

**STATE OF UTAH
DEPARTMENT OF ENVIRONMENTAL QUALITY
DIVISION OF WATER QUALITY
UTAH WATER QUALITY BOARD
SALT LAKE CITY, UTAH 84114-4870**

**GROUND WATER DISCHARGE PERMIT
Permit No. UGW350008**

In compliance with the provisions of the Utah Water Quality Act, Title 19, Chapter 5, Utah Code Annotated 1953, as amended, the Act,

**KENNECOTT UTAH COPPER CORPORATION
8315 WEST 3595 SOUTH
P.O. Box 6001
Magna, UTAH 84044-6001**

is granted a ground water discharge permit for the operation of the Smelter in Salt Lake County, Utah. The Smelter is located on a tract of land encompassed in Sections 16, 17, 20 and 21 Township 1 South, Range 3 West, Salt Lake Base and Meridian. (112° 11' 47" W. Long. and 40° 43' 27" N. Lat.)

The permit is based on representations made by the permittee and other information contained in the administrative record. It is the responsibility of the permittee to read and understand all provisions of this permit.

The facility shall be maintained and operated in accordance with conditions set forth in the permit and the Utah Ground Water Quality Protection Regulations.

This Ground Water Quality Discharge Permit for the Kennecott Smelter supersedes all other Ground Water Discharge permits for this facility previously issued.

This permit shall become effective on October 1, 2008.

This permit and the authorization to operate shall expire at midnight, October 1, 2013.

Signed this 15th day of September 2008.

Original signed by Walter L. Baker

Walter L. Baker, P.E.
Executive Secretary
Utah Water Quality Board

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Attachments

- Table 1A; Kennecott Smelter BAT and Performance Criteria Chart
- Table 1B; Kennecott Smelter: Permit by Rule Facilities
- Table 2; Operational Monitoring Points
- Table 3; Unit Process Monitoring Well Permit Limits
- Appendix A; Best Management Practices Plan
- Appendix B; BAT Monitoring Plan -Appendix C; Leak Detection and Repair Plan

I. SPECIFIC PERMIT CONDITIONS

A. Ground Water Classification

The ground water classification for the uppermost aquifers in the vicinity of the Smelter is generally Class III ground water based on TDS and the presence of contaminants. The shallow and intermediate aquifers have been affected by historical Smelter operations prior to permitting process and many site monitoring wells currently exceed one or more Utah Ground Water Quality Standard

B. Ground Water Protection Levels

Ground Water Protection Levels are established for the Slag Cooling Area to prevent further degradation of existing water quality and are represented in Table 3. Protection levels and compliance limits are based on monitoring well sampling performed to date and on the requirements of the criteria of R317-6-4. The permittee shall operate the facility such that the ground water standards and protection levels developed for this permit are not exceeded at the designated compliance monitoring points

C. Permitted Facilities

The Facilities authorized under this permit are listed in Table 1A column 1. These facilities constitute those, not permitted by rule, where there is potential for release of pollutants to ground water. The facilities listed in Table 1B under the "Permit By Rule" heading are for unit processes not specifically addressed by this permit. However, no discharge of pollutants to ground water from these sites is allowed.

D. Best Available Technology Performance Standard

The administration of this permit is founded on the use of best available technology (BAT), in accordance with the requirements of UAC R317-6-1.3. The enforceable performance standard for this permit to achieve protection of ground water quality will be no discharge of process fluids to ground water from the permitted facilities listed in column 1 of Table 1A. The permittee is responsible for implementing the best available technology noted in column 2 (BAT Description) of Table 1A to prevent discharge of process fluids from the permitted facilities to ground water. Maintenance of this performance standard will be demonstrated by:

1. Operation and maintenance of the leak collection and removal systems as specified in column 3 of Table 1A.
2. Adherence to the performance criteria in Table 1A (column 4)
3. No ground water degradation beyond historical mean values for perimeter monitoring wells listed in Part I D.5., and the greater of protection levels and

compliance limits established in Table 3 for unit process wells at the Slag Cooling Area.

4. Implementation of the Best Management Practices Plan (Appendix A) to ensure prompt clean up of any spills and proper handling of cooling and run off waters at the Acid Plant, Hydrometallurgical Plant, Anode Casting Process, the materials storage pads, matte storage area & sump, and vehicle decontamination pad & sump.

E. Compliance Monitoring

1. General Provisions

- a) *Future Modification of the Monitoring Network* - If at any time the Executive Secretary determines the monitoring program to be inadequate, Kennecott shall submit within 30 days of receipt of written notice from the Executive Secretary a modified monitoring plan that addresses the inadequacies noted by the Executive Secretary.
- b) *Compliance Monitoring Period* - Monitoring shall commence upon issuance of this permit and shall continue through the life of this permit. For facilities that are constructed during the term of this permit, monitoring shall commence upon initiation of operation of the new facility.
- c) *Laboratory Approval* - All water quality analyses shall be performed by a laboratory certified by the State of Utah to perform such analysis.
- d) *Water Level Measurement* - In association with each well sampling event, water level measurements shall be made in each monitoring well prior to removal of any water from the well bore. These measurements will be made from a permanent single reference point clearly marked on the top of the well or surface casing. Measurements will be made to the nearest 0.01 foot.
- e) *Sampling Protocol* - Water quality samples will be collected, handled and analyzed in conformance with the current approved version of the Kennecott Ground Water Characterization and Monitoring Plan.
- f) *Constituents Sampled* - The following analysis shall be performed on all monitoring samples collected:
 - i) Field Measurements: pH, specific conductance, temperature

- ii) Laboratory Analysis:
 - chloride, sulfate
 - TDS
 - Metals (dissolved): arsenic, barium, cadmium, chromium, copper, lead, selenium, zinc

2. Compliance Monitoring of Unit Process Wells

Kennecott shall monitor the following unit process wells adjacent to the Slag Cooling Area: NES729 and NES2556.

3. Monitoring of Perimeter Wells

Kennecott shall monitor the following wells throughout the term of this permit to assess best management practices: NES620B, NES621A and B, NES622A and B, NES623A and B, NES695A and B, NES707A and B, NES715A and B, NES725, and NES2574.

4. Well Monitoring Sampling Frequency

Unit Process wells shall be sampled semi-annually (twice each year at approximately six month intervals) throughout the duration of this permit. Perimeter monitoring wells shall be sampled semi-annually. For any new compliance monitoring wells that are installed, the permittee shall collect at least eight independent samples at equal time intervals over a one-year period from each well. The samples shall be analyzed for major ions and the parameters listed in Part I.E.1.F.

5. BAT Performance Monitoring

- a) Kennecott shall verify the operation of the BAT designated for each facility listed in column 1 of Table 1A with an inspection and maintenance program. Documentation of compliance with this program shall be maintained on site for review by representatives of the Division.
- b) Kennecott shall monitor the performance of each unit process that utilizes a leak collection and removal system in accordance with the BAT Performance Monitoring Plan (Appendix B). The results of this monitoring shall be reported in accordance with the schedule in Part I Section F.

6. Operational Monitoring

- a) Kennecott shall characterize the fluids utilized in the smelter processes with grab samples for the unit process sites listed on Table 2.

- b) *Monitoring Frequency* - Operational monitoring shall occur two times during the five-year term of this permit. The first sampling event shall occur in the second year of the permit term. The second sampling will be conducted in the last year of the permit term. Results from operational monitoring data shall be included in the application for permit renewal every five years.

