



# EIA Study for Onshore Oil & Gas Exploration & Development Drilling and Production in Ningru Oil & Gas Field under Ningru PML



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(भारत सरकार का उद्यम)  
**Oil India Limited**  
(A Government of India Enterprise)

Changlang and Namsai Districts, Arunachal Pradesh

Risk Assessment Report

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Changlang and Namsai Districts, Arunachal Pradesh

## **Risk Assessment Report**

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## 1. ADDITIONAL STUDIES

### 1.1 Risk Assessment

This section on Quantitative Risk Assessment (QRA) aims to provide a systematic analysis of the major risks that may arise 35 nos. of onshore drilling wells, 03 nos. of production installations and laying of associated pipelines. The QRA 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 QRA 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 QRA 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 B-80 Block.

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 quantitatively 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.

#### 1.1.1 Objectives of the QRA Study

The overall objective of this QRA 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.

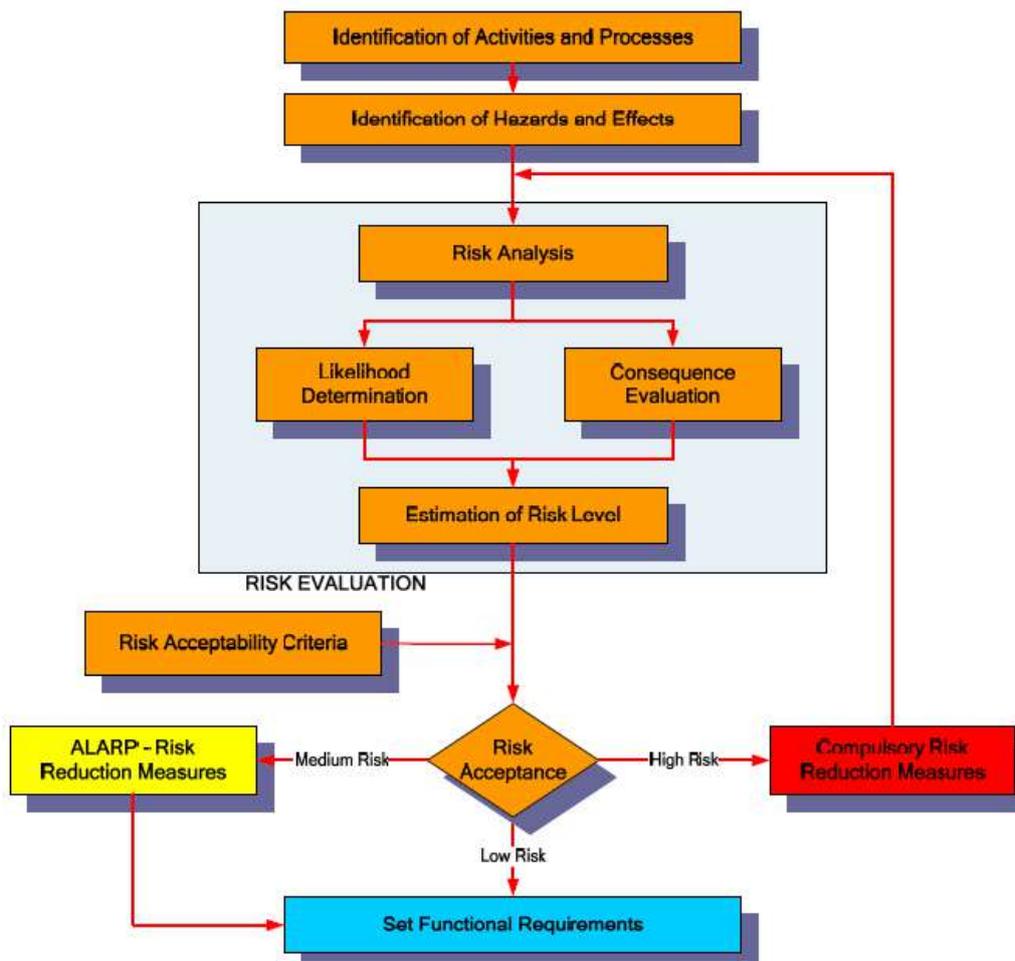
- Identify potential risk scenarios that may arise out of proposed development well drilling, operation of oil and gas pipelines and associated equipment's, mud chemicals storage and handling etc.
- Analyse the possible likelihood and frequency of such risk scenarios by reviewing historical accident 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 Management Plan (EMP) for the Project.

### 1.1.2 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 hypothetical accident scenarios. With respect to the proposed Project, major risks viz. blow outs, process leaks, non-process fires etc. have been assessed and evaluated through a risk matrix generated to combine the risk severity and likelihood factor. Risk associated with the well exploration and development activities have been determined semi-quantitatively as the product of likelihood/probability and severity/consequence by using order of magnitude data (risk ranking = severity/consequence factor X likelihood/probability factor). Significance of such project related risks was then established through their classification as high, medium, low, very low depending upon risk ranking.

The risk matrix is a widely accepted as standardized method of quantitative risk assessment and is preferred over purely quantitative methods, given that its inherent limitations to define a risk event is certain. Application of this tool has resulted in the prioritization of the potential risks events for the drilling activity thus providing the basis for drawing up risk mitigation measures and leading to formulation of plans for risk and emergency management. The overall approach is summarized in Figure 1.1.

