

**REGULATION 9
INORGANIC GASEOUS POLLUTANTS
RULE 10
NITROGEN OXIDES AND CARBON MONOXIDE FROM BOILERS, STEAM
GENERATORS AND PROCESS HEATERS IN PETROLEUM REFINERIES**

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GENERATORS AND PROCESS HEATERS IN PETROLEUM REFINERIES

(Adopted January 5, 1994)

9-10-100 GENERAL

9-10-101 Description: This rule limits the emissions of nitrogen oxides and carbon monoxide from boilers, steam generators, and process heaters, including CO boilers, in petroleum refineries.

(Amended December 15, 2010)

9-10-110 Exemptions: The requirements of this rule shall not apply to the following:

110.1 Boilers, steam generators and process heaters with a rated heat input less than 2 million BTU/hour, if fired exclusively with natural gas, liquefied petroleum gas, or any combination thereof.

110.2 Boilers, steam generators and process heaters with a rated heat input less than 1 million BTU/hour fired with any fuel.

110.3 Waste heat recovery boilers that are used to recover sensible heat from the exhaust of combustion turbines or reciprocating internal combustion engines.

110.4 Boilers, steam generators and process heaters processing hydrogen sulfide process flue gas in sulfur recovery plants and their tail-gas treating units, or sulfuric acid manufacturing plants.

110.5 Boilers, steam generators and process heaters fired on non-gaseous fuel when natural gas is unavailable for use.

110.6 Boilers, steam generators and process heaters, including CO boilers, that receive an Authority to Construct subject to BACT requirements for NOx on or after January 5, 1994.

(Amended December 15, 2010)

9-10-111 Limited Exemption, Small Units: The requirements of Sections 9-10-301, 303 and 305 shall not apply to the use of any small units, provided the requirements of Section 9-10-306 are satisfied.

(Amended July 17, 2002 and December 15, 2010)

9-10-112 Limited Exemption, Low Fuel Usage: The requirements of Sections 9-10-301, 303 and 305 shall not apply to the use of any boiler, steam generator or process heater that has an annual heat input less than 90,000 therms during each consecutive 12-month period or that accepts a condition in its Title V Permit limiting the annual heat input to less than 90,000 therms, provided the requirements of Sections 9-10-306 and 502.2 are satisfied.

(Amended July 17, 2002 and December 15, 2010)

9-10-200 DEFINITIONS

9-10-201 Deleted December 15, 2010

9-10-202 Boiler or Steam Generator: Any combustion equipment used to produce steam or heat water.

9-10-203 British Thermal Unit (BTU): The amount of heat required to raise the temperature of one pound of water from 59° F to 60° F at one atmosphere.

9-10-204 CO Boiler: A CO boiler is any boiler or furnace that processes the off-gases from a catalytic cracking unit (CCU) regenerator or a coker burner. A partial-burn CO boiler normally processes off-gases from a CCU regenerator that is operated in a partial-burn mode such that the off-gases normally have a CO concentration exceeding 2% by volume.

(Amended December 15, 2010)

9-10-205 Deleted December 15, 2010

9-10-206 Heat-Input: The heat of combustion released due to burning a fuel in a source, using higher heating value of the fuel. This does not include the sensible heat of

incoming combustion air. In the case of carbon monoxide boilers, the heat input includes the sensible heat of regenerator off-gases and the heat of combustion of the incoming carbon monoxide and of the auxiliary fuel.

