

HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT

Period: April 01, 2022 to September 30, 2022

For



HALDIA PETROCHEMICALS LIMITED HALDIA: PURBA MEDINIPUR: WEST BENGAL



Monitoring Agency



Certificate No. : TC-7649



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West Bengal Pollution Control Board (Department of Environment, Govt. of West Bengal) Memo No. 2600-5/WPB-S/99 (Part-VI), Validity: upto 31.12.2022.

Recognised by National Accreditation Board for Testing and Calibration Laboratories (NABL), Accreditation Standard ISO/IEC 17025:2005, Certificate Number TC-7649, Validity 16.12.2020 to 15.12.2022.

Recognised by MoEF & CC, Govt. of India for Air, Effluent and Drinking Water Quality Testing up to 11.04.2024 vide The Gazette of India, Extraordinary, Part-II, Section-3, Sub-Section(ii), F. No. Q-15018/61/ 2018 - CPW Dated - 13.12.2019.



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



PREFACE

Haldia Petrochemicals Limited, one of the largest petrochemical complexes in India and the only one of its kind in eastern region. The complex produces ethylene, propylene and associated liquid stream products for downstream processing into polymers and chemicals.

The scope of the study includes detailed characterisation of the environment in and around HPL complex covering an area of 10-km radius from the center of the HPL plant for Air, Noise, Effluent etc. Scientific Research Laboratory established an Environmental Laboratory in HPL Plant premises for this purpose. All sampling and testing were performed by following well-established and recognized standard procedures.

Scientific Research Laboratory wishes to place on record its deep appreciation for the trust reposed in Scientific Research Laboratory by Haldia Petrochemicals Limited for carrying out this study. Our heartiest thanks go to Shri Ashok Kumar Ghosh, EVP & Head Plant and Mr. Sasthi Mandal, Sr. GM - HSEF for their kind cooperation & help provided during the course of study.

We also appreciate tireless efforts of Mr. Avik Haldar, Sr. Manager – Environment Services & Mr. Saugata Mahindar, DGM -Environment Services without whom it would not have been possible to bring out the final report.

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Certificate No. :TC-7649

**HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022**



CONTENT

Chapter No.	Description	Page No.
1	INTRODUCTION	1 - 6
2	EFFLUENT QUALITY	7 - 19
3	GASEOUS EMISSION	20 - 29
4	METEOROLOGY	30 - 33
5	AMBIENT AIR QUALITY	34 - 43
6	VENT AND WORKZONE QUALITY	44
7	AMBIENT NOISE	45 - 46
8	LEAK DETECTION UNDER LDAR PROGRAM	47 - 52

CHAPTER NO. - 01

INTRODUCTION





Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



1.0 INTRODUCTION

1.1 General

Haldia Petrochemicals limited (HPL), Haldia, West Bengal is an integrated Petrochemicals production unit and only petrochemical complex in West Bengal. HPL mainly comprises of Naphtha Cracker Unit (NCU), Pyrolysis Gasoline Hydrogenation unit (PGHU), Py-gas Desulfurisation (PGDS), Butene-1, Benzene Extraction Unit (BEU), Butadiene Extraction Unit (BDEU). The down stream units comprise of Linear Low Density Poly Ethylene (LLDPE), High Density Poly Ethylene (HDPE) and Poly Propylene (PP).

HPL is located at about 58 nautical miles by waterways and 130 Km by roadways from Calcutta and lies in the Haldia Industrial area. Haldia is in Purba Medinipur district, West Bengal between at latitudes 21^o 56' 10" (N) and longitude 88^o 5' 47" (E). The site lies adjacent to the road linking SH 4 and NH 41. Nearest railway, station is Durgachak on the Panskura – Haldia branch line of SE railway.

A comprehensive Environmental Impact Assessment Studies for the Haldia Petrochemicals Complex was carried out in 1991. Due to the rapid urbanisation and industrialisation, the environmental scenario of this area has changed in many respects. HPL started commercial production from the month of August 2001. HPL has entrusted Scientific Research Laboratory, Kolkata, the job of Environmental Data Generation in respect of air, water, noise and solid waste after commissioning of their petrochemical complex at Haldia.

1.2 Study Area

Keeping in view the nature and size of the complex, the various guidelines available, past experience and the original EIA report, it was decided to cover an area of 10 km. radius for the purpose of ambient air monitoring from the center of the plant. Study area covers 196 villages. Field data collection are restricted within the 10 km. radius of the plant center.

1.3 Objective Of The Study

The purpose of the present study is to assess the effect of industrial activity on the environment at Haldia. The availability of resources in this area is the result of the interaction between the physical occurrence and the amount of requirement and economic means of their exploitation. Haldia is one of the most industrialized zones in the Bank of Hoogly River. The area has neither rapid industrial growth nor causes serious ecological/environmental imbalance bringing resultant problems. Ambient air quality with respect to PM_{2.5}, PM₁₀, SO₂, NO_x, CO, Benzene, B(a)P, As, Ni, Pb, NH₃ & O₃ has been monitored to evaluate the environmental conditions in and around the complex. These monitoring will help to assess the environmental scenario after commissioning of HPL also.



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



The Environmental Data Generation work has been undertaken by Laboratory of **Scientific Research Laboratory, Kolkata** for the following:

- Evaluation of present environmental status through comprehensive analysis of various generated & collected environmental data.
- Predict the probable impact on the various environmental factors due to the HPL operation.
- Analysis of the predicted impact vis-à-vis the regulatory environmental standards.
- Assessments of efficacy in process and pollution control systems.

1.4 Contents of the Report

Environmental monitoring for generation of data on meteorology, ambient air and effluent were carried out for the months of **April 2022 to September 2022**. This report contains the data of meteorology during the ambient air monitoring, analysis report of ambient air quality, work zone monitoring results, stack monitoring data, ambient Noise monitoring report, LDAR and effluent analysis report with respect to MoEF & CC and WBPCB parameter specified for Petrochemical industries and HPL respectively.

1.5 Location of the Site

Haldia Petrochemicals complex is in the industrial area of Haldia, which is developed by Haldia Development Authority. Haldia is situated at latitudes 21° 56' 10" (N) and longitude 88° 5' 47" (E) on the confluence of Hoogly and Haldi river in Purba Medinipur district, West Bengal. It is about 58 nautical miles by waterways and 130 km. by roadways from Calcutta. The area is well connected with roads, waterway and railways.

The site is flat and plain, typical of the Ganges's of the delta region. Up to the late 1960s, what is now Haldia was a very rural area. There was small set up of the Calcutta port from sand Heads and back. This was called the "Anchorage Camp" and was near the mouth of the Haldi River. With adequate favorable infrastructure such as roads, railways, waterways, port and power, Haldia has now become a major industrial township in west Bengal, after Durgapur – Asansol region. Haldia planning area is governed by Haldia Notified Area and is bounded by Hooghly, Haldi and Hijli river tidal canal. The total area of Haldia Notified Area is about 326.85 sq. km.



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



1.6 Major details of industries, which are contributing to pollution load in Haldia, its distance and location with respect to HPL Complex, are as follows:

Sl. No.	Name of the Industry	Distance from HPL complex	Direction with respect to HPL
1	Adani Wilmer Ltd.	1.0 km	North- West
2	Dhunseri Petrochem & Tea Ltd.	1.0 km	North-East
3	DPM Net Pvt. Ltd.	1.5Km	North
4	Exide Industries Ltd.	2.6 km	East
5	Emani Biotech Ltd.	2.0 km	East
6	Ennore Coke Private Ltd.	4.0 km	East ,North-East
7	Electrosteel Casting Ltd.	0.8 Km	North
8	Gokul Refoils & Solvent Ltd.	2.0 km	North- West
9	Greenways Shipping Agencies Pvt. Ltd.	3.5 km	North- West
10	Hindustan Unilever Ltd.	3.5 km	East
11	Hooghly Met Coke & Power Company	1.7 Km	South
12	Indian Oil Corporation Ltd., Haldia Refinery	3.6 km	South
13	IOC Petronas Ltd.	0.6 km	North
14	KoPT/Haldia Dock Complex	4.5 km	South
15	Lalbaba Seamless Tubes Pvt. Ltd.	1.5 km	North- West
16	MCC PTA India Corp. Private Limited	4.0 km	East ,North-East
17	M/S West Bengal Waste Management Ltd.	2.5 Km	North-East
18	Manaksia Ltd.	4.2km	East ,North-East
19	Marcus Oils Chemical Pvt. Ltd.	0.5 km	North
20	Ruchi Soya Industries Limited	0.5 km	South
21	Reliance Petroleum Ltd.	1.0 km	North
22	R.D.B. Rasayans Ltd.	0.5 km	East
23	SWAL Corporation Ltd.	2.5 km	East
24	Shamon Ispat Ltd.	2.3 km	North- West
25	Shree Renuka Sugars Ltd.	1.5 Km	South- West
26	Sanjana Cryogenic Storages Ltd.	3.5 km	East
27	Tata Chemicals Ltd.	3.0 km	East
28	URAL India Ltd.	2.5 Km	West



Certificate No. :TC-7649

**HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022**



Industrial map





Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



1.7 Site Environmental Monitoring

Site Environmental monitoring was carried out for six months (**April 2022 to September 2022**) through out the year comprising of two seasons as per MOEF & CC guidelines such as Sumer & Monsoon season in respect of

- Effluent Quality
- Stack Emission
- Meteorology
- Ambient Air Quality
- Work Zone Air Quality
- Ambient Noise
- LDAR Program

Monitoring was started in the month of **April 2022**. The purpose of the environmental monitoring was just to know environmental scenario in and around the HPL complex. Results of baseline studies are summarized in relevant chapters.

CHAPTER NO. – 02

EFFLUENT QUALITY

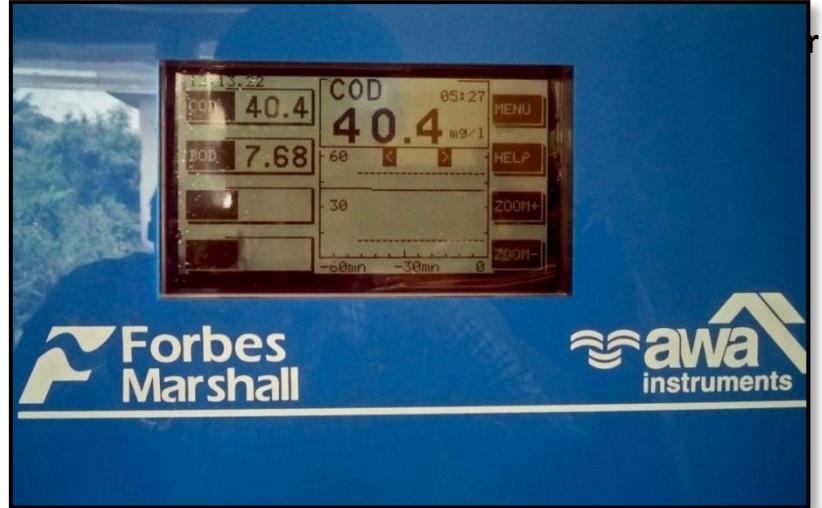


Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Online Treated Effluent Monitoring System



Online TSS analyser





Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



2.0 EFFLUENT QUALITY

HPL generates liquid waste water from Naphtha Cracker Unit, Butadiene Extraction Unit, Pyrolysis Gasoline Hydrogenation Unit, Benzene Extraction Unit, HDPE, LLDPE, PP, Cooling Tower, DM Water Plant, utilities and off site buildings. The waste-water generated requires suitable treatment before disposal and a comprehensive waste water management system comprising of collection, treatment, and disposal facilities are provided.

The treatment facilities are divided into two distinct sections, namely, pre- treatment section inside battery limits (ISBL) of the respective units and final treatments in Waste Water Treatment Plant (WWTP)

ISBL Treatment is provided for the following streams

- Spent caustic stream from Naphtha Cracker Units (NCU)
- Neutralization / free oil removal in NCU.
- Polyethylene Plants/Polypropylene Plant ISBL units for removal of Polymers and oil.
- Neutralization for Demineralisation of water plant

WWTP has been broadly designed for following treatment systems

- Oil Recovery System
- Contaminated Rain Water Treatment System
- Sanitary Sewer Treatment System
- Biological Treatment System
- Slop Oil Collection System
- Sludge Handling System
- Final Discharge System

2.1 PRETREATMENT FACILITIES

Spent Caustic from Cracker Unit

Spent caustic stream emerging from cracker unit are highly alkaline and contains high oxygen demand. In the spent caustic treatment plant, Na_2S is converted to sodium thiosulphate by oxidation process. After this treatment the stream is sent to WWTP.

Polyethylene Plants/ Poly Propylene Plant

Wash water and effluent streams from process contain trace hydrocarbon and polymers, which are collected in ISBL and then sent to WWTP after oil skimming and removal.



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



2.2 DETAILS OF WASTE WATER TREATMENT PLANT

The treatment facilities are designed for treating process water for reduction of free and emulsified oil, sulphide, phenol, thiosulphate, total suspended solids (TSS), bio-chemical oxygen demand (BOD), chemical oxygen demand (COD) and the contaminated rain water for removal of oil and suspended solids. The treated effluents from WWTP are meeting the discharge standards stipulated by West Bengal Pollution Control Board.

The wastewater treatment plant consists of Physical, Chemical and Biological treatment facilities for removal of oil, suspended solids and biodegradable organic.

Treatment Scheme of WWTP

The physical and chemical treatment scheme consists of the following units:

- Bar Screen and Grit Chamber
- Tilted Plate Interceptor (TPI)
- Equalization Tank
- pH Adjustment Tank
- Flash Mixing Tank
- Flocculation Tank
- Dissolved Air Flotation System

The biological treatment scheme consists of following units:

- Aeration tank
- Secondary Clarifier

The slop oil handling facility consists of the following units:

- Oil Skimmer
- Slop Oil Tank
- Wet slop oil sump

The sludge, handling facility consists of the following units:

- Chemical & Oily Sludge Sump
- Bio-Sludge Sump
- Thickener
- Thickened Sludge Sump
- Centrifuge



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



The treatment scheme for treating contaminated rainwater during wet weather flow consists the following units:

- Wet Weather Flow (WWF) Receiving sump
- Screen Chamber
- Grit Chamber
- Surge Pond
- Contaminated Rain Water (CRW) Transfer Sump
- TPI

WWTP has been broadly designed for following treatment systems:

Oil Removal / Recovery system

Pretreated effluent streams from various units are routed to TPI Separators for removal of free oil and suspended solids. The free oil removed from the TPI Separators, is being collected in the wet slop oil sump. The oily sludge from the bottom of TPI separators is routed to the chemical and oily sludge sump. Then the effluent from TPI units is routed (by gravity) to the equalization tank for equalization of flow and modulation of characteristics. Floating oil skimmer is provided to remove the free-oil layer formed in equalization tank. This free oil is being routed to the wet slop oil sump.

HDPE process effluent is directly received to the equalization tank for equalization of flow and its characteristics. An additional facility has been provided at the inlet of equalization tank for pH neutralization. When the equalization tank effluents will be pumped to the pH Adjustment tank where the pH of the effluent is maintained in-between 7.0 to 8.0 by dosing H₂SO₄ or Caustic solution. After achieving the desired level of the pH, the effluent is routed to Flash Mixing Tank where alum solution is added as a coagulant. It requires hydrogen peroxide solution dosing which ensures the low load of sulphides in effluent. The effluent is then routed to Flocculation Tank where addition of de- oiling Polyelectrolyte helps in breaking the oil – water emulsion and formation of alum flocks.

