Best Practices in Process Safety
It’s Not Just for Chemical Plants & Refineries

Richard W. Sarnie, CSP, P.E., ARM-E
richs@aiche.org
Rich Sarnie is AIChE’s Director of CCPS Projects and has over 30 years of risk management & safety experience in the manufacturing, transportation, mining and retail service industries.

Rich has a B.S. in Chemical Engineering from the University of Lowell (MA) and an MBA from Western New England College.

Rich is a Board Certified Safety Professional (CSP), a Licensed Professional Engineer (P.E) in Safety, an Associate in Risk Management with an Enterprise Risk Management Designation (ARM-E), a Construction Risk & Insurance Specialist (CRIS), and a Management Liability Insurance Specialist (MLIS).

Rich is licensed in New Jersey as a Producer of Property & Casualty Insurance.

Rich is a professional member of the American Society of Safety Engineers (ASSE) and the American Institute of Chemical Engineers (AIChE).
In order to protect people, property and the environment …..

… CCPS is committed to bringing the best process safety knowledge and practices to industry, academia, the governments and the public around the world through collective wisdom, tools, training and expertise.
**Mission** is to help eliminate catastrophic process industry accidents, by:

- **PROMOTING** process safety as a key societal value and expectation.
- **ESTABLISHING** process safety as the foundation for responsible operation.
- **SERVING** as the premier world-wide resource for process safety and the development of the “state-of-the-art solutions”.
- **FOSTERING** knowledge, understanding and implementation of process safety by executives, management, technicians, engineers, students, government officials and the public.
- **ADVANCING** process safety technology, culture and management practices.
For 30 Years CCPS Has Been Leading Process Safety

Creating Books and Publications

Creating Industry-wide Tools, Programs and Guidelines

Sharing Best Practices and Learning from Others

Conducting Global Conferences and Training

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Chemical Process Safety is a technical and management systems discipline that focuses primarily on prevention of loss of containment. However it also addresses the mitigation of possible consequences of accidental chemical releases, fires, and explosions.
Purpose and Scope

- This presentation includes:
  - A discussion of the continuing movement by many organizations to more formal and comprehensive enterprise wide risk management systems
  - A review of some examples of incidents in non-chemical industries
  - A review of the typical steps or phases an organization may take in developing and improving management system processes
Purpose and Scope

- An overview of a risk based process safety management system recommended by the AIChE Center for Chemical Process Safety (CCPS) and based on global chemical industry best practices.

  • Note: CCPS guidelines books shown in this presentations are listed on the publisher's website:
Purpose and Scope

• Present a rationale as to why a risk-based rather than regulatory-based approach to managing process safety and other risk exposures is prudent.
20 Elements

• Commit to Process Safety
  – *Process Safety Culture*
  – Compliance with Standards
  – *Process Safety Competency*
  – Workforce Involvement
  – *Stakeholder Outreach*

• Understanding Hazards & Risks
  – Process Knowledge Management
  – Hazard Identification & Risk Management

• Manage Risk
  – Operating Procedures
  – Safe Work Practices
  – Asset Integrity & Reliability
  – Contractor Management
  – Training & Performance Assurance
  – Management of Change
  – Operational Readiness
  – *Conduct of Operations*
  – Emergency Management

• Learn from Experience
  – Incident Investigation
  – *Measures & Metrics*
  – Auditing
  – *Management Review & continuous Improvement*
Food


- 130 people hospitalized
AIChE CCPS Risk Based PSM System Elements

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Sugar dust explosion--Imperial Sugar Plant - Savannah GA (Feb. 2008)

• 14 workers killed
• Several serious burn injuries
• Facility destroyed
20 Elements

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Why Process Safety in the Food Industry?

