



ऑयल इंडिया लिमिटेड
(भारत सरकार का उद्यम)
Oil India Limited
(A Government of India Enterprise)

Onshore Oil & Gas Development drilling and production in Dumduma-Pengeri Area in Tinsukia District under PMLs namely Mechaki PML, Borhapjan PML , Dumduma PML and Digboi PML

Tinsukia District, Assam

Risk Assessment Report

10 February 2021

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Acronyms and Abbreviations

ALARP	As Low as Reasonably Possible
DG	Diesel Generator
DNV	Det Norske Veritas
DPA	Dumduma Pengeri Area
EGIG	European Gas Pipeline Incident Data Group
EIA	Environmental Impact Assessment
IMD	Indian Meteorological Department
ITOPF	International Tanker Owners Pollution Federation Limited
LEL	Lower Explosive Limit
MoEF&CC	Ministry of Environment, Forest and Climate Change
MoPNG	Ministry of Petroleum and Natural Gas
MSDS	Material Safety Data Sheet
MWP	Minimum Work Programme
NABL	National Accreditation Board for Testing and Calibration Laboratories
OGP	International Association of Oil & Gas Producers
OIL	Oil India Limited
OISD	Oil Industry Safety Directorate
PEL	Petroleum Exploration License
PPE	Personnel Protective Equipment
RA	Risk Assessment
UEL	Upper Explosive Limit

1. ADDITIONAL STUDIES

1.1 Risk Assessment

This section on Risk Assessment (RA) aims to provide a systematic analysis of the major risks that may arise 26 nos. of onshore drilling wells, 03 nos. of production installations and laying of oil and gas pipelines. The RA process outlines rational evaluations of the identified risks based on their significance and provides the outline for appropriate preventive and risk mitigation measures. Results of the RA provides valuable inputs into the overall project planning and the decision making process for effectively addressing the identified risks. This will ensure that the project risks stay below As Low As Reasonably Practicable (ALARP) levels at all times during project implementation. In addition, the RA will also help in assessing risks arising from potential emergency situations like a blow out and develop a structured Emergency Response Plan (ERP) to restrict damage to personnel, infrastructure and the environment.

The risk study for the onshore drilling and testing activities has considered all aspects of operation of the drilling rig and other associated activities during the development phase. Loss of well control / blow-out and process/pipeline leaks constitute the major potential hazards that may be associated with the proposed onshore development and production of oil and natural gas at the identified well locations within the Dumduma-Pengeri Area.

The following section describes objectives, methodology of the risk assessment study and then presents the assessment for each of the potential risk separately. This includes identification of major hazards, hazard screening and ranking, frequency and consequence analysis for major hazards. The hazards have subsequently been evaluated through a criteria based risk evaluation matrix. Risk mitigation measures to reduce significant risks to acceptable levels have also been recommended as a part of the risk assessment study.

1.2 Objectives of the RA Study

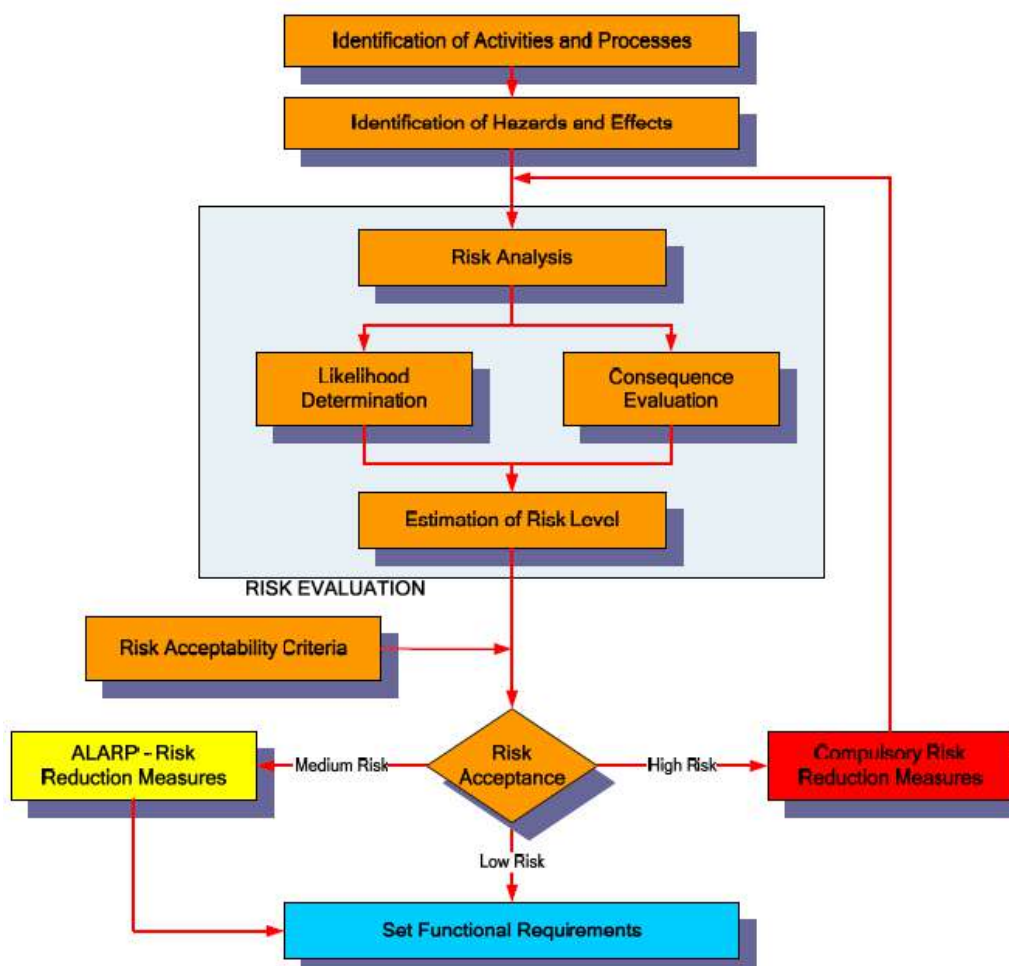
The overall objective of this RA with respect to the proposed project involves identification and evaluation of major risks, prioritizing risks identified based on their hazard consequences and formulating suitable risk reduction/mitigation measures in line with the ALARP principle. Hence in order to ensure effective management of any emergency situations (with potential individual and societal risks) that may arise during the exploration and development drilling activities, following specific objectives need to be achieved.

- Identify potential risk scenarios that may arise out of proposed development well drilling, operation of oil and gas pipelines and associated equipment's, mud chemicals storage and handling etc.
- Analyse the possible likelihood and frequency of such risk scenarios by reviewing historical accident related data for onshore oil and gas industries.
- Predict the consequences of such potential risk scenarios and if consequences are high, establish the same by through application of quantitative simulations.
- Recommend feasible preventive and risk mitigation measures as well as provide inputs for drawing up of Emergency Response Plan (ERP) for the Project.

1.3 Risk Assessment Methodology

The risk assessment process is primarily based on likelihood of occurrence of the risks identified and their possible hazard consequences particularly being evaluated through most probable and worst case accident scenarios. With respect to the proposed Project, the methodology adopted for risk assessment is summarized in **Figure 1.1**.

Figure 1.1 Risk Assessment Methodology



1.3.1 Hazard Identification

Hazard identification for the purposes of this RA comprised of a review of the Project and associated activity related information provided by OIL. In addition, guidance provided by knowledge platforms/portals of the upstream oil & gas industry including OGP, ITOPF, EGIG and DNV, Norwegian Petroleum Directorate etc. are used to identify potential hazards that can arise out of proposed Project activities. Considering the applicability of different risk aspects in context of the development drilling operations to be undertaken in the identified well locations, there are three major categories of hazards that can be associated with proposed Project. These includes:

- Blowouts leading to uncontrolled well flow, jet fires, flash fire from flammable cloud, pool fires;
- Non-process fires / explosions, the release of a dangerous substance or any other event resulting from a work activity which could result in death or serious injury to people within the site;

- Leaks from interconnecting pipeline network pipeline leading to jet fire; and
- Any event which may result in major damage to the structure of the rig

Well control incident covers a range of events which have the potential of leading to blow-outs but are generally controlled by necessary technological interventions. Hence, such incidents are considered of minor consequences and as a result not well documented. Other possible hazard scenarios like mud chemical spills, falls, etc. has also not been considered for detailed assessment as preliminary evaluation has indicated that the overall risk that may arise out of them would be low. In addition, it is understood that, causative factors and mitigation measures for such events can be adequately taken care of through exiting safety management procedures and practices of OIL.

It must also be noted here that many hazards identified are sometimes interrelated with one hazard often having the ability to trigger off another hazard through a domino effect. For example, a large oil spill in most instances is caused by another hazardous incident like a blowout or process leak. This aspect has been considered while drawing up hazard mitigation measures and such linkages (between hazards) has also been given due importance for managing hazards and associated risks in a composite manner through OIL's Health, Safety & Environmental Management System (HSEMS) and through the Emergency Response Plan, if a contingency situation so arises.

Other risks associated with the projects (i.e. apart from blowout) including environment security, drilling and associated activities, and handling & storage of drilling fluid and chemicals along with their mitigation measures has been provided in **Annexure 1**.

1.3.2 Frequency Analysis

Frequency analysis involves estimating the likelihood of each of the failure cases identified during the hazard identification stage. The analysis of frequencies of occurrences for the key hazards that has been listed out is important to assess the likelihood of such hazards to unfold during the lifecycle of the Project. The frequency analysis approach for the proposed Project is based primarily on historical accident frequency data, event tree analysis and judgmental evaluation. Major oil and gas industry information sources viz. statistical data, historical records and global industry experience were considered during the frequency analysis of the major identified risks¹.

For RA for the proposed Project, various accident statistics and published oil industry databases have been consulted for arriving at probable frequencies of identified hazards. However, taking into account the absence of representative historical data/statistics with respect to onshore operations², relevant offshore accident databases have been considered in the frequency analysis of identified hazards. The same has been recommended in the "*Risk Assessment Data Directory*" published by the International Association of Oil & Gas Producers (OGP). Key databases/reports referred as part of the RA study includes Worldwide Offshore Accident Databank (WOAD), Outer Continental Shelf (OCS) Reports, Norwegian Petroleum Directorate Directives, Offshore Reliability Data (OREDA) Handbook, HSE Offshore Incident Database, SINTEF Offshore Blowout Database etc.

Based on the range of probabilities arrived at for different potential hazards that may be encountered during the proposed well development activities, following criteria for likelihood rankings have been drawn up as presented in the **Table 1.1**.

¹It is to be noted that the frequency of occurrences are usually obtained by a combination of component probabilities derived on basis of reliability data and /or statistical analysis of historical data.

²Although Alberta Energy & Utilities Board (EUB) maintains a database for onshore incidents for the period 1975-1990 the same has not been considered in the context of the present study as the Alberta wells are believed to be sour with precaution being taken accordingly to minimize the likelihood of release

Table 1.1 Frequency Categories and Criteria

Likelihood Ranking	Criteria Ranking (cases/year)	Frequency Class
5	>1.0	Frequent
4	>10 ⁻¹ to <1.0	Probable
3	>10 ⁻³ to <10 ⁻¹	Occasional/Rare
2	>10 ⁻⁵ to <10 ⁻³	Not Likely
1	>10 ⁻⁶ to <10 ⁻⁵	Improbable

1.3.3 Consequence Analysis

In parallel to frequency analysis, hazard prediction / consequence analysis exercise assesses resulting effects in instances when accidents occur and their likely impact on project personnel, infrastructure and environment. In relation to the proposed Project, estimation of consequences for each possible event has been based either on accident experience, consequence modelling or professional judgment, as appropriate.

Given the high risk perception associated with blow outs in context of offshore drilling operation, a detailed analysis of consequences has been undertaken for blow outs considering physical factors and technological interventions. Consequences of such accidental events on the physical, biological and socio-economic environment have been studied to evaluate the potential of the identified risks/hazards. In all, the consequence analysis considers the following aspects:

- Nature of impact on environment and community;
- Occupational health and safety;
- Asset and property damage;
- Corporate image
- Timeline for restoration of environmental and property damage
- Restoration cost for environmental and property damage

The following criterion for consequence rankings (**Table 1.2**) is drawn up in context of the possible consequences of risk events that may occur during proposed well drilling and development activities:

Table 1.2 Severity Categories and Criteria

Consequence	Ranking	Criteria Definition
Catastrophic	5	<ul style="list-style-type: none"> ■ Multiple fatalities/Permanent total disability to more than 50 persons ■ Severe violations of national limits for environmental emission ■ More than 5 years for natural recovery ■ Net negative financial impact of >10 crores ■ Long term impact on ecologically sensitive areas ■ International media coverage ■ National stakeholder concern and media coverage
Major	4	<ul style="list-style-type: none"> ■ Single fatality/permanent total disability to one or more persons ■ Major violations of national limits for environmental emissions ■ 2-5 years for natural recovery ■ Net negative financial impact of 5 -10 crores ■ Significant impact on endangered and threatened floral and faunal species ■ Loss of corporate image and reputation
Moderate	3	<ul style="list-style-type: none"> ■ Short term hospitalization & rehabilitation leading to recovery ■ Short term violations of national limits for environmental emissions ■ 1-2 years for natural recovery ■ Net negative financial impact of 1-5 crores ■ Short term impact on protected natural habitats ■ State wide media coverage
Minor	2	<ul style="list-style-type: none"> ■ Medical treatment injuries ■ 1 year for natural recovery ■ Net negative financial impact of 0.5 - 1 crore ■ Temporary environmental impacts which can be mitigated ■ Local stakeholder concern and public attention
Insignificant	1	<ul style="list-style-type: none"> ■ First Aid treatment with no Lost Time Incidents (LTIs) ■ Natural recovery < 1year ■ Net negative financial impact of <0.5 crores. ■ No significant impact on environmental components ■ No media coverage

1.3.4 Risk Evaluation

Based on ranking of likelihood and frequencies, each identified hazard has been evaluated based on the likelihood of occurrence and the magnitude of consequences. Significance of risks is expressed as the product of likelihood and consequence of the risk event, expressed as follows:

$$\text{Significance} = \text{Likelihood} \times \text{Consequence}$$

The **Table 1.3** below illustrates all possible product results for five likelihood and consequence categories while the **Table 1.4** assigns risk significance criteria in four regions that identify the limit of risk acceptability. Depending on the position of intersection of a column with a row in the risk matrix, hazard prone activities have been classified as low, medium and high thereby qualifying a set of risk reduction / mitigation strategies.

Table 1.3 Risk Matrix

Consequence ↑	Likelihood →						
			Frequent	Probable	Remote	Not Likely	Improbable
			5	4	3	2	1
	Catastrophic	5	25	20	15	10	5
	Major	4	20	16	12	8	4
	Moderate	3	15	12	9	6	3
	Minor	2	10	8	6	4	2
	Insignificant	1	5	4	3	2	1

Table 1.4 Risk Criteria and Action Requirements

Risk Significance	Criteria Definition & Action Requirements
High (16 - 25)	“Risk requires attention” – Project HSE Management need to ensure that necessary mitigation are adopted to ensure that possible risk remains within acceptable limits
Medium (10 – 15)	“Risk is tolerable” – Project HSE Management needs to adopt necessary measures to prevent any change/modification of existing risk controls and ensure implementation of all practicable controls.
Low (5 – 9)	“Risk is acceptable” – Project related risks are managed by well-established controls and routine processes/procedures. Implementation of additional controls can be considered.
Very Low (1 – 4)	“Risk is acceptable” – All risks are managed by well-established controls and routine processes/procedures. Additional risk controls need not to be considered

1.4 Identified Project Hazards

A comprehensive risk assessment study has been undertaken to assess and evaluate significance of identified risks in terms of severity of consequences and likelihood of occurrence. Three major categories of risks are identified in relation to proposed development Project as summarized below:

1.4.1 Blow Outs/Loss of Well Control

Blow out is an uncontrolled release of well fluid (primarily hydrocarbons viz. oil and/or gas and may also include drilling mud, completion fluid, water etc.) from an exploratory or development well. Blow outs are the result of failure to control a kick and regain pressure control and are typically caused by

equipment failure or human error. The possible blow out cause events occurring in isolation or in combination have been listed below:

- Formation fluid entry into well bore;
- Loss of containment due to malfunction (viz. wire lining);
- Well head damage (e.g., by fires, storms, dropped object etc.); and
- Rig forced off station (e.g., by anchor failure) damaging Blow Out Preventer (BOP) or wellhead.

The most common cause of blow out can be associated with the sudden/unexpected entry/release of formation fluid into well bore that may arise as a result of the following events as discussed in the **Box 1.1** below:

Box 1.1 Primary Causes of Blow Outs

Shallow gas

In shallow formations there may be pockets of shallow gas. In these instances, there is often insufficient mud density in the well and no BOP is in place. If the hole strikes shallow gas the gas may be released on the drilling rig very rapidly. Typical geological features which suggest the presence of shallow gas can then be detected. Historically, striking of shallow gas has been one of the most frequent causes of blowouts in drilling.

Swabbing

As the drill pipe is pulled upwards during trips out of the hole or upward movement of the drill string, the pressure in the hole beneath the drill bit is reduced, creating a suction effect. Sufficient drilling mud must be pumped down-hole to compensate for this effect or well fluids may enter the bore. Swabbing is also a frequent cause of drilling blowouts.

High formation pressure

Drilling into an unexpected zone of high pressure may allow formation fluids to enter the well before mud weight can be increased to prevent it.

Insufficient mud weight

The primary method of well control is the use of drilling mud; in correct operation, the hydrostatic pressure exerted by the mud prevents well fluids from entering the well bore. A high mud weight provides safety against well fluids in-flows. However, a high mud weight reduces drilling speed, therefore, mud weight is calculated to establish weight most suitable to safely control anticipated formation pressures and allows optimum rates of penetration. If the required mud weight is incorrectly calculated, then well fluid may be able to enter the bore.

Lost Circulation

Drilling mud circulation can be lost if mud enters a permeable formation instead of returning to the rig. This reduces the hydrostatic pressures exerted by the mud throughout the well bore and may allow well fluids from another formation to enter the bore.

Gas cut mud

Drilling fluids are denser than well fluids; this density is required to provide the hydrostatic pressure which prevents well fluids from entering the bore. If well fluids mix with the mud, then its density will be reduced. As mud is circulated back to surface, hydrostatic pressure exerted by the mud column is reduced. Once gas reaches surface it is released into the atmosphere.

Source: A Guide to Quantitative Risk Assessment for Offshore Installations; John Spouge – DNV Technical Publication 99/100a

For better understanding, causes of blow outs have been systematically defined in terms of loss of pressure control (failure of primary barrier), uncontrolled flow of fluid or failure of secondary barrier (BOP). The blow out incidents resulting from primary and secondary failures as obtained through

comprehensive root cause analysis of the Gulf Coast (Texas, OCS and US Gulf of Mexico) Blow Outs¹ during 1960-1996 have been presented in the **Table 1.5** below.

