

August 2025

Environmental, Safety & Security Sequential Safety Meeting



ANACORTES REFINERY

ESS Safety Metrics



DSA Eligible	OSHA rec	ORIR	AFPM 1a/1p	H2S >50ppm	PSE 1 / 2	DEI 3/4	Permit dev
✓	1	0.11	0 / 5	2	0	0 / 1	17
	-	<0.30	-	≤3	≤3	≤1	≤34

- **ORIR:** OSHA Recordable Injury
- **Anacortes**
- 1 – Debris in eye needing prescription eye drops

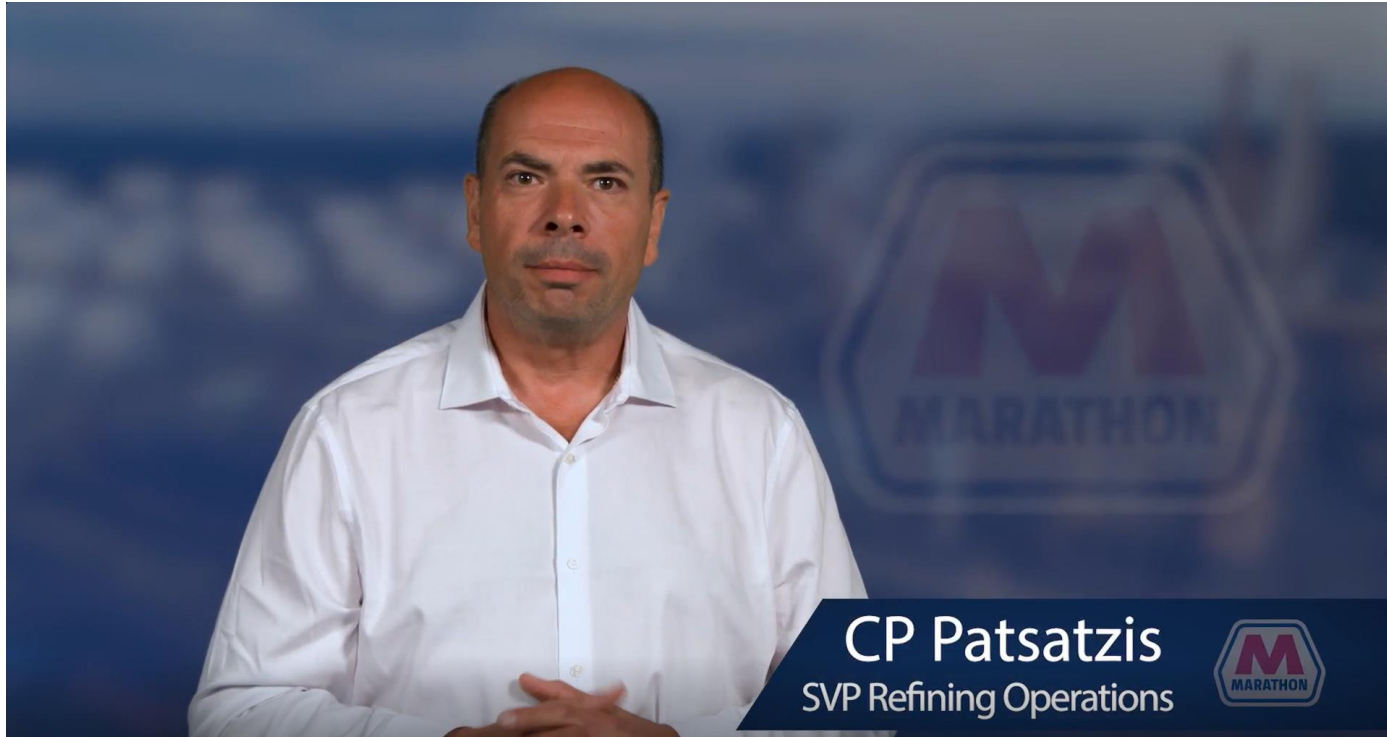
- **PSE:** Process Safety Event, refer to R-12-007
- **DEI:** Designated Environmental Incident, refer to R-13-027

- **AFPM 1a: Actual Incident** - serious injury that caused a fatality, hospitalization, or other life-altering event.
- **AFPM 1p: Potential Incident** - an incident with the potential for fatality, hospitalization, or other life-altering event, including near misses.

