IMPACT COMPLIANCE & TESTING

NSPS EMISSION TEST REPORT

Title:	NSPS EMISSION TEST REPORT FOR THE VERIFICATION OF AIR POLLUTANT EMISSIONS FROM A NATURAL GAS FIRED INTERNAL COMBUSTION ENGINE EMERGENCY GENERATOR SET
Report Date:	July 12, 2019
Test Date(s):	June 27, 2019

Facility Information	
Name:	BASF Corporation
Street Address:	13000 Levan Street
City, County:	Livonia, Wayne
SRN:	N1060

Permit / Emission Unit Information	
Permit to Install No.:	Not Applicable
Emission Unit:	Cummins GTA28, 500 kW, 770 hp SI-RICE genset

Testing Contractor	
Company:	Impact Compliance & Testing, Inc.
Mailing Address:	4180 Keller Road, Suite B Holt, MI 48842
Phone:	(517) 268-0043
Project No.:	1900182

IMPACT COMPLIANCE & TESTING

Executive Summary

BASF CORPORATION
CUMMINS MODEL GTA28 NATURAL GAS FUELED IC ENGINE
EMISSION TEST RESULTS

BASF Corporation (BASF) contracted Impact Compliance & Testing, Inc. (ICT) to conduct a performance demonstration for the determination of nitrogen oxides (NOx), carbon monoxide (CO), and volatile organic compounds (VOC) concentrations from one (1) Cummins Model GTA28 natural gas-fired reciprocating internal combustion engine (RICE) and electricity generator set operated at the BASF facility located in Livonia, Michigan.

While operations at the Livonia facility are regulated under the Michigan Department of Environment, Great Lakes and Energy - Air Quality Division (EGLE-AQD) Permit to Install (PTI) No. 198-00H, the RICE is currently exempt from the requirement to obtain a PTI under Rule 285(2)(g) of the Michigan Air Rules.

The following table presents the emissions results from the performance demonstration.

Emission Unit	NO_x Concentration (ppmvd @ 15% O_2)	CO Concentration (ppmvd @ 15% O_2)	VOC Concentration (ppmvd @ 15% O_2)
RICE	19.3	56.6	1.24
Subpart JJJJ limits	160	540	86

Parts per million by volume, dry basis, corrected to 15% oxygen. VOC concentration is C_3 (propane).

The RICE has a maximum electricity generation rate of 500 kilowatts (kW) and 770 horsepower (hp) and was operated at an average of 465 kW during the performance demonstration.

The data presented above indicate that the RICE was tested while the unit operated within 10% of its maximum capacity (500 kW and 770 hp) and is in compliance with the emission standards specified in 40 CFR 60.4233(e).

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FOR THE
VERIFICATION OF AIR POLLUTANT EMISSIONS
FROM A
NATURAL GAS FUELED INTERNAL COMBUSTION ENGINE
EMERGENCY GENERATOR SET

BASF CORPORATION

1.0 INTRODUCTION

BASF Corporation (BASF) operates a natural gas fired, spark-ignition reciprocating internal combustion engine emergency generator set (SI-RICE genset) located in Livonia, Wayne County, Michigan. The Cummins Model GTA28 SI-RICE genset is currently exempt from the requirement to obtain a PTI under Rule 285(2)(g) of the Michigan Air Rules.

The SI-RICE genset has a horsepower rating of 500 kW and 770 hp and is subject to the SI-RICE New Source Performance Standard (NSPS) codified in 40 CFR Part 60 Subpart JJJJ. The SI-RICE NSPS specifies that:

1. *Owners and operators of stationary SI ICE with a maximum engine power greater than or equal to 75 kW (except gasoline and rich burn engines that use LPG) must comply with the emission standards in Table 1 to this subpart for their stationary SI ICE.*

The compliance testing was performed by Impact Compliance & Testing, Inc. (ICT), a Michigan-based environmental consulting and testing company. ICT representatives Tyler Wilson and Brad Thome performed the field sampling and measurements June 27, 2019.

The exhaust gas sampling and analysis was performed using procedures specified in the Test Plan that was reviewed and approved by the EGLE-AQD in the December 19, 2018 Test Plan Approval Letter. EGLE-AQD representatives Ms. Regina Angellotti and Ms. Jill Zimmerman observed portions of the testing project.