F. Demonstration of Compliance for BAT

1. Unit Processes with Leak Collection and Removal

- a) *Performance Criteria* - Kennecott shall operate the facilities listed in Table 1A in accordance with the performance criteria noted therein. All instances where a performance criteria is exceeded shall be reported in the semi-annual ground water monitoring report.
- b) *Response to a Leak* - Upon determination that maximum water levels or leakage rates specified in the performance criteria from Table 1A Column 4 have been exceeded, Kennecott shall immediately:

Remove fluid from the affected leak collection system to a level below the allowable maximum fluid level specified in Table 1A and determine the leakage rate entering the leak collection system. If the cause of the high level alarm or leakage rate can be repaired within 24 hours of detection of the alarm condition, Kennecott is not obligated to undertake items i through iv of Part I Section E 1.b. If the cause of the high level alarm or leakage rate cannot be repaired within 24 hours of detection of the alarm condition, Kennecott shall undertake the following actions:

- i) Sample the effluent from the collection system for water quality field and lab constituents noted in Part I Section D 1(f) and submit the analytical results the next semi-annual monitoring report.
- ii) Notify the Executive Secretary in writing within 5 days that a performance criteria has been exceeded and what the measured leakage rate in the affected leak collection system is.
- iii) If the leakage rate is in excess of the maximum rate specified in Table 1A. Kennecott shall implement the approved Leak Detection and Repair plan (Appendix C).
- iv) Remove fluids from any affected leak collection system on a continuous basis to maintain fluid levels less than the specified maximum in Table 1A.

- c) *Non-Compliance Status* - Failure to maintain BAT or exceeding a performance criteria specified in Table 1A Column 4 shall be a violation of permit conditions relating to best available technology. Kennecott may affirmatively defend against that action by demonstrating the following:
- i) Kennecott has conformed with the provisions of Part I Section E 1 b of this permit.
 - ii) The failure of BAT was not intentional nor was it caused by Kennecott's negligence, either in action or in failure to act.
 - iii) Kennecott implements the Leak Detection and Repair Plan within the time frames specified by the plan.
 - iv) The assessment performed under the Leak Detection and Repair Plan indicates no reason to expect a release in excess of de minimus quantities to ground water has occurred.

2. Monitoring Wells

- a) *General Provisions* - Unit process monitoring wells have been installed adjacent to and downgradient from the Slag Cooling Area to detect releases to ground water. Wells will be monitored in accordance with the compliance monitoring requirements of Part I Section D 2 of this permit. Permit limits for TDS, pH, sulfate, and metals are listed in Table 3. Perimeter wells should be evaluated if constituents show a statistically significant increase above historical background levels of that well. Statistical significance shall be determined using methods described in Statistical Methods for Evaluating Ground Water Monitoring Data from Hazardous Waste Facilities, Vol. 53, No. 196 (Federal Register, Oct. 11, 1988).
- b) *Probable Out of Compliance* - When water quality sampling of Unit Process Well(s) shows that the permit limits have been exceeded Kennecott shall:
 - i) Immediately re-sample the monitoring well(s) that has exceeded permit limits, submit analytical results from the re-sampling, and notify the Executive Secretary of the probable out-of-compliance status within 30 days of initial detection.
 - ii) Implement a monthly frequency of sampling for the ground water monitoring well(s) in question. The monthly frequency shall continue until the Executive Secretary notifies Kennecott that a semi-annual monitoring frequency can be resumed.

- c) *Out of Compliance Status* - After completion of the accelerated monitoring results obtained under monthly sampling as spelled out in Part I E 2(b), Kennecott shall determine if statistically higher concentrations of a ground water pollutant have occurred in excess of the permit limits. Upon making this determination Kennecott shall:
 - i) Notify the Executive Secretary of the out of compliance status within 24 hours of detection.
 - ii) Submit a Source Assessment and Compliance Schedule to the Executive Secretary within 30 days of detection of the out of compliance status that outlines the following:
 - ▶ Steps of action that will assess the extent of the contamination and identify its source.
 - ▶ Measures that will be taken to alleviate contribution of any further contamination to the ground water and prevent any recurrence of the non-compliance.
 - ▶ Actions that will be taken to mitigate and remediate existing contamination from the repository.
 - iii) Implement the Source Assessment and Compliance Schedule within 120 days of approval by the Executive Secretary.

3. Unit Processes with Best Management Practices

Kennecott shall operate the Acid Plant, Hydrometallurgical Plant, the Anode Casting Process, materials storage pads, matte storage area & sump, and the vehicle decontamination pad & sump, in accordance with the Best Management Practices specified in Appendix A.

4. Process Pond Overflows

When water from process ponds overflow into their respective storm water ponds, Kennecott shall:

- i) Sample the overflow effluent in the storm water pond for water quality field and lab constituents identified in Part I Section D 1 f unless all process waters can be pumped back into the process water pond within 24 hours after start of release. The results of sampling shall be reported in the semi-annual water quality monitoring report.
- ii) The date and duration of all process water overflows shall be reported in the semi-annual monitoring report.

- iii) Remove fluids from the storm water ponds and return to the process water system. Storm pond level is considered empty at 5% of total volume.
- iv) Notify the Division of Water Quality of any releases from the storm water ponds to the environment. Reporting shall follow the requirements of Part II, I, 1,2,3, as applicable. Include information about the duration of the event and estimated volume released.

G. Reporting Requirements

- 1. Reporting
Water quality sampling results with any supporting data shall be submitted two times per year to the Executive Secretary as follows:

<u>Quarter</u>	<u>Report Due On</u>
1 st & 2 nd	August 15
3 rd & 4 th	February 15

Failure to submit reports within the time frame due shall be deemed as noncompliance and may result in enforcement action.

- 2. **Electronic Filing Requirements** - The permittee will electronically submit the required ground water monitoring data in the electronic format specified by the Executive Secretary. The data should be in an Adobe PDF document sent by e-mail, CD, or other approved transmittal mechanism.

H. Compliance Schedule

- 1. *Corrective Action* - Within 180 days of notification by the Executive Secretary that corrective action is not proceeding in a timely fashion, Kennecott shall submit for approval a Contamination Investigation and Corrective Action Plan to clean up the existing contamination problems at the Smelter. The characterization of pollution shall include a description of the amount, form, concentration, toxicity, environmental fate and transport and other significant characteristics of pollutants present. The Corrective Action Plan shall describe the measures that will be taken to contain, remove or eliminate contamination.
- 2. If Kennecott must place more than 50 tons of any material, other than those listed below, on the storage pads for a duration greater than one month, the executive secretary shall be notified. The notification will propose a plan for the characterization of these materials for approval by the executive secretary:
 - Copper Concentrate
 - Matte
 - Flux
 - Slag (including Flash Smelting, Flash Converter and Anode Slags)

- Copper Reverts
 - Process Pond Sediments
3. If road realignment of SR 201 by the Utah Department of Transportation should result in the abandonment of perimeter monitoring wells listed in Part I.E.3., or make them unsafe to sample, Kennecott shall pursue one of the following alternatives: replace the wells in a suitable location, recommend existing wells as replacements, or present an alternative plan for perimeter monitoring that will assess best management practices for the protection of ground water throughout the term of the permit.