**Figure 1.1 Risk Assessment Methodology**



### 1.1.2.1 Hazard Identification

Hazard identification for the purposes of this QRA 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, ITOFF, EGIG and DNV, Norwegian Petroleum Directorate etc. are used to identify potential hazards that can arise out of proposed Project activities. Taking into account 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 which has been dealt with in detail. This includes:

- Blowouts leading to uncontrolled well flow, jet fires, 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 Management Plan, if a contingency situation so arises.

### 1.1.2.2 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 actually 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 risks<sup>1</sup>.

For QRA 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 operations<sup>2</sup>, relevant offshore accident databases have been considered in the frequency analysis of identified

<sup>1</sup>It 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.

<sup>2</sup>Although 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

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 QRA 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**.

**Table 1.1 Frequency Categories and Criteria**

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

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

#### 1.1.2.4 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

	<b>Moderate</b>	<b>3</b>	15	12	9	6	3
	<b>Minor</b>	<b>2</b>	10	8	6	4	2
	<b>Insignificant</b>	<b>1</b>	5	4	3	2	1

**Table 1.4 Risk Criteria and Action Requirements**

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

### 1.1.3 Risk Assessment of Identified Project Hazards

As already discussed in the previous section, three major categories risk have identified in relation to proposed development drilling activities. 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. Risk assessment study details have been summarized in the subsequent sections below:

#### 1.1.3.1 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 for proposed operations as obtained through comprehensive root cause analysis of the Gulf Coast (Texas, OCS and US Gulf of Mexico) Blow Outs<sup>1</sup> during 1960-1996 have been presented in the **Table 1.5** below.

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

**Table 1.5 Blow Out Cause Distribution for Failures - Drilling Operations**

Sl. No.	Causal Factors	Blow Out Incidents (Nos.)
<b>A.</b>	<b>Primary Barrier</b>	
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>B.</b>	<b>Secondary Barrier</b>	
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 a given 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.

The blowout frequencies presented in this report are extracted from the latest revision of the Scandpower<sup>1</sup> report and are presented in **Table 1.6** below. The blowout probability is determined from blowouts in the North Sea. (i.e. British, Dutch and Norwegian sectors) given comparable data for onshore operations are not readily available.

**Table 1.6 Blow Out Frequencies Recommended per Drilled Well**

Drilling Operation	Well Category	Frequency, gas well	Frequency, oil well
Exploration	Normal	1.12E-04	1.23E-04
Wild Cat	Normal	9.70E-05	1.17E-04
Appraisal	Normal	1.07E-04	1.30E-04
Development	Normal	2.16E-05	2.62E-05

Based on the aforesaid frequency and information provided by OIL the blow out frequency for the proposed project has been computed as follows:

<sup>1</sup> "Blowout and Well Release Frequencies" - Based on SINTEF Offshore Blowout Database 2010, Report, Scandpower Risk Management. Report no. 19.101.001-3009/2011/R3, 05.04.2011.

No of wells to be drilled per year = 10 (A)

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

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

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

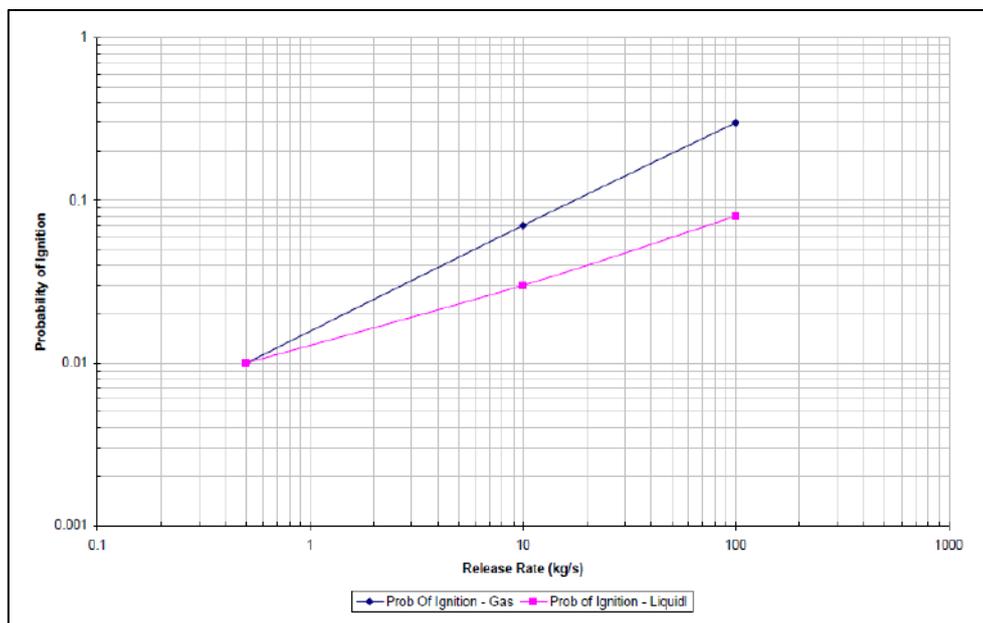
Frequency of blow out occurrence for development (gas) =  $(A \times C) = 10 \times 2.16 \times 10^{-5}$   
=  $2.16 \times 10^{-4}$  per well drilled

Thus, the blow out frequency for the proposed project for development oil and gas wells have been identified to be as “**Not Likely**”

### Blowout Ignition Probability

Review of SINTEF database indicates that a rounded ignition probability of 0.3 has been widely used for the purpose of quantitative 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 releases<sup>1</sup> (Table 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 QRA study this can be taken as occurring immediately on release and calculation provided below:

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

No of wells to be drilled per year = 10 (A)
Blow out frequency for drilling (oil) = $2.62 \times 10^{-5}$ per well drilled (B)
Blow out frequency for drilling (gas) = $2.16 \times 10^{-5}$ per well drilled (C)
Blow out ignition probability = 0.09 (D)
Probability of Blow out ignition for drilling (oil) = $(A \times B \times D) = 10 \times 2.62 \times 10^{-5} \times 0.09$ = $2.35 \times 10^{-5} = \sim 0.0023\%$
Probability of Blow out ignition for drilling (gas) = $(A \times C \times D) = 10 \times 2.16 \times 10^{-5} \times 0.09$ = $1.94 \times 10^{-5} = \sim 0.0019\%$

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 found to range within  $\sim 0.0023\%$  and  $0.0019\%$  and therefore can be considered to be as negligible.

### 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 vapor 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 vapor above the pool surface which, on ignition, leads to generation of pool fire.

For the purpose of consequence modeling for pool fires resulting from blow outs, following hypothetical scenarios in terms of hydrocarbon (particularly crude oil) release rates (**Table 1.7**) have been considered based on DNV Technica's FLARE program.

**Table 1.7 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/m<sup>2</sup>s)

The mass burning rate for crude oil has been considered to be 0.05 kg/m<sup>2</sup>s

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 1.8** below.

**Table 1.8 Pool Fire Diameter & Steady State Burning Scenario**

Scenario	Release Rate (kg/s)	Release Type	Pool fire diameter (m)	Steady State Burning Area (m <sup>2</sup> )
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 1.9** below:

**Table 1.9 Thermal Radiation Intensity Threshold Values Impact Criterion**

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

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.

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

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 (m<sup>2</sup>)
- 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 (m<sup>2</sup>) 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 1.10** below

**Table 1.10 Distance to Thermal Radiation Threshold Levels**

Release Type	Pool fire diameter (m)	Pool fire area (m <sup>2</sup> )	Distance to 5.0 kW/m <sup>2</sup> (m)	Distance to 12.5 kW/m <sup>2</sup> (m)	Distance to 37.5 kW/m <sup>2</sup> (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/m<sup>2</sup>** 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 (CH<sub>4</sub>) as a flammable component, but it also contains heavier gaseous hydrocarbons such as ethane (C<sub>2</sub>H<sub>6</sub>), propane (C<sub>3</sub>H<sub>8</sub>) and butane (C<sub>4</sub>H<sub>10</sub>). Other gases such as CO<sub>2</sub>, nitrogen and hydrogen sulfide (H<sub>2</sub>S) 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 1.11) have been considered for nature gas release consequence modelling:

**Table 1.11 Natural Gas Release Modelling Scenario**

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

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.

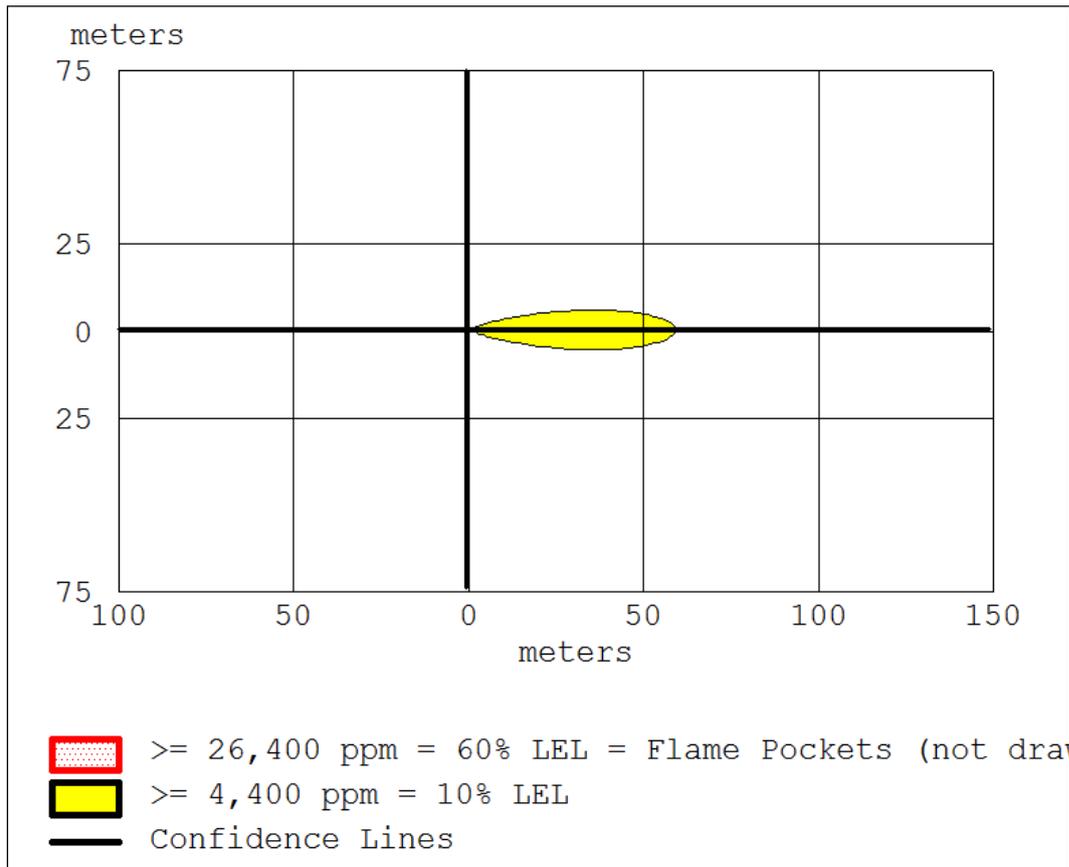
When a flammable vapor cloud is dispersing, the concentration of fuel in the air is not uniform; there will be areas where the concentration is higher than the average and areas where the concentration is lower than the average. This is called concentration patchiness. Because of concentration patchiness, 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