The effluent from flocculation tank is routed to the dissolved air floatation (DAF) tank. Oil skimmer skims off the oily scum generated in the floating tank top. Sludge settled at the bottom of the tank will be removed on periodically. The oily scum and the bottom sludge are routed to the chemical and oily sludge sump and a provision is also made to route the oily scum to wet slop through wet slop oil sump. Finally, DAF effluent is routed to the aeration tank for biological treatment.



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Contaminated Rain Water Treatment System

During wet weather, the contaminated rainwater streams of HPL complex will be received in the surge pond. Floating oil skimmer is provided to remove the free oil layer formed in the surge pond and routed to the wet slop oil sump. Provision is made to send the wastewater from the surge pond to TPI separator as and when required.

Effluent in surge pond is received after passing through Bar Screen & Grit Chamber. The effluent can be routed to equalization tank for processing after passing through TPI-02. If effluent quality is fit for disposal, it can be routed to guard pond via TPI-02.

Sanitary Sewer Treatment System

A dedicated underground sanitary sewer network is provided for entire HPL complex including the captive power plant of HPL Co-generation Ltd. and Nitrogen Plant of M/s Praxair India Pvt. Ltd. Sanitary effluent after collection in various suitable pits, is pumped to Bar screening chambers and then the grit chamber for physical removal of scum and suspended solids. Finally, sewer effluent is pumped to Aeration tank of WWTP for Biological Treatment along with other process effluents.

Biological Treatment System

An integrated biological treatment system has been adopted by HPL for reducing the biodegradable organic content of the effluents. The effluent from the DAF tank is routed to aeration tank operating in extended aeration mode for removal of biodegradable organic matter, resulting in reduction of BOD & COD. Aeration conditions are maintained in the tank by entrainment of the atmospheric air with the help of surface aerators.

The nutrients i.e. urea solution & DAP solution will be dosed at the inlet of aeration tank to provide nitrogen, phosphorus for microorganisms. The overflow from the aeration tank will contain a high concentration of microorganisms. A secondary clarifier helps in separating the microorganism from the liquid streams from the bottom sludge and the overflow is the treated effluent. Then aeration tank effluent is routed under gravity to the clarifier. The clarifier is provided with a sludge scraper, which moves slowly to scrap the bio-solids, which settle at the bottom. The collected sludge is routed to the bio-sludge sump (activated sludge sump).



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Bio – sludge sump flow is divided into two streams, one is routed to aeration tank and the other going to a sludge thickener. The excess sludge is sent to the thickened sludge sump and the balance stream is recycled back to the aeration tank to maintain the range. The overflow from the clarifier is the treated effluent, which is routed to the guard pond. Two Guard ponds (effluent holding capacity of approx. 8,180 m³) are provided to take care of all types of functional eventualities of the Waste Water Treatment Plant (WWTP). If the effluent does not meet the norms, it can be routed to equalization tank via surge pond for re-processing.

Co-generation power plant, cooling tower, nitrogen plant and DM water plant effluent will be collected in Cooling Tower Blow Down (CTBD) and DM waste pond. CTBD and DM waste pond overflow which is totally free of any organics or oil is routed to treated effluent sump along with treated effluent from guard pond for final disposal through a channel.

Effluent from LLDPE, PP, BDEU and PGHU units are received in receiving sump tank from where overflow of the tank is routed to bar screen, grit chamber, surge pond, respectively. Finally, effluent goes to TPI separator for further treatment and there is provision for pumping the effluent directly to the guard pond if effluent quality remains up to the desired level.

Slop Oil Collection System

The slop oil is collected in wet slop oil tank from various units e.g. TPI separators (I and II), equalization tank, floatation tank and surge ponds. Then slop oil is pumped to slop oil tank. The dry slop oil retained in the tank after decantation of water will be disposed as low grade fuel to external agencies. The decanted water from slop oil tank bottom will be routed to receiving sump by gravity.

Sludge Handling System

The oily sludge from the TPI separator and DAF tank are collected in chemical and oily sludge sump from, where it is routed to sludge thickener. The under flow of the sludge thickener is routed to the thickened sludge sump from where it is pumped to the centrifuge. Dewatering Polyelectrolyte is being dosed in centrifuge to achieved better sludge consistency. Periodically sludge will be collected from centrifuge and is shifted to secure on site storage pit. Latter on the accumulated bio-sludge will be incinerated in incinerator.

2.3 TREATED EFFLUENT QUALITY CHECK

SCIENTIFIC RESEARCH LABORATORY has established an Environmental Laboratory inside HPL in WWTP Laboratory as a third independent party to check the quality of effluent daily as per specifications of effluent standards.



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



2.5 METHODS OF MEASUREMENT

Sl. No.	Parameters	Specification / Standard (method) or technique used	Range of Testing	Methodology
1.	pH	Standard method (APHA)	0.1-14	pH is determined electrometrically using pH meter provided with pH electrode.
2.	TSS	Filtration Standard Method (APHA)	Min. 0.4 – 1000.0 mg/l	Measured Gravimetrically by filtering through GF/C filter paper.
3.	BOD	BOD Incubator method (APHA)	-	The dissolved oxygen content of the sample with or without dilution is measured before and after incubation at 27°C for 3 days.
4.	COD	Dichromate Reflux Method	-	Sample is refluxed in acid solution with known excess of potassium dichromate. After digestion, the remaining $K_2Cr_2O_7$ is titrated with ferrous ammonium sulphate to determine the amount of $K_2Cr_2O_7$ consumed and the oxidizable organic matter is calculated in terms of oxygen equivalent.
5.	Oil & Grease	Non-dispersive Infrared Analysis Method	0.0-200.0 mg/l	Extracted into Carbon tetrachloride after acidification of the sample and Measured Gravimetrically
6.	Phenol	Chloroform Extraction Method (APHA)	0.001-0.25mg/l	Steam distilled sample react with 4 – aminoantipyrine in presence of potassium ferricyanide at pH 7.9 and form a coloured antipyrine dye. The dye is extracted from aqueous solution with $CHCl_3$ and the absorbance is measured at 460 nm using a UV –VIS spectrophotometer.
7.	Sulphide	Iodometric Method (APHA)	0.1-10.0 mg/l	Iodometric titration with Sodium thiosulphate solution using starch as an indicator.



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Sl. No.	Parameters	Specifiction / Standard (method) or technique used	Range of Testing	Methodology
8.	Fluoride	SPADNS Method (APHA)	0.0-1.4 mg/l	Sample mixed with Zirconyl - SPADNS solution and the concentration was measured by the UV-VIS recording spectrophotometer
9.	Cyanide	Colorimetric Method (APHA)	0.02-0.2 mg/l	The alkaline distilled of cyanide is measured by pyridine – barbituric acid reagent using an UV –VIS spectrophotometer
10.	Chromium (cr ⁺⁶)	Colorimetric Method (APHA)	0.01-1.0 mg/l	Determined colorimetrically by reaction with di-phenyl carbazide in acidic solution using spectrophotometer
11.	Total Chromium	Colorimetric Method (APHA)	0.01-1.0 mg/l	Sample is oxidized with potassium permanganate and determined colorimetrically by reaction with di-phenyl carbazide in acidic solution spectrophotometer.
12.	Total Iron	Phenanthroline Method (APHA)	0.05-10.0 mg/l	Iron is reduced to ferrous state by Hydroxyl amine hydrochloride and treated with 1,10-phenanthroline at pH 3.2 to 3.3 and measured spectrophotometrically
13.	Total Zinc	Atomic Absorption Spectrophotometric Method (APHA)	0.005-2.0 mg/l	Zinc is determined by atomic absorption spectrophotometer using air-acetylene flame
14.	Total Copper	Atomic Absorption Spectrophotometric Method (APHA)	0.01-10.0 mg/l	Copper is determined by atomic absorption spectrophotometer using air-acetylene flame
15.	Phosphate (as P)	Stannous Chloride Method (APHA)	0.003-1.0 mg/l	Ammonium molybdate reacts with water sample to form Molybdophosphoric acid and reduced by stannous chloride to intensely coloured molybdenum blue and measured spectrophotometrically.



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



2.6 WATER CONSUMPTION AND EFFLUENT DISCHARGE

Water Consumption	Average Data on April 2022 to September 2022 (KL/Day)	WBPCB Conditions as per Renewed "Consent to Operate" (KL/Day)
Industrial cooling + Boiler feed water + Fire water makeup	37470	36751
Domestic purpose	1206	1510
Processing where by water gets polluted and the pollutants are easily biodegradable	1544	2000
Total Discharge of Effluent	6131	7625
Treated Effluent from Guard Pond & Surge Pond	3911	
Effluent from CTBD & DM Regeneration Pond (as diluents)	2220	

2.7 EFFLUENT QUALITY

Half Yearly Average Data of WWTP Outlet & HPL Final Outfall
Period of Monitoring: April 2022 to September 2022

Sl. No.	Parameter	Unit	Standards	WWTP Outlet	HPL Final Outfall
1.	pH	--	6.5-8.5	7.43	7.46
2.	TSS	mg/l	100	16.26	25.12
3.	BOD	mg/l	30	9.95	9.17
4.	COD	mg/l	250	47.88	43.40
5.	Total Oil & Grease	mg/l	10	<5.0	<5.0
6.	Phenol	mg/l	1	<0.002	<0.002
7.	Sulphide	mg/l	2	0.70	0.59
8.	Cyanide	mg/l	0.2	<0.02	<0.02
9.	Fluoride	mg/l	5	0.71	0.58
10.	Total Chromium	mg/l	2	<0.05	<0.05
11.	Chromium (Cr ⁺⁶)	mg/l	0.1	<0.01	<0.01
12.	FRC	mg/l	0.5	<0.1	<0.1
13.	Temperature	°C	Not >10° higher than intake	30.0	29.5
	Intake Temperature	°C		31.0	

Note: All values are in mg/l except pH.



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Monthly Average Data of WWTP Outlet & HPL Final Outfall

Sl.No.	Parameter	WWTP Outlet					
		Apr'22	May'22	Jun'22	Jul'22	Aug'22	Sep'22
1.	pH	7.66	7.49	7.45	7.36	7.21	7.43
2.	TSS	16.20	18.35	15.47	17.84	15.16	14.53
3.	BOD	7.20	11.29	8.76	13.06	9.26	10.13
4.	COD	31.63	53.71	42.30	64.03	44.08	51.50
5.	Oil & Grease	<5.0	<5.0	<5.0	<5.0	<5.0	<5.0
6.	Phenol	<0.002	<0.002	<0.002	<0.002	<0.002	<0.002
7.	Sulphide	<0.5	<0.5	<0.5	<0.5	<0.5	<0.5
8.	Cyanide	<0.02	<0.02	<0.02	<0.02	<0.02	<0.02
9.	Fluoride	0.72	0.72	0.72	0.72	0.69	0.71
10.	Total Chromium	<0.05	<0.05	<0.05	<0.05	<0.05	<0.05
11.	Chromium (Cr ⁺⁶)	<0.01	<0.01	<0.01	<0.01	<0.01	<0.01
12.	FRC	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1
13.	Temperature	31.0	30.5	30.0	30.0	30.5	30.0

Sl.No.	Parameter	HPL Final Outfall					
		Apr'22	May'22	Jun'22	Jul'22	Aug'22	Sep'22
1.	pH	7.91	7.42	7.48	7.49	7.24	7.23
2.	TSS	25.37	25.71	24.77	26.05	24.63	24.20
3.	BOD	8.73	9.55	8.14	11.07	8.90	8.63
4.	COD	39.40	44.61	41.37	51.03	42.32	41.67
5.	Oil & Grease	<5.0	<5.0	<5.0	<5.0	<5.0	<5.0
6.	Phenol	<0.002	<0.002	<0.002	<0.002	<0.002	<0.002
7.	Sulphide	<0.5	<0.5	<0.5	<0.5	<0.5	<0.5
8.	Cyanide	<0.02	<0.02	<0.02	<0.02	<0.02	<0.02
9.	Fluoride	0.60	0.60	0.58	0.57	0.57	0.55
10.	Total Chromium	<0.05	<0.05	<0.05	<0.05	<0.05	<0.05
11.	Chromium (Cr ⁺⁶)	<0.01	<0.01	<0.01	<0.01	<0.01	<0.01
12.	FRC	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1
13.	Temperature	30.0	29.5	30.0	29.0	29.5	29.0

Intake Water							
1.	Intake Temperature (°C)	31.0	30.5	30.0	30.0	31.0	31.0

Note: All values are in mg/l except pH & Temperature.

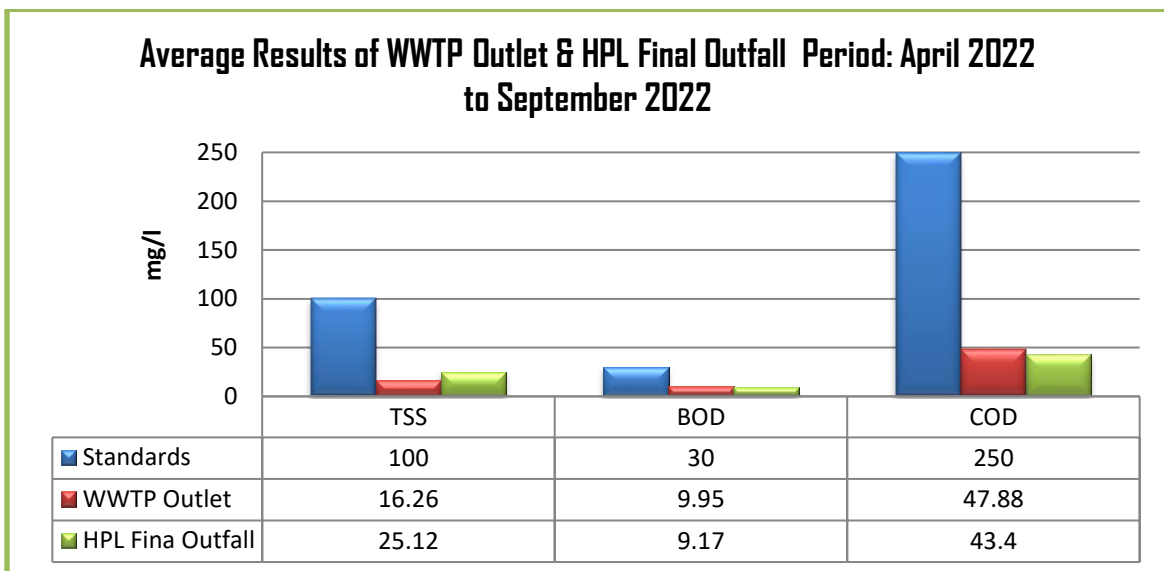


Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Graphical Representation of Effluent



WWTP I/L, WWTP O/L and HPL Final Outfall had also been analyzed for 15 parameters.