Table 1.5 Blow Out Cause Distribution for Failures - Drilling Operations

Sl. No.	Causal Factors	Blow Out Incidents (Nos.)
A.	Primary Barrier	
1	Swabbing	77
2	Drilling Break	52
3	Formation breakdown	38
4	Trapped/expanding gas	09
5	Gas cut mud	26
6	Low mud weight	17
7	Wellhead failure	05
8	Cement setting	05
B.	Secondary Barrier	
1	Failure to close BOP	07
2	Failure of BOP after closure	13
3	BOP not in place	10
4	Fracture at casing shoe	03
5	Failure to stab string valve	09
6	Casing leakage	06

Thus, underlying blowout causes as discussed in the above table can be primarily attributed to swabbing as the primary barrier failure which is indicative of insufficient attention given to trip margin and controlling pipe movement speed. Also, it is evident from the above table that lack of proper maintenance, operational failures and absence of BOPs as secondary barrier contributed to majority of blowout incidents (approx. 30 nos.) is recorded.

Blowout Frequency Analysis

Blow out frequency estimates is obtained from a combination of incident experience and associated exposure in an area over a given period. For the purpose of calculation of blow out frequency analysis in context of the present study involving developmental drilling, blow out frequencies per well drilled have been considered.

For onshore operations, comparable data were not found hence offshore data presented here, the fraction of subsea releases compiled by DNV have been considered for frequency analysis. Based on the given frequency and information provided by OIL on the proposed project drilling program the blow out frequency for the proposed Project has been computed as follows:

¹ "Trends extracted from 1200 Gulf Coast blowouts during 1960-1996" – Pal Skalle and A.L Podio

No of wells to be drilled per year = 9(A)

Blow out frequency for drilling (oil) = 2.62×10^{-5} per well drilled (B)

Blow out frequency for drilling (gas) = 2.16×10^{-5} per well drilled (C)

Frequency of blow out occurrence for (oil) = $(A \times B) = 9 \times 2.62 \times 10^{-5}$
= 2.35×10^{-4} per well drilled

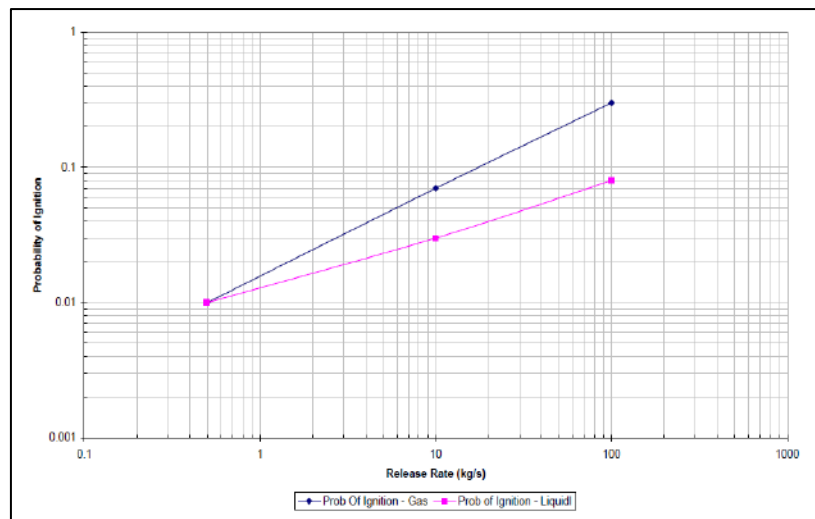
Frequency of blow out occurrence for development (gas) = $(A \times C) = 9 \times 2.16 \times 10^{-5}$
= 1.94×10^{-4} per well drilled

Thus, the blow out frequency for the proposed project for oil and gas wells have been at **2.35×10^{-4} and 1.94×10^{-4} per well drilled per year respectively i.e., the likelihood of its occurrence is identified to be as “Not Likely”.**

1.4.1.1 Blowout Ignition Probability

Review of SINTEF database indicates that a rounded ignition probability of 0.3 has been widely used for the purpose of risk analysis arising from blow outs. As per this database generally ignition occurred within first 5 minutes in approximately 40% of the blowouts leading to either pool and/or jet fire. Blow out leading to flammable gas release has a greater probability of ignition compared to liquid releases¹ (Figure 1.2).

Figure 1.2 Ignition Probability Vs Release Rate



An alternative to the blowout ignition probabilities given by the UKOOA look-up correlations can be obtained from Scandpowers's interpretation of the blowout data provided by SINTEF 2. The most significant category is that for deep blowouts which indicates an early ignition probability of 0.09. For the purpose of the RA study this can be taken as occurring immediately on release and calculation provided below:

¹Fire and Explosion – Fire Risk Analysis by Daejun Change, Division of Ocean System and Engineering

No of wells to be drilled per year = 9 (A)

Blow out frequency for drilling (oil) = 2.62×10^{-5} per well drilled (B)

Blow out frequency for drilling (gas) = 2.16×10^{-5} per well drilled (C)

Blow out ignition probability = 0.09 (D)

Probability of Blow out ignition for drilling (oil) = $(A \times B \times D) = 9 \times 2.62 \times 10^{-5} \times 0.09$
 $= 2.12 \times 10^{-5} = \sim 0.0021\%$

Probability of Blow out ignition for drilling (gas) = $(A \times C \times D) = 9 \times 2.16 \times 10^{-5} \times 0.09$
 $= 1.74 \times 10^{-5} = \sim 0.0017\%$

Hence based on the aforesaid calculation the probability of ignition of blow out releases of hydrocarbons for the proposed development project for both oil and gas is computed to be around 2.12×10^{-5} ($\sim 0.0021\%$) and 1.74×10^{-5} (0.0017%) and can be “**Not Likely**”.

1.4.1.2 Blowout Consequence Analysis

Blow out from a hydrocarbon development wells may lead to the following possible risk consequences:

- Jet fires resulting from ignited gas blow outs; and
- Oil slicks resulting from un-ignited oil pools.

Pool fire

A pool fire is a turbulent diffusion fire burning above a pool of vaporizing hydrocarbon fuel where the fuel vapour has negligible initial momentum. The probability of occurrence of pool fires for oil and gas exploration is high due to continuous handling of heavy hydrocarbons. The evaporation of hydrocarbons from a pool forms a cloud of vapour above the pool surface which, on ignition, leads to generation of pool fire.

For the purpose of consequence modelling for pool fires resulting from blow outs, following hypothetical scenarios in terms of hydrocarbon (particularly crude oil) release rates (**Table 1.6**) have been considered based on DNV Technica’s FLARE program.

Table 1.6 Pool Fire Modelling Scenario

Scenario	Release Rate (kg/s)	Release Type
Scenario - I	1	Small
Scenario - II	10	Medium
Scenario – III (Worst Case)	50	Large

The release rates as specified for the aforesaid scenarios have been utilized in the computing the pool fire diameter utilizing the following equation and input parameters:

$$D = \sqrt{4Q/\pi b}$$

Where D = pool diameter (m)

Q = release rate (kg/s)

b = burning rate (kg/m²s)

The mass burning rate for crude oil has been considered to be 0.05 kg/m²s

Based on above equation, the pool fire diameter and the steady study burning areas computed for various release types have been presented in the **Table 1.7** below.

Table 1.7 Pool Fire Diameter & Steady State Burning Scenario

Scenario	Release Rate (kg/s)	Release Type	Pool fire diameter (m)	Steady State Burning Area (m ²)
Scenario - I	1	Small	5.05	6.37
Scenario - II	10	Medium	15.96	63.69
Scenario - III	50	Large	35.69	318.47

The impact zone for long duration fires is conveniently described by thermal radiation contours and its effects on the people who are exposed to such radiation levels for one minute (60sec). The thermal radiation threshold values (measured in kilowatts per square meter) defined for crude oil pool fire consequence modelling is provided in **Table 1.8** below:

Table 1.8 Thermal Radiation Intensity Threshold Values Impact Criterion

Threshold Radiation Intensity	Threat Zone	Impact Criterion
5.0 kW/m ²	Green	<ul style="list-style-type: none"> ■ Escape actions within one minute. ■ Cause second degree burns within 60 sec.
12.5 kW/m ²	Blue	<ul style="list-style-type: none"> ■ Escape actions lasting for few seconds. ■ Cause second degree burns within 40 sec.
37.5 kW/m ²	Red	<ul style="list-style-type: none"> ■ Results in immediate fatality. ■ Pain threshold is instantaneous leading to second degree burns within 8 sec.

For estimating the distance to a pool fire heat radiation level that could cause second degree burns and fatality for a maximum exposure of 60 sec the following EPA equation and input parameters are utilized.

$$X = H_c \sqrt{\frac{0.0001A}{5000 \Pi (H_v + C_p (T_B - T_A))}}$$

Where:

- X = distance to the heat radiation level (m)
- HC = heat of combustion of the flammable liquid (joules/kg)
- HV = heat of vaporization of the flammable liquid (joules/kg)
- A = pool area (m²)
- CP = liquid heat capacity (joules/kg-°K)
- TB = boiling temperature of the liquid (°K)
- TA = ambient temperature (°K)

For crude oil **HC = 42600000 joules/kg; HV = 957144 joules/kg; CP = 1892 joules/kg-°K; TB = 633 °K and TA = 300 °K**. The following input parameter along with pool area (m²) computed for blow out

risk scenarios provided the distance to the threshold heat radiation levels for the threat zones and have been presented in **Table 1.9** below:

Table 1.9 Distance to Thermal Radiation Threshold Levels

Release Type	Pool fire diameter (m)	Pool fire area (m ²)	Distance to 5.0 kW/m ² (m)	Distance to 12.5 kW/m ² (m)	Distance to 37.5 kW/m ² (m)
Small	5.05	6.37	6.81	4.31	2.49
Medium	15.96	63.69	21.54	13.62	7.86
Large	35.69	318.47	48.16	30.46	17.59

The worst hazard for release and ignition of crude oil at a rate of **50kg/s** for a thermal radiation intensity of **37.5 kW/m²** is likely to be experienced to a maximum distance of **17.59m** from the source with potential lethal effects experienced within 8 sec.

Risk Ranking – Blowout Pool Fire (Worst Case Scenario)

Likelihood ranking	3	Consequence ranking	4
Risk Ranking & Significance = 12 i.e. “Medium” i.e. Risk is Tolerable and can be managed through adoption of necessary controls.			

Ignition of Flammable Gas Release leading to Jet Fire

Jet fires are burning jet of gas or sprays of atomized liquids resulting from gas and condensate release from high pressure equipment and blow outs. Jet fires may also result in the release of high pressure liquid containing dissolved gas due to gas flashing off and turning the liquid into a spray of small droplets. In context of the present study, formation of jet fires can be attributed by the high pressure release and ignition of natural gas if encountered during exploration of block hydrocarbon reserves.

Natural gas as recovered from underground deposits primarily contains methane (CH₄) as a flammable component, but it also contains heavier gaseous hydrocarbons such as ethane (C₂H₆), propane (C₃H₈) and butane (C₄H₁₀). Other gases such as CO₂, nitrogen and hydrogen sulfide (H₂S) are also often present. Methane is typically 90 percent, ethane 5-15 percent, propane and butane, up to 5 percent. Thus, considering higher percentage of methane in natural gas, the thermo-chemical properties of the same has been utilized in the jet fire blow out consequence modelling. The following risk scenarios (**Table 1.10**) have been considered for nature gas release consequence modelling:

Table 1.10 Natural Gas Release/Flammable Vapour Cloud Formation Modelling Scenario from Blow Outs

Scenario	Release Rate (kg/s)	Release Type
Scenario - I	1	Small
Scenario - II	5	Medium
Scenario – III	10	Large
Scenario – IV	310	Worst Case

The modelling of nature gas releases has been carried out using ALOHA. A Flammable Level of Concern approach has been utilized for assessing safety risk associated with the release of flammable gases (here methane) from well blow outs. In ALOHA, a flammable Level of Concern

(LOC) is a threshold concentration of fuel in the air above which a flammability hazard may exist. While modelling the release of a flammable gas that may catch fire—but which is not currently burning—ALOHA can predict the flammable area of the vapour cloud so that flammability hazard can be established.

The flammable area is the part of a flammable vapor cloud where the concentration is in the flammable range, between the Lower and Upper Explosive Limits (LEL and UEL). These limits are percentages that represent the concentration of the fuel (that is, the chemical vapor) in the air. If the chemical vapor comes into contact with an ignition source (such as a spark), it will burn only if its fuel-air concentration is between the LEL and the UEL—because that portion of the cloud is already pre-mixed to the right mixture of fuel and air for burning to occur. If the fuel-air concentration is below the LEL, there is not enough fuel in the air to sustain a fire or an explosion—it is too lean. If the fuel-air concentration is above the UEL, there is not enough oxygen to sustain a fire or an explosion because there is too much fuel—it is too rich.

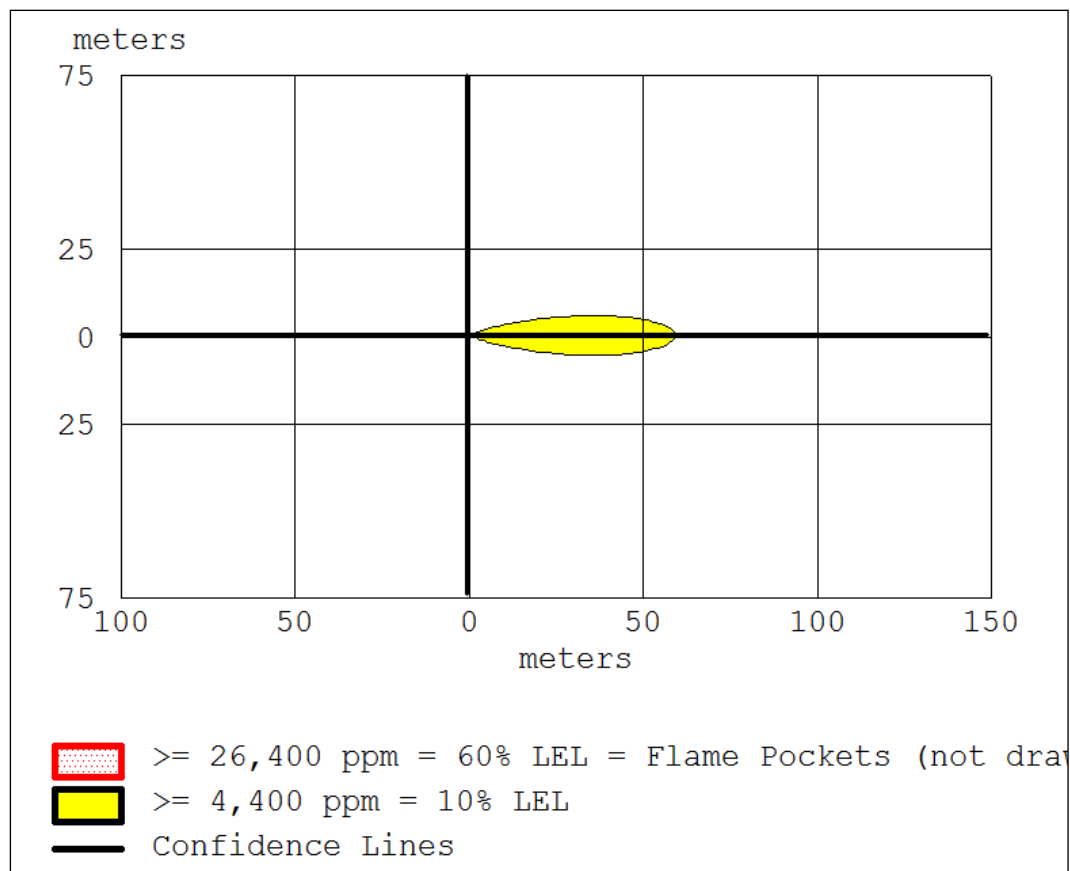
When a flammable vapor cloud is dispersing, the concentration of fuel in the air is not uniform; there will be areas where the concentration is higher than the average and areas where the concentration is lower than the average. This is called concentration patchiness. Because of concentration patchiness, there will be areas (called pockets) where the chemical is in the flammable range even though the average concentration has fallen below the LEL. Because of this, ALOHA's default flammable LOCs are each a fraction of the LEL, rather than the LEL itself. ALOHA uses 60% of the LEL as the default LOC for the red threat zone, because some experiments have shown that flame pockets can occur in places where the average concentration is above that level. Another common threat level used by responders is 10% of the LEL, which is ALOHA's default LOC for the yellow threat zone. The flammable LOC threat zones for methane release are as follows:

Red : 26,400 ppm = 60% LEL = Flame Pockets

Yellow: 4,400 ppm = 10% LEL

Well site risk contour maps for worst case scenario prepared based on ALOHA modelling of natural gas releases for flammable vapour cloud has been presented in **Figures 1.3-1.5** below.

Figure 1.3 Scenario I: Risk Contour Map



THREAT ZONE:

Threat Modelled: Flammable Area of Vapor Cloud

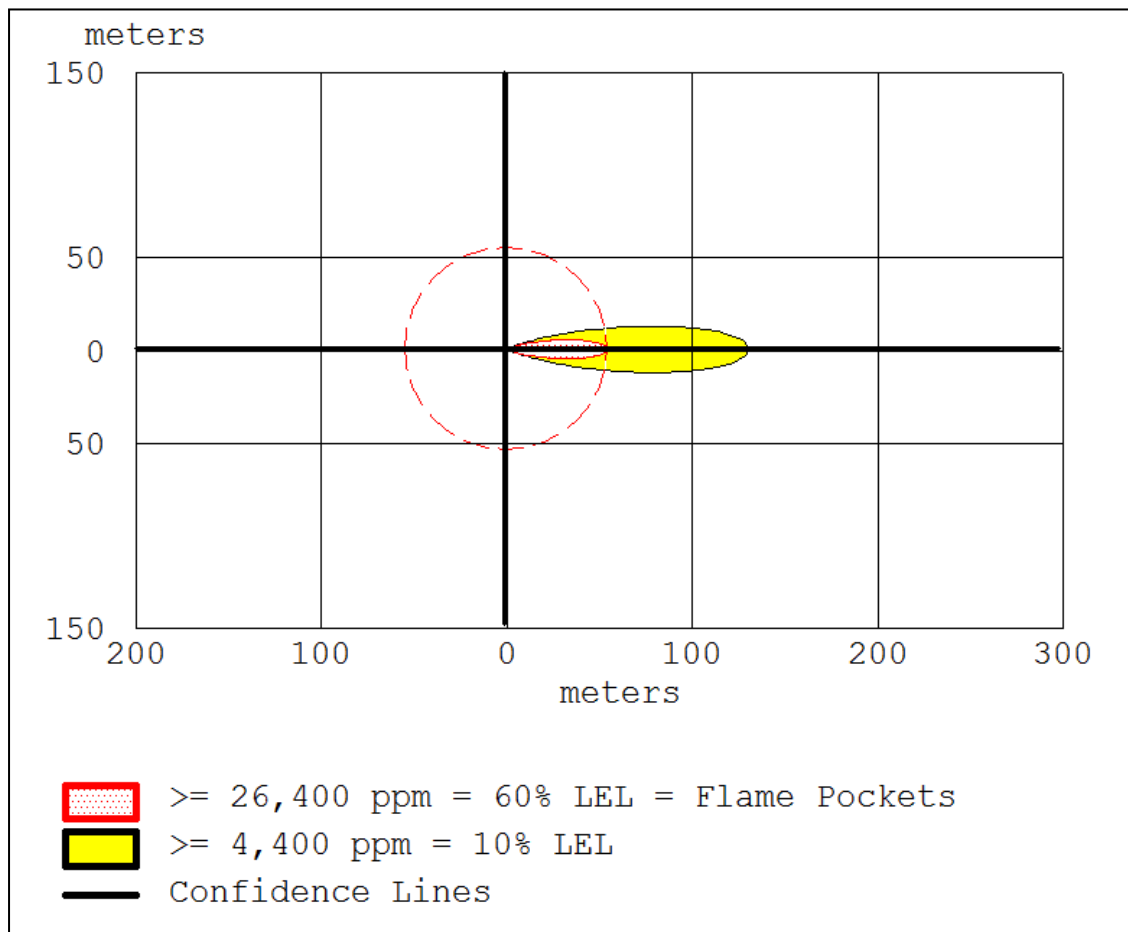
Model Run: Gaussian

Red : 25 meters --- ($26,400$ ppm = 60% LEL = Flame Pockets)

Note: Threat zone was not drawn because effects of near-field patchiness make dispersion predictions less reliable for short distances.

