

Proposed Expansion of Refinery

on LOT 5957 (PLOT 7195) and LOT NO 60634, Teluk Kalong Industrial Estate, Kemaman, Terengganu



PROJECT PROPONENT



Tri Ecoedge Sdn. Bhd.

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PLANT OFFICE AND REFINERY

Kemaman Bitumen Company Sdn. Bhd.

Lot No 5957 (Plot 7195), Teluk Kalong Industrial Estate,
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Email:

EIA CONSULTANT

OVERVIEW

	Current Operation	Phase 1	Phase 2
	Train 1	Train 2	Train 3
Refining capacity	30,000 bpd (4,794 tons/day)	30,000 bpd (additional) (4,794 tons/day)	40,000 bpd (additional) (6,392 tons/day)
Total capacity after implementation	-	60,000 bpd (9,588 tons/day)	100,000 bpd (maximum) (15,980 tons/day)
Plant facilities	Train 1 operation (present), complete with full facilities	Development of Train 2 comprising of 2 nd CDU-VDU and supporting facilities	Development of Train 3 comprising of 3 rd CDU-VDU and supporting facilities
Implementation Schedule	-	2021 (36 months construction time)	2025 (tentative)

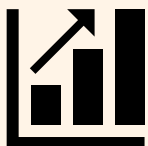
LEGAL REQUIREMENT (EIA ORDER 2015)

SECOND SCHEDULE

9 PETROLEUM

(a) Construction of oil refineries

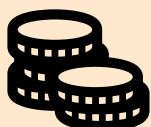
STATEMENT OF NEED



- Contribution to East Coast Economic Region (ECER)
- Drives economy of Malaysia up



- Increase jobs for local community
- Increase creation of skilled jobs
- Increases opportunity for local contractors / subcontractors



- Approx. 87 mil tonnes consumed annually in 2015
- Estimate market size, USD 70.24 billion in 2019
- Forecasted to increase to USD 79.91 billion in 2024
- Expected growth of infrastructures especially in Asia-Pacific countries will increase demand

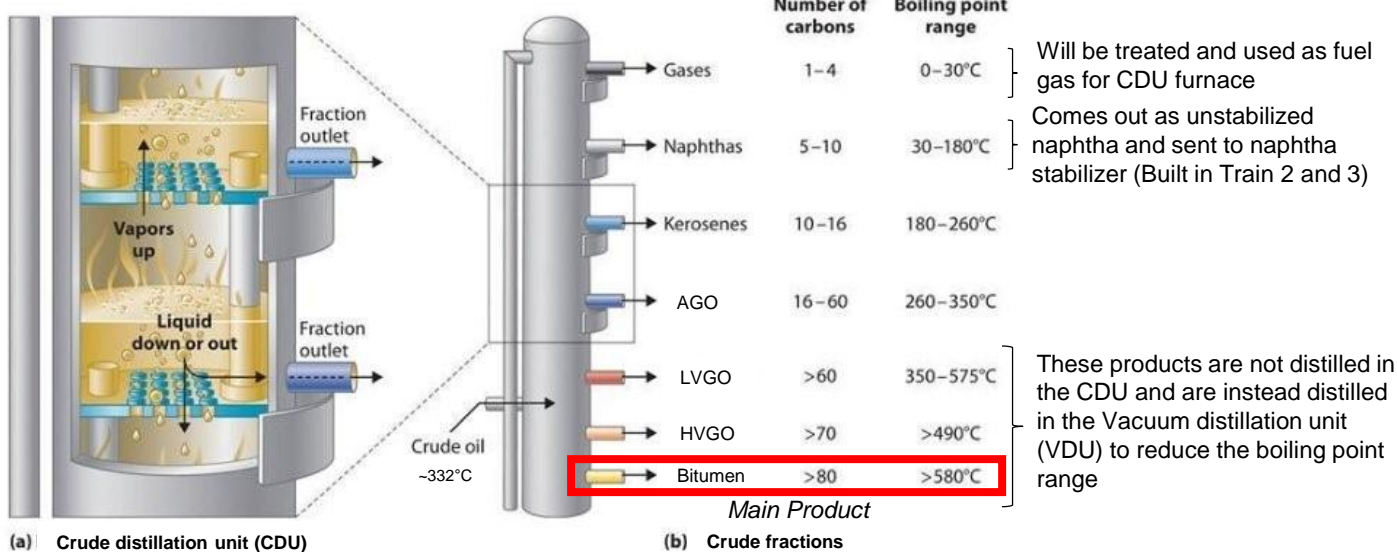
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PROJECT DESCRIPTION

Crude Distillation Unit (CDU)

Image from Department of Energy U.S.A.



New Project Components

Production Capacity

Phase 1 (Train 2)	Phase 2 (Train 3)
2 nd CDU	3 rd CDU
2 nd VDU	3 rd VDU
1 st Naptha Stabilizer	2 nd Naptha Stabilizer
Additional Sour Water Stripper	Additional Sour Water Stripper
1 st Desalter Unit	2 nd Desalter Unit
WWTP upgrade (+30 m ³ /hr)	WWTP upgrade (+40 m ³ /hr)
8 Tanks Constructed, 6 Tanks Modified, 2 Existing Tanks Demolished	6 Tanks Constructed
Existing Flare Stack Refitted	2 nd Flare Stack

Products	Production Capacity (MT/year)		
	Train 1	Projected Train 2	Projected Train 3
Bitumen	1,250,000	1,250,000	1,666,667
Atmospheric Gas Oil (AGO)	350,000	350,000	466,667
Vacuum Gas Oil (VGO)	67,000	67,000	89,333
Kerosene	53,000	53,000	70,667
Naphtha	42,500	42,500	56,667

