

From: Ryan, Timothy Charles <RYANTC@airproducts.com>

Sent: 20 February 2023 10:10

To: Burton, Luke <Luke.Burton@cyfoethnaturiolcymru.gov.uk>; Parr, Elizabeth <Elizabeth.Parr@cyfoethnaturiolcymru.gov.uk>

Subject: Air Products Llanwern - Annual 2022 Energy Report

Hi Luke,

**Yes that is a typo on my part, thanks for pointing this out.
Please take this e mail as a correction for this.**

Thanks.

Tim.

Tim Ryan

Facilities Manager, Llanwern and Dragon LNG



From: Burton, Luke <Luke.Burton@cyfoethnaturiolcymru.gov.uk>

Sent: 17 February 2023 14:38

To: Ryan, Timothy Charles <RYANTC@airproducts.com>; Parr, Elizabeth <Elizabeth.Parr@cyfoethnaturiolcymru.gov.uk>

Subject: Air Products Llanwern – Annual 2022 Energy Report

Hello Tim, hope you're well. Thanks for your submissions.

Table 2 in the report notes:

**Table 2 shows the actual energy performance for the plant for the period
January 2021 to December 2021**

I assume this is an error and should read Jan 22 – Dec 22?

Please confirm if so, and if that's the case, I'm happy to use the email as a correction, rather than you have to produce another report.

Best regards,

Luke Burton

Uwch-Swyddog - Rheoliad Diwydiant / Senior Officer - Industry Regulation

Rheoliad Diwydiant De-ddwyrain / South East Industry Regulation

Cyfoeth Naturiol Cymru / **Natural Resources Wales**

Ffôn / Tel: 07 920 450 986

From: Ryan, Timothy Charles <RYANTC@airproducts.com>

Sent: 27 January 2023 14:05

To: Parr, Elizabeth <Elizabeth.Parr@cyfoethnaturiolcymru.gov.uk>

Cc: Burton, Luke <Luke.Burton@cyfoethnaturiolcymru.gov.uk>; Grimstead, Wayne <wayne.grimstead@cyfoethnaturiolcymru.gov.uk>

Subject: Air Products Llanwern

Liz,

Please find enclosed the energy report for permit number BL2459.

Thanks.

Tim Ryan

Plant Manager, Llanwern and Dragon LNG

Air Products (BR) Limited
Queensway, Spencer Works,
Llanwern, Newport,
South Wales
NP19 4QX

| | |
|-------------------------|----------------|
| Telephone Plant: | (0)1633 281614 |
| Fax Plant | (0)1633 277191 |
| Telephone Plant Manager | (0)1633 273405 |
| Fax Plant Manager | (0)1932 259094 |

27th January 2023

Natural Resources Wales
Rivers House
St Mellons Business Park
St Mellons
Cardiff
CF3 0EY

Attention: Mr Luke Burton.

Re IPPC Permit number BL 2459.

Dear Mr Luke Burton.

Please find enclosed:

Energy Efficiency report, year ending December 2022.

Yours sincerely

TC Ryan

Plant Manager



Air Products plc
Hersham Place, Molesey Road
Walton-on-Thames, Surrey, KT12 4RZ
Telephone (0) 1932 249992

AIR PRODUCTS (BR) LTD

PROJECT NUMBER: A3145

**INSTALLATION: LLANWERN HYDROGEN
INSTALLATION
(BL 2459)**

Distribution: **TITLE: Energy Efficiency Report**
Environment Agency - Cardiff (1 copy)
Plant Manager, UK Operations - Llanwern (APBR Ltd)
Safety & Quality, UK EH&S – HERSHAM