II. MONITORING, RECORDING AND REPORTING REQUIREMENTS

- A. Representative Sampling Samples taken in compliance with the monitoring requirements established under Part I shall be representative of the monitored activity.
- B. Analytical Procedures Water sample analysis must be conducted according to test procedures specified under UAC R317-6-6.12, unless other test procedures have been specified in this permit.
- C. Penalties for Tampering The Act provides that any person who falsifies, tampers with, or knowingly renders inaccurate, any monitoring device or method required to be maintained under this permit shall, upon conviction, be punished by a fine of not more than \$10,000 per violation, or by imprisonment for not more than six months per violation, or by both.
- D. Reporting of Monitoring Results Monitoring results obtained for each monitoring period specified in the permit, shall be submitted to the Executive Secretary, Utah Division of Water Quality at the following address no later than 45 days after the end of the monitoring period:

State of Utah
Division of Water Quality
Department of Environmental Quality
P.O. Box 144870
Salt Lake City, Utah 84114-4870
Attention: Ground Water Quality Program
electronic address: rherbert@utah.gov

- E. Compliance Schedules Reports of compliance or noncompliance with, or any progress reports on interim and final requirements contained in any Compliance Schedule of this permit shall be submitted no later than 14 days following each schedule date.
- F. Additional Monitoring by the Permittee If the permittee monitors any pollutant more frequently than required by this permit, using approved test procedures as specified in this permit, the results of this monitoring shall be included in the calculation and reporting of the data submitted. Such increased frequency shall also be indicated.
- G. Records Contents. Records of monitoring information shall include:
1. The date, exact place, and time of sampling or measurements;
 2. The individual(s) who performed the sampling or measurements;
 3. The date(s) and time(s) analyses were performed;
 4. The individual(s) who performed the analyses;
 5. The analytical techniques or methods used; and,
 6. The results of such analyses.

- H.** Retention of Records. The permittee shall retain records of all monitoring information, including all calibration and maintenance records and copies of all reports required by this permit, and records of all data used to complete the application for this permit, for a period of at least three years from the date of the sample, measurement, report or application. This period may be extended by request of the Executive Secretary at any time.
- I.** Twenty-four Hour Notice of Noncompliance and Spill Reporting
1. The permittee shall verbally report any noncompliance, or spills subject to the provisions of UCA 19-5-114, which may endanger public health or the environment as soon as possible, but no later than twenty-four (24) hours from the time the permittee first became aware of the circumstances. The report shall be made to the Utah Department of Environmental Quality 24 hour number, (801) 536-4123, or to the Division of Water Quality, Ground Water Protection Section at (801) 538-6146, during normal business hours (8:00 am - 5:00 pm Mountain Time).
 2. A written submission shall also be provided to the Executive Secretary within five days of the time that the permittee becomes aware of the circumstances. The written submission shall contain:
 - a. A description of the noncompliance and its cause;
 - b. The period of noncompliance, including exact dates and times;
 - c. The estimated time noncompliance is expected to continue if it has not been corrected; and,
 - d. Steps taken or planned to reduce, eliminate, and prevent reoccurrence of the noncompliance.
 3. Reports shall be submitted to the addresses in Part II D, Reporting of Monitoring Results.
- J.** Other Noncompliance Reporting Instances of noncompliance not required to be reported within 24 hours, shall be reported at the time that monitoring reports for Part II D are submitted.
- K.** Inspection and Entry. The permittee shall allow the Executive Secretary, or an authorized representative, upon the presentation of credentials and other documents as may be required by law, to:
1. Enter upon the permittee's premises where a regulated facility or activity is located or conducted, or where records must be kept under the conditions of the permit;

2. Have access to and copy, at reasonable times, any records that must be kept under the conditions of this permit;
3. Inspect at reasonable times any facilities, equipment (including monitoring and control equipment), practices, or operations regulated or required under this permit; and,
4. Sample or monitor at reasonable times, for the purpose of assuring permit compliance or as otherwise authorized by the Act, any substances or parameters at any location

III. COMPLIANCE RESPONSIBILITIES

- A. Duty to Comply. The permittee must comply with all conditions of this permit. Any permit noncompliance constitutes a violation of the Act and is grounds for enforcement action; for permit termination, revocation and re-issuance, or modification; or for denial of a permit renewal application. The permittee shall give advance notice to the Executive Secretary of any planned changes in the permitted facility or activity which may result in noncompliance with permit requirements.
- B. Penalties for Violations of Permit Conditions. The Act provides that any person who violates a permit condition implementing provisions of the Act is subject to a civil penalty not to exceed \$10,000 per day of such violation. Any person who willfully or negligently violates permit conditions is subject to a fine not exceeding \$25,000 per day of violation. Any person convicted under Section 19-5-115(2) of the Act a second time shall be punished by a fine not exceeding \$50,000 per day. Nothing in this permit shall be construed to relieve the permittee of the civil or criminal penalties for noncompliance.
- C. Need to Halt or Reduce Activity not a Defense. It shall not be a defense for a permittee in an enforcement action that it would have been necessary to halt or reduce the permitted activity in order to maintain compliance with the conditions of this permit.
- D. Duty to Mitigate. The permittee shall take all reasonable steps to minimize or prevent any discharge in violation of this permit which has a reasonable likelihood of adversely affecting human health or the environment.
- E. Proper Operation and Maintenance. The permittee shall at all times properly operate and maintain all facilities and systems of treatment and control (and related appurtenances) which are installed or used by the permittee to achieve compliance with the conditions of this permit. Proper operation and maintenance also includes adequate laboratory controls and quality assurance procedures. This provision requires the operation of back-up or auxiliary facilities or similar systems which are installed by a permittee only when the operation is necessary to achieve compliance with the conditions of the permit.

IV. GENERAL REQUIREMENTS

- A. Planned Changes. The permittee shall give notice to the Executive Secretary as soon as possible of any planned physical alterations or additions to the permitted facility. Notice is required when the alteration or addition could significantly change the nature of the facility or increase the quantity of pollutants discharged.
- B. Anticipated Noncompliance. The permittee shall give advance notice of any planned changes in the permitted facility or activity which may result in noncompliance with permit requirements.
- C. Permit Actions. This permit may be modified, revoked and reissued, or terminated for cause. The filing of a request by the permittee for a permit modification, revocation and re-issuance, or termination, or a notification of planned changes or anticipated noncompliance, does not stay any permit condition.
- D. Duty to Reapply. If the permittee wishes to continue an activity regulated by this permit after the expiration date of this permit, the permittee must apply for and obtain a permit renewal or extension. The application should be submitted at least 180 days before the expiration date of this permit.
- E. Duty to Provide Information. The permittee shall furnish to the Executive Secretary, within a reasonable time, any information which the Executive Secretary may request to determine whether cause exists for modifying, revoking and reissuing, or terminating this permit, or to determine compliance with this permit. The permittee shall also furnish to the Executive Secretary, upon request, copies of records required to be kept by this permit.
- F. Other Information. When the permittee becomes aware that it failed to submit any relevant facts in a permit application, or submitted incorrect information in a permit application or any report to the Executive Secretary, it shall promptly submit such facts or information.
- G. Signatory Requirements. All applications, reports or information submitted to the Executive Secretary shall be signed and certified.
1. All permit applications shall be signed as follows:
 - a. For a corporation: by a responsible corporate officer;
 - b. For a partnership or sole proprietorship: by a general partner or the proprietor, respectively.
 - c. For a municipality, State, Federal, or other public agency: by either a principal executive officer or ranking elected official.

2. All reports required by the permit and other information requested by the Executive Secretary shall be signed by a person described above or by a duly authorized representative of that person. A person is a duly authorized representative only if:
 - a. The authorization is made in writing by a person described above and submitted to the Executive Secretary, and,
 - b. The authorization specified either an individual or a position having responsibility for the overall operation of the regulated facility or activity, such as the position of plant manager, operator of a well or a well field, superintendent, position of equivalent responsibility, or an individual or position having overall responsibility for environmental matters for the company. (A duly authorized representative may thus be either a named individual or any individual occupying a named position.)
3. Changes to Authorization. If an authorization under Part IV G 2. is no longer accurate because a different individual or position has responsibility for the overall operation of the facility, a new authorization satisfying the requirements of Part IV G 2. must be submitted to the Executive Secretary prior to or together with any reports, information, or applications to be signed by an authorized representative.
4. Certification. Any person signing a document under this section shall make the following certification:

"I certify under penalty of law that this document and all attachments were prepared under my direction or supervision in accordance with a system designed to assure that qualified personnel properly gather and evaluate the information submitted. Based on my inquiry of the person or persons who manage the system, or those persons directly responsible for gathering the information, the information submitted is, to the best of my knowledge and belief, true, accurate, and complete. I am aware that there are significant penalties for submitting false information, including the possibility of fine and imprisonment for knowing violations."