Questions regarding this emission test report should be directed to:

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Report Certification

This test report was prepared by Impact Compliance & Testing, Inc. based on field sampling data collected by Impact Compliance & Testing, Inc. Facility process data were collected and provided by Cummins employees or representatives (hired by BASF). This test report has been reviewed by BASF representatives and approved for submittal to the EGLE-AQD.

I certify that the testing was conducted in accordance with the approved test plan unless otherwise specified in this report. I believe the information provided in this report and its attachments are true, accurate, and complete.

Report Prepared By:

Tyler J. Wilson
Senior Project Manager
Impact Compliance & Testing, Inc.

Responsible Official Certification:

Catherine L Way

Cathy Way
Sr. Operations Engineer
BASF Corporation

2.0 SOURCE AND SAMPLING LOCATION DESCRIPTION

2.1 General Process Description

The SI-RICE genset is classified as an emergency generator and is only operated to provide electricity to the BASF facility during power outages and for periodic maintenance testing.

2.2 Rated Capacities and Air Emission Controls

The Cummins Model GTA28 SI-RICE genset has a rated output of 770 horsepower (HP) and the connected generator has a rated electricity output of 500 kilowatts (kW). The engine is fueled exclusively with pipeline natural gas and equipped with an air-to-fuel ratio controller.

The engine is equipped with a non-selective catalytic reduction (NSCR) system for passively controlling CO, NOx, and hydrocarbon (HC) emissions. The NSCR system consists of two catalyst beds that allow CO and HC to be oxidized by the oxygen that is a component of the NOx. This system relies on a low concentration of oxygen at the catalyst bed inlet. The engine is equipped with controls to adjust the fuel-air-ratio of the engine intake manifold.

The NSCR is passive in nature and its efficiency is dependent on exhaust gas temperature and oxygen content as well as catalyst bed condition. In accordance with 40 CFR 60.4243, the air-to-fuel ration controller is optimized for emissions reduction.

2.3 Sampling Locations

The RICE exhaust gas is released to the atmosphere through two (2) identical vertical exhaust stacks with vertical release points.

The exhaust stack sampling ports for the RICE are located in exhaust stacks with an inner diameter of 4.50 inches. Each stack is equipped with two (2) sample ports, opposed 90°, that provide a sampling location 82.0 inches (18.2 duct diameters) upstream and 48.0 inches (10.7 duct diameters) downstream from any flow disturbance and satisfies the USEPA Method 1 criteria for a representative sample location.

Appendix A provides diagrams of the emission test sampling locations.

3.0 SUMMARY OF TEST RESULTS AND OPERATING CONDITIONS

3.1 Purpose and Objective of the Tests

The provisions of 40 CFR Part 60 Subpart JJJJ require the BASF to test the SI-RICE for carbon monoxide (CO), nitrogen oxides (NOx), and volatile organic compounds (VOC) emissions every 8,760 hours of operation or 3 years, whichever comes first. Measurements were performed for the RICE exhaust to determine CO, NO_X, and VOC (as non-methane hydrocarbons, NMHC) concentrations and diluent gas content (oxygen and carbon dioxide).

3.2 Operating Conditions During the Compliance Tests

The testing was performed while the SI-RICE genset was operated within at least 10% of maximum rated capacity of 500 kW electricity output. Cummins representatives (hired by BASF) provided kW output data at 15-minute intervals for each test period. The SI-RICE genset kW output was 465 kW during the test periods (93% of maximum capacity).

Appendix B provides operating records provided by Cummins representatives for the test periods.

3.3 Summary of Air Pollutant Sampling Results

The gases exhausted from the SI-RICE genset were sampled for three (3) one-hour test periods during the compliance testing performed June 27, 2019. Since the SI-RICE has two (2) exhaust stacks, gases exhausted from each stack were sampled for 30-minutes during each one-hour test.

Table 3.1 presents the average measured CO, NO_X, and VOC emission rates for the SI-RICE (average of the three test periods for the engine) and applicable emission limits.