Yellow: 60 meters --- ($4,400$ ppm = 10% LEL)

Figure 1.4 Scenario II: Risk Contour Map



THREAT ZONE:

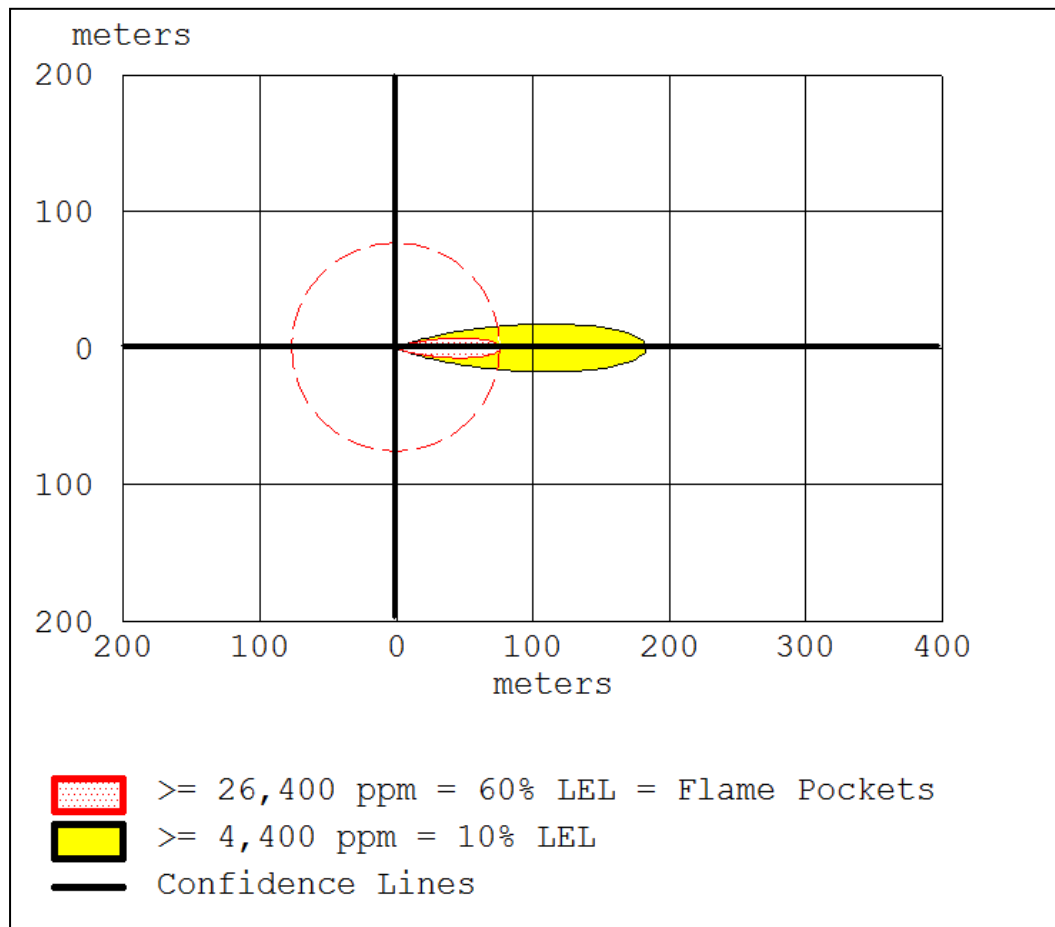
Threat Modeled: Flammable Area of Vapor Cloud

Model Run: Gaussian

Red : 55 meters --- (26,400 ppm = 60% LEL = Flame Pockets)

Yellow: 131 meters --- (4,400 ppm = 10% LEL)

Figure 1.5 Scenario III: Risk Contour Map



THREAT ZONE:

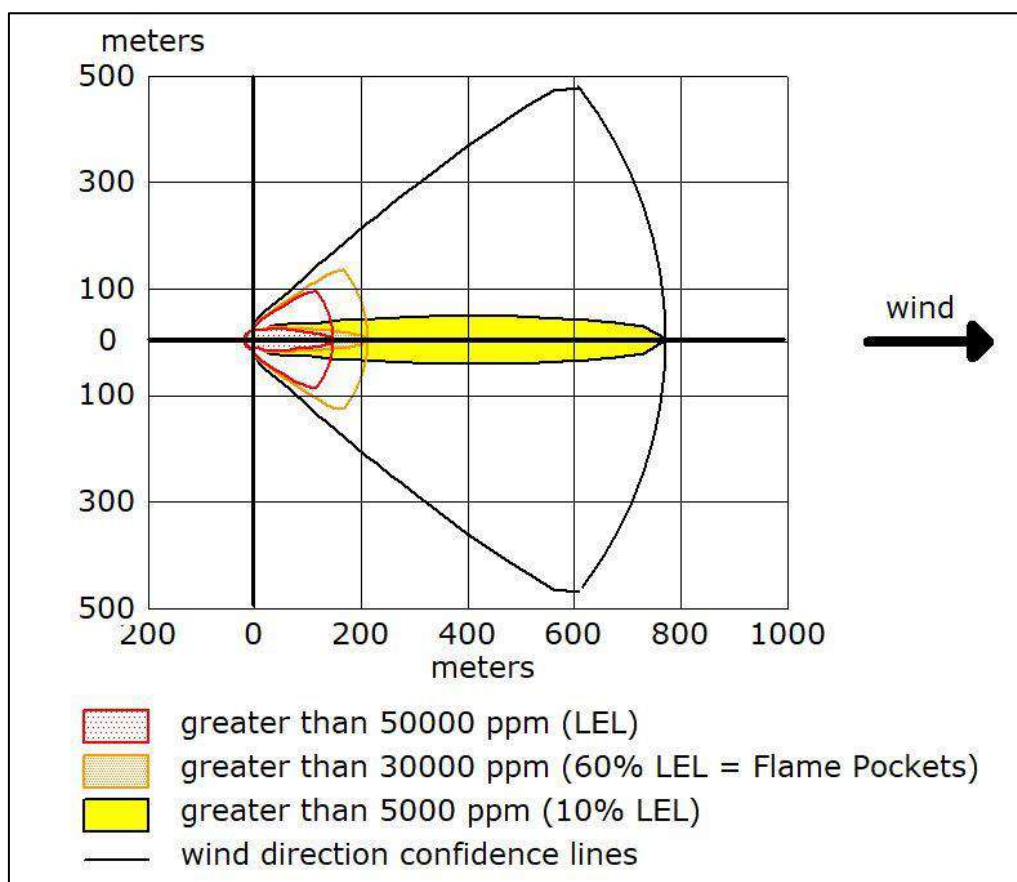
Threat Modelled: Flammable Area of Vapor Cloud

Model Run: Gaussian

Red : 77 meters --- (26,400 ppm = 60% LEL = Flame Pockets)

Yellow: 183 meters --- (4,400 ppm = 10% LEL)

Figure 1.6 Scenario IV: Risk Contour Map



THREAT ZONE:

Threat Modelled: Flammable Area of Vapour Cloud

Model Run: Gaussian

Red : 148 meters --- (50000 ppm = LEL)

Orange : 214 meters --- (30000 ppm = 60% LEL = Flame Pockets)

Yellow: 774 meters --- (5000 ppm = 10% LEL)

The zone of flammable vapour cloud calculated for hypothetical natural gas release under risk scenarios discussed in the earlier sections have been presented in the **Table 1.11** below.

Table 1.11 Zone of Flammable Vapour Cloud-Natural Gas Release Scenarion

Release Type	Release Rate (kg/s)	Red -60% LEL (m)	Orange	Yellow -10% LEL (m)
Small	1	25		65
Medium	5	55		131
Large	10	77		183
Worst Case	310	148 (LEL)	214 (60% LEL)	774

Hence for a worst case scenario the flammable vapour cloud zone/flame pockets' resulting from accidental release of natural gas due to blow out will be resulting in LEL concentration of 50,000 ppm at 148 m from source with the flammable gas concentration within this zone being 50,000 ppm i.e. LEL. For methane, the explosive limit ranges from 5% volume i.e. LEL to 15% by volume (which is the upper explosive limit). In the present worst case scenario modelled, the explosive range falls within 57 to 148 m.

Based on the flammable vapour cloud concentration modelled for the worst case scenario an effort was made to establish the overpressure (blast force zone) that may result from delayed ignition of vapour cloud generated from any such accidental release. For overpressure risk modelling using ALOHA a delayed ignition time of 5 minutes was considered of the vapour cloud mass. However the threat modelled revealed that Level of Concern (LOC) was never exceeded that may possibly lead to damage to property or life within the blast radius. The results have been provided in **Figure 1.7** below.

Figure 1.7 Scenario III (Worst Case) – Overpressure Risk Modelling

```
Threat Modeled: Overpressure (blast force) from vapor cloud explosion
Time of Ignition: 5 minutes after release begins
Type of Ignition: ignited by spark or flame
Level of Congestion: uncongested
Model Run: Gaussian
Explosive mass at time of ignition: 188 kilograms
Red : LOC was never exceeded --- (8.0 psi = destruction of buildings)
Orange: LOC was never exceeded --- (3.5 psi = serious injury likely)
Yellow: LOC was never exceeded --- (1.0 psi = shatters glass)
```

The risk significance for the potential blow out scenario resulting from development drilling has been presented below. For calculating the risk significance, the likelihood ranking is considered to be “2” as the frequency analysis for blow outs incidents is computed at “ $\sim 10^{-5}$ ” whereas the consequence ranking has been identified to be as “4” given the worst case scenario modelling (blast overpressure) indicates that the LOC was never exceeded leading to multiple fatalities (For criteria ranking please refer to **Table 1.1 & 7.2**).

Risk Ranking – Blowout Natural Gas Release Overpressure (Worst Case Scenario)

Likelihood ranking	2	Consequence ranking	4
Risk Ranking & Significance = 8 i.e. “Low” i.e. Risk is Acceptable and are managed by well-established controls and routine processes/procedures. Implementation of additional controls can be considered, as may be required.			

1.4.2 Hydrocarbons Leaks Due to Loss of Containment While Drilling & Testing

The releases of hydrocarbons that may be isolated from reservoir fluids include gas releases in the mud return area during drilling. The consequences of gas releases are described in this section. ALOHA model has been used to model the releases from failure of the test separator.

1.4.2.1 Frequency Analysis

Review of the hydrocarbon release database (HCRD) of 2003 for **One North Sea Platform** indicates the process gas leak frequencies for large releases (>10 kg/s) to be about **6.0×10^{-3} per year**. The

same frequency has been considered for potential release from leaks due to loss of containment while drilling.

1.4.2.2 Gas Releases during Drilling

a) Flash Fire

If gas is entrained in the mud then it could be released from the mud pits or shakers. The amount of gas returned is unlikely to be so great that a jet fire could occur, but the gas could build up into a flammable vapour cloud in the mud pit area. If the cloud then ignites it will result in a flash fire or vapour cloud explosion. Again, there is also the potential for a toxic cloud to be present if the release is during a period when sour crude is a possibility. The mud return typically contains around 50% water this means it cannot be ignited in liquid form so there is no danger of pool fires. Liquid mud fires are therefore not considered further.

The mud - gas separator can be other source that contains both flammable liquid and gas.

A well test separator rupture could result in release of gas when a gas cloud will form, initially located around the release point. If the release is ignited immediately then a fireball will be formed. If this cloud is not immediately ignited, then a vapour cloud will form, which will disperse with the wind and diluted as a result of air entrainment. The principal hazard arising from a cloud of dispersing flammable material is its subsequent (delayed) ignition, resulting in a flash fire. Large-scale experiments on the dispersion and ignition of flammable gas clouds show that ignition is unlikely when the average concentration is below the lower flammability limit (LFL).

As in the case for blow outs,) an effort was made to establish the overpressure (blast force zone) that may result from delayed ignition of vapour cloud generated from any such accidental release. For overpressure risk modelling using ALOHA a delayed ignition time of 5 minutes was considered of the vapour cloud mass. However the threat modelled revealed that Level of Concern (LOC) was never exceeded that may possibly lead to damage to property or life within the blast radius. The results have been provided in **Figure 1.8**.

Figure 1.8 Overpressure Risk Modelling – Well Releases during drilling

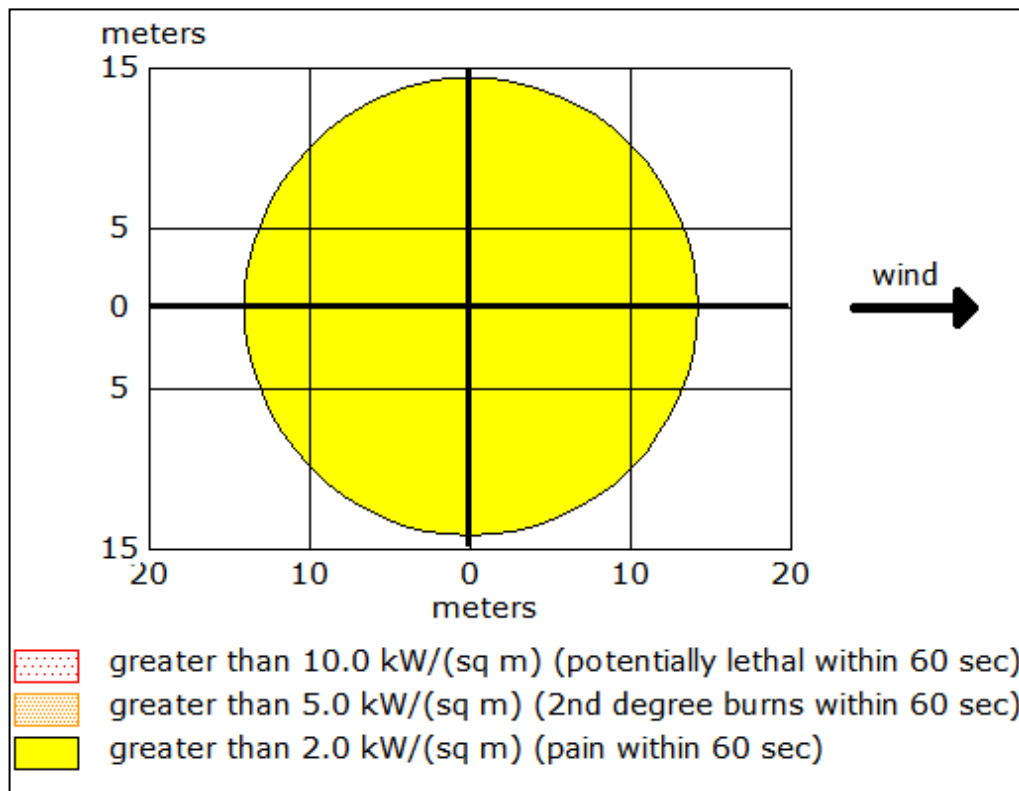
Threat Modeled: Overpressure (blast force) from vapor cloud explosion
Type of Ignition: ignited by spark or flame
Level of Congestion: uncongested
Model Run: Gaussian
Red : LOC was never exceeded --- (8.0 psi = destruction of buildings)
Orange: LOC was never exceeded --- (3.5 psi = serious injury likely)
Yellow: LOC was never exceeded --- (1.0 psi = shatters glass)

b) Jet Fire

The term jet fire is used to describe the flame produced due to the ignition of a continuous pressurised leakage from the pipe work. Combustion in a jet fire occurs in the form of a strong turbulent diffusion flame that is strongly influenced by the initial momentum of the release. Flame temperatures for typical jet flames vary from 1600°C for laminar diffusion flames to 2000°C for turbulent diffusion flames. The principal hazards from a jet fire are thermal radiation and the potential

for significant knock-on effects, such as equipment failure due to impingement of the jet fire. The thermal radiations distances due to Jet Flame are shown in **Figure 1.9** and **Figure 1.10** below.

