Contents

Pref	ace	XV
Abo	ut the	Authors xvii
On t	he Co	ver xviii
Nom	encla	ture xix
1	Intr	coduction 1
	1-1	Safety Programs 2
	1-2	Engineering Ethics 4
	1-3	
	1-4	Acceptable Risk 12
	1-5	Public Perceptions 14
	1-6	The Nature of the Accident Process 15
	1-7	Inherent Safety 20
	1-8	Seven Significant Disasters 23
		Flixborough, England 23
		Bhopal, India 25
		Seveso, Italy 26
		Pasadena, Texas 27
		Texas City, Texas 29
		Jacksonville, Florida 30
		Port Wentworth, Georgia 30
		Suggested Reading 31
		Problems 32

2	Tox	cicology	37
	2-1	How Tox	icant
		Gastro	ointe

ow Toxicants Enter Biological Organisms 38

Gastrointestinal Tract 39

Skin 39

Respiratory System 40

- 2-2 How Toxicants Are Eliminated from Biological Organisms 41
- 2-3 Effects of Toxicants on Biological Organisms 42
- 2-4 Toxicological Studies 43
- 2-5 Dose versus Response 44
- 2-6 Models for Dose and Response Curves 50
- 2-7 Relative Toxicity 56
- 2-8 Threshold Limit Values 56
- 2-9 National Fire Protection Association (NFPA) Diamond 58

On-Line Resources 59

Suggested Reading 60

Problems 60

3 Industrial Hygiene 65

3-1 Government Regulations 66

Laws and Regulations 66

Creating a Law 66

Creating a Regulation 66

OSHA: Process Safety Management 71

EPA: Risk Management Plan 73

DHS: Chemical Facility Anti-Terrorism Standards (CFATS) 76

3-2 Industrial Hygiene: Anticipation and Identification 78

Material Safety Data Sheets 81 Industrial Hygiene: Evaluation 84

Evaluating Exposures to Volatile Toxicants by Monitoring 84

Evaluating Worker Exposures to Dusts 88

Evaluating Worker Exposures to Noise 89

Estimating Worker Exposures to Toxic Vapors 91

3-4 Industrial Hygiene: Control 99

Respirators 101

Ventilation 103

On-Line Resources 109

Suggested Reading 109

Problems 110

4 Source Models 119

3-3

- 4-1 Introduction to Source Models 119
- 4-2 Flow of Liquid through a Hole 122
- 4-3 Flow of Liquid through a Hole in a Tank 126
- 4-4 Flow of Liquids through Pipes 131

2-K Method 134

4-5 4-6 4-7 4-8 4-9 4-10	Flow of Gases or Vapors through Holes 140 Flow of Gases or Vapors through Pipes 146 Adiabatic Flows 146 Isothermal Flows 153 Flashing Liquids 163 Liquid Pool Evaporation or Boiling 169 Realistic and Worst-Case Releases 170 Conservative Analysis 172 Suggested Reading 173 Problems 174
Tox	ic Release and Dispersion Models 185
5-1 5-2	Parameters Affecting Dispersion 186 Neutrally Buoyant Dispersion Models 190 Case 1: Steady-State Continuous Point Release with No Wind 194 Case 2: Puff with No Wind 195 Case 3: Non-Steady-State Continuous Point Release with Wind 196 Case 4: Steady-State Continuous Point Source Release with Wind 197 Case 5: Puff with No Wind and Eddy Diffusivity Is a Function of Direction 197 Case 6: Steady-State Continuous Point Source Release with Wind and Eddy Diffusivity Is a Function of Direction 198 Case 7: Puff with Wind 198 Case 8: Puff with No Wind and with Source on Ground 199 Case 9: Steady-State Plume with Source on Ground 199 Case 10: Continuous Steady-State Source with Source at Height H, above the Ground 200 Pasquill-Gifford Model 200 Case 11: Puff with Instantaneous Point Source at Ground Level, Coordinates Fixed at Release Point, Constant Wind Only in x Direction with Constant Velocity u 204 Case 12: Plume with Continuous Steady-State Source at Ground Level and Wind Moving in x Direction at Constant Velocity u 205 Case 13: Plume with Continuous Steady-State Source at Height H, above Ground Level and Wind Moving in x Direction at Constant Velocity u 206 Case 14: Puff with Instantaneous Point Source at Height H, above Ground Level and a Coordinate System on the Ground That Moves with the Puff 207 Case 15: Puff with Instantaneous Point Source at Height H, above Ground Level and a Coordinate System Fixed on the Ground at the Release

