**SPRING 2024 WESTERN CANADA BLRBAC MEETING**

**Apr 30th / 2024**

**Richmond, British Columbia**

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**Agenda Members Closed Session Apr 30th / 2024**

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**Tuesday Apr 30/ 2024**

(Meeting Room: Whistler A BallRoom)

Great Canadian Breakfast 8-8:45am

Attendees - See link

8:30 a.m. – Closed Business Meeting for Western Canada BLRBAC Members

1. Introduction of New Members & Guests - Greg Burns - Director Power & Recovery DOMTAR. Presenting at the end of Incidents. Lots of first time attendees this session.

2. Review minutes of Fall Meeting [MINUTES- Agenda Closed Session Nov 14 / 2023](https://docs.google.com/document/d/1MFVodEKWaOLYeIy7hvIlTM7sCzzAFllxNS6AdO4sqtE/edit?usp=drive_link)

Mike Bates Reviewed.

3. Treasurer’s Report - Mike Bates. Feb 29 start date 2024. Should be approx $7200 in the bank minus $5000 deposit for the fall session. Newly updated fees are keeping us sustainable with enough money to maintain the website and any other fees that come up.

4. Correspondence - NONE

5. Old Business- No Update

6. Discussion of Submitted Incidents -

ANGELO PORCETTA - Howe Sound PE. Boiler Leak back end of the economizer. Was found during regular walk arounds. Off liquor to repair the man hole weld. Human error with weld failure.

NISHAN reported for Crofton - Gasket issue (Mike to finish)

Blair Ryberg - Gen bank issue that was identified. An operator identified quickly and the event was not nearly as big. (Mike help me describe this)

Shawn Fenner - Skook. Discuss ideal pressure level for the (what ???)

Tom Jurista - how to monitor changes to BLRBAC best practices ? Mike reviewed that WC should be attending Alanta and bring back the best practices discussed there and implement them into our WC. Dino would have reported but is not here this session.

Bill A -HARMAC. Super heater leak found by walkaround. ESP put into effect. 2 cracked super heater tubes.

Walked down, shift engineer. Suspected another super heater leak and ESP again. IN fact there were another couple tubes leaking. Took the 2 weeks down to do the unplanned repair. Could not take the chance to wait 6 weeks until the planned outage.

3rd incident - Engineer noticed moisture on theRD6 Gen Bank floor. ESP again, more tube leaks were repaired.

Leaking tubes Shawn - Corrosion cold trial time 3-4 hours.

Greg Burns - Spring 2024 Atlanta BLRBAC. 20 incidents. 3 critical. 4 dissolving tank explosions. Reviewed the ESP events and 100% of the ESP’s should have been.

* Most leaks are in the economizer area. First place to see the water. Celgar has seen 4 leaks here due to weld failure. [Shawn Fenner](mailto:Shawn.Fenner@paperexcellence.com) reviewed Skook replaced last year.
* Top leak cause - weld failure, then thinning
* How discovered - majority on walk downs. Found upon hydro after shutdown.
* 40% of the mills have leak detection and none were found by the system
* ESP time from initial indication ranged from 45 secs to 189 minutes. Median time is 56mins.
* Reviewed incident rates and the trends show rising but explosions decreasing.
* Discussed average Recovery Boiler age: 47.5 years max age 77 in Canada.
* **INCIDENT** - Georgia Pacific- Dissolving tank explosion. Aug 14/2023. Kept the boiler down for 30 days to train operators to react more efficiently. Not many companies would do this. Continued to run with only one spout flowing which is already a violation of the mill's own safety protocol. #1 agitator alarms there was no eyes on check at this point. 2 hrs later #2 agitator alarms and now both #1 and 2 have both lost their belts. Field operator injured at time of explosion. He was wearing the gortex PPE coat for spout deck workers but it came up from underneath. 1985 changed from solid concrete floor to grating ( this should be solid, not grating) and the worker was standing directly over the only place the explosion would occur.
* **LEARNINGS**- increase manual TTA checks to every 30m from 4 hrs.

High alarm, should have done field check at that point.

MOC procedures must be used

Firing rates must be limited when number of spouts flowing is reduced. There must be standard rates established and SOP’d for max rates when 1,2,3,4 spouts are flowing.

ESTABLISH a max time limit for siring liquor if there is no smelt flow

Obtain a copy of AFPA “recommendations for dissolving tank safety”

Review high furnace pressure trip settings.

