07/06/26 02:30	07/06/26 02:36:	Lime Kiln B ESP	Equipment Issue/Failure	Kiln ESP tripped while feed inlet chute was cleaned, High CO Spike	Plant stabilized and ESP back online.	22.73
07/06/26 10:48	07/06/26 10:54:	Lime Kiln A ESP	Equipment Issue/Failure	Kiln A ESP tripped due to a high CO Spike caused by process upset	Plant Stabilized and ESP restarted	40.29

Sulphur Dioxide (SO2) **Period:** 60 Minutes **Limit:** 250.00 mg/Nm3

Start Time	End Time	Cause	Operational State	Explanation	Corrective Action	Max Reading
06/11/25 18:00	06/11/25 20:00:	Recovery Boiler A	Equipment Issue/Failure	Recovery boiler A tripped due to low drum level caused by RBB tripping on low Instrument air pressure, this caused the SOG / NCG Gasses to divert to the Power Boiler	Plants sorted out and stabilized, Gas diverted back to RBA	297.66
09/02/26 05:00	09/02/26 07:00:	Recovery Boiler A	Equipment Issue/Failure	Igniter on Burner 3 Failed: NCG and SOG Gasses diverted to Power Boiler to Steam out the Flame Arrestors - On call Electrician called out as shift Electrician was busy on Paper machine.	E&I called to replace igniter: Igniter replaced and steaming of system Completed, Gasses returned to the Recovery Boiler.	265.47

Main Stack 2

Monitoring Location No: 22

Monitoring Type Continuous

Sample Type: Air

Description: Exit point from Stack 2 to atmosphere

Opacity **Period:** 6 Minutes **Limit:** 20.00 %

Start Time	End Time	Cause	Operational State	Explanation	Corrective Action	Max Reading
27/10/25 12:06	27/10/25 12:18:	Recovery Boiler B ESP2	Equipment Issue/Failure	ESP SIR set 3 lost load causing the opacity exceedance.	Load recovered but not fully, investigating issue, but opacity is back in spec.	34.68
04/11/25 17:30	04/11/25 17:36:	Recovery Boiler B ESP2	Equipment Issue/Failure	Issues with field 3 loading still looking for solution	Will action with next Planned Shut Down	20.05
04/11/25 17:42	04/11/25 17:48:	Recovery Boiler B ESP2	Equipment Issue/Failure	Issues with field 3 loading, still trying to find solution.	Will action with next Planned Shut Down	20.33
10/11/25 15:36	10/11/25 15:48:	Recovery Boiler B ESP2	Equipment Issue/Failure	ESP Field 3 load dropped off causing the Opacity.	Boiler load reduced during this time, ESP field 3 powered back up and boiler returned to normal load.	20.64
10/11/25 15:54	10/11/25 16:00:	Recovery Boiler B ESP2	Equipment Issue/Failure	ESP Field 3 load dropped off causing the Opacity.	Boiler load reduced during this time, ESP field 3 powered back up and boiler returned to normal load.	20.79
15/11/25 12:24	15/11/25 12:30:	Recovery Boiler B ESP1	Equipment Issue/Failure	Suspect Bias between ESP1 and 2 was too high causing ESP1 to exceed. (Bias was increased to take more load on ESP 1 than 2)	Bias reduced to take some load of from ESP1.	20.75
17/11/25 23:42	17/11/25 23:54:	Recovery Boiler B ESP1	Equipment Issue/Failure	ESP 1 Fields 1 and 3 Powered down causing the exceedance.	Will ask E&I TO investigate this issue	21.08
29/11/25 13:54	29/11/25 14:18:	Recovery Boiler B ESP2	Equipment Issue/Failure	Field 3 on ESP2 tripped	Field reset and started; we have a planned shut on Dec.16th to investigate field 1	23.70
30/11/25 13:36	30/11/25 13:42:	Recovery Boiler B ESP1	Equipment Issue/Failure	Field 1 tripped and caused the other 2 fields to overload dropping all load causing the exceedance.	E&I Department asked to investigate why this field would trip, but at the moment no explanation was given yet.	28.63