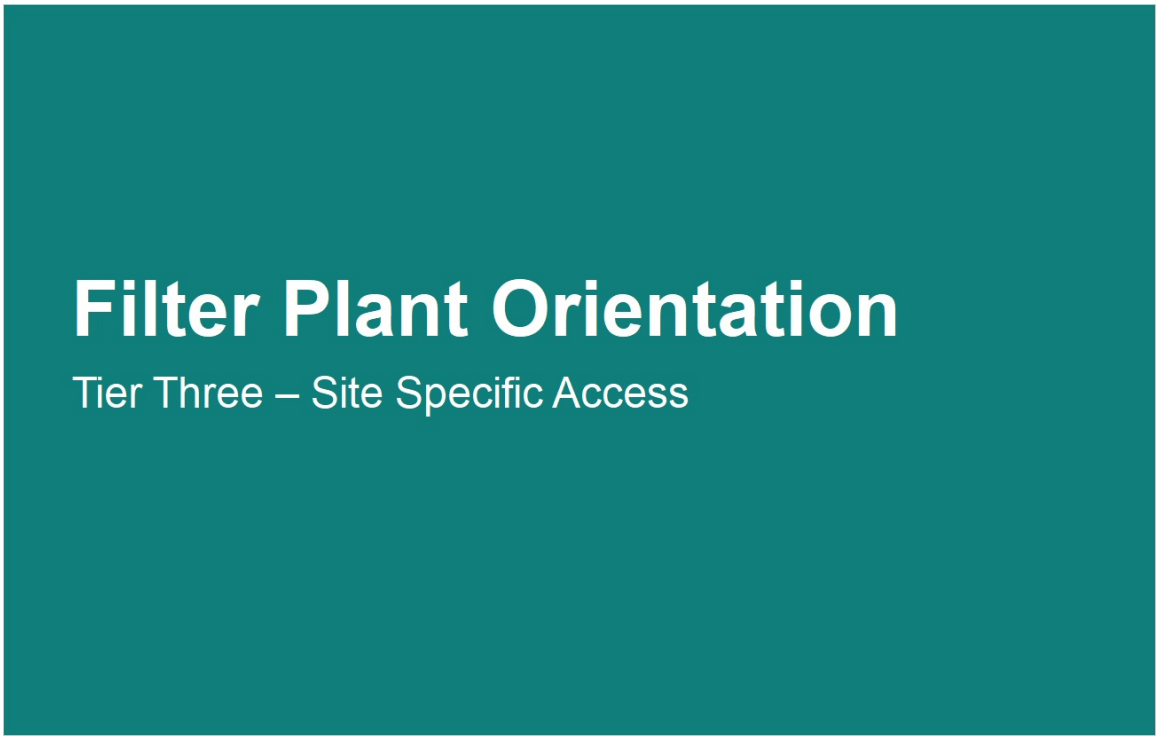
Tier 3: Filter Plant Orientation - 18

1. Filter Plant Orientation

1.1 Filter Plant

1.2 Filter Plant



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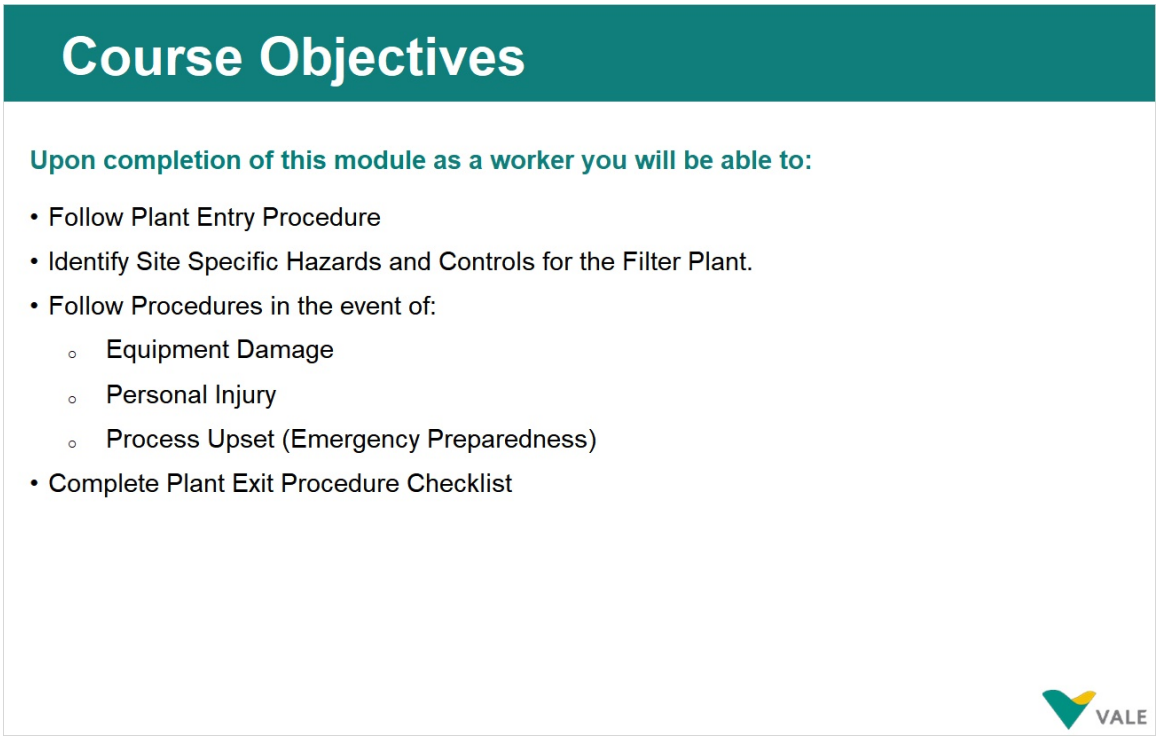
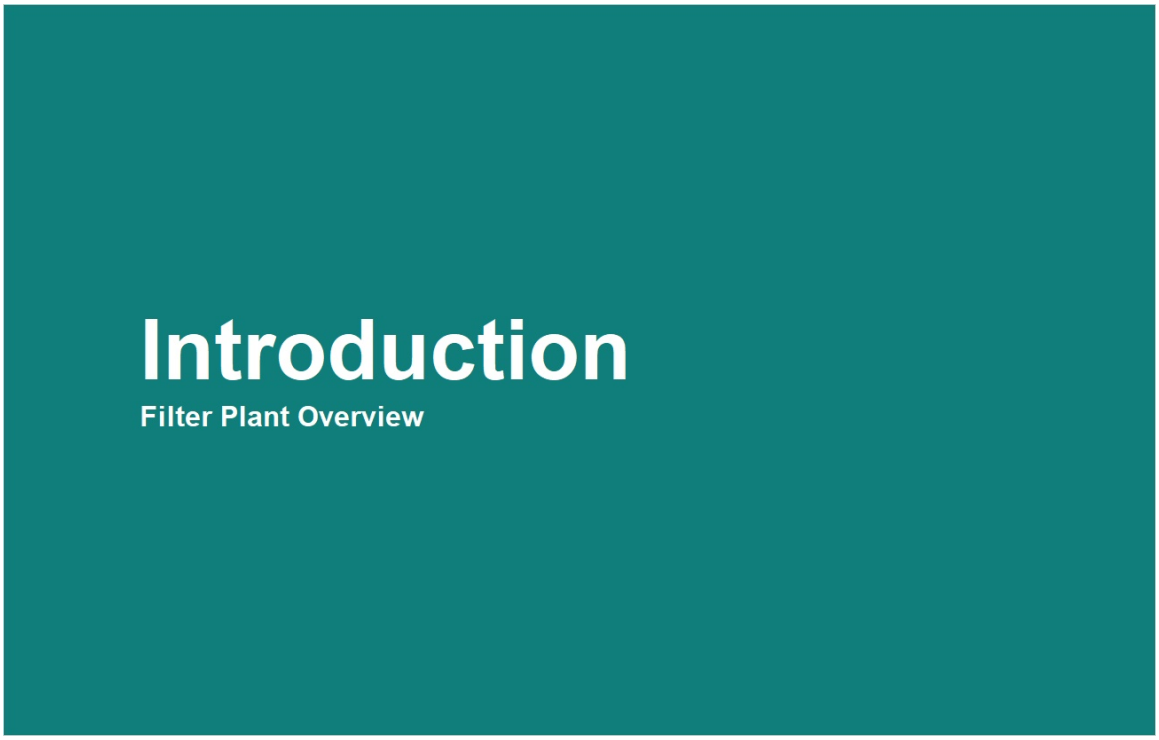
1.3 Course Objectives



1.4 Introduction



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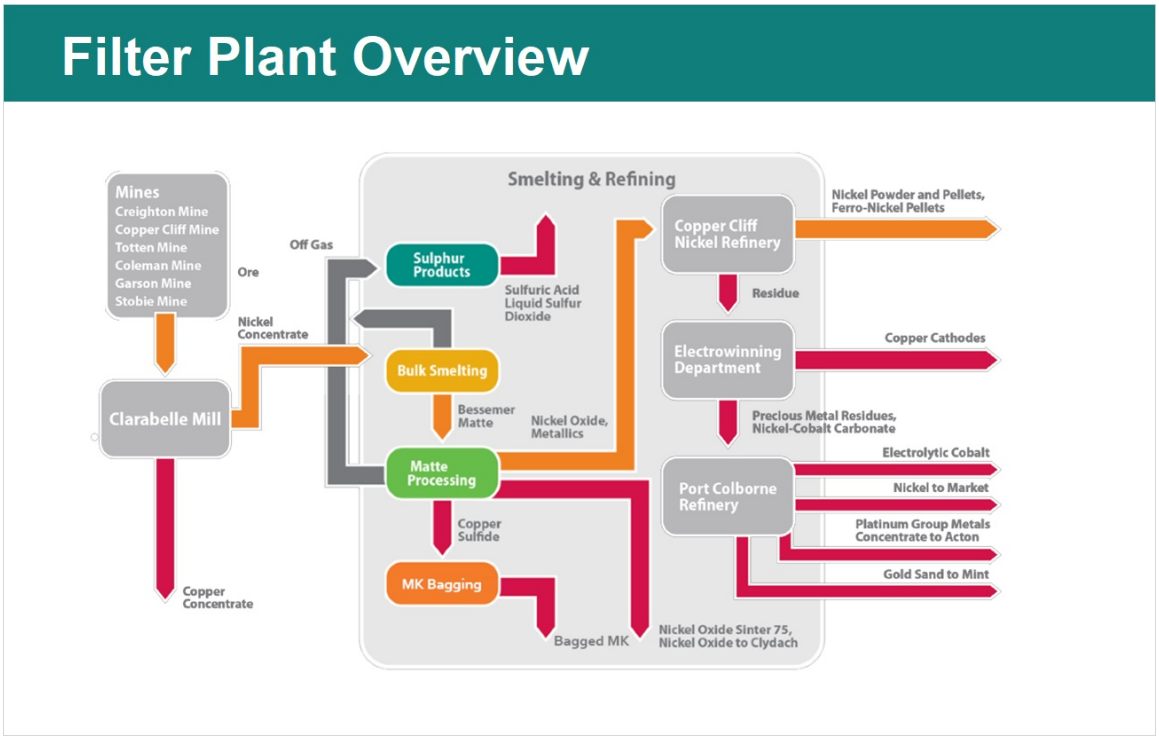
1.5 Filter Plant Overview



1.6 Filter Plant Overview

Filter Plant Overview

The purpose of the Filter Plant is to supply the Copper Cliff Smelter with dry feed for the furnaces. Feeds include concentrate from Clarabelle Mill, dry reverts and other dry feeds.

1.7 Filter Plant Overview

Filter Plant Overview

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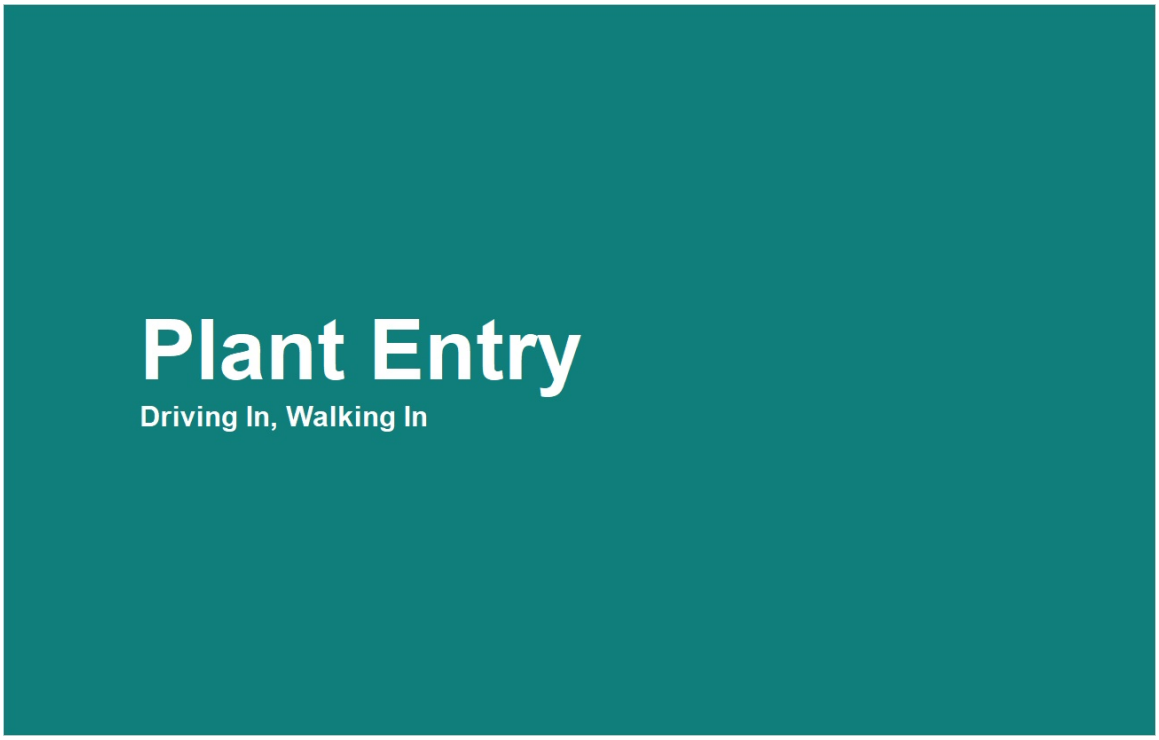
The Weak Acid Treatment Plant receives weak acid slimes from:

- The existing gas cleaning equipment associated with the Flash Furnaces,
- The Converter Wet Gas Cleaning Plant
- The FBR Wet Gas Cleaning Plant

Slimes paste containing the insoluble nickel components are recovered and sent to the Smelter.

The arsenic component of the overflow is treated and sent to the Tailings area.

1.8 Plant Entry

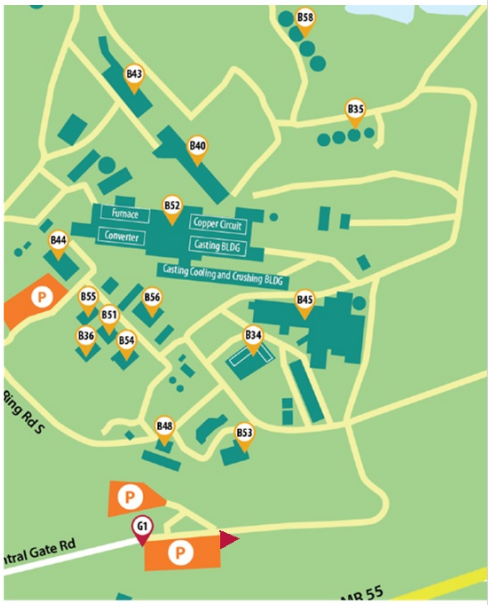


1.9 Approaching The Plant

Approaching The Plant

Using the main gate entrance to the Smelter, follow the main route and turn left on Ring Road South at the 'Y', continue to designated door.

Some workers may have access through the General Office gate.



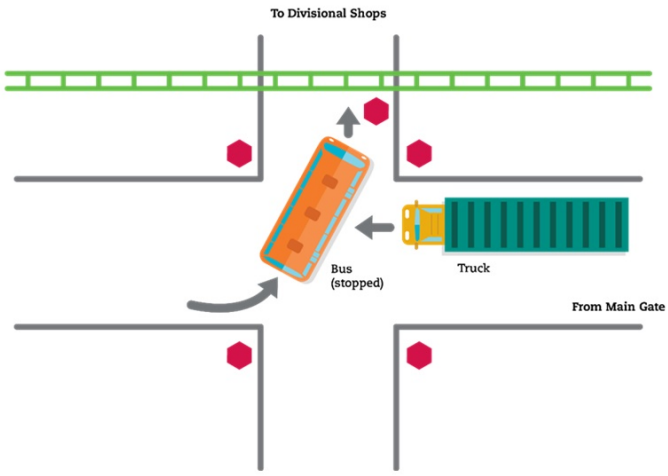
1.10 Approaching The Plant

Approaching The Plant

At the intersection of the Central Gate Road and Divisional Shops Road, there is a history of near miss collisions.

Be aware that adjacent to this intersection lies a set of railway tracks with an additional stop sign.

Be sure that before proceeding through the intersection that vehicles at this stop sign are completely clear of the crossing before you proceed through the 4-way stop.

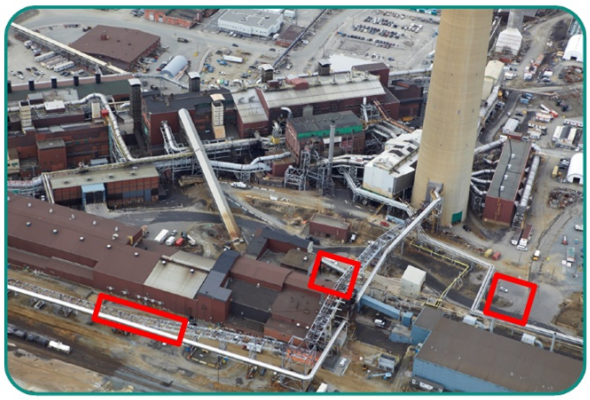


1.11 Parking Lot 1

Parking

The Parking Lot for the Filter Plant is very limited and workers are encouraged to park in contractor assigned areas such as parking at the Main Gate or Benjamin Drive Parking Lot.

If parking near the plant is necessary, contact your Vale contact person to see which area is most appropriate.



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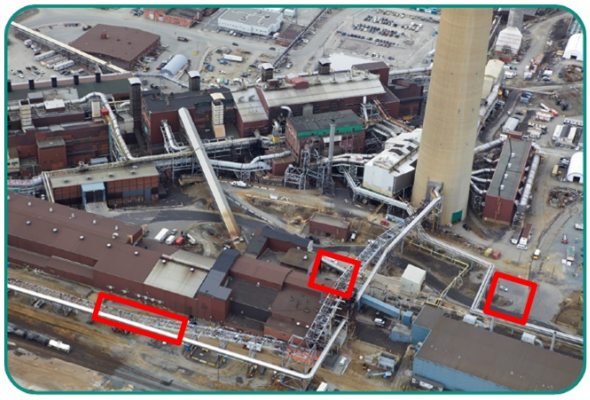

off (Slide Layer)

Parking

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If parking near the plant is necessary, contact your Vale contact person to see which area is most appropriate.

1.12 Plant Entry

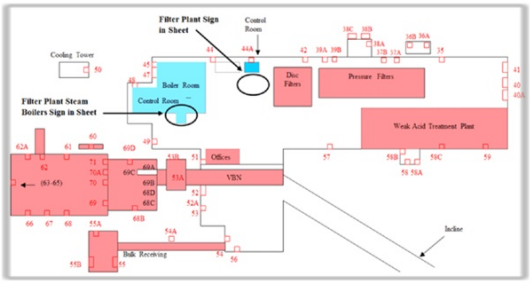
Plant Entry

All contractors and visitors going to the Filter Plant must proceed to door 44A and sign in with the Filter Plant Control Room:

- The sign in book is located outside the Filter Plant Control Room

Before signing in or out, workers must be authorized by their Vale Contact Person.

