



62-00017

UNITED REFINING COWARREN PLT



COMMONWEALTH OF PENNSYLVANIA  
DEPARTMENT OF ENVIRONMENTAL PROTECTION  
AIR QUALITY PROGRAM

**TITLE V/STATE OPERATING PERMIT**

Issue Date: February 13, 2019

Effective Date: February 6, 2020

Revision Date: February 6, 2020

Expiration Date: [REDACTED]

Revision Type: Modification, Significant

In accordance with the provisions of the Air Pollution Control Act, the Act of January 8, 1960, P.L. 2119, as amended, and 25 Pa. Code Chapter 127, the Owner, [and Operator if noted] (hereinafter referred to as permittee) identified below is authorized by the Department of Environmental Protection (Department) to operate the air emission source(s) more fully described in this permit. This Facility is subject to all terms and conditions specified in this permit. Nothing in this permit relieves the permittee from its obligations to comply with all applicable Federal, State and Local laws and regulations.

The regulatory or statutory authority for each permit condition is set forth in brackets. All terms and conditions in this permit are federally enforceable applicable requirements unless otherwise designated as "State-Only" or "non-applicable" requirements.

**TITLE V Permit No: 62-00017**

Federal Tax Id - Plant Code: 25-1411751-1

**Owner Information**

Name: UNITED REF CO OF PA

Mailing Address: PO BOX 780  
WARREN, PA 16365-0780

**Plant Information**

Plant: UNITED REFINING COWARREN PLT

Location: 62 Warren County

62001 Warren City

SIC Code: 2911 Manufacturing - Petroleum Refining

**Responsible Official**

Name: DAN SOBINA

Title: ENVIRONMENTAL COMPLIANCE

Phone (814) 726 - 4609

**Permit Contact Person**

Name: WILLIAM J ROY

Title: ENVIRONMENTAL ENGINEER

Phone: (814) 726 - 4859

[Signature]

ERIC A. GUSTAFSON, NORTHWEST REGION AIR PROGRAM MANAGER

Pages 2-501 and 505-556 are redacted entirely.

**SECTION I: Source Group Restrictions**

Group Name: CASE-BY-CASE RACT 2

Group Description: Requirements pertaining to Case-by-Case RACT 2

Sources included in this group

ID	Name
051	PRETREATER HEATER
053	SAT GAS PLANT (DEBUT) REBOILER
055	D.H.T. HEATER 2
056	PREFACTIONATOR REBOILER 2
101A	FCC UNIT
110	WASTEWATER FUGITIVE EMISSION
219	WASTEWATER SEPARATORS
250	COOLING WATER TOWERS (2 SYTEMS) (3 TOWERS)

**I. RESTRICTIONS.****Emission Restriction(s).**

# 001

**Operating permit terms and conditions.**

NOx emissions shall not exceed the following limits for the respective Source:

Pretreater Heater - 0.11 lb/mmbtu and 21.4 TPY (12-month rolling)  
Sat Gas Plant Reboiler - 0.1 lb/mmbtu and 8.2 TPY (12-month rolling)  
DHT2 Heater - 0.12 lb/mmbtu and 19.3 TPY (12-month rolling)  
Prefactionator Reboiler 2 - 0.1 lb/mmbtu and 19.4 TPY (12-month rolling)  
FCC Unit - 11.5 lb/hr and 40.2 TPY (12-month rolling)

[Additional authority for this condition based on 129.99]

# 002

**Operating permit terms and conditions.**

- (a) Total VOC emissions from the cooling water towers shall not exceed 7.5 TPY calculated as a 12-month rolling total.
- (b) Combined VOC emissions from the Isom and Alky Pit(s) shall not exceed 3.6 TPY calculated as a 12-month rolling total.

[Additional authority for this condition based on 129.99]

**IV. RECORDKEEPING REQUIREMENTS.**

# 003

**Operating permit terms and conditions.**

The facility shall keep records of the NOx and VOC emissions for each month for the affected sources of this group (Sources 051, 053, 055, 056, 101A, 110, and 250) and shall keep records of the 12-month rolling totals to demonstrate compliance with the NOx and VOC limits for these sources.

[Additional authority for this condition based on 129.99]

**SECTION E Source-Specific Restrictions**

# 004 [REDACTED]

**Operating permit terms and conditions.**

The facility shall keep records of each biennial tuneup including the following information:

- (i) The date of the tuning procedure.
- (ii) The name of the service company and technicians.
- (iii) The final operating rate or load.
- (iv) The final CO and NOx emission rates.
- (v) The final excess oxygen rate.
- (vi) Other information required by the applicable operating permit.

[Additional authority for this condition is based on 129.99]

**VI. WORK PRACTICE REQUIREMENTS.**

# 005 [REDACTED]

**Operating permit terms and conditions.**

Sources 051, 053, 055, and 056 shall comply with the following work practices:

The sources shall be operated according to good operating practices to minimize emissions of NOx. This shall, at a minimum, consist of the following:

- (a) The permittee shall conduct a biennial tuneup of the heater which shall, at a minimum, consist of the following procedures:
  - (i) Inspection, adjustment, cleaning or replacement of fuel-burning equipment, including the burners and moving parts necessary for proper operation as specified by the manufacturer.
  - (ii) Inspection of the flame pattern or characteristics and adjustments necessary to minimize total emissions of NOx, and to the extent practicable minimize emissions of CO.
  - (iii) Inspection of the air-to-fuel ratio control system and adjustments necessary to ensure proper calibration and operation as specified by the manufacturer.
- (b) The permittee shall operate the heater at or below 9% excess oxygen, at all times except within one (1) hour of startup and/or shutdown.
- (c) During any periods of process downtime (to exclude emergencies), permittee shall inspect the heater, burner(s), air register(s), and burner tip(s); and shall repair or replace necessary components as soon as practicable.
- (d) The permittee shall document all tuneups and inspections, and any corrective actions taken.

[Additional authorization for this condition based on 129.99]

**SECTION E: Source Group Restrictions**

# 006 [REDACTED]

**Operating permit terms and conditions.**

The cooling towers shall be operated according to good operating practices to minimize emissions of VOC. This shall, at a minimum, consist of the following:

The permittee shall comply with the monitoring and repair provisions of 40 CFR 63.654.[See Section C of this permit]

[Additional authorization for this condition is based on 129.99]

# 007 [REDACTED]

**Operating permit terms and conditions.**

The Isom and Alky Pit(s) shall be operated according to good operating practices to minimize emissions of VOC. This shall, at a minimum, consist of the following:

- (a) The permittee shall minimize discharge of hydrocarbons to the Isom and Alky Pit(s), to the greatest extent practicable.
- (b) The permittee shall conduct daily inspections of the Isom and Alky Pit(s) for odors which indicate elevated VOC concentrations; and shall take corrective actions as indicated by the results of these inspections.

[Additional authorization for this requirement is based on 129.99]