- H. Penalties for Falsification of Reports. The Act provides that any person who knowingly makes any false statement, representation, or certification in any record or other document submitted or required to be maintained under this permit, including monitoring reports or reports of compliance or noncompliance shall, upon conviction be punished by a fine of not more than \$10,000 per violation, or by imprisonment for not more than six months per violation, or by both.

- I. Availability of Reports. Except for data determined to be confidential by the permittee, all reports prepared in accordance with the terms of this permit shall be available for public inspection at the offices of the Executive Secretary. As required by the Act, permit applications, permits, effluent data, and ground water quality data shall not be considered confidential.
- J. Property Rights. The issuance of this permit does not convey any property rights of any sort, or any exclusive privileges, nor does it authorize any injury to private property or any invasion of personal rights, nor any infringement of federal, state or local laws or regulations.
- K. Severability. The provisions of this permit are severable, and if any provision of this permit, or the application of any provision of this permit to any circumstance, is held invalid, the application of such provision to other circumstances, and the remainder of this permit, shall not be affected thereby.
- L. Transfers. This permit may be automatically transferred to a new permittee if:
1. The current permittee notifies the Executive Secretary at least 30 days in advance of the proposed transfer date;
 2. The notice includes a written agreement between the existing and new permittee containing a specific date for transfer of permit responsibility, coverage, and liability between them; and,
 3. The Executive Secretary does not notify the existing permittee and the proposed new permittee of his or her intent to modify, or revoke and reissue the permit. If this notice is not received, the transfer is effective on the date specified in the agreement mentioned in paragraph 2 above.
- M. State Laws. Nothing in this permit shall be construed to preclude the institution of any legal action or relieve the permittee from any responsibilities, liabilities, penalties established pursuant to any applicable state law or regulation under authority preserved by Section 19-5-117 of the Act.
- N. Reopener Provision. This permit may be reopened and modified (following proper administrative procedures) to include the appropriate limitations and compliance schedule, if necessary, if one or more of the following events occurs:
1. If new ground water standards are adopted by the Board, the permit may be reopened and modified to extend the terms of the permit or to include pollutants covered by new standards. The permittee may apply for a variance under the conditions outlined in R317-6.4(D)
 2. If alternate compliance mechanisms are required.
 3. If water quality of the facility is significantly worse than represented in the original permit application.

Table 1A

October 2008

**KENNECOTT SMELTER BAT AND PERFORMANCE CRITERIA CHART
FOR FACILITIES WITH LEAK DETECTION AND REMOVAL SYSTEMS**

Facility	BAT Description	Inspection and Maintenance	Performance Criteria
West Process Water Pond	Two 60 mil HDPE liners with leak collection layer; pump back system to remove leakage and minimize head; 12 inch engineered subgrade with a hydraulic conductivity of no greater than 1×10^{-5} cm/sec; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 4 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
East Process Water Pond	Two 60 mil HDPE liners with leak collection layer; pump back system to remove leakage and minimize head; 12 inch engineered subgrade with a hydraulic conductivity of no greater than 1×10^{-5} cm/sec; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 4 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Granulation Cooling Tower Basin	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Granulation Pumphouse Sump	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Acid Plant Pumphouse Sump	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Vehicle Repair Shop Basin	Concrete basin with PVC underliner and leak detection and removal	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Vehicle Wash Station	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.

Table 1A

Permit No. UGW350008

October 2008

**KENNECOTT SMELTER BAT AND PERFORMANCE CRITERIA CHART
FOR FACILITIES WITH LEAK DETECTION AND REMOVAL SYSTEMS**

Facility	BAT Description	Inspection and Maintenance	Performance Criteria
<p>Sumps and Drains. See Table 2A for the list of sumps and drains</p>	<p>Sumps, concrete or steel lined, with impervious coatings suited for the liquids handled. Drains are concrete or asphalt lined and those that convey strong acid are lined with acid resistant materials</p>	<p>Annual inspections to verify integrity of the lining.</p>	<p>No detectable leakage</p>
<p>Materials Storage Pads (concentrate, matte, blister copper, pond sludge, copper reverts & fines, converter slag)</p>	<p>Compacted road base overlain with asphalt paving. Perimeter berms three feet high for total containment of all run-off.</p>	<p>Monthly inspections to verify integrity of asphalt. Prompt removal of any accumulated run off waters.</p>	<p>Removal of storm water runoff within 5 days after the end of a storm event. Total containment of all runoff unless storm is greater than a 25 year 24- hour storm.</p>
<p>Slag Cooling Area</p>	<p>Concrete pad with sloping drain channel to remove water to west process pond</p>	<p>Surface inspected quarterly; repaired if needed, drainage channels kept clear</p>	<p>Monitoring Well(s) of Unit Process with permit limits. All runoff contained and routed to West Process Pond.</p>
<p>Acid Plant</p>	<p>Lined basins with acid resistant material in areas with potential for acid spills.</p>	<p>Daily monitoring of plant operations</p>	<p>Prompt clean up of any spills. No process fluids allowed to pond or remain on floor or in sumps. Adherence to Best Management Practices Plan. (see Appendix A)</p>
<p>Matte Storage Area with sump</p>	<p>10 inch thick concrete slab with 5% slope to sump</p>	<p>Monthly inspections to verify integrity of concrete. Continuous removal of run-off waters via sump pump to process water circuit.</p>	<p>Removal of storm water runoff within 5 days after the end of a storm event. Total containment of all runoff unless storm is greater than a 25 year 24 hour storm.</p>
<p>Equipment Decontamination and Materials Processing Pad</p>	<p>6 inch thick concrete slab with slope to total containment concrete sump.</p>	<p>Monthly inspections to verify integrity of concrete. Hydrostatic testing of sump annually.</p>	<p>Total containment of all runoff unless storm is greater than a 25 year 24 hour storm.</p>

Table 1A

October 2008

**KENNECOTT SMELTER BAT AND PERFORMANCE CRITERIA CHART
FOR FACILITIES WITH LEAK DETECTION AND REMOVAL SYSTEMS**

Anode Casting Process	Sloped concrete floor to concrete collection sump	Visual inspection during scheduled shutdowns for concrete integrity	No discharge of waters used for anode cooling from floor or sump. Adherence to Best Management Practices Plan. (see Appendix A)
Intermediate By-Products Building	Concrete floor with concrete floor sumps lined with HDPE.	Visual inspection of concrete floor and sumps on a quarterly basis.	No detectable leakage
Jacket Water Pumphouse Sump	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Acid Plant Cooling Water Basin	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Power House/ Furnace Cooling Water Basin	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Power House/ Furnace Pumphouse Sump	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.