Fuel Consumption

Equipment	Unit			Type of Fuel	Fuel Consumption, kg/hr		
	Train 1	Train 2	Train 3		Train 1	Train 2	Train 3
CDU Furnace	√			Natural Gas	1,424.53		
VDU Furnace	√				541.58		
Hot Oil Furnace	√				235.31		
Boilers 1, 2, 3	√				1,024.52 × 3		
Flaring Stack	√				5		
Total					5,337.4		
Boiler 4 (BL-403D)		√		Natural Gas		1,033	
2 nd CDU		√			1,055		
2 nd VDU		√			385		
Cumulative Total					7,810		
Boiler 5			√	Natural Gas			1,380
3 rd CDU			√		1,410		
3 rd VDU			√		520		
2 nd Flaring Stack			√		5		
Cumulative Total					11,125		

Proposed Expansion of Refinery

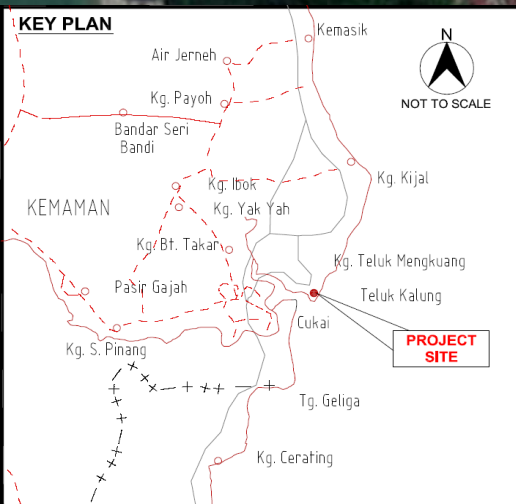
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PROJECT LOCATION



Project Area
100 acres
(40.47 ha)

Project Boundary ID	Latitude	Longitude
1	4°15'43.36"N	103°26'53.20"E
2	4°15'39.64"N	103°26'56.99"E
3	4°15'39.18"N	103°27'0.08"E
4	4°15'33.31"N	103°27'6.53"E
5	4°15'13.82"N	103°27'6.70"E
6	4°15'24.11"N	103°26'49.43"E
7	4°15'27.63"N	103°26'52.00"E
8	4°15'28.99"N	103°26'48.47"E
9	4°15'27.18"N	103°26'46.31"E
10	4°15'33.92"N	103°26'40.03"E



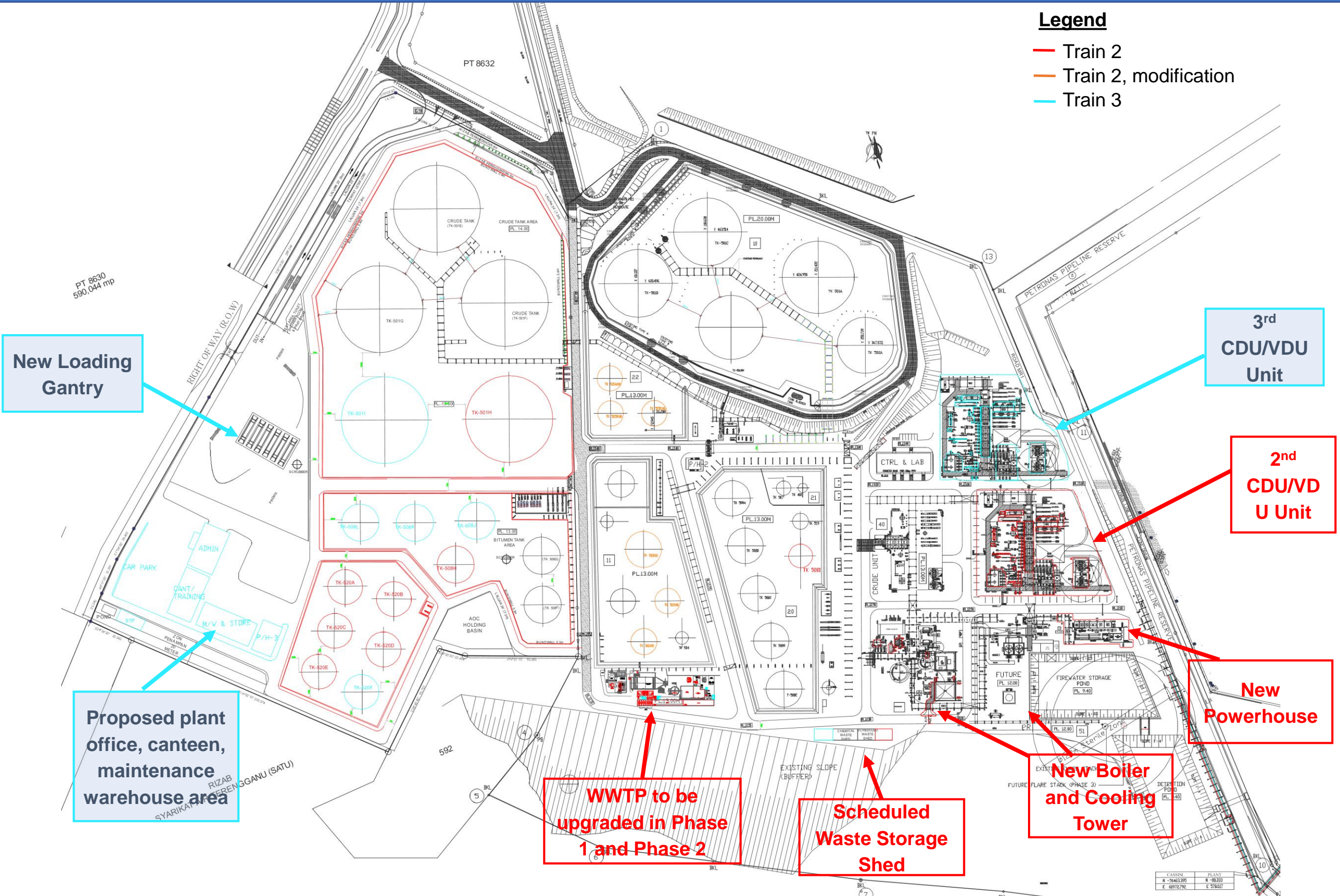
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PROJECT LAYOUT