Be sure to write legibly when filling in the Sign-In Sheet



2. Site Specific Hazards

2.1 Plant Hazards and Controls

2.2 Site Specific Hazards

Site Specific Hazards

Using the tools that you learned in Tier 1 Orientation, ensure to use operation controls to mitigate risk associated to the identified hazards.

Be Aware
Be aware of my surroundings and the risks around me.

Follow Policies & Procedures
Our internal policies and procedures guide us in doing our work in a manner that reduces risk.

The following section lists identified hazards that may be encountered in the work you're doing. Knowing if these hazards apply to your work can be found through:

- Vale Contact Person
- PHA/PHR
  (or other Risk Assessment Tools)
- SLAM

2.3 Site Specific Hazards

Site Specific Hazards

The Filter Plant has workplace specific hazards that have been identified and need to be controlled. These include but are not limited to:

- Nickel
- Reagents
  - Lime
  - Magnesium Hydroxide
  - Flocculent (Magnafloc 338)
  - Sodium Hydroxide
- Moving Equipment
- Overhead Crane
- Traffic Congestion
- SO_2
- Load Restricted Areas
- Process Contaminants

Communicate with your Vale contact person concerning the procedures pertaining to designated substances, product locations, and process hazards in your work area.
*** Separate training is required for handling / working with designated substances.**

2.4 Nickel - Hazard

Nickel - Hazard

Feed coming into the Filter Plant from the Voisey's Bay Nickel (VBN) Facility contains significant amounts of Nickel.

Part of the feed is categorized as "Nickel Insoluble" and is the primary species throughout the Copper Cliff Complex.

There is also "Soluble Nickel" and "Nickel Sub-Sulphide" (a form of insoluble).

Soluble Nickel: Contains smaller particles that can be excreted through the body and do not accumulate. Soluble nickel is found in Separation and FBR.

Insoluble Nickel: Known to accumulate in tissue such as lungs, where, depending upon particle size, it may only slowly be absorbed over time. Insoluble nickel is found in FBR and Shipping.

2.5 Nickel - Hazard

Nickel - Hazard

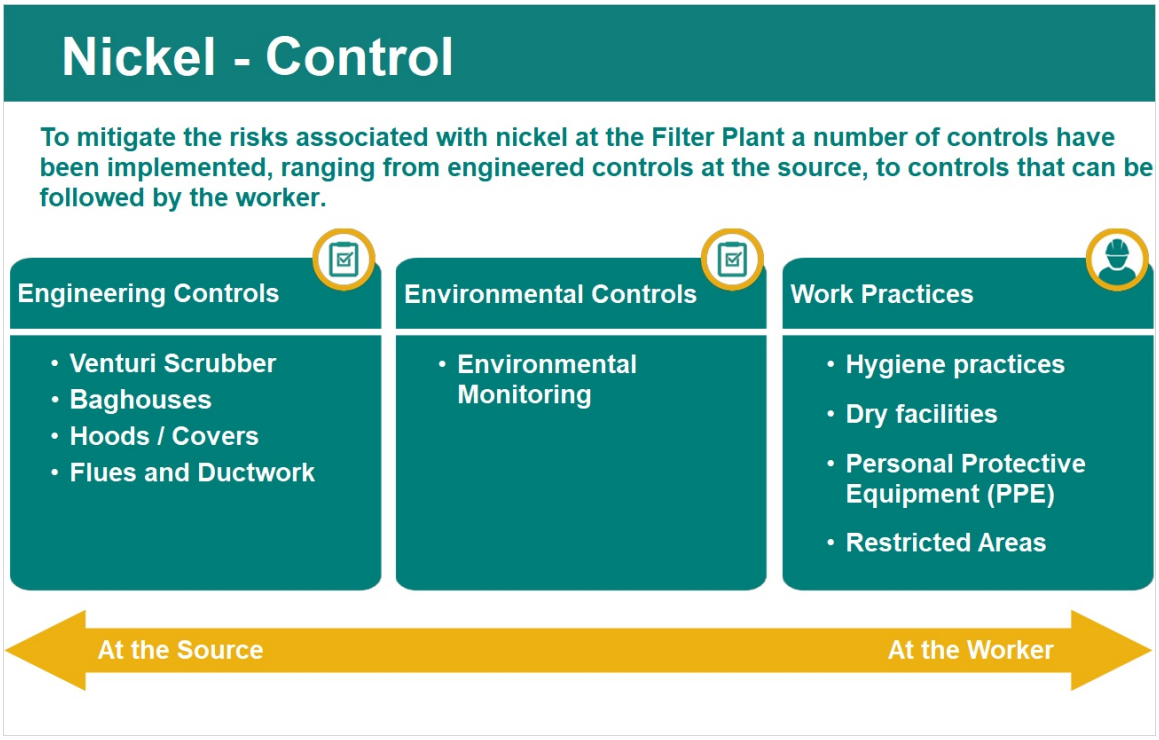
How does Nickel enter my body?

- Primary routes of entry are inhalation and ingestion.
- Skin absorption (although very little is absorbed through skin and into bloodstream).

How can it affect me?

- Continuous exposure to nickel dust increases risk of long term lung damage and in past, has been associated with increased respiratory cancers.
- Allergic contact dermatitis or “nickel itch” can result after prolonged and direct contact.
- Reproductive toxicity (female effect- pregnancy effects-baby developmental problems).

2.6 Nickel - Control



2.7 Nickel - Control

Nickel - Control

Engineering Controls

To reduce the amount of dust at the source, the Filter Plant has a number of engineered controls to reduce the soluble nickel exposure in the area:

Diverter Baghouse

Located in the VBN Building, removes particulates from the air.

Venturi Scrubber

Removes Particulates from the air at drop off points between conveyors.

2.8 Nickel - Control

Nickel - Control

Environmental Monitoring

Air Sampling is done by a Senior Environmental Analyst. Personal Sampling (wearing a dust monitor) determines personal dust exposure.

Environmental Sampling determines dust levels in the work place. Results assist in identifying problem areas and implementing adequate controls.

Worker Wearing a Dust Monitor

2.9 Nickel - Control

Nickel - Control

PPE – Respirator Protection

In order to protect workers from residual dust concentrations, adhere to the Mandatory Respirator Dust areas from the VBN facility to the incline of #29 and #30 conveyor which stipulates:

All employees, contractors, or visitors entering the VBN Handling facility or entering #29 and #30 Conveyor up the gallery process areas shall wear at a minimum, an approved ½ face respirator with combination particulate and gas cartridge.

In the Filter Plant a PAPR with combination particulate and gas protection is also acceptable.

All other areas in the Filter plant require workers to carry a ½ mask at all times.

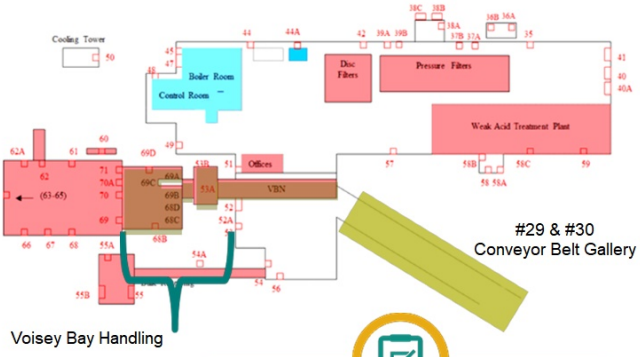
2.10 Nickel - Control

Nickel - Control

PPE – Respirator Protection

The Filter Plant requirements are that workers throughout the entire plant, at a minimum, shall carry a ½ face respirator on their person.

All workers are required to be clean shaven at all times to ensure a proper face to facepiece seal.



In addition, there are two areas that are mandatory to wear a ½ face respirator at all times:
The 29/30 Conveyor Belt Gallery
The Voisey Bay Handling (VBN) building.

2.11 Reagents (General) - Hazard

Reagents (General) - Hazard

Sodium Hydroxide

In addition to the hazards with general reagents, Sodium Hydroxide poses an increased risk of chemical burns that workers in the area should be aware of :

- Sodium Hydroxide causes severe eye burns
- Small quantities can result in permanent damage and or loss of vision.
- If Sodium Hydroxide is swallowed, severe chemical burns to mouth, throat and stomach will occur
- Brief contact with the skin may cause severe burns

2.12 Reagents (General) - Control

Reagents (General) - Control

To mitigate the risks associated to reagents, the Filter Plant has implemented several controls:

- Emergency Showers in the Weak Acid Treatment Plant area
- Emergency Eyewashes
- Job procedures for offloading chemicals (i.e. Sodium Hydroxide)
- Spill kits in areas of potential spill
- Standard PPE requirements apply and in addition:
  - Neoprene gloves (if required)
  - an approved ½ face respirator (if required)
  - Face shield (if required)

There are specific job procedures for offloading and handling Sodium Hydroxide.

2.13 Reagents (General) - Control

Reagents (General) - Control

Remember to apply standard good hygiene practices

- No smoking, drinking and/or eating in the workplace.
- Before smoking or eating in designated areas remove PPE, and ensure that all exposed skin surfaces are washed with soap and water.
- PPE must be removed prior to entering the lunchroom.
- The Contractor Hygiene Compliance Plan ensures that washing facilities and storage lockers are made available so that contaminants are not brought home.

2.14 Moving Equipment - Hazard

Moving Equipment - Hazard

The purpose of the Filter Plant area is to receive Ontario Division feed in slurry form and dry the feed.

The dry feed is then mixed with reverts and sent to the Smelter furnaces for further production. In doing this, the Filter Plant utilizes several pressure filters and conveyors.

The hazards that relate to this type of equipment are:

- The possibility of entanglement in rotating or moving equipment
- Exposure to noise and vibration

2.15 Moving Equipment - Control

Moving Equipment - Control

To maintain the safety of employees working around moving equipment, the following controls are in place:

- Guarding installed on rotation machinery
- Interlocks and shutdown devices
- Local and remote stop stations
- Designated walk areas
- Lubrication and maintenance programs are maintained
- Light curtains on pressure filters

Report any leaks, vibrations or abnormal noise to an operator

2.16 Overhead Crane - Hazard

Overhead Crane - Hazard

There is a 10T Crane in the Main aisle and a 7.5T crane in the Weak Acid Treatment plant.

Hazards associated to crane movement include:

- Suspended loads
- Contact with stationary equipment

2.17 Overhead Crane - Control

Overhead Crane - Control

To maintain the safety of employees working around cranes, the following controls are in place;

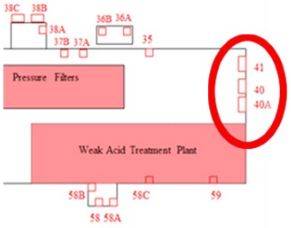
- The main aisle is equipped with several red flashing lights to indicate crane activity. If lights are activated in a particular area, be aware of crane activity and the possibility of overhead loads.
- Locate and be aware of the crane's position and status prior to entering the aisle.
- Do not walk under a suspended load.
- If access to an area where the crane is performing a lift is required, contact the craneman for further instructions.

Listen and watch for crane travel before crossing any part of an operating area

2.18 Door #40 – Hazard and Control

Door #40 – Hazard and Control

Door #40 is the main unloading area for most reagents for the Filter Plant. During daytime hours, there is increased activity with mobile equipment and pedestrians.
When going into this area, especially when backing in a truck, visibility is hampered as your eyes try to adjust from brightness to darkness; in this there is increased risk of making contact with other equipment or pedestrians.



Prior to backing into Door #40 at the Filter Plant, workers must contact the Filter Plant Control Room Operator at 705-682-8704. The operator will meet drivers at the door to help them back in.

2.19 Traffic Congestion – Hazard and Control

Traffic Congestion – Hazard and Control

Due to truck congestion and blind corners, the area between area 10 and door #40 posses the risk of collision, especially at the intersection.

Street traffic lights have been installed to mitigate the risk by providing more controlled traffic patterns:

- Obey the traffic lights on the one way road on the South East sides
- To activate the light, simply pull up to the street light marker.

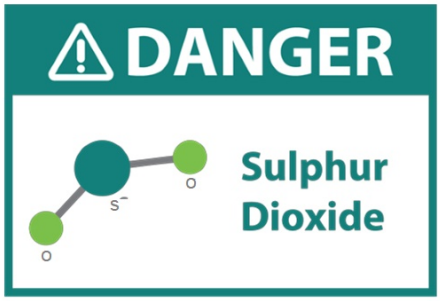
2.20 Sulfur Dioxide (SO2) - Hazard

Sulfur Dioxide (SO_2) - Hazard

The Weak Acid Treatment Plant receives effluents from the Smelter's processes.

The effluent contains SO_2 gas and although it is normally contained within the system, there is always a potential for spills and leaks. SO_2 is a colourless gas, with a sharp, pungent, suffocating or choking odor.

SO_2 is soluble in water. In water, Sulphur Dioxide is converted to sulfurous acid; this acid is what causes irritation of the nose and throat, rhinorrhea, choking, cough and in some instances reflex bronchoconstriction with increased pulmonary resistance.



2.21 Sulfur Dioxide (SO2) - Control

Sulfur Dioxide (SO_2) - Control

The controls for SO_2 gas in the Filter Plant are mostly geared to detection.

If you encounter a gas leak anywhere in the Filter Plant, especially in the Weak Acid Treatment area, report the leak to the Control Room Operator and leave the area immediately and maintain a position upwind from the hazard and proceed to the nearest safe assembly area.

Additional Controls include:

- Workers mandated to carry a ½ face mask on them at all times
- Clean Shaven Policy
- Several SO_2 alarms on the south side of the WATP area that triggers when gas reaches 5ppm.
- The alarm is a continuous tone in the field and also alarms in the control room.

The Filter Plant Control Room Operator will provide instruction on how to respond in the case of an SO_2 Leak

2.22 Load Restricted Areas - Hazard

Load Restricted Areas - Hazard

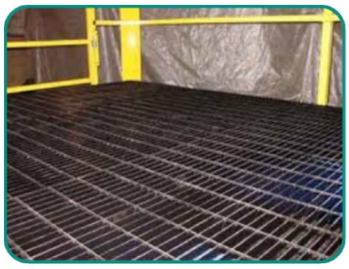
The Filter Plant has areas that are not designed for heavy traffic such as mobile equipment.

The grating in the Weak Acid Treatment Plant is designed for pedestrian traffic only.

Mobile equipment is restricted from accessing this area.

The platform south of control room by the office ramp is designed for equipment with a maximum weight of 1300 lbs/wheel.

Mobile equipment use in this area is limited.

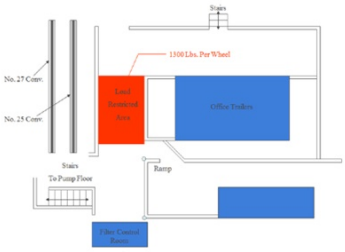


2.23 Load Restricted Areas - Control

Load Restricted Areas - Control

To manage pedestrians, equipment and general traffic, the Filter Plant has identified all restricted areas with appropriate signage.

- Signage on the walls around the floor grating area to remind workers that only human traffic is allowed in the area.
- In areas where equipment is allowed provided it's within the allowable weight, signage is also present.
- When using the load restricted area with mobile equipment, be sure to consider the load being carried by the equipment as well.



2.24 Filter Dust Chute - Hazard

Filter Dust Chute - Hazard

The Disc Filter chutes in the Feed Preparation Area tend to plug with feed over a period of time.

Operators are required to use an air lance to blow the chutes down.

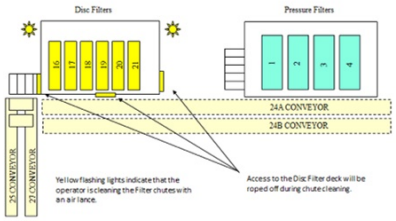
During the process of blowing the chutes, dust sometimes becomes airborne, posing the hazard of airborne insoluble nickel dust to workers in the area.

2.25 Filter Dust Chute - Control

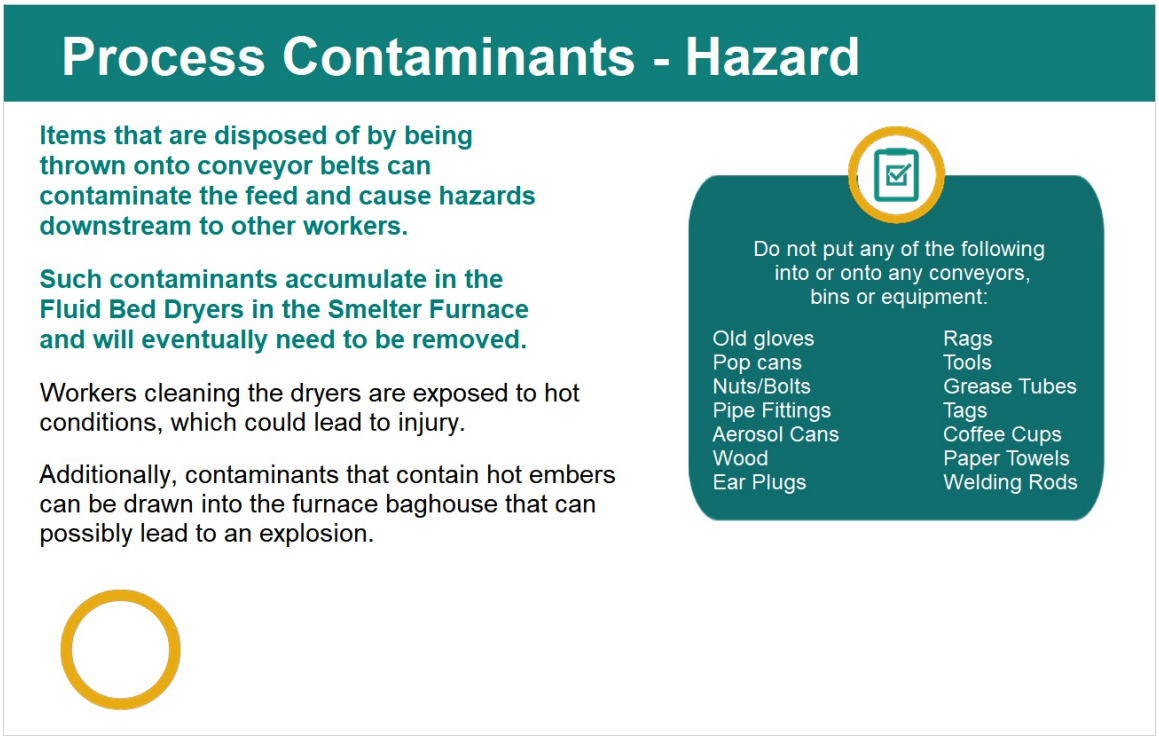
Filter Dust Chute - Control

To minimize the workers' risk of exposure to insoluble nickel dust, the Filter plant has installed yellow flashing lights that are activated when workers are blowing chutes.

- The operator will restrict all access to the Disc Filter deck by chaining off all access.
- The operator will activate an amber light at either end of the Filter Deck sub floor beneath the deck.
- Once the amber lights are activated, all personnel using the sub floor must wear their ½ face respirator when walking through the subfloor.
- When the operator has completed their task, the operator will remove the chains and turn off the amber light.