Figure 1.9 Thermal Radiation Distances of Jet Flame due to Leak of 25 mm size



THREAT ZONE:

Threat Modeled: Thermal radiation from jet fire

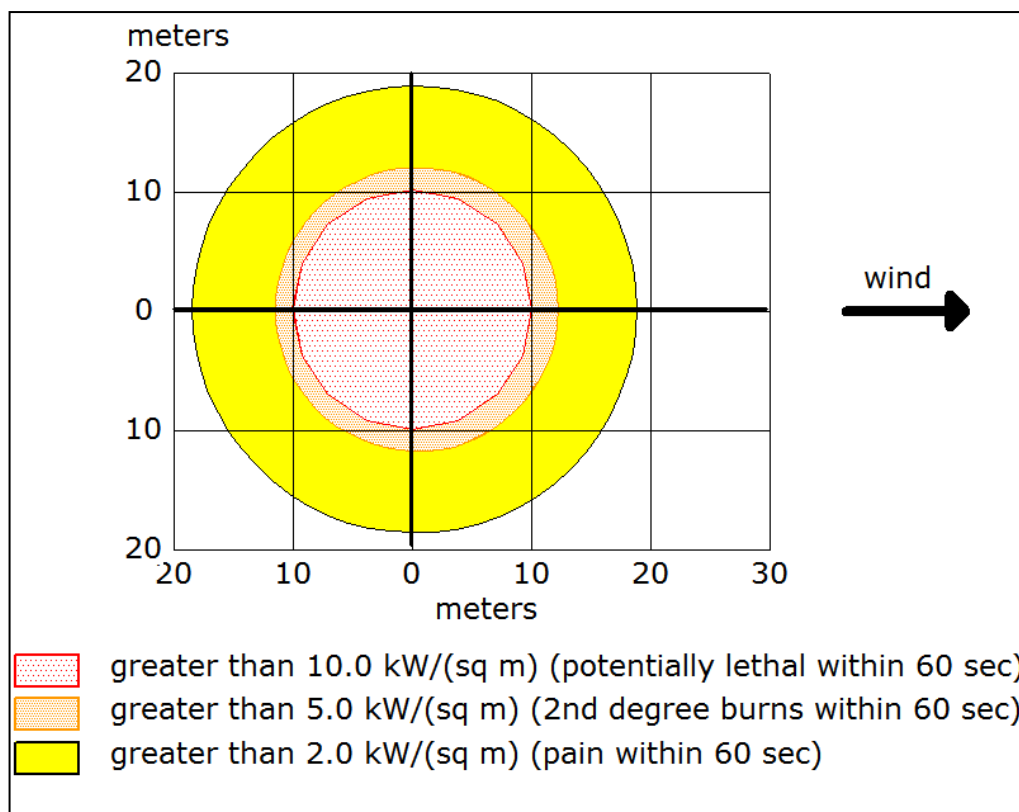
Model Run: Gaussian

Red: < 10 meters --- (10.0 kW/(sq m) = potentially lethal within 60 sec)

Orange: < 10 meters --- (5.0 kW/(sq m) = 2nd degree burns within 60 sec)

Yellow: 14 meters --- (2.0 kW/(sq m) = pain within 60 sec)

Figure 1.10 Thermal Radiation Distances of Jet Flame due to Leak of 50 mm size



THREAT ZONE:

Threat Modeled: Thermal radiation from jet fire

Model Run: Gaussian

Red : 10 meters --- (10.0 kW/(sq m) = potentially lethal within 60 sec)

Orange: 12 meters --- (5.0 kW/(sq m) = 2nd degree burns within 60 sec)

Yellow: 19 meters --- (2.0 kW/(sq m) = pain within 60 sec)

The zone of thermal radiation calculated for hypothetical release and ignition of natural gas during well testing have been presented in the **Table 1.12** below.

Table 1.12 Thermal Radiation Zone -Natural Gas Release Scenario during Well Testing

Release Type	Red (kW/sqm)	Orange (kW/sqm)	Yellow (kW/sqm)
Leak of 25 mm size	<10	<10	14
Leak of 50 mm size	10	12	19

Hence for a worst case scenario (50 mm leak) the ignition of natural gas release will be resulting in generation of thermal radiation which will be lethal within a maximum radius of 10m within 1 minute of its occurrence.

The risk significance for the potential well release scenario resulting from development drilling has been presented below. For calculating the risk significance, the likelihood ranking is considered to be

“3” as the frequency analysis for pipeline leak from jet fire is computed at “ 6.0×10^{-3} ” whereas the consequence ranking has been identified to be as “4” given the worst case scenario modelling (blast overpressure)/jet fire indicates that the LOC was never exceeded leading to multiple fatalities (For criteria ranking please refer to **Tables 7.1 and 7.2**).

Risk Ranking – Jet Fire/Blast Overpressure from Well Releases (Worst Case Scenario)

Likelihood ranking	3	Consequence ranking	4
Risk Ranking & Significance = 12 i.e. “Medium” i.e. Risk is Tolerable and can be managed through adoption of necessary controls and technologies.			

1.4.3 Interconnecting Hydrocarbon Pipeline Network

As discussed in the project description section, the project involves laying of 100 km long assorted oil & gas flow lines/ delivery lines in Dumduma-Pengeri Area under Tinsukia district of Assam. Some of the key hazard likely to be associated with same has been presented below

- Jet fires associated with pipework failures;
- Vapour cloud explosions; and
- Flash fires.

Each of these hazards has been described below.

Jet Fire

Jet fires result from ignited releases of pressurized flammable gas or superheated/pressurized liquid. The momentum of the release carries the material forward in a long plume entraining air to give a flammable mixture. Jet fires only occur where the natural gas is being handled under pressure or when handled in gas phase and the releases are unobstructed.

Flash Fire

Vapour clouds can be formed from the release of vapour of pressurized flammable material as well as from non-flashing liquid releases where vapour clouds can be formed from the evaporation of liquid pools or leakage/rupture of pressurized pipelines transporting flammable gas.

Where ignition of a release does not occur immediately, a vapour cloud is formed and moves away from the point of origin under the action of the wind. This drifting cloud may undergo delayed ignition if an ignition source is reached, resulting in a flash fire if the cloud ignites in an unconfined area or vapour cloud explosion (VCE) if within confined area.

Vapour Cloud Explosion

If the generation of heat in a fire involving a vapour-air mixture is accompanied by the generation of pressure then the resulting effect is a vapour cloud explosion (VCE). The amount of overpressure produced in a VCE is determined by the reactivity of the gas, the strength of the ignition source, the degree of confinement of the vapour cloud, the number of obstacles in and around the cloud and the location of the point of ignition with respect to the escape path of the expanding gases.

However, in the case of the interconnecting gas pipeline network *jet fire* has been identified as the most probable hazard.

1.4.3.1 Pipeline Frequency Analysis

An effort has also been made to understand the primary failure frequencies of pressurised gas/oil to be transported through the interconnecting pipeline network. Based on the European Gas Pipeline Incident Data Group (EGIG) database the evolution of the primary failure frequencies over the entire period and for the last five years has been provided in **Table 1.13**.

Table 1.13 Primary Gas Pipeline Failure Frequency

Period	No. of Incidents	Total System Exposure (km.yr)	Primary failure frequency (1000 km.yr)
1970-2007	1173	3.15.10 ⁶	0.372
1970-2010	1249	3.55.10 ⁶	0.351
1970-2013	1309	3.98.10 ⁶	0.329
1970-2016	1366	4.41.10 ⁶	0.310
1970-2019	1411	4.84.10 ⁶	0.292
1980-2019	1050	4.36.10 ⁶	0.241
1990-2019	663	3.63.10 ⁶	0.183
2000-2019	388	2.64.10 ⁶	0.147
2010-2019	184	1.42.10 ⁶	0.129
2015-2019	90	0.71.10 ⁶	0.126

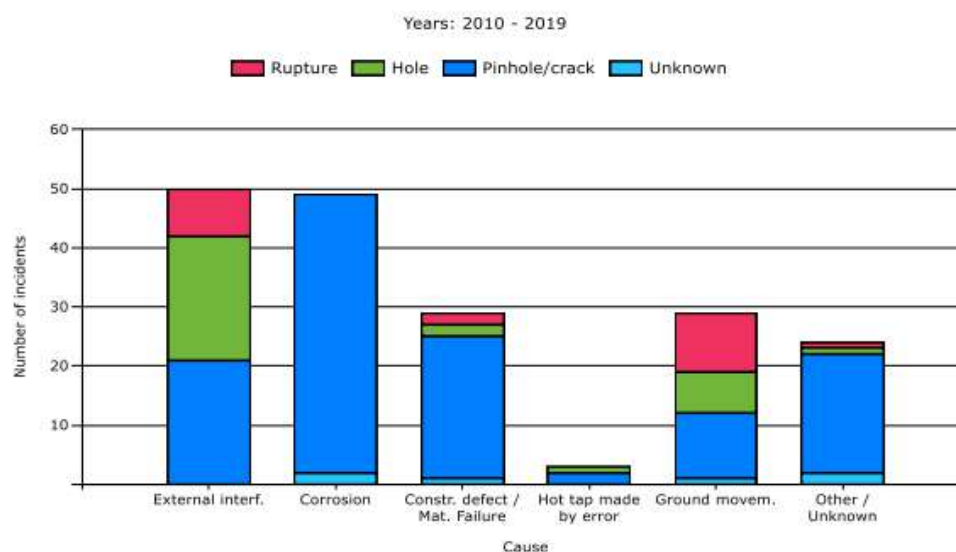
Source: 11th EGIG Report

As referred in the above table the overall failure frequency (0.33) of the entire period (1970-2013) is slightly lower than the failure frequency of 0.35 reported in the 8th EGIG report (1970-2010). The failure frequency of the last 5 years was found to be 0.16 per 1000km.year, depicting an improved performance over the recent years.

Incident Causes

Gas pipeline failure incidents can be attributed to the following major causes viz. external interference, construction defects, corrosion (internal & external), ground movement and hot tap. The distribution of incidents with cause has been presented in **Figure 1.11**.

Figure 1.11 Gas Pipeline Failure – Distribution of Incident & Causes



Source: 11th EGIG Report

The interpretation of the aforesaid figure indicated external interference as the major cause of pipeline failure contributing to about 48.4% of the total failure incidents followed by construction defects (16.7%) and corrosion related problems (16.1%). Ground movement resulting from seismic disturbance, landslides, flood etc. contributed to only 7.4% of pipeline failure incident causes.

Review of the 11th EGIG report indicates that primary failure frequency varies with pipeline diameter, and the same has been presented in **Table 1.14**.

Table 1.14 Primary Failure Frequency based on Diameter Class (1970-2013)

Nominal Diameter (inch)	Primary failure frequency (per km.yr)		
	Pinhole/Crack	Hole	Rupture
diameter < 5"	4.45×10^{-4}	2.68×10^{-4}	1.33×10^{-4}
5" ≤ diameter < 11"	2.80×10^{-4}	1.97×10^{-4}	6.40×10^{-5}
11" ≤ diameter < 17"	1.27×10^{-4}	0.98×10^{-4}	4.10×10^{-5}
17" ≤ diameter < 23"	1.02×10^{-4}	5.00×10^{-5}	3.40×10^{-5}
23" ≤ diameter < 29"	8.50×10^{-5}	2.70×10^{-5}	1.20×10^{-5}
29" ≤ diameter < 35"	2.30×10^{-5}	5.00×10^{-6}	1.40×10^{-5}
35" ≤ diameter < 41"	2.30×10^{-5}	8.00×10^{-6}	3.00×10^{-6}
41" ≤ diameter < 47"	7.00×10^{-6}	-	-
diameter ≥ 47"	6.00×10^{-6}	6.00×10^{-6}	6.00×10^{-6}

Source: 9th EGIG Report

The pipeline failure frequency viz. leaks or rupture for the natural gas pipeline has been computed based on the aforesaid table. Considering the interconnecting gas pipeline to be laid is likely to have the following diameters - 50mm (1.96 inches), 200mm (7.87 inches) to 300mm (11.81 inches), the failure frequency has been presented in **Table 1.15**.

Table 1.15 Interconnecting Pipeline - Failure Frequency

Sl. No	Pipeline Failure Case	EGIG Failure Frequency (per km.year)	Pipeline Dia (mm)	Avg. Pipeline Length (km)	Project Pipeline Failure Frequency (per year)	Frequency
1	Pipeline Rupture	1.33×10^{-4}	50	10	1.33×10^{-3}	Occasional/Rare
2	Pipeline Leak	4.45×10^{-4}	50	10	4.45×10^{-3}	Occasional/Rare
3	Pipeline Rupture	6.40×10^{-5}	200	180	11.52×10^{-3}	Occasional/Rare
4	Pipeline Leak	2.80×10^{-4}	200	180	5.04×10^{-2}	Occasional/Rare
5	Pipeline Rupture	4.10×10^{-5}	300	10	4.10×10^{-4}	Not Likely
6	Pipeline Leak	1.27×10^{-4}	300	10	1.27×10^{-3}	Occasional/Rare

Thus the probability of pipeline leak and rupture with respect to the interconnecting hydrocarbon pipeline network is identified to be as "Occasional/Rare".

Pipeline Failure – Ignition Probability

The ignition probability of natural gas pipeline failure (rupture & leaks) with respect to the proposed expansion project is derived based on the following equations as provided in the IGEM/TD/2 standard

$$P_{ign} = 0.0555 + 0.0137pd^2; \text{ for } 0 \leq pd^2 \leq 57$$

(For pipeline ruptures)

$$P_{ign} = 0.81; \text{ for } pd^2 > 57$$

$$P_{ign} = 0.0555 + 0.0137(0.5pd^2); \text{ for } 0 \leq 0.5pd^2 \leq 57$$

(For pipeline leaks)

$$P_{ign} = 0.81; \text{ for } 0.5pd^2 > 57$$

Where:

P_{ign} = Probability of ignition
 p = Pipeline operating pressure (bar)
 d = Pipeline diameter (m)

The ignition and jet fire probability of natural gas release from a leak/rupture of interconnected pipeline network is calculated based on the above equations and presented in **Table 1.16** below.

Table 1.16 Interconnecting Pipeline – Ignition & Jet Fire Probability

Sl. No	Pipeline Failure Case	Pipeline Dia (mm)	Project Pipeline Failure Frequency (per year)	Ignition Probability	Jet Fire Probability
1	Pipeline Rupture	50	1.33×10^{-3}	0.056	7.46×10^{-5}
2	Pipeline Leak	50	4.45×10^{-3}	0.055	2.48×10^{-4}
3	Pipeline Rupture	200	11.52×10^{-3}	0.064	7.48×10^{-4}
4	Pipeline Leak	200	5.04×10^{-2}	0.060	3.03×10^{-3}

Sl. No	Pipeline Failure Case	Pipeline Dia (mm)	Project Pipeline Failure Frequency (per year)	Ignition Probability	Jet Fire Probability
5	Pipeline Rupture	300	4.10×10^{-4}	0.076	3.14×10^{-5}
6	Pipeline Leak	300	1.27×10^{-3}	0.066	0.83×10^{-4}

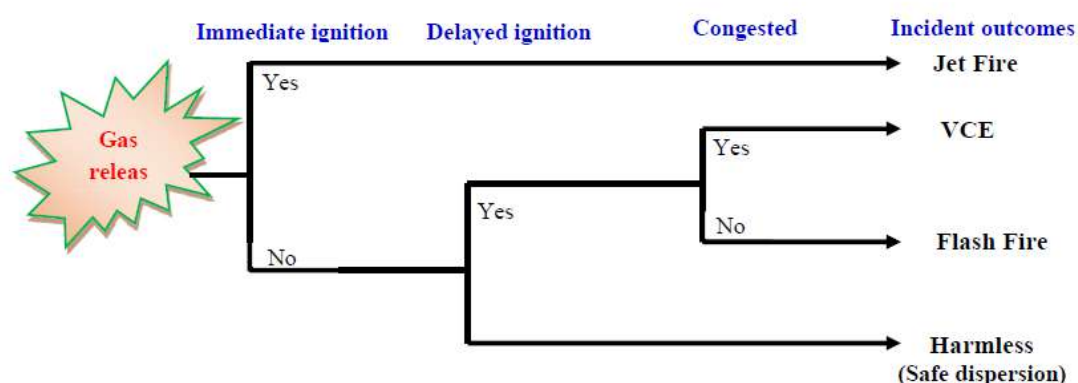
Hence from the above table it can be concluded that ignition probability of natural gas that may be released from the trunk and assorted pipelines due to any accidental event is mostly considered to be **“Not likely”**.

1.4.3.2 Consequence Analysis – Pipelines & GCS

Pipelines generally contains large inventories of oil or gas under high pressure; although accidental releases from them are remote they have the potential of catastrophic or major consequences if related risks are not adequately analysed or controlled. The consequences of possible pipeline failure is generally predicted based on the hypothetical failure scenario considered and defining parameters such as meteorological conditions (stability class), leak hole & rupture size and orientation, pipeline pressure & temperature, physicochemical properties of chemicals released etc.

In case of pipe rupture containing highly flammable natural gas, an immediate ignition will cause a jet fire. Flash fires can result from the release of natural gas through the formation of a vapour cloud with delayed ignition and a fire burning through the cloud. A fire can then flash back to the source of the leak and result in a jet fire. Flash fires have the potential for offsite impact as the vapour clouds can travel considerable distances downwind of the source. Explosions can occur when a flammable gas cloud in a confined area is ignited; however where vapour cloud concentration of released material is lower than Lower Flammability Limit (LFL), consequently the occurrence of a VCE is highly unlikely. VCE, if occurs may result in overpressure effects that become more significant as the degree of confinement increases (Refer **Figure 1.12**). Therefore, in the present study, only the risks of jet fires for the below scenarios have been modelled and calculated.

Figure 1.12 Natural Gas Release – Potential Consequences



[Source: “Safety risk modelling and major accidents analysis of hydrogen and natural gas releases: A comprehensive risk analysis framework” - Iraj Mohammadfam, Esmaeil Zare]

Based on the above discussion and frequency analysis as discussed in the earlier section, the following hypothetical risk scenarios (Refer **Table 1.17**) have been considered for consequence analysis of the interconnecting pipelines.

Table 1.17 Interconnecting Pipeline Risk Modelling Scenarios

Scenario	Source	Pipeline dia (mm)	Accident Scenario	Design Pressure (bar)	Temperature	Potential Risk
1	Pipeline	50	Complete rupture	17.23	24°C	Jet Fire
2	Pipeline	300	Leak of 75mm dia	17.23	24°C	Jet Fire
3	Pipeline	300	Complete rupture	17.23	24°C	Jet Fire
4	Pipeline	200	Leak of 50mm dia	17.23	24°C	Jet Fire
5	Pipeline	200	Complete Rupture	17.23	24°C	Jet Fire

The pipeline failure risk scenarios have been modeled using ALOHA and interpreted in terms of Thermal Radiation Level of Concern (LOC) encompassing the following threshold values (measured in kilowatts per square meter) for natural gas (comprising of ~95% methane⁵) to create the default threat zones:

Red: 10 kW/ (sq. m) -- potentially lethal within 60 sec;

Orange: 5 kW/ (sq. m) -- second-degree burns within 60 sec; and

Yellow: 2 kW/ (sq. m) -- pain within 60 sec.