Sl. No.	Parameter	Unit	WWTP Inlet					
			Apr'22	May'22	Jun'22	Jul'22	Aug'22	Sep'22
1.	pH	--	10.45	7.98	9.66	11.40	10.41	11.33
2.	Total Suspended Solids	mg/l	73.0	31.0	70.0	62.0	68.0	153.0
3.	Chemical Oxygen Demand	mg/l	302.0	186.0	247.0	181.0	214.0	507.0
4.	Biochemical Oxygen Demand (3 days at 27°C)	mg/l	76.0	52.0	44.0	41.0	53.0	93.0
5.	Oil and Grease	mg/l	5.22	<5.0	<5.0	<5.0	<5.0	5.38
6.	Phenol	mg/l	3.08	3.85	2.70	2.84	1.85	3.18
7.	Sulphide (as S)	mg/l	5.49	5.31	5.49	4.57	6.43	7.15
8.	Cyanide (as CN),	mg/l	<0.02	<0.02	<0.02	<0.02	<0.02	<0.02
9.	Fluoride (as F)	mg/l	1.16	1.15	0.96	0.82	1.20	1.12
10.	Total Chromium (as Cr)	mg/l	<0.05	<0.05	<0.05	<0.05	<0.05	<0.05
11.	Hexavalent Chromium (as Cr ⁶⁺)	mg/l	<0.01	<0.01	<0.01	<0.01	<0.01	<0.01
12.	Iron as Fe	mg/l	0.90	1.37	1.52	0.41	0.24	0.31
13.	Zinc as Zn	mg/l	0.199	0.332	1.10	0.236	0.312	1.42
14.	Copper as Cu	mg/l	<0.05	<0.05	<0.05	<0.05	<0.05	<0.05
15.	Phosphate as P	mg/l	0.15	0.07	0.24	0.13	0.25	0.19



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Sl. No.	Parameter	Unit	WBPCB Standards	WWTP Outlet					
				Apr'22	May'22	Jun'22	Jul'22	Aug'22	Sep'22
1.	pH	--	6.5-8.5	7.79	7.38	7.56	7.08	6.98	7.35
2.	Total Suspended Solids	mg/l	100	16.0	18.0	20.0	14.0	15.0	19.0
3.	Chemical Oxygen Demand	mg/l	250	29.0	48.0	40.0	36.0	38.0	41.0
4.	Biochemical Oxygen Demand (3 days at 27°C)	mg/l	30	7.0	10.0	9.0	9.0	8.0	9.0
5.	Oil and Grease	mg/l	10	<5.0	<5.0	<5.0	<5.0	<5.0	<5.0
6.	Phenol	mg/l	1	<0.002	<0.002	<0.002	<0.002	<0.002	<0.002
7.	Sulphide (as S)	mg/l	2	<0.5	<0.5	<0.5	<0.5	<0.5	<0.5
8.	Cyanide (as CN),	mg/l	0.2	<0.02	<0.02	<0.02	<0.02	<0.02	<0.02
9.	Fluoride (as F)	mg/l	5	0.82	0.79	0.75	0.64	0.76	0.70
10.	Total Chromium (as Cr)	mg/l	2	<0.05	<0.05	<0.05	<0.05	<0.05	<0.05
11.	Hexavalent Chromium (as Cr ⁶⁺)	mg/l	0.1	<0.01	<0.01	<0.01	<0.01	<0.01	<0.01
12.	Iron as Fe	mg/l	1	0.70	0.28	0.41	0.29	0.22	0.26
13.	Zinc as Zn	mg/l	1	0.195	0.356	0.243	0.105	0.0084	0.101
14.	Copper as Cu	mg/l	1	<0.05	<0.05	<0.05	<0.05	<0.05	<0.05
15.	Phosphate as P	mg/l	5	0.65	0.69	0.94	0.64	0.37	0.35

Sl. No.	Parameter	Unit	WBPCB Standards	HPL Final Outfall					
				Apr'22	May'22	Jun'22	Jul'22	Aug'22	Sep'22
1.	pH	--	6.5-8.5	7.65	7.40	7.48	7.59	7.02	7.56
2.	Total Suspended Solids	mg/l	100	11.0	22.0	34.0	11.0	22.0	22.0
3.	Chemical Oxygen Demand	mg/l	250	36.0	36.0	33.0	40.0	44.0	44.0
4.	Biochemical Oxygen Demand (3 days at 27°C)	mg/l	30	8.0	7.0	7.0	11.0	9.0	10.0
5.	Oil and Grease	mg/l	10	<5.0	<5.0	<5.0	<5.0	<5.0	<5.0
6.	Phenol	mg/l	1	<0.002	<0.002	<0.002	<0.002	<0.002	<0.002
7.	Sulphide (as S)	mg/l	2	<0.5	<0.5	<0.5	<0.5	<0.5	<0.5
8.	Cyanide (as CN),	mg/l	0.2	<0.02	<0.02	<0.02	<0.02	<0.02	<0.02
9.	Fluoride (as F)	mg/l	5	0.76	0.65	0.58	0.52	0.62	0.57
10.	Total Chromium (as Cr)	mg/l	2	<0.05	<0.05	<0.05	<0.05	<0.05	<0.05
11.	Hexavalent Chromium (as Cr ⁶⁺)	mg/l	0.1	<0.01	<0.01	<0.01	<0.01	<0.01	<0.01
12.	Iron as Fe	mg/l	1	0.62	0.56	0.35	0.17	0.72	0.45
13.	Zinc as Zn	mg/l	1	0.094	0.191	0.125	0.077	0.076	0.050
14.	Copper as Cu	mg/l	1	<0.05	<0.05	<0.05	<0.05	<0.05	<0.05
15.	Phosphate as P	mg/l	5	0.53	0.76	0.65	0.41	0.30	0.28

CHAPTER NO. – 03

GASEOUS EMISSION

(STACK MONITORING)



Certificate No. :TC-7649

**HALDIA PETROCHEMICALS LIMITED
 HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
 APRIL 2022 – SEPTEMBER 2022**



**Online Stack Monitoring System at CPP
 Online SO_x, NO_x & CO analyser**



Online PM analyser



3.0 GASEOUS EMISSION

GENERAL INFORMATION ABOUT STACK								
Sl. No.	Particulars	Auxiliary Boiler (2 Nos.)	GT & HRSG (2 Nos.)	PGHU	PGDS	*NCU (9 Nos.)	Incinerator	EDG
1	Stack height from ground level	54.3 mt.	45 mt.	33 mt.	30 mt.	--	30 mt.	17.2 mt.
2	Sampling port from ground level	36.5 mt.	30.5 mt.	24.95 mt.	19.70 mt.	--	15 mt.	16.4
3	Stack made by	MS	MS	MS	MS	--	MS	MS
4	Diameter of the stack at sampling point	2.3 mt.	3.6 mt.	0.95 mt.	1.06 mt.	--	0.76 mt.	--
5	Shape of the stack	Circular	Circular	Circular	Circular	--	Circular	Circular
6	Area of the stack	4.1527 m ²	10.17 m ²	0.7091 m ²	0.883 m ²	--	0.4538 m ²	0.0707 m ²
7	Whether stack is attached with permanent ladder & platform	Yes	Yes	Yes	Yes	--	Yes	Yes
8	Type of Fuel	CBFS, RFG & Naphtha	Naphtha & RFG	RFG	RFG	RFG	RFG	HSD
9	Fuel consumption (Rated)	7.2 (Naphtha)	9.65(Naphtha)	---	1.44 KTA (0.16T/Hr.)	--	Primary Combustion Chamber : 0.7 M Kcal/hr. Secondary Combustion Chamber : 0.35 M Kcal/hr.	Full Load – 315 Liter/KW & ¾ Load -235 Liter/KW
10	Capacity (Rated)	120 TPH	GT-34.5 MW; HRSG-120 TPH SHP & 22 TPH MP	60 TPH	30 TPH	--	Solid waste : 220 Kg/hr. & Liquid Waste : (30 – 35) Kg/hr.	--
12	Whether stack is attached with emission control device	No	No	No	No	No	Yes, (Ventury Scrubber & Droplet Catcher)	NO

*CPCB Emission Regulations Part-Three for stack is not applicable for NCU. The Licensor did not provide any provision for Iso-Kinetic sampling of flue gas for measurement of PM. However, gas sampling can be done for SO₂, NO_x & CO.



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Standards of Stacks

Unit	Standards	SO ₂	NO _x	CO	PM	HCL	HF	TOC	Dioxin & Furan
NCU & PGHU	Standard as per WBPCB	50	350		10				
PGDS		50	250		05				
CPP Stacks			100 ppm of 15% excess O ₂	1% V/V	50				
Incinerator	Standards for Common hazardous waste Incinerator (CPCB & MOEF – 2005) (mg/Nm ³) Except Dioxin & Furan (ng TEQ/Nm ³)	200	400	100	50	50	4	20	0.1

Note: 188 mg/Nm³ = 100 ppm, 11500 mg/Nm³ = 1%V/V

All units are expressed as mg/Nm³ except Dioxin & Furan (ng TEQ/Nm³)

Correction Factor: 1.3 % O₂ for NCU, PGHU & PGDS, 2.11 % O₂ for Incinerator

NA = Not Applicable

Methodology of Stack Sampling & analysis

Sl. No.	Parameters	Specification / Standard (method) or technique used	Range of Testing	Methodology
1.	Particulate matter	Emission Regulations, Part – Three, COINDS/18/1984-85 (chapter 2 & 3)	1 mg/m ³ & above	Sampling using stack kit
2.	Nitrogen Oxides	EPA method-7	2-400 mg/m ³	Absorption in hydrogen peroxide- sulphuric acid solution using EPA flask & spectrophotometric analysis
3.	Sulfur-di-oxide	Emission Regulations, Part – Three, COINDS/18/1984-85 (chapter 4)/EPA method-6	3.4mg-80,000 mg/m ³	Absorption in hydrogen peroxide solution & titration using Ba-perchlorate
4.	Carbon Monoxide (CO)	IS: 5182 (Part 10): 1999 (First Revision)	0.05 – 200 ppm	Sampling of CO in gas sampling tubes & analysis by Non-dispersive Infrared Absorption Method.
5.	TOC	Sampling same as particulate matter	1mg/m ³ & above	TOC Analyser



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Sl. No.	Parameters	Specification / Standard (method) or technique used	Range of Testing	Methodology
6.	HCL	APHA 20 th edition , 4500 Cl – B	1mg/m ³ & above	Tritation with std. AgNO ₃
7.	HF	EPA Method – 13A	0.1mg/m ³ & above	SPADNS Method
8.	Total Dioxin & Furan	EPA Method – 5	1 to 100 pg/μL	Sampling in Soxhlet Extraction Apparatus and analysis by GCMS.

Monitoring Frequency

Major source of pollutants from various stacks and parameters monitored are as follows:

Sl. No.	Unit	No.of Stack	Parameters	Frequency of Monitoring
1.	Naphtha Cracker Unit	09	SO ₂ , NO _x , CO	Once in a month
2.	Pyrolysis Gasoline Hydrogenation Unit	01	SO ₂ , NO _x , CO, PM	Once in a month
3.	Py-gas Desulfurisation Unit	01	SO ₂ , NO _x , CO, PM	Once in a month
4.	Incinerator	01	SO ₂ , NO _x , CO, PM, TOC	Once in a month
			HCL, HF, Dioxin & Furan	Quarterly
5.	CPP – Auxiliary Boiler	02	SO ₂ , NO _x , CO, PM	Twice in a month
6.	CPP –GT & HRSG	02	SO ₂ , NO _x , CO, PM	Twice in a month
7.	CPP – Emergency DG	01	SO ₂ , NO _x , CO, PM	Quarterly



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



STACK MONITORING RESULTS
(April 2022 to September 2022)

A.Naphtha Cracker Unit (NCU)

Half-Yearly Average Results

Furnace Heater No.	Temp. (°c)	SO ₂ (mg/Nm ³)	NO _x (mg/Nm ³)	CO (mg/Nm ³)	No. of Monitoring
2F – 201	144.0	5.60	24.12	2.83	6
2F – 202	134.0	5.61	24.07	3.83	6
2F – 203	111.0	5.71	26.53	3.83	6
2F – 204	123.0	5.70	26.52	4.00	6
2F – 205	112.0	6.38	24.53	3.67	6
2F – 206	152.0	5.59	24.36	4.00	6
2F – 207	126.0	5.82	25.68	4.00	6
2F – 208	159.0	5.45	25.13	4.67	6
2F – 209	139.0	6.16	26.72	3.67	6

Stack Monitoring Results – Location Wise

Sl.No.	Furnace Heater No.	Unit	Date of Monitoring	Temp. (°C)	Results in mg / Nm ³		
					SO ₂	NO _x	CO
1	2F-201	NCU	06.04.2022	142.0	7.05	29.12	3.0
2			10.05.2022	145.0	2.91	24.69	3.0
3			24.06.2022	143.0	4.21	16.99	3.0
4			26.07.2022	143.0	4.01	23.02	3.0
5			12.08.2022	144.0	7.48	23.19	3.0
6			07.09.2022	145.0	7.95	27.69	2.0
1	2F-202		06.04.2022	136.0	5.71	24.73	4.0
2			10.05.2022	131.0	5.18	22.30	5.0
3			24.06.2022	136.0	6.29	20.14	4.0
4			26.07.2022	132.0	4.26	29.17	3.0
5			12.08.2022	134.0	6.16	27.69	4.0
6			07.09.2022	136.0	6.06	20.37	3.0
1	2F-203		06.04.2022	109.0	6.17	36.59	4.0
2			10.05.2022	112.0	4.81	27.48	4.0
3			24.06.2022	109.0	4.44	20.01	4.0
4			26.07.2022	113.0	6.29	24.43	4.0
5			12.08.2022	110.0	5.66	27.20	3.0
6			07.09.2022	113.0	6.88	23.48	4.0

All values corrected to 3% Oxygen



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Stack Monitoring Results – Location Wise

Sl.No.	Furnace Heater No.	Unit	Date of Monitoring	Temp. (°C)	Results in mg / Nm ³		
					SO ₂	NO _x	CO
1	2F-204	NCU	06.04.2022	126.0	7.39	35.03	3.0
2			10.05.2022	120.0	4.94	27.91	4.0
3			24.06.2022	116.0	5.85	25.81	5.0
4			26.07.2022	131.0	4.46	25.98	4.0
5			12.08.2022	121.0	7.32	23.22	4.0
6			07.09.2022	125.0	4.22	21.18	4.0
1	2F-205		07.04.2022	110.0	5.86	27.55	4.0
2			11.05.2022	121.0	4.19	29.74	5.0
3			25.06.2022	112.0	7.18	22.15	4.0
4			27.07.2022	108.0	5.52	19.34	3.0
5			18.08.2022	107.0	6.92	22.36	3.0
6			08.09.2022	113.0	8.61	26.05	3.0
1	2F-206		07.04.2022	152.0	4.71	30.50	5.0
2			11.05.2022	149.0	4.41	19.83	4.0
3			25.06.2022	150.0	4.21	24.96	3.0
4			27.07.2022	151.0	5.57	21.09	5.0
5			18.08.2022	150.0	6.57	19.98	4.0
6			08.09.2022	161.0	8.08	29.78	3.0
1	2F-207	07.04.2022	126.0	5.24	26.16	4.0	
2		11.05.2022	122.0	5.78	23.19	4.0	
3		25.06.2022	122.0	5.30	30.00	5.0	
4		27.07.2022	131.0	4.67	28.80	4.0	
5		18.08.2022	126.0	5.79	21.40	3.0	
		08.09.2022	127.0	8.12	24.55	4.0	
1	2F-208	07.04.2022	163.0	4.12	25.51	5.0	
2		11.05.2022	160.0	5.74	27.78	5.0	
3		25.06.2022	157.0	4.43	25.99	4.0	
4		27.07.2022	160.0	6.76	25.44	5.0	
5		18.08.2022	159.0	4.39	24.48	5.0	
6		29.09.2022	158.0	7.28	21.60	4.0	
1	2F-209	07.04.2022	138.0	5.53	22.75	4.0	
2		10.05.2022	136.0	6.00	26.94	3.0	
3		25.06.2022	135.0	6.53	24.23	4.0	
4		27.07.2022	144.0	5.69	29.81	4.0	
5		18.08.2022	141.0	5.34	28.34	4.0	
6		08.09.2022	142.0	7.84	28.25	3.0	

