



Qenos

MAY 2021 ACNCG



Introduction

- Qenos actions arising from August meeting (nil)
- Safety performance
- Regulatory interface
- Community interface

Presentations

- EIP update
- PSV graph

Safety performance

- Zero recordable injuries year to date (all Altona)
- Olefins celebrated best ever 1500+ recordable injury free days
- Altona contractors at record 1390 days !



I will:

- Lead the way with high standards, communication & behaviours that meet the SHE Policy & this Charter
- Be constantly mindful and have SHE as the foremost consideration in all decisions, actions and communications.
- Do what's right and understand and apply all SHE requirements.
- Maintain with pride a clean and orderly work area.
- Protect myself and others by being fit for duty without impairment from alcohol, drugs, medications or other influences.
- Be accepting of constructive interventions & feedback on my own 'at risk' behaviours or practices.
- Have the courage to constructively intervene & give feedback on 'at risk' behaviours or practices of others.
- Participate in required rehabilitation programs.
- Actively participate in SHE programs with the intention to improve SHE performance outcomes.

For Managers & Team Leaders, I will also:

- Be visible and accountable for setting and managing required SHE standards and procedures.
- Ensure the people I lead have the required competencies & tools for the tasks they need to do.
- Provide leadership to carry out SHE risk identification, assessment and implement required controls.
- Always lead the way by displaying exemplary SHE behaviours.
- Carry out my duty of care & ensure any 'at risk' behaviours are quickly addressed with face to face engagement using clear resolution and feedback processes.
- Create an environment of openness, trust and mutual respect and foster a strong behaviour based recognition culture.

! NO HARM! RISK: IDENTIFY IT, ASSESS IT, CONTROL IT!



Regulatory Interface

- EPA
 - 19th March EPA attended site for Annual License Compliance Assessment.
 - Advised to have a logging and checklist system in place for the stormwater system maintenance at the Resins site.
 - Advised that the premises put in source controls at the stormwater system in the high-risk areas to minimise migration to the stormwater system at the Plastics site.
 - Advised that EPA intends to serve a Pollution Abatement Notice to address implementation of recommendations of flaring assessment undertaken as part of remedial notice no. 90009621.
 - Site 53V Assessment Clean Up Notice (90009622).
 - Sampling and Analysis Quality Plan Submitted to EPA on 31st March
 - Clean Up Notice 90009008 (PFAS) revoked on 15th February as Qenos complied with all requirements.



Regulatory Interface

- CWW
 - Olefins Trade Waste agreement renewed with minor amendments for 3 years on 30th March
- Worksafe
 - Worksafe plan to visit Qenos every 2 months in 2021 as part of their oversight role.
 - Worksafe have completed a scheduled visit to Resins and to Olefins so far this year.
 - No significant issues identified.