For vapour cloud explosion, the following threshold level of concern has been interpreted in terms of blast overpressure as specified below:

Red: 8.0 psi – destruction of buildings;

Orange: 3.5 psi – serious injury likely; and

Yellow: 1.0 psi – shatters glass

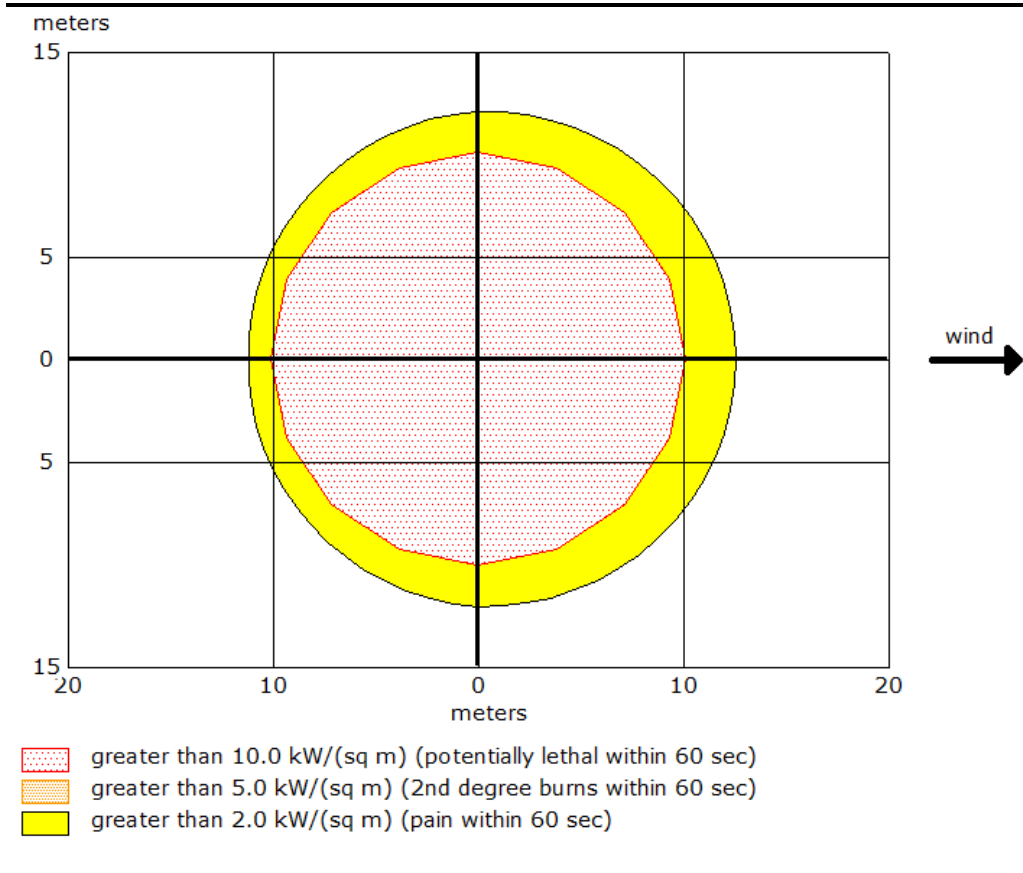
The risk scenarios modelled for pipeline failure has been presented below:

Scenario 1: 50mm dia Pipeline Complete Rupture

The jet fire threat zone plot for release and ignition of natural gas from 50 mm dia pipeline rupture is represented in **Figure 1.13** below.

⁵ https://www.naesb.org/pdf2/wqg_bps100605w2.pdf
http://www.google.co.in/url?sa=t&rct=j&q=&esrc=s&source=web&cd=18&ved=0ahUKEwjF7MiDttPRAhVCMi8KHd7aD6cQFghrMBE&url=http%3A%2F%2Fwww.springer.com%2Fcd%2Fcontent%2Fdocument%2Fcd_downloaddocument%2F9781848828711-c1.pdf%3FSGWID%3D0-0-45-862344-p173918930&usq=AFQjCNEAkJlfYKl3fRUdi6xiRYeW-FJb2A

Figure 1.13 Threat Zone Plot – 50mm dia pipeline complete rupture



Source: ALOHA

THREAT ZONE:

Threat Modeled: Thermal radiation from jet fire

Red : 10 meters --- (10.0 kW/ (sq. m) = potentially lethal within 60 sec)

Orange: 10 meters --- (5.0 kW/ (sq. m) = 2nd degree burns within 60 sec)

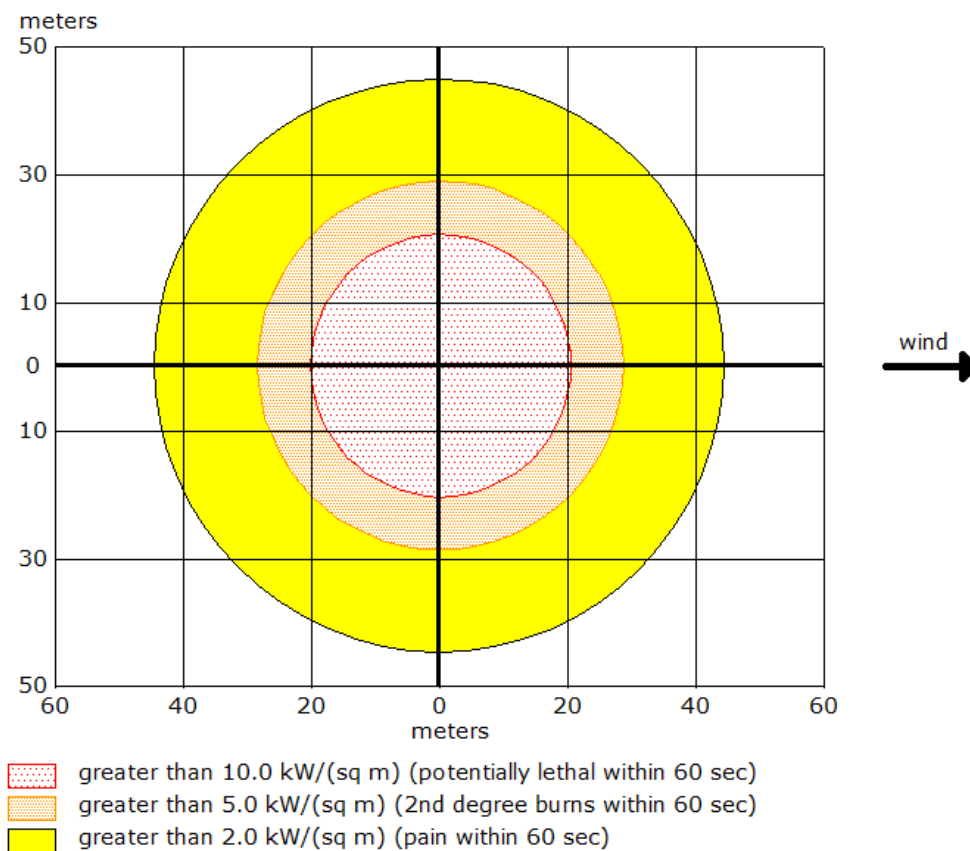
Yellow: 13 meters --- (2.0 kW/ (sq. m) = pain within 60 sec)

The worst hazard for release and ignition of natural gas from the 50m dia pipeline rupture will be experienced to a maximum radial distance of 10m from the source with potential lethal effects within 1 minute.

Scenario 2: 300mm dia Pipeline Leak (75mm dia)

The jet fire threat zone plot for release and ignition of natural gas from 300mm dia pipeline leak of 75mm dia is represented **Figure 1.14**.

Figure 1.14 Threat Zone Plot – 300mm dia pipeline leak (75mm dia)



Source: ALOHA

THREAT ZONE:

Threat Modeled: Thermal radiation from jet fire

Red : 21 meters --- (10.0 kW/ (sq. m) = potentially lethal within 60 sec)

Orange: 29 meters --- (5.0 kW/ (sq. m) = 2nd degree burns within 60 sec)

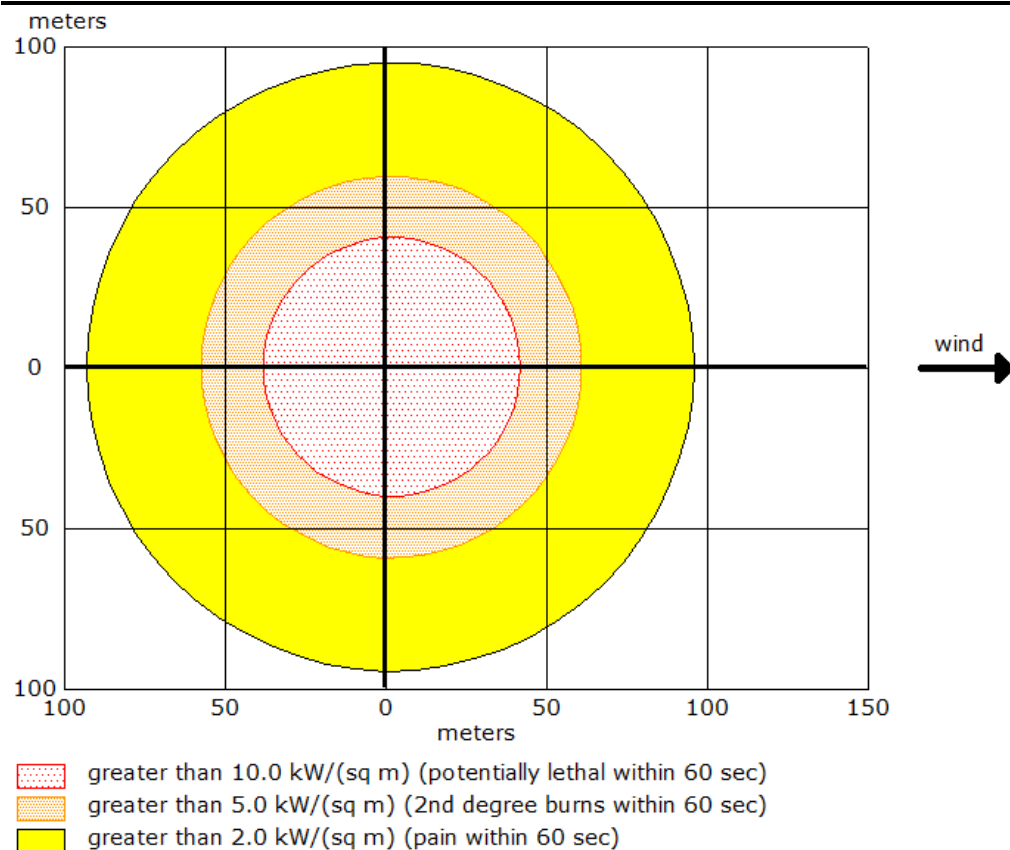
Yellow: 45 meters --- (2.0 kW/ (sq. m) = pain within 60 sec)

The worst hazard for release and ignition of natural gas from 300m dia pipeline leak of 75mm dia will be experienced to a maximum radial distance of 21m from the source with potential lethal effects within 1 minute.

Scenario 3: 300mm dia Pipeline Rupture

The jet fire threat zone plot for release and ignition of natural gas from 300m dia pipeline rupture is represented **Figure 1.15**.

Figure 1.15 Threat Zone Plot – 300mm dia pipeline rupture



Source: ALOHA

THREAT ZONE:

Threat Modeled: Thermal radiation from jet fire

Red : 41 meters --- (10.0 kW/ (sq. m) = potentially lethal within 60 sec)

Orange: 61 meters --- (5.0 kW/ (sq. m) = 2nd degree burns within 60 sec)

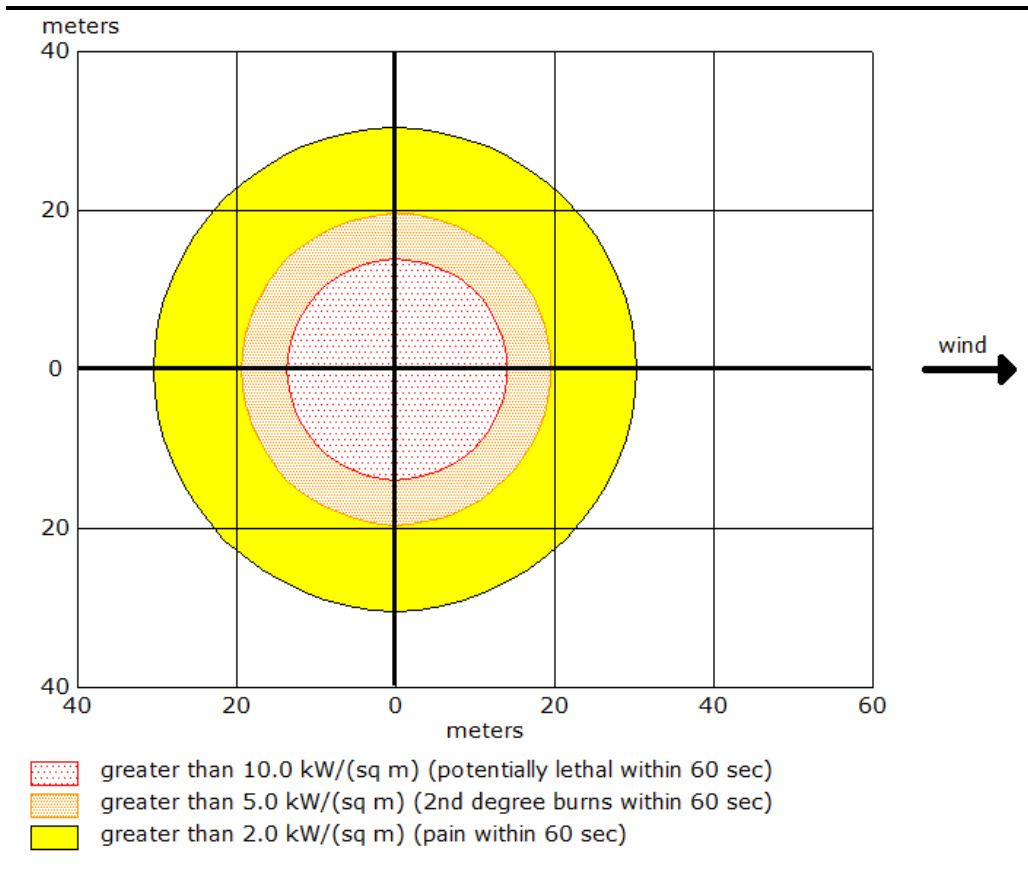
Yellow: 96 meters --- (2.0 kW/ (sq. m) = pain within 60 sec)

The worst hazard for release and ignition of natural gas from 300mm dia pipeline rupture will be experienced to a maximum radial distance of 41m from the source with potential lethal effects within 1 minute.

Scenario 4: 200mm dia Pipeline Leak (50mm dia)

The jet fire threat zone plot for release and ignition of natural gas from 200mm dia pipeline leak of 50mm dia is represented **Figure 1.16**.

Figure 1.16 Threat Zone Plot –200mm dia pipeline leak (50mm dia)



Source: ALOHA

THREAT ZONE:

Threat Modeled: Thermal radiation from jet fire

Red : 15 meters --- (10.0 kW/ (sq. m) = potentially lethal within 60 sec)

Orange: 21 meters --- (5.0 kW/ (sq. m) = 2nd degree burns within 60 sec)

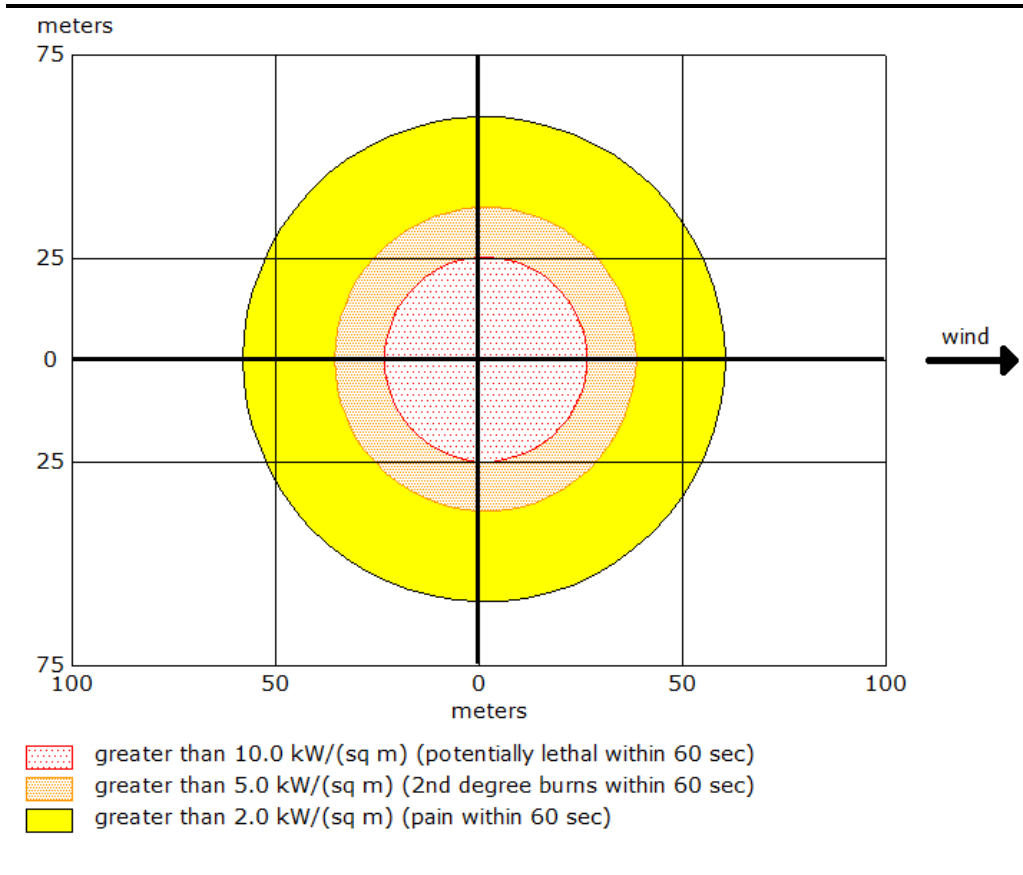
Yellow: 31 meters --- (2.0 kW/ (sq. m) = pain within 60 sec)

The worst hazard for release and ignition of natural gas from 200mm dia pipeline leak of 50mm dia will be experienced to a maximum radial distance of 15m from the source with potential lethal effects within 1 minute.

Scenario 5: 200mm dia Pipeline Rupture

The jet fire threat zone plot for release and ignition of natural gas from 200mm dia pipeline rupture is represented in **Figure 1.17**.

Figure 1.17 Threat Zone Plot –200mm dia pipeline rupture



Source: ALOHA

THREAT ZONE:

Threat Modeled: Thermal radiation from jet fire

Red : 28 meters --- (10.0 kW/ (sq. m) = potentially lethal within 60 sec)

Orange: 38 meters --- (5.0 kW/ (sq. m) = 2nd degree burns within 60 sec)

Yellow: 60 meters --- (2.0 kW/ (sq. m) = pain within 60 sec)

The worst hazard for release and ignition of natural gas from 200mm dia pipeline rupture will be experienced to a maximum radial distance of 28m from the source with potential lethal effects within 1 minute.

For VCE modelled for catastrophic failure of interconnecting pipeline the LOC level was never exceeded

THREAT ZONE:

Threat Modeled: Overpressure (blast force) from vapour cloud explosion

Type of Ignition: ignited by spark or flame

Level of Congestion: uncongested

Model Run: Heavy Gas

Red : LOC was never exceeded --- (8.0 psi = destruction of buildings)

Orange: LOC was never exceeded --- (3.5 psi = serious injury likely)

Yellow: LOC was never exceeded --- (1.0 psi = shatters glass)

For calculating the risk significance of natural gas pipeline, the likelihood ranking is considered to be “3” as the probability of pipeline rupture is computed to be $\sim 10^{-4}$ per year; whereas the consequence ranking has been identified to be as “3” as given for a worst case scenario (rupture) lethal effects is likely to be limited within a radial zone of ~ 41 m. Further as discussed in the earlier section, adequate number of gas leak and fire detection system of appropriate design will be provided for the interconnecting pipeline network including GCS to prevent for any major risk at an early stage of the incident.