- 9-10-207 Higher Heating Value (HHV):** The total heat liberated per mass of fuel burned (BTU per pound) when fuel and dry air at standard conditions undergo complete combustion and all resultant products are brought to their standard states at standard conditions per Section 9-10-604.
- 9-10-208 Natural Gas:** Any mixture of gaseous hydrocarbons containing at least 80 percent methane by volume, as determined according to Standard Method ASTM D1945-64.
- 9-10-209 Nitrogen Oxides (NO_x):** The sum of nitric oxide (NO) and nitrogen dioxide (NO₂) in the flue gas, collectively expressed as nitrogen dioxide.
- 9-10-210 Non-Gaseous Fuel:** Any fuel that is not a gas at 68° F and one atmosphere.
(Amended December 15, 2010)
- 9-10-211 Operating Day:** 24 hours from midnight to midnight.
- 9-10-212 Out of Service:** The period of time during which a unit is in an inactive state following shutdown.
- 9-10-213 Petroleum Refinery:** Any facility engaged in producing gasoline, kerosene, distillate fuel oils, residual fuel oils, lubricants or other products through distillation of petroleum or through redistillation, cracking, or reforming of unfinished petroleum derivatives.
- 9-10-214 Process Heater:** Any combustion equipment that transfers heat from combustion gases to water or process streams.
- 9-10-215 Rated Heat Input:** The heat input capacity specified on the nameplate of the combustion source. If the combustion source has been physically modified and/or operated in such a manner that its maximum heat input is different from the heat input capacity specified on the nameplate, then the modified maximum heat input per Section 9-10-503 shall be considered as the rated heat input.
- 9-10-216 Refinery-wide Emission Rate:** The ratio of the total mass of discharge into the atmosphere of nitrogen oxides, in pounds, to the sum of the actual heat input, in million BTU, calculated over a twenty-four (24) hour operating day.
(Amended December 15, 2010)
- 9-10-217 Small Unit:** Any refinery boiler, steam generator or process heater with a rated heat input less than 10 million BTU/hour.
(Amended December 15, 2010)
- 9-10-218 Startup or Shutdown:** Startup is that period of time, not to exceed twelve (12) hours unless specifically extended by a Title V Permit, during which a unit is brought up to its normal operating temperature from a cold start, initially at zero fuel flow, by following a prescribed series of separate steps or operations. Shutdown is that period of time, not to exceed nine (9) hours unless specifically extended by a Title V Permit, during which a unit is taken out of service from a normal operating mode to an inactive status following a prescribed series of separate steps or operations.
(Amended December 15, 2010)
- 9-10-219 Therm:** One hundred thousand (100,000) BTUs.
- 9-10-220 Deleted December 15, 2010**
- 9-10-221 Best Available Control Technology (BACT):** As defined in Regulation 2, Rule 2.
(Adopted December 15, 2010)
- 9-10-222 Curtailed Operation:** Operation of a boiler, steam generator or process heater at no more than 30% of its rated heat input.
(Adopted December 15, 2010)

9-10-300 STANDARDS

- 9-10-301 Refinery-wide NO_x Emission Limit:** A person shall not exceed a refinery-wide emission rate from boilers, steam generators and process heaters, excluding CO boilers, of 0.033 pounds NO_x per million BTU of heat input, based on an operating day average. Boilers, steam generators and process heaters that are undergoing startup or shutdown, that are temporarily out of service, that are in curtailed operation, or that are test-fired on non-gaseous fuel shall be included in the refinery-wide emission rate as follows:

- 301.1 Deleted December 15, 2010
- 301.2 Deleted December 15, 2010
- 301.3 Units Test-Fired On Non-Gaseous Fuel: For the purposes of determining compliance with the emission limit of Section 9-10-301, the contribution of each boiler, steam generator or process heater that is fired on non-gaseous fuel for equipment testing shall be taken as the operating day average of NOx emissions at the average heat input over the previous thirty (30) day period. Equipment testing shall not exceed a total of forty-eight (48) hours during any calendar year for any one unit.
- 301.4 Units in Start-up or Shutdown or in Curtailed Operation: For the purposes of determining compliance with the emission limit of Section 9-10-301, the emission contribution of each boiler, steam generator or process heater that is undergoing startup or shutdown or that is in curtailed operation shall be one of the following:
 - 4.1 The operating day average NOx emissions (either from a continuous emission monitoring system (CEMS) or from an equivalent parametric monitoring system developed in accordance with a Title V Permit and Section 9-10-502.1), and the operating day heat input.
 - 4.2 The operating day average NOx emissions (either from a CEMS or from an equivalent parametric monitoring system developed in accordance with a Title V Permit and Section 9-10-502.1), and the operating day heat input averaged over the previous thirty (30) day period or, subject to the approval of the APCO, an alternate 30-day period representative of normal operation.
- 301.5 Units Temporarily Out of Service: For the purposes of determining compliance with the emission limit of Section 9-10-301, the emission contribution of each boiler, steam generator or process heater that is temporarily out of service shall be the operating day average NOx emissions (either from a continuous emission monitoring system (CEMS) or from an equivalent parametric monitoring system developed in accordance with a Title V Permit and Section 9-10-502.1), and the operating day heat input, averaged over the previous thirty (30) day period or, subject to the approval of the APCO, an alternate 30-day period representative of normal operation.

(Amended December 15, 2010)

9-10-303 Federal Refinery-wide and CO Boiler NOx Emission Limits: A person shall not exceed a refinery-wide emission rate from boilers, steam generators or process heaters, excluding CO boilers, of 0.20 pounds NOx per million BTU of heat input, based on an operating day average.