Results of the engine performance tests demonstrate compliance with emission limits specified in 40 CFR Part 60 Subpart JJJJ. Test results for each one-hour sampling period are presented in Section 6.0 of this report.

Table 3.1 Average measured emission concentrations for the SI-RICE genset (three-test average)

Emission Unit	CO Concentration (ppmvd)†	NOx Concentration (ppmvd)†	VOC Concentration (ppmvd)†
RICE	56.6	19.3	1.24
Emission Standard	540	160	86

† Parts per million by volume, dry basis, corrected to 15% oxygen. VOC concentration is C_3 (propane).

4.0 SAMPLING AND ANALYTICAL PROCEDURES

A protocol for the air emission testing was reviewed and approved by the EGLE-AQD. This section provides a summary of the sampling and analytical procedures that were used during the testing periods.

4.1 Summary of Sampling Methods

USEPA Method 3A	Exhaust gas O_2 and CO_2 content was determined using paramagnetic and infrared instrumental analyzers, respectively.
USEPA Method 4	Exhaust gas moisture was determined based on the water weight gain in chilled impingers.
USEPA Method 7E	Exhaust gas NOx concentration was determined using a chemiluminescence instrumental analyzer.
USEPA Method 10	Exhaust gas CO concentration was measured using an NDIR instrumental analyzer.
USEPA Method 25A /ALT-096	Exhaust gas VOC (as NMHC) concentration was determined using a flame ionization analyzer equipped with an internal methane separation GC column.

4.2 Exhaust Gas Molecular Weight Determination (USEPA Method 3A)

CO_2 and O_2 content in the RICE exhaust gas stream was measured continuously throughout each test period in accordance with USEPA Method 3A. The exhaust gas CO_2 content was monitored using a Servomex 1440D single beam single wavelength (SBSW) infrared gas analyzer. The exhaust gas O_2 content was monitored using a paramagnetic sensor within the Servomex 1440D gas analyzer.

During each sampling period, a continuous sample of the RICE exhaust gas stream was extracted from the stack using a stainless steel probe connected to a Teflon® heated sample line. The sampled gas was conditioned by removing moisture prior to being introduced to the analyzers; therefore, measurement of O_2 and CO_2 concentrations correspond to standard dry gas conditions. Instrument response data were recorded using an ESC Model 8816 data acquisition system that monitored the analog output of the instrumental analyzers continuously and logged data as one-minute averages.

Prior to, and at the conclusion of each test, the instruments were calibrated using upscale calibration and zero gas to determine analyzer calibration error and system bias (described in Section 5.0 of this document). Sampling times were recorded on field data sheets.

Appendix D provides O_2 and CO_2 calculation sheets. Raw instrument response data are provided in Appendix E.

4.3 Exhaust Gas Moisture Content (USEPA Method 4)

Moisture content of the RICE exhaust gas was determined in accordance with USEPA Method 4 using a chilled impinger sampling train. The moisture sampling was performed concurrently with the instrumental analyzer sampling. During each sampling period, a gas sample was extracted at a constant rate from the source where moisture was removed from the sampled gas stream using impingers that were submersed in an ice bath. At the conclusion of each sampling period, the moisture gain in the impingers was determined gravimetrically by weighing each impinger to determine net weight gain.

4.4 NO_x and CO Concentration Measurements (USEPA Methods 7E and 10)

NO_X and CO pollutant concentrations in the RICE exhaust gas streams were determined using a Thermo Environmental Instruments, Inc. (TEI) Model 42c High Level chemiluminescence NO_X analyzer and a TEI Model 48i infrared CO analyzer.

Throughout each test period, a continuous sample of the engine exhaust gas was extracted from the stack using the heated sample line and gas conditioning system described previously in this section. Prior to, and at the conclusion of each test, the instruments were calibrated using upscale calibration and zero gas to determine analyzer calibration error and system bias.

Appendix D provides CO and NO_X calculation sheets. Raw instrument response data are provided in Appendix E.

