



FOR A BETTER WORLD

# Visy Pulp and Paper Tumut CEMS - Exceedance Report

Reporting Period: 1/07/2022 - 1/07/2023 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
17/07/22 09:36	17/07/22 09:48:	Lime Kiln A	Lime Kiln A Un Scheduled Start-up/Shut-down	Hammer crusher tripped causing the main drive to trip, kiln down and tripped again on restart with high CO	Plant restarted again and stabilized	28.99
18/07/22 06:54	18/07/22 07:00:	Lime Kiln B ESP	Normal (Steady State)	Kiln ESP tripped due to high CO while cleaning the feed chute	ESP restarted and plant stabilized	45.31
18/07/22 12:06	18/07/22 12:12:	Lime Kiln B ESP	Normal (Steady State)	Kiln ESP tripped due to high CO after flushing the lime feed pump.	ESP restarted and plant stabilized	41.65
20/07/22 01:00	20/07/22 01:06:	Lime Kiln A	Normal (Steady State)	Plant tripped due to high CO exceedance	Plant restarted and stabilized	26.96
23/07/22 02:00	23/07/22 02:06:	Lime Kiln A	Normal (Steady State)	Lime kiln ESP Tripped due to high CO	ESP restarted and plant stabilized	38.61
23/07/22 02:12	23/07/22 02:18:	Lime Kiln A	Normal (Steady State)	Lime kiln ESP Tripped due to high CO	ESP restarted and plant stabilized	35.24
04/08/22 10:30	04/08/22 10:36:	Lime Kiln A	Normal (Steady State)	Kiln ESP tripped due to a high CO spike causing the exceedance.	Equipment restarted and plant stabilized	30.75
16/08/22 07:24	16/08/22 07:36:	Lime Kiln B ESP	Normal (Steady State)	Kiln B ESP tripped due to a high CO spike.	Equipment restarted and plant stabilized.	62.02
16/08/22 07:54	16/08/22 08:00:	Lime Kiln B ESP	Normal (Steady State)	Blowing out the smoke box caused the opacity exceedance	Task completed and plant stabilized.	20.80
18/08/22 02:18	18/08/22 02:42:	Lime Kiln B ESP	Normal (Steady State)	High CO causing ESP to trip, having some operational upsets.	Plant stabilized and equipment restarted,	64.99
27/09/22 09:00	27/09/22 09:12:	Lime Kiln B	Normal (Steady State)	Kiln reduced to blow out the ID Fan, causing the exceedance	Plant returned to normal conditions and stabilized.	38.68
28/09/22 15:30	28/09/22 15:36:	Lime Kiln A ESP	Normal (Steady State)	Kiln ESP tripped due to high CO Spike	Equipment restarted and plant stabilized.	20.54
29/09/22 06:54	29/09/22 07:00:	Lime Kiln A	Lime Kiln A Un Scheduled Start-up/Shut-down	Kiln tripped due to high CO	Plant restarted, adjusted and stabilized	34.06

