



STATE OF WASHINGTON
DEPARTMENT OF ECOLOGY

PO Box 47600, Olympia, WA 98504-7600 • 360-407-6000

July 28, 2022

Phil Oyer, Environmental Manager
Emerald Kalama Chemical, LLC
1296 Third Street NW
Kalama, Washington 98625

Re: Class 1 Water Quality Inspection on April 1, 2022

Dear Phil Oyer:

Enclosed is a copy of the report for the non-sampling water quality inspection I conducted at Emerald Kalama Chemical, LLC (Emerald) on April 1, 2022. The purpose of the inspection was to determine Emerald's level of compliance with NPDES permit number WA0000281.

The inspection included a visual examination of the anaerobic treatment system (ANTS); biological treatment (BIOX) plant; other wastewater treatment system units; Outfalls 001, 002 and 003; intake cooling water structure and filter backwash water filters; and portions of the main process area. Emerald appeared to comply with their NPDES permit at the time of the inspection.

Thank you for your time during the inspection. If you have any questions, please contact me at (360) 819-6426 or greg.gould@ecy.wa.gov.

Sincerely,

Gregory Gould, P.E.
Industrial Section
Solid Waste Management Program



Water Quality Compliance Inspection Report Industrial Section

Facility Name & Address:	Emerald Kalama Chemical, LLC 1296 Third Street NW Kalama, Washington 98625
NPDES Permit Number:	WA0000281
Date of Inspection:	April 1, 2022
Ecology Representatives:	Greg Gould Scott Fobes
Emerald Representative:	Phil Oyer
Report by:	Greg Gould
Supervisor Review by:	Shingo Yamazaki
Report Date:	April 20, 2022

Scott Fobes and I arrived at Emerald Kalama Chemical, LLC (Emerald) around 9:45 AM on April 1, 2022 for an announced Class 1 (non-sampling) water quality inspection and site visit. We met with Emerald's Environmental Manager Phil Oyer who accompanied us during the inspection, which included a visual examination of the anaerobic treatment system (ANTS); biological treatment (BIOX) plant; other wastewater treatment system units; Outfalls 001, 002 and 003; intake cooling water structure and filter backwash water filters; and portions of the main process area. I discussed the findings of the inspection with Phil Oyer and exited the facility around 12:50 PM.

Site Background

Emerald owns a 155-acre property on the Columbia River near the town of Kalama, Washington. The facility is on the northern end of the Kalama Industrial Park, bounded at the north by a man-made wetland, west by the river, and east by Interstate 5. Emerald is a manufacturer of organic chemicals. The chemical plant operates 24 hours a

day, 7 days a week. Using toluene as the raw material, the plant produces an estimated 170,000 tons of chemicals per year. The products include benzoic acid, benzaldehyde, benzyl alcohol, benzyl amine, sodium and potassium benzoate, cinnamic aldehyde, dibenzyl amine, benzyl acetate, benzyl salicylate, and Lilience®. The products are used in food preservatives, fragrances, perfumes, adhesives, resins, coatings, dyes, detergents, sun screens, and solvents.

The facility has a National Pollutant Discharge Elimination System (NPDES) permit, number WA0000281, for the discharge of treated wastewater and non-contact cooling water into the Columbia River. The NPDES permit became effective on March 1, 2021 and expires on February 28, 2026.

Description of Wastewater Treatment Plant

The wastewater treatment plant (WWTP) consists of a flow equalization system, anaerobic treatment system (ANTS), and biological treatment (BIOX) plant. The system can treat up to 400 gallons per minute (gpm) of wastewater, including contaminated groundwater from the North and West Impacted Areas, stormwater from process and non-process areas, process wastewater, and laboratory wastewater.

Flow Equalization System

The flow equalization system is comprised of numerous collection and equalization tanks within each of the main process areas. Alarm systems are set up on many of the equalization tanks to ensure that the WWTP operates as designed.

Anaerobic Treatment System (ANTS)

The ANTS provides pretreatment for acid wastewater from the benzoic acid processes and the wastewater generated during production of hexyl cinnamic aldehyde. The system consists of three digesters and two clarifiers. The system is designed for a COD loading of 14,000 pounds per day and a maximum flow of 35 gpm. Emerald pumps the ANTS effluent to tank T-22 and surge tank T-90. T-22 and T-90 also hold wastewater from the API oil/water separator. Wastewater from the tanks flows to the BIOX plant.