4.5 Measurement of Volatile Organic Compounds (USEPA Methods 25A / ALT-096)

The VOC emission rate was determined by measuring the nonmethane hydrocarbon (NMHC) concentration in the engine exhaust gas. NMHC pollutant concentration was determined using a TEI Model 55i Methane / Nonmethane hydrocarbon analyzer. The TEI 55i analyzer contains an internal gas chromatograph column that separates methane from non-methane components. The concentration of NMHC in the sampled gas stream, after separation from methane, is determined relative to a propane standard using a flame ionization detector in accordance with USEPA Method 25A.

The USEPA Office of Air Quality Planning and Standards (OAQPS) has issued several alternate test methods approving the use of the TEI 55-series analyzer as an effective instrument for measuring NMOC from gas-fueled reciprocating internal combustion engines (RICE) in that it uses USEPA Method 25A and 18 (ALT-066, ALT-078 and ALT-096).

Samples of the exhaust gas were delivered directly to the instrumental analyzer using the Teflon® heated sample line to prevent condensation. The sample to the NHMC analyzer was not conditioned to remove moisture. Therefore, VOC measurements correspond to standard conditions with no moisture correction (wet basis).

Prior to, and at the conclusion of each test, the instrument was calibrated using mid-range calibration (propane) and zero gas to determine analyzer calibration error and system bias.

Appendix D provides VOC calculation sheets. Raw instrument response data for the NMHC analyzer is provided in Appendix E.

5.0 QA/QC ACTIVITIES

5.1 NO_x Converter Efficiency Test

The NO_2 – NO conversion efficiency of the Model 42c analyzer was verified prior to the testing program. A USEPA Protocol 1 certified concentration of NO_2 was injected directly into the analyzer, following the initial three-point calibration, to verify the analyzer's conversion efficiency. The analyzer's NO_2 – NO converter uses a catalyst at high temperatures to convert the NO_2 to NO for measurement. The conversion efficiency of the analyzer is deemed acceptable if the measured NO_x concentration is greater than or equal to 90% of the expected value.

The NO_2 – NO conversion efficiency test satisfied the USEPA Method 7E criteria (measured NO_x concentration was 100% of the expected value, i.e., greater than 90% of the expected value as required by Method 7E).

5.2 Sampling System Response Time Determination

The response time of the sampling system was determined prior to the compliance test program by introducing upscale gas and zero gas, in series, into the sampling system using a tee connection at the base of the sample probe. The elapsed time for the analyzer to display a reading of 95% of the expected concentration was determined using a stopwatch.

The TEI Model 42c analyzer exhibited the longest system response time at 37 seconds. Results of the response time determinations were recorded on field data sheets. For each test period, test data were collected once the sample probe was in position for at least twice the maximum system response time.

5.3 Gas Divider Certification (USEPA Method 205)

A STEC Model SGD-710C 10-step gas divider was used to obtain appropriate calibration span gases. The ten-step STEC gas divider was NIST certified (within the last 12 months) with a primary flow standard in accordance with Method 205. When cut with an appropriate zero gas, the ten-step STEC gas divider delivered calibration gas values ranging from 0% to 100% (in 10% step increments) of the USEPA Protocol 1 calibration gas that was introduced into the system. The field evaluation procedures presented in Section 3.2 of Method 205 were followed prior to use of gas divider. The field evaluation yielded no errors greater than 2% of the triplicate measured average and no errors greater than 2% from the expected values.

5.4 Instrumental Analyzer Interference Check

The instrumental analyzers used to measure NO_X, CO, O_2, and CO_2 have had an interference response test preformed prior to their use in the field pursuant to the interference response test procedures specified in USEPA Method 7E. The appropriate interference test gases (i.e., gases that would be encountered in the exhaust gas stream) were introduced into each analyzer, separately and as a mixture with the analyte that each analyzer is designed to measure. All of analyzers exhibited a composite deviation of less than 2.5% of the span for all measured interferent gases. No major analytical components of the analyzers have been replaced since performing the original interference tests.

5.5 Instrument Calibration and System Bias Checks

At the beginning the day of the testing program, initial three-point instrument calibrations were performed for the NO_x, CO, CO_2, and O_2 analyzers by injecting calibration gas directly into the inlet sample port for each instrument. System bias checks were performed prior to and at the conclusion of each sampling period by introducing the upscale calibration gas and zero gas into the sampling system (at the base of the stainless steel sampling probe prior to the particulate filter and Teflon® heated sample line) and determining the instrument response against the initial instrument calibration readings.