All values corrected to 3% Oxygen



Certificate No. : TC - 7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



B. Pyrolysis Gasoline Hydrogenation Unit (PGHU 4F-101)
(April 2022 to September 2022)

Furnace Heater No.	Temp. (°c)	SO ₂ (mg/Nm ³)	NO _x (mg/Nm ³)	CO (mg/Nm ³)	PM (mg/Nm ³)	No. of Monitoring
4F - 101	296.0	14.31	64.92	36.83	7.31	06

Month Wise Report

Sl. No.	Furnace Heater No.	Unit	Date Of Monitoring	Temp. in OC	Results in mg/Nm ³			
					SO ₂	NO _x	CO	PM
1	4F-101	PGHU	20.04.2022	279.0	16.77	53.61	39.0	6.59
2			24.05.2022	271.0	19.10	61.55	32.0	7.13
3			27.06.2022	275.0	14.00	64.35	38.0	8.65
4			21.07.2022	284.0	11.71	67.24	34.0	6.33
5			22.08.2022	281.0	13.61	73.11	42.0	7.39
6			22.09.2022	264.0	10.64	69.65	36.0	7.77

All values Calculated to 3% O₂ dry basis

C. Pyrolysis Gasoline De Sulphurisation Unit (PGDS 4F-201)
(April 2022 to September 2022)

Furnace Heater No.	Temp. (°c)	SO ₂ (mg/Nm ³)	NO _x (mg/Nm ³)	CO (mg/Nm ³)	PM (mg/Nm ³)	No. of Monitoring
4F - 201	292.0	11.47	67.21	29.83	3.89	06

Month Wise Report

Sl. No.	Furnace Heater No.	Unit	Date Of Monitoring	Temp. in OC	Results in mg/Nm ³			
					SO ₂	NO _x	CO	PM
1	4F-201	PGDS	26.04.2022	288.0	11.57	55.81	34.0	3.37
2			18.05.2022	295.0	9.56	51.03	28.0	4.10
3			28.06.2022	296.0	11.66	74.12	26.0	3.60
4			19.07.2022	289.0	13.60	75.06	28.0	3.34
5			26.08.2022	294.0	10.62	74.99	34.0	4.08
6			19.09.2022	291.0	11.83	72.24	29.0	4.86

All values Calculated to 3% O₂ dry basis

D. Incinerator stack is shutdown.



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



E. Captive Power Plant

(April 2022 to September 2022)

Furnace /Heater Name	Temp. (°c)	SO ₂ (mg/Nm ³)	NO _x (mg/Nm ³)	CO (mg/Nm ³)	PM (mg/Nm ³)	No. of Monitoring
Auxiliary Boiler #1	147.0	7.58	21.98	4.00	8.18	08
Auxiliary Boiler #2	154.0	6.38	24.01	4.00	7.51	01
GT & HRSG #1	194.0	6.75	44.06	6.25	9.56	04
GT & HRSG #2	193.0	6.32	43.17	5.60	9.47	10

Month Wise Report

Sl. No.	Furnace Heater No.	Date Of Monitoring	Temp. in OC	Results in mg/Nm ³			
				SO ₂	NO _x	CO	PM
1	Auxiliary Boiler -1	10.06.2022	153.0	5.97	23.72	3.0	6.76
		29.06.2022	143.0	8.06	14.93	3.0	9.27
		14.07.2022	145.0	8.46	19.81	6.0	11.40
		14.07.2022	146.0	9.07	20.43	6.0	10.87
		09.08.2022	148.0	8.04	25.60	4.0	9.37
		29.08.2022	147.0	6.98	22.15	3.0	7.15
		14.09.2022	149.0	7.46	26.10	3.0	5.36
		26.09.2022	147.0	6.64	23.13	4.0	5.28
2.	Auxiliary Boiler -2	14.09.2022	154.0	6.38	24.01	4.0	7.51
3.	GT -1 & HRSG - 1	29.06.2022	192.0	7.54	38.16	6.0	17.94
		13.07.2022	194.0	6.07	44.74	6.0	6.52
		14.07.2022	194.0	6.45	50.09	8.0	7.50
		08.08.2022	197.0	6.96	43.24	5.0	6.29
4.	GT -1 & HRSG - 2	05.05.2022	192.0	6.22	53.99	6.0	8.14
		26.05.2022	195.0	7.21	46.46	7.0	8.49
		09.06.2022	195.0	6.80	50.87	5.0	7.75
		29.06.2022	191.0	5.64	35.79	4.0	12.62
		13.07.2022	190.0	4.55	38.77	7.0	7.65
		29.07.2022	191.0	5.57	41.48	6.0	9.30
		08.08.2022	195.0	7.21	39.55	6.0	7.21
		29.08.2022	192.0	8.95	43.10	4.0	11.25
		14.09.2022	197.0	6.60	47.61	5.0	14.81
26.09.2022	192.0	4.47	34.05	6.0	7.44		
5.	Emergency DG	12.04.2022	119.0	8.61	27.48	46.0	18.16
		14.07.2022	120.0	9.90	25.73	32.0	21.01

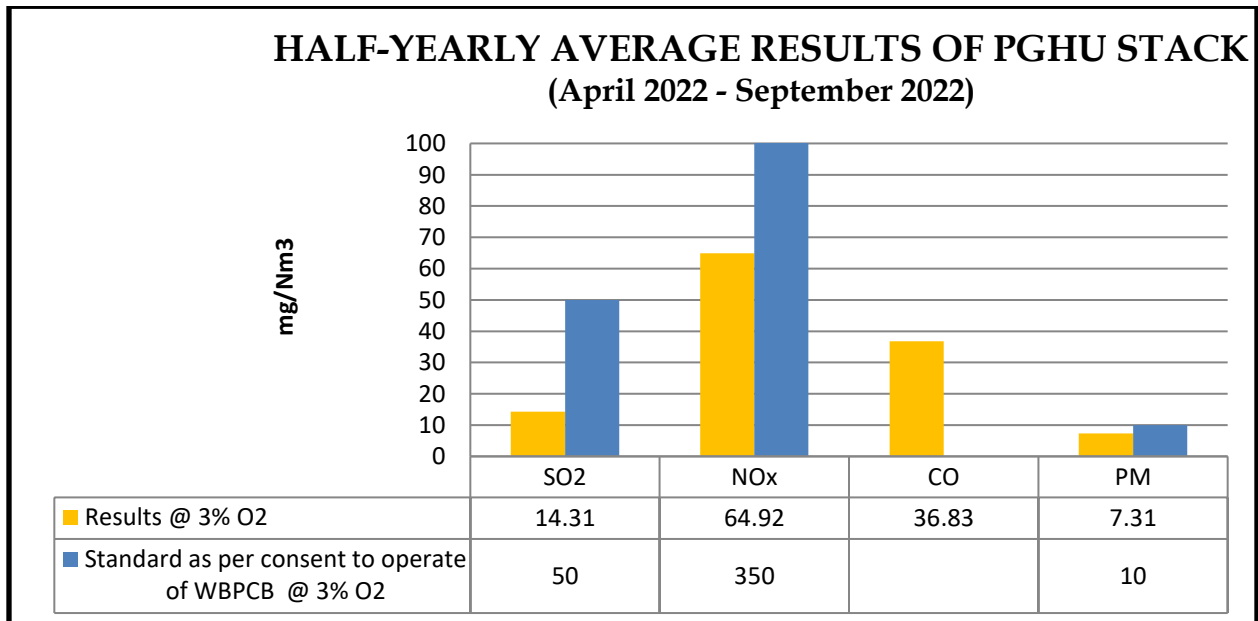
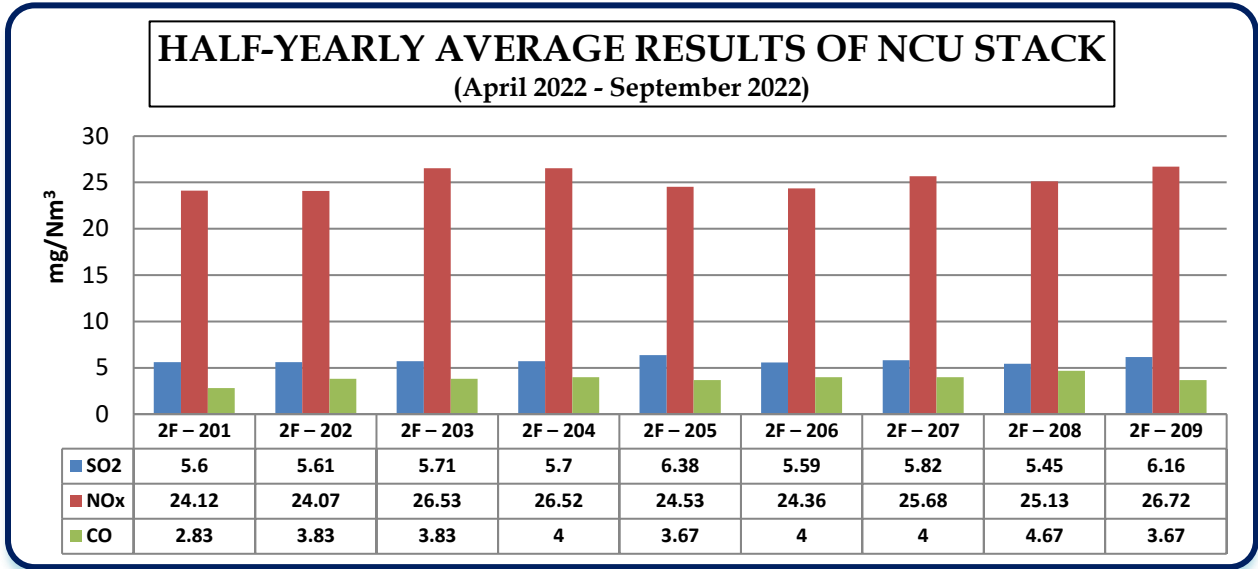


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HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Graphical Representation of Stacks



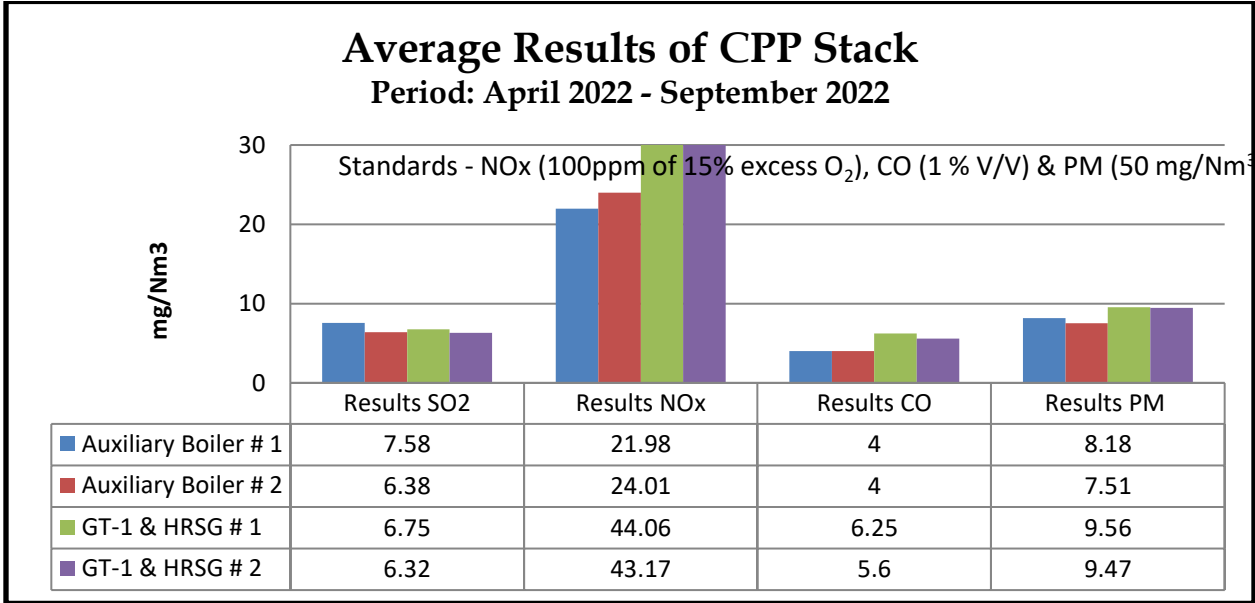
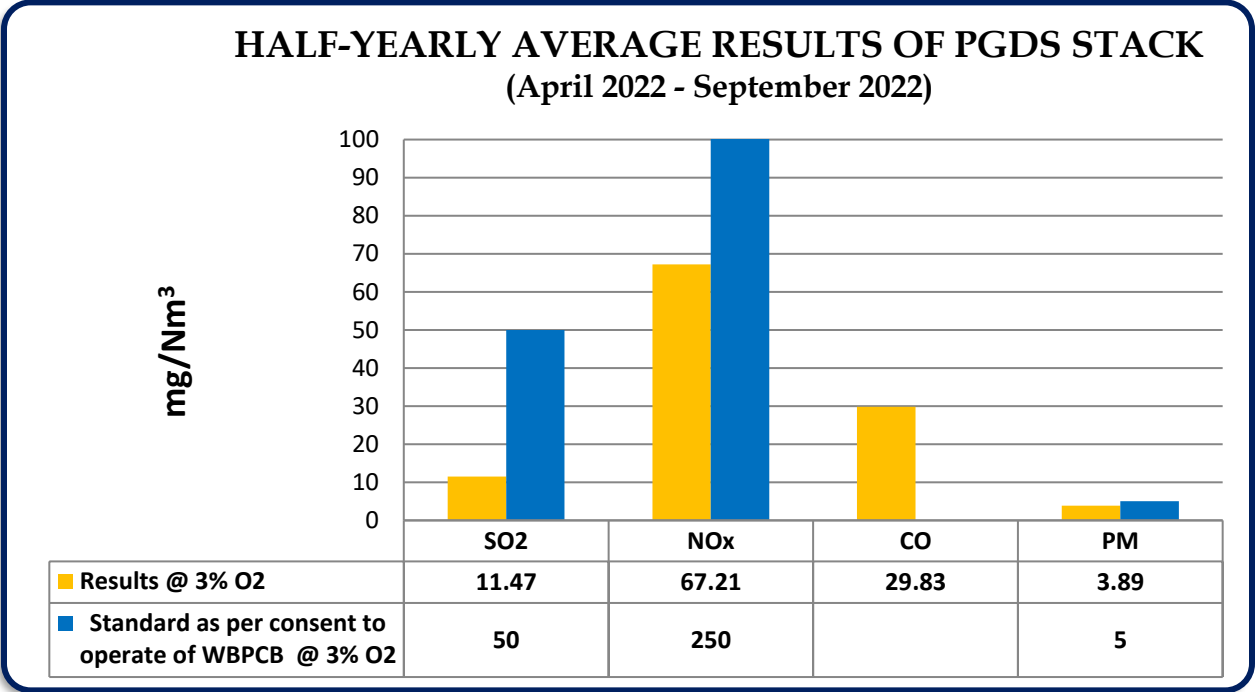


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HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Graphical Representation of Stacks



CHAPTER NO. - 04

METEOROLOGY



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



4. METEOROLOGY

The following Meteorological parameters:

- Temperature (Dry & Wet Bulb),
- Relative Humidity
- Wind Speed And Direction
- Atmospheric Pressure
- Cloud Cover (Visual Inspection)
- Rainfall

Following instruments are used for conducting meteorological data recording:

Temperature and relative humidity : Dry & Wet Bulb Thermometer And Sychrometric Chart
 Wind direction and wind velocity : Wind - Vane And Cup Counter Anemometer
 Rainfall : Rain Gauge
 Atmospheric Pressure : Barometer

Wind direction was recorded in all the sixteen directions.