Legend

- Train 2
- Train 2, modification
- Train 3

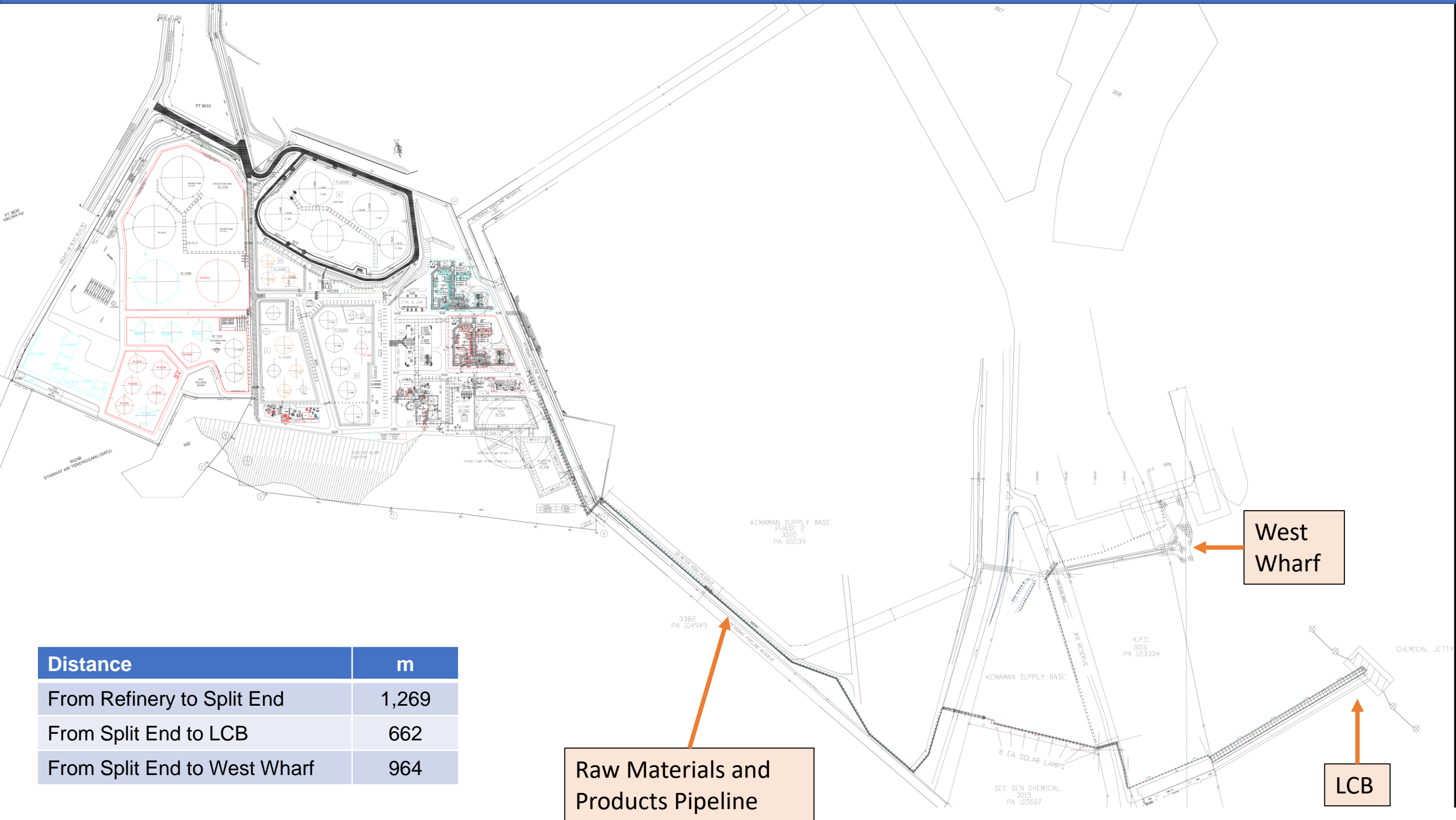


CASSINI	PLANT
N - 74643.295	N - 80.333
E - 68972.792	E - 578.617

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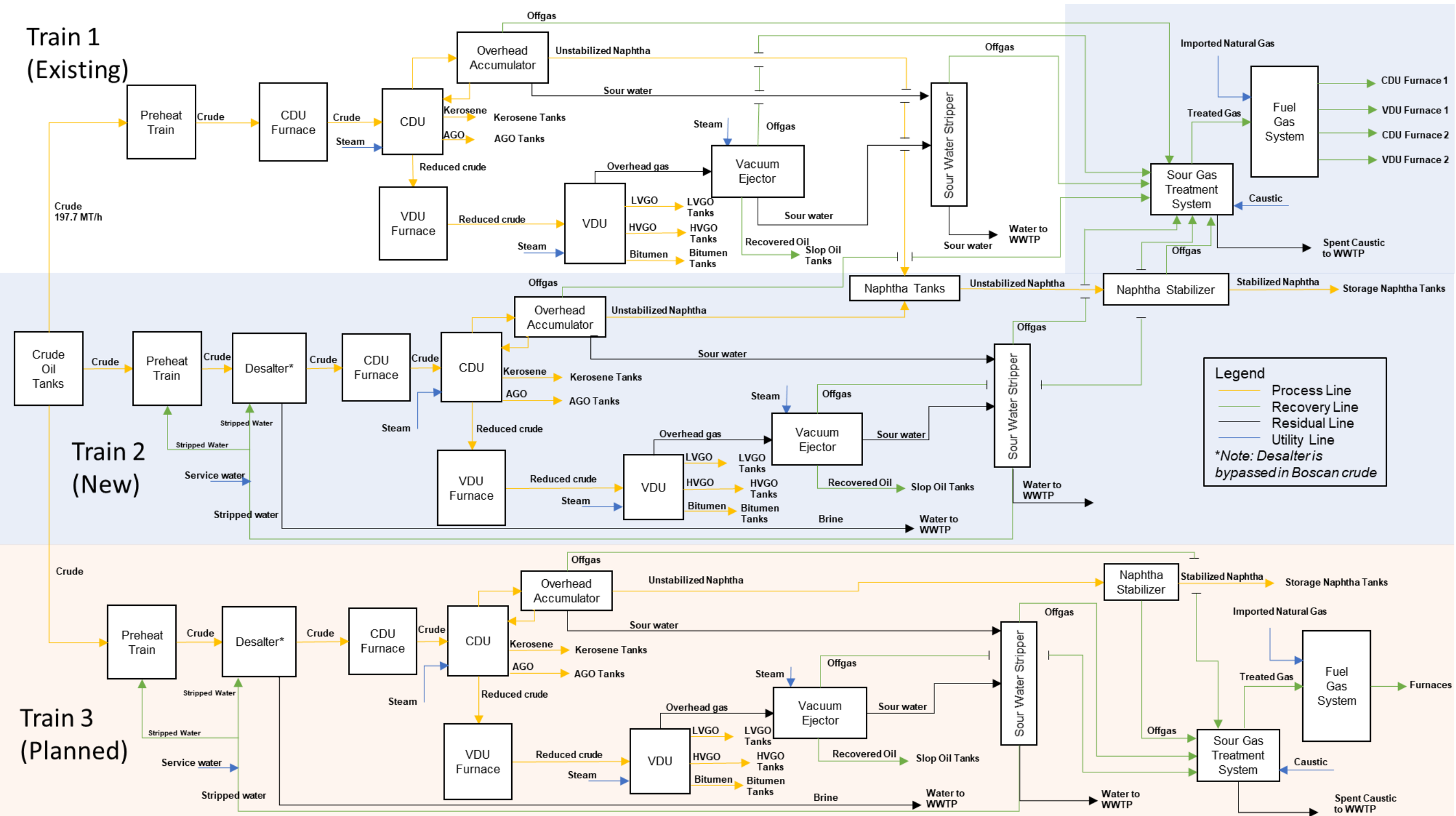
PROJECT LAYOUT



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OVERALL FLOW DIAGRAM



Proposed Expansion of Refinery

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EXISTING ENVIRONMENT

Hydrology

Within Sungai Chukai catchment. However, no discharge flows into the river. It flows into a drainage system in Kemaman Supply Base before discharge into the sea.



Road Network



Connections from Jalan Kemaman – Dungun, Federal Route 3, East Coast Expressway 2. Traffic in FR3 is heavy but serviceable.

Land Use



Most receptors are towards West and South as TKIE covers East and North. Closest receptor is 0.36 km west (Taman Sepakat).

Socio Economic



Project located in Kemaman under the planning zone of Majlis Perbandaran Kemaman.

Geology



Underlain by unconsolidated sediment from the quaternary age. Consists of clay, silt, and sandy material. Characterized as peat, humic clay and silt.

Topography



Low lying, flat area. Elevation of 4.61 m - 12.59 m. Platform level for Existing Area. No Earthworks will be required

Climate & Meteorology



Mean Rainfall

Highest in December (736 mm)
Lowest in February (79.9 mm)

Mean Rain Days

Highest in December (24)
Lowest in June (10)

Mean Temperature

Highest in May (28.4°C)