Point 208

Worst-Case Conditions 208

Limitations to Pasquill-Gifford Dispersion Modeling 208

6

5-3 5-4	Dense Gas Dispersion 209 Dense Gas Transition to Neutrally Buoyant Gas 219 Continuous Release Transition 219 Continuous Release Downwind Concentration 221 Instantaneous Release Transition 221
	Instantaneous Release Downwind Composition 222
5-5	
5-6	Effect of Release Momentum and Buoyancy 233
5-7	
	Suggested Reading 235
	Problems 236
Fire	es and Explosions 245
	-
6-1	The Fire Triangle 245
6-2	Distinction between Fires and Explosions 247
6-3	
0-4	Flammability Characteristics of Liquids and Vapors 249
	Liquids 250
	Gases and Vapors 253
	Vapor Mixtures 253
	Flammability Limit Dependence on Temperature 255
	Flammability Limit Dependence on Pressure 256
6-5	Estimating Flammability Limits 256
6-6	Limiting Oxygen Concentration and Inerting 260
6-7	Flammability Diagram 262
6-8	Ignition Energy 270
6-9	Autoignition 270 Auto-Oxidation 271
6-10	
	Adiabatic Compression 272
	Ignition Sources 273
	Sprays and Mists 274
0-13	Explosions 275 Determine and Deflectation 276
	Detonation and Deflagration 276
	Confined Explosions 277 Blast Damage Populting from Overpressure 287
	Blast Damage Resulting from Overpressure 287 TNT Equivalency 291
	*
	TNO Multi-Energy Method 293
	Energy of Machanical Explosions 296
	Energy of Mechanical Explosions 298 Missile Damage 301
	Blast Damage to People 301
	Vapor Cloud Explosions 303
	Boiling-Liquid Expanding-Vapor Explosions 304
	Suggested Reading 304
	Problems 305

7 Concepts to Prevent Fires and Explosions 317

7-1 Inerting 318

Vacuum Purging 318

Pressure Purging 321

Combined Pressure-Vacuum Purging 323

Vacuum and Pressure Purging with Impure Nitrogen 323

Advantages and Disadvantages of the Various Pressure and Vacuum

Inerting Procedures 325

Sweep-Through Purging 325

Siphon Purging 327

Using the Flammability Diagram To Avoid Flammable

Atmospheres 327

7-2 Static Electricity 333

Fundamentals of Static Charge 333

Charge Accumulation 334

Electrostatic Discharges 335

Energy from Electrostatic Discharges 337

Energy of Electrostatic Ignition Sources 338

Streaming Current 339

Electrostatic Voltage Drops 342

Energy of Charged Capacitors 342

Capacitance of a Body 347

Balance of Charges 350

7-3 Controlling Static Electricity 356

General Design Methods To Prevent Electrostatic

Ignitions 357

Relaxation 358

Bonding and Grounding 358

Dip Pipes 359

Increasing Conductivity with Additives 362

Handling Solids without Flammable Vapors 363

Handling Solids with Flammable Vapors 363

7-4 Explosion-Proof Equipment and Instruments 363

Explosion-Proof Housings 365

Area and Material Classification 365

Design of an XP Area 366

7-5 Ventilation 367

Open-Air Plants 367

Plants Inside Buildings 368

7-6 Sprinkler Systems 370

7-7 Miscellaneous Concepts for Preventing Fires and Explosions 374
 Suggested Reading 374

Problems 375

8 Chemical Reactivity 381

- 8-1 Background Understanding 382
- 8-2 Commitment, Awareness, and Identification of Reactive Chemical Hazards 384
- 8-3 Characterization of Reactive Chemical Hazards Using Calorimeters 390

Introduction to Reactive Hazards Calorimetry 391

Theoretical Analysis of Calorimeter Data 397

Estimation of Parameters from Calorimeter Data 408

Adjusting the Data for the Heat Capacity of the Sample

Vessel 412

Heat of Reaction Data from Calorimeter Data 413

Using Pressure Data from the Calorimeter 414

Application of Calorimeter Data 415

8-4 Controlling Reactive Hazards 416
Suggested Reading 418
Problems 418

9 Introduction to Reliefs 429

- 9-1 Relief Concepts 430
- 9-2 Definitions 432
- 9-3 Location of Reliefs 433
- 9-4 Relief Types and Characteristics 436

Spring-Operated and Rupture Discs 436

Buckling-Pin Reliefs 440

Pilot-Operated Reliefs 440

Chatter 441

Advantages and Disadvantages of Various Reliefs 442

- 9-5 Relief Scenarios 443
- 9-6 Data for Sizing Reliefs 444
- 9-7 Relief Systems 444

Relief Installation Practices 445

Relief Design Considerations 447

Horizontal Knockout Drum 448

Flares 451

Scrubbers 452

Condensers 452

Suggested Reading 452

Problems 453

10 Relief Sizing 459

- 10-1 Conventional Spring-Operated Reliefs in Liquid Service 460
- 10-2 Conventional Spring-Operated Reliefs in Vapor or Gas Service 466

