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erthwrks

AIR EMISSIONS TESTING FOR INDUSTRY

Relative Accuracy Test Audit

for

Marathon Petroleum Company LP

at the

Marathon Detroit Refinery in Detroit, MI

on the

North Plant Incinerator (CX-6 SRU)

Unit: EU72-SULRBLOCK2-S1

Permit No. MI-ROP-A9831-2012c

Prepared for:



**Marathon
Petroleum Company LP**

Test Date: September 12, 2023

Erthwrks Project No. 9284.1.C3




Endorsement Page

This report was developed in accordance with the requirements designated in the applicable regulatory permit(s) and/or regulatory rules. To the best of my knowledge the techniques, instrumentation, and calculations presented in this report will serve to accurately and efficiently detail the results of the test campaign requirements.

Erthwrks, Inc.

Name: Jarrold Hoskinson

Title: Senior Project Manager

Signature: 

This report has been reviewed for accuracy and completeness. The actions presented in this report are, to the best of my knowledge, an accurate representation of the results and findings of the test campaign. Erthwrks, Inc. operates in conformance with the requirements on ASTM D7036-04 Standard Practice for Competence of Air Emission Testing Bodies and is accredited as such by the Stack Testing Accreditation Council (STAC) and the American Association for Laboratory Accreditation (A2LA).

Erthwrks, Inc.

Name: John Wood

Title: Technical Director

Signature: 

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1.0 INTRODUCTION

1.1 Identification, location and dates of tests

Erthwrks, Inc. was contracted to conduct emissions testing on the North Plant SRU in operation at the Marathon Detroit Refinery, located in Detroit Michigan. The testing program was conducted on September 12, 2023.

1.2 Purpose of Testing

The exhaust from North Plant SRU was sampled and analyzed to determine the relative accuracy of the associated sulfur dioxide (SO₂) and oxygen (O₂) continuous emissions monitoring system (CEMS) in accordance with the requirements in the Marathon Permit No. MI-ROP-A9831-2012c and the Title 40 CFR Part 60, Appendix F.

1.3 Description of Source

Marathon Petroleum Company LP operates the North Plant SRU (EU72-SULRBLOCK2-S1) under EGLE Renewable Operating Permit No. MI-ROP-A9831-2012c and is required to conduct an annual RATA to demonstrate the relative accuracy of the CEMS associated with this unit.

Table 1.1—Marathon North Plant SRU CEMS Details

North Plant SRU CEMS	Manufacturer	Model No.	S/N	Install Date
SO ₂	ABB	Limas 11	3.342682.1	2012
O ₂	ABB	Magnos 206	3.342283.1	2012

1.4 Contact Information

Marathon Petroleum Company LP

Chase Every
Environmental Engineer
Michigan Refining Division
313-551-6961 office
248-302-0285 cell
crevery@marathonpetroleum.com

Erthwrks, Inc.

John Wood
Technical Director
P.O. Box 150549
Austin, TX 78745
512-585-1685 office
888-573-9994 fax
jwood@erthwrks.com

Erthwrks, Inc.

Jarrod Hoskinson
Senior Project Manager
P.O. Box 150549
Austin, TX 78745
512-994-7487 office
888-573-9994 fax
jhoskinson@erthwrks.com

Erthwrks, Inc.

Jason Dunn
QC Specialist
P.O. Box 150549
Austin, TX 78745
614-565-9177 office
888-573-9994 fax
jdunn@erthwrks.com

Facility Location:

Marathon Petroleum Company LP
Detroit Refinery
1300 South Fort Street
Detroit, MI 48217



2.0 SUMMARY OF RESULTS

Table 2.1— Marathon NP SRU (EU72-SULRBLOCK2-S1) CEMS RATA Results

Pollutant Measured	Performance Specification	Relative Accuracy	Applicable Limit	Pass/Fail
SO ₂ (ppmvd @ 0% O ₂)	Performance Spec. 2	1.1% <i>RA_{AS}</i>	10%	Pass
O ₂ (%vd)	Performance Spec. 3	0.04% <i>RA_{MD}</i>	1%	Pass

3.0 SOURCE DESCRIPTION

3.1 Description of the process

Marathon Petroleum Company LP produces refined petroleum products from crude oil and is required to demonstrate that select process emission sources are operating in compliance with permitted emissions limits.