Make sure it is not the SOFL - Site of a Future Leak. Welding a pinhole is unlikely to not hold, and high probability of recurrence.

7. Committee Reports

7.1 PAPTAC - B&W representative (no one went)

7.2 Eastern BLRBAC - Blair Rydberg - 2023 Sherbrooke QC. Previous meeting was back in 2019. Mill tour, w/ 40ppl attending. 5 presentations, including one by Blair will do tomorrow. 149 years old, one of the oldest mills in Canada.

7.3 Atlanta BLRBAC - Greg Burns. Venue changing. Quality is poor, moving it to the Hilton. Costs will increase for hotel nights by $100 per night. Greg to send to Mike: Boiler stats slide. October 7,8,9 2024 for Fall Session. Mike Bates. Add document link from Atlanta to our site.

7.4 Action/Advisory Committee - Remove this item.

7.5 Steering Committee - Mike Bates-

7.6 Recovery Statistics report -

8. Chiefs Only Meeting (11:00-11:30) No Public Minutes for this.

**SKOOK**- [Shawn Fenner](mailto:Shawn.Fenner@paperexcellence.com) Canvas group what group wants the meeting to look going forward. Leverage Greg Burns more. 30+ years experience. Angelo says yes. Mike says yes.

ACTION - Bill A: Steering committee to develop a “Best Practices” guidebook. Is there an appetite to pay Greg for that service? Or is it just within the Mill Representative role. Prob no cost required per the group. Consider moving to Feb from November or move us to before Atlanta to reverse the info flow.

Shawn Fenner/Jeff - Skook is now Resolute. Greg Burns oversees all of it, PE, resolute. Next year will be a full turbine rebuild and will be the first mill in Canada to burn hog in the (kiln) process. Recaust - trying new sock. LOP changes for operators. Starting real on the job training with a union training coordinator.

**HARMAC**- Bill Albertson- Challenges. Lack of trades, contractors and workers for shutdowns. Got to be a Better way to coordinate with the mills and contractors. LOA is a bigger driver whether trades will come to one shut vs. another. Business decision at the corporate level. Mills are going to18 month rotations. Some mills have tried 18 and gone back to 12. Reviewed the Shut Calendar 2024 from BC Labour Relations calendar.

**HINTON** Launy McKay -. Now a Mondi mill. PB3 had some Economizer leaks. Hydrogen leak was fixed. Engineering is happening now for all upgrades Mondi wants to do.

**CANADIAN KRAFT PAPER**  Blair Rydberg. Manitoba. Super heater install 2018 , wrong length of hockey stick and now tunes are burning out. Dan Hotel is leaving (Chief) so they are looking as well. The Manitoba exam is becoming a problem to pass.

**HOWE SOUND**- Angelo Porcetto - Teck Safety BC increasing their expectations making things difficult. WorkSafe implemented the spout guidelines and there is some reluctance to implement all the changes until sure they will stick and not change. Some injuries popping up, stairs and scrolling on phones rolling an ankle. Skills of new and young workers overall are seemingly low of late regarding industrial experience. Chemical Acid cleaning: They haven’t previously done it but [Mike Bates](mailto:mikebates50@gmail.com) reviewed Celgar had to adopt it in order to get insurance w/ FM Global to go to 18m shut cycle. Annual shut coming up.

**MERCER PEACE RIVER** Keith Bentham - Floor denting in the boiler is the biggest issue rn. Put a new soot blower in to try to make it to shutdown. Still don;t understand why it is only building up in one corner. Generators are getting old, and will need a major rebuild in the near future. Trades shortage means cannot do both at the same time. FM has started to ask more questions around kilns which means there will be more focus on risk around kilns. Had to step up the super heater replacement. Screening is a big issue. PB showing membrane cracking.

Rumors of a nuclear plant coming to PR area.

**CROFTON -** Mike Bates **Celga**r frist. [Mike Bates](mailto:mikebates50@gmail.com) left January and Jeremy Lodge took over but resigned after a few months. We have a temp Role in Matt Angus but do have an offer out to a local first class that we are hopeful he will accept.

Rinus has been dealing with TSBC. Mike is laid up after knee surgery so great to have Rinus still supporting. Reliability seems to be a reason they are not as profitable as expected. Haven’t hit the budget in quite some time.