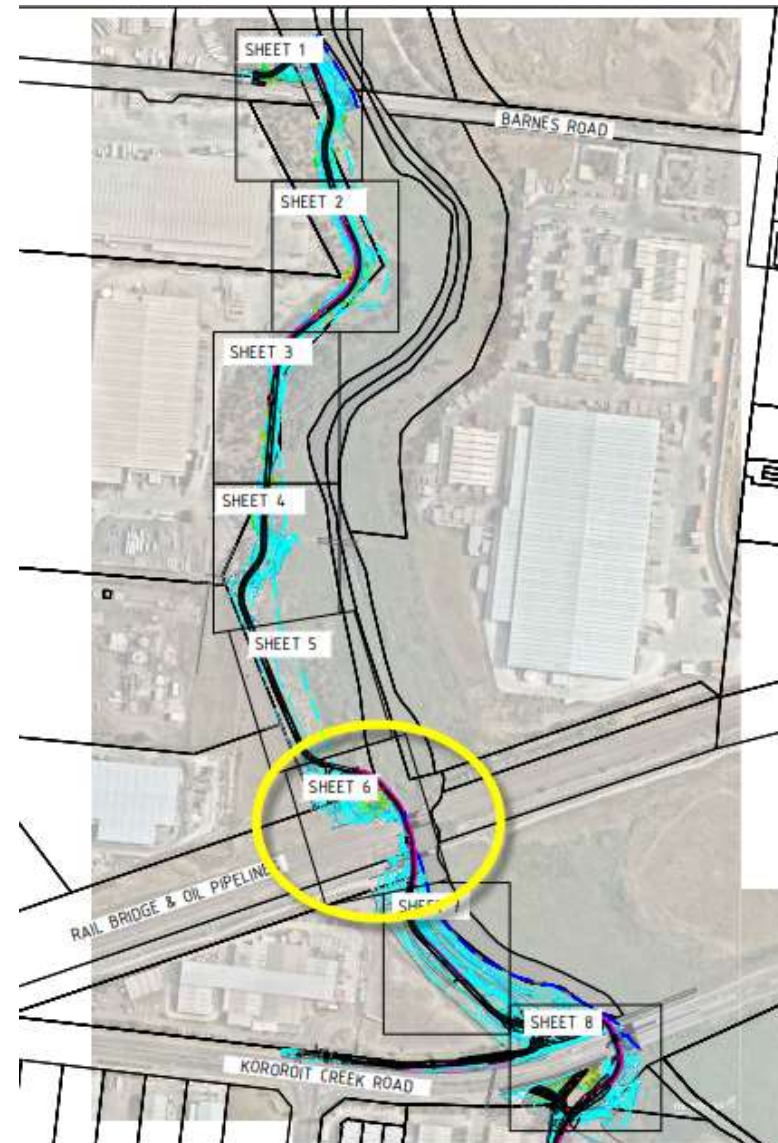
Community Interface

- Sponsored Hobsons Bay Artists Society 5" x 7" Art Exhibition which is open to residents and schools.
 - Sponsored for over 30 years. Cathy Krohn of Qenos acting as one of the judges
- Team participated in Hobsons Bay Community Fund charity golf day at Koorungal in March
- Latitude: Directions for Young People in Altona
 - Beneficiaries of the Qenos Contractor Workforce quarterly safety KPI achievements.



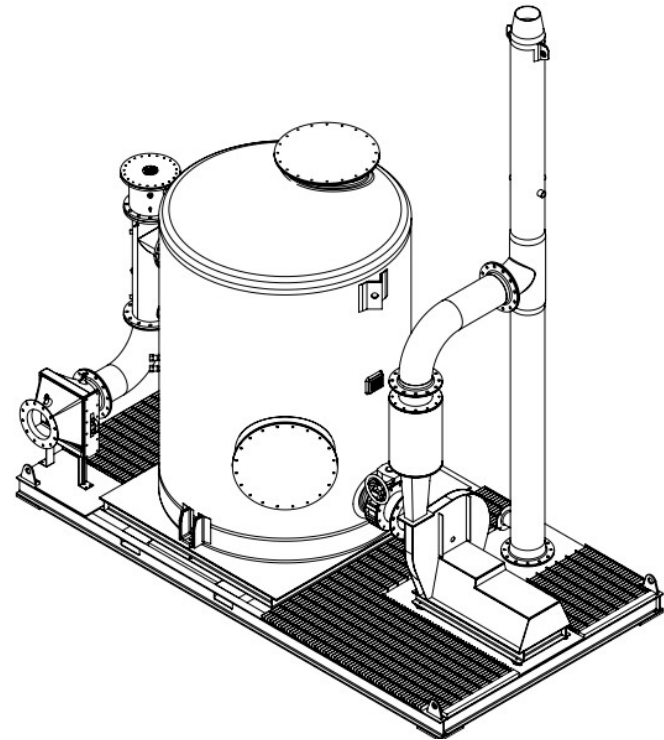
Community Interface

- Assisting the Friends of Lower Kororoit Creek with Stage 4 of the Kororoit Creek Shared Trail.
 - Involves liaising with various stakeholders including Melbourne Water and HBCC regarding necessary approvals and safety/regulatory obligations to be complied with to enable the installation of the trail under the MHF pipeline bridge.
- Complaints
 - Two odour complaints from Charles Road accepted related to Effluent Treatment Plant odour. 26th March and 4th April.
 - Activated carbon filter project to reduce odours covered in EP update