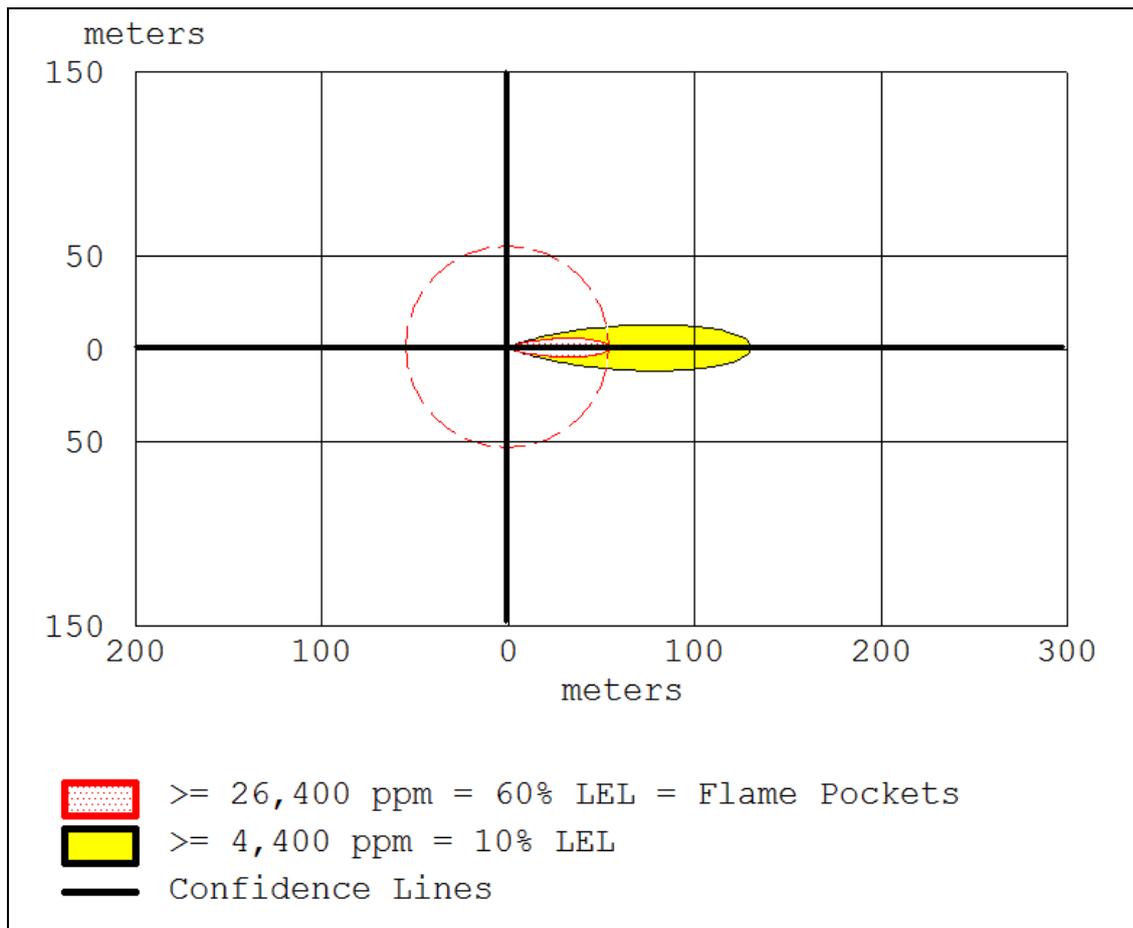
Model Run: Gaussian

*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:**

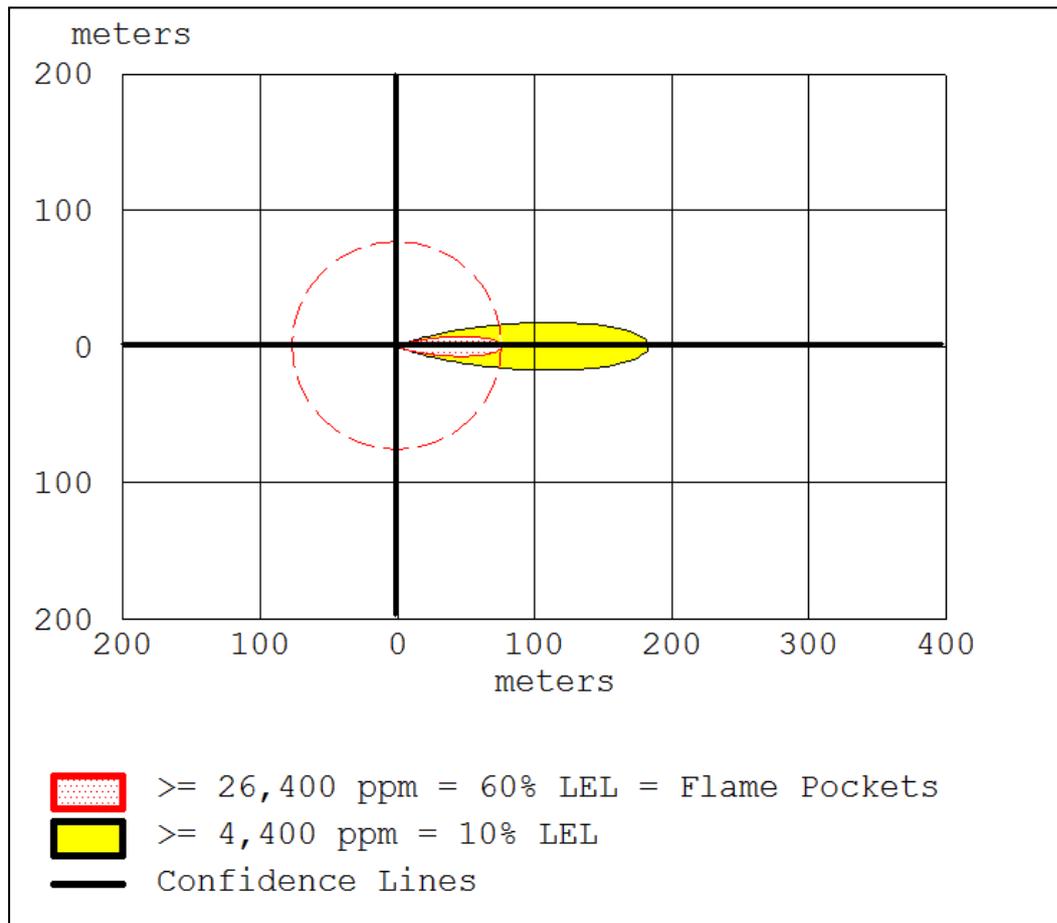
Threat Modeled: Flammable Area of Vapor Cloud

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)

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 1.12** below.

**Table 1.12 Zone of Flammable Vapour Cloud-Natural Gas Release Scenarion**

Release Type	Release Rate (kg/s)	Red -60% LEL (m)	Yellow -10% LEL (m)
Small	1	25	65
Medium	5	55	131
Large	10	77	183

Hence for a worst case scenario (10kg/s) the flammable vapor cloud zone/flame pockets' resulting from accidental release of natural gas will be covering a radial zone of 77m from source with the flammable gas concentration within this zone being 26,400 ppm.

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Based on the flammable vapour cloud concentration modelled for the worst case scenario (10 kg/s) 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 1.6** below.