11

12

10-3	Rupture Disc Reliefs in Liquid Service 470
10-4	Rupture Disc Reliefs in Vapor or Gas Service 471
10-5	Two-Phase Flow during Runaway Reaction Relief 472 Simplified Nomograph Method 478
10-6	Pilot-Operated and Bucking-Pin Reliefs 481
10-7	Deflagration Venting for Dust and Vapor Explosions 48 Vents for Low-Pressure Structures 483 Vents for High-Pressure Structures 485
10-8	Venting for Fires External to Process Vessels 488
10-9	Reliefs for Thermal Expansion of Process Fluids 492 Suggested Reading 496 Problems 497
Haz	zards Identification 505
11-2	Process Hazards Checklists 508 Hazards Surveys 508 Hazards and Operability Studies 524
	Safety Reviews 530 Informal Review 533 Formal Review 534
11-5	Other Methods 537
	Suggested Reading 538
	Problems 538
Risl	Assessment 549
12-1	Review of Probability Theory 550 Interactions between Process Units 552 Revealed and Unrevealed Failures 558 Probability of Coincidence 562 Redundancy 564 Common Mode Failures 564
12-2	Event Trees 564
12-3	Fault Trees 569 Determining the Minimal Cut Sets 572 Quantitative Calculations Using the Fault Tree 575 Advantages and Disadvantages of Fault Trees 576
12-4	Relationship between Fault Trees and Event Trees 576 QRA and LOPA 577
12-4	Quantitative Risk Analysis 577
	Layer of Protection Analysis 578 Consequence 581
	Frequency 581
	Typical LOPA 585
	Suggested Reading 588
	Problems 588

13-1	Process Safety Hierarchy 598
	Process Safety Strategies 598
	Layers of Protection 598
13-2	Managing Safety 599
	Documentation 599
	Communications 599
	Delegation 599
	Follow-up 600
13-3	Best Practices 600
13-4	Procedures—Operating 600
13-5	Procedures—Permits 601
	Hot Work Permit 601
	Lock-Tag-Try Permit 601
	Vessel Entry Permit 602
13-6	Procedures—Safety Reviews and Accident Investigations
	Safety Reviews 603
	Incident Investigations 603
13-7	Designs for Process Safety 604
	Inherently Safer Designs 605
	Controls—Double Block and Bleed 606
	Controls—Safeguards or Redundancy 607
	Controls—Block Valves 608
	Controls—Explosion Suppression 608
	Flame Arrestors 608
	Containment 609
	Materials of Construction 610
	Process Vessels 610
	Deflagrations 612
	Detonations 612
13-8	Miscellaneous Designs for Fires and Explosions 615
13-9	Designs for Runaway Reactions 615
13-10	Designs for Handling Dusts 616
	Designs for Preventing Dust Explosions 617
	Management Practices for Preventing Dust Explosion
	Suggested Reading 617
	Problems 618

14 Case Histories 621

14-1 Static Electricity 622
Tank Car Loading Explosion 622
Explosion in a Centrifuge 622
Duct System Explosion 623
Conductor in a Solids Storage Bin 623

B

C

Pigment and Filter 624	
Pipefitter's Helper 624	
Lessons Learned Concerning Static Electricity 624	
14-2 Chemical Reactivity 626	
Bottle of Isopropyl Ether 630	
Nitrobenzene Sulfonic Acid Decomposition 630	
Organic Oxidation 631	
Lessons Learned Concerning Chemical Reactivity 631	
14-3 System Designs 631	
Ethylene Oxide Explosion 631	
Ethylene Explosion 632	
Butadiene Explosion 632	
Light Hydrocarbon Explosion 632	
Pump Vibration 633	
Pump Failure 633	
Second Ethylene Explosion 633	
Third Ethylene Explosion 634	
Second Ethylene Oxide Explosion 634	
Lessons Learned Concerning Designs 635	
14-4 Procedures 637	
Leak Testing a Vessel 637	
Man Working in Vessel 638	
Vinyl Chloride Explosion 638	
Dangerous Water Expansion 638	
Phenol-Formaldehyde Runaway Reaction 639	
Conditions and Secondary Reaction Cause Explosion 63	9
Fuel-Blending Tank Explosion 640	
Lessons Learned Concerning Procedures 641	
14-5 Training 642	
Weld Failure 642	
Safety Culture 642	
Training within Universities 643	
Training Regarding the Use of Standards 643	
Lessons Learned Concerning Training 645	
14-6 Conclusion 645	
Suggested Reading 646	
Problems 646	
TI '4 C	
Unit Conversion Constants 649	
Flammability Data for Selected Hydrocarbons 653	
Detailed Equations for Flammability Diagrams 659)

Equations Useful for Gas Mixtures 659

Equations Useful for Placing Vessels into and out of Service 664

D	Formal Safety Review Report for Example 10-4 669
E	Saturation Vapor Pressure Data 679
F	Special Types of Reactive Chemicals 681
G	Hazardous Chemicals Data for a Variety of Chemical Substances 687
	Index 695