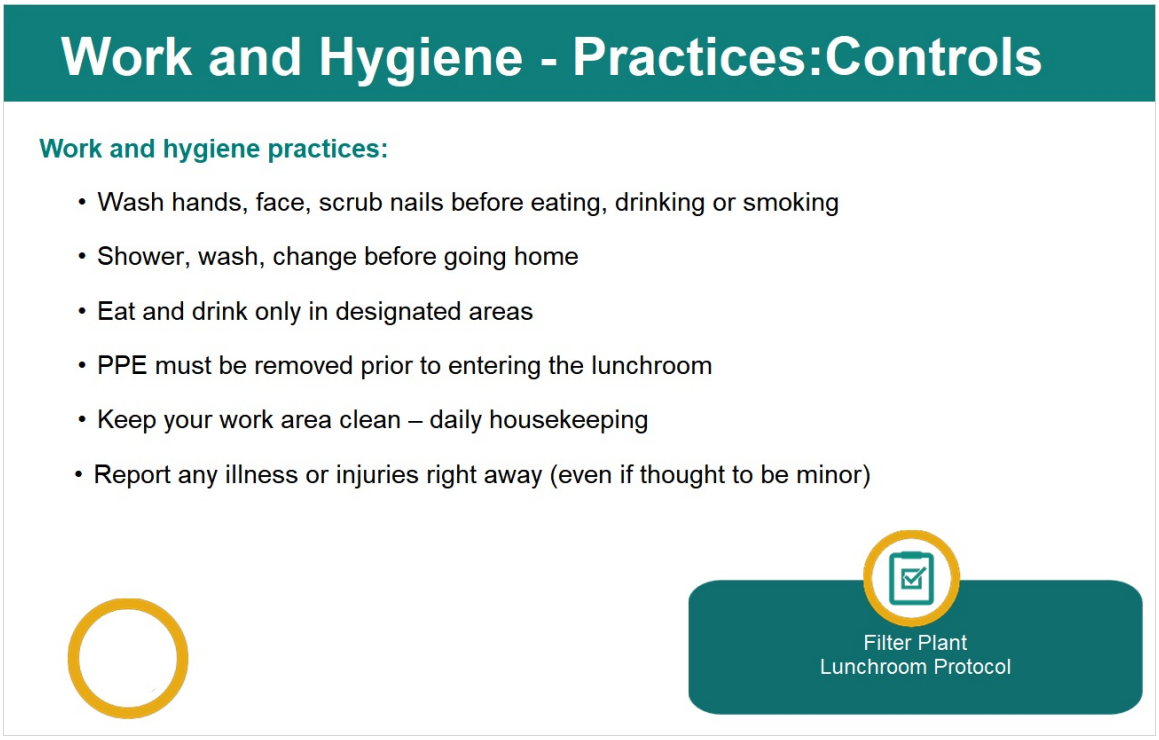


2.26 Process Contaminants - Hazard

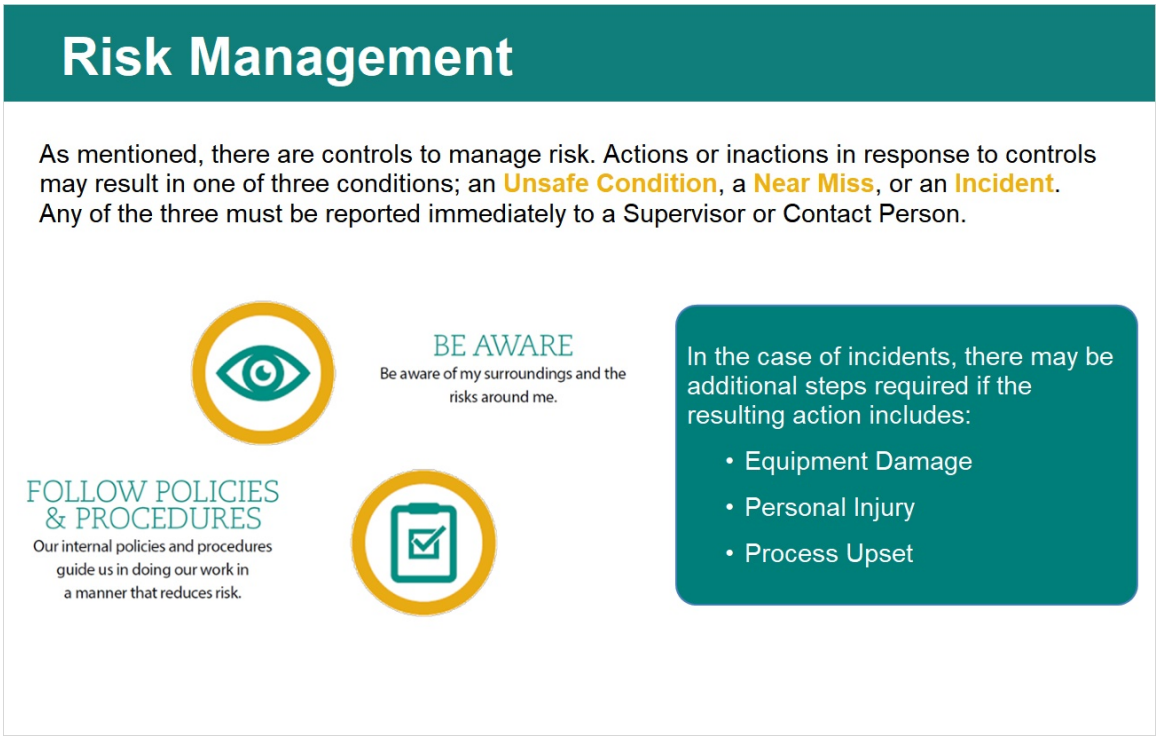


2.27 Process Contaminants - Control

2.28 Work and Hygiene - Practices:Controls

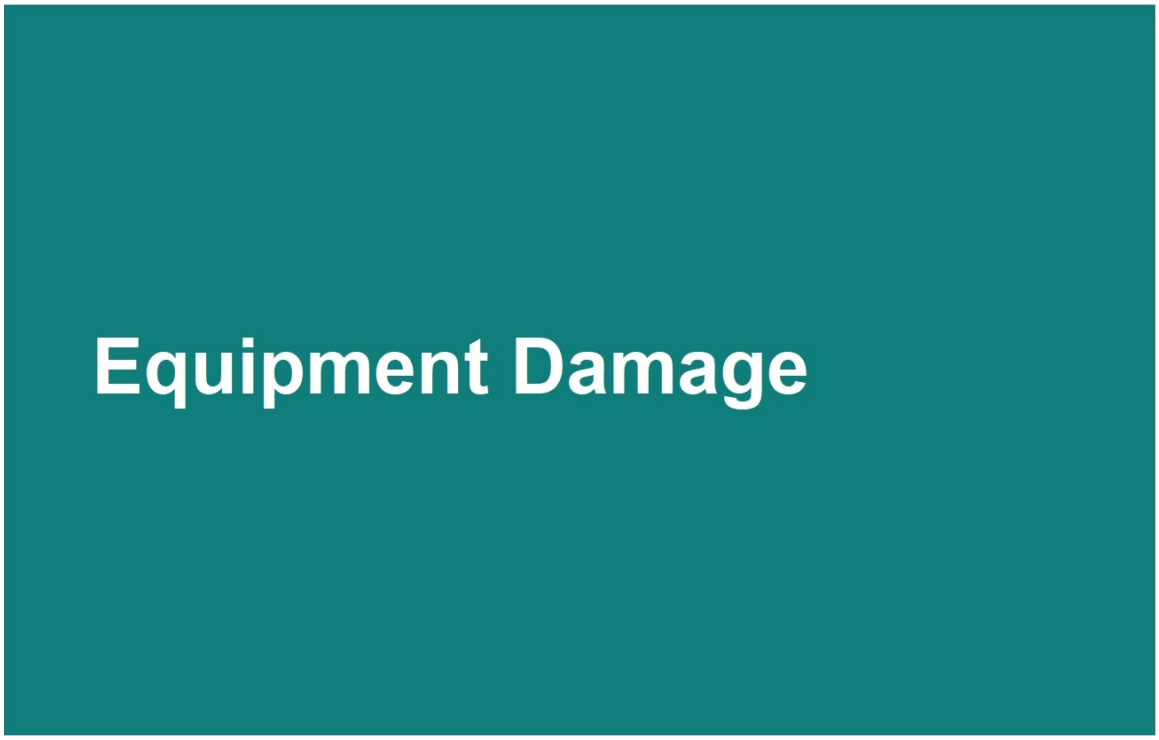


2.29 Equipment Damage

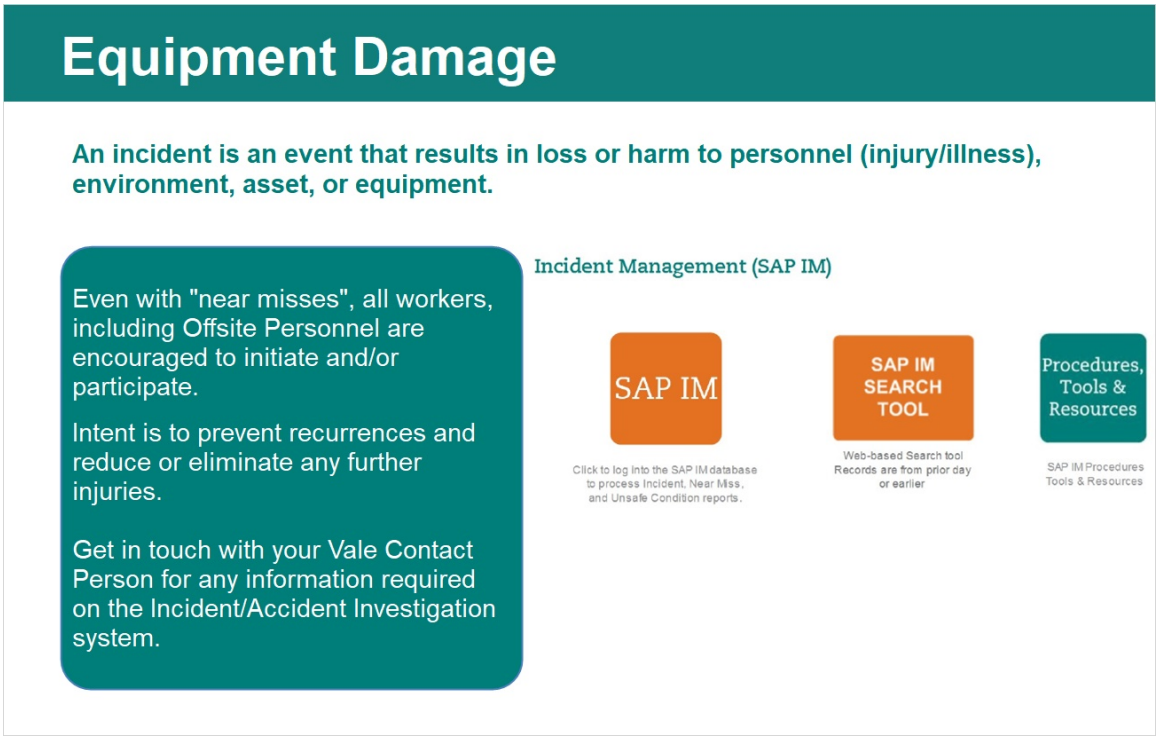


3. Equipment Damage

3.1 Equipment Damage



3.2 Equipment Damage



4. Personal Injury

4.1 Personal Injury

4.2 Personal Injury

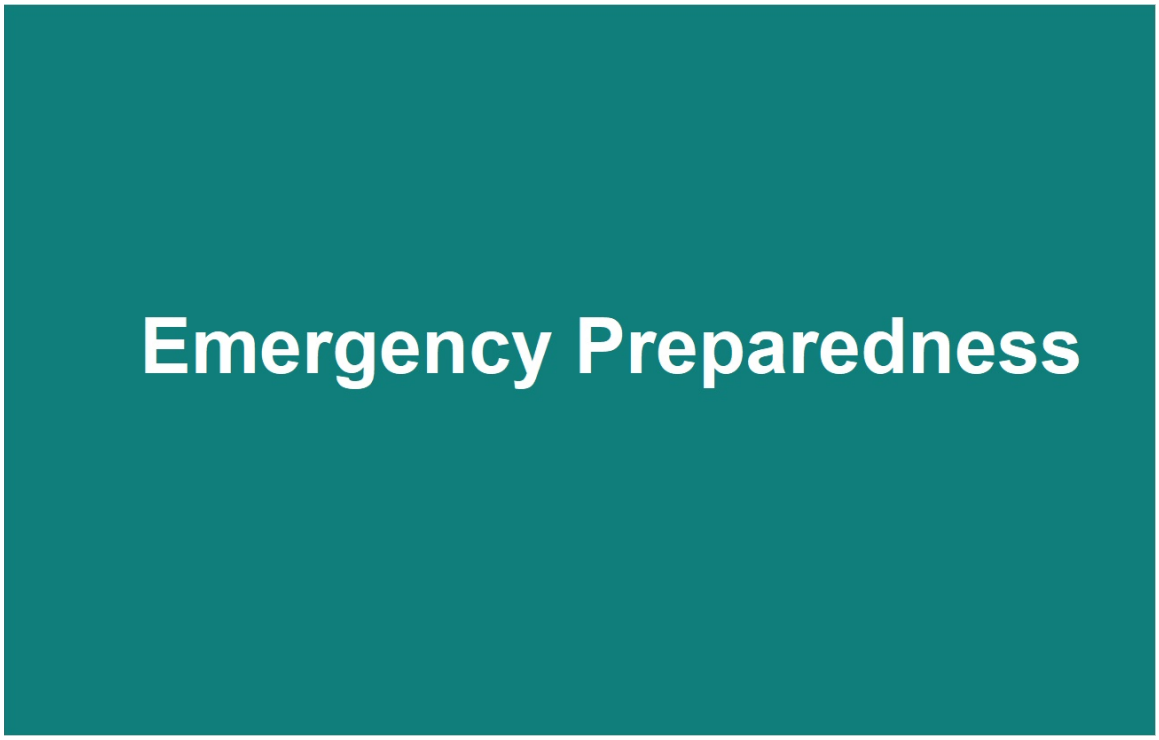
Personal Injury

In the case of personal injury, generally, contact your Supervisor then report immediately to # 1 First Aid located at door # 11 of building B41.

In the event you cannot physically report to First Aid, phone first aid at 705-682-6622.

5. Emergency Preparedness

5.1 Emergency Preparedness



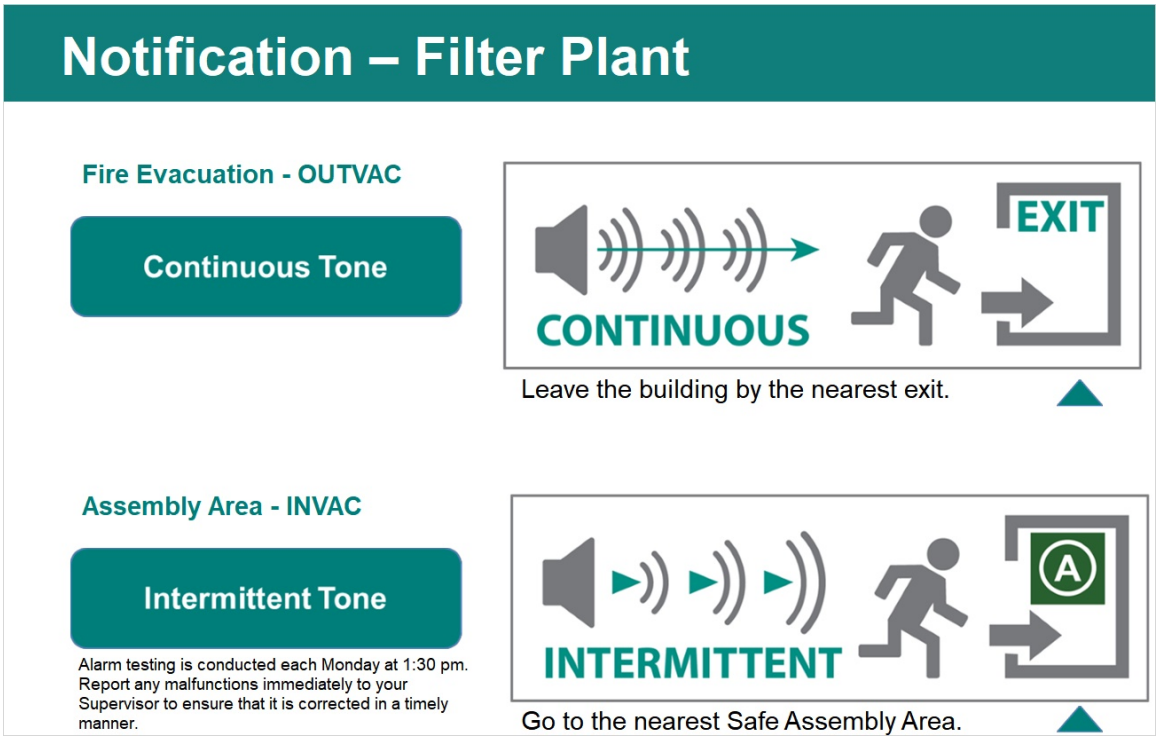
5.2 Emergency Preparedness

Emergency Preparedness

The Surface Tier 2 Orientation provided guidance on the application of Emergency Preparedness including activating an emergency and how to classify.

The following is how to respond to an emergency at the Filter Plant.

5.3 Notification – filter plant

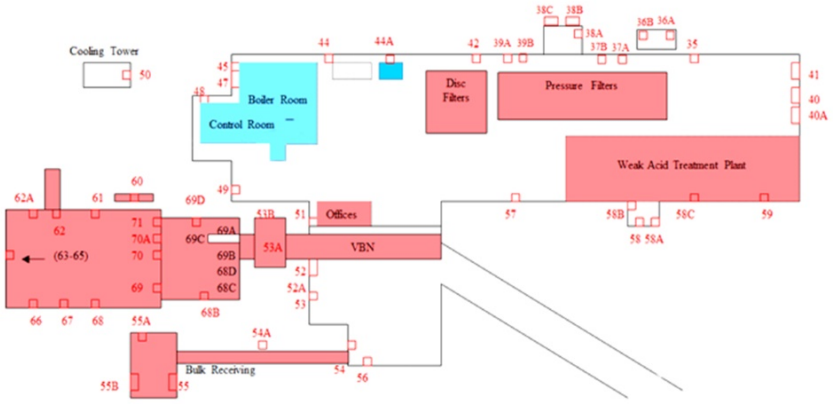


5.4 Fire Evacuation Area - OUTVAC

Fire Evacuation Area - OUTVAC

In the event of a fire evacuation at Filter Plant, proceed immediately to the following fire evacuation area located outside Door #44A and await further instructions.

Do not leave the evacuation area until instructed to do so, or until the all clear is given.