**Figure 1.6 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 “~ 10<sup>-5</sup>” 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 & 1.2**).

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

Likelihood ranking	2	Consequence ranking	4
<b>Risk Ranking &amp; Significance = 8 i.e. “Low” i.e. Risk is Acceptable and can be managed through use of existing controls and evaluation of additional controls.</b>			

**1.1.3.2 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.

*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 7.13** 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 1.13 Tank Failure Frequency**

Sl. No	Type of Release	Failure Rate (per vessel per year)	Frequency
1	Catastrophic tanks failure	5.0 x 10 <sup>-6</sup>	Remote

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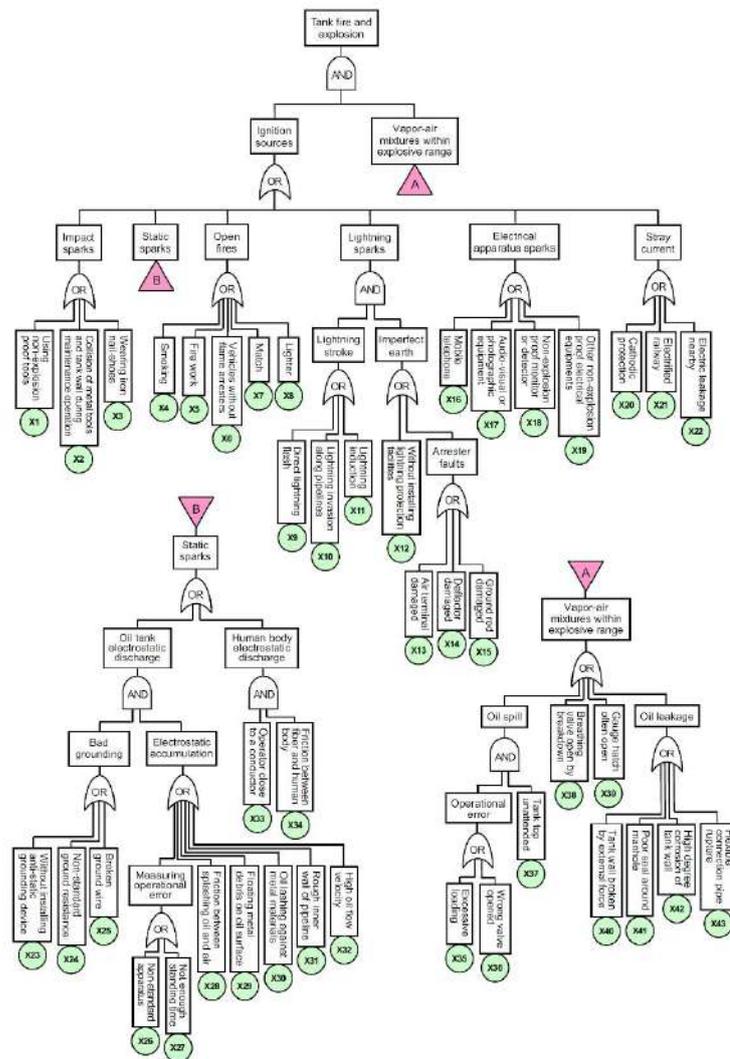
Sl. No	Type of Release	Failure Rate (per vessel per year)	Frequency
2	Small bund fire	9.0 x 10 <sup>-5</sup>	Remote
3	Large bund fire	6.0 x 10 <sup>-5</sup>	Remote

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

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 1.7.