- **Anacortes**
- 1p - Fall Protection Not Utilized
- 1p - HVAC Electrical Spark
- 1p – GFCI Electrical Shock
- 1p – Grating/Handrail Removal Fall Hazard
- 1p – Energy Isolation Verification

CP Patsatzis

SVP Refining Operations



[Video Link](#)



Start Safe and Stay Safe: Joint Job Site Visits



Owning Department Representative Responsibilities

- Ensure the Servicing group understands site rules and expectations, hazards in the work area, and tasks planned for the day.
- Confirm the scope of work planned matches the equipment preparation already completed
- Ensure any work plans or JSAs match the scope of work on the permit

Servicing Group Representative Responsibilities

- Ensure the Owning Department understands the job requirements, including job steps, planning, and any other requirements
- Gather information about the work area prior to work beginning
- Verify the equipment preparation already completed matches the scope of work planned.
- The foreman, at the least, shall go out each morning to check the work planned

At least 1 member of the crew conducting the work must be part of the JJSV.

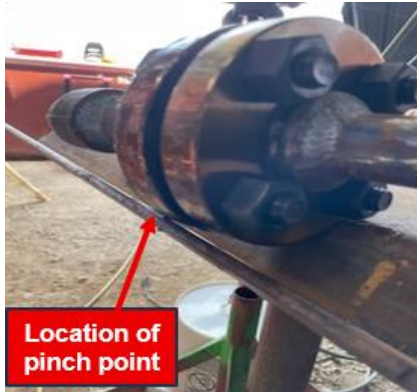
To ensure accurate communication, a JJSV attendee must be present at the job site during work

What questions should be asked during a JJSV?

- How long will the work take?
- Where will the permit hard copy be posted?
- What type of tools and equipment will be used?
- Are there any other workers that will come in at a later time?
- Where is the nearest eyewash/safety shower? Fire extinguisher? Evacuation location?
- Are any chemicals or hazardous substances going to be used (solvents, lubrication, etc)? SDS provided?
- What hazards exist on the job site?
- Has the Master Isolation List been checked against the isolations in the field?



Start Safe and Stay Safe:



← July 2025 – Employee received laceration requiring sutures when pipe positioned on fab table shifted

June 2024 – Employee tripped over uneven scaffold plank and experienced ruptured bicep tendon →



← June 2024 – Employee was utilizing rigging to remove a panel when tension released, pinching the hand between the panel and flange, resulting in a fractured index finger

February 2025 – Employee received fracture to pinky finger when using wrench to open a valve and wrench slipped →



Would you be able to recognize these hazards in a future JJSV?

Start Safe and Stay Safe: Engagement questions



There will be a JJSV on equipment in the area shown

- What questions or concerns would you bring up?
- How would you make the JJSV an effective process rather than a checkbox activity?
- What are some hazards that could be missed? What are the potential consequences of those hazards?
- How can we ensure all members of a JJSV have their concerns heard and addressed?

Neutralization Pond

- Penalty and News Release August 4th from Ecology
 - Penalty \$1,397,000 (DEI 4)
- In September 2024, we committed to remove the neutralization pond from service.
- In January 2025, we completed removal, and we are continuing to work closely with the Department of Ecology to finalize a formal closure plan.



Environmental POI: FE Tag Redbox

What to do?

When an LDAR valve is replaced, the yellow tag must be removed from the existing valve and placed in the FE Tag Redbox in the field ops centers. Please do not put the tag on the new valve.

Why?

All new valves are required to be monitored within 30 days of installation. When tags are found in the Redbox, this signals to Environmental that a valve has been replaced and will need an LDAR inspection. This is especially important for replacement in kind valves that are not tracked in an MOC.

Who is responsible?

The person who removes the old valve and tag is responsible for placing the FE tag in the Redbox. This could be maintenance, operations, or contract personnel.



Example of LDAR tag:



COMING SOON!

Anacortes 2025 Process Safety Culture



We are excited to have you involved with the 2025 Process Safety Culture Survey.

Your participation and feedback will not only make this a safer facility, but it will make it a more desirable place to want to come to every day.

As a way of saying thank you we will be holding a raffle at the completion of the survey process for employees.



Thank you in advance for completing the survey and for working together to help strengthen and improve our safety culture.

- Anacortes Process Safety Council

*Cameron Hunt, Jeremiah Harju,
Kyle Cassidy, Marc Ranieri,
Joel Vidmore, Bret Fritch, Rachael
Pletenik, John Carlson, Aaron
Eastwood, David Arellano, Joshua
Bertch, Myles Hulsey, Archie
Jorgensen, Ian Sewell
Trevor Smith, Clay Hathaway,
Trent Kies, Diane Rusher*

Everyone's Opinion Matters!