Lowest in January (25.9°C)

Mean Humidity

Highest in December (86.7%)
Lowest in April (78.2%)

Wind and Direction

Annual wind speed average of 1.6 m/s
South from May – September
North from October – April

Flora & Fauna Assessment



Kuala Kemaman Forest Reserve (a mangrove forest) of 775 hectares is 1.2 km away from the Project Site (nearest point) The bulk of the forest is about 4.4 km away.

Other Notable Areas:

TCS River Terrapin Conservation Centre located 17.24 km from Project Site.

Cherating Turtle Sanctuary located 13.72 km from Project Site.

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EXISTING ENVIRONMENT



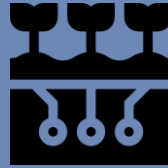
Marine Water Quality

Samples were compared with the MMWQS 2019, Class 3, no exceedance. Only boron was detected in high amounts (2.470 mg/l).

Soil Quality



Measured in 4 locations. Sandy silt with small to large gravel in upper layers. Medium to coarse sand primarily in lower layers. Samples were tested vs 2015 CLMCG Site Screening Levels for Industrial Soil, no exceedance.



Groundwater Quality

Measured in 4 locations. Exceedance was detected for Aluminum (3,430 µg/L) for GW2 and Arsenic (2.5 µg/L, 6.1 µg/L, and 3.4 µg/L) for GW1, GW2 and GW2s. Samples were compared with the 2015 CLMCG Site Screening Levels for Groundwater



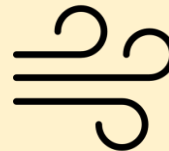
Water Quality

Measured in 7 locations. Exceedance recorded for COD (FDC & WQ5, downstream of KSB drain) and Iron (WQ5) when compared with NWQS Class III.