| | | | | | |
|------------|--------------------|-------------|-------------------|--|--|
| 20 | 2023 revised | 27/01/2023 | Plant Manager | | |
| 19 | 2022 revised | 26/01/2022 | Plant Manager | | |
| 18 | 2021 revised | 27/01/2021 | Plant Manager | | |
| 17 | 2020 revised | 24/01/2020 | Plant Manager | | |
| 16 | 2019 revised | 23/01/2018 | Plant Manager | | |
| 15 | 2018 revised | 25/01/2018 | Plant Manager | | |
| 14 | 2017 revised | 30/01/2017 | Plant Manager | | |
| 13 | 2016 revised | 27/01/2016 | Plant Manager | | |
| 12 | 2015 revised | 27-01-2015 | Plant Manager | | |
| 11 | 2014 revised | 27-01-2014 | Plant Manager | | |
| 10 | 2013 revised | 14-01-2013 | Plant Manager | | |
| 9 | 2012 revised | 20-01-2012 | Plant Manager | | |
| 8 | 2011 revised | 24-01-2011 | Plant Manager | | |
| 7 | 2010 revised | 07-01-2010 | Plant Manager | | |
| 6 | 2009 revised | 08-01-2009 | Plant Manager | | |
| 5 | 2008 revised | 03/01/2008 | Plant Manager | | |
| 4 | 2007 revised | 05/01/2007 | Plant Manager | | |
| 3 | 2006 revised | 05/01/2006 | Plant Manager | | |
| 2 | 2005 revised | 10/01/05 | Plant Manager | | |
| 1 | 2004 revised | 16/4/04 | Quality & Safety | | |
| 0 | Original Issue | 22/4/03 | Quality & Safety | | |
| REV | Description | Date | Originator | | |

Llanwern Hydrogen Installation Energy Efficiency Report

Objective

This report documents all the available techniques and the estimated CO2 reductions associated with these, in accordance with improvement item 9.2.

This energy efficiency report reviews the plant performance against the design, and proposes any energy efficiency improvements that might be required against the Environment Agencies PPC application template, published in December 2002. This report is kept on site and reviewed at a minimum every year, and updated if necessary.

General

The plant was commissioned in April 2002. The electrical equipment (detailed in the PPC application V3145 section 2.7) was all purchased from new for the project and to state of the art energy efficiency standards. The reformer itself and the burners were also manufactured specifically for this project and represent BAT.

BAT for energy use on the plant was described in the PPC application V3145 section 2.7). The site is covered by a CCL agreement and thus only housekeeping energy efficiency measures are subject to PPC regulation. In addition the site energy use is below the threshold for low impact installations) of 1 MW.

A Natural Gas Booster Compressor has been installed, within the Air products facility compound. This was a late request from Tata Steel, and was not included in the original energy calculations

The Booster compressor is designed to prevent loss of feed gas pressure from the Tata Steel distribution main, as more equipment is brought on line within the Tata Steel facility. (including gas fired boilers and pipeline gas supply to other sites within the Tata Steel works)

Plant Performance vs Design

Further efficiencies made, by increasing the use of purge gas for burner operation. This also reduced the natural gas required for burner operation

The plant reformer tube temperatures have been maintained.

Plant operation still to design, Customers on reduced demand since September 2008, plant load following capability increased, now 43% reduction in rates possible. The customer demands increased in 2018.

Due to the loss of one of our customers we have lowered our production again to 43% of rates, as of December 2019.

Table 1 show the basis theoretical annual energy performance

| Energy source | Base units | Energy consumption Base theoretical | | | Emissions Tonnes CO2 |
|--|------------|--|------------------|------------|----------------------------|
| | | Delivered, Mwhr | Primary, Mwhr | % of total | |
| Electricity - National Grid | 170.5 | 1494 | 4267 | 67% | 708 |
| Gas - burners only not feedstock | 42 | 2120 | 2120 | 33% | 403 |
| Total | | 3613 | 6387 | 100% | 1111 |
| Production | kg/yr | 727000 | | | |
| Efficiency | MWHr/Tonne | 8.79 | | | |

Table 2 shows the actual energy performance for the plant for the period
January 2021 to December 2021

← should read 2022, see email dated 20/2/23

| Energy source | Base units | Energy consumption Period Jan 2021 to Dec 2021 | | | Emissions Tonnes CO2 |
|--|------------|---|------------------|------------|----------------------------|
| | | Delivered, Mwhr | Primary, Mwhr | % of total | |
| Electricity - National Grid | 102 | 832 | 2376 | 68% | 394 |
| Gas - burners only not feedstock | 24 | 1127 | 1127 | 32% | 214 |
| Total | | 1959 | 3503 | 100% | 609 |
| Production | kg/yr | 47962 | | | |
| Efficiency | MWHr/Tonne | 73.04 | | | |