Figure 1.7 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

Consequence Analysis – Tankages

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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 corrosion<sup>6</sup>. The following representative scenarios for the tanks were considered (Refer **Table 1.14**).

**Table 1.14 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*

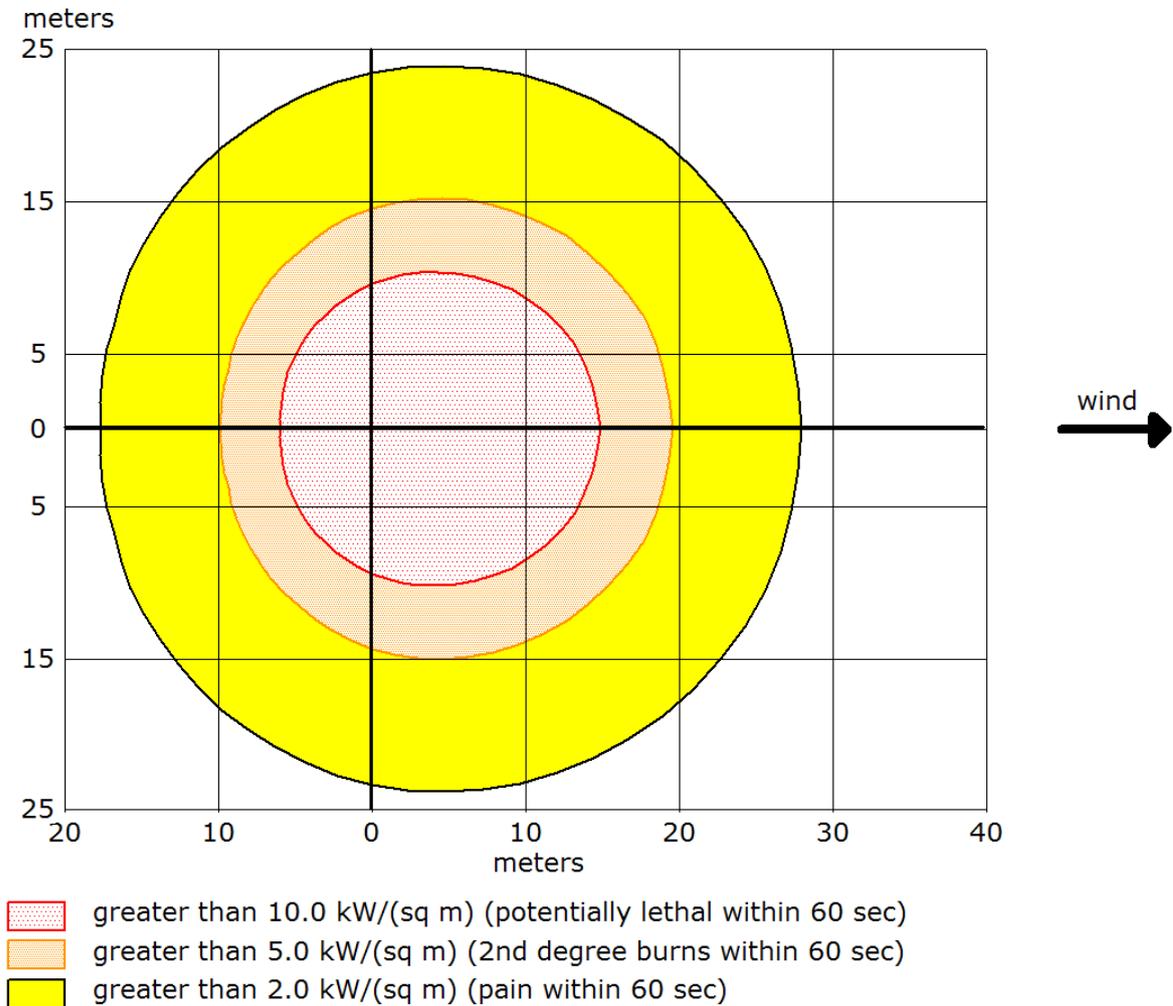
*Yellow: 2 kW/ (sq. m) -- pain within 60 sec*

<sup>6</sup> 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 1.8** below.