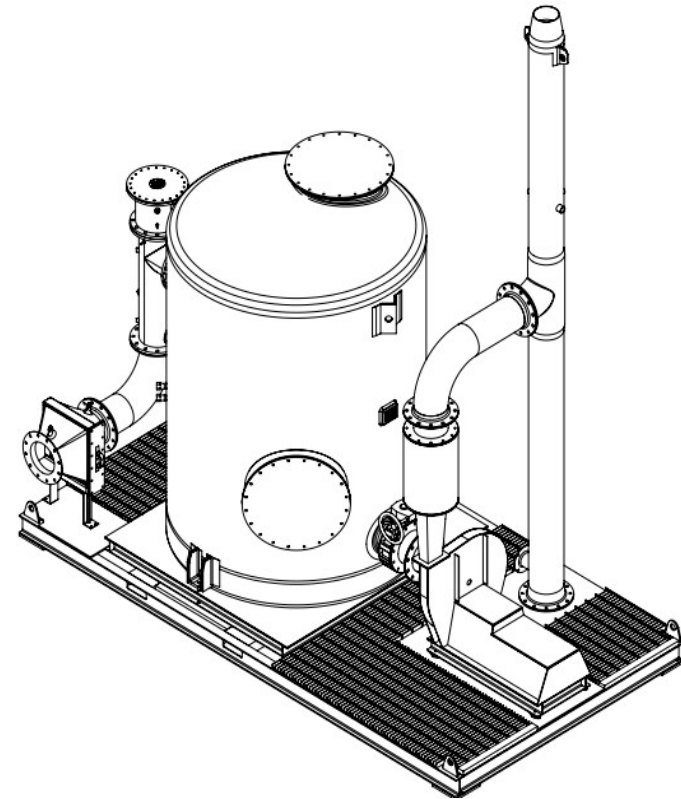
Activated Carbon (AC) Filter project on API Afterbay

- Installing 2750 KG AC purpose built kg unit
- Design features.
 - Six air changes per hour of API headspace.
 - Inlet filter to remove dust.
 - Inlet heater to keep humidity low to avoid condensation in unit.
 - 1500 m³/hr blower to feed unit.
 - 5 M high discharge stack with testing port
 - Instrumentation to plant DCS control system
 - Installation has minimal operational impact
 - Six month run-length,
 - 1 week off line to change out AC media.



Activated Carbon (AC) Filter project Timeline

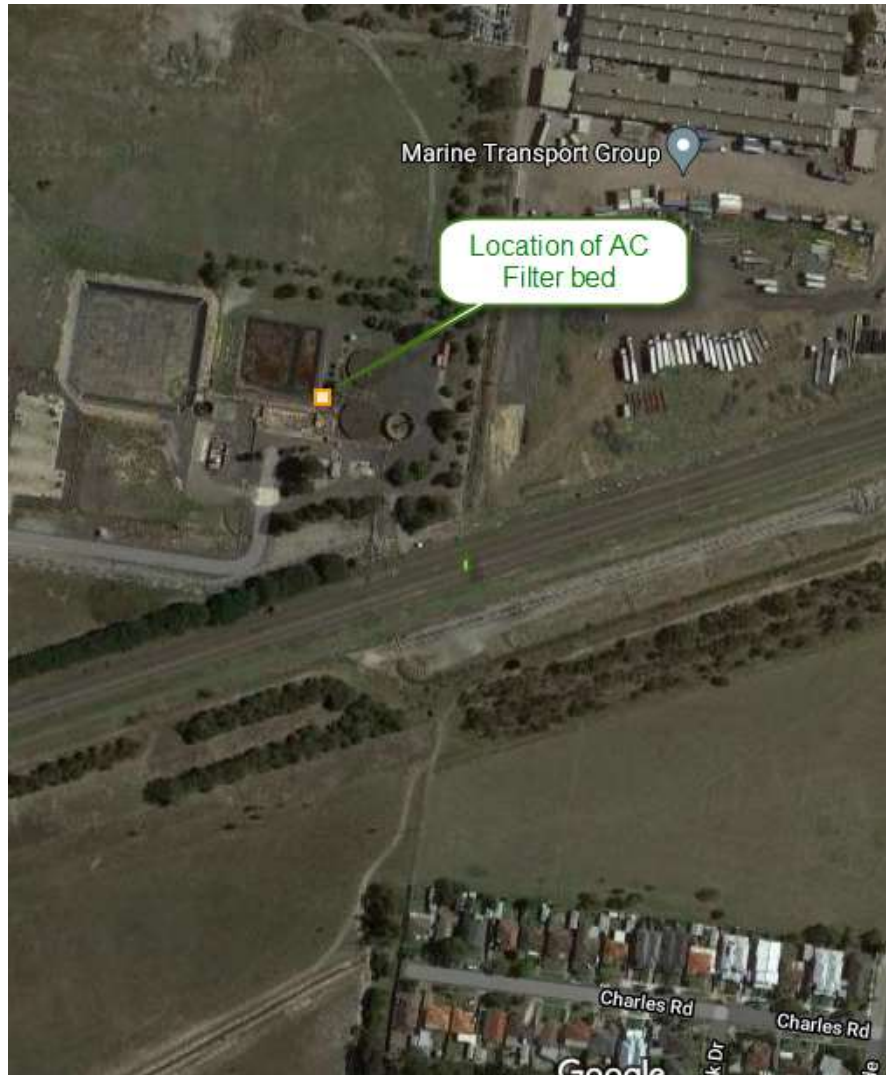
- Project Funds approved Jan 2021
 - A \$550 k including 10% contingency
- Vendor Unit skid fabrication Feb to Aug 21.
- Onsite installation Sep/Oct 21
- Commissioning Nov/Dec 21



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Activated Carbon (AC) Filter project location



OLE010275: API Afterbay AC Filter



AC filter skid location on new concrete pad.