- 303.1 Except during startup and shutdown, a person shall not operate a CO boiler unless the emissions of nitrogen oxides (NOx) do not exceed 300 ppmv, dry at 3% oxygen, based on an operating day average.

(Amended July 17, 2002 and December 15, 2010)

9-10-304 Interim NOx Emission Limit For CO Boilers: Until Section 9-10-307 is effective, and except during startup and shutdown, a person shall not operate a CO boiler unless at least one of the following is met:

- 304.1 Emissions of nitrogen oxides (NOx) do not exceed 150 ppmv, dry at 3% oxygen, based on an operating day average; or
- 304.2 Emissions of nitrogen oxides (NOx) are controlled by an emission control system with a NOx control efficiency of at least 50 percent by weight.

(Amended December 15, 2010)

9-10-305 CO Emission Limit: Except during start-up, shutdown or curtailed operation, a person shall not operate a boiler, steam generator or process heater, including CO boilers, unless carbon monoxide emissions of 400 ppmv, dry at 3% oxygen, based on an operating day average, are not exceeded.

(Amended December 15, 2010)

9-10-306 Small Unit Requirements: A person shall not operate a small unit unless at least one of the following is met:

- 306.1 Operate in a manner that maintains stack-gas oxygen concentrations at less than or equal to 3 percent by volume on a dry basis; or

- 306.2 Tune at least once every twelve (12) months, or within two weeks of unit startup if not operated in the last twelve (12) months, by a technician in accordance with the procedure specified in Section 9-10-605; or
- 306.3 Meet the applicable emission limits in Sections 9-10-301, 303 and 305.
(Amended December 15, 2010)

9-10-307 Final NOx Emission Limits For CO Boilers: Effective January 1, 2015, and except during start-up or shutdown, a person shall not operate a CO boiler unless it meets the applicable NOx emission limits in Sections 9-10-307.1 and 307.2.

307.1 A person shall not operate a CO boiler, except for a partial-burn CO boiler, unless the following NOx limits are not exceeded:

Averaging Period	NOx (ppmv, dry at 3% O ₂)
1.1 Operating day	150
1.2 Calendar year (excluding periods when the CO boiler does not process CCU regenerator offgas)	45

307.2 A person shall not operate a partial-burn CO boiler, unless the following NOx limits are not exceeded:

Averaging Period	NOx (ppmv, dry at 3% O ₂)
2.1 Operating day	125
2.2 Calendar year	85

(Adopted December 15, 2010)

9-10-400 ADMINISTRATIVE REQUIREMENTS

9-10-401 Deleted December 15, 2010

9-10-402 Deleted December 15, 2010

9-10-403 Deleted December 15, 2010

9-10-404 Final Control and Monitoring Plan: A person subject to Section 9-10-307 shall comply with the following increments of progress:

- 404.1 No later than twenty-four (24) months prior to the effective date of Section 9-10-307, submit to the APCO a control plan detailing the proposed measures, if any, to be taken in order to meet the requirements of Section 9-10-307, as well as proposed measures, if any, to be taken to continue to meet the requirements of Section 9-10-301.
- 404.2 No later than eighteen (18) months prior to the effective date of Section 9-10-307, submit applications for all Authorities to Construct required for compliance with Section 9-10-307.
- 404.3 No later than 30 days after the effective date of Section 9-10-307, perform testing for nitrogen oxide and carbon monoxide emissions at each CO boiler subject to Section 9-10-307 at the rated heat input or as near thereto as practicable. This requirement may be satisfied by monitoring nitrogen oxide and carbon monoxide emissions with a continuous emission monitoring system (CEMS).

(Adopted December 15, 2010)

9-10-500 MONITORING AND RECORDS

9-10-501 Deleted December 15, 2010

9-10-502 Monitoring: A person subject to Sections 9-10-301, 303, 304, 305 or 307 shall maintain in good working order, and operate the following equipment:

- 502.1 An in-stack nitrogen oxide (NOx), carbon monoxide (CO), and oxygen (O₂) continuous emission monitoring system (CEMS), or equivalent parametric monitoring system as specified in a Title V Permit. The CEMS must meet the requirements of the District Manual of Procedures, Volume V, Continuous Emission Monitoring, Policy and Procedures.

502.2 A fuel-flow meter in each fuel line for each boiler, steam generator and process heater, including each CO boiler.

(Amended July 17, 2002 and December 15, 2010)

9-10-503 Modified Maximum Heat Input: Any unit that has been physically modified such that its maximum heat input is different than the heat input specified on the nameplate shall demonstrate to the APCO the maximum heat input while operating the source at maximum capacity.