Comments

With load following implemented, average natural gas usage to burners has been maintained at an average of 35.4 Kg/Hr.
Minimum plant rate achievable 43% of plant production.
Customer demand for H2 below contract levels during all of 2022 as we have lost one of our customers Or Electrical Steels. Air Products as a company are actively seeking

other markets for the excess Hydrogen at the Llanwern Facility. We are currently in the initial phase of installing a hydrogen trailer fill system at Llanwern, this will be online sometime in 2023. This will restore the plants efficiency as we will be running at near 100% rates.

Energy Efficiency Plan

Continued operation of the (VAX) system. (Installed November 2007).

The VAX system collects data from the plant processor, enabling close monitoring of plant efficiency and load following.

Further routines added during 2009

The assumptions made in the original PPC application were also reviewed and remain valid. All the relevant techniques identified in the guidance note H2 have been implemented in the plant design

Relocation of Fire eye monitors, to provide better monitoring of burner flame.

This has resulted in reduced Purge gas venting, allowing more purge gas to be used for burner operation and reducing natural gas usage.

Main furnace burners replaced in summer shutdown 2013.

New plant cooling tower December 2013.

Plant gas coolers cleaned summer 2015.

Plant process heat exchangers cleaned using a CO2 surface blasting technique summer 2018.

Power meter installed to measure total power to the plant.

Plant process heat exchangers cleaned using a CO2 surface blasting technique summer 2022.

Main furnace burners replaced in summer shutdown 2022.

Main furnace insulation stripped out and replaced with new like for like material summer 2022.

The reformer tube catalyst was replaced in summer 2022.

Regarding the trending and analysis of the Smart plant efficiency, this data has been added to the KPI visualization tool via the VAX data system. This allows the plant and process support staff to monitor the Smart plant efficiency in real time

Appendix 1 Based on Environment Agencies IPPC template.

Basic energy efficient operating and maintenance measures are described in the Table below.

Table 2.7.2.1

| Are documented <u>operating maintenance and housekeeping measures</u> in place for the following (where relevant): | Yes/no | Not relevant | Further Information (reference documentation, date measures will be in place or reason why not relevant) |
|---|---------------|---------------------|---|
| | | | |

air conditioning, process refrigeration and cooling systems (leaks, seals, temperature control, evaporator/condenser maintenance);

Yes

Reformer catalyst changed March 2010.
Syngas cooler cleaned March 2010.
Syngas cooler cleaned July 2011.
Syngas cooler cleaned July 2012.
Syngas cooler cleaned July 2013.
Reformer catalyst changed July 2013.
New plant cooling tower December 2013.
Syngas cooler cleaned July 2014.
Plant gas coolers cleaned July 2014.
Syngas cooler cleaned June 2015.
Plant gas coolers cleaned June 2015.
Burners check for correct operation June 2015.
Syngas cooler cleaned July 2016.
Reformer catalyst changed July 2016.
Syngas cooler cleaned July 2017.
C201 Natural Gas compressor coolers cleaned July 2017.
Syngas cooler cleaned July 2018.
Reformer inner/outer tubes plus catalyst changed July 2018.
Process gas heat exchangers cleaned July 2018.
Burners check for correct operation June 2018.
Burners check for correct operation July 2019.
Syngas cooler cleaned July 2019.
Full cooling tower clean completed November 2019.
Burners check for correct operation July 2020.
Syngas cooler cleaned July 2020.
Full cooling tower clean completed November 2021.
Burners check for correct operation August 2021.
Syngas cooler cleaned August 2021.
Process gas heat exchangers cleaned using CO2 July 2022.
Syngas cooler cleaned July 2022.
Reformer catalyst changed July 2022.
Burners replaced July 2022.
Main furnace insulation replaced with like for like material.