Risk Ranking – Pipeline Rupture (Worst Case Scenario)

Likelihood ranking	3	Consequence ranking	3
Risk Ranking & Significance =9 i.e. “Low” i.e. Risk is Acceptable and can be managed through use of existing controls with the option for installation of additional controls, if necessary.			

1.4.4 OCS Tank Failure

This section assesses the risks resulting from the storage of crude oil at the OCS in two production tanks of 795 KL capacity each.

1.4.4.1 Frequency Analysis

The most credible scenario of a storage tank will be pool fire. In order to determine the probability of a pool fire occurring, the failure rate needs to be modified by the probability of the material finding an ignition source. The probability of a pool fire occurring in the event of a release is therefore equal to the product of the failure rate and the probability of ignition. The frequency of the release scenarios identified in the earlier section is represented in **Table 1.18** below. The ignition probability is dependent on a number of factors including the type of site, the release rate and the type of material released.

Table 1.18 Tank Failure Frequency

Sl. No	Type of Release	Failure Rate (per vessel per year)	Frequency
1	Catastrophic tanks failure	5.0×10^{-6}	Remote
2	Small bund fire	9.0×10^{-5}	Remote

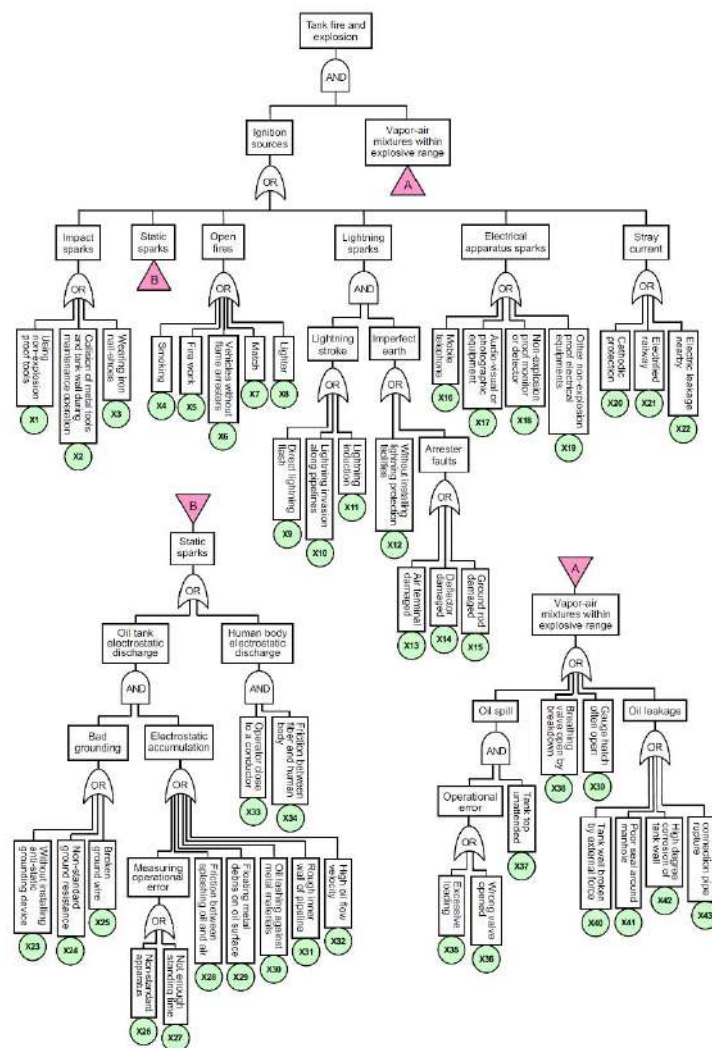
Sl. No	Type of Release	Failure Rate (per vessel per year)	Frequency
3	Large bund fire	6.0×10^{-5}	Remote

Source: OGP Risk Assessment Data Directory Report No 434 – 3, March 2010, Section 2 – Summary of Recommended Data

1.4.4.2 Event Tree Analysis

Event tree analysis (ETA) is used to model the evolution of an event from the initial release through to the final outcome such as jet fire, fireball, flash fire etc. This may depend on factors such as whether immediate or delayed ignition occurs, or whether there is sufficient congestion to cause a vapour cloud explosion. The event tree for fire and explosion for an oil storage tank is shown in **Figure 1.18**.

Figure 1.18 Scenario III: Risk Contour Map



Source: Fuzzy Fault Tree Analysis for Fire and Explosion in Crude Oil Tanks – Daqing Wang, Peng Zhang and Liqiong Chen, Journal of Loss Prevention in the Process Industries

1.4.4.3 Consequence Analysis – Tankages

The main hazards associated with the storage and handlings of crude oil are pool fires resulting from the ignition of released material as well as explosions and Flash fires resulting from the ignition of a

flammable cloud formed in the event of tank overfilling. The hazards may be realised following tank overfilling and leaks/failures in the storage tank and ancillary equipment such as transfer pumps, metering equipment, etc. all of which can release significant quantities of flammable material on failure.

Bulk Storage Tank Scenarios

In addition to overfill, the scenarios considered for the crude oil storage tanks were partial/local failures and cold catastrophic failures. Factors that have been identified as having an effect on the integrity of tanks are related to design, inspection, maintenance, and corrosion⁶. The following representative scenarios for the tanks were considered (Refer **Table 1.19**).

Table 1.19 OCS Storage Tank – Risk Modelling Scenarios

Scenario	Tank	Tank Diameter (m)	Tank Height (m)	Tank Volume (KL)	Accident Scenario
1	OCS Storage Tank	10.0	10.0	795	50mm leak
2		10.0	10.0	795	100mm leak
3		10.0	10.0	795	300mm leak (worst case)

The OCS storage tank failure risk scenarios have been modeled using ALOHA for n-decane which best represent the properties of crude oil and interpreted in terms of Thermal Radiation Level of Concern (LOC) encompassing the following threshold values (measured in kilowatts per square meter) to create the default threat zones:

Red: 10 kW/ (sq. m) -- potentially lethal within 60 sec;

Orange: 5 kW/ (sq. m) -- second-degree burns within 60 sec; and

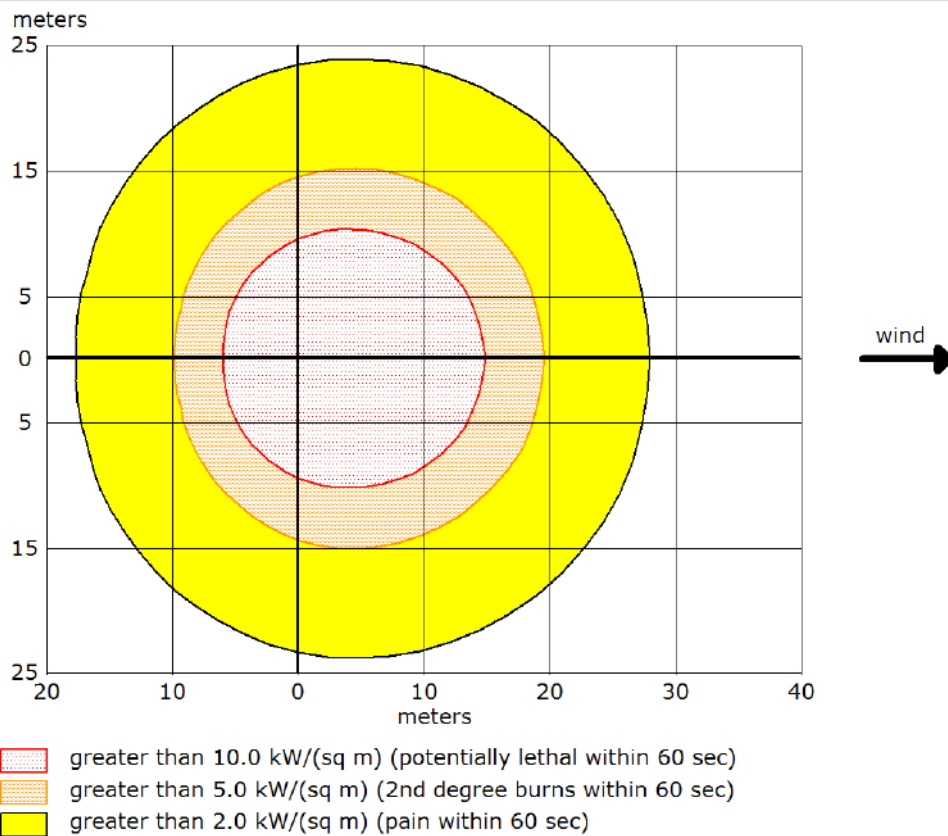
Yellow: 2 kW/ (sq. m) -- pain within 60 sec

⁶ AEA Technology, HSE Guidance Document

Scenario 1: OCS Storage Tank Leak (50mm dia.)

The pool fire threat zone plot for release and ignition of crude oil from a storage tank leak of 50mm dia is represented in **Figure 1.19** below.

Figure 1.19 Threat Zone Plot – OCS Storage Tank Leak (50mm dia)



Source: ALOHA

THREAT ZONE:

Threat Modeled: Thermal radiation from pool fire

Red : 15 meters --- (10.0 kW/ (sq. m) = potentially lethal within 60 sec)

Orange: 20 meters --- (5.0 kW/ (sq. m) = 2nd degree burns within 60 sec)

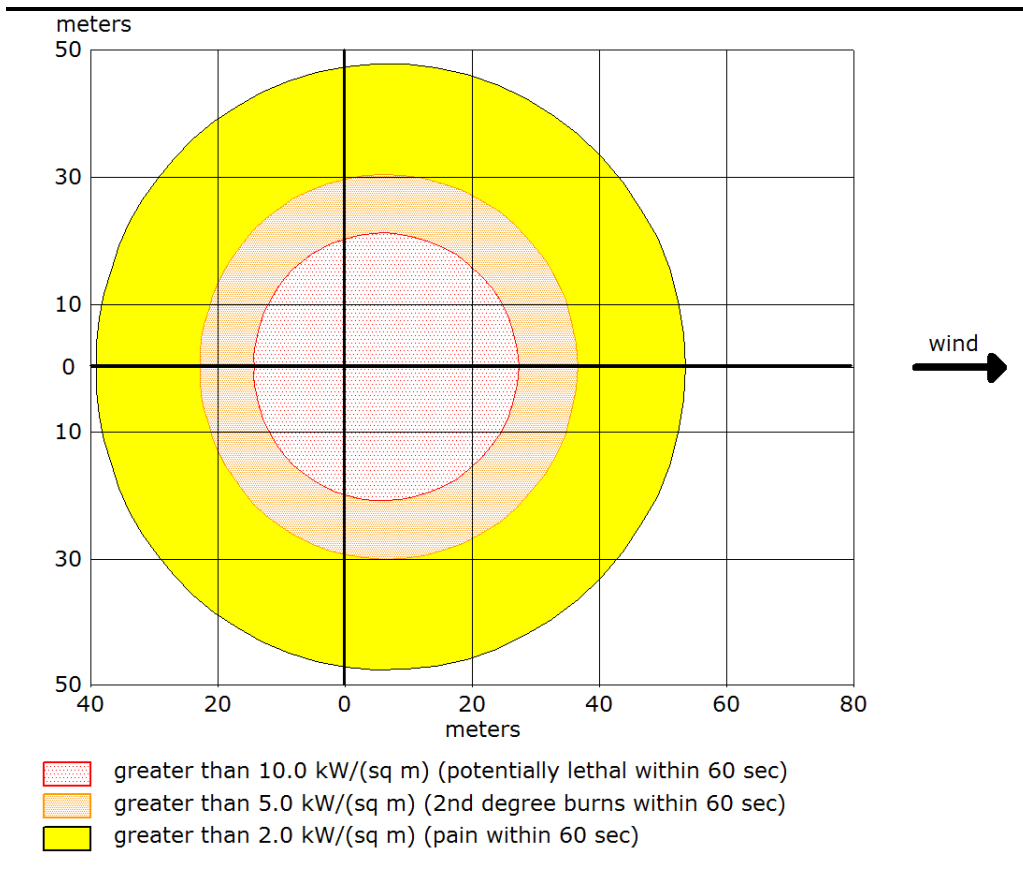
Yellow: 28 meters --- (2.0 kW/ (sq. m) = pain within 60 sec)

The worst hazard for release and ignition of crude oil from storage tank leak (50mm) will be experienced to a maximum radial distance of 15m from the source with potential lethal effects within 1 minute.

Scenario 2: OCS Storage Tank Leak (100mm dia)

The pool fire threat zone plot for release and ignition of crude oil from a storage tank leak of 100mm dia is represented in **Figure 1.20** below.

Figure 1.20 Threat Zone Plot – Diesel Storage Tank Leak (100mm dia)



Source: ALOHA

THREAT ZONE:

Threat Modeled: Thermal radiation from pool fire

Red : 26 meters --- (10.0 kW/ (sq. m) = potentially lethal within 60 sec)

Orange: 38 meters --- (5.0 kW/ (sq. m) = 2nd degree burns within 60 sec)

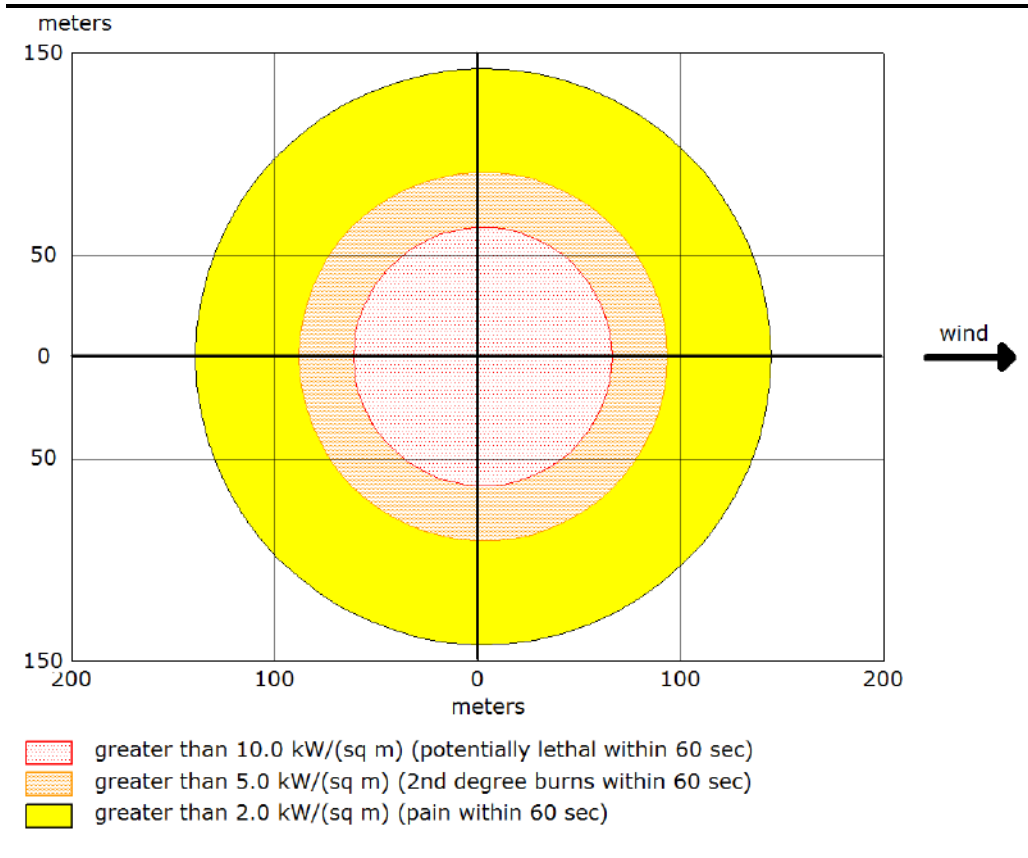
Yellow: 54 meters --- (2.0 kW/ (sq. m) = pain within 60 sec)

The worst hazard for release and ignition of crude oil from OCS storage tank leak (100mm) will be experienced to a maximum radial distance of 26m from the source with potential lethal effects within 1 minute.

Scenario 3: OCS Storage Tank Leak (300mm dia)

The pool fire threat zone plot for release and ignition of crude oil from a storage tank leak of 300mm dia (worst case) is represented in **Figure 1.21** below.

Figure 1.21 Threat Zone Plot – OCS Storage Tank Leak (300mm dia)



Source: ALOHA

THREAT ZONE:

Threat Modeled: Thermal radiation from pool fire

Red : 67 meters --- (10.0 kW/ (sq. m) = potentially lethal within 60 sec)

Orange: 93 meters --- (5.0 kW/ (sq. m) = 2nd degree burns within 60 sec)

Yellow: 145 meters --- (2.0 kW/ (sq. m) = pain within 60 sec)

The worst hazard for release and ignition of crude oil from storage tank leak (300mm) will be experienced to a maximum radial distance of 67m from the source with potential lethal effects within 1 minute.

For calculating the risk significance of crude oil storage failure, the likelihood ranking is considered to be “2” as the failure probability for such failure is computed to be $\sim 5 \times 10^{-6}$ per year. With respect to consequence ranking, for the aforesaid incident it has been identified to be as “4” given for a worst case scenario lethal effects is likely to be experienced within a maximum radial zone ~ 67 meters. However, considering that isolated crude oil storages will be equipped appropriate state of the art process and fire safety controls in consistent with OISD-117 requirements, the risk is likely to be less significant.

Risk Ranking – OCS Tank Failure (Worst Case Scenario)

Likelihood ranking	2	Consequence ranking	4
Risk Ranking & Significance = 8 i.e. “Low” i.e. Risk is Acceptable and can be managed through use of existing controls with the option for installation of additional controls, if necessary.			

1.4.5 Hazardous Material Releases or Mishaps

Release of following materials are not considered as major accidents and therefore are not quantified in terms of frequency, consequence and the resulting risk.

- Diesel fuel;
- Lubricants;
- Mud Chemicals;
- Explosives.

Exposure to such hazards would be **occupational** rather than **major** hazards.

1.4.6 External Hazards

External hazards which may impair the safety of the rig include the following:

- Severe weather conditions;
- Earthquake or ground movement; and
- Security breaches.

Extreme weather conditions are primarily lightening, cyclones and high winds and heavy rains. They may result in injury (through slips trips of personnel) or equipment damage. Cyclones and high winds may damage the rig structure. There are potential hazards to workers from direct impact of the structure i.e. falling equipment and any subsequent hydrocarbon releases caused by equipment damage. However, no fatalities are expected from such conditions i.e. the risk to workers is low, providing:

- Reliable weather forecasts are available;
- Work or rig move is suspended if conditions become too severe;
- Design and operational limits of the rig structure are known and not exceeded.