Noise Quality

Measured at 5 locations, no exceedance when compared to Second Sch. Limiting Sound Level by Receiving Land Use for Existing Built-Up Areas, Guidelines for Environmental Noise Limits & Control, 3rd Edition 2019



Air Quality

Measured at 6 locations, no exceedance when compared to MAAQS 2020 limits. No foul odours were perceived and only low concentrations were detected at monitoring locations.

Public Health



Statistics from 2018 at three different clinics/hospitals within 10 km of Project.

Total Number

Adult Patients
72,488

Child Patients
23,070

Disease Cases Related to Air Pollution
6283 Adults, 3891 Children

Disease Cases Related to Water Pollution
76 Adults, 270 Children

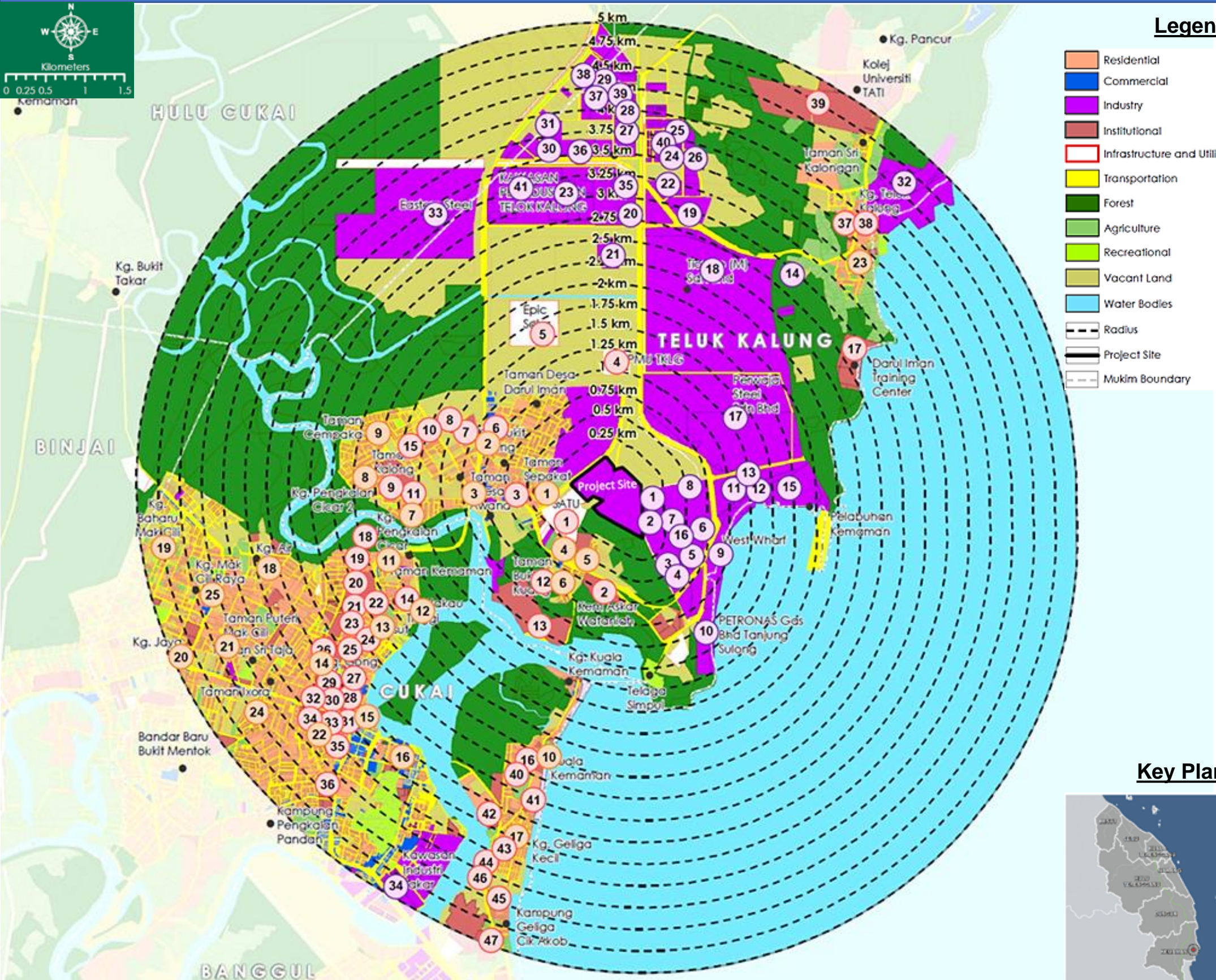
Disease Cases Related to Animal Vectors and Reservoirs
155 Adults, 76 Children

Skin Disease Cases
936 Adults, 701 Children

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EXISTING LANDUSE



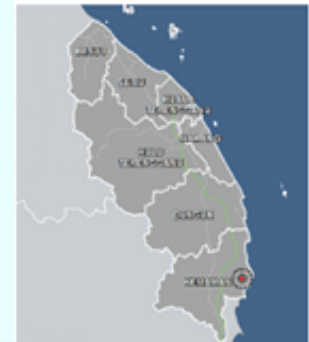
Legend

- Residential
- Commercial
- Industry
- Institutional
- Infrastructure and Utility
- Transportation
- Forest
- Agriculture
- Recreational
- Vacant Land
- Water Bodies
- Radius
- Project Site
- Mukim Boundary