01/10/22 02:48	01/10/22 02:54:	Lime Kiln A ESP	Normal (Steady State)	ESP Tripped due to low O2, causing high CO spike taking out the Precipitator.	Plant adjusted and equipment restarted.	41.54
25/10/22 12:18	25/10/22 12:24:	Lime Kiln A ESP	Lime Kiln A Un Scheduled Start-up/Shut-down	Kiln A ESP tripped due to a high CO spike.	Plant stabilized and ESP restarted	29.22
29/10/22 19:24	29/10/22 19:42:	Lime Kiln B ESP	Normal (Steady State)	While cleaning Teflon chute and Lime mud disc filter the process had a high CO spike causing the ESP to trip	Equipment restarted and plant stabilized.	46.29
05/12/22 13:18	05/12/22 13:24:	Lime Kiln B	Normal (Steady State)	Cleaning the disc filter chutes admitted too much lime in the feed end causing the opacity exceedance.	Plant stabilized after cleaning, monitoring process	32.07
20/12/22 17:54	20/12/22 18:06:	Lime Kiln B ESP	Normal (Steady State)	Trip Precip on high CO while cleaning the back end.	Restart the Precip, back to normal. Will calibrate O2 sensor on 21 Dec mornings as part of further investigation on the trip.	60.53
25/12/22 20:24	25/12/22 20:36:	Recovery Boiler A ESP1	Normal (Steady State)	ESP 1 TR3 tripped --> reason unknown	Reset and ran since without any issues	27.11
26/12/22 16:24	26/12/22 16:48:	Lime Kiln B	Lime Kiln B Un Scheduled Start-up/Shut-down	LK B tripped	Had to purge and restart LK B	32.33
26/12/22 17:24	26/12/22 17:36:	Lime Kiln B	Lime Kiln B Un Scheduled Start-up/Shut-down	LK B tripped	Had to purge and restart LK B	26.66
03/01/23 07:06	03/01/23 07:18:	Lime Kiln B ESP	Normal (Steady State)	Kiln ESP tripped due to a high CO spike	Plant process adjusted and equipment restarted.	53.12
05/01/23 15:42	05/01/23 15:48:	Lime Kiln B ESP	Normal (Steady State)	Kiln ESP tripped due to high CO	Plant process adjusted and equipment restarted.	47.22
06/01/23 05:06	06/01/23 05:18:	Lime Kiln B ESP	Normal (Steady State)	ESP tripped due to a CO spike	Plant stabilized and ESP restarted	58.31
06/01/23 17:54	06/01/23 18:00:	Lime Kiln B	Normal (Steady State)	Kiln ESP Tripped due to a CO spike	Plant stabilized and equipment restarted	25.19
07/01/23 18:06	07/01/23 18:18:	Lime Kiln B	Normal (Steady State)	Kiln ESP tripped due to a High CO spike.	Plant stabilized and ESP started	68.59
19/01/23 04:00	19/01/23 04:12:	Lime Kiln B ESP	Normal (Steady State)	Exceedance due to a CO spike	Process adjusted and equipment restarted.	58.37
28/01/23 05:00	28/01/23 05:18:	Lime Kiln B	Normal (Steady State)	Kiln ESP tripped due to high CO spike	Plant stabilized and ESP re-started	58.12
29/01/23 02:18	29/01/23 02:24:	Lime Kiln B ESP	Normal (Steady State)	Kiln ESP tripped due to a high CO spike	Plant stabilized and equipment restarted	23.95
29/01/23 13:00	29/01/23 13:06:	Recovery Boiler A ESP2	Normal (Steady State)	Field 3 on ESP 2 tripped out.	Field 3 reset and started with no further issues.	47.99
09/02/23 16:24	09/02/23 16:30:	Lime Kiln B	Lime Kiln A Un Scheduled Start-up/Shut-down	Kiln tripped due to lime feed screw tripping	Plant restarted and stabilized	20.04
24/02/23 10:48	24/02/23 11:06:	Lime Kiln B	Lime Kiln B Un Scheduled Start-up/Shut-down	Kiln B Burner tripped.	Burner restarted and plant stabilized.	33.16
14/03/23 09:00	14/03/23 09:30:	Lime Kiln B	Lime Kiln B Un Scheduled Start-up/Shut-down	Kiln B tripped on gas generator issues	Repairs done and plant restarted	44.88

29/03/23 21:06	29/03/23 21:18:	Recovery Boiler A	RB A Un Scheduled Start-up/Shut-down	Recovery boiler A tripped on drum level caused by upset in the Instrument air system causing most of the mill to be down	Plant restored and mill restarted and stabilized,	24.54
30/03/23 08:24	30/03/23 08:30:	Power Boiler	Power Boiler Un Scheduled Start-up/Shut-down	We had the fuel be sintered and the plant was shut down	Cleaning out the sand bed and restarting the boiler when cleaned	31.39
31/03/23 03:06	31/03/23 03:12:	Power Boiler	Normal (Steady State)	New fuel trial seems to have a lot more dust than regular fuel.	We sintered the bed after a few hours stopping fuel.	21.71
31/03/23 03:18	31/03/23 03:48:	Power Boiler	Normal (Steady State)	New fuel trial seems to have a lot more dust than regular fuel.	We sintered the bed after a few hours stopping fuel.	31.73
31/03/23 08:06	31/03/23 08:42:	Power Boiler	Power Boiler Un Scheduled Start-up/Shut-down	We had the fuel be sintered and the plant was shut down	Cleaning out the sand bed and restarting the boiler when cleaned	66.24
15/04/23 13:24	15/04/23 13:30:	Lime Kiln B	Power Boiler Un Scheduled Start-up/Shut-down RB B Un Scheduled Start-up/Shut-down	Cleaning of boiler sand bed creating lots of dust with precipitates off (isolated) Kiln Burner Failed, trouble shooting and multiple start attempts	Issue found with the Gas Generator, this unit was replaced, and plant was started with no remaining issues.	20.46
17/04/23 14:42	17/04/23 14:48:	Lime Kiln B	Normal (Steady State)	Some process upsets causing the exceedance.	Plant stabilized and monitored	26.88
30/04/23 10:30	30/04/23 10:36:	Power Boiler	Normal (Steady State)	Tested load burners and had issues with the air dampers not closing causing a pressure swing in the flue gas resulting in the exceedance	Dampers sorted out and boiler settled down.	25.45
08/06/23 17:42	08/06/23 17:54:	Power Boiler	Normal (Steady State)	Opacity exceeded due to operations testing the load burners and did not notice the air damper was stuck open, causing the ID fan to increase quite a bit resulting in the exceedance.	Damper was noticed open after about 47 minutes, this was then closed and the opacity reduced to normal levels.	26.57
13/06/23 15:54	13/06/23 16:24:	Lime Kiln B	Lime Kiln B Un Scheduled Start-up/Shut-down	ID Fan vibration picked up.	Plant stopped and ID impeller fan cleaned, plant restarted and stabilized	33.39
21/06/23 16:54	21/06/23 17:00:	Power Boiler EP	Normal (Steady State)	Power boiler EP Field 2 cycled down to 43mA from 200mA causing the exceedance	Performance not too good on this field as it cycles between 267mA to <40mA, This issue could be internal which will be a MSD task, ongoing monitoring.	24.90
26/06/23 05:36	26/06/23 05:42:	Power Boiler EP	Normal (Steady State)	Opacity was caused during sootblowing the power boiler	Will monitor and also do more sootblowing as it looks like we have a lot of ash in the boiler	20.26