Other natural hazards, such as earthquake are predominant in the region.

The risk of external hazards causing blowouts has been considered in the frequency estimation of oil and gas blowouts in the earlier sections.

1.5 Disaster Management Plan

Disaster Management is a process or strategy that is implemented when any type of catastrophic event takes place. The Disaster Management Plan envisages the need for providing appropriate action so as to minimize loss of life/property and for restoration of normalcy within the minimum time in event of any emergency. Adequate manpower, training and infrastructure are required to achieve this.

The objectives of Disaster Management Plan are as follows:

- Rapid control and containment of the hazardous situation;
- Minimising the risk and impact of occurrence and its catastrophic effects;
- Effective rehabilitation of affected persons and prevention of damage to Property and environment;
- To render assistance to outside the factory.

The following important elements in the disaster management plan (DMP) are suggested to effectively achieve the objectives of emergency planning:

- Reliable and early detection of an emergency and careful response;
- The command, co-ordination, and response organization structure along with efficient trained personnel;
- The availability of resources for handling emergencies;
- Appropriate emergency response actions;
- Effective notification and communication facilities;
- Regular review and updating of the DMP;
- Proper training of the concerned personnel.

1.5.1 Emergency Identified

Emergencies that may arise:

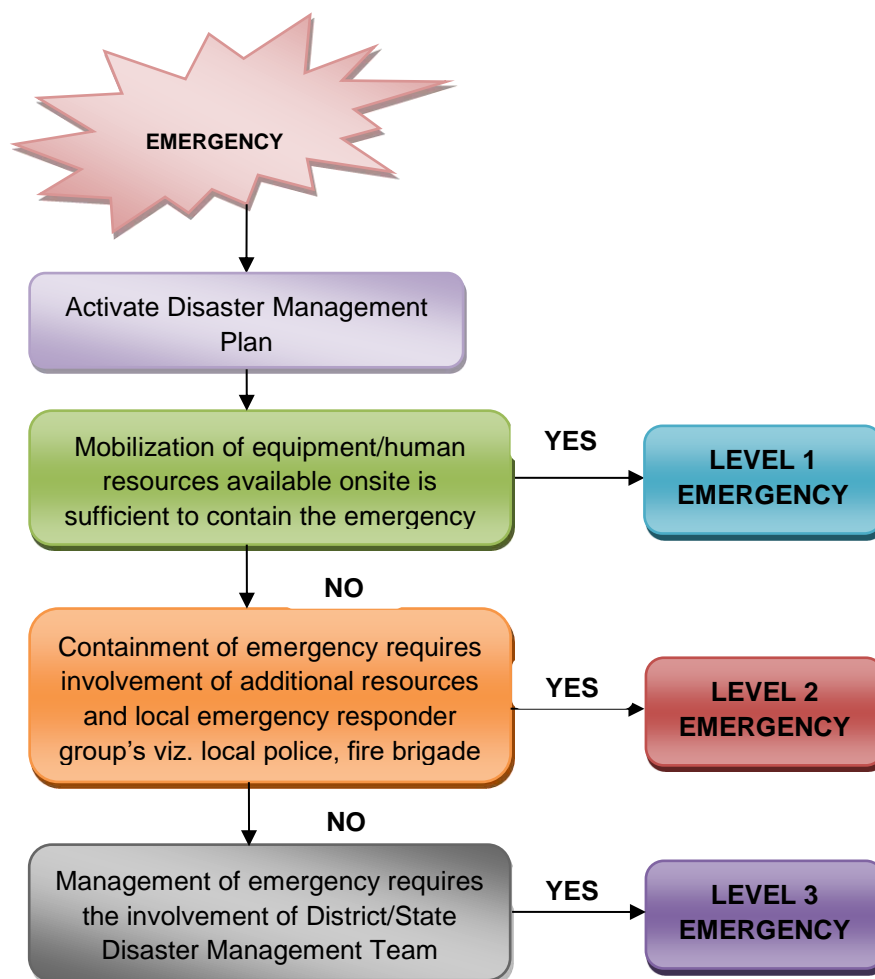
- Such an occurrence may result in on-site implications like :
 - Fire or explosion;
 - Leakage of natural gas; and
 - Oil spillage and subsequent fire.
- Incidents having off-site implications can be:
 - Natural calamities like earthquake, cyclone, lightening, etc.
- Other incidents, which can also result in a disaster, are :
 - Agitation / forced entry by external group of people;
 - Sabotage.

1.5.2 Emergency Classification

Due consideration is given to the severity of potential emergency situation that may arise as a result of accident events as discussed in the **Risk Analysis (RA)** study. Not all emergency situations call for

mobilization of same resources or emergency actions and therefore, the emergencies are classified into three levels depending on their severity and potential impact, so that appropriate emergency response procedures can be effectively implemented by the Emergency Response Team. The emergency levels/tiers defined with respect to this project based on their severity have been discussed in the subsequent sections with 'decision tree' for emergency classification being depicted in **Figure 1.22**.

Figure 1.22 Emergency Classification "Decision Tree"



The emergency situations have been classified in three categories depending upon their magnitude and consequences. Different types of emergencies that may arise at the project site can be broadly classified as:

1.5.2.1 Level 1 Emergency

The emergency situation arising in any section of one particular plant / area which is minor in nature, can be controlled within the affected section itself, with the help of in-house resources available at any given point of time. The emergency control actions are limited to level 1 emergency organization only. But such emergency does not have the potential to cause serious injury or damage to property / environment and the domino effect to other section of the affected plant or nearby plants/ areas.

1.5.2.2 Level 2 Emergency

The emergency situation arising in one or more plants / areas which has the potential to cause serious injury or damage to property / environment within the affected plant or to the nearby plants / areas. This level of emergency situation will not affect surrounding community beyond the facility. But such emergency situation always warrants mobilizing the necessary resources available in-house and/or outsources to mitigate the emergency. The situation requires declaration of On – Site emergency.

1.5.2.3 Level 3 Emergency

The emergency is perceived to be a kind of situation arising out of an incident having potential threat to human lives and property not only within the facility but also in surrounding areas and environment. It may not be possible to control such situations with the resources available within OIL facility. The situation may demand prompt response of multiple emergency response groups as have been recognized under the off-site district disaster management plan of the concerned district(s).

1.5.3 Preventive and Mitigation Measures for Blow Outs

In case of a blowout Fire service team from OIL and other Mutual Aid partners will report at site and will start spraying water continuously from all directions to disperse the formation of any explosive mixture in and around the well head area and keep the well head area cool to avoid any fire incident. The Disaster Control Room will be activated and information will be sent to all Disaster Management Coordinators of Mutual Aid partners. The Oil and Natural Gas Corporation Ltd. (ONGCL), Crisis Management Team (CMT) will be contacted for their expertise and support to control the situation. International Blowout control agencies will also be engaged for blowout control as necessary.

Proposed action plan control blowout of hydrocarbon prior to fire incident

- Creation of facilities for pumping water to the blowing well.
- Infrastructure arrangement for capping the well.
- Pumping of sufficient water through the well annulus to make the flowing gas wet, thereby reducing gas condensate spread to the nearby areas.
- Adequate water spraying through Fire Service pumps and nozzles/ monitors.
- Taking all adequate HSE measures.
- Continuous gas testing for LEL level around the well plinth area.
- To clear all equipment's and debris from site.
- Arrange adequate drilling mud and pumping infrastructure
- To complete the fabrication of hydraulically operated mechanized structure (for moving/ placing Blow out Preventer (BOP)) at OIL's workshop, incorporating all the points identified in the mock drill.
- Place fabricated mechanized structure 20-25 m from the wellhead
- Move BOP to well mouth hydraulically. Splash water continuously
- Cap the well by placing BOP on the wellhead
- Subdue the well by pumping drilling mud immediately.

Proposed action plan to extinguish the fire in case of blowout

- Heat shielding of the working areas by suitable means.

- To clear all debris and damaged rig package & equipment from site.
- Arrange water and pumping infrastructure.
- Arrange adequate drilling mud and pumping infrastructure.
- Special tools and equipment's used for controlling well under fire to be mobilized from various sources nationally and internationally.
- Arranging to cap the well by placing BOP with the help of special tools (Athey wagon) after creating a continuous water umbrella.
- Subdue the well by pumping drilling mud & kill the well immediately.
- Bring the well under control.

1.5.4 Preventive Measures for Handling of Natural Gas

- Leak detection sensors to be located at areas prone to fire risk/ leakages;
- All safety and firefighting requirements as per OISD norms to be put in place;
- High temperature and high pressure alarm with auto-activation of water sprinklers as well as safety relief valve to be provided;
- Flame proof electrical fittings to be provided for the installation;
- Periodical training/awareness to be given to work force at the project site to handle any emergency situation;
- Periodic mock drills to be conducted so as to check the alertness and efficiency and corresponding records to be maintained;
- Signboards including emergency phone numbers and 'no smoking' signs should be installed at all appropriate locations;
- Plant shall have adequate communication system;
- Pipeline route/equipment should be provided with smoke / fire detection and alarm system. Fire alarm and firefighting facility commensurate with the storage should be provided at the unloading point;
- 'No smoking zone' to be declared at all fire prone areas. Non sparking tools should be used for any maintenance; and
- Wind socks to be installed to check the wind direction at the time of accident and accordingly persons may be diverted towards opposite direction of wind.

1.5.5 Preventing Fire and Explosion Hazards

- Proper marking to be made for identification of locations of flammable storages;
- Provision of secondary containment system for all fuel and lubricating oil storages;
- Provision of fire and smoke detectors at potential sources of fire and smoke;
- Storing flammables away from ignition sources and oxidizing materials;
- Providing specific worker training in handling of flammable materials, and in fire prevention or suppression;
- Equipping facilities with fire detectors, alarm systems, and fire-fighting equipment;
- Fire and emergency alarm systems that are both audible and visible;

- For safety of people the building, regulations concerning fire safety to be followed. Some of the requirements include:
- Installation of fire extinguishers all over the building;
- Provision of water hydrants in operative condition;
- Emergency exit;
- Proper labelling of exit and place of fire protective system installation;
- Conducting mock drills;
- Trained personnel to use fire control systems.

1.5.6 Preventive Measures for Interconnecting Pipeline Risk Management

- Design all pipes and vessels to cope with maximum expected pressure;
- Install pressure transmitters that remotely monitor high- and low-pressure alarms;
- Design equipment to withstand considerable heat load;
- Conduct regular patrols and inspections of pipeline easements;
- Fit pumps with automatic pump shutdown or other safety devices;
- Minimise enclosed spaces where flammable gas may accumulate;
- Where necessary, automate emergency shutdown systems at production facilities;
- Consider installing flow and pressure instrumentation to transmit upset conditions and plant shutdown valves status;
- Install fire and gas detection systems;
- Implement security controls;
- Install emergency shutdown buttons on each production facility;
- Bury gathering lines at a minimum depth of 600 mm and where above ground, maintain a clear area;
- Implement management of change processes; and
- Conduct pressure testing and inspection of equipment and pipelines.

1.5.7 Preventing Fire and Explosion Hazards

- Proper marking to be made for identification of locations of flammable storages;
- Provision of secondary containment system for all fuel and lubricating oil storages;
- Provision of fire and smoke detectors at potential sources of fire and smoke;
- Storing flammables away from ignition sources and oxidizing materials;
- Providing specific worker training in handling of flammable materials, and in fire prevention or suppression;
- Equipping facilities with fire detectors, alarm systems, and fire-fighting equipment;

- Fire and emergency alarm systems that are both audible and visible;
- For safety of people the building, regulations concerning fire safety to be followed. Some of the requirements include:
- Installation of fire extinguishers;
- Provision of water hydrants in operative condition;
- Emergency exit;
- Proper labelling of exit and place of fire protective system installation;
- Conducting mock drills;
- Trained personnel to use fire control systems.

1.5.8 General Health and Safety

- The facility will adopt a total safety control system, which aims to prevent the probable accidents such as fire accidents or chemical spills.
- Firefighting system, such as sprinklers system, portable extinguishers (such as CO₂) and automated fire extinguishers shall be provided at strategic locations with a clear labelling of the extinguisher so the type of the extinguisher is easily identifiable. Also a main hydrant around the buildings will be available. On all floors an automated fire detection system will be in place.
- The site operations manager will take steps to train all emergency team members and shall draw up an action plan and identify members. The appointed emergency controller shall act as the in-charge at the site of the incident to control the entire operation.
- The staff shall be trained for first-aid and firefighting procedures. The rescue team shall support the first-aid and firefighting team.
- A first-aid medical centre will be onsite to stabilise the accident victim. The emergency team will make contact with a nearby hospital for further care, if required.
- A training and rehearsal of the emergency response by emergency team members and personnel on site will be done regularly.
- A safe assembly area will be identified and evacuation of the premises will be practised regularly through mock drills.
- In case an emergency is being declared, the situation shall be reported to the authorities such as local police, the chief inspector of factories and the state pollution control board as per rules and regulation of law of the land.
- Safety manual for storage and handling of Hazardous chemicals shall be prepared.
- All the personnel at the site shall be made aware about the hazardous substance stored and risk associated with them.
- Personnel engaged in handling of hazardous chemicals shall be trained to respond in an unlikely event of emergencies.
- A written process safety information document shall be compiled for general use and summary of it shall be circulated to concerned personnel.
- MSDS shall be made available and displayed at prominent places in the facility. The document compilation shall include an assessment of the hazards presented including (i) toxicity information

(ii) permissible exposure limits. (iii) Physical data (iv) thermal and chemical stability data (v) reactivity data (vi) corrosivity data (vii) safe procedures in process.

- Safe work practices shall be developed to provide for the control of hazards during operation and maintenance
- In the material storage area, hazardous materials shall be stored based on their compatibility characteristics.
- Near miss and accident reporting system shall be followed and corrective measures shall be taken to avoid / minimize near miss incidents.
- Safety measures in the form of DO and Don't Do shall be displayed at strategic locations.
- Safety audits shall be conducted regularly.
- Firefighting system shall be tested periodically for proper functioning.
- All hydrants, monitors and valves shall be visually inspected every month.
- Disaster Management Plan shall be prepared and available with concerned personnel department.

1.5.9 Personal Protective Equipment

In certain circumstances, personal protection of the individual maybe required as a supplement to other preventive action. It should not be regarded as a substitute for other control measures and must only be used in conjunction with substitution and elimination measures. PPEs must be appropriately selected individually fitted and workers trained in their correct use and maintenance. PPEs must be regularly checked and maintained to ensure that the worker is being protected.

1.5.10 First Aid

First aid procedures and facilities relevant to the needs of the particular workforce should be laid down and provided in consultation with an occupational physician or other health professional.

Health assessment should form a part of a comprehensive occupational health and safety strategy. Where employees have to undergo health assessment, there should be adequate consultation prior to the introduction of such program. Medical records should be kept confidential. Site should be able to relate employee health and illness data to exposure levels in the workplace.

Annexure 1.1 Risk Register

ID	Risk Area	Risk	Potential Anticipated Hazard	Hazard Effects	Risk Category	Risk Reducing Measures	
						Preventive measures	Mitigation measures
	HSE, Environment& Security						
1	HSE	Oil Spill	Oil spill resulting in significant HSE impact	1) Impact on flora and fauna 2) Disturbance of aquatic habitat	Low	1) OIL's Oil spill contingency plan must be ready before mobilization 2) Collaboration with Tier -3 Response centers 3) Procurement/ rental of adequate pollution response equipment 4) Provision of shut down valve at source	1) Get emergency support from ONGCL, 2) Standby of OIL Emergency response team
2	HSE	Fire	Fire can be happen due to Gas release / Mishandling or Improper storage of flammable material / Uncertified electrical equipment / fire load/equipment failure / bad housekeeping	1) Ignition of flammable substances like chemicals, HSD, 2) Emission of toxic fumes 3) Serious Injury to personal	high	1)Certified electrical Equipment 2) Follow safe Operating procedure for loading and unloading of flammable product, 3) Zone area classification recommendations 4) Follow, good housekeeping 5) Mandatory Fire proofing of steel structures required as per OISD-STD-164 6) Ensure good condition of firefighting equipment's	1) Engagement of experienced personals for firefighting 2) Activate Fire Alarm 3) Evacuation and assembly to Assembly Point 4) Fire / smoke detection systems 5) Usage of Portable fire extinguishers, 6) Emergency preparedness as per OISD-GDN -227 7) Get emergency support from OIL and ONGC as per MoU
3	HSE	Fall from Height	1) Failure to follow safe working procedure 2) Improper tools(absence of proper working platform) 3) Improper provision of anchorage point	1) Serious injury of personal 2) Equipment damage	high	1) Follow safety requirements, SOP 2) PTW System should be followed 3) Usage of Certified fall protection equipment 4) Periodic Inspection 5) Awareness of work from heights	1)Proper training procedures 2) Engagement of experienced personals 3)Medic & first aiders and Medevac provisions
4	HSE	Inadequate medivac process	Failure to medivac in time in case medical emergency	1) Prolonged injury 2) Loss of life	high	1) Keep Emergency Response plan in place 2) Tie up with nearest	1) Arrangement of ambulance 2)Proper training procedures 3) Engagement of experienced

**Onshore Oil & Gas Development DRILLING AND PRODUCTION IN
DUMDUMA-PENGERI AREA IN TINSUKIA DISTRICT**
Risk Assessment Report

ID	Risk Area	Risk	Potential Anticipated Hazard	Hazard Effects	Risk Category	Risk Reducing Measures	
						Preventive measures	Mitigation measures
						hospital from Dibrugarh, Tinsukia etc.	personals 4) Medic & first aiders and Medevac provisions
6	HSE	Exposure to Chemicals	Chemical burns/ health hazards- Exposure to drilling and completion fluids, lab chemicals etc.	1) Serious injury 2) Eye & Skin Irritation 3) respiratory illness	Medium	1) Regular onsite and in house HAZCOM trainings. 2) Adherence to SOP. 3) Provision on adequate PPE like splash proof goggles, emergency eye wash stations. 4) Labelling & Classification of hazardous substances 5) Handling precaution of chemicals to be done as per OISD-STD-114 Handling / storage of chemicals as guided in MSDS	1) Usage of PPE stated in MSDS 2) Proper training procedures 2) Engagement of experienced personals 3) Medic & first aiders and Medevac provisions
7	Environment	Exposure to smoke	1) So-called secondary smoking (exposure to cigarette smoke from others) 2) All potential causes of fires. 3) Failure to escape area before smoke becomes too thick during fire	1) Smoke inhalation, poisoning, asphyxiation, and inability to find way to safety etc. – 2) Respiratory illness	Medium	1) All fire prevention controls. 2) Fire dampers & smoke detectors. 3) Demarcation of smoking area 4) Activation of alarms,	1) Competent Fire teams, 2) Fire Suppression systems 4) Evacuation procedures 5) Emergency preparedness as per OISD-GDN -227
8	Health	Ergonomic like Manual Handling and Poor job design	1) Crane or other lifting gear down for maintenance 2) Manual handling of heavy equipment/objects 3) Handling tongs on drill floor, improper hand placements	1) Muscular-skeletal disorder 2) Crushed fingers etc.	Medium	1) Mechanical aids for all lifting and heavy equipment handling operations, policy. 2) Colour coding for safe places to put hands. 3) Identification of pinch points 4) Supervision and time out	1) Awareness of work 2) Medic and first aiders
9	Health	Psychological factors	1) Isolation and separation from family, work stress and pressure.	1) Increased accident risk, 2) reduced moral on board,	Low	1) Awareness of organisational goals/ objectives 2) Continuous Supervision	1) Employee refresher program and counselling