Kemaman Bitumen Company

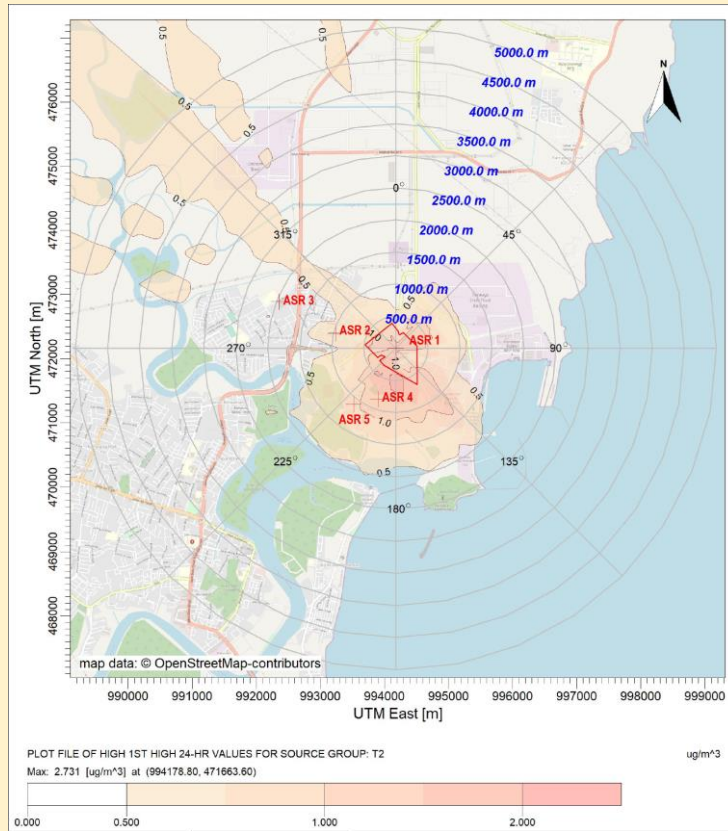
Industrial	
1	Valesto Energy Sdn. Bhd
2	Halliburton Energy Services
3	Schlumberger Warehouse 29
4	HB Laboratories
5	Malaysian Energy Chemical Services
6	Destini Oil Services Sdn. Bhd.
7	EPIC Oilfield Services Sdn. Bhd.
8	Cangali Hess Operating Company Sdn. Bhd
9	West wharf, Kemaman
10	Liquid Chemical Berth (LCB) Kemaman
11	MEMS
12	Pengkalan Bekalan Kemaman Sdn Bhd
13	Sobena Offshore Inc. Sdn. Bhd.
14	Rigging Equipment Engineering
15	Kemaman Supply Base Phase 1
16	Kemaman Supply Base Phase 2
17	Perwaja Steel Sdn. Bhd.
18	Venator Asia Sdn. Bhd.
19	See Sen Chemical Sdn. Bhd.
20	Tosoh Advanced Materials Sdn. Bhd.
21	Lion Plate Mills
22	Malay Sino Chemical Industries Sdn. Bhd.
Residential	
1	Taman Sepakat
2	Kampung Bukit Kuang
3	Taman Desa Awana
4	Kampung Sungai Terjun
5	Kampung Teluk Mengkuang
6	Taman Bukit Kuang
7	Kampung Pengkalan Cicar
8	Kampung Pengkalan Cicar 2
9	Taman Cempaka
10	Kampung Kuala Kemaman
11	Taman Kemaman
12	Kampung Bakau Tinggi
13	Kampung Besut
14	Kampung Gong Melimau
15	Kampung Banggol Kanan
16	Kampung Dusun Nyior
17	Kampung Geliga Kecil
18	Kampung Air
19	Kampung Baharu Mak Cili
20	Kampung Jaya
21	Taman Puteri Mak Cili
22	Taman Seri Pauh
Institutional & Others	
1	Syarikat Air Terengganu, SATU
2	Kem Askar Wataniah
3	Klinik Satu Malaysia
4	PMU TNB
5	EPIC Solar
6	Tadika Taman Desa Darul Iman
7	Masjid Bukit Kuang
8	SK Bukit Kuang
9	SMK Bukit Kuang
10	Klinik Kesihatan Desa Bukit Kuang
11	Surau Pengkalan Cicar
12	Surau Rahmat
13	Kemaman Maritime Zone
14	Sek Ren Islam Darul Taqwa Kemaman
15	Tadika Bukit Kuang
16	SRJK (C) Kuala Kemaman
17	Darul Iman Training Centre
18	Bakau Tinggi Recreation Park

Key Plan



EVALUATION OF IMPACTS

Air & Odour Quality Assessment



Construction Phase

Generation of dust, CO and dark smoke. Fugitive dust which is generally heavier is usually found concentrated at or near to ground level. Minimal impacts can be mitigated by BMPs and is short term in nature.

Operational Phase

The main emission sources during operation stage are from heaters, scrubbers, boilers, fume hoods, fugitive gas from tanks, and flare stacks. Off-gas from the operational process will be flared off. Air & Odour Modelling was assessed for the air pollutants (namely Particulates, H₂S, NH₃, NO₂ etc.) by using AERMOD. 2 cumulative scenarios are modelled for Proposed Train 2 and Future ultimate Phase (including Train 3). Modelling results showed that air and odour emission quality from the plant is complied with both the Environmental Quality (Clean Air) Regulations 2014 and the Malaysian Ambient Air Quality Standard 2013 (MAAQS 2013).

The pollutants are found mainly at the site and the highest concentration fall at the hill at the south of the site. Hence, the predicted impact towards the surrounding receptors are minimal and insignificant.

For odour gases such as H₂S, NH₃, TOC (as Halogenated Hydrocarbon and Non-Halogenated Hydrocarbon), Benzene, Toluene, Ethylbenzene, Xylene, Methyl Ethyl Ketone (MEK), predicted 24-hr MAICs are minimal. They are below the limits of Ontario's Ambient Air Quality Criteria Limits since there are none yet available in Malaysia.