A. Abstract of monitored meteorological data (Half-Yearly Max. & Min.):

Location: WWTP (Roof of Environmental Laboratory), HPL Plant

Monitoring Period: April 2022 to September 2022.

Monitoring Frequency: Twice in a week

Wind Velocity (Km/hr)		Temperature (O ⁰ C)		RH (%)		Predominant Wind Direction		Rainfall (mm)	Calm (%)	
Max.	Min.	Max.	Min.	Max.	Min.	Day	Night		Day	Night
21.8	1.2	39.0	22.5	96.0	32.0	SSE	S	2033.90	1.40	0.00

B. Abstract of monitored meteorological data (Monthly Max. & Min.):

Month	Wind Velocity (Km/hr)		Temperature (°C)		RH (%)		Predominant Wind Direction		Rainfall (mm)	Calm (%)	
	Max.	Min.	Max.	Min.	Max.	Min.	Day	Night	Monthly	Day	Night
April 2022	19.6	3.0	39.0	22.5	96.0	32.0	WSW	W	1.8	0.0	1.89
May 2022	14.3	2.3	37.5	28.0	88.0	50.0	E	ESE	205.30	0.0	0.0
June 2022	14.5	2.2	36.0	25.5	96.0	48.0	SSW	S	220.40	0.0	0.0
July 2022	11.4	2.2	36.5	28.5	96.0	48.0	SSE	S	496.40	0.00	0.00
August 2022	21.8	1.2	37.0	26.0	96.0	46.0	SSE	S	516.2	0.70	1.89
September 2022	12.9	1.6	36.0	26.0	96.0	48.0	SSE	SE	566.80	0.69	0.00



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022

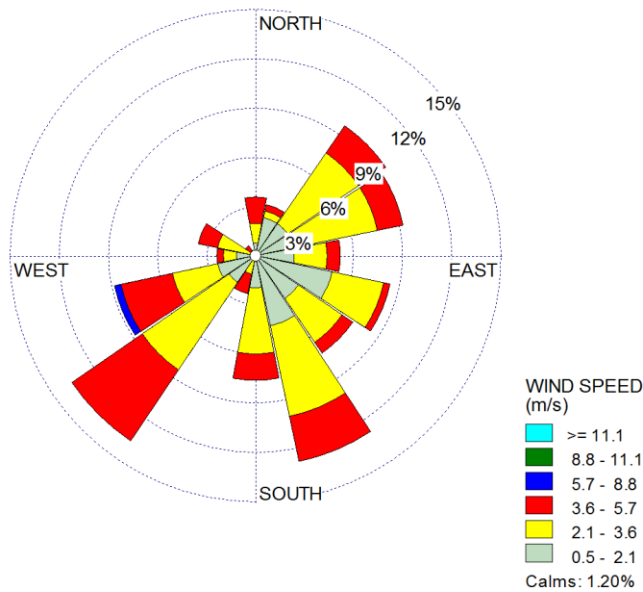


C. Meteorological Observation:

WINDROSE-FREQUENCY TABLE – FULL TIME
(Period: April 2022 to September 2022)

WIND DIRECTION	VELOCITY (in m/sec) RANGES						SUM%
	0.5<V<=2.1	2.1<V<=3.6	3.6<V<=5.7	5.7<V<=8.8	8.8<V<=11.1	V>=11.1	
N	0.80	1.20	1.60	0.00	0.00	0.00	3.60
NNE	2.40	0.40	0.40	0.00	0.00	0.00	3.20
NE	2.40	5.20	2.00	0.00	0.00	0.00	9.60
ENE	2.40	5.20	1.60	0.00	0.00	0.00	9.20
E	2.40	2.00	0.80	0.00	0.00	0.00	5.20
ESE	4.80	3.20	0.40	0.00	0.00	0.00	8.40
SE	3.20	3.20	0.80	0.00	0.00	0.00	7.20
SSE	4.40	5.60	2.80	0.00	0.00	0.00	12.80
S	2.00	4.00	1.60	0.00	0.00	0.00	7.60
SSW	0.00	1.20	1.20	0.00	0.00	0.00	2.40
SW	2.00	6.40	5.20	0.00	0.00	0.00	13.60
WSW	2.40	2.80	3.20	0.40	0.00	0.00	8.80
W	1.20	0.80	0.40	0.00	0.00	0.00	2.40
WNW	0.00	2.40	1.20	0.00	0.00	0.00	3.60
NW	0.00	0.40	0.40	0.00	0.00	0.00	0.80
NNW	0.00	0.40	0.00	0.00	0.00	0.00	0.40
SUM%	30.40	44.40	23.60	0.40	0.00	0.00	98.80
CALM	(0.00<=V<=0.5)						1.20
							100.00

WINDROSE & GRAPH – FULL TIME





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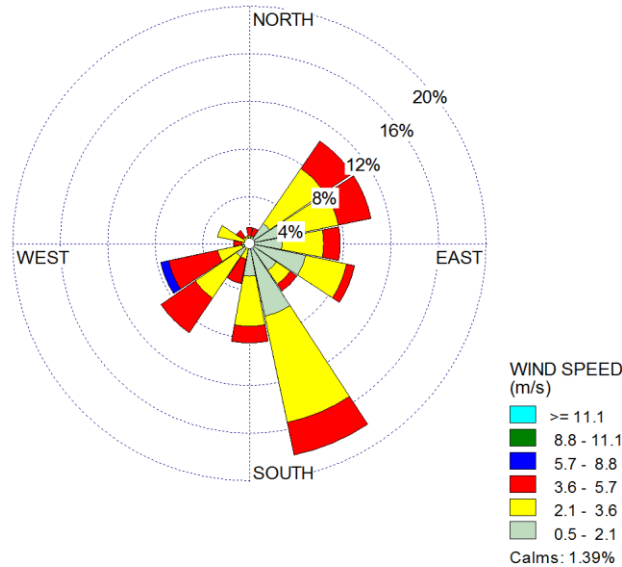
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HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



WINDROSE-FREQUENCY TABLE – DAY TIME

WIND DIRECTION	VELOCITY (in m/sec) RANGES						SUM%
	0.5<V<=2.1	2.1<V<=3.6	3.6<V<=5.7	5.7<V<=8.8	8.8<V<=11.1	V>=11.1	
N	0.00	0.70	0.70	0.00	0.00	0.00	1.40
NNE	0.70	0.00	0.70	0.00	0.00	0.00	1.40
NE	2.10	5.59	2.80	0.00	0.00	0.00	10.49
ENE	2.80	4.89	2.80	0.00	0.00	0.00	10.49
E	2.80	3.50	1.40	0.00	0.00	0.00	7.70
ESE	4.90	3.50	0.70	0.00	0.00	0.00	9.10
SE	2.80	1.40	0.70	0.00	0.00	0.00	4.90
SSE	6.30	9.02	2.80	0.00	0.00	0.00	18.12
S	2.80	4.20	1.40	0.00	0.00	0.00	8.40
SSW	0.00	1.40	2.10	0.00	0.00	0.00	3.50
SW	1.40	4.20	3.50	0.00	0.00	0.00	9.10
WSW	0.70	2.10	4.20	0.70	0.00	0.00	7.70
W	0.00	0.70	0.70	0.00	0.00	0.00	1.40
WNW	0.00	2.80	0.00	0.00	0.00	0.00	2.80
NW	0.00	0.70	0.70	0.00	0.00	0.00	1.40
NNW	0.00	0.70	0.00	0.00	0.00	0.00	0.70
SUM%	27.30	45.40	25.20	0.70	0.00	0.00	98.60
CALM	(0.00<=V<=0.5)						1.40
							100.00

WINDROSE & GRAPH – DAY TIME





Certificate No. :TC-7649

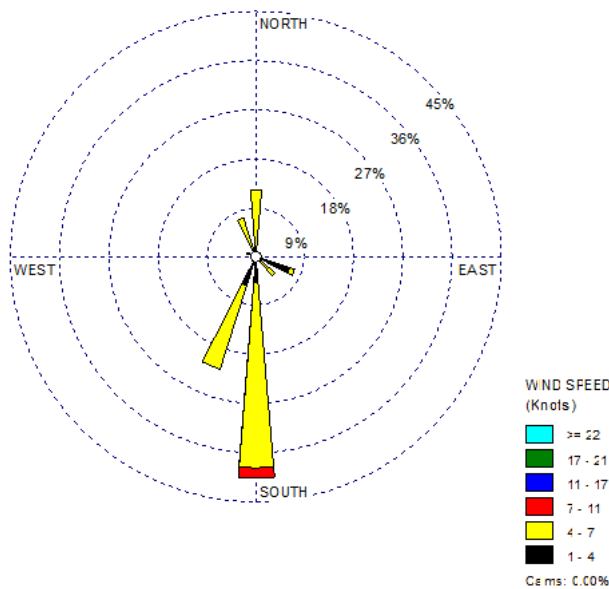
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HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



WINDROSE-FREQUENCY TABLE – NIGHT TIME

WIND DIRECTION	VELOCITY (in m/sec) RANGES						SUM %
	0.5<V<=2.	2.1<V<=3.	3.6<V<=5.	5.7<V<=8.	8.8<V<=11.	V>=11.	
	1	6	7	8	1	1	
N	1.89	10.38	0.00	0.00	0.00	0.00	12.27
NNE	0.00	0.00	0.00	0.00	0.00	0.00	0.00
NE	0.00	0.00	0.00	0.00	0.00	0.00	0.00
ENE	0.00	0.00	0.00	0.00	0.00	0.00	0.00
E	0.94	0.00	0.00	0.00	0.00	0.00	0.94
ESE	6.60	0.94	0.00	0.00	0.00	0.00	7.54
SE	0.00	4.72	0.00	0.00	0.00	0.00	4.72
SSE	0.00	0.94	0.00	0.00	0.00	0.00	0.94
S	4.72	33.97	1.89	0.00	0.00	0.00	40.58
SSW	5.66	16.04	0.00	0.00	0.00	0.00	21.70
SW	0.94	0.00	0.00	0.00	0.00	0.00	0.94
WSW	0.00	0.94	0.00	0.00	0.00	0.00	0.94
W	0.00	0.00	0.00	0.00	0.00	0.00	0.00
WNW	1.89	0.00	0.00	0.00	0.00	0.00	1.89
NW	0.00	0.00	0.00	0.00	0.00	0.00	0.00
NNW	0.94	6.60	0.00	0.00	0.00	0.00	7.54
SUM%	23.58	74.53	1.89	0.00	0.00	0.00	100.00
CALM	(0.00<=V<=0.5)						0.00
							100.00