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Fire Evacuation Area - OUTVAC

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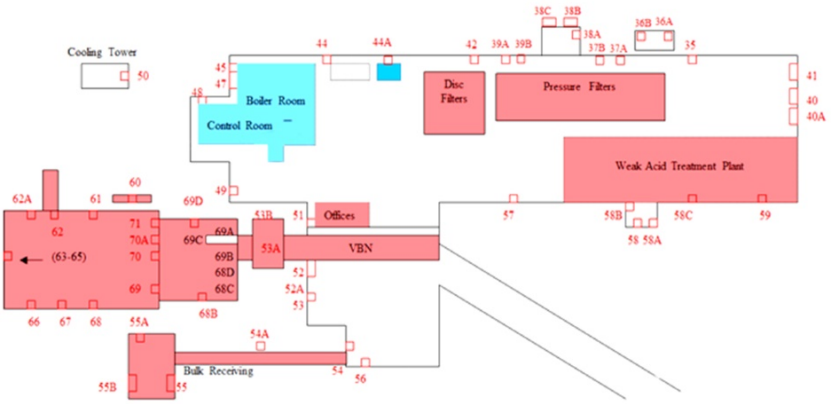
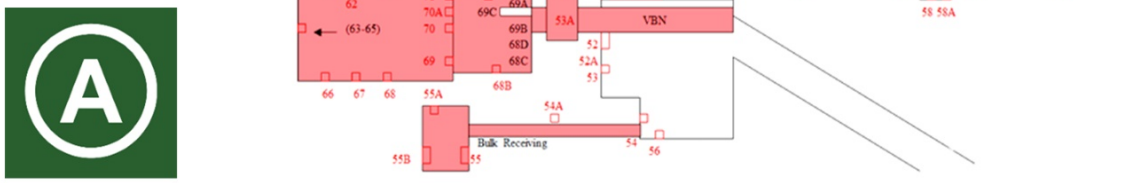


5.5 Safe Assembly Area - INVAC

Safe Assembly Area - INVAC

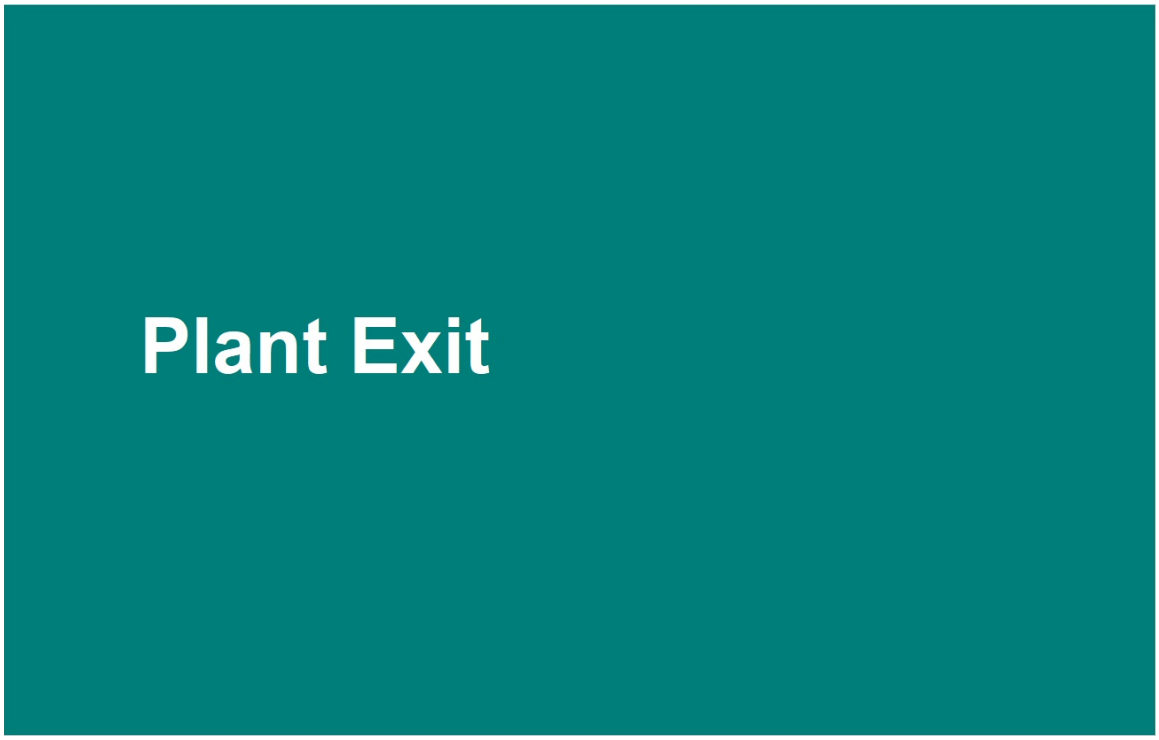
Upon hearing an intermittent alarm, proceed immediately to the Filter Plant safe assembly area which, is located in the lunchroom and await further instructions.

Do not leave the Safe Assembly area until instructed to do so, or until the all clear is given.



6. Plant Exit

6.1 Plant Exit



6.2 Plant Exit

Plant Exit

Good work practices dictate that you close the loop on work you were doing to avoid creating risks or hazards for other work groups, cross shifts, or other work in the area. Here are some tasks to consider when getting ready to exit the plant to ensure the safety to you and those around you:

- ✓ **Housekeeping** – Is your worksite cleaned up after your job?
- ✓ **Personal Lock and Tag** – Has your personal protection been removed at the end of the shift.
- ✓ **Status Tagging** - Is there ongoing work that needs a status tag placed or is there equipment in Bad Order that needs to be identified?
- ✓ **End States** – Have you left the process in the proper state?
- ✓ **Waste Segregation** - Have you disposed of materials in the appropriate waste receptacles/bin/area?
- ✓ **Control room** – Do I need to let the control room know that I'm clear of an area?
- ✓ **Vale Contact Person** – do they need an end of shift report from me?
- ✓ **Permits** – do I need to close or hand in any permits?

When signing in and out, always wait for the operator to initial and authorize your access. Write legibly and ensure all details are written.

7. Orientation Review

7.1 Plant Exit

7.2 Plant Exit

Plant Exit

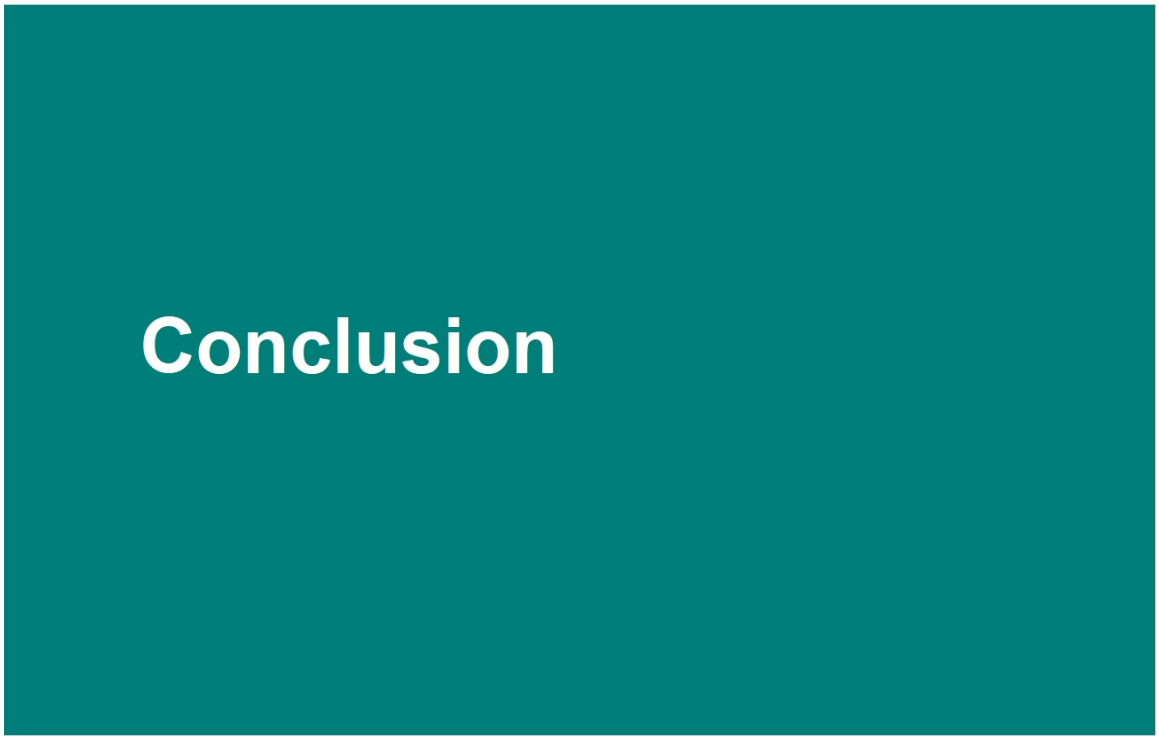
Good work practices dictate that you close the loop on work you were doing to avoid creating risks or hazards for other work groups, cross shifts, or other work in the area. Here are some tasks to consider when getting ready to exit the plant to ensure the safety to you and those around you:

- ✓ **Housekeeping** – Is your worksite cleaned up after your job?
- ✓ **Personal Lock and Tag** – Has your personal protection been removed at the end of the shift.
- ✓ **Status Tagging** - Is there ongoing work that needs a status tag placed or is there equipment in Bad Order that needs to be identified?
- ✓ **End States** – Have you left the process in the proper state?
- ✓ **Waste Segregation** - Have you disposed of materials in the appropriate waste receptacles/bin/area?
- ✓ **Control room** – Do I need to let the control room know that I'm clear of an area?
- ✓ **Vale Contact Person** – do they need an end of shift report from me?
- ✓ **Permits** – do I need to close or hand in any permits?
- ✓ **Sign out at the gate or other designated areas**

When signing in and out, always wait for the operator to initial and authorize your access. Write legibly and ensure all details are written.

8. Conclusion

8.1 Conclusion



8.2 Conclusion

Conclusion

This concludes the material for the Filter Plant Orientation. You should now have a working knowledge and understanding of:

- Plant Entry
- Site Specific Hazards and Controls for Filter Plant Procedures in the event of:
  - Equipment Damage
  - Personal Injury
  - Process Upset (Emergency Preparedness)
- Plant Exit Procedure

This Orientation provided information to access the Filter Plant. In order to feel comfortable with the area, you may arrange a field visit with your Vale Contact Person to specifically identify procedures provided in the Orientation.

Additionally, depending on the site or work you're doing, you may require task-specific information through either the local Learning & Development Group or your Vale Contact Person.

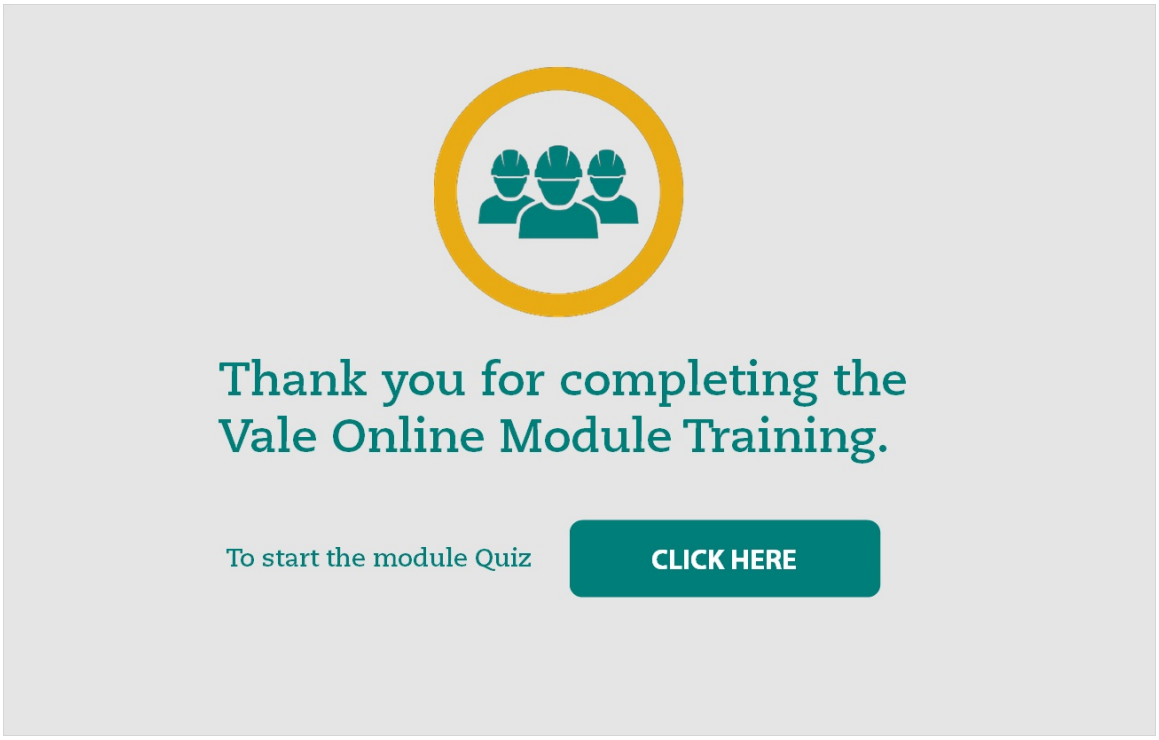
8.3 Conclusion

Remember, At Vale we believe
Life Matters Most and that
no job is worth doing if it cannot be done safely.

Thank-you for your participation
and your commitment to safety at Vale.

HOME SAFE

8.4 Start The Module Quiz



1. Question Bank 1

Q1.1 What colour light indicates that an overhead crane is in use?

(Multiple Choice, 10 points, unlimited attempts permitted)

Filter Plant Orientation Quiz

What colour light indicates that an overhead crane is in use?

- ○ Yellow
- ○ Blue
- ◉ Red
- ○ Green

Correct	Choice
	Yellow
	Blue
X	Red
	Green

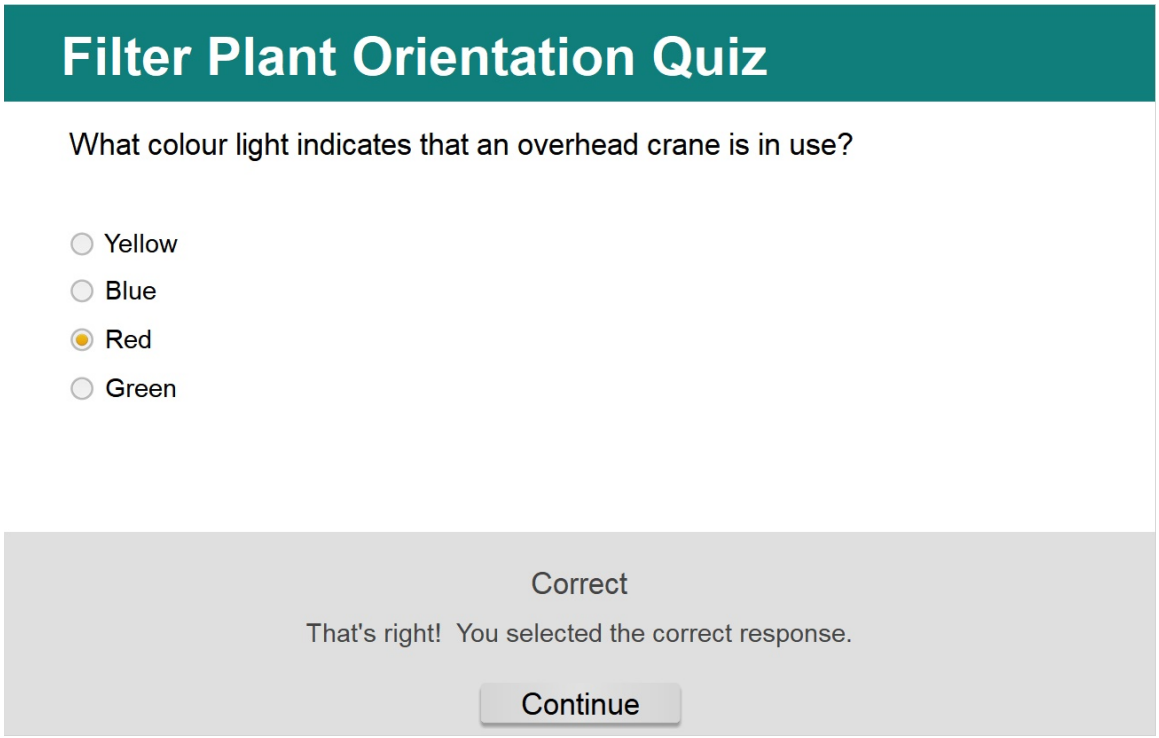
Feedback when correct:

That's right! You selected the correct response.

Feedback when incorrect:

You did not select the correct response.

Correct (Slide Layer)



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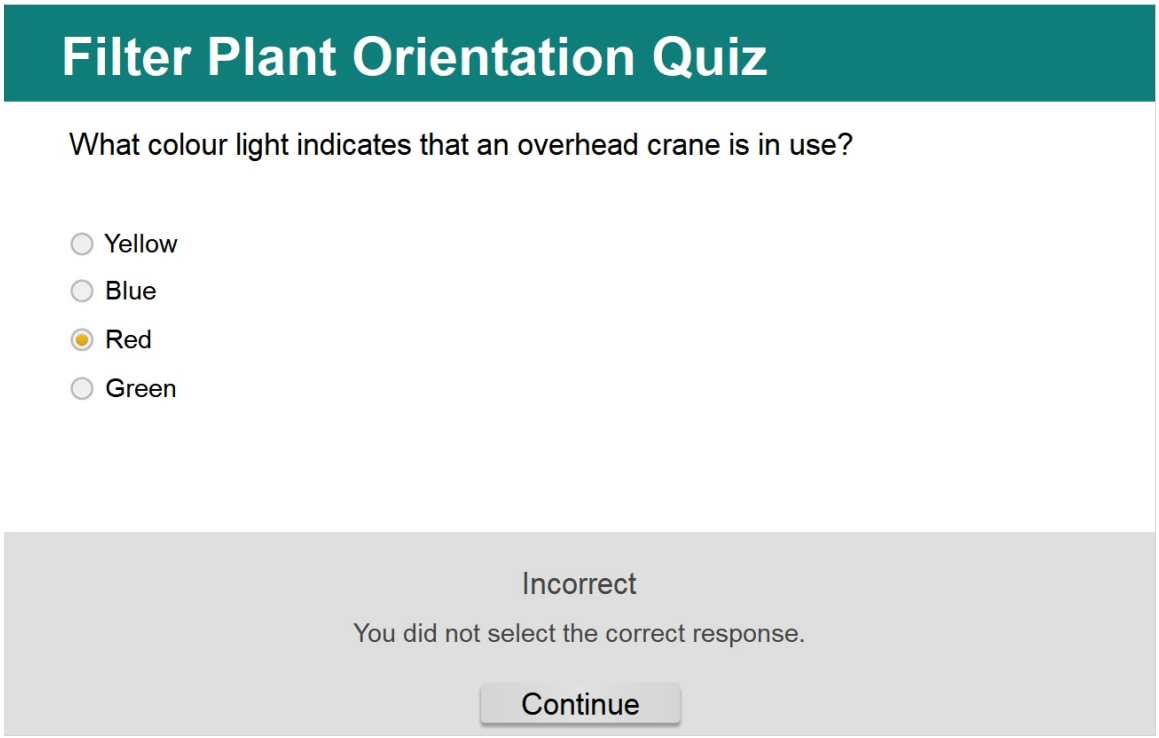
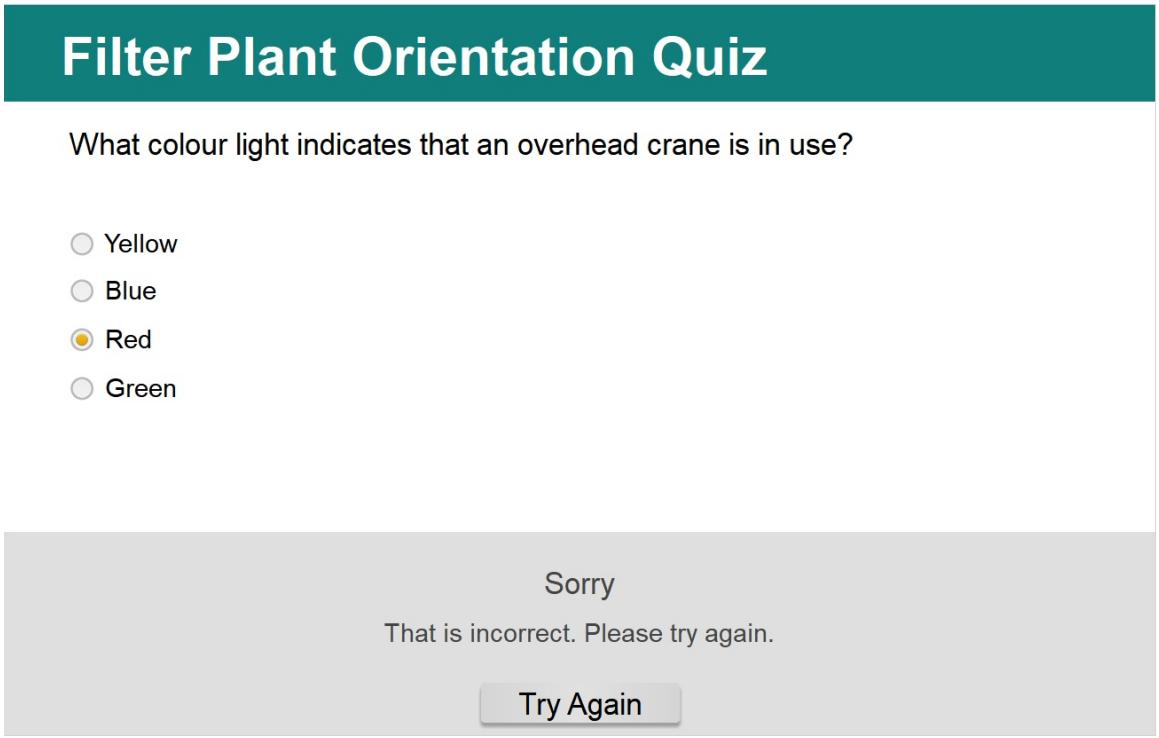


Try Again (Slide Layer)



Q1.2 What is the protocol when backing your vehicle in at Door #40?