The North Plant Incinerator, or Sulfur Recovery Unit, removes H₂S from the acid gas and converts it into elemental sulfur using the Claus Process (Trains A and B), the SCOT Tail Gas Treating Unit process (Train No. 1 and No. 2), and associated amine treating equipment. Tail gas is routed to a thermal oxidizer, or incinerator, which oxidizes the remaining H₂S in the tail gas to SO₂ before exhausting to the atmosphere via the SRU Incinerator Stack (SV72-V22). The emission group also consists of process vessels, heaters, tanks, containers, compressors, seals, process valves, flanges, connectors, etc.

3.2 Applicable permit and source designation

Marathon Petroleum Company LP operates the North Plant SRU (EU72-SULRBLOCK2-S1) under EGLE Renewable Operating Permit No. MI-ROP-A9831-2012c and is required to conduct an annual RATA to demonstrate the relative accuracy of the CEMS associated with this unit.

3.3 Type and quantity of materials processed during tests

During the emission testing on September 12, 2023, at the Marathon Petroleum Company LP Refinery, the North Plant SRU was tested while operating at load conditions representative of normal conditions. The load conditions during the testing were documented by Marathon Detroit Refinery and provided in Appendix F.

4.0 SAMPLING AND ANALYTICAL PROCEDURES

4.1 Gaseous Sampling – SO₂ and O₂

For the gaseous sampling, Erthwrks utilized a stainless-steel probe, of sufficient length to reach all sampling points, inserted into a sampling port that is located on the stack in accordance with EPA Method 1. The sample is extracted through the probe, a heated Teflon sampling line, to a heating filter. The sample then enters a minimum contact sample conditioner that cools and removes moisture from the gas matrix prior to entering the Erthwrks sampling manifold.

Erthwrks followed all quality assurance and quality control procedures as defined in US EPA 40 CFR 60 Appendix A. The Calibration Error (CE) Test was conducted as specified in EPA Method 7E §8.2.3. In accordance with this requirement, a three-point analyzer calibration error test was conducted prior to sampling. The CE test was conducted by introducing the low, mid, and high-level calibration gasses (as defined in EPA Method 7E §3.3.1-3) sequentially and the response was recorded. The results of the CE test are acceptable if the calculated calibration error is within $\pm 2.0\%$ of calibration span (or ≤ 0.5 ppmv).

The Initial System Bias and System Calibration Error Check was conducted in accordance with EPA Method 7E §8.2.5. The upscale calibration gas was introduced at the probe upstream of all sample system components and the response recorded. The procedure was repeated with the low-level gas and the response recorded. During this activity, the sample system response time was also recorded. This specification is acceptable if the calculated values of the system calibration error check are within $\pm 5.0\%$ of the calibration span value (or ≤ 0.5 ppmv).

After each test run, the sample system bias check is conducted to validate the run data. The low-level and upscale drift are calculated using Equation 7E-4. The run data is valid if the calculated drift is within $\pm 3.0\%$ of the calibration span value (or ≤ 0.5 ppmv).

After each test run, the corrected effluent gas concentration was calculated as specified in EPA Method 7E §12.6. The arithmetic average of all valid concentration values are adjusted for bias using equation 7E-5B.

The figure below details the Erthwrks gaseous sampling system:

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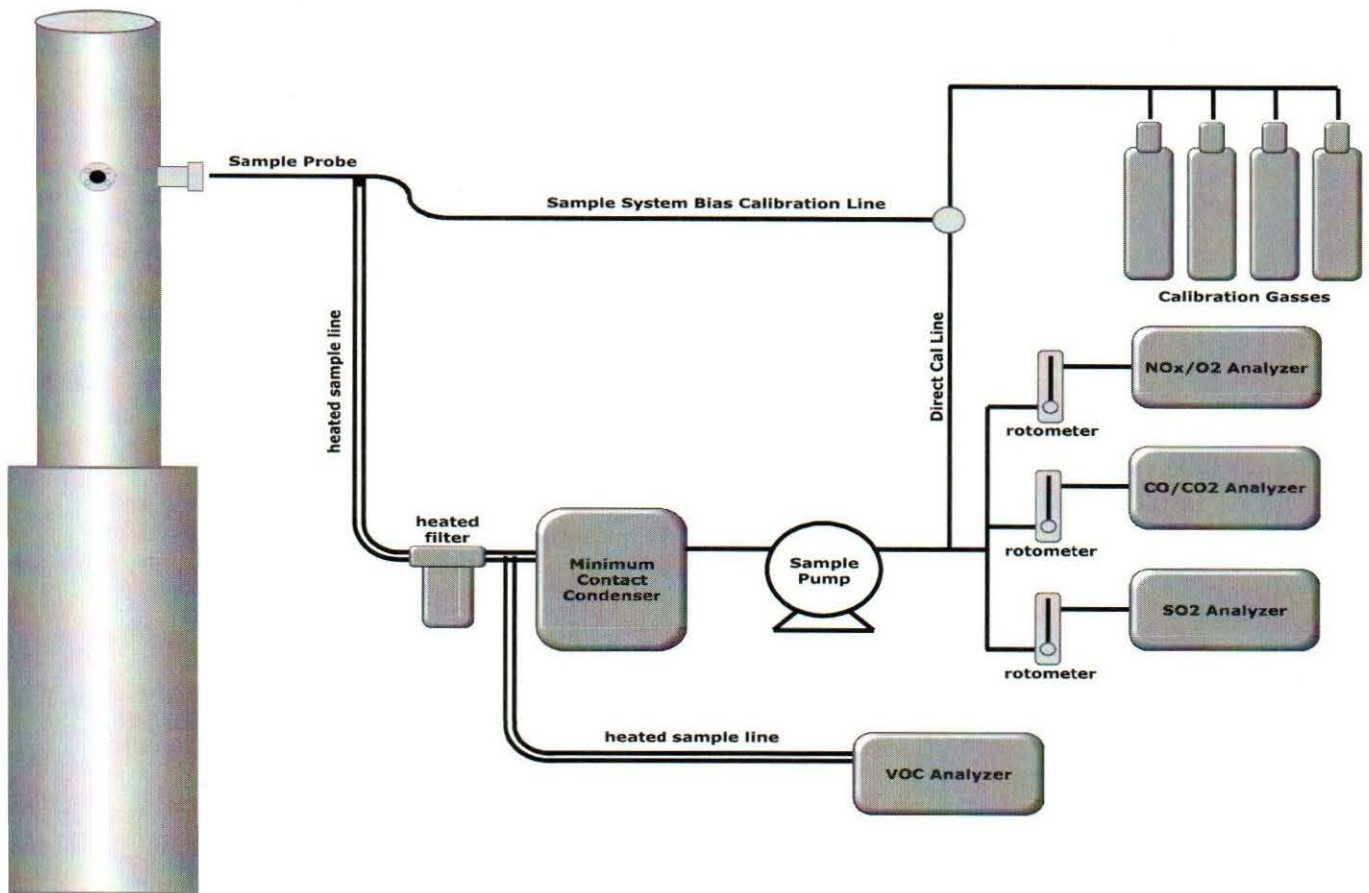


Figure 1: Example Erthwrks Gaseous Sampling System Diagram

4.2 RATA Procedures

The RATA testing was conducted following the sampling and measurement procedures found in the **EPA Part 60, Appendix B, Performance Specifications** which requires that EPA Reference Methods, from EPA Part 60, Appendix A, be utilized to conduct independent stack emissions measurements for comparison with installed CEMS readings. The following performance specifications will be used during this testing program.

- EPA Performance Specification 2 for SO₂ relative accuracy
- EPA Performance Specification 3 for O₂ relative accuracy

As required by these methods, the use EPA Protocol 1 gases are mandatory and were used for this portion of the project.

The RATA test is a direct comparison of the CEMS monitoring data with that data collected from an independently operated EPA Reference Method tests for each pollutant, following all the quality assurance and quality control procedures as required in the reference method. The following EPA reference methods were utilized to complete this testing program:

- EPA Method 3A for the determination of O₂ concentration
- EPA Method 6C for the determination of SO₂ concentration

For this testing program, Erthwrks utilized a calibration gas dilution system, operated in accordance with EPA Method 205, for the generation of the calibration gases used to calibrate the reference method analyzers. This gas dilution system is calibration annual in accordance with section 2.1.1 of this method. This documentation is located in Attachment E. In addition, the gas diluter accuracy was verified on the day of the test in accordance with the Field Evaluation procedure defined in Section 3.2 of the method. This activity is documented in Attachment B and the raw data logs are located in Attachment D.

The reference method sampling locations are defined in the Erthwrks QA/QC worksheet located in Attachment B. Three sampling points were used in accordance with the EPA Performance Specification 2, §8.1.3.2, located at 16.7, 50.0 and 83.3 percent of the stack inner diameter from the port location. Erthwrks sampled at each traverse point individually for 7-minutes per point for each 21-minute test run.

