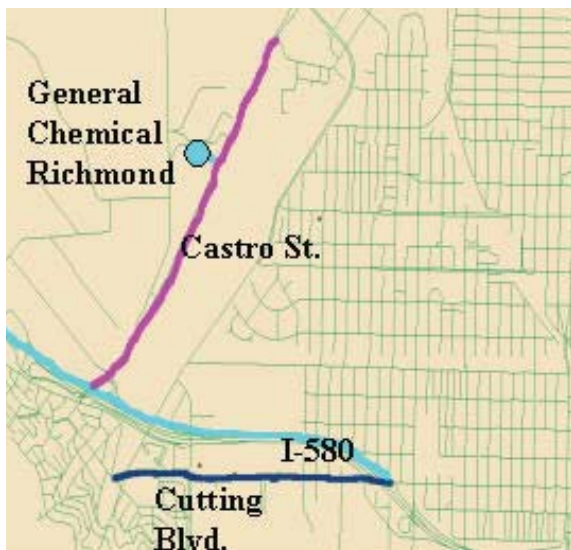




**General Chemical West Richmond Works** is located immediately adjacent to the Chevron Richmond Refinery, one-half mile north of Interstate 580 and Cutting Boulevard, on Castro Street in Richmond, CA. General Chemical West's Richmond Works began operation in 1944 to serve the neighboring Standard Oil of California (now Chevron) Refinery. This relationship still exists: Chevron uses fresh sulfuric acid as alkylation catalyst and ships the spent sulfuric acid back to General Chemical West via a pipeline for regeneration.



### **Hazardous Substances Stored or Produced Onsite and their Immediate Health Effects**

- **Sulfur Dioxide:** a colorless, corrosive gas with an irritating pungent odor. Irritates nose, throat and lungs.
- **Oleum/Sulfur Trioxide:** Oleum is a cloudy, gray, fuming, oily, corrosive liquid with a sharp, penetrating odor. When Oleum comes into contact with air following a spill, it releases Sulfur Trioxide. Sulfur Trioxide is a white gas having the appearance of fog. It also has a sharp, penetrating odor that is detectable at low concentrations. Irritates nose, throat and lungs.

## **3-Year Accident History**

(Last updated February 2007)

6/23/06 The main turbine tripped and the automatic shutdown interlock on the combustion air blower did not work correctly, so the blower pressured up the upstream side of the system which is normally under a vacuum. The release impacted four offsite Chevron contract employees. The entire plant shut down. The incident was determined to have the potential to affect the offsite community health.

7/26/05 A flow meter on a feed to the oleum stripper in the acid plant developed a leak. The plant estimated that between two and eighteen pounds of sulfur trioxide were released. The acid plant was shut down. The oleum flow was stopped within three minutes and the release of sulfur trioxide within fifteen to twenty minutes. The incident was determined to have the potential to affect the offsite community health.

There were no other accidents within the last three years.

### **Safety Features and Recent Improvements (updated June 2006):**

- The plant continues to implement the installation of the Digital Control System and the associated controls. The plant also replaced the faulty controls from the 6/23/06 incident.

#### **For more information:**

Copies of the latest audit findings, Risk Management Plan, and Safety Plan can be found in the following locations:

CCHS Hazardous Materials Office  
4333 Pacheco Blvd, Martinez, CA 94553

Richmond Public Library  
325 Civic Center Plaza, Richmond, CA 94804

Visit our website at  
[www.cchealth.org/groups/hazmat](http://www.cchealth.org/groups/hazmat) or  
call 925-646-2286



### **Summary of Most Recent Audit (October 2006):**

CCHS completes tri-annual audits of General Chemical West to ensure that they are in compliance with safety programs required by the California Accidental Release Prevention Programs and the City of Richmond's Industrial Safety Ordinance, and that the descriptions of their safety programs described in their Risk Management Plan and Safety Plan are accurate. These prevention programs were generally found to be in compliance and suggestions were made to enhance the existing programs. The following program elements were determined to need improvement:

- The quality of the process safety information that is available to employees, and that is referenced in operating procedures.
- The follow-up and documentation for process hazards review, management of change, and contractor safety.
- The implementation, follow-up and documentation of their human factors programs.
- The inherently safer systems process.