Biological Treatment Plant (BIOX)

The BIOX plant consists of two aeration tanks, three clarifiers, and a digester unit. Wastewater enters aeration tank T-91A and then aeration tank T-92. The tanks contain blowers for air sparging. The optimum temperature of wastewater in T91A is from 24 to 26 degrees Celsius (°C).

Wastewater in T-92 overflows to two secondary clarifiers, T-96 and T-96A, which operate in parallel. Each clarifier has an apparatus to skim floating sludge and deposit it in a sump, where it is pumped back to T-91A. The clarifier bottoms are returned back to T-91A as recycled activated sludge. Flows from the top of the clarifiers enter the third

“polishing” clarifier T-93. Operators can maintain constant hydraulics to the system by pumping T-93 bottoms back to aeration tank T-91A as needed. Employees monitor the depth to the sludge surface in the clarifiers daily to maintain an optimal depth of 10 to 12 feet.

The BIOX plant is designed to handle a COD loading of 5,000 pounds per day. Staff sample T-91A feed twice a day for COD. They also monitor for ammonia, phosphorus, and mixed liquor suspended solids. Emerald controls the COD and hydraulic loading to the plant through routine sampling and uses weir boxes to double-check flow rates to T-91A.

Emerald adds polymers to the clarifiers as a flocculant. A higher molecular weight polymer is added to the sludge in the SOMAT to improve de-watering. During the day and night shifts, staff take water samples from the aeration tanks, clarifiers, and the final effluent. Operators visually compare the sample jars and check for solids coagulation.

Sludge Management

Waste sludge from the BIOX plant clarifiers (T-96 and T-96A) flows to the sludge holding tank and then to a SOMAT unit. The SOMAT dewateres the waste sludge to about 8.5 to 9.5 percent solids. Water removed by the SOMAT returns to aeration tank T-91A. Emerald disposes of the sludge at a RCRA permitted landfill in Arlington, Oregon.

Site inspection

Wastewater Treatment System

We inspected the American Petroleum Institute (API) oil/water separator. Phil Oyer said Emerald cleans out the solids from the API oil/water separator and manages the solids as dangerous waste. I noted no issues with the API oil/water separator at the time of inspection.

We observed the ANTS and Phil Oyer described the wastewater process. I noted no issues with the ANTS at the time of inspection.

We observed the BIOX and Phil Oyer described the wastewater process. We inspected aeration tank T-91A and the weir boxes. We viewed the following weir boxes (WB):

- WB T-103B - Untreated wastewater flow from Modu-tank T-103B
- WB T-22 - Anaerobic treatment plant effluent
- WB T-96 RAS - Bottoms from clarifier T-96
- WB T-96A RAS - Bottoms from clarifier T-96A

- WB T-93 - Bottoms from clarifier T-93.

Phil Oyer said that Emerald completed the repairs on aeration tank T-92 that had been in planning for many years. We observed clarifier T-96. I noted solids floating on the surface of the water, which Phil Oyer stated was normal. I observed the clarifier overflow water was clear. At the time of the inspection, the SOMAT was running. We observed the SOMAT screw press that dewateres the industrial wastewater biological solids. I noted no issues with the BIOX at the time of inspection.

We inspected the Modu-tanks T-103A and T-103B. Both Modu-tanks had some water and appeared to be operating properly.

Outfalls

The outfalls and sampling stations are near the intake pump house by the Columbia River. Monitoring Point 002, which is BIOX effluent, flows through a weir box before entering a mixing basin. At the time of the inspection, the BIOX effluent was clear.

An automated composite sampler normally collects 500 mL/hour from the Monitoring Point 002 weir box. The compositor unit also has a refrigerator to cool the sample. The digital thermometer in the refrigerator was 5.3°C and Emerald has the thermometer calibrated every year. The flow and pH at Monitoring Point 002 were 201 gpm and 8.02 standard units. Emerald's Monitoring Point 002 pH discharge limit is between 6.0 and 9.0 standard units.

The treated process wastewater from Monitoring Point 002 combines with non-contact cooling water in the mixing basin and Emerald discharges it through Outfall 001 to the Columbia River through a submerged diffuser port. At the time of the inspection, the mixing basin appeared clear, had no odor, and no debris. In addition, the temperature at Outfall 001 fluctuated around 21.7°C, which was below the permit limit of 40.7°C.

Outfall 003 is rarely used. Discharge to this outfall only occurs in the situation where the holding capacity of the berm enclosing tanks T-70 and T-71 is exceeded during heavy rain. The last time Emerald discharged to Outfall 003 was in January 2002.

I noted no issues with the Monitoring Point 002, mixing basin, and Outfall 003 at the time of inspection.