A minimum of nine (9) RATA test runs were conducted at each exhaust stack for a minimum duration of twenty-one (21) minutes for each run. A 3-point traverse located at 16.7%, 50.0%, and 83.3% of the way across the stack (or 0.4, 1.2, and 2.0 meters from the stack wall) was conducted during each RATA test run (7 minutes per point). The results of the reference method tests were compared to CEMS measurement data from the same time periods to determine the relative accuracy of the CEMS.

For SO₂, the results of the RATA test are considered acceptable if the calculated relative accuracy does not exceed 20.0% as calculated by Equation 2-6 in Performance Specification 2. Alternatively, for affected units where the average of the reference method measurements is less than 50 percent of the emission standard (emission limit), the relative accuracy must not exceed 10% when the applicable emission standard is used in the denominator of Eq. 2-6.

For O₂, the results of the RATA test are considered acceptable if the calculated relative accuracy does not exceed 20.0% as calculated by Equation 3.1 in Performance Specification 3. The results are also acceptable if the result of Equation 3-2 is less than or equal to 1.0 percent.

4.3 Discussion of sampling procedure or operational variances

Erthwrks, Inc. conducted the emissions testing with no sampling or procedural variances.

Attachment A
Detailed Results of Emission Test

Erthwrks Relative Accuracy Test Audit--O₂ RATA Performance Specification 3

North Plant SRUO₂ CEMS RATA

Test Run	Run 1	Run 2	Run 3	Run 4	Run 5	Run 6	Run 7	Run 8	Run 9	Run 10
Date	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023
Start Time	8:15	8:36	8:57	9:27	9:48	10:09	10:40	11:01	11:22	11:54
End Time	8:36	8:57	9:18	9:48	10:09	10:30	11:01	11:22	11:43	12:15
RM O ₂ Result (%vd)	2.64	2.69	2.71	2.69	2.64	2.67	2.72	2.68	2.69	2.68
CEMS O ₂ Data (%vd)	2.71	2.76	2.73	2.75	2.70	2.70	2.75	2.71	2.72	2.71
Difference	-0.07	-0.07	-0.02	-0.06	-0.06	-0.03	-0.03	-0.03	-0.03	-0.03
Accept or Reject	Accept	Accept	Accept	Accept	Accept	Accept	Accept	Accept	Accept	Reject

Mean of the Difference (d_{avg})
Standard Deviation (S_d)
Confidence Coefficient (CC)

-0.04
0.02
0.02
0.04%

← Pass

Relative Accuracy via RM, RA_{RM-CEMS}*

*RA_{RM-CEMS} (Reference Method - CEMS) Absolute difference must be less than 1.0%

Erthwrks Relative Accuracy Test Audit--SO₂ RATA Performance Specification 2

North Plant SRU								SO ₂ CEMS RATA - O ₂ Corrected		
Test Run								Corrected to:	0	% O ₂
	Run 1	Run 2	Run 3	Run 4	Run 5	Run 6	Run 7	Run 8	Run 9	Run 10
Date	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023	9/12/2023
Start Time	8:15	8:36	8:57	9:27	9:48	10:09	10:40	11:01	11:22	11:54
End Time	8:36	8:57	9:18	9:48	10:09	10:30	11:01	11:22	11:43	12:15
RM SO ₂ Results (ppmvd)	14.96	15.44	15.32	15.86	15.38	15.62	15.61	15.14	15.13	15.64
RM O ₂ Results (%vd)	2.64	2.69	2.71	2.69	2.64	2.67	2.72	2.68	2.69	2.68
RM SO ₂ Result (ppmvd @ 0% O ₂)	17.12	17.72	17.60	18.20	17.60	17.91	17.95	17.37	17.37	17.94
CEMS SO ₂ Result (ppmvd @ 0% O ₂)	20.08	19.93	19.85	20.36	19.70	20.11	20.43	20.10	19.97	19.93
Difference	-2.96	-2.21	-2.25	-2.16	-2.10	-2.20	-2.48	-2.74	-2.60	-1.99
Accept or Reject	Accept	Accept	Accept	Accept	Accept	Accept	Accept	Accept	Accept	Reject

Applicable Standard (ppmvd @ 0% O₂)

Mean of the Difference (d_{avg})

Standard Deviation (S_d)

Confidence Coefficient (CC)

Relative Accuracy via AS, RA_{AS}[†]

*RA_{RM} (Reference Method) must be less than 20%

†RA_{AS} (Applicable Standard) must be less than 10%

250
-2.41
0.301
0.23
1.06% ← Pass

Attachment B
Quality Control Documentation

Erthwrks Method 1 Traverse Point Location Worksheet

Client: Marathon Petroleum Company
Project #: 9284.1.C3
Facility: Detroit Refinery
Unit ID: North Plant SRU