EIP STATUS

Environmental Impact	Plan	Scheduled	Current status
Environmental Audit and Assessments	Complete Olefins SCAL-2 Environment risk re assessments	1Q	Assessment complete seven new scenarios identified
Environmental Audit and Assessments	Implement CUN 2020 90009622 actions, Complete Sampling Analysis Quality Plan	Q1	SAQP submitted to EPA on 30th March on schedule
Odour	Conduct the annual Odour Audit.	2Q	
Surface water	Refresh marking of surface water drains with Blue fish	2Q	
Training	Conduct Environmental & Sustainability Awareness training sessions	2-4Q	Currently in progress at all sites.
Environmental Audit	Conduct Olefins Off sites & BHAL	3Q	
Environmental Audit and Assessments	Implement CUN 2020 90009622 actions, Progress site investigations contained in SAQP	Q3-Q4	Planning progressing to implement SAQP starting in July
Soil and Groundwater	Conduct annual groundwater monitoring	4Q	
Environmental Audit and Assessments	ISO 14001 Progress system documentation and develop new implementation schedule		

EIP Project	Current status	Target
OLE010275 : ETP Odour Reduction: Activated Carbon Filter on API afterbay	Project approved. Equipment ordered and installation plan developed. Expect to be on line in November.	Nov-21



Flare EIP STATUS

Environmental Impa	Plan	Schedule	Current status
Flares	Carry out annual flare noise testing to verify flare tip noise performance is at baseline. (Plastics & Olefins)	3Q	
Flares	Replace F-656 tubes - Reduces CO make immediately after furnace feed in. Higher CO make can result in an offspec event at R720 as CO acts as a catalyst moderator	1Q	Completed in March
Flares	Review of SCAL1 DMDS injection facilities, including alarms, set points of alarms and robustness of pump operation, improvement in robustness of pumps (which may require replacement), consideration of maintenance routines and implement these actions. - Reduced rate of DMDS injection has resulted in several off spec events at R202.		Performance so far this year has been improved over prior years as a result of a change to maintenance of an item. Formal review to be completed int in 3Q
Flares	Share content of this review (Flare EMP) with leadership, technical support staff, operations and maintenance to discuss findings and flare performances and key learnings from this review. - Highlight flare performance, provide context for future changes and trials and aid with guiding work prioritization as some key equipment may not have been recognized as integral to flaring performance		Shared with Olefins Operstions Integrity Committee. Will need to share more widely with various groups over the next few months.
Flares	T301 level instrument – improve reliability of instrument - False level reading has resulted in plant upset and flaring.		Initial review completed. Still being worked
Flares	Review flare data and controller tuning to determine & implement improvement opportunities. Update operating guidelines excess steam addition. - Reduces noise of flare to community		Have actively been reviewing each flaring incident to look for opportunities to improve steam addition rates. Seeking advice from Overseas manufacturer for sensitivity settings & other recommendations .
Flares	Provide annual feedback of flaring events, cause and status of associated action items. - Review flaring performance (rate and impact), identify opportunities for further improvement		
Flares	Review Elevated flare control system and retune as required. - Using learning from Olefins, optimise flare operation using IR camera. Update the Flare control system and operator guidance to match the retuned control system	2Q	Work in progress
Flares	Review Ground flare performance. - When it next activates, review that the updated staging controls worked as designed and whether it has reduced the level of off-site concern about its activation.		Review when the ground flare activates



2020 Total - 5 (2 in Dec '20)
 2019 Total - 5
 2018 Total - 11
 2017 Total - 12
 2016 Total - 6

In period 2009 - 2015
 Lowest rate 2 p.a
 Highest rate 23 p.a

High Pressure Events > PSV Set Points 90 Day Trend

2021 YTD 7 PSV Lifts (2 since last update)
 -2 Scal-1 PSVs lifted following compressor trip -
 issue with compressor now rectified

Annualised trend
 90 day abnormal operation trend
 90 day normal operation trend