WINDROSE & GRAPH – NIGHT TIME

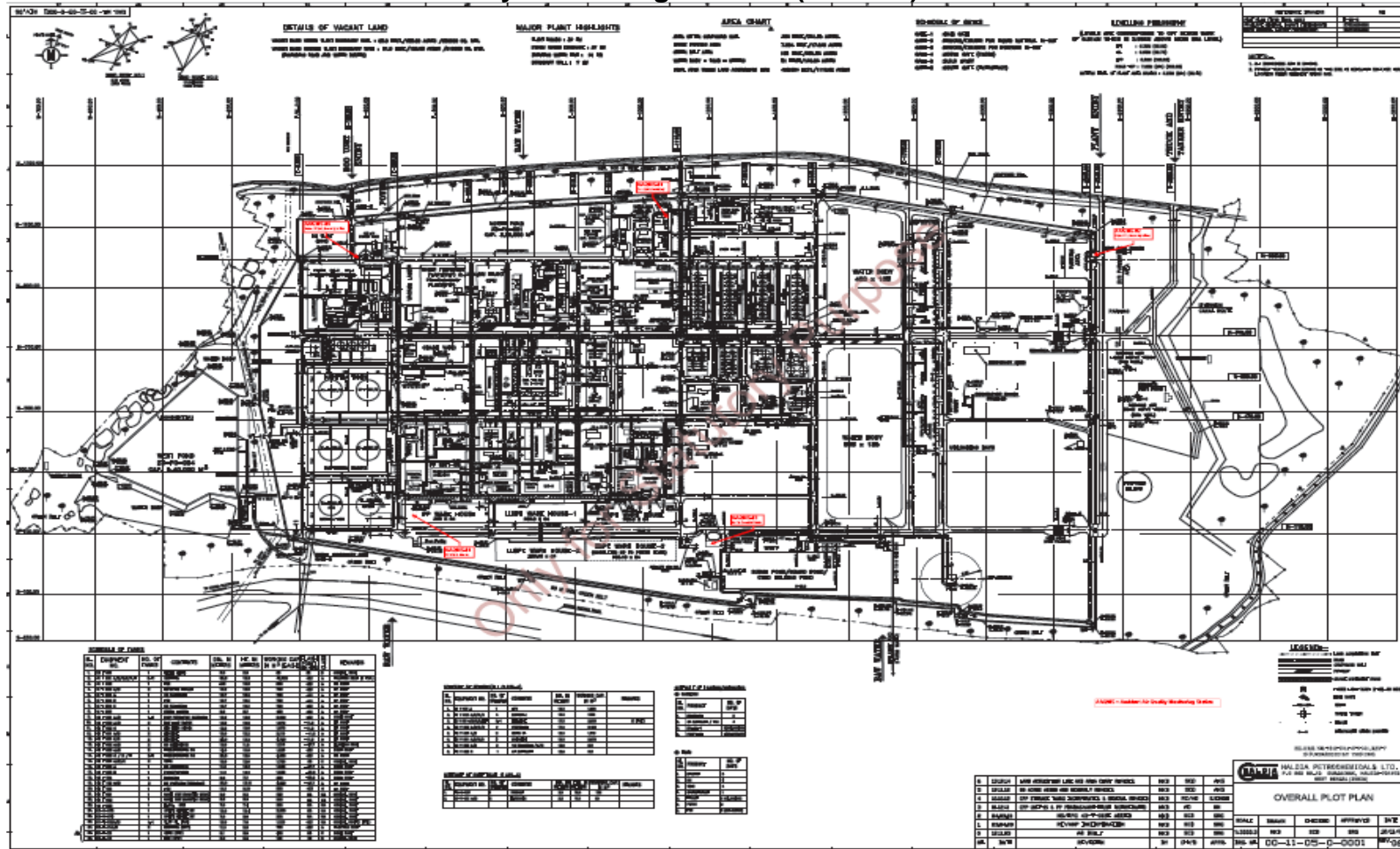


CHAPTER NO. – 05

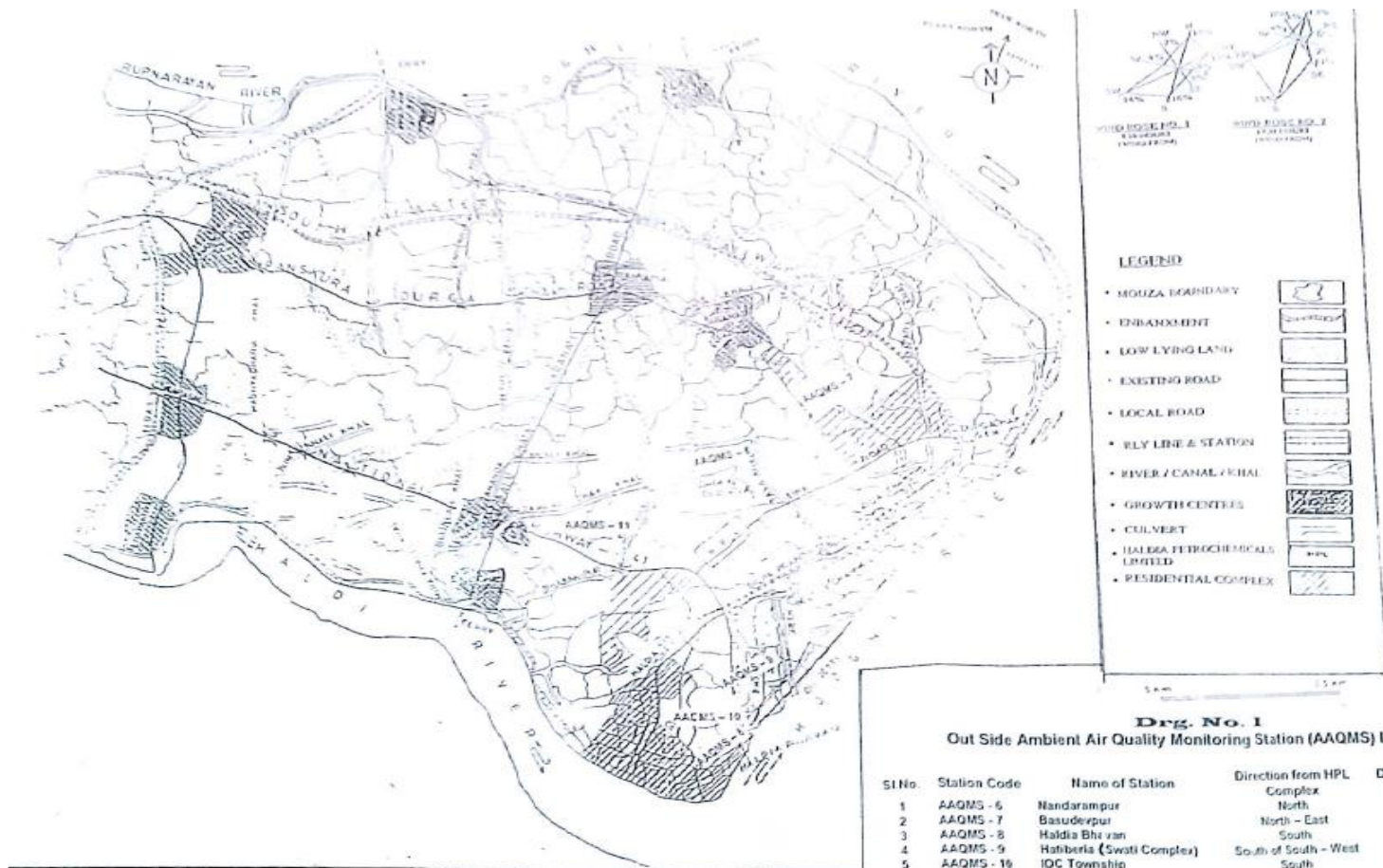
**AMBIENT AIR
QUALITY**

5.0 AMBIENT AIR QUALITY

Ambient Air Quality Monitoring stations (AAQMS) In-side 5 Location



Ambient Air Quality Monitoring stations (AAQMS) Out-side 6 Location





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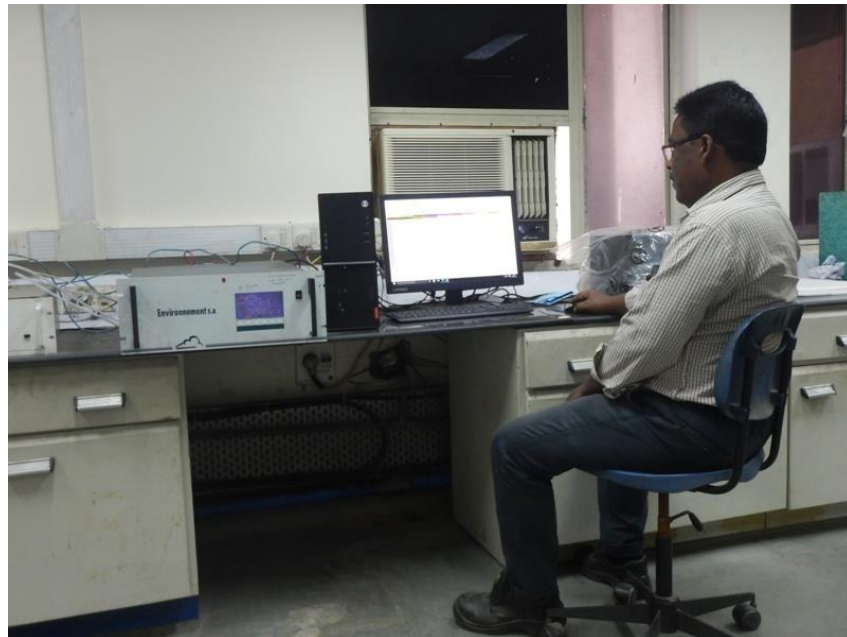
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HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022**



On-Line Ambient Air Quality Monitoring Station at South Control Room



On-Line Hydrocarbon Analyzer at Central Laboratory





Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Ambient Air Quality Monitoring stations (AAQMS)

A. In Side Ambient Air Quality Monitoring stations (Five locations):

Sl. No.	Station Code	Station Name	Direction from the center of the plant
1	AAQMS - 1	Central Laboratory	North
2	AAQMS - 2	Gate No. 1	East
3	AAQMS - 3	South Control Room	South
4	AAQMS - 4	PP Ware House	South – West
5	AAQMS - 5	CPP Entry Gate	North - West

B. Out Side Ambient Air Quality Monitoring stations (Six locations):

Sl. No.	Station Code	Name of Station	Direction from HPL Complex	Distance from HPL Complex (km)
1.	AAQMS – 6	Nandarampur	North	2.6 Km
2.	AAQMS – 7	Basudevpur	North- East	5.0 Km
3.	AAQMS – 8	Haldia Bhavan	South	6.0 Km
4.	AAQMS – 9	Hatiberia (Swati Complex)	South of South-West	4.0 Km
5.	AAQMS – 10	IOC Township	South	5.0 Km
6.	AAQMS – 11	Manaharpur	West of North-West	3.5 Km

C. Methodology of Ambient Air Sampling & Analysis

Sl. No.	Parameters	Unit	Specification / Standard (method) or technique used	Range of Testing	Methodology
1	Particulate Matter (PM ₁₀)	µg/m ³	IS: 5182(Part 23): 2006	1 µg/m ³ & above	Sampling of PM ₁₀ using Respirable Dust Sampler
2	Particulate Matter (PM _{2.5})	µg/m ³	USEPA 40 CFR Parts 53 & 58	2 µg/m ³ & above	Sampling of PM _{2.5} using Ambient Fine Dust Sampler,
3	Sulphur Dioxide (SO ₂)	µg/m ³	IS:5182 (Part-2):2006 (First Revision)	4 µg /m ³ & above	Absorption in Na-tetrachloromercurate solution followed by Spectrophotometric analysis
4	Oxides of Nitrogen (NO _x)	µg/m ³	IS:5182 (Part-6):2006 (First Revision)	10 µg /m ³ & above	Absorption in sodium hydroxide & Na-arsenite solution followed by Spectrophotometric analysis



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Sl. No.	Parameters	Unit	Specifiction / Standard (method) or technique used	Range of Testing	Methodology
5	Ozone (O ₃)	µg/m ³	Methods of air sampling and examination, Third Edition, Edited by James P. Lodge, Method 411.	8.2 µg /m ³ & above	Micro-amounts of O ₃ liberate iodine when absorbed in a 1% solution of potassium iodide buffered at pH 6.8(± 0.2). The liberated iodine is determined Spectrophotometrically by measuring the absorption of triiodide ion at 352 nm.
6	Ammonia (NH ₃)	µg/m ³	Method of Air Sampling & examination, Third Edition, Edited by James P. Lodge, Method 401	5 µg /m ³ & above	Ammonia is absorb in dilute H ₂ SO ₄ & measured colorimetrically by reaction with phenol & alkaline sodium hypochlorite to produce indophenols, a blue dye.
7	Lead (Pb)	µg/m ³	Method of Air Sampling & examination, Third Edition, Edited by James P. Lodge, Method 303A, 822	0.01 µg /m ³ & above	Lead is determined by Atomic Absorption Spectrophotometer using air-acetylene flame.
8	Benzene (C ₆ H ₆)	µg/m ³	IS: 5182(Part 11): 2006	0.042 µg /m ³ & above	Absorption on activated charcoal, desorption by carbon disulphide & analysis by GC using FID.
9	Arsenic (As)	ng/m ³	Standard Method-APHA, 20 th Edition,	0.14 ng /m ³ & above	Standard Method-APHA, 20 th Edition, 1998 by Atomic Absorption Spectrophotometer using vapour generation assembly (VGA)
10	Nickel (Ni)	ng/m ³	Method of Air Sampling & examination, Third Edition, Edited by James P. Lodge, Method 303A, 822	2.8 ng /m ³ & above	Nickel is determined by Atomic Absorption Spectrophotometer using air-acetylene flame



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Sl. No.	Parameters	Unit	Specification / Standard (method) or technique used	Range of Testing	Methodology
11	Benzo (a) Pyrene (BaP), Particulate phase only	ng/m ³	IS: 5182(Part 12): 2009	0.11 ng /m ³ & above	Benzo(a)pyrene and other polynuclear hydrocarbons are extracted from the particulate matter using a non-polar solvent cyclohexane, which extracts less extraneous material than a more polar solvent. The extract is concentrated and analyzed by Gas Chromatograph – Mass Spectrometer.
12	Carbon Monoxide (CO)	mg/m ³	IS: 5182 (Part 10): 1999 (First Revision)	0.01 mg /m ³ & above	Sampling of CO in gas sampling tubes & analysis by NDIR

D. National Ambient Air Quality Standards

Sl. No.	Parameters	Unit	Time Weighted Average	Ambient air concentration (µg/m ³)	
				Industrial, Residential, Rural & Other Area	Ecologically Sensitive Area
1	Sulphur Dioxide (SO ₂)	µg/m ³	Annual*	50	20
			24 hours**	80	80
2	Nitrogen Dioxide (NO ₂)	µg/m ³	Annual*	40	30
			24 hours**	80	80
3	Particulate Matter (PM ₁₀)	µg/m ³	Annual*	60	60
			24 hours**	100	100
4	Particulate Matter (PM _{2.5})	µg/m ³	Annual*	40	40
			24 hours**	60	60
5	Ozone (O ₃)	µg/m ³	8 hours**	100	100
			1 hours**	180	180
6	Lead (pb)	µg/m ³	Annual*	0.50	0.50
			24 hours**	1.0	1.0
7	Carbon monoxide (CO)	mg/m ³	8 hours**	02	02
			1 hours**	04	04



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Sl. No.	Parameters	Unit	Time Weighted Average	Ambient air concentration ($\mu\text{g}/\text{m}^3$)	
				Industrial, Residential, Rural & Other Area	Ecologically Sensitive Area
8	Ammonia (NH_3)	$\mu\text{g}/\text{m}^3$	Annual*	100	100
			24 hours**	400	400
9	Benzene (C_6H_6)	ng/m^3	Annual*	05	05
10	Benzo(a)Pyrene (BaP)		Annual*	01	01
11	Arsenic (As)		Annual*	06	06
12	Nickel (Ni)		Annual*	20	20

* Annual arithmetic mean of minimum 104 measurements in a year at a particular site taken twice a week 24 hourly at uniform intervals.

** 24 hourly or 08 hourly monitored values, as applicable, shall be complied with 98% of the time in a year. 2% of the time, they may exceed the limits but not on two consecutive days of monitoring.

Note.-Whenever and wherever monitoring v results on two consecutive days of monitoring exceed the limits specified above for the respective category, it shall be considered adequate reason to institute regular or continuous monitoring and further investigation.

HALF YEARLY AVERAGE RESULTS OF AMBIENT AIR QUALITY
(April 2022 to September 2022)

	PM10($\mu\text{g}/\text{m}^3$)	PM2.5($\mu\text{g}/\text{m}^3$)	SO2($\mu\text{g}/\text{m}^3$)	NOx($\mu\text{g}/\text{m}^3$)	C6H6($\mu\text{g}/\text{m}^3$)	CO(mg/m^3)
On-site Plant	53.84	26.97	19.32	21.92	2.18	0.566
Off-site Plant	44.95	22.23	12.93	15.83	1.72	0.365
	O3($\mu\text{g}/\text{m}^3$)	NH3($\mu\text{g}/\text{m}^3$)	BaP(ng/m^3)	As(ng/m^3)	Ni(ng/m^3)	Pb($\mu\text{g}/\text{m}^3$)
On-site Plant	31.39	9.03	0.29	4.26	12.11	0.139
Off-site Plant	26.87	6.15	0.13	2.23	8.04	0.081



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



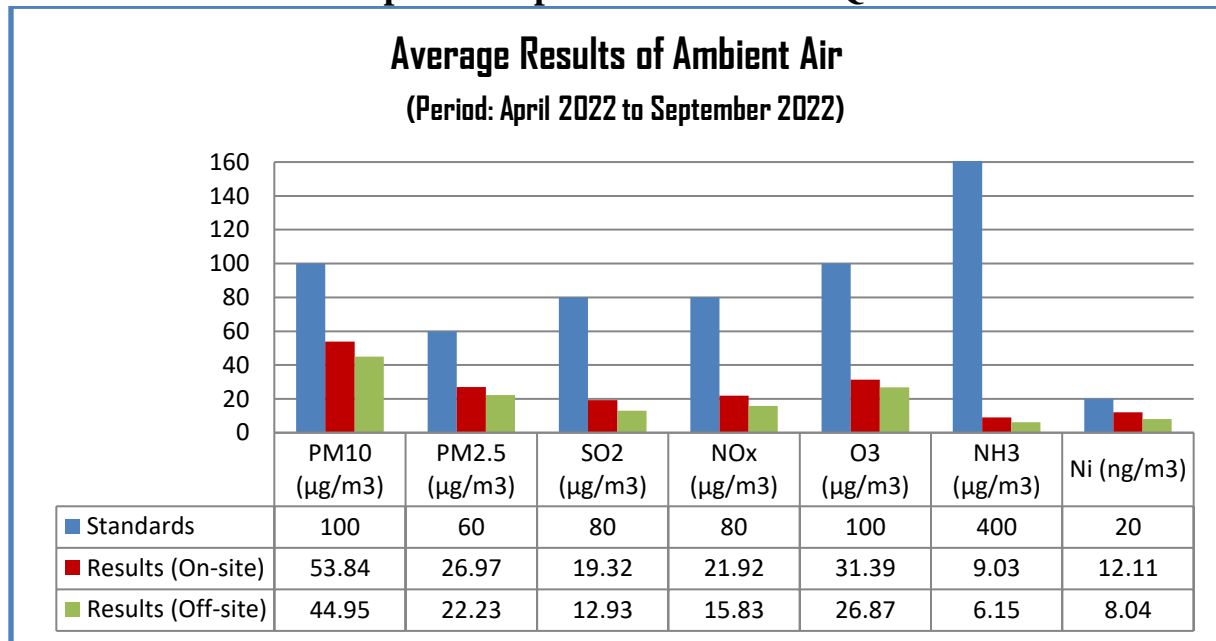
MONTHLY AVERAGE RESULTS OF AMBIENT AIR QUALITY (On-site Plant)