(Multiple Choice, 10 points, unlimited attempts permitted)

Filter Plant Orientation Quiz

What is the protocol when backing your vehicle in at Door #40?

- ○ Back your vehicle into the building with no escort.
- ◉ Call the Filter Plant Control Room and have an operator assist you when backing in
- ○ Call #1 First Aid for permission to back into the building

Correct	Choice
	Back your vehicle into the building with no escort.
X	Call the Filter Plant Control Room and have an operator assist you when backing in
	Call #1 First Aid for permission to back into the building

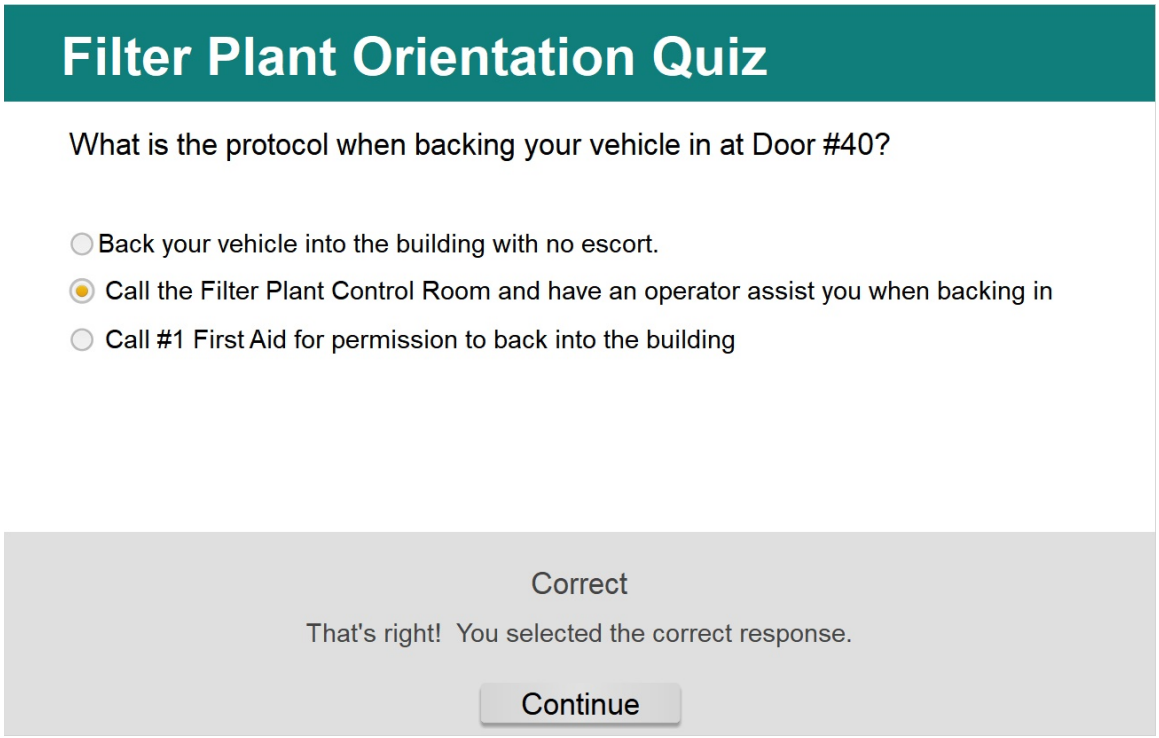
Feedback when correct:

That's right! You selected the correct response.

Feedback when incorrect:

You did not select the correct response.

Correct (Slide Layer)



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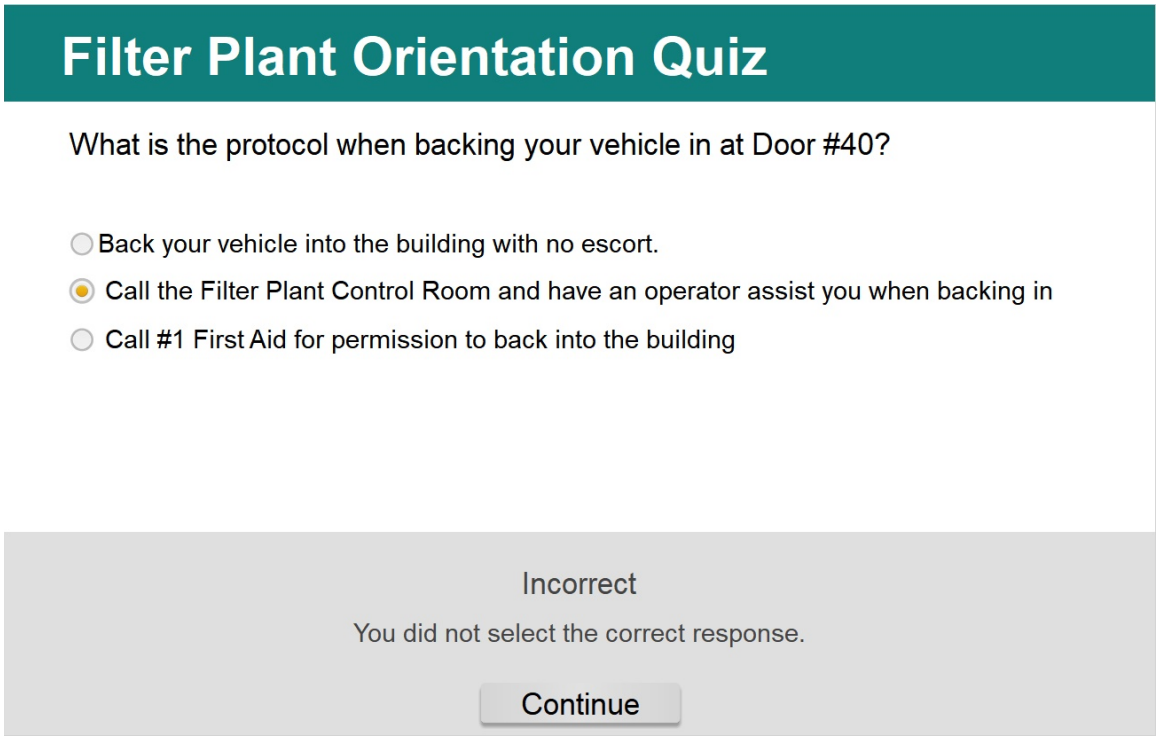
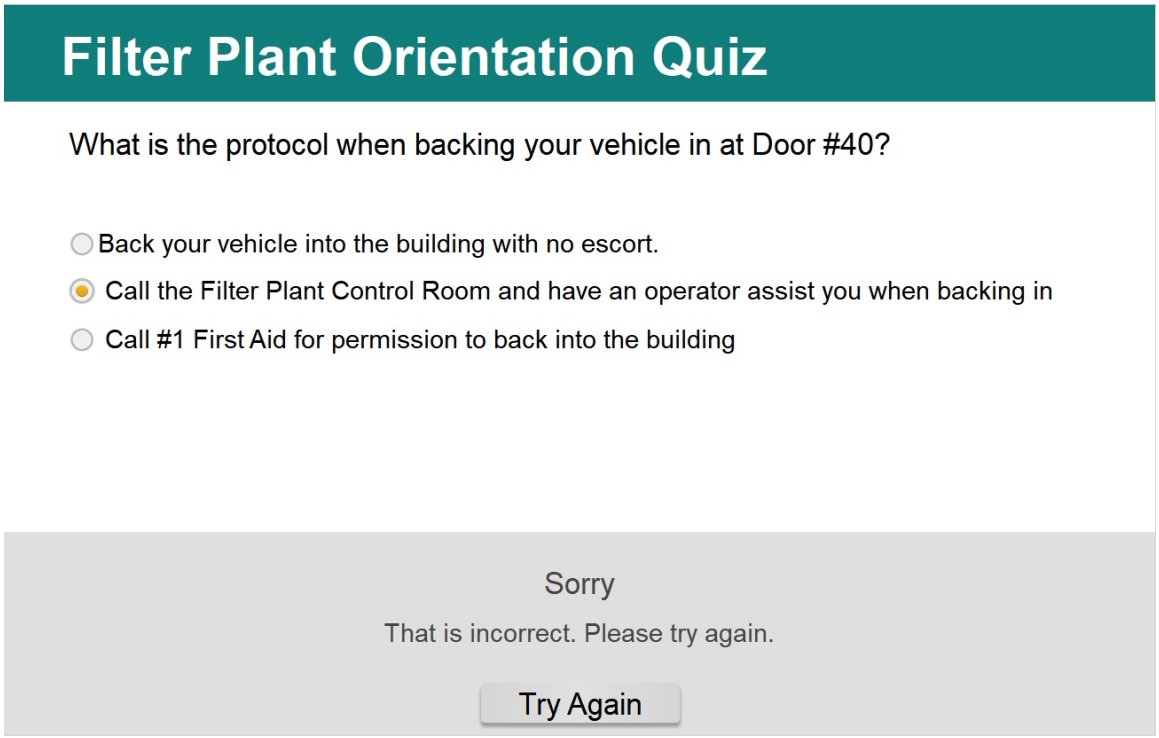


Try Again (Slide Layer)



Q1.3 Where is the Invac in the Filter Plant?

(Multiple Choice, 10 points, unlimited attempts permitted)

Filter Plant Orientation Quiz

Where is the Invac in the Filter Plant?

- ○ In the basement at the Filter Plant
- ○ In the Filter Plant Offices
- ○ Flashing Red (in plant)
- ◉ Outside at door #44A

Correct	Choice
	In the basement at the Filter Plant
	In the Filter Plant Offices
	Flashing Red (in plant)
X	Outside at door #44A

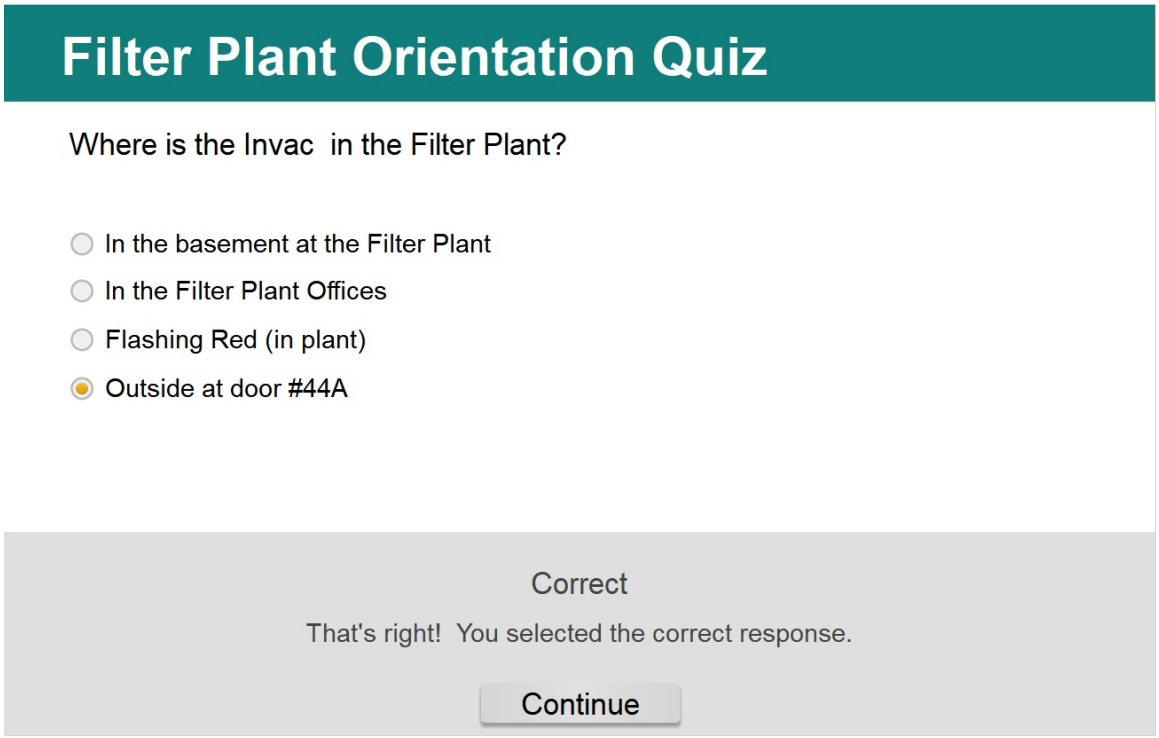
Feedback when correct:

That's right! You selected the correct response.

Feedback when incorrect:

You did not select the correct response.

Correct (Slide Layer)



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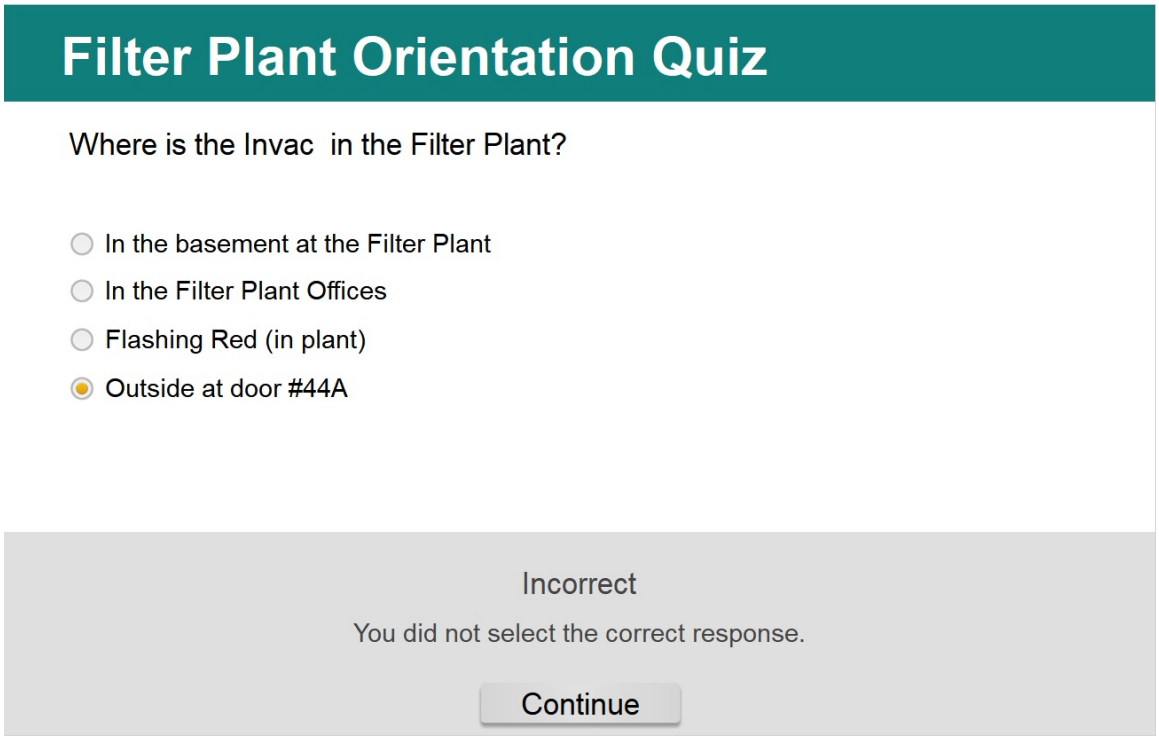
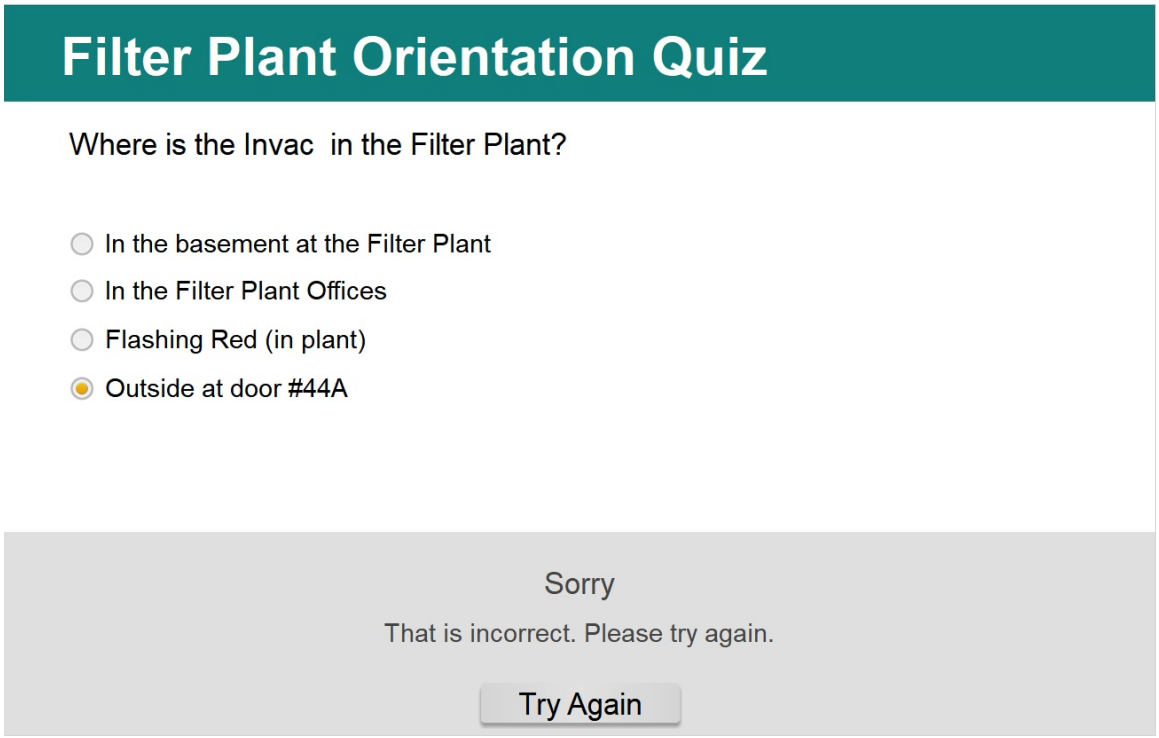


Try Again (Slide Layer)



Q1.4 You must be clean shaven to work at the filter plant.

(Multiple Choice, 10 points, unlimited attempts permitted)

Filter Plant Orientation Quiz

You must be clean shaven to work at the filter plant.

- ○ False
- ◉ True

Correct	Choice
	False
X	True

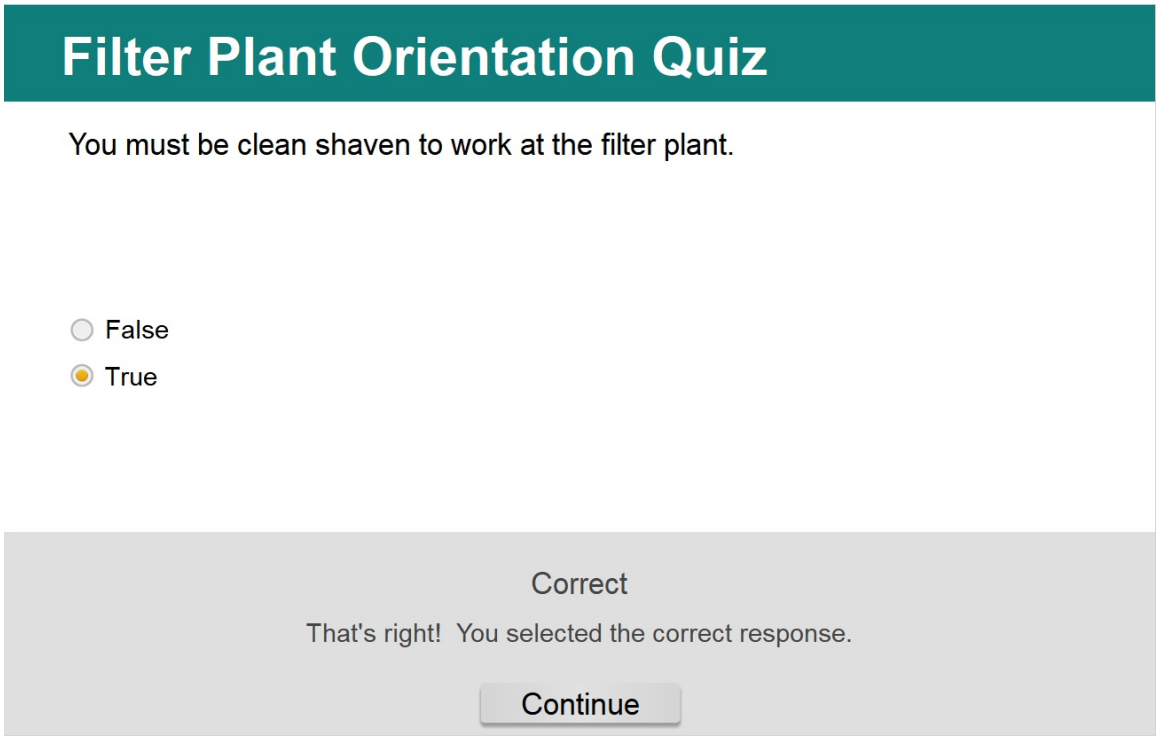
Feedback when correct:

That's right! You selected the correct response.