- Are these Statistics Acceptable?
  - Over the last 20 years (Average)
    - Ammonia Releases: 60 per year
    - Dust Explosions: 10 per year
Other Non-Chemcial Plants

Do They Need Process Safety?
Ammonium Nitrate explosion in West Texas in April 2013. 15 killed and 260 injured.
20 Elements

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  – *Management Review & continuous Improvement*
• The CSB identified 281 combustible dust incidents in the US between 1980 and 2005 that killed 119 workers and injured 718, and extensively damaged industrial facilities.
  – However, NO comprehensive federal OSHA standard exists to control the risk of dust explosions in general industry.
• PSM not fully understood by the majority of “non-chemical” manufacturers “We make food, not chemicals”
• Ammonium Nitrate not listed as a PSM Chemical
What did these incidents all have in common?
A Breakdown or Lack of Process Safety Management System

And
A Reliance on **Regulatory** Based Process Safety Management System

Versus

**Risk** Based Approach
Are we having new & improved incidents???

NO!!
We are having the same incidents over & over!

From a management system failure, what is the difference between a Tier 1 & Tier 4 event?

Tier 4: Unsafe PS Behaviors or Insufficient Operating Discipline

Tier 3: Process Safety Near Miss
Minor Loss of Primary Containment or system failure that could have resulted in a PSE

Tier 2 Process Safety Event

Tier 1 Process Safety Event

Process Safety Incident Pyramid
Avoidance of major losses – people and property

– Creation of positive business value

– Provides a license to operate

– Freedom to manage the business

Why Risk Based Process Safety?

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A Risk-Based Process Safety Management System

Goal: To design, implement, correct, and improve process safety management activities based on consideration of the risk exposures.

- A risk-based process safety management system allocates resources for specific business processes, implementation tactics and activities commensurate with the process safety risk exposures.
- Risk-based analysis and decision making need to be core competencies.
Comparison

**CCPS**

- Commit to Process Safety
  - *Process Safety Culture*
  - Compliance with Standards
  - *Process Safety Competency*
  - Workforce Involvement
  - *Stakeholder Outreach*

- Understanding Hazards & Risks
  - Process Knowledge Management
  - Hazard Identification & Risk Management
  - *(No CCPS Element)*

**OSHA**

- RAGAGEP
- Employee Participation
- Process Safety Information (PSI)
- Process Hazard Analysis (PHA)
- Trade Secrets
## Comparison

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No Matching OSHA Elements for Six RBPS Elements – CCPS vs OSHA

- Process safety culture
- Process safety competency
- Stakeholder outreach
- Conduct of operations
- Measures & metrics
- Management review & continuous improvement
“For risk based process safety (RBPS) to work most effectively, companies should integrate it practices with elements of other management systems so that RBPS is totally consistent with manufacturing operations; safety, health, an environmental controls; security; and related technical and business areas.”

What’s New at CCPS?
CCPS Certified Process Safety Professional

Launched April 10, 2016
Purpose: To provide an introduction to engineering faculty on how process safety impacts the management, design and operation of a chemical plant.

Outcomes: The workshop will enable faculty to teach process safety in their undergraduate and graduate curricula so that graduating students will have a basic understanding of process safety for their careers in industry.

Scope: The course will provide an overview of basic concepts in risk management systems and technical competencies required to prevent loss of containment of highly hazardous chemicals and materials.

Target Audience: All faculty in chemical, biochemical, materials, and mechanical engineering.

- Workshop Duration: 3 days
- Expected # of Attendees: 20-30 faculty
- Total Cost: $40K
** Purpose: ** To provide an introduction to engineering students on how leading companies across a variety of chemical process industry (CPI) sectors manage Process Safety so as to prevent catastrophic accidents involving toxic, highly reactive, and flammable materials.

** Scope: ** The course will provide an overview of basic concepts in risk management systems and technical competencies required to prevent loss of containment of highly hazardous chemicals and materials.

** Target Audience: ** Undergraduate students in their junior or senior year and graduate students in chemical, biochemical, materials, and mechanical engineering who hope to work in CPI process/plant design and manufacturing operations in the oil and gas/refining sectors, food manufacturing/storage, commodity chemicals and polymers, pharmaceuticals / nutraceutical, pulp and paper, or specialty chemicals sectors.

- **Boot Camp Duration:** 2 days
- **Each Boot Camp instructor has over 30 years of experience in the chemical, petrochemical, food or pharmaceutical industries**
- **Expected # of Attendees:** 20-30 students
- **Total Cost:** $25K
THANK YOU VERY MUCH

FOR MORE INFORMATION
CONTACT
RICH SARNIE
RICHS@AICHE.ORG