At the beginning of the test day, appropriate high-range, mid-range, and low-range span gases followed by a zero gas were introduced to the NMHC analyzer, in series at a tee connection, which is installed between the sample probe and the particulate filter, through a poppet check valve. After each one hour test period, mid-range and zero gases were re-introduced in series at the tee connection in the sampling system to check against the method's performance specifications for calibration drift and zero drift error.

The instruments were calibrated with USEPA Protocol 1 certified concentrations of CO_2, O_2, NO_x, and CO in nitrogen and zeroed using hydrocarbon free nitrogen. The NMHC (VOC) instrument was calibrated with USEPA Protocol 1 certified concentrations of propane in air and zeroed using hydrocarbon-free air. A STEC Model SGD-710C ten-step gas divider was used to obtain intermediate calibration gas concentrations as needed.

5.6 Meter Box Calibrations

The Nutech Model 2010 dry gas meter and sampling console, which was used for exhaust gas moisture content sampling, was calibrated prior to and after the testing program. This calibration uses the critical orifice calibration technique presented in USEPA Method 5. The metering console calibration exhibited no data outside the acceptable ranges presented in USEPA Method 5.

The digital pyrometer in the Nutech metering consoles were calibrated using a NIST traceable Omega® Model CL 23A temperature calibrator.

Appendix F presents test equipment quality assurance data (NO_2 – NO conversion efficiency test data, instrument calibration and system bias check records, calibration gas and gas divider certifications, interference test results, and meter box calibration records).

6.0 RESULTS

6.1 Test Results and Allowable Emission Limits

Engine operating data and air pollutant emission measurement results for each one-hour test period are presented in Table 6.1. The serial number (SN) for the RICE is presented at the top of the table.

The measured average air pollutant concentrations for the SI-RICE are less than the allowable limits specified in 40 CFR Part 60 Subpart JJJJ for the engine:

- 540 parts per million by volume, dry basis, corrected to 15% oxygen (ppmvd @ 15% O_2) CO;
- 160 ppmvd @ 15% O_2 NO_x; and
- 86 ppmvd @ 15% O_2 VOC.