Anacortes 2025 Process Safety Culture



- Our last Survey was in 2022.
- The purpose of the survey is to use the results to help us better understand our process safety culture and identify actions for improving our process safety programs/culture
- We are aiming for 100% participation!
- This survey process is being managed by ISN, an independent consulting firm.
- The survey will be administered electronically, and the completed surveys will be handled directly by ISN for processing.
- No one in Anacortes will see any individual's completed survey response. **Please do not write your name or any name on the survey.**
- All Marathon employees will receive an email inviting you to participate in the survey and containing a hyperlink to the survey. Your supervisor will have a participation sticker that is also a raffle ticket.
- All Contractors will be scheduled to participate in the survey. This will take place at the Gate 20, PSM Trailer. Representatives from the Process Safety Council will help administer the survey.

Click on the link below for an introductory video about our upcoming Survey.

The survey will be administered from Tuesday, September 9th through Friday, October 3rd. Please complete and submit this survey by midnight Friday, October 3rd, 2025, at the latest.

<https://vimeo.com/1105499586?share=cop#t=0>

ST. PAUL PARK STEAM HOSE FAILURE RESULTING IN EMPLOYEE INJURY INC# 425074

PSA 25-06

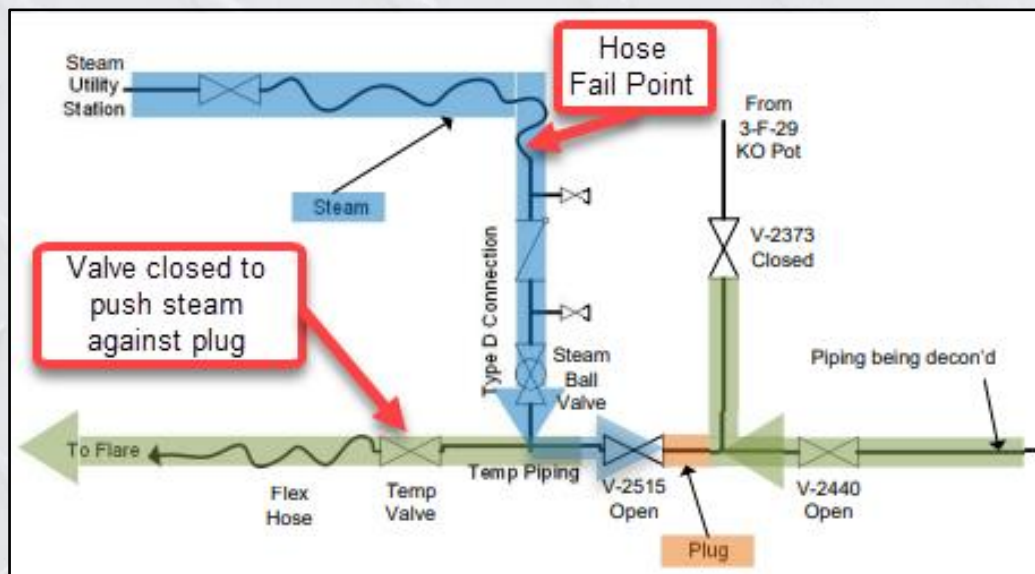
Published 7/16/2025

On April 14, 2024, Operators were decontaminating foul/sour water piping for the installation of a new sample station during the Spring Turnaround when the drain line plugged. Operators attempted to clear the line by using steam to push backwards against the plug. Within minutes of applying steam pressure (120 PSIG), the hose burst causing steam and condensate to impact one of the Operators performing the work.

- This incident was categorized as a PSE1 due to a LOPC resulting in an employee Days Away from Work injury.

Causal Factors:

- A manufacturer tagging system was adopted for steam hoses in 2021, but there was no documented plan on managing the service life of hoses within the refinery that predated this tagging system.
- There was no documented system/policy to audit steam hoses for condition and service life.



“THE REST OF THE STORY”: The SPP Refinery Policy (RSW-42-243-SP) for the Selection and Use of Hoses was modified in December of 2021. This modification adopted a maximum service time for all refinery hoses (2 -5 years depending on type). A tagging system was also adopted for new hoses but no such plan for the existing refinery hoses could be located. It could not be confirmed that training of site personnel occurred to ensure that the new policy was understood. This training was added to New Operator Training in 2024. Additionally, there was no plan to audit policy conformance, the policy relied primarily on pre-use visual inspection, and role/responsibilities were not assigned. An audit of the immediate area was completed following the incident and 15 hoses were found without tags, and 3 hoses had outdated tags (1 being a steam hose). The hose that was involved in the incident was disposed of prior to conducting this investigation, and no further information could be obtained.