Stack ID Measurements

Stack ID + Port (inches):	91
Port Extension (inches):	8.5
Stack Diameter (inches):	82.5

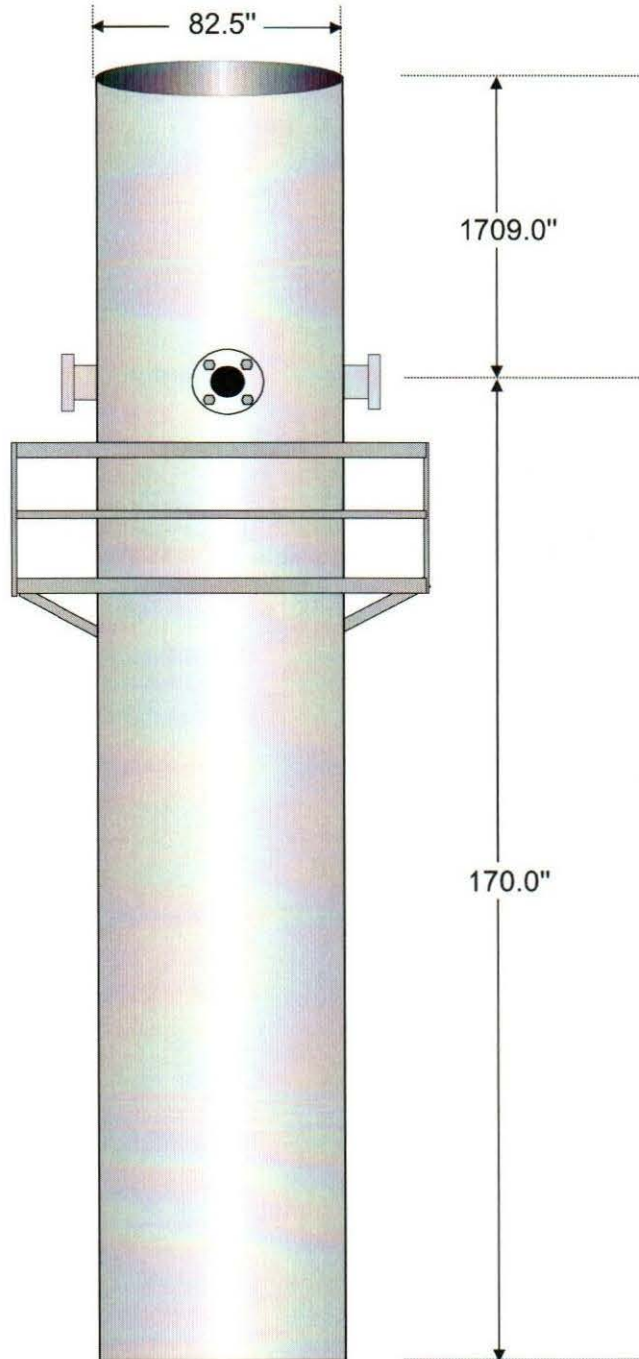
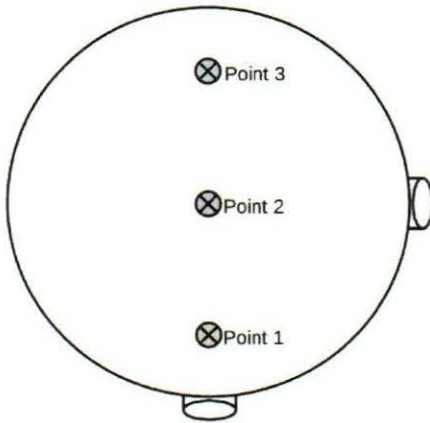
Port Location Measurements

Distance Upstream (A) (inches):	1709
Distance Downstream (B) (inches):	170
Stack Diameters Upstream (A):	20.7
Stack Diameters Downstream (B):	2.1

Total Traverse Points to be used:	3
Traverse Points per Diameter:	3

Traverse Point Locations ⁽¹⁾⁽²⁾	
Point 1:	13.78"
Point 2:	41.25"
Point 3:	68.72"

Stack Cross Section View



⁽¹⁾For stack diameter >4.0" and <2.4 meters, stratification is measured at 16.7%, 50.0%, and 83.3" of stack diameter (M7E, §8.1.2).

⁽²⁾For stack diameter >2.4 meters, stratification is measured at 0.4, 1.2, and 2.0 meters from stack wall (M7E, §8.1.2).