6.2 Variations from Normal Sampling Procedures or Operating Conditions

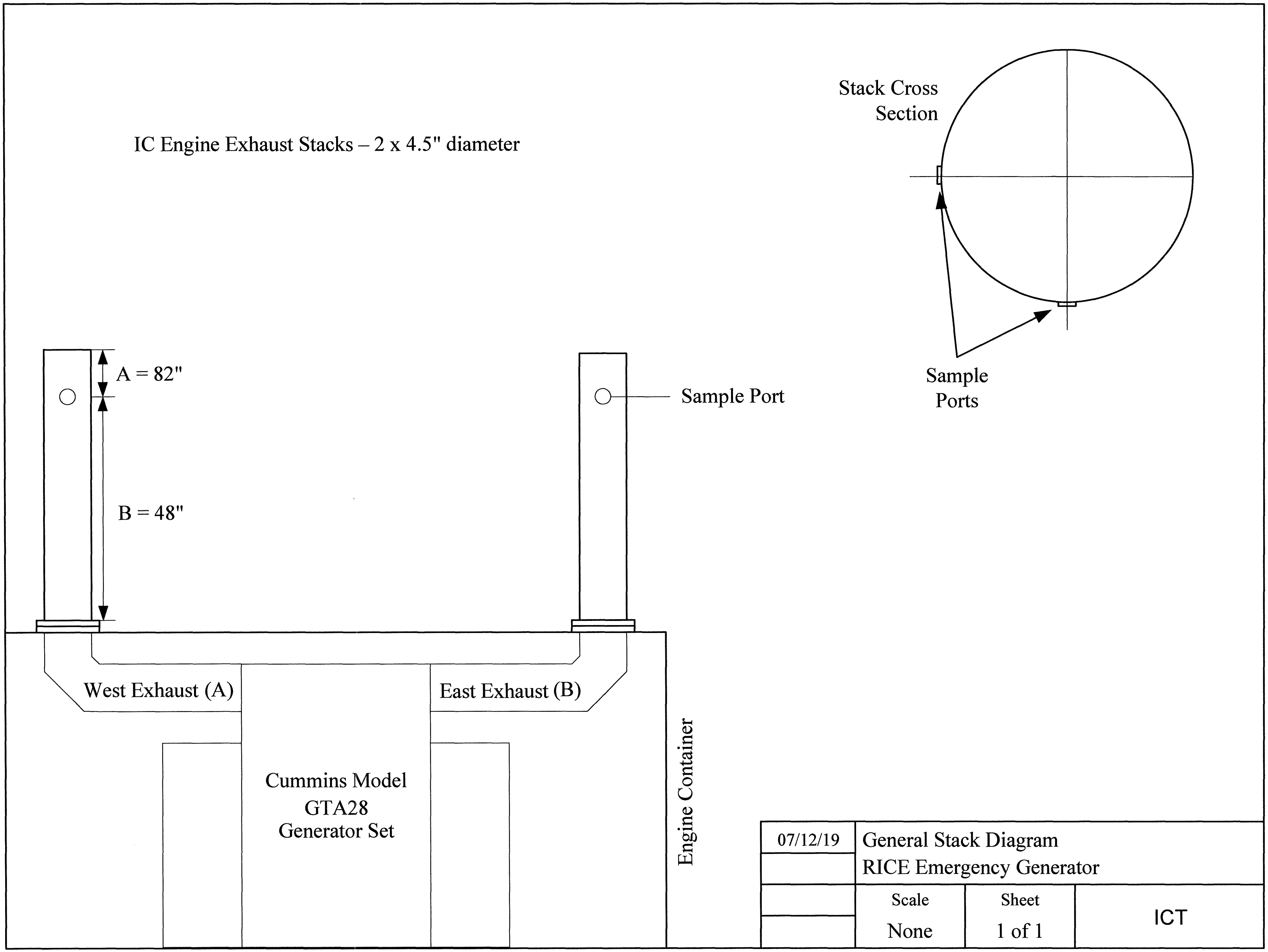
The testing for all pollutants was performed in accordance with the approved Test Protocol. The engine-generator set was operated within 10% of maximum output.

Table 6.1 Measured exhaust gas conditions and NO_x, CO, and VOC air pollutant concentrations for the BASF SI-RICE genset, SN: 99800411

Test No. Test date Test period (24-hr clock)	1 6/27/19 928-1030	2 6/27/19 1056-1159	3 6/27/19 1226-1330	Three Test Average
Generator output (kW)	465	465	465	465
<u>Exhaust Gas Composition</u>				
CO_2 content (% vol)	11.7	11.6	11.3	11.5
O_2 content (% vol)	1.10	1.34	1.33	1.26
Moisture (% vol)	19.0	19.7	19.3	19.3
<u>Nitrogen Oxides</u>				
NO_X conc. (ppmvd)	63.8	66.1	63.2	64.4
NO_X conc. corrected to 15% O_2	19.0	19.9	19.1	19.3
NO_X Subpart JJJJ limit @ 15% O_2 (ppmvd)	-	-	-	160
<u>Carbon Monoxide</u>				
CO conc. (ppmvd)	194	188	184	189
CO conc. corrected to 15% O_2	57.8	56.7	55.4	56.6
CO Subpart JJJJ limit @ 15% O_2 (ppmvd)	-	-	-	540
<u>Volatile Organic Compounds</u>				
VOC conc. (ppmv C_3)	3.45	3.39	3.17	3.34
VOC conc. corrected to 15% O_2 (dry)	1.27	1.27	1.19	1.24
VOC Subpart JJJJ limit @ 15% O_2 (ppmvd)	-	-	-	86

APPENDIX A

- IC Engine Sample Port Diagram


IC Engine Exhaust Stacks – 2 x 4.5" diameter
Stack Cross Section
Sample Ports
A = 82"
B = 48"
Sample Port
West Exhaust (A)
East Exhaust (B)
Cummins Model GTA28 Generator Set
Engine Container
07/12/19
General Stack Diagram
RICE Emergency Generator
Scale
None
Sheet
1 of 1
ICT