Feedback when incorrect:

You did not select the correct response.

Correct (Slide Layer)



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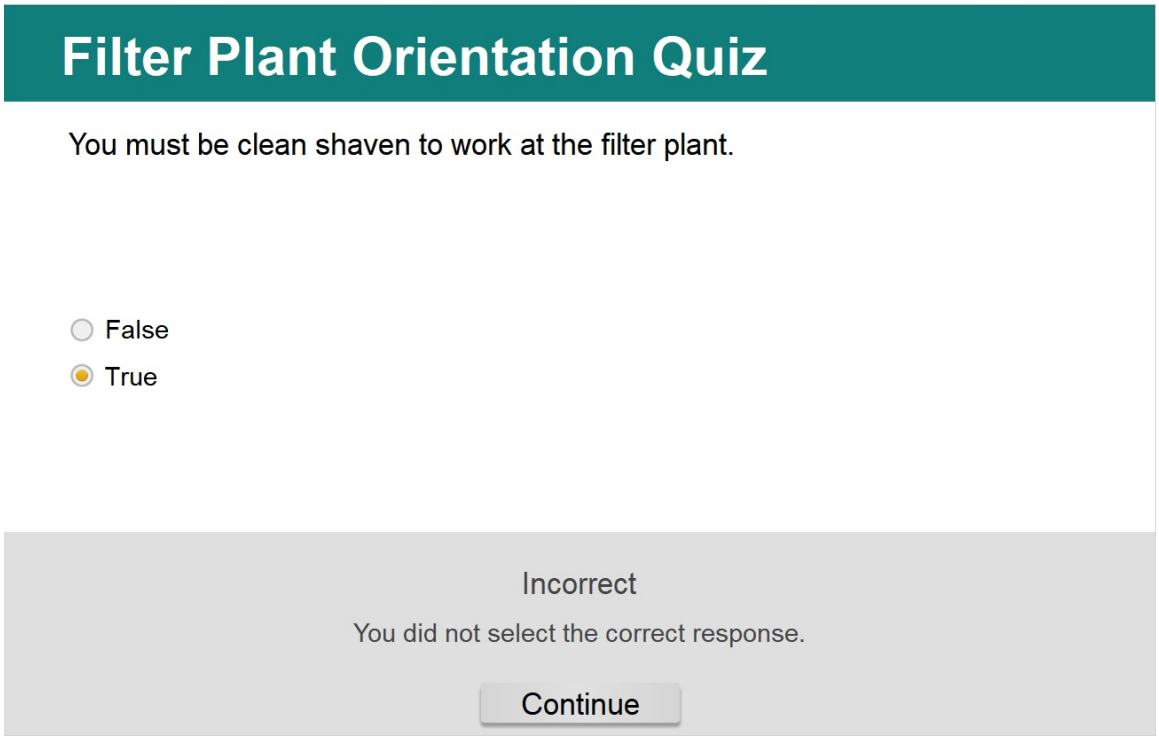
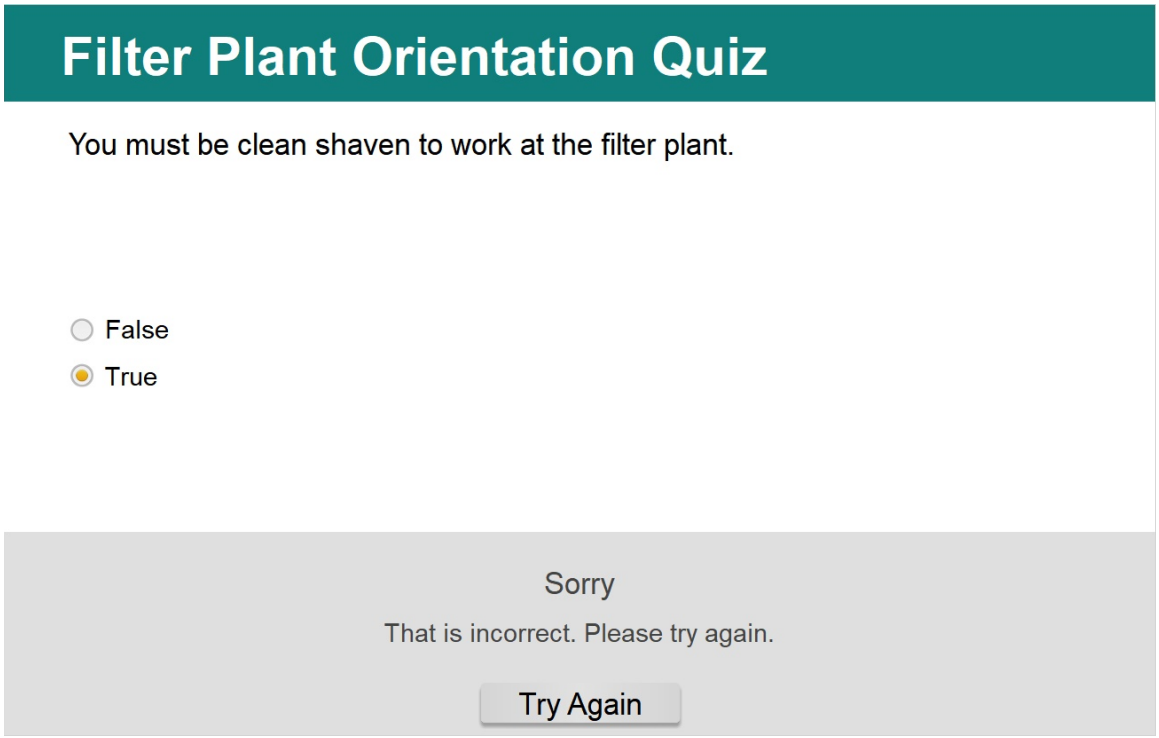


Try Again (Slide Layer)



Q1.5 It is mandatory to carry your ½ mask in the Filter Plant.

(Multiple Choice, 10 points, unlimited attempts permitted)

Filter Plant Orientation Quiz

It is mandatory to carry your ½ mask in the Filter Plant.

- ○ False
- ◉ True

Correct	Choice
	False
X	True

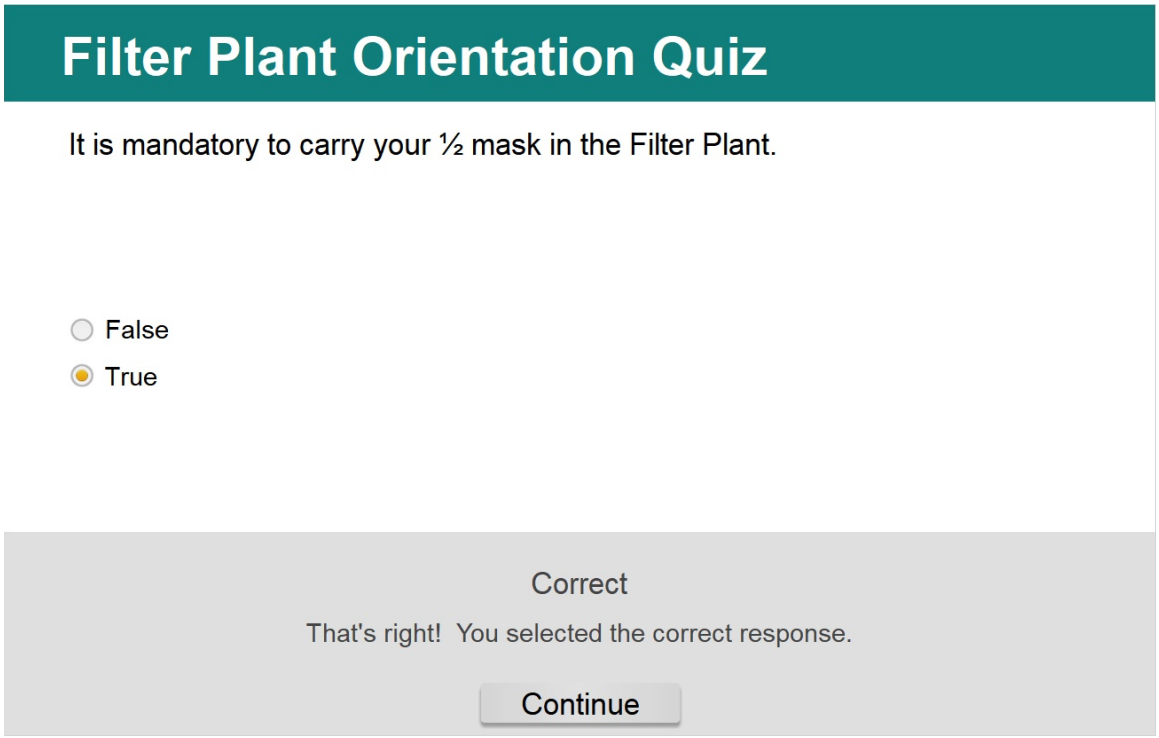
Feedback when correct:

That's right! You selected the correct response.

Feedback when incorrect:

You did not select the correct response.

Correct (Slide Layer)



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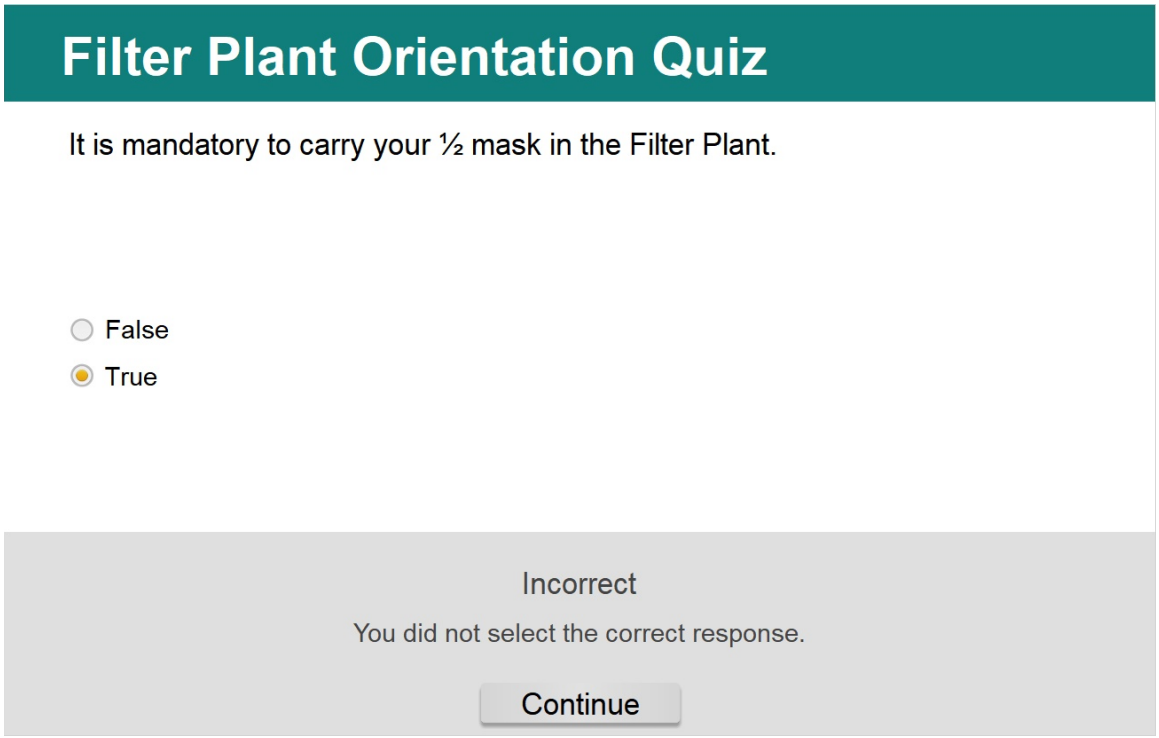

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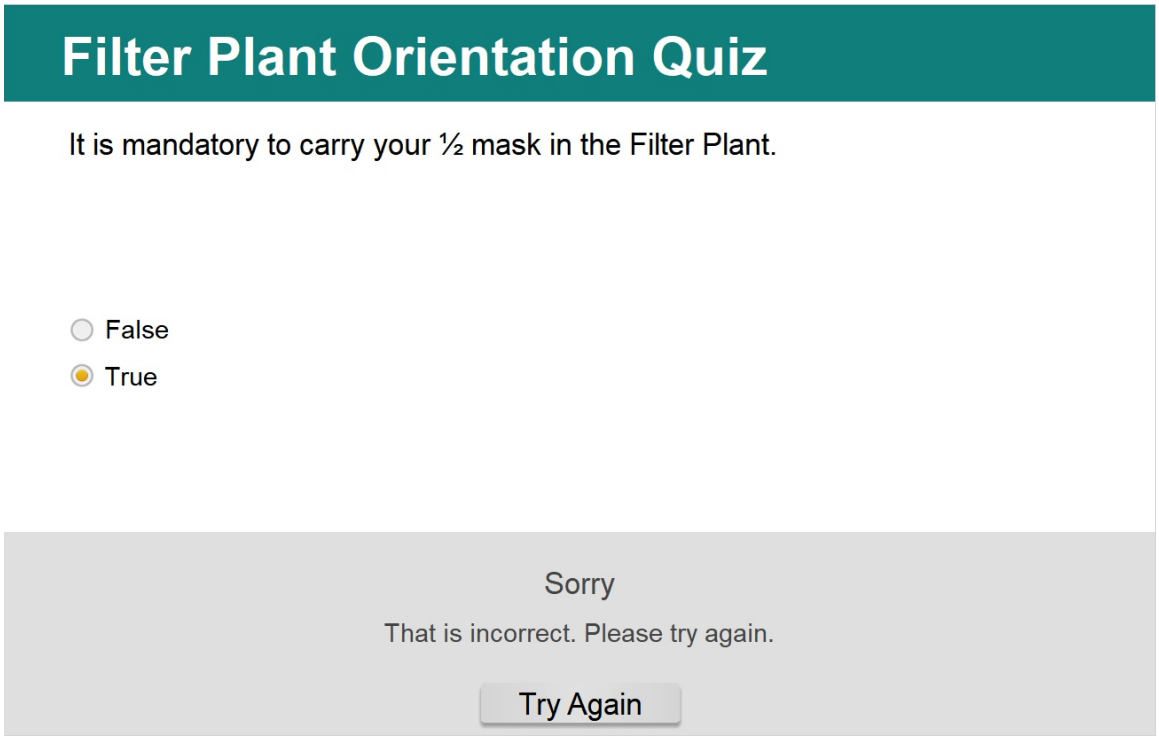


Q1.6 You may walk or stand under a suspended Load.

(Multiple Choice, 10 points, unlimited attempts permitted)

Filter Plant Orientation Quiz

You may walk or stand under a suspended Load.

- (●) False
- ( ) True

Correct	Choice
X	False
	True

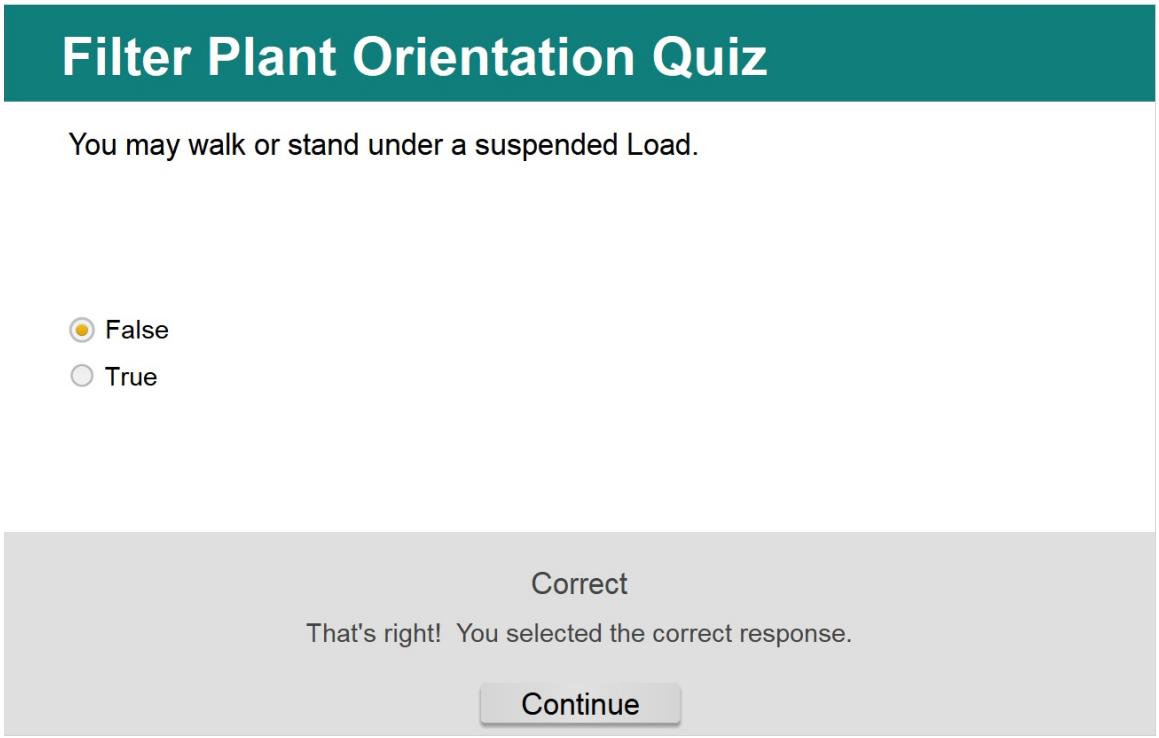
Feedback when correct:

That's right! You selected the correct response.

Feedback when incorrect:

You did not select the correct response.