**Figure 1.8 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)

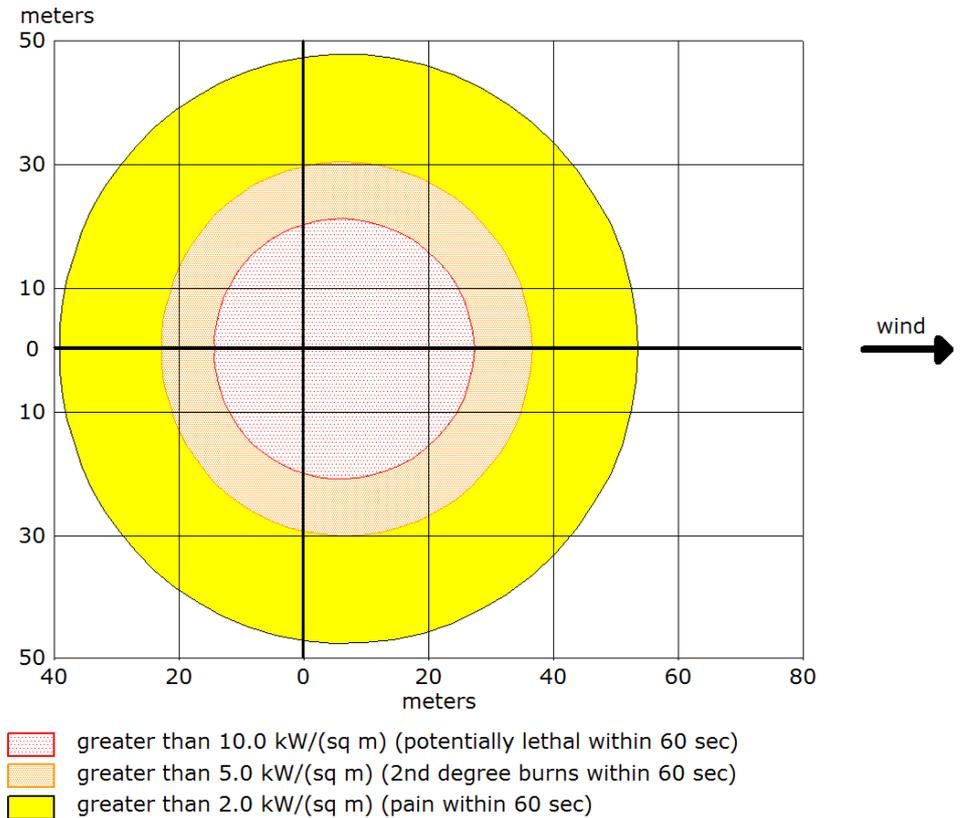
Yellow: 28 meters --- (2.0 kW/ (sq. m) = pain within 60 sec)

**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 1.9** below.

**Figure 1.9 Threat Zone Plot – Diesel Storage Tank Leak (100mm dia)**



Source: ALOHA

**THREAT ZONE:**

Threat Modeled: Thermal radiation from pool fire

Red : 27 meters --- (10.0 kW/ (sq. m) = potentially lethal within 60 sec)

Orange: 37 meters --- (5.0 kW/ (sq. m) = 2nd degree burns within 60 sec)

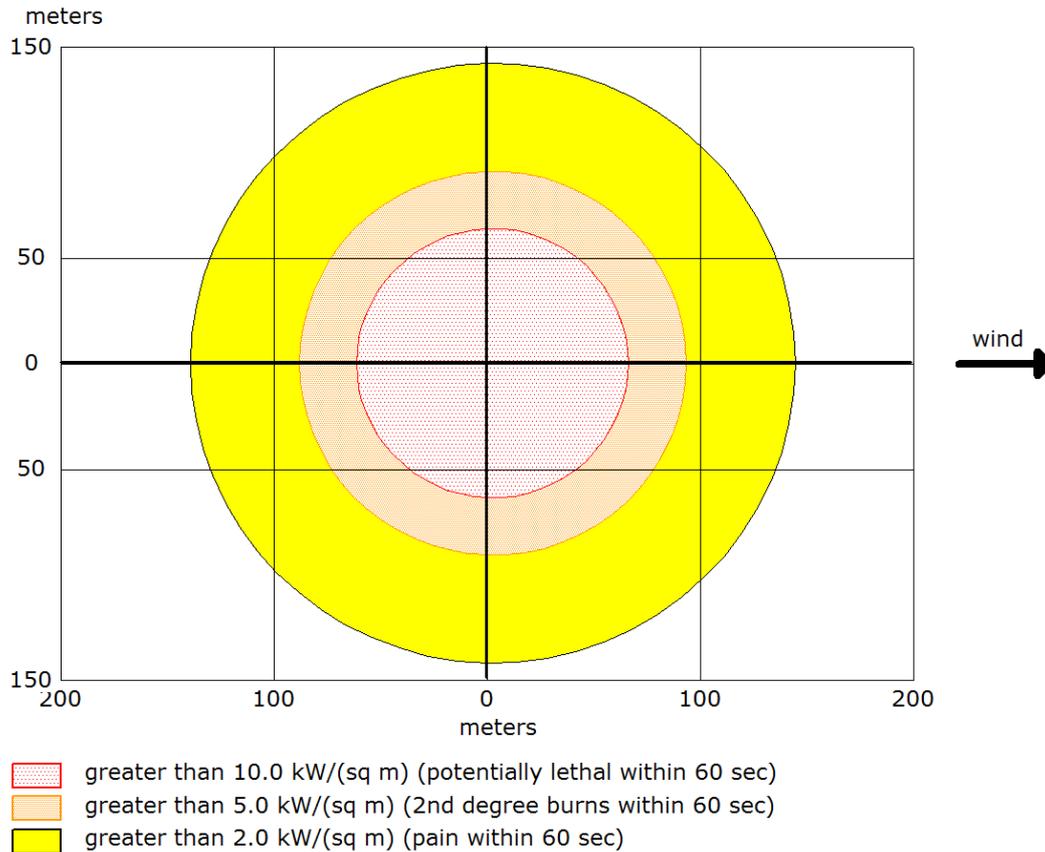
Yellow: 54 meters --- (2.0 kW/ (sq. m) = pain within 60 sec)

**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 27m 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 1.10** below.