Month	PM ₁₀ ($\mu\text{g}/\text{m}^3$)	PM _{2.5} ($\mu\text{g}/\text{m}^3$)	SO ₂ ($\mu\text{g}/\text{m}^3$)	NO _x ($\mu\text{g}/\text{m}^3$)	C ₆ H ₆ ($\mu\text{g}/\text{m}^3$)	CO (mg/m^3)	O ₃ ($\mu\text{g}/\text{m}^3$)	NH ₃ ($\mu\text{g}/\text{m}^3$)	BaP (ng/m^3)	As (ng/m^3)	Ni (ng/m^3)	Pb ($\mu\text{g}/\text{m}^3$)
April 22	68.51	35.55	19.82	24.89	2.94	0.561	33.32	8.86	0.46	4.49	12.46	0.147
May 22	62.43	30.28	21.19	23.64	2.40	0.538	33.24	8.94	0.31	4.37	12.28	0.141
June 22	58.91	29.32	19.46	24.21	2.24	0.569	31.61	10.67	0.36	4.25	12.11	0.140
July 22	47.39	23.49	18.46	20.50	1.74	0.538	29.34	8.59	0.17	4.27	12.16	0.134
Aug 22	42.66	21.73	18.33	18.42	1.57	0.628	30.02	8.32	0.11	4.13	12.12	0.138
Sept 22	43.14	21.42	18.65	19.83	2.17	0.564	30.81	8.82	0.33	4.04	11.54	0.133
Average	53.84	26.97	19.32	21.92	2.18	0.566	31.39	9.03	0.29	4.26	12.11	0.139

MONTHLY AVERAGE RESULTS OF AMBIENT AIR QUALITY (Off-site Plant)

Month	PM ₁₀ ($\mu\text{g}/\text{m}^3$)	PM _{2.5} ($\mu\text{g}/\text{m}^3$)	SO ₂ ($\mu\text{g}/\text{m}^3$)	NO _x ($\mu\text{g}/\text{m}^3$)	C ₆ H ₆ ($\mu\text{g}/\text{m}^3$)	CO (mg/m^3)	O ₃ ($\mu\text{g}/\text{m}^3$)	NH ₃ ($\mu\text{g}/\text{m}^3$)	BaP (ng/m^3)	As (ng/m^3)	Ni (ng/m^3)	Pb ($\mu\text{g}/\text{m}^3$)
April 22	56.47	28.72	13.59	17.05	2.43	0.384	27.67	6.07	0.29	2.20	7.99	0.082
May 22	54.80	26.50	13.54	17.79	1.90	0.324	28.82	6.13	0.15	2.24	8.10	0.083
June 22	49.69	23.27	12.97	17.12	1.78	0.386	27.83	5.84	0.17	2.22	8.18	0.080
July 22	38.31	19.30	12.59	14.69	1.44	0.323	25.29	7.21	0.05	2.31	8.04	0.076
Aug 22	34.56	17.46	12.48	14.13	1.36	0.398	25.94	5.65	0.05	2.30	8.10	0.083
Sept 22	35.86	18.14	12.40	14.21	1.42	0.375	25.67	5.97	0.08	2.11	7.84	0.079
Average	44.95	22.23	12.93	15.83	1.72	0.365	26.87	6.15	0.13	2.23	8.04	0.081

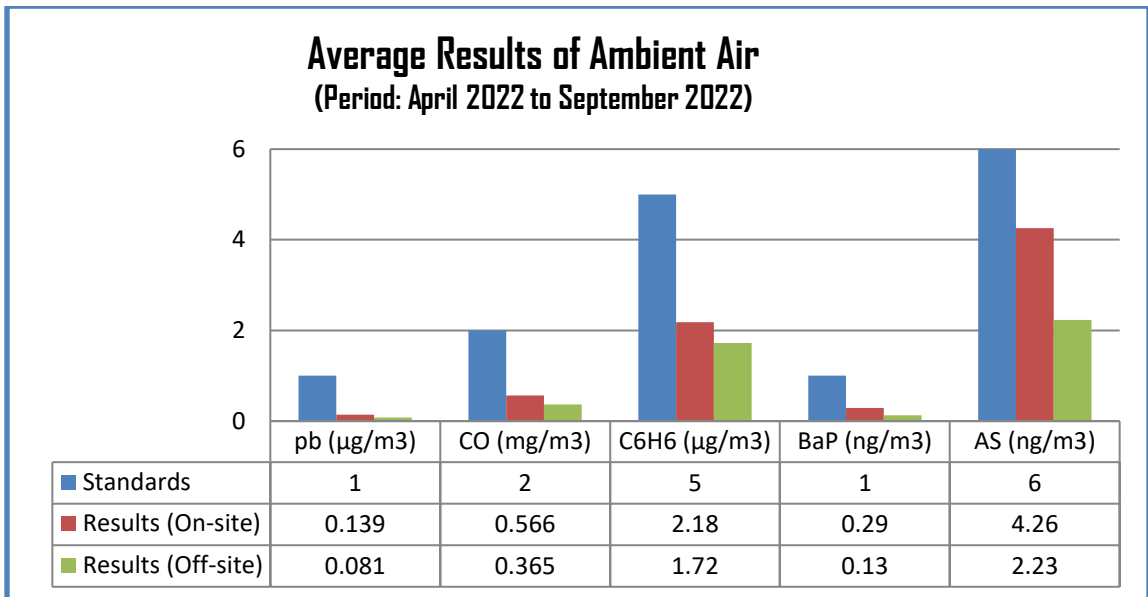
Graphical Representation of AAQ Data





Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



On-line Hydrocarbon Analyzer

One no. On-line Hydrocarbon Analyzer was installed & commissioned on January 2007. The On-line Hydrocarbon Analyzer was located at Central Laboratory. Monitoring of ambient air quality has been carried out at Central Laboratory (Inside the plant). The identified location monitoring is carried out every one hour for Total Hydrocarbon, Methane & Non Methane Hydrocarbon. The study area has been considered as an industrial area. The results for the month of **April 2022 to September 2022** are given.

Average results of On-line Hydrocarbon Analyzer Location : Central Laboratory

Month	THC (ppm)	CH ₄ (ppm)	NMHC (ppm)
April 22	3.87	2.54	1.33
May 22	4.10	2.83	1.31
June 22	3.22	2.23	1.05
July 22	2.41	1.42	0.99
Aug 22	2.87	1.77	1.10
Sept 22	2.90	1.79	1.11
Average	3.23	2.10	1.15



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HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



On-line Ambient Air Quality Monitoring Station (AAQMS)

One On-line Ambient Air Quality Monitoring station was installed & commissioned on 29 February 2008. The on-line AAQMS was located at South Control Room. AAQMS contains four analyzers (PM_{2.5}, SO₂ & H₂S, NO_x, and Hydrocarbon analyzer) for ambient air quality analysis and five sensors (Wind Speed, Wind Direction, Relative Humidity, Pressure and Temperature) for monitoring of meteorological parameters. AAQMS contains five analyzers (PM₁₀, NH₃, O₃, CO & Benzene) was installed on August 2018. The study area has been considered as an industrial area. The results for the month of **April 2022 to September 2022** are given.

Average results of On-line Ambient Air Quality Monitoring Station (AAQMS) Location : South Control Room

Month	PM ₁₀ (µg/m ³)	PM _{2.5} (µg/m ³)	SO ₂ (µg/m ³)	H ₂ S (µg/m ³)	NO _x (µg/m ³)	NH ₃ (µg/m ³)	O ₃ (µg/m ³)	Benzene (µg/m ³)	CO (mg/m ³)
April 22	75.31	21.81	78.27	13.36	25.99	19.38	35.63	1.75	0.61
May 22	55.0	23.68	15.04	11.71	21.40	19.17	36.40	4.04	0.60
June 22	44.00	25.47	15.40	11.60	15.82	38.23	35.63	4.04	0.61
July 22	31.00	12.47	8.55	10.61	10.22	53.67	31.33	4.22	0.59
Aug 22	54.0	14.13	9.2	10.91	16.59	13.05	26.34	4.03	0.59
Sept 22	47.0	14.74	7.88	10.82	18.08	13.55	24.03	2.51	0.60
Average	51.05	18.72	22.39	11.50	18.02	26.18	31.56	3.43	0.60

Month	WS (m/s)	Wind Degree	Temperature (°C)	RH (%)	Pressure (mbar)	THC (PPM)	CH ₄ (PPM)	NMHC (PPM)
April 22	4.08	106.32	32.89	50.13	746.2	2.14	1.46	0.72
May 22	3.75	354.63	33.25	49.14	712.70	2.53	1.64	0.90
June 22	3.63	352.46	33.21	49.24	747.3	2.47	1.67	0.80
July 22	4.16	326.56	32.60	50.94	724.4	2.80	1.56	1.25
Aug 22	4.13	333.79	32.39	51.54	702.2	3.09	1.59	1.50
Sept 22	5.07	335.67	32.71	50.65	702.3	2.70	1.59	1.11
Average	4.14	301.57	32.84	50.27	722.52	2.62	1.59	1.05

CHAPTER NO. – 06

**VENT EMISSION
& WORK ZONE AIR
QUALITY**



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



6.0 VENT EMISSION AND WORK ZONE AIR QUALITY

A. Methods of measurement

Sl. No.	Parameters	Standards of measurement	Range of Testing	Methodology
1.	Benzene	Method no. 12, OSHA	0.04 ppm & above	Absorption on activated charcoal, desorption by carbon disulphide & analysis by GC using FID
2.	Butadiene	Method no. 56, OSHA	0.09 ppm & above	Absorption on activated charcoal, desorption by carbon disulphide & analysis by GC using FID
3.	Hexane	Methods of Air Sampling and Examination, Third Edition. Edited by James P. Lodge, Method 109	0.05 ppm & above	Absorption on activated charcoal, desorption by carbon disulphide & analysis by GC using FID

Work Zone Monitoring Results

Half-Yearly Average Results

(April 2022 to September 2022)

Plant	Standard (ppm)	Average Results (ppm)
Benzene Extraction Unit	1.0	0.135
Butadiene Extraction Unit	1.0	0.215
Butadiene Loading Area	1.0	0.025
Hexane Area	500.0	9.16

Standards as per OSHA (TWA for 8 hrs. exposure)

Month-Wise Results

(April 2022 to September 2022)

Month	BENZENE		BUTADIENE			HEXANE	
	5P – 02 A & B Hartcut Feed Pump(BEU)	Benzene Sampling Point (050-SP-108)& 5P-07 A & B (BEU)	Butadiene Loading Gantry	In Front Of Vessel No.-581	Butadiene product sampling point	V- 2405 Draining Point	Flaker House(Ground Floor)
April 22	0.042	0.258	0.026	0.188	0.264	9.30	12.86
May 22	0.038	0.272	0.018	0.214	0.286	7.04	11.44
June 22	0.041	0.264	0.016	0.208	0.262	5.34	9.86
July 22	0.052	0.178	0.022	0.156	0.238	7.04	10.22
Aug 22	0.066	0.184	0.032	0.148	0.224	8.16	11.34
Sept 22	0.054	0.166	0.038	0.154	0.238	7.46	9.82

All results are in ppm.

Month-Wise Benzene Emission from Vent of Benzene Extraction Unit & Benzene Recovery Unit.

(April 2022 to September 2022)

Location	Standard	Month
BEU	5.0 mg/Nm ³	All results are well below the standards in all months (<0.1µg/m ³)
BRU	≤ 20.0 mg/Nm ³	All results are well below the standards in all months (<0.1µg/m ³)

CHAPTER NO. – 07

AMBIENT NOISE



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



7.0 AMBIENT NOISE

In order to establish ambient noise levels for the Study Area, measurement of noise levels were performed at seven locations. i.e 5 (Five) Nos. of identified main noise generation units and 5 (Five) locations at the boundary wall (1 meter away from the boundary walls). Noise monitoring was measured in decibel unit i.e. Leq dB(A) where A denotes the frequency weighting in the measurement of noise and corresponds to frequency response characteristics of the human ear and Leq is an energy mean of the noise level, over a specified period. Monitoring was carried out once in a season in each location.

The monitoring locations in plant boundary for ambient noise level are as follows:

Sl.No.	Location Details	Location Code	Direction from the plant Center
1.	Near Gate No.-1	AN 1	East of north east
2.	Near Gate No.-3	AN 2	East of south east
3.	South Gate	AN 3	South
4.	BOO Gate	AN4	North of north west
5.	North Gate	AN5	North

24 hours Noise (Ambient Noise) Standards (CPCB & WBPCB Standards)

Duration	Unit are dB(A)			
	Industrial	Commercial	Residential	Silence
DAY (6 am to 10 pm)	75	65	55	50
NIGHT (10 pm to 6 am)	70	55	45	40

Ambient Noise Level (Average) April 2022 to September 2022

LOCATION	April 2022		July 2022	
	Day	Night	Day	Night
Near Gate No-1	59.18	57.84	58.49	57.74
Near Gate No-3	67.06	66.76	66.88	66.26
Near South Gate	58.64	57.97	57.91	56.81
Near CPP Security Office	68.07	67.90	67.25	66.65
Near North Gate	56.85	55.67	57.30	56.16