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

Start Time	End Time	Cause	Operational State	Explanation	Corrective Action	Max Reading
01/08/22 11:00	01/08/22 17:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Gasses diverted to Power boiler due to mill upset and not firing liquor in RBA	Mill settled down, firing liquor and diverted gasses back to Recovery boiler.	325.18
04/08/22 22:00	05/08/22 00:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Gasses diverted to Power boiler due to Digester issues requiring us to cut liquor flow to protect	Issues sorted out and mill restarted, gasses back to Recovery Boiler A	348.35

Start Time	End Time	Operational State	Cause	Explanation	Corrective Action	Max Reading
02/09/22 04:00	02/09/22 05:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Upset with Digester top separator blockage causing liquor firing to stop in RBA and gasses diverted to Power Boiler.	Plant settled and all issues resolved, liquor firing resumed and gasses returned to Recovery boiler.	264.33
08/09/22 09:00	08/09/22 10:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Gasses diverted to power boiler to replace burner tip.	Burner returned to service and gasses diverted back to the Recovery boiler.	299.50
16/09/22 11:00	16/09/22 15:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Digester upset with top separator, reducing Recovery boiler A and diverting gasses to Power boiler	Recovery back to full firing and gasses back to RBA	364.03
18/09/22 07:00	18/09/22 12:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Recovery boiler A still on low firing due to Digester upset and gasses diverted to PB.	Recovery boiler on full load and gasses diverted back.	329.39
24/09/22 13:00	24/09/22 16:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Upsets in the mill required liquor reduction on the Recovery boilers, NCG gasses diverted to Power boiler during this time.	Issues resolved and gasses diverted back to the Recovery boiler A.	332.95
24/09/22 17:00	24/09/22 22:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Upsets in the mill required liquor reduction on the Recovery boilers, NCG gasses diverted to Power boiler during this time.	Issues resolved and gasses diverted back to the Recovery boiler A.	384.16
07/10/22 08:00	07/10/22 10:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Load reduced due to Digester issues, gasses diverted to Power Boiler	Recovery boiler load increased and gasses diverted back to RBB	278.72
07/10/22 12:00	07/10/22 13:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Load reduced due to Digester issues, gasses diverted to Power Boiler	Recovery boiler load increased and gasses diverted back to RBB	306.90
07/10/22 16:00	07/10/22 17:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Load reduced due to Digester issues, gasses diverted to Power Boiler	Recovery boiler load increased and gasses diverted back to RBB	314.40
25/10/22 17:00	25/10/22 21:00:	Power Boiler	Burning NCG/Stripper Gases in Power Boiler	Gasses diverted to power boiler due to low liquor firing	Liquor firing increased as inventory improved	266.92
30/03/23 01:00	30/03/23 03:00:	Recovery Boiler A	RB A Un Scheduled Start-up/Shut-down	Recovery boiler A tripped on drum level caused by upset in the Instrument air system causing most of the mill to be down	Plant restored and mill restarted and stabilized,	339.32

## 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
09/09/22 17:00	09/09/22 17:12:	Recovery Boiler B ESP2	Normal (Steady State)	SIR set on Field 1 tripped out causing the exceedance.	SIR Unit restarted and opacity brought back in spec.	28.17