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						Preventive measures	Mitigation measures
			2) External problems such as substance abuse.	3) violence to other crew members 4) Low productivity		3) Recreation facilities on board 4) Adequate rest intervals	
Rig- Aided Activities							
1	Rig	Drill string, Draw works	1) Safety harness lanyards (Getting caught in drill string). 2) Hoses, free cables etc. on drill floor (Getting caught up by drill string). 3) Slipping & cutting drill line - in vicinity of operating draw works.	1) Potential fatalities due to impact or Strangulation. 2) Entanglement with draw works. 3) Using incorrect or inappropriate tools. 4) Inexperienced personnel.	High	1) Use of top drive (not Kelly) 2) Draw works enclosed with protective guard 3) Implementation of physical barriers, supervision, mentoring system 4) Proper tools for job as defined in the Work Instructions 5) Proper handling of the drill line (hand over hand technique)	1) Emergency shut down devices -ESD (for drill string) 2) Inclusion of experienced personals 3) Follow standard operating procedures 4) Ensure Job safety analysis 5) Medic & first aiders
2	Rig	Winches & Cranes	1) Manual guiding of winch lines / crane cables	1) Being caught and crushed.	High	1) Installation of drum guards 2) Policy disallowing manual handling. 3) Ensure good condition of machines 4) Periodic inspection of winches & cranes	1) Engage experienced personal 2) Follow standard operating procedures 3) Ensure Job safety analysis
3	Rig	Rotating galley equipment.	1) Improperly trained people using tools. 2) Trailing parts of clothes/ strings etc., incorrect PPE.	1) Cuts & abrasions, fractures, damage to limbs etc.	Medium	1) Contract requirements. 2) HSE standards & modules. 3) Training & competency, supervision. 4) PPE 5) Proper guards on equipment.	1) Lock out tags for all rotating equipment's in galley 2) Engagement of experienced personal 3) Follow standard operating procedures 4) Ensure good condition of the machines 5) Medic & first aiders
4	Rig	Exhaust fans / Intake	1) Parts of clothes getting sucked in. 2) Use of guard	1) Physical injuries like cuts on the body	High	1) PPE policy (use of coveralls) 2) Enclosed drives. Signage for auto-start equipment.	1) Awareness of Entanglement of loose clothes 2) Proper training methods

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						Preventive measures	Mitigation measures
			cages for climbing up/down	2) Serious impact injury		3) Lockout-tagout for Maintenance	3) Engagement of experienced personnel
5	Rig	(Belt- driven) Centrifugal pumps	1) Parts of clothes getting entangled	1) Physical/ impact injuries	Medium	1) PPE policy (use of coveralls). 2) Enclosed drives / guards for belts 3) Third party inspections. 4) Signage for auto-start equipment 5) Lockout- tagout for Maintenance	1) Awareness of Entanglement of loose clothes 2) Proper training methods 3) Engagement of experienced personnel 4) Follow standard operating procedures 5) Ensure Job safety analysis 6) Medic & first aiders
6	Rig	Large electric Motors	1) Motor explosion / Disintegration	1) Physical/ burn injuries	Low	1) Procurement practice (approved vendors good quality equipment) and maintenance system. 2) Signage for auto-start Equipment 3) Lockout- tagout for maintenance. 4) Ensure good condition of machines	1) Emergency shut down devices -ESD 2) Engagement of of experienced personals 3) Follow standard operating procedures 4) Ensure Job safety analysis
7	Rig	Augers & Agitators	1) Loose gratings or guards removed. 2) Maintenance work on auger and/or in mud pits	1) Loss of limbs 2) Serious injury	Low	1) PTW & Job Safety Analysis guidelines 2) Lockout- tagout for maintenance, and physical barriers. 3) Confined space entry procedures for mud pits, 4) Two-way radios communication	1) Emergency shut down devices -ESD 2) Engagement of experienced personals 3) Follow standard operating procedures 4) Ensure Job safety analysis 5) Rescue plan for confined space entry 6) Medic & first aiders
8	Rig	Swinging loads (crane operations)	1) Personnel in lifting zone. 2) Chasing tag lines. 3) Heavy / critical lifts, blind lifts. 4) Misunderstandings associated with language differences.	1) Personnel impacts - Serious injury	Medium	1) Lifting procedures, work instructions, Job safety analysis, spotters etc. 2) Policy of using hand signals in preference to radio.	1) Engagement of experienced personals 2) Proper training procedures 3) Medic & first aiders
9	Rig	Objects at height - drops	1) Crane operation or hoist operations.	1) Dropped objects (ranging	High	1) Dropped object prevention scheme, proper safety	1) Engagement of experienced personals

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						Preventive measures	Mitigation measures
			2) Derrick Personnel working on derrick 3) Working at height anywhere on rig, using tools & equipment for maintenance painting etc. 4) Stacked tubular on main deck area 5) Elevator size too big for OD of tubulars being lifted on the rig floor	from hand tools to the crown block!) 2) Crane collapse 3) Collapse of stacked Tubular 4) Personnel impacts – Serious injury		slings. 2) Tethered tools & tool log, purpose- built tethered tools. 100% tie-off for equipment and personnel. 3) Hazard awareness / toolbox talks. 4) Restricted access to drill floor and derrick. 5) Job safety analysis, DROPS Program, PTW for heavy lifts. 6) Physical measurement of elevators before lifting ops. 7) Placement of Sampson posts 8) Crane Operator competence Inspection & maintenance of rig systems and structures	2) Follow standard operating procedures 3) Ensure Job safety analysis 4) Proper training procedures 5) Medic & first aiders and Medevac provisions
10	Rig	Racking operations in derrick (90' up)	1) Climbing access ladder 2) Manual operation of monkey board (to unlatch collars). 3) Limited time for successful rescue after a fall.	1) Falls from up to 90' leading to Serious Injury/ head injury/broken bones etc.	High	1) Policy & procedure for working at heights, and written work instruction 2) Training & competency. 3) Enclosed cabin. 4) Rescue plan 5) PTW for working at heights	1) Fall Protection for working above 60 feet. 2) 3-point contact system 3) Inclusion of experienced personals 4) Awareness for working at heights 5) Medic & first aiders
11	Rig	Stabbing basket	1)Top drive impacts, hoses	Falls from up to 60' - leading to Serious Injury	High	1) Policy & procedure for working at heights. 2) Training & competency. 3) Zone management systems	1) Fall Protection for working above 60 feet. 2) Engagement of experienced personals 3) Proper training procedures 4)Medic & first aiders
12	Rig	Work basket	1) Crane failures 2) Bad weather ie severe wind and rain 3) No tag line	Falls from height leading to serious Injury	High	1) Certification & testing of basket 2) PTW, working at height procedures 3) Use of authorized tangle free tag lines inspected by 3rd parties	1) Fall Protection for working above 60 feet 2) Engagement of experienced personals 3) Proper training procedures 4) Medic & first aiders

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						Preventive measures	Mitigation measures
13	Rig	Working with vertical ladders.	1) Excessive reliance on vertical ladders for access (rig design feature). 2) Limited time for successful rescue after a fall.	Personnel falls – injuries	Medium	1) Ensure correct ladder safety Procedure 2) Inspect defects, cracks before usage 3) Ensure ladder has slip-resistant pads	1) Ensure 3-point contact system 2) Vertical ladder must be 3 feet above the point of support. 3) Engagement of experienced personals 4) Proper training procedures 5) Medic & first aiders
14	Rig	Galley equipment - sharp cutting instruments, knives.	1) Untrained personnel operating galley equipment.	Minor Injuries	Medium	1) PPE (chain mail gloves etc.) 2) Catering contract requirements. 3) Proper handling procedures for sharp objects	1) Proper training procedures 2) Medic & first aiders
15	Rig	Hand tools	1) Carrying screwdrivers at height esp. in pockets. 2) Fabrication of unauthorized personnel tools, misuse of tools at rig workshop	Minor Injuries	Medium	1) Policy on hand tools & tool pouches. 2) Competency & training.	1) Proper training procedures 2) Medic & first aiders
16	Rig	Surgical / Medical equipment.	1) Unauthorized access to sickbay. 2) Improper disposal of medical sharps	Minor Injuries	Low	1) Locks on sick bay cupboards. 2) Waste management plan.	1) Proper disposal methods 2) Medic & first aiders
17	Rig	Slippery surfaces:-Metal stairs & decks Lube oil Chemical gels gets water wet (Rain)	1) Failure to use handrail 2) Any spilled liquids on metal floors. 3) Open decks (for rain). 4) Anti-slip limited to Walkways	Minor Injuries	Medium	1) PPE (Safety shoes: with oil-water resistant) 2) Good Housekeeping policy. 3) Safety signs 4) Non-slip coatings, defined walking paths. 5) Bunding storage areas.	1) Monitoring program and inspection procedures for the pathway/ floors 2) Proper training procedures 3) Medic & first aiders
18	Rig	High pressure liquids	1) Connection failures, mismatched unions. 2) Hose failures. 3) Unidentified lines under pressure.	1) Uncontrolled HP liquid releases / jets, whiplash of HP hoses causing potential fatalities.	High	1) PTW for maintenance system 2) Policy on high- pressure connections. 3) Usage of PPE 4) Inspection of pressure relieving devices as per	1) Calibration of pressure monitoring devices 2) Engagement of experienced personals 3) Follow standard operating procedures

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						Preventive measures	Mitigation measures
			4) Pressure regulating devices	2) HP oil injection under skin may result in loss of limb due to severe Oedema and Erythema.		OISD-STD-132 5) Hazard awareness 6) Safety valve certificate from OEM	4) Proper training procedures 5) Emergency shut down
19	Rig	High Pressure Gases	1) Connection failures, mismatched unions. 2) Hose failures. 3) Unidentified lines under pressure. 4) Pressure regulating failures. 5) High-pressure gas bottles taking off as projectiles. 6) Incorrect labelling of bottles.	1) Uncontrolled HP Gas releases / jets, whiplash of HP hoses causing potential fatalities. 2) Major failure (burst) of tanks under Pressure	High	1) PTW for maintenance system 2) Policy on high- pressure connections. 3) Usage of PPE 4) Hazard awareness 5) Inspection of pressure relieving devices as per OISD-STD-132 Safety valve certificate from OEM	1) Calibration of pressure monitoring devices 2) Engagement of experienced personals 3) Follow standard operating procedures 4) Proper training procedures 5) Emergency shut down-ESD 6) Ensure Job safety analysis 7) Medic & first aiders
20	Rig	Hot surfaces	1) Unprotected hot surfaces in, galley equipment 2) Mud circuit piping & pumps. 3) Engine surfaces esp. exhausts, & radiators. 4) Laundry Equipment	1) Minor burns from touching hot surfaces.	Low	1) Warning signs, piping identification. 2) Usage of PPE (coveralls, gloves). 3) Liner retention system for mud circuit. 4) Lagging / insulation. 5) Awareness on heat hazard	1) Removal of source heat hazard. 2) Increase the rate of heat loss 3) Increase air motion by usage of fan or coolants. 4) Medic & first aiders
21	Rig	Hot liquids	1) spillage of Hot / boiling water & hot drinks in galley. 2) Temperature regulation failure. 3) horseplay	1) Minor burns from touching hot liquids 2) Eye damage	Low	1) Catering contract requirements. 2) Induction / hazard awareness. 3) Restricted access areas include kitchen, house rules 4) Usage of PPE	1) Usage of cold water 2) Proper training procedures 3) Engagement of experienced personals 4) Follow standard operating procedures 5) Medic & first aiders
22	Rig	1) Choke manifold during well control situation 2) Liquid N ₂	1) Getting locked in refrigerator. 2) Touching v cold surface. 3) Liquid N ₂ releases	1) Hypothermia Skin cold burns, severe skin cold burns. 2) Brittle fracture	Medium	1) Freezer door opens from inside 2) PPE for drill floor personnel. 3) 3rd party procedures for	1) Activation of Alarm button 2) Proper training procedures 3) Engagement of experienced personals 4) Follow standard operating

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						Preventive measures	Mitigation measures
		(for well stimulation jobs). 3) Dry ice CO2 Cylinders and fire suppression systems. 4) Working inside freezer		of steel structures		liquid N ₂ handling and storage.	procedures 5) Ensure job safety analysis 6) Medic & first aiders
23	Rig	Confined spaces e.g. bulk tanks, mud pits, crane pedestals and	1) Unregulated entry to spaces. 2) Hot work in confined spaces. 3) Undetected build-up of toxic gases like H ₂ S 4) O ₂ depletion or enrichment in confined spaces.	1) Suffocation / asphyxiation / poisoning, falling/impacts 2) Confined gas Explosions	high	1) PTW confined Space, 2) Gas testing & Gas detection training. 3) Confined Space policy 4) Recue plan 5) Usage of signage board for restricted access 6) Undertake risk assessment 7) PPE & fall arrest system	1) Activation of alarm button 2) Proper training procedures 3) Engagement of experienced personals 4) Follow standard operating procedures 5) Ensure job safety analysis 6) Keep log records 7) Medic & first aiders
24	Rig	Trips/falls	work area with Hoses, cables, tools, tubulars, ropes have the chances of trips/falls	Poor housekeeping	Medium	1) Housekeeping policy, 2) Warning signs. 3) Yellow marking of structural trip hazards. 4) Poor illumination of surface/floors	1) Self-inspection 2) Slip resistant footwear 3) Training procedure for holding handrail 4) Focused physiological characteristics of the walker
25	Rig	Toxic liquids like Acids Cleaning agents Paint thinners (fumes) and Caustic & toxic Mud additives. Chemicals	1) Unlabeled containers. 2) Fumes. 3) Spills Ingestion	1) Poisoning 2) Skin burns 3) Eyes damage 4) Environmental damage	Medium	1) MSDS & Chemical handling procedures. 2) Usage of PPE. 3) Eye wash stations, emergency showers. 4) General policy of replacing toxic liquids with less harmful substances.	1) Spill control system 2) Spill control equipment's 3) Proper training procedures 4) Engagement of experienced personals 5) Follow standard operating procedures 6) Ensure job safety analysis
26	Rig	Toxic gases :- Asphyxiate	1) Inadvertent release of CO ₂ or N ₂ into enclosed spaces with personnel present. 2) Personnel trapped	Asphyxiation – potential fatality.	Medium	1) Audible and visual alarms (for fire suppression systems) 2) Procedures for using N ₂ 3) PTW for access to tanks. 4) Enforcement of confined	1) Usage of respiratory devices 2) Proper training procedures 3) Engagement of experienced personals 4) Follow standard operating

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						Preventive measures	Mitigation measures
			in fire zone when CO ₂ flooding is set off. 3) Falling into sea or liquid tank. 4)Failing to observe confined space procedures			space procedures. 5) Confined space policy	procedures 5) Ensure job safety analysis 6) Medic / Hospital, Medevac capabilities
27	Rig	Perforating explosives used in TCP Guns	1) Inadvertent detonation e.g. by lightning, cell phones. 2) Adjacent heat sources – fires, welding. 3) Over-tired / stressed personnel handling explosives	Serious Injury	Very Low	1) Use of specialist contractors with procedures for handling explosives. 2) Explosive handling policy. 5) Non-Spark arrestor tools 6) Usage of PPE	1) Emergency preparedness as per OISD-GDN -227 2) Proper training procedures 3) Engagement of experienced personals 4) Follow standard operating procedures 5) Ensure job safety analysis 6) Medic, first aider & medivac operation
28	Rig	Ignition Sources	All types/ class of fire caused by 1) Smoking. 2) Electrical Faults. 3) Welding Hot Work 4) Sparks from grinding / failure to use non- sparking tools etc.	1) Major fire, asset damage, and smoke inhalation. 2) Burns/ serious injury	High	1) Designated smoking area. 2) Use of match box, lighters 3) Grounding static charges. 4) periodic inspection and HSE walk around 5) timely scheduled maintenance	1) Fire / smoke detection systems, 2) Activation of alarms, 3) Fire teams, 4) Suppression systems, 5) Fire extinguishers, 6) Evacuation procedures
Handling & Storage of Drilling fluid & Chemicals							
1	Handling & Storage	Chemical exposure	1) Occupational hazard due to chemical exposure	1) Harm to people- finger injury, burn injury 2) Irritation to eyes and skin 3) contamination of surrounding area	Medium	1) Collection of MSDS for the chemicals to evaluate 2) Proper training procedures 3) Rotation of manpower frequency to avoid prolonged exposure 4) Ensure Spill control system on rig 5) Ensure Spill control equipment's on rig	1) Use of specified PPE 2) Engagement of experienced personals 3) Follow standard operating procedures 4) Ensure job safety analysis 5) Emergency preparedness should include provisions of face showers, medical facilities and medical evacuation procedures.
2	Handling & Storage	moving rotating equipment	1) Occupational hazard due to	1) Harm to people- serious	High	1) Inspection and maintenance of equipment	1) Use of specified PPE 2) Engagement of experienced

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						Preventive measures	Mitigation measures
			mechanical hazard of moving/rotating equipment	injury, 2) Equipment damage.		i.e. hopper, mud mixing unit, mud tanks, 2) Inspection of inlet/outlet/ and emergency shut down valves	personals 3) Follow standard operating procedures 4) Ensure job safety analysis 5) Emergency preparedness should include medical facilities and medical evacuation procedures.
3	Handling & Storage	Hazardous Chemicals	1) Material Handling Storage of hazardous Chemicals	1) Harm to people- serious injury 2) Equipment damage. 3) Environmental damage	Medium	1) Effective functioning of drainage system should be evaluated for all work areas. 2) Dedicated storage areas should be allocated for incompatible chemicals 3) The storage area should have display board stating "Prohibited area" and must have at least two exits. 4) Periodic checks should be organised in all storage area 5) Each storage tank should have necessary instruments to monitor the level, pressure and temperature of the substance. 6) The storage tanks should have fire fighting facility and should be fenced. 7) All cables and electrical fittings should be insulated in order to prevent the risk of open sparking.	1) Use of specified PPE 2) Engagement of experienced personals 3) Follow standard operating procedures 4) Ensure job safety analysis 5) Emergency preparedness should include medical facilities and medical evacuation procedures 6) Spillage of chemicals should be properly handled.

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