Correct (Slide Layer)



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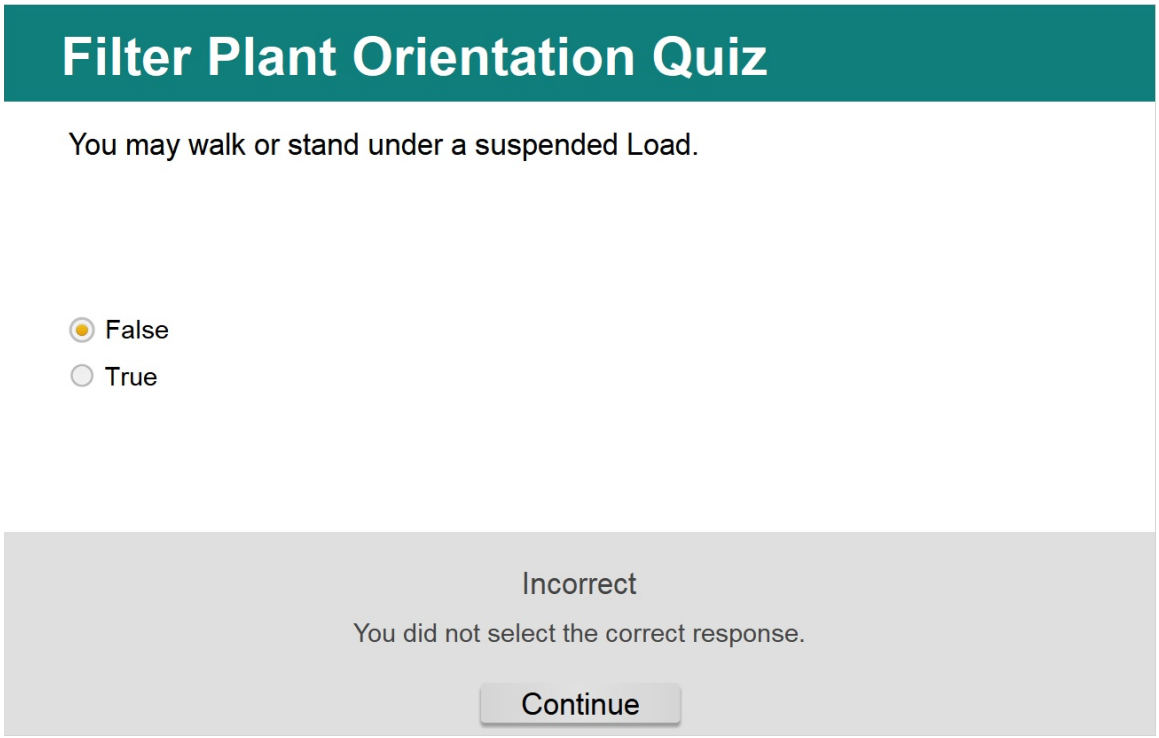
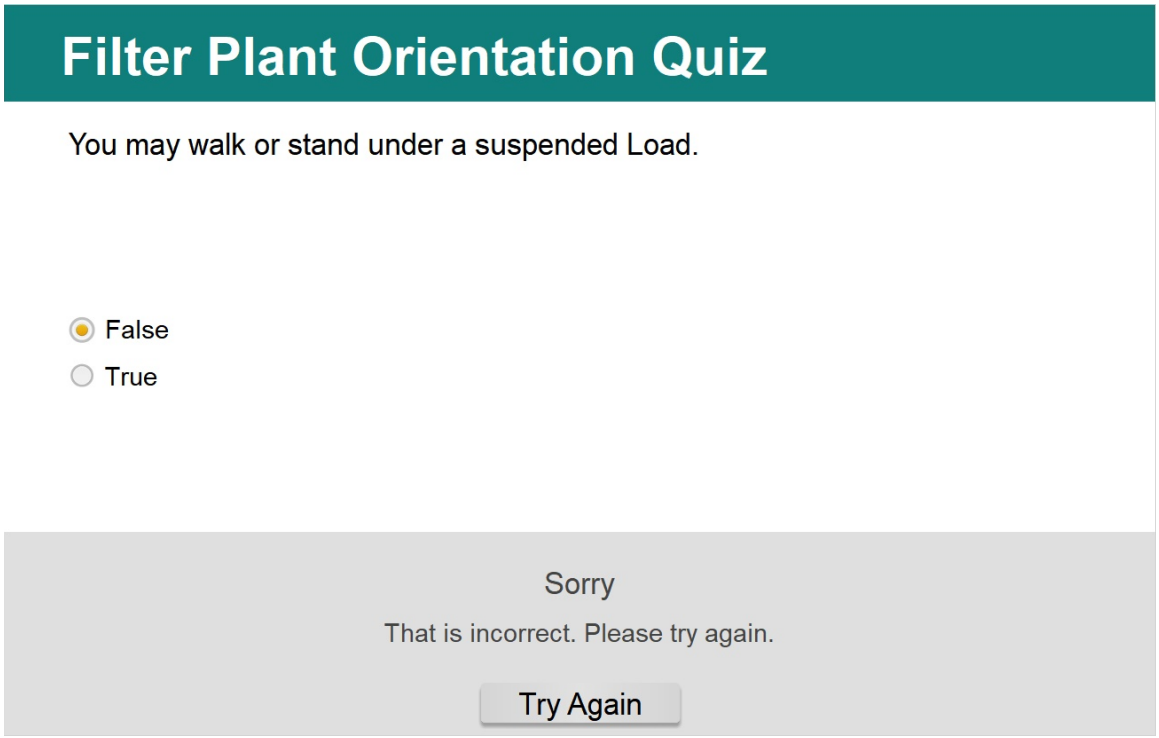


Try Again (Slide Layer)



Q1.7 Trash cannot be disposed of on conveyor belts. The trash can cause hazards downstream to other workers. Trash must be disposed into a proper disposal Bin.

(Multiple Choice, 10 points, unlimited attempts permitted)

Filter Plant Orientation Quiz

Trash cannot be disposed of on conveyor belts. The trash can cause hazards downstream to other workers. Trash must be disposed into a proper disposal Bin.

- ○ False
- ◉ True

Correct	Choice
	False
X	True

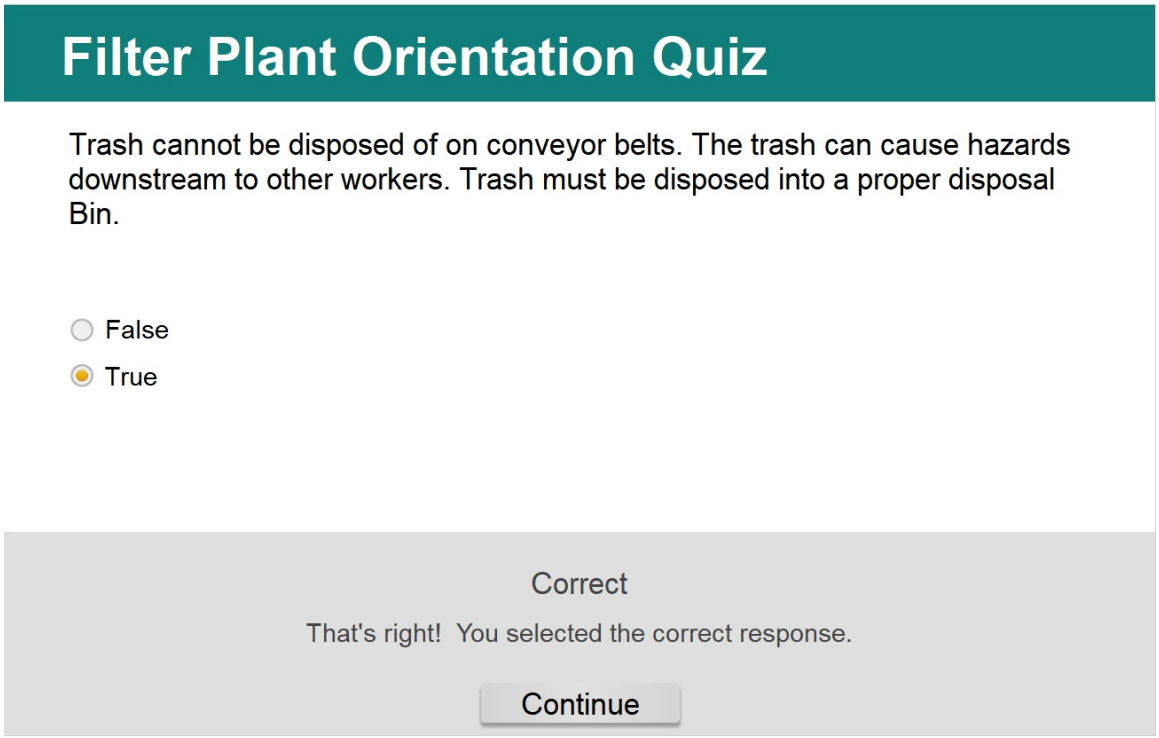
Feedback when correct:

That's right! You selected the correct response.

Feedback when incorrect:

You did not select the correct response.

Correct (Slide Layer)



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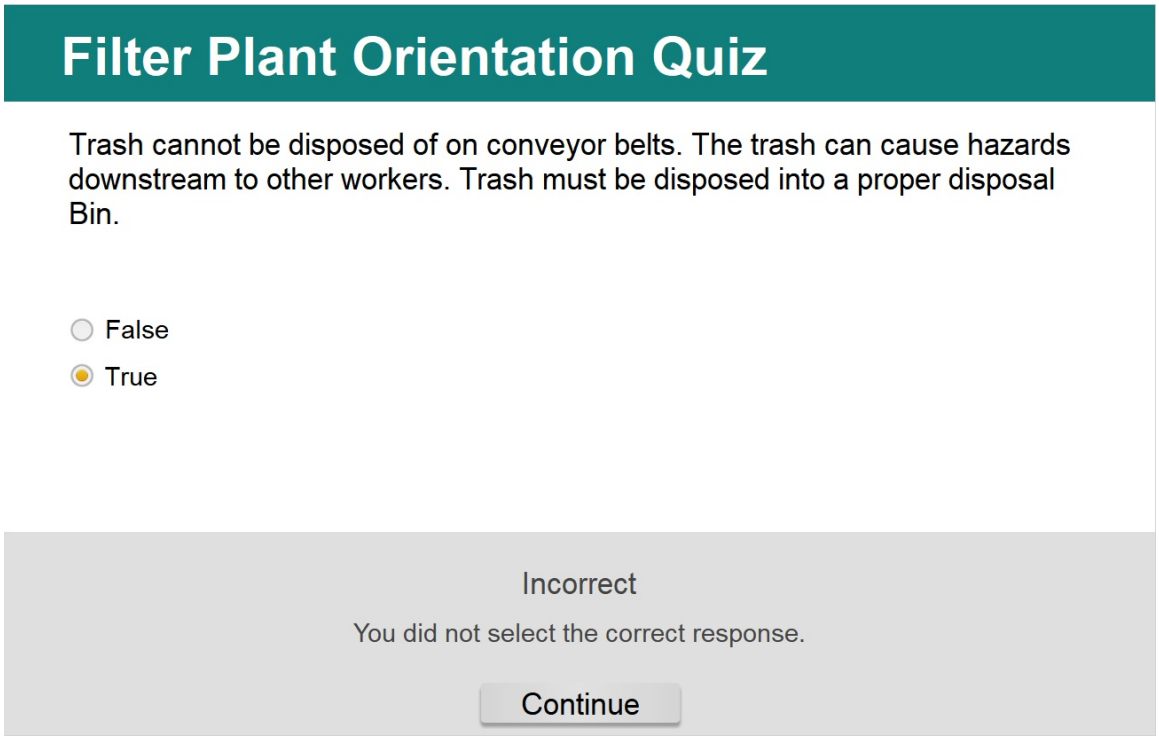

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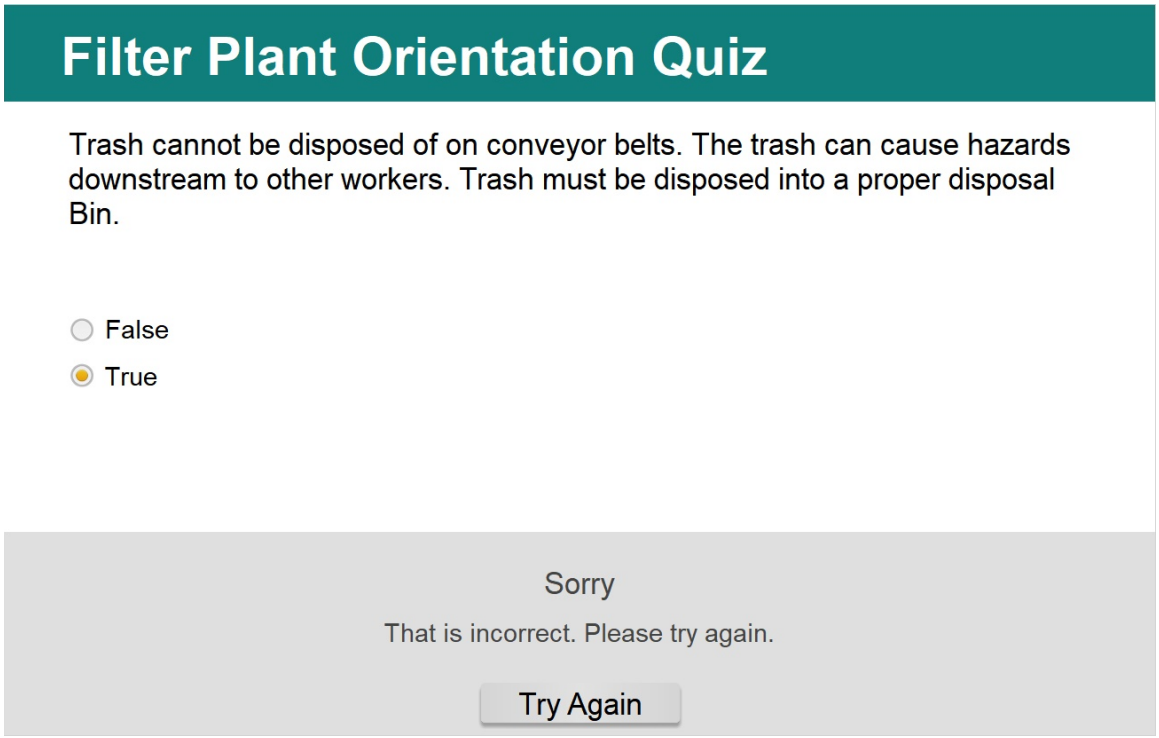


Q1.8 Inhalation and ingestion are the primary routes for Nickel to enter the body.

(Multiple Choice, 10 points, unlimited attempts permitted)

Filter Plant Orientation Quiz

Inhalation and ingestion are the primary routes for Nickel to enter the body.

- ○ False
- ◉ True

Correct	Choice
	False
X	True

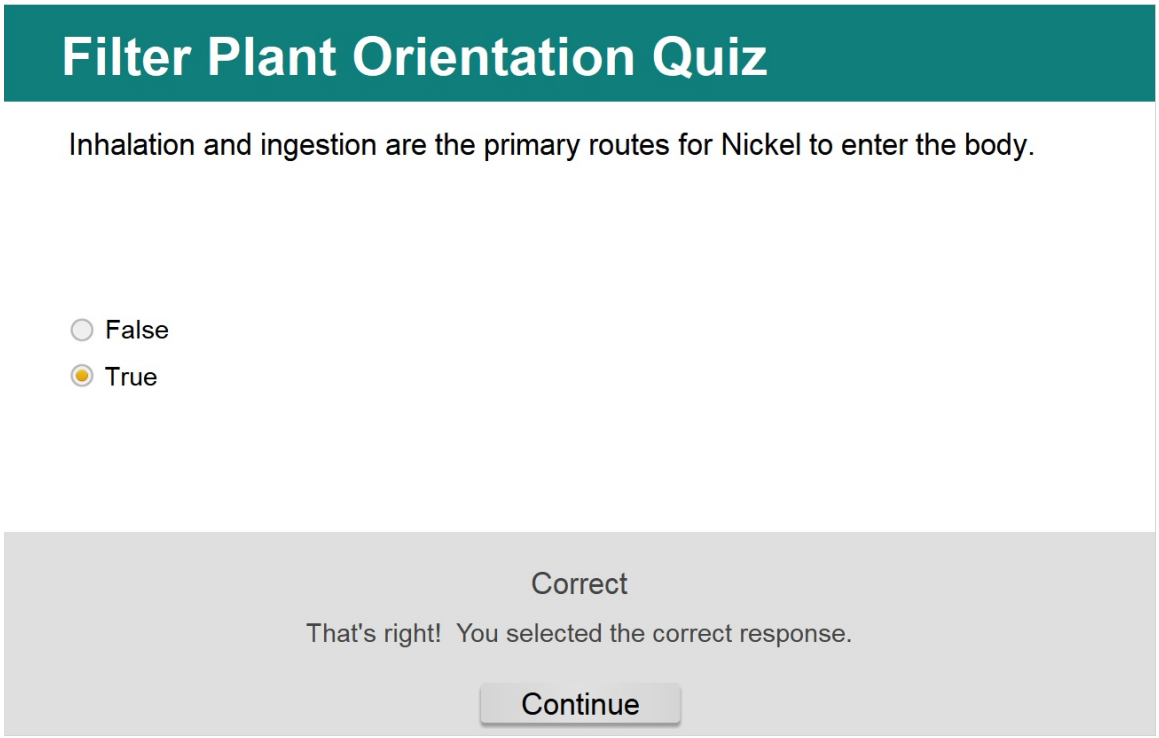
Feedback when correct:

That's right! You selected the correct response.

Feedback when incorrect:

You did not select the correct response.

Correct (Slide Layer)



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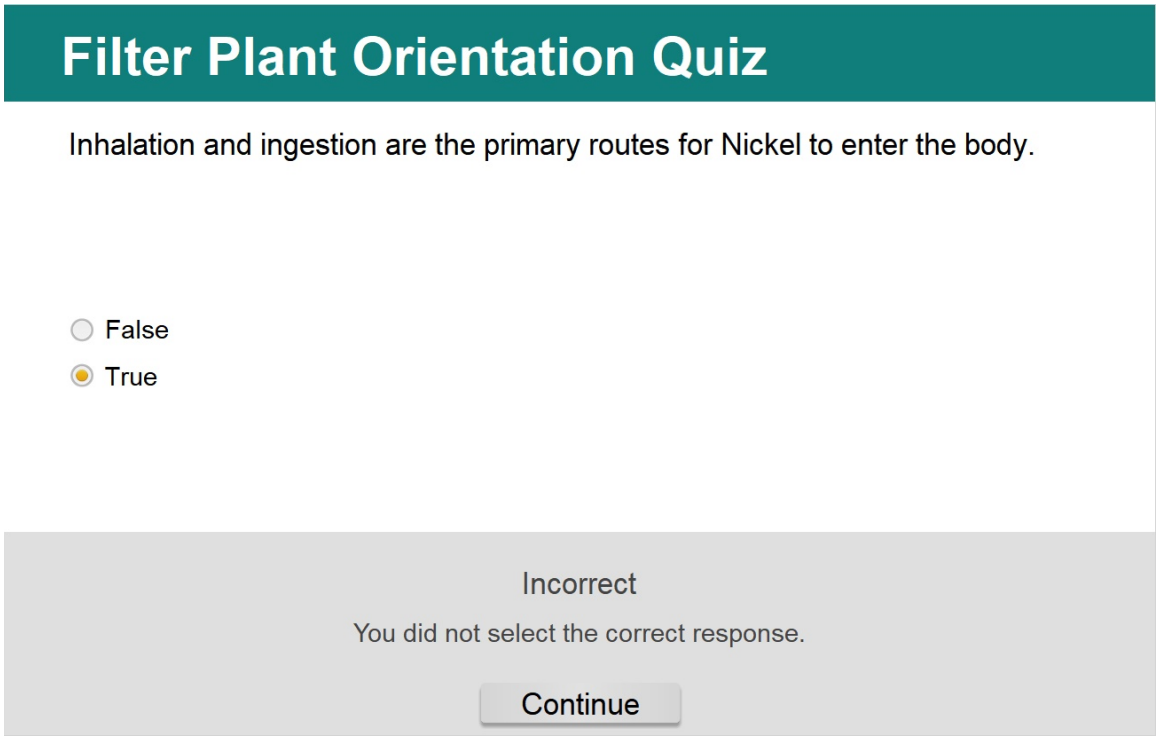
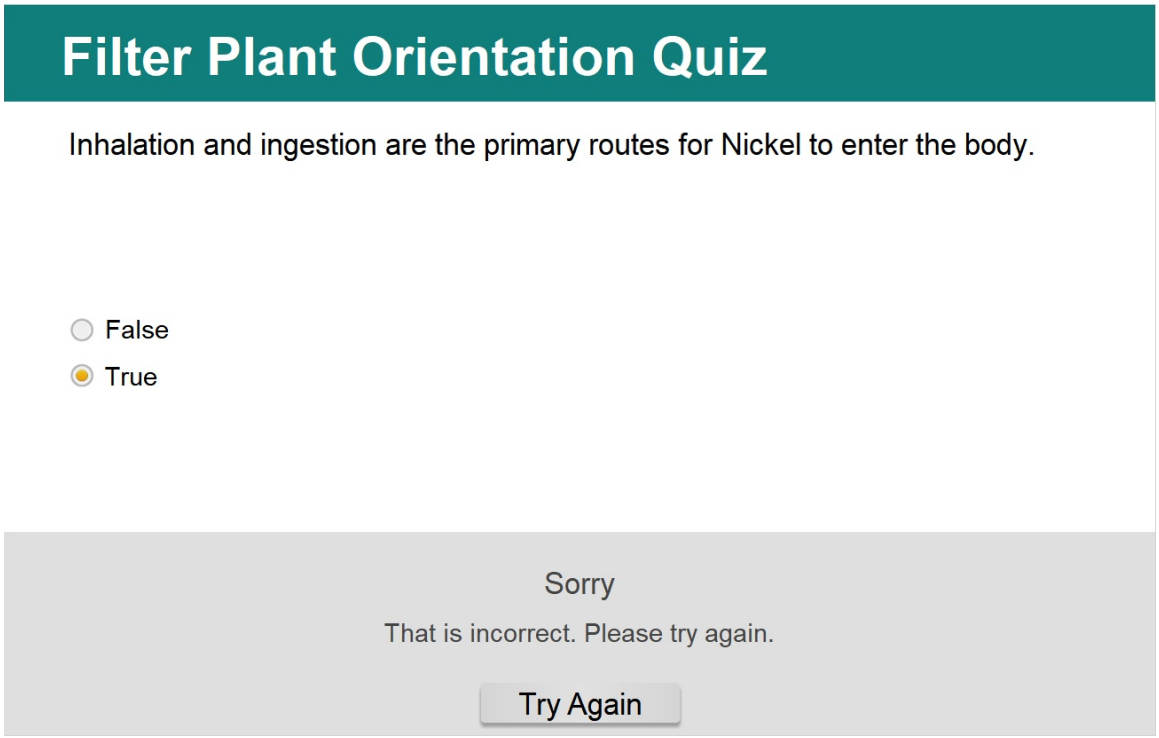


Try Again (Slide Layer)



Q1.9 Where are the required areas that you must wear a minimum of a ½ mask in the Filter Plant? (Select 2 correct answers from the list below.)