Table 1B**Permit No. UGW350008****October 2008****KENNECOTT SMELTER: PERMIT BY RULE FACILITIES**

Permit by Rule Facilities	Discharge Control Technology	Inspection and Maintenance	Performance Criteria
West Storm water Pond	12 inch thick clay liner and 60 mil HDPE liner		NONE
East Storm water Pond	60 mil HDPE liner		NONE
Surface Storage Tanks	Steel Tanks on concrete		NONE
Slag Concentrate Thickener	Above ground tank on a concrete pad	monthly inspection of tank	NONE
Fresh Water Reservoir	60 mil HDPE liner on top of an engineered base		NONE
Fire Water Pond	60 mil HDPE liner		NONE
Acid Storage/Loadout	Steel above ground tanks with cathodic protection, "membrane liner", concrete ringwall, foundation contained in diked area lined with acid resistant asphalt (void and gilsonite coating)		NONE
Granulation Clarifier	Above ground tank	monthly inspection	NONE
Granulation Tanks	Above ground tanks	monthly inspection	NONE

APPENDIX A
BEST MANAGEMENT PRACTICES PLAN
FOR
ACID PLANT
HYDROMETALLURGICAL PLANT
ANODE CASTING PROCESS
DECONTAMINATION PAD AND SUMP
MATTE STORAGE AREA AND SUMP
MATERIAL STORAGE PADS
INTERMEDIATE BY-PRODUCTS STORAGE BUILDING

INTRODUCTION

The Kennecott Utah Copper Smelter has been granted a Ground Water Discharge Permit (Permit No. UGW350008) by the State of Utah. This permit details the construction, operation and monitoring requirements for the facilities at the Smelter that have the potential of releasing fluids to the ground water. The permit specifies that Best Available Technology (BAT) be used in the construction of all facilities and that facilities be operated according to Best Management Practices (BMP).

The permit lists fifteen individual facilities that have BAT criteria associated with them. This document addresses the facilities that require a BMP Plan. These facilities are the Acid Plant, Hydrometallurgical Plant, the Anode Casting Process, the matte storage pad and sump, the decontamination pad and several material storage pads. The BMP describes operations and maintenance practices that will be utilized for spill prevention, spill cleanup, materials handling, housekeeping practices and reporting of spill events.

BEST AVAILABLE TECHNOLOGY

Acid Plant

The acid plant is located on the southwestern portion of the modernized Smelter foot print. The plant incorporates lined basins with acid-resistant material in areas where the potential for acid spills exists. Equipment is constructed above-grade. Above-ground acid lines are constructed of corrosion resistant materials.

Hydrometallurgical Plant

The hydrometallurgical plant is located in the northwest corner of the modernized Smelter foot print. All of the process tanks are constructed above-ground on concrete pads. Floor sumps are constructed of acid-resistant materials. Process areas are provided with containment in areas where the potential for spills exists.

Anode Casting Process

The anode casting process is located in the casting building of the modernized Smelter. Molten blister copper is poured from the anode refining furnace directly into an anode mold. The anode is then cooled by water sprays as it is rotated. The anode is stripped from the mold and placed in an above-grade, anode cooling tank. Wash-down water will have a slightly elevated pH and metals concentration due to contact with the anode copper and the barite-coated mold.

The anode casting process area is constructed with a sloped concrete floor which drains to a circular concrete collection sump. Sumps and floor drains in the area flow to the process water recycle system.

Decontamination Pad and Sump

The equipment decontamination and material processing pad is located due west of the modernized Smelter Maintenance/Administration Building. The facility is used to decontaminate equipment and scrap metal via water spray. This facility is also used for processing solutions collected off materials storage pads, out of sumps or containments and from street sweeping equipment. Solutions are collected in a two-cell collection basin which separates solids for recycle and desilted water for introduction back into the process water system.

The decontamination pad is constructed with a sloped concrete floor which drains to a concrete collection basin. Solutions reporting to the basin are designed to gravity flow to the west process water ponds. The collection basin is comprised of two cells. Each cell will be hydrostatically tested twice annually to demonstrate no leakage is occurring as described in the last paragraph on page 5 of this appendix.

Matte Storage Area and Sump

The matte storage area and sump are located due east of the matte dome. This facility is used to store granulated matte generated from the flash smelting process prior to transport for further processing or sale.

The matte storage pad is constructed of a 10-inch thick concrete slab with a 5% slope draining to a collection sump. Solutions reporting to the collection sump are pumped to the granulation clarifier tank.

Material Storage Pads

Four material storage pads (Blending Pad, Green Concentrate Pad, Cherry Bowl and Rail Loading Pads) and several smaller pads are located throughout the active smelter footprint. These pads have been constructed to temporarily store concentrate, matte, blister copper, pond sludge, copper reverts and converter slag prior to introducing these materials back into the smelting process.

The pads are constructed of compacted road base overlain with asphalt paving. Perimeter berms provide containment of all run-off up to a 25 year, 24-hour storm event. The pads are positioned such that no run-on of surface flows is allowed. Pads are either equipped with sump and piping to continuously remove liquids from the pad or vacuum trucks will provide removal of accumulated waters within 5 days following storm events.

INSPECTION AND MAINTENANCE PROCEDURES

General

Operations

Operations at the acid plant, hydrometallurgical plant and anode casting process are monitored on a continuous basis via a distributed control system (DCS). Operators are assigned to monitor the DCS on a twenty-four hour a day basis. Additionally, employees are assigned to each area and are responsible for patrolling areas at least once a day to verify system operations. Operator logs are kept to verify day patrols have been conducted. Any irregularities in operating components are investigated immediately and necessary action taken to correct the problem.

Maintenance

Each area (acid plant, hydrometallurgical plant, matte storage area and sump, decontamination pad and sump and anode casting process area and Intermediate By-Products Storage Building) has been assigned personnel responsible for repair and maintenance of all equipment. Scheduling of maintenance activities is part of a comprehensive preventive and predictive maintenance program (PM). The Smelter maintenance program utilizes computer assisted preventive maintenance scheduling. For each piece of equipment, a PM schedule has been developed.

Tracking of the PM schedule, as well as the PM procedures, is done via a computerized maintenance program. The Smelter utilizes an information management system for scheduling maintenance tasks and compiling equipment, material and supply data. Based on information from the control system, feedback from operator inspections, and preset schedule inputs, the information management system assists maintenance planners in tracking and scheduling PMs. When a PM is due, the computer system triggers the PM process for a specific piece of equipment. The pumps and sumps are included in the information management system.

When a PM is due, the information management system triggers the process of scheduling the PM. Pre-established job procedures are printed out for the PM. Maintenance schedulers then assign an employee the responsibility of completing the PM.

After the PM is completed, the employee returns the signed PM checklist indicating the PM has been completed to the maintenance scheduler. Any items noted during the inspection that require additional repair are noted by the maintenance planner. A work order is then written for any additional repair work and the work will be scheduled. Any repair work not completed will be highlighted on a work order backlog. The work order tracking system should assure that proper and complete implementation of required repairs occur.

As previously mentioned, the pumping system components are included in a scheduled preventative and predictive maintenance (PM) program. Pumping system components include the pump, motor, inlet and outlet piping and pump fittings. The pumping system is inspected and

a PM conducted at a minimum of once every three months. The PM procedures for the pumping systems include changing lubricating fluids as needed, inspecting foundations and mounting assemblies, checking pump for excessive heat, noise, or vibration, inspecting piping for leaking and proper sealing and checking automatic level controls as required. The level controls will be checked manually to ensure the controls activate at the appropriate levels. Piping inspections are done on a visual basis. An example of a PM for a pump is provided as Attachment A.

Sumps in the acid plant, hydrometallurgical plant, anode casting process area, equipment decontamination and material processing pad, matte storage area, and Intermediate By-Products Storage Building are also included in the PM program and are tracked through the information management system. Via the information management system, sumps are scheduled for hydrostatic testing during planned shutdowns (or a minimum of once every three years, except for the decontamination pad which is tested annually). The inspection will consist of filling the sump with fresh water and monitoring the liquid level for a period of two hours (or longer if the equipment down-time allows). If the test indicates leakage, necessary corrective action is taken. An example of a PM for a sump is provided as Attachment A. A list of sumps and pumps in the hydrometallurgical plant, anode casting process area, acid plant, decontamination pad, and matte storage area is provided in Table 1.

