Cargill
Meat Solutions

February 9, 2021 ***VIA CERTIFIED MAIL***

Wisconsin Department of Natural Resources
101 S. Webster Street PO Box 7921
Madison, WI 53707-7921

Re: Written follow up ammonia release from Cargill Meat Solutions Corporation ("Cargill")
Butler, WI Facility

Owner--- Cargill Meat Solutions Corporation
Phone--- (262) 781-2400
Contact--- Kelvin Byfield
Address--- 4700 North 132nd St., Butler, WI 53007
NRC Report# 1296746

To whom it may concern:

This letter is submitted following an ammonia release to the atmosphere from the Cargill Butler, WI facility on January 26, 2021. The Facility contacted all required agencies to provide notice of the release. There were no on-site or off-site impacts, and no anticipated acute or chronic health risks associated with the release. Anhydrous Ammonia is classified as an Extremely Hazardous Substance. The CAS number for Anhydrous Ammonia is 7664-41-7.

At approximately 12:37pm on January 26th, Facility personnel detected a slight ammonia smell. Further investigation revealed a leak in a compressor gasket. Facility personnel addressed the leak at 3:43pm. The duration of the release was approximately three hours and six minutes based on the time of discovery. The Facility later conservatively estimated that 7lbs. of liquid ammonia was released, which is below the Reportable Quantity of 100lbs for ammonia..

If you or your staff should have any questions, please call me at (262) 781-2400 or email me at Kelvin_Byfield@cargill.com.

Sincerely,

Kelvin Byfield

cc: Tizoc Zarate

Cargill Meat Solutions Corporation
Kelvin Byfield
EHS Manager

4700 North 132nd Street
Butler, WI 53007

Tel: (262) 781-2400
Fax: (262) 957-3232
Kelvin_Byfield@cargill.com

Pfeiffer, Jane K - DNR

From: Pfeiffer, Jane K - DNR
Sent: Wednesday, January 27, 2021 10:36 AM
To: Chris Bui
Cc: LaTanya Dunn
Subject: RE: WI SPILL #16128 ID 20210126SE68-1 - ANHYDROUS AMMONIA (NON-AG) - Spill Follow-Up

Hi Chris,

Thank you for the information you presented below. I am glad to hear that the system is up and running!

Best,

Jane

From: Chris Bui <Chris_Bui@cargill.com>
Sent: Wednesday, January 27, 2021 10:31 AM
To: Pfeiffer, Jane K - DNR <jane.pfeiffer@wisconsin.gov>
Cc: LaTanya Dunn <LaTanya_Dunn@cargill.com>
Subject: FW: WI SPILL #16128 ID 20210126SE68-1 - ANHYDROUS AMMONIA (NON-AG) - Spill Follow-Up

Thanks Jane,
I'll keep you posted with the letter, below is the summary of what happened.
Further investigation is in progress as well as for the amount ammonia released.

- 12:37 Notification of leak
- 12:43 0ppm outside engine room door
- 12:47 50ppm a the compressor 101
- 12: 49 leak source was identified at the head gasket
- 12:51 NRC notified, report # 1296746. SERC, LEPC, DNR was also notified.
- 13:00 Entry team came into engine room to isolate the compressor
- 13:02 Entry team came out, wasn't able to get close to the compressor to isolate. Decided to Shut down the entire system.
- 13:03 Kuhlman Refrigeration was contacted to come in.
- 13:06 Entry team tried to come in the engine room again, reading was over 150 ppm so entry team came out.
- 13:10 Entry team came in to close King Valve #101, reading was at 55ppm at the King Valve
- 13:18 Shut Off Make up air units on South Plant
- 13:25 Closing valves # 148, 337, 338, 149 to isolate the compressor, reading was at 37 ppm
- 13:28 Valves were closed, but there was still ammonia trapped in the compressor and leaking by.
- 13:41 Entry team came back into engine room to check readings. 0ppm at the entrance, 150 ppm at the water softener (about 10ft from compressor)
- 13:53-2:35 Discussed plans to pump down the compressor
- 2:37 -2:51 Entry team came in and out to check readings and come up with the plans, reading was at 50 ppm by compressor 108, 45ppm by compressor 101.
- 2:54 Open hand expansion valve # 1134
- 2:54-3:15 Entry team stayed at MCC room to discuss, planning to pump down compressor by jetter
- 3:17 Closed suction valve on compressor 105 and 108, reading was at 29ppm

- 3:22-3:25 prepping for jetting out compressor 101
- 3:26 started jetting out compressor 101
- 3:43 Closed suction valve on compressor 114, reading was 0ppm and stayed constant
- 3:45 slowly open King Valve, started system back up.

Thank you,
Chris Bui
PSM Coordinator
Work: (262) 957-3306
Cell: 402-202-3735 (for out of office)
*Email: **Chris_Bui@cargill.com***

Cargill Butler, WI Meat Solutions

From: Pfeiffer, Jane K - DNR <jane.pfeiffer@wisconsin.gov>
Sent: Tuesday, January 26, 2021 2:30 PM
To: LaTanya Dunn <LaTanya_Dunn@cargill.com>
Subject: WI SPILL #16128 ID 20210126SE68-1 - ANHYDROUS AMMONIA (NON-AG) - Spill Follow-Up

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Good Afternoon Latanya,

This is Jane Pfeiffer from the WI Department of Natural Resources Spills Team. Thank you for speaking with me today about the above-referenced spill at the Cargill facility, located at 4700 N 132nd St, Butler, WI. Submit a spill cleanup report, per Wis. Admin. Code § NR 708.05(6), within 45 days after the initial hazardous substance discharge. This report can be submitted to me via email. Please do not hesitate to contact me with any comments, questions or concerns may have.

Thank you,

Jane

We are committed to service excellence.
Visit our survey at http://dnr.wi.gov/customersurvey to evaluate how I did.

Jane Pfeiffer
Phone: (414) 435-8021
jane.pfeiffer@wisconsin.gov