| | | | |
|---|-----|---|--|
| Operation of motors and drives | Yes | | Maintained as part of the planned maintenance system |
| Compressed gas systems (leaks, procedures for use); | Yes | | Small Compressed (instrument) air system part of planned maintenance |
| Steam distribution systems (leaks, traps, insulation); | Yes | | Maintained as part of the planned maintenance system |
| Space heating and hot water systems; | | ✓ | No buildings in the installation |
| Lubrication to avoid high friction losses; | Yes | | Compressor operations and maintenance |
| Boiler maintenance e.g. optimising excess air; | | ✓ | Automatic control system |
| Other maintenance relevant to the activities within the installation. | | | Reformer burners constantly monitored Fire eye monitors relocated to provide better monitoring of burner operation, and increased use of Purge gas within the burners (Also reducing natural gas usage) July 2008 Reformer furnace burners replaced July 2013. |

Table 2.7.2.2

| Confirm that the following physical measures are in place to avoid excessive heating or cooling losses for the following (where relevant): | Yes/no | Not relevant | Further Information (date measures will be in place or reason why not relevant) |
|---|--------|--------------|---|
| Sufficient insulation of steam systems, heated vessels and pipework | Yes | | September 2004. Screens installed to minimise the effects of high winds during winter conditions. Some vessel insulation replaced July 2013. |
| Provision of sealing and containment methods to maintain temperature | Yes | | |
| Simple sensors and timers are fitted to prevent unnecessary discharge of heated liquids and gases. | | ✓ | Discharges are only what is necessary for the blow down of the steam system |
| Other appropriate measures | | | |

Table 2.7.2.3

| Confirm that the following building service measures are in place for the following (where relevant): | Yes/no | Not relevant | Further Information (reference documentation, date measures will be in place or reason why not relevant) |
|--|--------|--------------|---|
| | | | |

| | | | |
|--|-----|---|---|
| Energy efficient lighting is in place | Yes | | External flood lights with LED lighting. Internally with high efficiency fluorescent tubes (appropriate to relevant hazardous area classification) Lighting replaced with units requiring less maintenance September 2008 |
| Energy efficient climate control systems are in place for: Space Heating Hot water Temperature control Ventilation Draught proofing | | ✓ | No buildings in the installation |

An energy efficiency plan is provided below to identify and appraise applicable energy efficiency techniques.

Table 2.7.2.4

| ALL APPLICANTS | | | APPLICANTS WITHOUT CCA OR TRADING ONLY | | |
|---|----------------------------------|----------|--|--------------------------------------|-------------------------|
| Energy efficiency measure e.g. CHP | CO ₂ savings (tonnes) | | Equivalent Annual Cost (EAC) £k | EAC/CO ₂ saved £/tonne | Date for implementation |
| | Annual | lifetime | | | |
| CHP | NA | NA | N/a | | |
| Process efficiency measures | NE | NE | | | |
| Further information | | | | | |
| See below on CHP | | | | | |
| As a new plant operating well within original design, no process changes planned and none evaluated (NE) at this early stage. However energy efficiency work is on going and any process changes identified will be added to the efficiency plan. | | | | | |

Notes

1. Refer to Energy Efficiency Guidance Note for cost appraisal methodology and CO₂ emission factors.
2. Where other appraisal methodologies have been used, state the method, and provide evidence that appropriate discount rates, asset life and expenditure (£/t) criteria have been employed

Efficient Energy supply techniques
Table 2.7.3.2

| Energy supply techniques | Is this technique currently used at the installation? (Y / N) | If NO explain why technique is not appropriate or provide implementation date |
|--------------------------------------|--|---|
| Use of CHP; | No | Not economic, v low energy user There is no on or off site use for other low grade heat such as the process steam. Thus the plant is designed to operate as close as possible to steam balance, with the excess vented |
| Recovery of energy from waste; | No | No high calorific value streams |
| Use of less polluting fuels. | Yes | Natural gas is the feedstock |
| Others applicable to your activities | | None |
| Further information | | |

Plant Manager
TC Ryan

27-01-2023