PERFORMANCE CRITERIA

Housekeeping

Any spillage within the contained areas is designed to drain to sumps. Sumps that are equipped with automatically controlled pumps, will pump the sump contents to the appropriate location for use as a reagent. Sumps that are not equipped with automatically controlled pumps will activate a high level alarm. Upon indication of a high level, an operator is dispatched to investigate the problem and take appropriate corrective action.

The plant is designed to facilitate meeting strict housekeeping standards. Appropriately designed floor slopes, drains, and area containments are incorporated into the system. KUC housekeeping standards require prompt cleanup of spilled materials and areas are to be kept reasonably free of excess dirt, grease, and oil.

Spill Prevention/Spill Cleanup

The acid plant, hydrometallurgical plant and anode casting process area are included in the Emergency Response and Spill Prevention Control and Countermeasure Plans (SPCC) as required. The plans specify procedures to be followed for spill response and spill prevention. Spills are contained and cleaned up as quickly as possible.

Materials Handling

Various chemicals and reagents are used throughout the Smelter operations. The Occupational Safety and Health Administration (OSHA) requirements for Hazard Communications is enforced at the Kennecott Smelter. The purpose of the standard is to ensure that:

- Labels and/or appropriate warning concerning hazardous chemicals, as required by the standard, are in place.
- Material Safety Data Sheets (MSDS) are obtained and distributed such that they are readily available to employees working in areas where hazardous chemicals are used. KUC has developed a computerized MSDS system that expedites retrieval.
- Employees are informed and trained concerning hazardous chemicals and the Hazard Communication program.
- Employees are informed concerning non-routine tasks involving hazardous chemicals.
- Contractor employers are informed concerning hazardous chemicals to which their employees may be exposed while working at the Kennecott Smelter.

Tanks used for chemical storage are provided with secondary containment. Material transfer operations are conducted in such a manner as to minimize the potential for spillage. Through the Hazard Communication program, employees and contractors/vendors are trained to understand the proper methods for handling chemicals.

Chemicals are stored, in compatible containers and tanks. Containers are properly labeled with NFPA stickers. Drums are stored on pallets to minimize the potential for corrosion and to facilitate visual inspections. Storage racks, cabinets and tanks are provided secondary containments.

Housekeeping standards have been established for the principal purpose of ensuring consistent application of housekeeping throughout KUC. KUC facility standards require floors be washed at an interval necessary to keep them in a clean state. In areas where washing is not feasible, vacuum systems have been installed. Floors are kept as dry as possible to minimize potential for slips and falls. Hoses, brooms, squeegees and similar type of equipment are located in strategic areas to facilitate housekeeping. Spills are to be promptly contained and cleaned up.

Each employee at KUC is responsible for maintaining housekeeping standards. As part of the new hire orientation, housekeeping is reviewed with each new employee. Supervisors are responsible for conducting periodic housekeeping inspections and ensuring areas are kept clean.

Spill Reporting

A verbal report of any noncompliance, or spills subject to the provisions of UCA 19-5-114 which may endanger public health or the environment are made as soon as possible, but no later than twenty-four hours from the time KUC first became aware of the incident. The report will be made to the Utah Department of Environmental Quality 24 hour number, (801) 536-4123 or to the Division of Water Quality, Ground Water Protection Section at (801) 538-6146, during normal business hours.

A written report will be provided to the Executive Secretary within five days of the time that KUC becomes aware of the incident. The written submission will contain:

- a) A description of the noncompliance event and its cause;
- b) The period of noncompliance event, including exact dates and times;
- c) The estimated time noncompliance is expected to continue if it has not been corrected;
- d) Steps taken or planned to reduce, eliminate, and prevent reoccurrence of the noncompliance event.

Training

All new employees are given an overview of the KUC housekeeping requirements and SPCC plan elements. Supervisors and salaried employees are provided annual training on key environmental and safety policies and procedures including the SPCC plan and housekeeping standards.

For the Smelter operations, all personnel have undergone extensive training for the startup of the facilities. This training has been given to both hourly and salaried personnel.

KUC also encourages employee participation and suggestions in developing ways of improving operations from both safety, environmental and productivity perspectives. This process is part of KUC's ongoing commitment to continuous improvement in all areas of its operations.

Record keeping

Records which document compliance with the elements required in the BMP will be maintained for a minimum of three years. Copies of records are kept at the Smelter Record keeping Center or on a tape backup of the DCS and the information management system files.

TABLE 1
(Revised 1-7-99)
LIST OF EQUIPMENT
HYDROMETALLURGICAL PLANT

<u>PUMP</u>	<u>SUMP</u>	<u>AREA DESCRIPTION</u>
551-PP-715	551-ZM-715	Lime Storage Area
551-PP-716	551-ZM-716	Lime Area
551-PP-767	551-ZM-767	Copper Precipitation Area
551-PP-768	551-ZM-768	NaHS Storage Area
551-PP-791	551-ZM-791	Acid Leach Area
551-PP-792	551-ZM-792	Bismuth Precipitation Filter Area
551-PP-793	551-ZM-793	Bismuth Precipitation Thickener Area
551-PP-794	551-ZM-794	Copper Precipitation Filter Area
551-PP-795	551-ZM-795	Arsenic/Cadmium Precip. Thickener Area
551-PP-796	551-ZM-796	Iron Precipitation Reactor Area
551-PP-797	551-ZM-797	Refinery Bleeds Storage Area
551-PP-799	551-ZM-799	Lime Slaking Area
572-PP-810	572-ZM-810	Lime Unloading Area
572-PP-857	572-ZM-857	Caustic Tank Area

ANODE CASTING AREA

<u>PUMP</u>	<u>SUMP</u>	<u>AREA DESCRIPTION</u>
527-PP-265 & 266	527-TK-261	Anode Cooling Water Area

ACID PLANT

<u>PUMP</u>	<u>SUMP</u>	<u>AREA DESCRIPTION</u>
546-PP-509	546-ZM-509	FSG Area
546-PP-519	546-ZM-519	FCG Area
546-PP-649	546-SU-649	Strong Acid Area
546-PP-531	546-ZM-531	ESP Area
546-PP-672	546-SU-641	Backup Acid Cooling System

<u>PUMP</u>	<u>SUMP</u>	<u>AREA DESCRIPTION</u>
N/A	572-SU-001	Decontamination Pad
572-PP-893	572-SU-893	Matte Storage Pad
N/A	N/A	Material Storage Pads
N/A	572-SU-726	Intermediate By Products Building
N/A	572-SU-724	Intermediate By Products Building
N/A	572-SU-723	Intermediate By Products Building

APPENDIX B

BAT PERFORMANCE MONITORING PLAN FOR SMELTER FACILITIES WITH LEAK COLLECTION AND REMOVAL SYSTEMS

INTRODUCTION

The Kennecott Utah Smelter has been granted a Ground Water Discharge Permit (Permit No. UGW350008) by the State of Utah. This permit details the construction, operation, and monitoring requirements for the facilities at the Smelter that have the potential of releasing fluids to the ground water. The permit specifies that Best Available Technology (BAT) be used in the construction of all facilities and that facilities be operated according to Best Management Practices (BMP).

The permit lists fifteen individual facilities that have BAT criteria associated with them. This monitoring plan addresses the facilities that require leak collection and removal systems. These facilities and their BAT and performance criteria are listed in the table at the end of this section.