9-10-504 Records: The owner/operator of a source subject to this rule shall keep the following records, in a form suitable for inspection for a period of at least five (5) years. Such records shall be retained for a minimum of sixty (60) months from date of entry and made available to the APCO upon request. These records shall include, but are not limited to the following:

504.1 For all sources subject to the requirements of Sections 9-10-301, 303, 304, 305, 307 or 404.3:

1.1 The continuous emission monitoring system (CEMS) measurements or equivalent parametric monitoring system parameters for NO_x, CO, and O₂ in ppmv; and hourly (lb/hour) and daily (lb/day) NO_x emissions for each source.

1.2 The type, heat input (BTU/hr and BTU/day), and higher heating value of each fuel burned, and the injection rate for any reactant chemicals used by the emission control system(s) on a daily basis.

1.3 The date, time, and duration of any startup, shutdown or malfunction in the operation of any unit, emission control equipment or emission monitoring equipment.

1.4 The results of performance testing, evaluations, calibrations, checks, adjustments, and maintenance of any CEMS required by this rule.

1.5 A list of all sources subject to the NO_x refinery-wide emission rate limits in Sections 9-10-301 and 303.

1.6 Total NO_x emissions and total heat input for all sources listed in Section 9-10-504.1.5, on a daily basis.

1.7 The date, time and duration of all start-up and shutdown periods.

1.8 The results of source tests required by Section 9-10-404.3.

504.2 For all sources subject to Section 9-10-306.2, records of annual tune-ups.

(Amended July 17, 2002 and December 15, 2010)

9-10-505 Reporting Requirements: A person subject to the requirements of Sections 9-10-301, 303, 304, 305, 306 or 307 shall meet the following reporting requirements:

505.1 Report to the APCO any violation of Section 9-10-301, 303, 304, 305, 306 or 307 in accordance with the requirements of Regulation 1-522 for continuous emission monitoring systems (CEMS) and Regulation 1-523 for parametric monitoring systems.

505.2 Submit a written report for each calendar quarter to the APCO. The report shall be due on the 30th day following the end of the calendar quarter and shall include:

2.1 A summary of the data obtained from the CEMS or equivalent parametric monitoring system and the fuel meters installed pursuant to Section 9-10-502; and

2.2 The date, time, duration, and magnitude of emissions in excess of the appropriate standards; the nature and cause of the excess (if known); the corrective actions taken; and the preventive measure adopted.

(Amended July 17, 2002 and December 15, 2010)

9-10-600 MANUAL OF PROCEDURES

9-10-601 Determination of Nitrogen Oxides: Compliance with the nitrogen oxide emission requirements of Sections 9-10-301, 303, 304 and 307 shall be determined by a continuous emission monitoring system (CEMS) that meets the requirements of Regulation 1-522, or by an equivalent parametric monitoring system that is authorized in a Title V Permit and that meets the requirements of Regulation 1-523. CEMS operation and compliance with Section 9-10-404.3 shall be verified by source

test as set forth in the District Manual of Procedures, Volume IV, ST-13A (nitrogen oxides) and ST-14 (oxygen).

(Amended July 17, 2002 and December 15, 2010)

9-10-602 Determination of Carbon Monoxide and Stack-Gas Oxygen: Compliance with the carbon monoxide emission requirements of Section 9-10-305 shall be determined by a continuous emission monitoring system (CEMS) that meets the requirements of Regulation 1-522, or by an equivalent parametric monitoring system that is authorized in a Title V Permit and that meets the requirements of Regulation 1-523. CEMS operation and compliance with Section 9-10-404.3 shall be verified by source test as set forth in the District Manual of Procedures, Volume IV, ST-6 (carbon monoxide) and ST-14 (oxygen).

(Amended December 15, 2010)

9-10-603 Compliance Determination: All emission determinations shall be made in the as-found operating condition, except during periods of start-up or shutdown.

(Amended December 15, 2010)

9-10-604 Determination of Higher Heating Value: If certification of the higher heating value is not provided by the third-party fuel supplier, it shall be determined by one of the following test methods: (1) ASTM D2015-85 for solid fuels; (2) ASTM D240-87 or ASTM D2382-88 for liquid hydrocarbon fuels; or (3) ASTM D1826-88 or ASTM D1945-81 in conjunction with ASTM D3588-89 for gaseous fuels.

9-10-605 Tune-Up Procedures: The tuning procedure required by Section 9-10-306.2 shall be performed in accordance with the procedure set forth in the District Manual of Procedures, Volume I, Chapter 5.