- ☒ Operations
- ☒ Maintenance
- ☐ Engineering
- ☐ Technical



DISCUSSION TOPICS:

- Does your site policy for the selection and use of hoses have clear roles and responsibilities? When do you retire/replace hoses? What other policies or procedures might lack clarity on roles and responsibilities to ensure effective use?
- Steam hoses are pressure rated for 250 PSIG and manufacturer tested at 2500 PSIG (Reference SP 50-14 for more information).
- How effective are policy and procedure updates communicated? Is understanding adequately reinforced and confirmed? What ways could communication be improved?
- Are policy and procedure updates communicated in a way that ensures both existing employees and employees that will be onboarded after the change occurs are notified/trained?
- Are routine visual inspections documented, reinforced, and reviewed to ensure complacency or normalization doesn't set in?
- Are you aware of any ancillary and/or temporary equipment that may have outlived its service life?
- Is there anywhere where the attrition process is used to correct an identified problem over time instead of a planned/tracked system that monitors all corrections until there is complete turnover?
- Ensure all personnel are aware of the importance of collecting evidence after an incident occurs.

Global Action

Recommendations	Assigned to:	Due Date:
Review this advisory with your leadership team, and cascade to your entire organization to ensure site-wide review to improve process safety hazard recognition	Division Managers	10/31/2025
Update SP-50-14, Rubber and Corrugated Metal Hoses, to include a requirement for sites to have a local document that covers utility hose lifecycle management. Include a list of topics that should be addressed in the local document.	Mike Alford	1/31/2026
Develop a local site practice for hose management consistent with the revisions to SP-50-14 for utility hose lifecycle management. The local site practice must include an annual self audit that the program is implemented and effective.	Maintenance Managers	1/31/2027

EXAMPLE: CANTON REFINERY UTILITY HOSE SELECTION AND CONNECTION

Key steps for correct use:

- Identify the process utility type, pressure and temperature.
- Use the **hose selection guide** to identify the correct hose and fittings.
- Complete a visual **pre-use inspection** (no holes, cuts, bulges, cracks, etc.).
 - Verify the hose has not been in use for more than the allowed time using the inspection tag.
 - Place any hoses that **fail** inspection or have missing/expired tags into a collection bin for recertification (NOTES: Hoses must be clean. Alky hoses must be disposed of. Full bins go to warehouse).
- Connect the hose with a **check valve and bleeder** for a Type D Connection.
- Periodically **monitor** the hose for problems while in service.
- When task is complete, blow **hose clear** after use to remove any leftover material and to confirm dry.
- Disconnect, rollup, and **store** on a hose rack for the next user.

ORD Hose Selection Guide

Air Hose



Maximum work pressure = 300 psig
Design maximum temperature = 210°F
Stock Numbers:
• 50' 66100003
• Fitting: 66230003

Steam/Condensate Hose



Maximum work pressure = 250 psig
Design maximum temperature = 450°F
This hose is not to be used for 450# steam
Stock Numbers:
• 10' 66990008
• Fitting: 66990016

Nitrogen Hose



Maximum work pressure = 300 psig
Design maximum temperature = 180°F
Stock Numbers:
• 50' 66100002 • Fitting: QM103 66100062
• 100' 66230002 • Fitting: QM43 66100015
• Fitting: QM63 6610004 • Fitting: QM83 66100060

Water Hose



Maximum work pressure = 200 psig
Design maximum temperature = 210°F
Stock Numbers:
• 50' 66990025

Breathing Air Hose



Maximum work pressure = 300 psig
Design maximum temperature = 180°F
Stock Numbers:
• 25' 73990290
• 50' 73990203
• 100' 73990291

Fire Watch Hose



Maximum work pressure = 200 psig
Stock Numbers:
• 1.5" 66990084

Acid/Base Chemical Hose



Maximum work pressure = 200 psig
Design maximum temperature = 250°F
Stock Numbers:
• 50' 66990105
• 100' 66990106
• Fitting: 66230007

Alky Monel Hose



Maximum work pressure = 700 psig
Design maximum temperature = 820°F
Stock Numbers:
• 25' 66990153

Hydrocarbon Hose



Stock Numbers:
• 25' 45600005
A pressure derating factor applies in services above 300 P.

3 Year Service Life Tag



REMOVED FROM SERVICE
OCTOBER 2022

Manufacture Data Tag



ALL utility hoses shall be tagged from the manufacturer with maximum working pressure, maximum working temperature, and date of fabrication.

Hose Ramp



Stock Number: 65210001

3/4" T316 Annulus Application Guide

Temperature (Deg F)	Maximum Working Pressure
100	898
200	898
300	898
400	871
500	808
600	763
650	754
700	736
750	727
800	718
850	709
900	700
950	691
1000	691
1050	656
1100	557
1150	440
1200	332
1250	251
1300	189



Bring It Up!!!



If there are Safety questions or concerns you wish to discuss, please bring them up!