Each of the fifteen facilities consists of a concrete or HDPE sump or basin. Under the concrete structure is an HDPE lined sump with drain pipes sloped to a low point. At the low point there is a collection pipe to allow access to measure the level of liquid in the sump and to remove the liquid. The theory of operation is that if the concrete basin leaks, the fluid will be trapped in the drain field on top of the liner. When fluid is detected in the collection pipe, this is an indication that the basin is leaking. In each collection pipe a level detector has been installed. The level detector will signal an alarm in the Smelter central control room. Installations not connected to the Smelter control room will have a local strobe light installed to function as an alarm. Fluid can be removed from the collection pipe with portable pumps to maintain a low head of fluid on the liner. If leakage is discovered, the permit details required response actions.

The permit requires that the Smelter develop and follow a monitoring, inspection and maintenance plan for permitted facilities. In addition, it details what actions must be taken if a leak is detected or a system is out of compliance with the permit. This document describes the procedures required to comply with the Ground Water Discharge Permit for the fifteen facilities with leak collection and removal systems.

MONITORING, INSPECTION AND MAINTENANCE

Kennecott is responsible for implementing the best available technology, noted in the preceding table, to prevent discharge of process fluids from the permitted facilities to ground water. Maintenance of the performance standard will be demonstrated by operation and maintenance of the leak collection and removal systems and adherence to the performance criteria.

BAT Performance Monitoring

Inspection and Maintenance: Each system will be included in the Smelter Preventive Maintenance Program. The PM program requires that inspections and the PM requirements be performed quarterly.

Attached, under the Record keeping section, are checklist/forms for inspections of each facility and the PM requirements for the continuous water level alarms.

Monitoring Plan: The primary tool for monitoring the leak collection systems will be the continuous water level alarms in the leak collection sumps. These alarms will be monitored at the Smelter control room. Any alarms will be logged by the operators and the cause of the alarm investigated and documented.

Monitoring results will be documented on an alarm and leak removal form contained in this plan. Records will be kept according to criteria in the Record keeping section of this plan.

A summary of monitoring results will be reported to the Department of Water Quality on a semi-annual basis. This report will be due 45 days following the end of the reporting semester.

Leakage Rate Evaluation: To determine the leakage rate into a leak collection system, flow totalizers will be used to measure the amount of water pumped from the leak collection pipe over a given period of time. If the flow totalizer fails or is unable to be successfully read, the pump will be de-energized, a measurement taken and another measurement taken at a later time. Based upon the diameter of the pipe and quantity of water collected over a specific time period, a leakage rate will be calculated.

LEAK DETECTION AND REMOVAL PROCEDURES

Leak Detection

Leaks into the collection system will be detected by the continuous level alarms or by physical measurements taken during scheduled inspections. When a collection sump alarm is received at the Smelter control room, the operator will log the time on the alarm and dispatch the appropriate person to verify that the level alarm is working correctly and verify the level in the monitoring collection pipe. If the level in the collection pipe is in fact at the alarm level, leak response procedures will be implemented. If the cause of the high level alarm or leakage rate can be repaired within 24 hours of detection of the alarm condition, Kennecott is not obligated to undertake the Response to a Leak procedures in the following paragraph. If the alarm is not

valid, the alarm system will be repaired as soon as possible. Until the alarm is repaired, periodic measurements of the liquid level in the collection pipe will be taken and recorded.

Response to a Leak

Upon determination that the maximum fluid level specified in the permit has been exceeded, **and the cause of the elevated level has not been repaired within 24 hours**, the following actions are required:

- ▶ Sample the effluent from the collection system for water quality field and lab constituents. Results must be submitted to the State in the next semiannual report. Sample collection, analysis, and reporting will be the responsibility of the Environmental Department.
- ▶ Immediately remove fluid from the affected leak collection system to a level below the allowable maximum fluid level specified in the permit and determine the leakage rate entering the leak collection system. The fluid removed from the collection pipe should be discharged back into the basin. Plant personnel are responsible for implementing this action.
- ▶ Notify the Executive Secretary in writing within five days that a performance criteria has been exceeded and what the measured leakage rate in the affected leak collection system is. All communications with the State will be done by the Environmental Department.
- ▶ If the leakage rate is in excess of the maximum rate or level specified, Kennecott shall implement the approved leak detection and repair plan.
- ▶ Remove fluids from any affected leak collection system on a continuous basis to maintain fluid levels less than the specified maximum.

AREA RESPONSIBILITIES

Completion of the required actions in the permit are the responsibility of the following functional areas:

- ▶ The overall responsibility for compliance with the permit and auditing of required actions rests with the Smelter Environmental Facility Engineer and Smelter Management.
- ▶ Alarm monitoring is the responsibility of the Smelter Operations - Control Room Supervisor.
- ▶ Routine inspections are done by the Environmental Department.
- ▶ Compliance with the PM requirements is the responsibility of Smelter Operations and the Maintenance Service Provider.
- ▶ Leak response is the responsibility of Smelter Operations and the Maintenance Service Provider.

- ▶ Sampling, Analysis, and Reporting is the responsibility of the Environmental Department.

RECORD KEEPING

The Kennecott Environmental Record keeping Procedures is used for all records. Copies of the records are kept at the Smelter Record keeping Center and at the Environmental Record keeping Center. The following forms and procedures follow this section:

- ▶ Quarterly Inspection Form.
This form is used to document routine inspections of the facilities.

QUARTERLY PM REQUIREMENTS

All inspections and services performed on this equipment shall be done in accordance with accepted safety rules and formal procedures. Visually inspect this equipment for damage or problems which might cause unsafe operation.

Continuous Level Alarm

- 1) Notify the Control Room and advise that the leak detection system is being inspected.
Ask control Room if the system is in alarm on the DCS system
- 2) Remove the alarm cable
- 3) Invert the end of the cable, allowing the ball float to drop to the top of the probe.
- 4) Notify the Control Room to verify the alarm probe on the DCS screen
- 5) Drop the ball float to the bottom end of the probe.
- 6) Notify the Control Room to verify a normal mode on the DCS screen.
- 7) Inspect all mechanical and electrical components for proper operation.
- 8) Inspect all components for corrosion.
- 9) Take a flow totalizer reading or measure the water depth and record the reading and time.
Note: If water depth is measured, remove pumpcord from power source.
- 10) Take a second reading at least two hours later and record the current time.
Note: If a water depth was measured, be sure to re-energize power to the pump.
- 11) Replace all protective covers
- 12) Calculate gallons per minute (gpm) and record.

SMELTER PLANT - QUARTERLY INSPECTION
Leak Detection & Removal Systems - Summary Report

Quarter: _____ **Year:** _____ **Date:** _____

The following checks were made as part of this inspection:

1. Alarm Status was checked first at the EMC DCS consol to confirm "normal" status. Then the function of the alarm was checked by field activation with confirmation acknowledged by the control room.
2. Basin Status was checked by verifying if process materials were present and/or being pumped through the protected facility.
3. Liquid Depth was checked by opening the leak detection pump sump and measuring using Schill IT30 electron depth measure probe.
4. Visual Inspection was conducted to verify the condition and function of leak detection components.
5. Leakage Rate was calculated by verifying a "pump down" condition and then taking a beginning totalizer and time reading during initial inspection, with follow-up reading taken two to six hours later.
6. Wells with a "zero" leakage rate were confirmed by a "no change" manual measurement of well depth.