(Multiple Response, 10 points, unlimited attempts permitted)

Filter Plant Orientation Quiz

Where are the required areas that you must wear a minimum of a ½ mask in the Filter Plant? *(Select 2 correct answers from the list below.)*

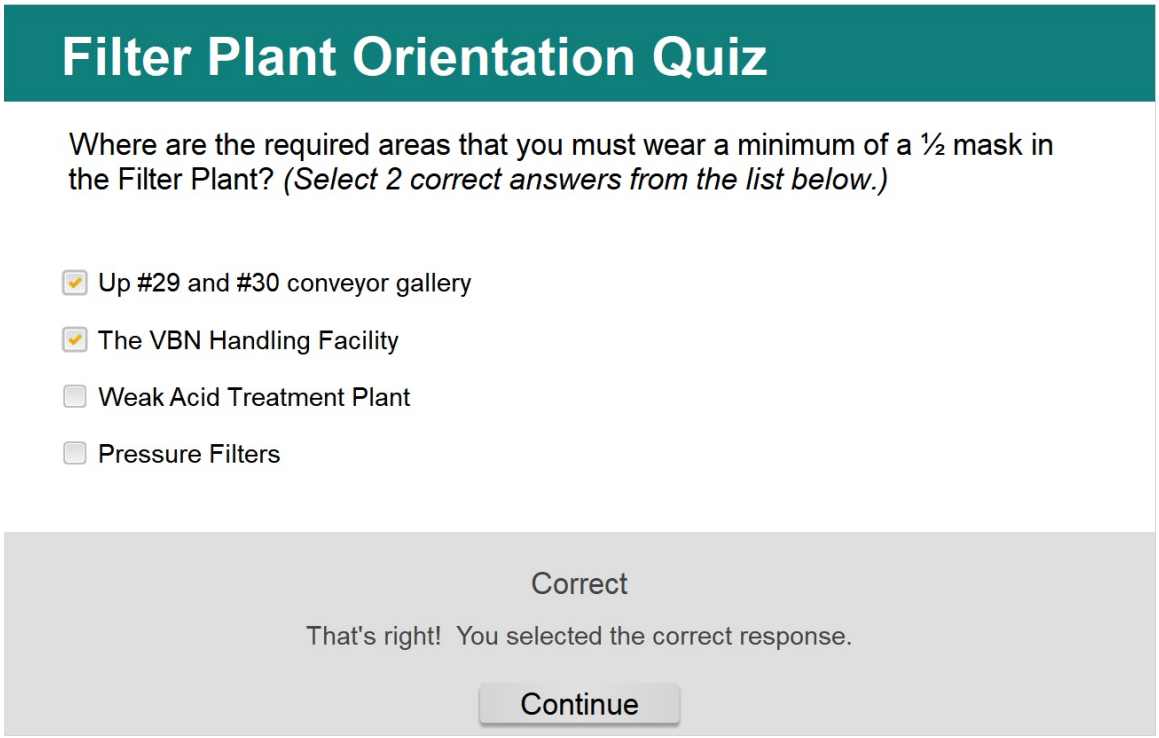
- [x] Up #29 and #30 conveyor gallery
- [x] The VBN Handling Facility
- [ ] Weak Acid Treatment Plant
- [ ] Pressure Filters

Correct	Choice
X	Up #29 and #30 conveyor gallery
X	The VBN Handling Facility
	Weak Acid Treatment Plant
	Pressure Filters

Feedback when incorrect:

You did not select the correct response.

Correct (Slide Layer)



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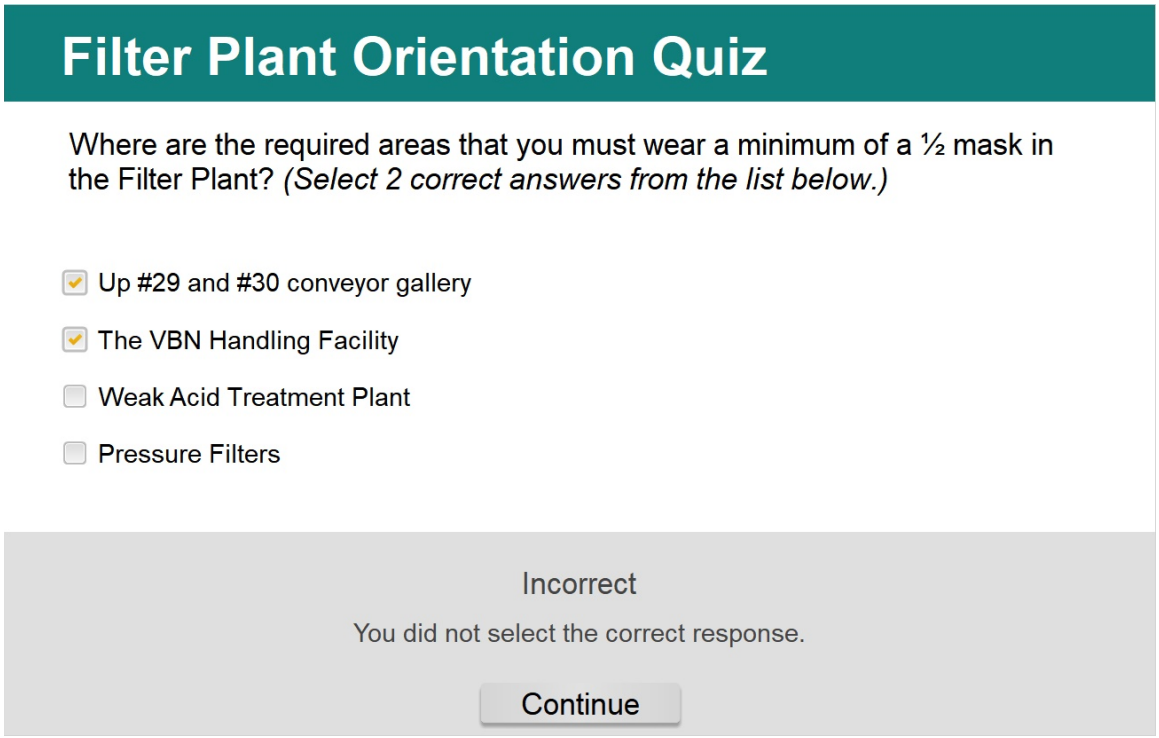

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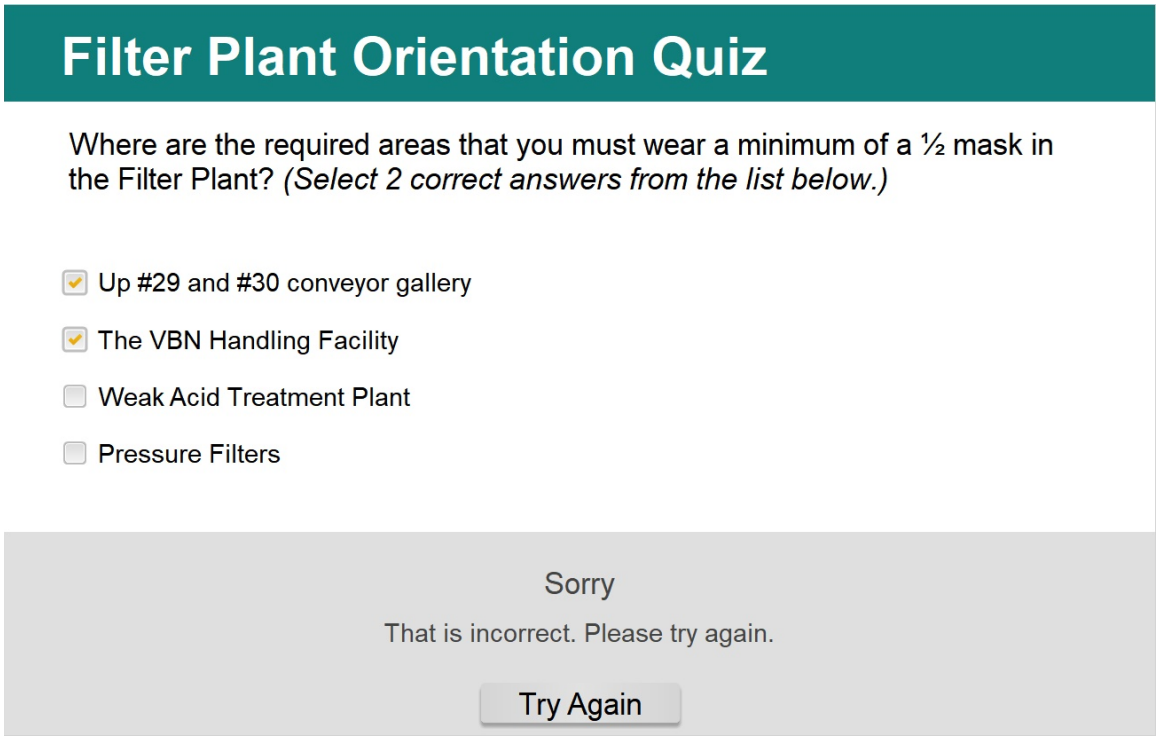


Q1.10 Where are the required areas that you must wear a minimum of a ½ mask in the Filter Plant? (Select correct answers from the list below.)

(Multiple Response, 10 points, unlimited attempts permitted)

Filter Plant Orientation Quiz

Where are the required areas that you must wear a minimum of a ½ mask in the Filter Plant? *(Select correct answers from the list below.)*

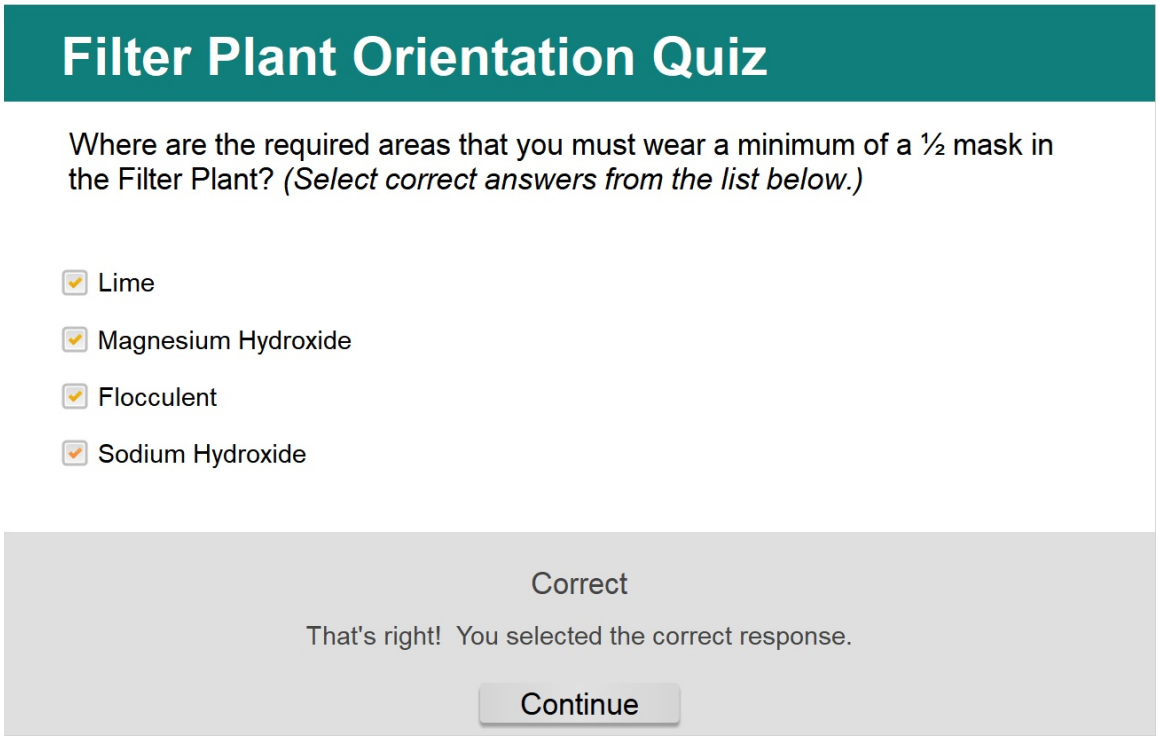
- [x] Lime
- [x] Magnesium Hydroxide
- [x] Flocculent
- [x] Sodium Hydroxide

Correct	Choice
X	Lime
X	Magnesium Hydroxide
X	Flocculent
X	Sodium Hydroxide

Feedback when incorrect:

You did not select the correct response.

Correct (Slide Layer)



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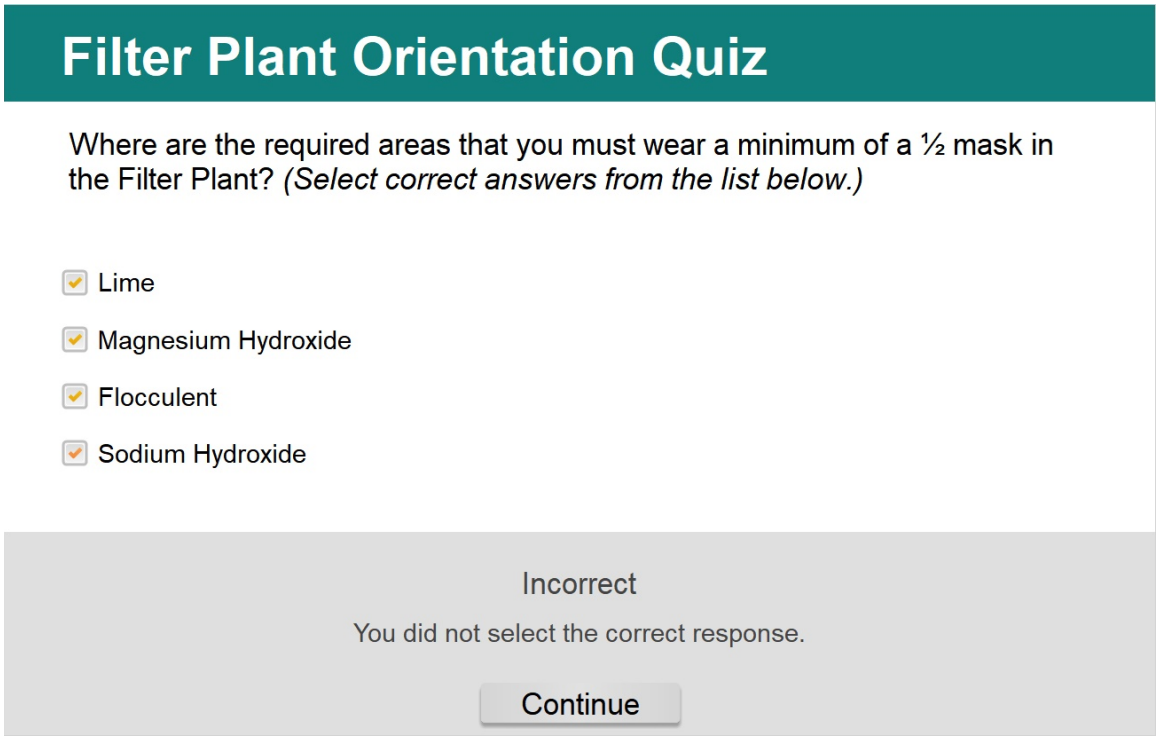
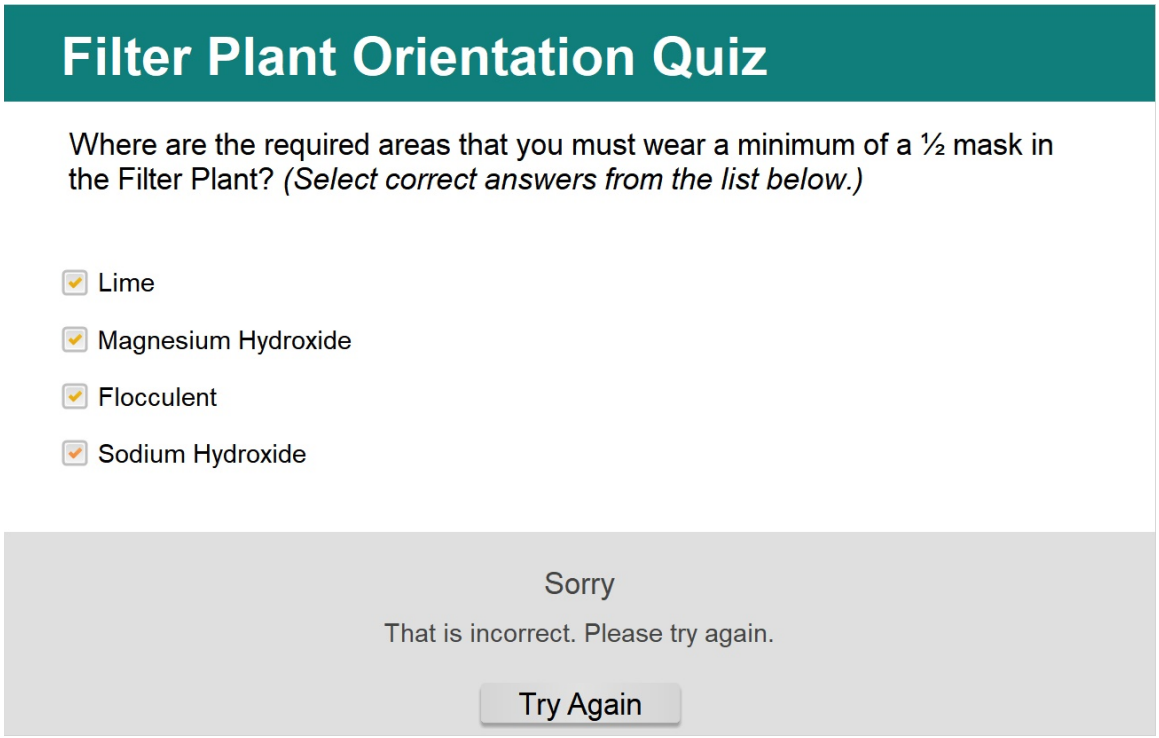
Try Again (Slide Layer)