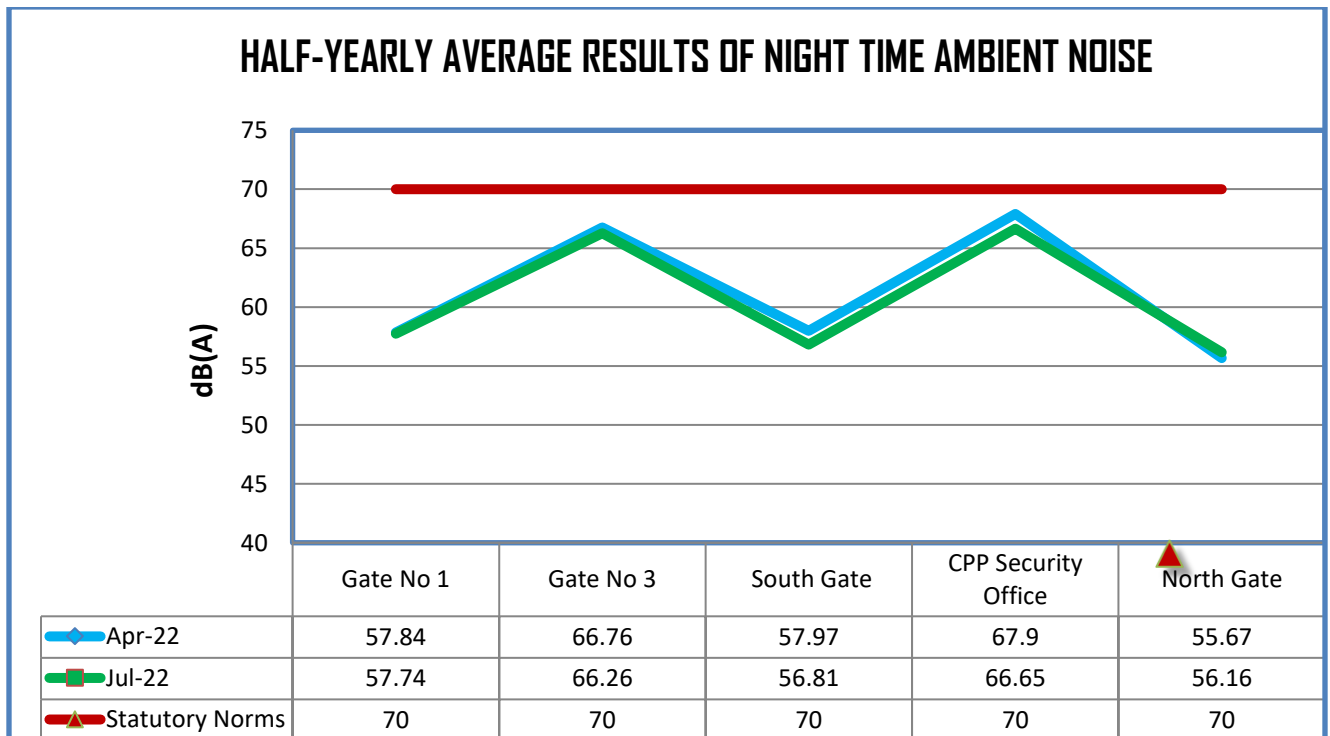
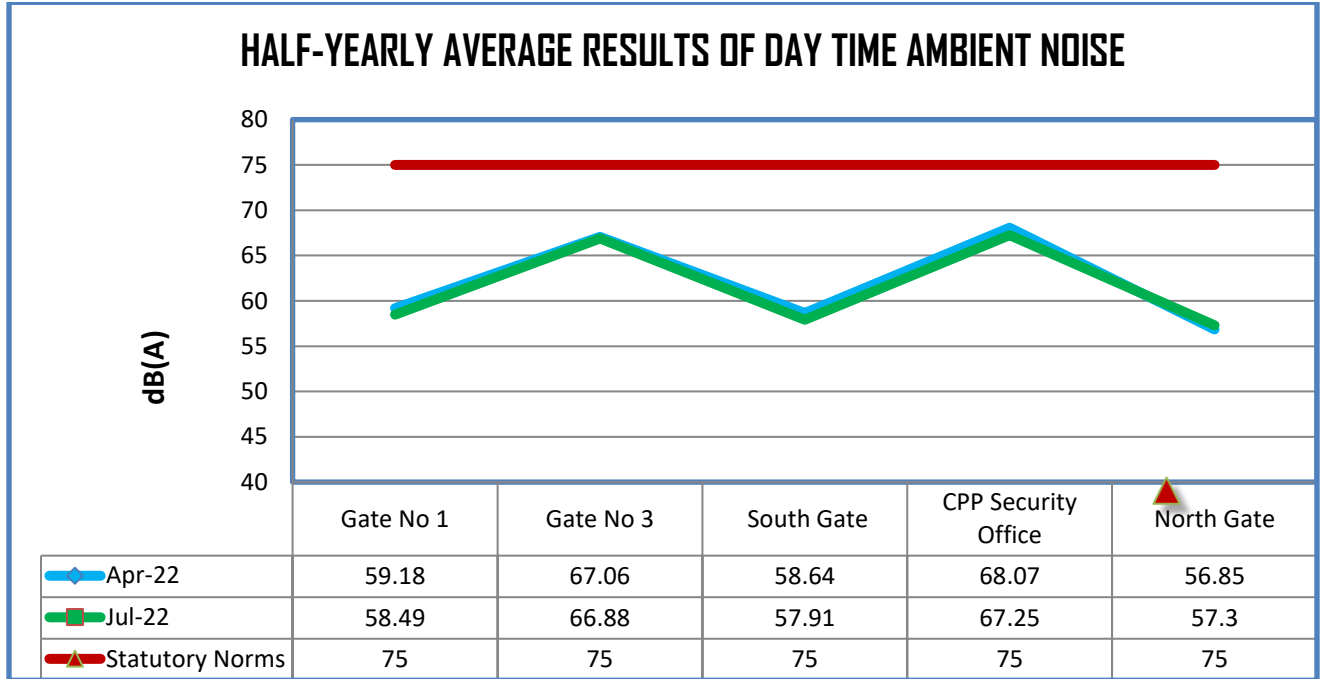


Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Graphical Representation of Ambient Noise Data



CHAPTER NO. – 08

LEAK DETECTION

UNDER LDAR

PROGRAM



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



8.0 LDAR PROGRAM

Fugitive emission monitoring

Fugitive Emission Sources:

Fugitive emission sources include leaks of hydrocarbon vapors from process equipment and evaporation of hydrocarbons from open areas, rather than through a stack or vent. Fugitive emission sources include valves of all types, flanges, pump seals, process drains, cooling towers, and oil/water separators. Normally, control of fugitive emissions involves minimizing leaks and spills through equipment changes, procedure changes, and improved monitoring, housekeeping, and maintenance practices.

Fugitive emission monitoring:

The technique which has been used to detect and control emissions from equipment leaks is known as Leak Detection and Repair (LDAR) Programme. The method which is used in LDAR program is Stratified Emission Factor Method. In this method the screening values are distributed in different ranges, like

- 0-1000 ppmv
- 1001-10,000 ppmv
- Over 10,000 ppmv

Emission factors for each screening value range have been generated from data gathered during previous EPA studies. These stratified emission factors represent the leak rate measured during fugitive emission testing. Their development incorporated the statistical methods used by EPA in developing other emission factors. The emission factor for each discrete interval, by equipment type and service, is presented in the table.

Emission Factors(kg/hr/source) for Screening value range (ppmv)				
Source	Service	0-1000	1001-10000	Over- 100000
Valves	Gas/Vapor	0.00014	0.00165	0.0451
	Light liquid	0.00028	0.00963	0.0852
	Heavy liquid	0.00023	0.00023	0.00023
Pump	Light liquid	0.00198	0.0335	0.437
	Heavy liquid	0.0038	0.0926	0.3885
Compressor seals	Gas/Vapor	0.01132	0.264	1.608
Pressure relief devices	Gas/Vapor	0.0114	0.279	1.691
Source	Service	0-1000	1001-10000	Over- 100000
Flanges, connections	All	0.00002	0.00875	0.0375
Open-ended lines	All	0.00013	0.00876	0.01195



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT APRIL 2022 – SEPTEMBER 2022



Reference: USEPA Handbook on Control Techniques for Fugitive VOC Emissions from Chemical Process Facilities. EPA/625/R-93/005, March 1994.

All screening values must be recorded according to the applicable ranges. The product of the appropriate emission factor and the number of components in each screening value range and source type. The total emission rate is the sum of all the emission rates for each value range and source type.

$EE=(NL1 *SEF1)+(NL2*SEF2)+(NL3*SEF3)$
EE=emission estimate
NL1= number leaking in first range (0-1000)
NL2= number of leaking in second range (1001-10,000)
NL3= number of leaking component in third range(over 10,000)
SEF1= stratified emission factor for first range
SEF2= stratified emission factor for second range
SEF3= stratified emission factor for third range

LDAR program has been adopted for identifying the leakage valves, pumps and flanges and quantifying the total VOC emitted from those equipments of different units. The points where the emission is over 1 ppm are considered as leaking points. Based on those identified points the total VOC emission will be estimated for each unit.



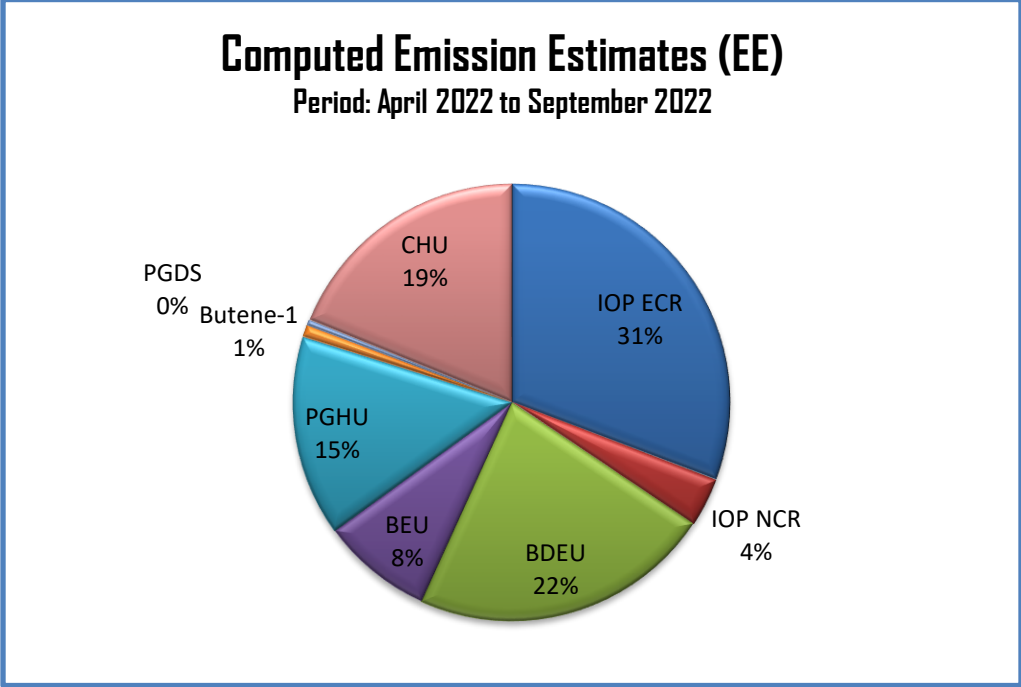
Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Estimated VOC emission from IOP (ECR & NCR), NCAU (Butadiene, Benzene, PGHU, Butene-1, PGDS & CHU)

Location	Computed Emission Estimates (EE) Actual Unit – Ton/Annum	Computed Emission Estimates (EE) in 100%
IOP ECR	0.116	30.75
IOP NCR	0.014	3.61
BDEU	0.085	22.44
BEU	0.031	8.22
PGHU	0.056	14.85
Butene-1	0.0034	0.90
PGDS	0.002	0.42
CHU	0.071	18.83
Total	0.377	100.00





Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



Total VOC emission from IOP (ECR & NCR), NCAU (Butadiene, Benzene, PGHU, PGDS, Butene-1 & CHU)

1. Total VOC emission from IOP-ECR measured in April 22:

No of points checked: 1300
 No of leaking (VOC>1ppm) points: 71
 No of non leaking points: 1229

Number of Source Screened(ppmv)					Computed Emission Estimates (EE)
Source	Service	0-1000	1001-10000	Over 10,000	Per Source Type(kg/hr)
Pump	Light liquid	4	0	0	0.00792
	Heavy liquid	0	0	0	0
Valve	Gas/Vapor	0	0	0	0
	Light liquid	16	0	0	0.00448
	Heavy liquid	0	0	0	0
Flange	All	51	0	0	0.00102
Total					0.0134
					9.66 (kg/month) / 0.116 (Ton/Annum)

2. Total VOC emission from IOP-NCR measured in May 2022:

No of points checked: 364
 No of leaking (VOC>1ppm) points: 14
 No of non leaking points: 350

Number of Source Screened(ppmv)					Computed Emission Estimates (EE)
Source	Service	0-1000	1001-10000	Over 10,000	Per Source Type(kg/hr)
Pump	Light liquid	0	0	0	0
	Heavy liquid	0	0	0	0
Valve	Gas/Vapor	0	0	0	0
	Light liquid	5	0	0	0.0014
	Heavy liquid	0	0	0	0
Flange	All	9	0	0	0.00018
Total					0.00158
					1.14 (kg/month) / 0.014 (Ton/Annum)

3. Total VOC emission from NCAU (Butadine) measured in May 2022:

No of points checked: 500
 No of leaking (VOC>1ppm) points: 40
 No of non leaking points: 460

Number of Source Screened(ppmv)					Computed Emission Estimates (EE)
Source	Service	0-1000	1001-10000	Over 10,000	Per Source Type(kg/hr)
Pump	Light liquid	3	0	0	0.00594
	Heavy liquid	0	0	0	0
Valve	Gas/Vapor	0	0	0	0
	Light liquid	12	0	0	0.00336
	Heavy liquid	0	0	0	0
Flange	All	25	0	0	0.00050
Total					0.0098
					7.06 (kg/month) / 0.085(Ton/Annum)



Certificate No. : TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022

**4. Total VOC emission from NCAU (Benzene) measured in June 2022:**

No of points checked: 500

No of leaking (VOC>1ppm) points: 31

No of non leaking points: 469

Number of Source Screened(ppmv)					Computed Emission Estimates (EE)
Source	Service	0-1000	1001-10000	Over 10,000	Per Source Type(kg/hr)
Pump	Light liquid	1	0	0	0.00198
	Heavy liquid	0	0	0	0
Valve	Gas/Vapor	0	0	0	0
	Light liquid	4	0	0	0.00112
	Heavy liquid	0	0	0	0
Flange	All	26	0	0	0.00052
				Total	0.00362
					2.606 (kg/month) / 0.031 (Ton/Annum)

5. Total VOC emission from NCAU (PGHU) measured in June 2022:

No of points checked: 500

No of leaking (VOC>1ppm) points: 59

No of non leaking points: 441

Number of Source Screened(ppmv)					Computed Emission Estimates (EE)
Source	Service	0-1000	1001-10000	Over 10,000	Per Source Type(kg/hr)
Pump	Light liquid	1	0	0	0.00198
	Heavy liquid	0	0	0	0
Valve	Gas/Vapor	2	0	0	0.00028
	Light liquid	12	0	0	0.00336
	Heavy liquid	0	0	0	0
Flange	All	44	0	0	0.00088
				Total	0.0065
					4.68 (kg/month) / 0.056(Ton/Annum)

6. Total VOC emission from NCAU (Butene-1) measured in July 2022:

No of points checked: 520

No of leaking (VOC>1ppm) points: 20

No of non leaking points: 500

Number of Source Screened(ppmv)					Computed Emission Estimates (EE)
Source	Service	0-1000	1001-10000	Over 10,000	Per Source Type(kg/hr)
Pump	Light liquid	0	0	0	0
	Heavy liquid	0	0	0	0
Valve	Gas/Vapor	0	0	0	0
	Light liquid	0	0	0	0
	Heavy liquid	0	0	0	0
Flange	All	20	0	0	0.0004
				Total	0.0004
					0.288 (kg/month) / 0.0034(Ton/Annum)



Certificate No. :TC-7649

HALDIA PETROCHEMICALS LIMITED
HALF YEARLY ENVIRONMENTAL DATA GENERATION REPORT
APRIL 2022 – SEPTEMBER 2022



7. Total VOC emission from NCAU (PGDS) measured in August 2022:

No of points checked: 68

No of leaking (VOC>1ppm) points: 9

No of non leaking points: 51

Number of Source Screened(ppmv)					Computed Emission Estimates (EE)
Source	Service	0-1000	1001-10000	Over 10,000	Per Source Type(kg/hr)
Pump	Light liquid	0	0	0	0
	Heavy liquid	0	0	0	0
Valve	Gas/Vapor	0	0	0	0
	Light liquid	0	0	0	0
	Heavy liquid	0	0	0	0
Flange	All	9	0	0	0.00018
				Total	0.00018
					0.129 (kg/month) / 0.0015(Ton/Annum)

8. Total VOC emission from NCAU (CHU) measured in August 2022:

No of points checked: 120

No of leaking (VOC>1ppm) points: 9

No of non leaking points: 111

Number of Source Screened(ppmv)					Computed Emission Estimates (EE)
Source	Service	0-1000	1001-10000	Over 10,000	Per Source Type(kg/hr)
Pump	Light liquid	4	0	0	0.00792
	Heavy liquid	0	0	0	0
Valve	Gas/Vapor	0	0	0	0
	Light liquid	1	0	0	0.00028
	Heavy liquid	0	0	0	0
Flange	All	4	0	0	0.00008
				Total	0.00828
					5.962 (kg/month) / 0.0715(Ton/Annum)

Reference: USEPA Handbook on Control Techniques for Fugitive VOC Emissions from Chemical Process Facilities. EPA/625/R-93/005, March 1994.