**Figure 1.10 Threat Zone Plot – OCS Storage Tank Leak (300mm dia)**



Source: ALOHA

**THREAT ZONE:**

Threat Modeled: Thermal radiation from pool fire

Red : 66 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: 144 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 66m from the source with potential lethal effects within 1 minute.**

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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  $\sim 66$  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.			

### 1.1.3.3 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.

### 1.1.3.4 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.

### 1.1.4 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.

#### 1.1.4.1 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.

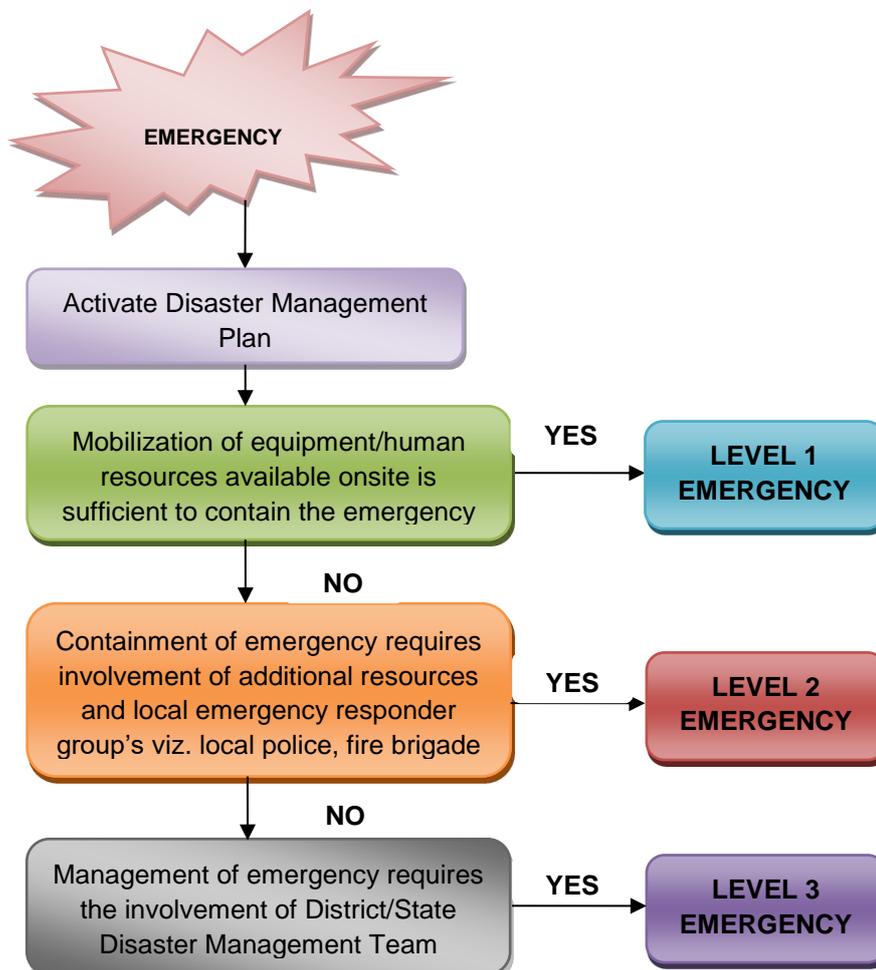
#### 1.1.4.2 Emergency Classification

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

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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 1.11**.

**Figure 1.11 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:

### 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.

### 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 power plant

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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.

### *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 power plant 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).

#### **1.1.5 Preventive and Mitigation Measures for Blow Outs**

Blowouts being events which may be catastrophic to any well operation, it is essential to take up as much a preventive measures as feasible. This includes:

- Necessary active barriers (eg. Well-designed Blowout Preventer) be installed to control or contain a potential blowout.
- Weekly blow out drills be carried out to test reliability of BOP and preparedness of drilling team.
- Close monitoring of drilling activity be done to check for signs of increasing pressure, like from shallow gas formations.
- Installation of hydrocarbon detectors.
- Periodic monitoring and preventive maintenance be undertaken for primary and secondary barriers installed for blow out prevention, including third party inspection & testing
- An appropriate Emergency Response Plan be finalized and implemented by OIL.
- Marking of hazardous zone (500 meters) around the well site and monitoring of human movements in the zone.
- Training and capacity building exercises/programs be carried out for onsite drilling crew on potential risks associated with exploratory drilling and their possible mitigation measures.
- Installation of mass communication and public address equipment.
- Good layout of well site and escape routes.

Additionally, OIL will be adopting and implementing the following Safe Operating Procedures (SOPs) developed as part of its Onsite Emergency Response Plan to prevent and address any blow out risks that may result during drilling and work over activities:

- Blow Out Control Equipment
- Choke lines and Choke Manifold Installation with Surface BOP
- Kill Lines and Kill Manifold Installation with Surface BOP
- Control System for Surface BOP stacks
- Testing of Blow Out Prevention Equipment
- BOP Drills

##### **1.1.5.1 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;

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- 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.

#### **1.1.5.2 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.

#### **1.1.5.3 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 CO<sub>2</sub>) and automated fire extinguishers shall be provided at strategic locations with a clear labelling of the

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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.

#### *1.1.5.4 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

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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.

#### *1.1.5.5 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.

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