Intake Cooling Water Structure and Filter Backwash Water Filters

We inspected the intake pump house, which includes the traveling screens and pumps. We also inspected the filter backwash water filters, which are located just north of the intake pump house. Phil Oyer described the sampling locations and flow measurement locations Emerald plans to use for the NPDES permit required Filter Backwash Water Characterization Study. I noted no issues with the intake cooling water structure and filter backwash water filters at the time of inspection.

Process Areas

We observed process areas where Emerald collects stormwater. Phil Oyer explained that Emerald routes all stormwater that falls within the process area to the API oil/water separator. I noted no issues with the stormwater collection system in the process area at the time of inspection.

Conclusion

Emerald appeared to comply with their NPDES permit at the time of the inspection.

Water Compliance Inspection Report

Section A: National Data System Coding (i.e., PCS)

Transaction Code		NPDES										yr/mo/dy					Inspection Type		Inspector		Facility Type	
1 <u>N</u>	2 <u>5</u>	3 <u>W</u>	<u>A</u>	<u>0</u>	<u>0</u>	<u>0</u>	<u>2</u>	<u>8</u>	<u>1</u>	11	12	<u>2</u>	<u>2</u>	<u>0</u>	<u>4</u>	<u>0</u>	<u>1</u>	17	18 <u>C</u>	19 <u>S</u>	20 <u>2</u>	
Remarks																						
21		<u>A</u>	<u>N</u>	<u>N</u>	<u>O</u>	<u>U</u>	<u>N</u>	<u>C</u>	<u>E</u>	<u>D</u>	<u>C</u>	<u>L</u>	<u>A</u>	<u>S</u>	<u>S</u>	<u>1</u>					66	
Inspection Work Days			Facility Self-Monitoring Evaluation Rating										B1		QA		-----Reserved-----					
67		<u>4</u>	69	70 <u>5</u>					71 <u>N</u>					72 <u>N</u>	73	74	75			80		

Section B: Facility Data

Name and Location of Facility Inspected <i>(For industrial users discharging to POTW, also include POTW name and NPDES permit number)</i> Emerald Kalama Chemical, LLC 1296 Third Street NW Kalama, Washington 98625	Entry Time/Date 9:45 a.m. 04/01/2022	Permit Effective Date March 1, 2021
	Exit Time/Date 12:50 p.m. 04/01/2022	Permit Expiration Date February 28, 2026
Name(s) of On-Site Representative(s)/Title(s)/Phone and Fax Number Phil Oyer, Environmental Manager Phone: (360) 673-0305	Other Facility Data <i>(e.g., SIC NAICS, and other description information)</i> SIC – 2869, 2865 NAICS – 325199, 325194	
Name, Address of Responsible Official/Title/Phone and Fax Number Galen Hathcock, Site Director Phone: (360) 673-0304		
Contacted <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No		



Section C: Areas Evaluated During Inspection (Check only those areas evaluated)

<input type="checkbox"/> Permit	<input type="checkbox"/> Self-Monitoring Program	<input type="checkbox"/> Pretreatment	<input type="checkbox"/> MS4
<input type="checkbox"/> Records/Reports	<input type="checkbox"/> Compliance Schedules	<input type="checkbox"/> Pollution Prevention	
<input checked="" type="checkbox"/> Facility Site Review	<input type="checkbox"/> Laboratory	<input checked="" type="checkbox"/> Stormwater	
<input checked="" type="checkbox"/> Effluent/Receiving Waters	<input type="checkbox"/> Operations & Maintenance	<input type="checkbox"/> Combined Sewer Overflow	
<input checked="" type="checkbox"/> Flow Measurement	<input checked="" type="checkbox"/> Sludge Handling/Disposal	<input type="checkbox"/> Sanitary Sewer Overflow	

Section D: Summary of Findings/Comments

(Attach additional sheets of narrative and checklists, including Single Event Violation codes, as necessary)

The facility appeared to be in compliance on the day of the inspection. See attached report.

Verify Latitude and Longitude 46.02097, -122.85675		<input checked="checked" type="checkbox"/> Announced <input type="checkbox"/> Unannounced
Name(s) and Signature(s) of Inspector(s)  Greg Gould	Agency/Office/Home and Fax Numbers Washington State Department of Ecology, Solid Waste Management, Industrial Section Phone:(360) 407-6934	Date 04/01/2022
Signature of Management A Q Reviewed  Shingo Yamazaki	Agency/Office/Phone and Fax numbers Washington State Department of Ecology, Solid Waste Management, Industrial Section Phone:(360) 515-8479	Date 04/01/2022