Leak Detection Facility (location)	DCS ID	Monitor Well No.	Alarm Status	Basin Status	Liquid Depth ft.	Leakage Rate in gpm	Comments (Visual Inspection)	Date Inspected	Inspected By
<i>West Process Ponds</i>									
West Cell (west)	572268	SMP732							
East Cell (east)	572267	SMP733							
Pump Sump (center)	572269	SMP731							
<i>East Process Ponds</i>									
North Cell (west)	572409	SMP1400							
South Cell (east)	572407	SMP1401							
Pump Sump (north)	572413	SMP1402							
<i>Pump House</i>									
Jacket Cooling Water (NW)	529008	SMP1409							
Granulation Water (NE)	529363	SMP1408							
Powerhouse/Furnace (SW)	529469	SMP1407							
Acid Plant (SE)	529414	SMP1406							
<i>Cooling Towers</i>									
Granulation (north)	529361	SMP1403							
Powerhouse (center)	529468	SMP1405							
Acid Plant (south)	529416	SMP1404							
<i>Others</i>									
Vehicle Wash	572176	SMP1410							
Vehicle Repair Wash Bay Sump	572177	SMP1411							

Inspection Report Completed By: _____

KENNECOTT SMELTER BAT AND PERFORMANCE CRITERIA CHART FOR FACILITIES WITH LEAK DETECTION AND REMOVAL SYSTEMS

FACILITY	BAT DESCRIPTION	INSPECTION AND MAINTENANCE	PERFORMANCE CRITERIA
West Process Water Pond	Two 60 mil HDPE liners with leak collection layer; pump back system to remove leakage and minimize head; 12" engineered subgrade with a hydraulic conductivity of no greater than 1×10^{-5} cm/sec; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 4 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
East Process Water Pond	Two 60 mil HDPE liners with leak collection layer; pump back system to remove leakage and minimize head; 12" engineered subgrade with a hydraulic conductivity of no greater than 1×10^{-5} cm/sec; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 4 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Granulation Cooling Tower Basin	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection ; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner
Acid Plant Cooling Tower Basin	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner
Powerhouse Cooling Tower Basin	Concrete basin with 60 mil HDPE underliner and leak collection and removal; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner

KENNECOTT SMELTER BAT AND PERFORMANCE CRITERIA CHART FOR FACILITIES WITH LEAK DETECTION AND REMOVAL SYSTEMS

Granulation Pumphouse Sump (NE)	Concrete basin with 60 mil HDPE underliner and leak collection and removal system; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Jacket Water Pumphouse Sump (NW)	Concrete basin with 60 mil HDPE underliner and leak collection and removal system; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Powerhouse/Furnace Pumphouse Sump (SW)	Concrete basin with 60 mil HDPE underliner and leak collection and removal system; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Acid Plant Pumphouse Sump (SE)	Concrete basin with 60 mil HDPE underliner and leak collection and removal system; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Vehicle Wash Station	Concrete basin with 60 mil HDPE underliner and leak collection and removal system; continuous pump back system; pipe spacing in leak collection system no greater than 10 feet	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower HDPE liner.
Vehicle Repair Shop Basin	Concrete basin with PVC underliner and leak collection and removal	Continuous water level alarm in leak collection sump; remove fluid from leak collection sump upon detection; flow rates into leak collection measured if leaking	No more than 2 gallons per minute entering leak collection system. Maintain less than 12 inches of fluid above elevation of lower PVC liner.

APPENDIX C

KENNECOTT UTAH COPPER CORPORATION LEAK DETECTION AND REPAIR PLAN

1. INTRODUCTION

The following procedures reflect the KUCC standard protocol for QA/QC and address the elements consistent with quality workmanship and liner integrity of the geomembrane. Should the performance criteria fluid level established in the BAT Performance Monitoring Plan (Appendix B) be exceeded, Kennecott will immediately remove fluid from the affected leak collection system to a level below the allowable maximum fluid level specified in the permit and determine the leakage rate entering the leak collection system. If the leakage rate is in excess of the maximum rate or level specified, Kennecott shall within seven (7) days initiate the identification of liner damage. During this time, Kennecott will remove fluids from any affected leak collection system on a continuous basis to maintain fluid levels less than specified maximum. Repairs will be completed within thirty (30) days or the pond will be taken out of service until repairs can be made.

2. DEFECTS AND REPAIRS

A. Earthwork

- Should damage to the subgrade below the liner be observed, the subgrade will be prepared to specifications suitable for installation of the liner.
- Surfaces to be lined shall be smooth and free of debris, roots, and angular or sharp rocks. All fill material shall be free of trash, organics and other deleterious material that could potentially cause damage to the geomembrane. The upper 6" of subgrade shall not contain material larger than 1/2".
- The subgrade shall be compacted to provide a firm unyielding foundation.

B. Repair Procedures

Any portion of the geomembrane or geomembrane seam showing a flaw, or failing a destructive or non-destructive test in non-compliance shall be repaired. Several procedures exist for repair and the decision as to the appropriate repair procedure shall be made by Kennecott's Project Manager. Options available for repair include the following:

- **Patching** used to repair large holes, tears, and destructive sample locations. All patches shall extend at least three inches (3") beyond the edges of the defect and all corners of patches shall be rounded.

- **Grinding and Welding** used to repair sections of extruded fillet seams.
- **Spot Welding or Seaming** used to repair small tears, pinholes, or other minor localized flaws.
- **Capping** used to repair lengths of extrusion or fusion welded seams. Extrude overlap along the length of fusion welded seams.
- Removal of a seam and replacement with a strip of new material seamed into place.

C. Verification of Repairs

Every repair shall be non-destructively tested. Testing protocol is based upon the method of repair. The following non-destructive testing procedures may be utilized.

- **Seam Testing** The welded seam created by the fusion welding process is composed of a primary seam and a secondary track that creates an unleaded channel. The presence of an unleaded channel permits the fusion seams to be tested by inflating the sealed channel with air to a predetermined pressure and observing the stability of the pressurized channel over time.
- **Pressure Testing**
 - Both ends of the seam to be tested will be sealed.
 - An approved pressure feed device will be fed into the sealed channel.
 - The test channel will be inflated and pressure maintained within the range listed below:

Material (Mill)	Min. PSI	Max PSI
40	24	30
60	27	35
80	30	35
100	30	35

- After 5 minutes, the pressure should be observed and recorded. If the loss of pressure exceeds 4 psi, pressure loss source should be identified and repaired.
- All cuts or needle holes through the liner, as a result of testing, will be repaired by extrusion bead or welding.

- **Vacuum Testing** This test is used on extrusion welds, or when the geometry of fusion weld makes air pressure testing impractical, or when attempting to locate the precise location of a defect believed to exist after air pressure testing.
 - Trim excess overlap from the seam.
 - Apply a generous amount of strong soapy solution to the area to be tested.
 - Place the vacuum box over the area to be tested and apply downward pressure to seat the seal strip against the liner.
 - Apply a minimum of 5 psi vacuum to the area.
 - For a period of approximately 10 seconds, examine the geomembrane through the viewing window for the presence of soap bubbles.

3. **DOCUMENTATION**

Repairs which pass the non-destructive test shall be deemed acceptable. Repairs in excess of 150 consecutive feet require destructive testing. Testing of repairs shall be recorded with information regarding the location or repairs, date of testing, time, weather conditions and name of technician performing the tests. Before and after photographs of the repaired liner will be collected.

4. **ASSESSMENT OF POTENTIAL LOSSES OF PROCESS WATER TO GROUNDWATER**

Complete an assessment of the potential for the loss of process water to ground water and an assessment of the potential impacts.

5. **REPORTING**

The QA/QC documentation information and the assessment of the potential impacts of the leak will be submitted to the Division of Water Quality (DWQ) as part of the Ground Water Discharge Permit Semi-Annual Report.