

POST INSPECTION MEMORANDUM**Inspector:** Scott Rukke-UTC**Reviewed:** David Lykken-UTC**Peer Review:** Tom Finch - PHMSA *TF 11/20+23/09***Follow-Up Enforcement:** ~~██████████~~**Director Approval*** *OT* 11/25/09**Date:** 11/17/2009**Operator Inspected:** ~~Williams Gas Pipeline~~**OPID:** 13845**Region:** Western**Unit Address:**

42612 East Christy Road

P.O. Box 330

Plymouth, WA 99346

Unit Inspected: ~~Plymouth LNG~~**Unit ID:** ~~1155~~**Unit Type:** Liquefied Natural Gas Plant**Inspection Type:** Standard**Record Location:** On-site at above address**Inspection Dates:** November 9 to 12, 2009**AFOD:** 4**SMART Activity Number:** 123897**Operator Contact:** Lauri Duncombe**Phone:** (801) 584-6509**Fax:** (801) 584-6988**Emergency:** (800) 972-7733**Unit Description:**

Liquefied Natural Gas Plant consisting of two storage tanks with a capacity of 348,000 bbl each and 90 feet tall. The liquefaction process consists of two, 6MMCFD cold towers, each operated as an integrated cascade loop system. The facility includes four vaporizers rated at 75MMCFD. LNG 1 was placed in operation in 1975 and LNG 2 was placed in operation in 1979. Both LNG system 1 and LNG system 2 share use of the four vaporizers. The facility is located approximately 45 minutes southwest of Pasco, Washington, west of Interstate 395 and south of Highway 82, in Plymouth, Washington. The Plymouth LNG facility uses an integrated cascade loop liquefaction process to produce and store LNG gas during the summer months as a peak shaving operation. The LNG can then be vaporized and injected into the pipeline during times of higher than normal demand. LNG boil off is re-injected into the pipeline.

Facilities Inspected:

Operations and maintenance records were reviewed. A field inspection was conducted of fire eyes, gas detectors, random CP reads, rectifier maintenance, atmospheric corrosion, supports, tank foundations and walls, ESD's, fire protection equipment, backup power, control room, fencing and emergency valves.

Persons Interviewed:

Dave Otnes
Von Studer
Lauri Duncombe
Ron Ehrstrom
Les Edwards

Probable Violations/Concerns:

No violations or concerns.

Follow up on the history of prior offenses that are still open:

Prior Offenses (for the past 5 years)		
CPF #	What type of open enforcement action(s)?	Status of the regulations(s) violated (Reoccurrence Offenses, Implement a NOA Revision, Completion of PCO or CO, and etc...)

Recommendations:

Move this inspection unit into the biennial rotation currently in place for other WA interstate inspection units. The next inspection would occur in CY2011.

Comments:

Attachments:

- PHMSA Form 4-Standard Inspection Report of an LNG Facility
- PHMSA Form 15-OQ Field Inspection Protocol