Gortex jackets are being used. Spout floor PPE is still getting push back from Shift Engineers being too hot.

9. Boiler Manufacturers Update (15 minutes for update or presentation + 5 for Q/A). (will be in

alphabetic order)

**Andritz**- Greg Imig. 6m and 2024 lower furnace replacement in Texas, weld overlay within the next 2m. Clearwater Paper, Idaho in June brand new lower furnace going in. South Carolina 3 pass economizer, and a 2pass in Alabama for Fall 2024. Nov 11-13 Kraft Recovery Seminar in Savannah, Georgia. Young engineers, Project ppl. Automated BL gun w/ self cleaning nozzle. Atlanta or the Georgia session above will have a live demo. Bought a shop in Croatia, it’s now up to speed to build just about anything they carry.

**B&W- Al Ankersen.** Bought a company out of bankruptcy. Doing Fossil power systems. Waste to energy plant close to signing, carbon capturing, burner conversions, O2 firing for plant decarbonization.

**BUCKMAN** - Online monitoring for trends.

**GE -** Denise Levesque. Lots of ongoing Problem solving studies. Ash accumulating in PB (oem) Customer in QC spending 5M/yr getting rid of their sludge, working to convert to burn the sludge. Updating drawings to include ages of assets and when they were installed or upgraded.

Pressure Wave, can clean these remotely now, on line. PB upgrade project - to meet new CO emissions.

**JANSEN**- More work on the optimization and tuning side of their business., due to low capital spending. Biomass seminar in Madson , WI

**VALMET -**

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10. New Business

10.1 New Website - [WCBLRBAC](https://www.wcblrbac.com/) is LIVE. Review for new attendees.

10.2 Election for Steering Committee. New 2 year term for all positions 2024-2026 (Admin is not voted on)

* Chairman - Nominations | Shawn Fenner. New Chairman is Mike Bates
* Treasurer - Nominations | Mike Bates. New Treasurer is Shawn Fenner
* 4 Members - Nominations are Keith Bentram, ~~Jeff Hebert~~ (Declined), Angelo Porcetta, James Leithbridge, Johan Opsteen, Kim Koz, Meadow Lake

11. Round Table Discussion – What's New / Well Done / Near Misses / Mill Operating

Problems / Inspections

Harmac - Bill Albertson. Dissolving Tank cleaning - Opened it up and it was spotless switched from 4 wall firing to 2 wall firing. Installed new mini hoods.

SKOOK - Shawn Fenner. Coming soon, Hog firing in the kiln, lower furnace inspection this year. Smelt pumping challenges. PB - the redesign on the gen bank is causing issues. LOP changes. Panel and field ops, 6 person crews. Created union training coordinator position has been really positive. Summer 2024, expected water restrictions.

MONDI Hinton - Launy - TG3 leaks. Clean those up over shut. TG1 fire, back in commission now. Mondi transition.

[Blair Rydberg](mailto:blair.rydberg@gmail.com) Asking the group about Reducing operating pressure of the boiler and deregulating the boiler. Acuren can come and do a full assessment. New Gen bank is recommended.

Howe Sound – Angelo Porchetta - Heading into a shut next week.

MPR - Keith Bentram - new ESP’ valves have 5 settings not 2 as previous. They do not know for sure what the other 2 modes do in between. Just came out of a shut and had a nice safe outage. New Sootblowers went in. Dialing in the order and angles with which they fire now. Lime mud filter. Making sure everyone understands how there can be no holes in it! Near misses- Aug 2022 led to mill blackout. Cooling water lost and never came back on. Spouts replaced.

Jan 2024 another mill blackout, fire water plugged, lost flow. Keith suggests adding a PM to check the gap in the firewater valve. Lot more drone inspections. Loss of knowledge, retirements, a training coordinator would be very helpful.

Mike Bates - Crofton - Been off work for a month now. Added some fans to both precips to bypass the precip when water washing, lots of corrosion in the back of the precips. Weld overlay on their spouts - extreme thinning. Did PMI testing. Chromium was very low at 14% needs to be 24% keep adding overlay until we got to 28%. Fan balancing issues. Amalgamating Domtar, Resolute and Paper Excellence trying to standardize best practices. Took out last 35 feet of the kiln due to delaminating. Just hired a 5th shift engineer. RB audit in mid June. Paper mill will not be coming back up. Down indefinitely.

12. Adjournment