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EVALUATION OF IMPACTS

Public Health



Construction Phase

Health impacts due to exposure to dust and noise to be insignificant and short term

Operational Phase

Health Impacts would be caused by air pollutants, so Malaysian Ambient Air Quality Standards 2013 (2020) and the Ontario's Ambient Air Quality Criteria 2012 will be compared to. The air pollutants generated will be fine particulate (PM_{2.5}), respirable particulate (PM₁₀), nitrogen dioxide (NO₂), carbon monoxide (CO), hydrogen sulphide (H₂S), ammonia (NH₃), toluene (C₇H₈), xylene (C₈H₁₀), benzene (C₆H₆), ethylbenzene (C₆H₅C₂H₅) and methyl ethyl ketone (MEK)

Normal Operations

The hazard quotient (HQ) due to chronic inhalation exposure to the air pollutants is calculated. Predicted maximum ambient concentrations of air pollutants expected to be below their respective guideline values for both Phase 1 and Phase 2.

Of all the air pollutants that have individual community incremental concentrations, only benzene is carcinogenic. The Lifetime Cancer Risk (LCR) is assessed will be well below the acceptable cancer risk range and is deemed as clearly acceptable.

Abnormal Operations

Predicted maximum ambient concentrations of air pollutants expected to be below their respective guideline values for both Phase 1 and Phase 2.

Water Quality



In overall, the mixing modelling results show that the predicted concentration of BOD, COD, SS, Oil & Grease, Sulphide and AN was way below the limit of the Standard B limit of the Environmental Quality (Industrial Effluent) Regulations 2009 and Class III limit of National Water Quality Standard (NWQS) except for Ammoniacal Nitrogen (AN)

Scheduled Waste



The current scheduled waste shed will be expanded twice in order to accommodate for the additional waste produced from Train 2 and 3. In addition, frequency of disposal for waste has been specifically scheduled depending on the type of waste.

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EVALUATION OF IMPACTS

Soil Erosion



Construction

Existing Condition: Initial soil loss that occurred every year and act as a benchmark for comparison.

Worst case scenario: Soil loss estimation during development phase where the development is carried out without implementation any of mitigation measures.

With control measures: Soil loss estimation during development phase where mitigation measures are implemented such as an installation of erosion sediment control (ESC) tools before commencement of the earthwork activities.

Operation

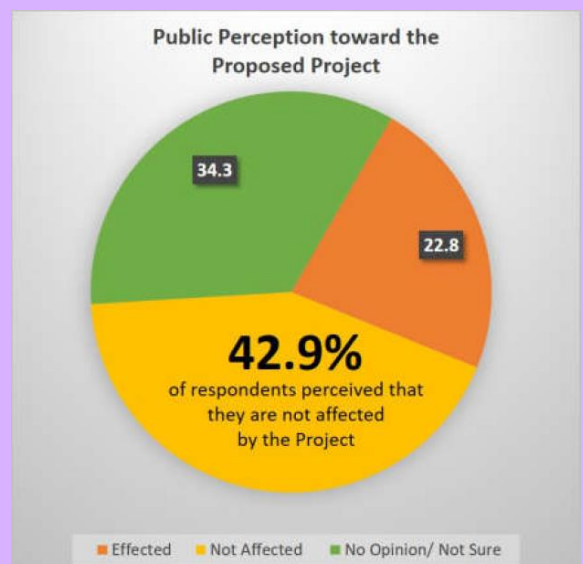
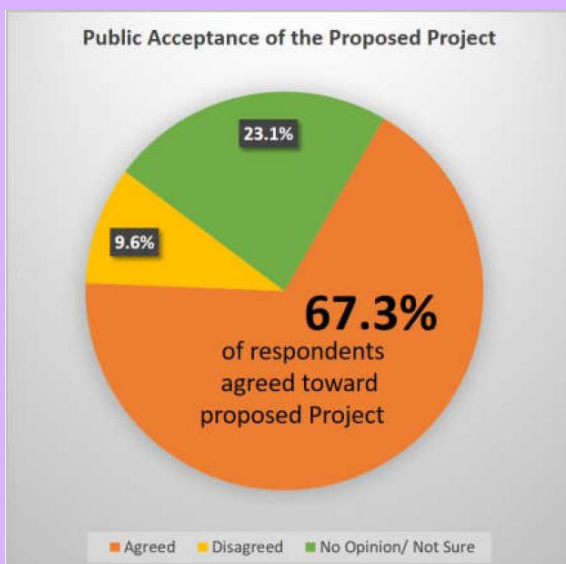
The proposed development will result in land use changes to certain areas to accommodate buildings, roadway and other infrastructure. The general land use conversion for the project development will not change the hydrologic and drainage pattern of the area.

Socio Economic



The socio-economy study found that there were no significant social impacts that could not be managed by the mitigation measures. Through this study, the benefit and negative impacts of the proposed Project have been identified and assessed.

Majority of the respondents have agreed with the proposed project as they conclude that they are not affected by the Project as the driving factor Mitigation measures and actions have been proposed for each identified potential social impact in order to avoid or minimize the impacts, as well as to enhance the possible benefit of the Project.



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EVALUATION OF IMPACTS

Noise Quality



Qualitative noise assessment has been conducted for the Project.

Construction Phase

Noise impacts during construction is mainly directed to the workers and will be short term in nature.

Operation Phase

Using modelling prediction results, it is anticipated that the increment in noise level is “low” and will adhere to OSH Noise Regulations 2019

Risk Assessment



Potential risk hazards identified during transport of raw materials and finished products to and from the Plant, handling and storage of materials, and production processes.

Transportation

Heavy crude oil and products are mostly transported using pipelines and sea vessels. Road tankers are used for transport of bitumen for local consumption and it is concluded that spillage of bitumen from road tankers will not give rise to significant risk as bitumen is not considered flammable.

