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United States of America
Environmental Protection Agency

A FAX FROM: Region 6

TO: Ms. Hope Monzeglio NMED	FAX NO: (505)428-2567
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SUBJECT:
Proposed diagram for 2 benzene strippers at Giant Refining.

FROM: Ron Shannon	PHONE NO: (214) 665-2282
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OFFICE: Hazardous Waste Enforcement Branch	FAX NO. FOR: (214) 665-7264
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COMMENTS:

DATE and TIME: 06/29/2006 11:02 AM	NO. OF PAGES 5
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December 20, 2005

**VIA FEDERAL EXPRESS
VIA FACSIMILE (214) 665-3177**

Marcia Moncrieffe, Esq.
Assistant Regional Counsel
United States Environmental Protection Agency
Region 6
Mail Code 6RC-EW
1445 Ross Avenue, Suite 1200
Dallas, TX 75202-2733

**Re: San Juan Refining Company d/b/a Giant Refining Company;
Docket No. RCRA-06-2005-0918**

Dear Ms. Moncrieffe:

By letter to you dated November 11, 2005, I described a proposed course of action for resolving the referenced Complaint. The purpose of this letter is to follow up on that proposed course of action by providing you with a conceptual proposal for addressing benzene in effluent from the API Separator.

Please find enclosed for EPA's review a description and a flow diagram of two benzene strippers. These two benzene strippers would be configured in series and would receive all discharges from the API Separator. The second stripper would discharge directly into the first of three, multiple-lined aeration ponds. The discharge would be below the RCRA toxicity characteristic level for benzene.

Giant has reviewed the potential need to protect the two benzene strippers from the possibility of discharge surges from the API Separator. As a result of the declining production of crude oil in the Four Corners area in recent years, we have not been able to cost-effectively obtain sufficient amounts of crude oil to operate the Bloomfield refinery at full capacity. We are planning to bring supplemental crude oil supplies to the refinery

Marcia Moncrieffe, Esq.
December 20, 2005
Page 2

from other areas through an idle crude oil pipeline system, but that plan, if successful, would not be operational before the end of 2006. Giant therefore is currently operating the Bloomfield Refinery at approximately 60% capacity. The current API Separator is designed for the Refinery to operate at 100% capacity as well as for the handling of additional volumes of liquids due to unforeseen events. Consequently, Giant believes that the API Separator has sufficient excess capacity that in itself can protect the benzene strippers from the possibility of surges of discharges from the Separator.

As we have indicated, Giant is a relatively small company without an engineering staff able to fully develop a technical proposal of this type. Giant will obtain the assistance of an engineering consultant to refine the enclosed conceptual proposal. However, before Giant proceeds further in developing a detailed engineering plan for the proposal, Giant would like to discuss the proposal with EPA and obtain assurance that the approach is acceptable.

Giant looks forward to discussing the enclosed conceptual proposal with EPA at your earliest convenience. I believe Giant and EPA share the desire to move forward as rapidly as possible to explore approaches to resolving the Complaint.

Sincerely,



David R. Kirby
Corporate Counsel

Enclosures

Giant Industries, Bloomfield Refinery

Description of Refinery Wastewater Flow Scheme

Current

The process sewers and drains within the refinery collect hydrocarbon and water and route that material to the API Separator where solids are settled out and oil is recovered from this stream. The water then gravity flows through a series of three, multiple-lined aeration ponds, where (1) any residual oil is separated and collected for return to the refining process and (2) the water receives high rate mechanical aeration in order to promote strong biological activity. The water is then pumped to the on-site evaporation ponds and/or to the on-site injection well for disposal.

Proposed Change

Giant proposes the following changes to the current water handling system:

- The two benzene strippers will be configured in series and will be located near the discharge point at the water side of the API Separator.
- Each of the two benzene strippers will be the shallow-tray type for ease of scaling/fouling maintenance.
- The first benzene stripper will receive all discharges from the API Separator.
- Benzene levels will be tested at the outlet of the first benzene stripper to confirm that these levels are below the RCRA toxicity characteristic level for benzene.
- The second benzene stripper will be identical to the first stripper and will serve as a "polisher" to further reduce benzene levels.
- Water from the outlet of the second benzene stripper will flow directly into the first, multiple-lined aeration pond.
- If either benzene stripper must be taken out of service temporarily for repairs, water flow from the API Separator to the first, multiple-lined aeration pond will continue to flow through the other, operating stripper.