Storage

Stored materials consists of flammable/combustible substances: Crude Oil, Naphtha, AGO, VGO, Bitumen and Kerosene. The storage tanks are the vertical cone roof type constructed to International codes and standards and tanks will not be its maximum all the time as per safety precautions

Natural Gas

A concern due to high flammability nature of the material. However, natural gas is supplied via pipelines with gas station located within the refinery with no physical storage of NG on site.

The significant potential hazards identified during the production processes are attributable to loss of containment (i.e., hydrocarbons, sour water, etc.) from the process units and faulty equipment parts leading to abnormal operation.

Potential hazards have been assessed and determined to be acceptable.

Abandonment



- Standard Procedures to be followed for Operational Phase
- Valves checked for adequacy
- Sequenced shutdowns
- Raw Materials and Scheduled Waste removed
- Equipment disassembled

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MITIGATION MEASURES

Air Quality



Construction Phase

- Provide perimeter fencing
- Construction materials covered with tarpaulin/plastic covers
- Regular water spraying or use of water bowser
- Vehicles and machineries to be regularly maintained
- Prohibit open burning

Operational Phase

- Stack Emission monitoring as per the EQ (Clear Air) Regulations 2014 and relevant DOE *Best Available Techniques* (BAT) guidelines.
- Exceedance of air pollutants shall be reported to KBC management and further action to be taken by the Environmental Officer to ensure permissible emission limits.

Water Quality



Construction Phase

- Mitigation measures as recommended in the LDP2M2 document
- Provision of portable toilets for construction workers
- Monthly water quality monitoring for Total Suspended Solids and Oil & Grease

Operational Phase

- Regular maintenance of detention ponds and wastewater treatment plant
- Periodic monitoring programs for effluent and waster discharge points

Scheduled Waste



Construction Phase

- Waste to be segregated and stored in different containers or skips to enhance reuse or recycling of materials
- Tanks demolished to be cleaned first and disposed off properly.
- All waste to be disposed of properly as per Environmental Quality (Scheduled Wastes) Regulations 2005

Operational Phase

- Waste to be stored and labelled properly, in the right containers.
- Scheduled wastes should not be stored for more than 180 days or exceed 20 tons
- Waste to be managed and disposed properly at prescribed premises.
- The notification of scheduled waste generation at site, E-Consignment Notes and Inventory record shall be done via eSWIS

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MITIGATION MEASURES

Noise Quality



Construction Phase

- Provide proper lubrication and provide silencers wherever possible
- Vehicles and machineries to be regularly maintained
- Proper PPE for workers
- Construction to be conducted during time duration approved
- Compliance with OSH (Noise Exposure) Regulations 2019

Operational Phase

- Periodic maintenance on equipment
- PPE for workers working in noisy environments
- Periodic noise monitoring

Occupational Health & Safety



Construction Phase

- Safety induction training for new workers & periodic briefings
- Safety maintenance for vehicles and machinery
- PPE to be provided and mandated to workers
- Safety and Health Officer to be appointed to oversee safety conditions
- Safety precautions to be followed at all times

Operational Phase

- Monitoring of ambient air quality
- Systematic review of procedures should be regularly conducted
- Worker health to be kept and recorded

Risk Assessment



Operational Phase

- Continuous elimination of possible ignition sources
- Regular checks and maintenance to ensure high mechanical integrity
- Regular inspection & maintenance to fire fighting equipment
- Precautions for use and safe handling of chemicals
- Storage and containers to be properly labelled
- PPE to be mandated

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ENVIRONMENTAL MANAGEMENT PLAN

CONSTRUCTION STAGE



Water Quality

Measured at 6 water quality monitoring locations

Proposed Limits for
Total Suspended Solids: 100 mg/l
Oil and Grease: 10 mg/l



Ambient Air Quality

Measured at 4 air quality monitoring locations

Compliance with Malaysia Ambient Air Quality Standards 2020

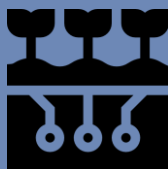


Noise Quality

Measured at 4 noise quality monitoring locations

Compliance with Guidelines for Environmental Noise Limits and Control (Third Edition 2019), Second Sch. Limiting Sound Level (LAeq) by Receiving Land Use For Existing Built Up Areas

OPERATIONAL STAGE



Groundwater Quality

Measured at 4 groundwater quality monitoring locations

Quarterly Monitoring, compliance with DOE Guidelines - National Groundwater Quality Standard for Industry, 2019



Ambient Air Quality

Measured at 5 air quality monitoring locations

Quarterly Monitoring, compliance with Malaysia Ambient Air Quality Standards 2020



Sewage Discharge Quality

Measured at Sewage Treatment Plant

Monthly Monitoring to comply with the EQA 1974, Environmental Quality (Sewage) Regulations 2009, Standard B limit



Noise Quality

Measured at 5 noise air quality monitoring locations

Quarterly Monitoring, compliance with Guidelines for Environmental Noise Limits and Control (Third Edition 2019), Second Sch. Limiting Sound Level (LAeq) by Receiving Land Use For Existing Built-Up Areas



Water Quality

Measured at 8 water quality monitoring locations including Final Discharge Point

Weekly Monitoring for FDC, and Quarterly Monitoring for the rest, compliance with Full Standard B Parameters of Environmental Quality (Industrial Effluent) Regulations 2009

Stack Emissions

13 Stacks will continue to be monitored for the Existing Refinery. Compliance with the Environmental Quality (Clean Air) Regulations 2014

4 additional Stacks to be monitored for Train 2. Compliance with the Environmental Quality (Clean Air) Regulations 2014

3 additional Stacks to be monitored for Train 3. Compliance with the Environmental Quality (Clean Air) Regulations 2014

