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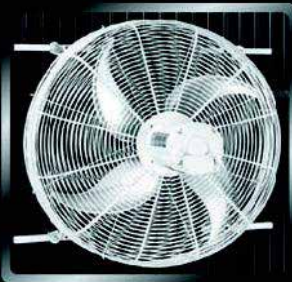
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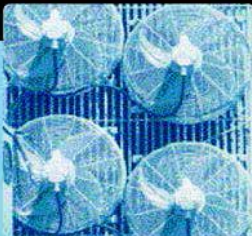
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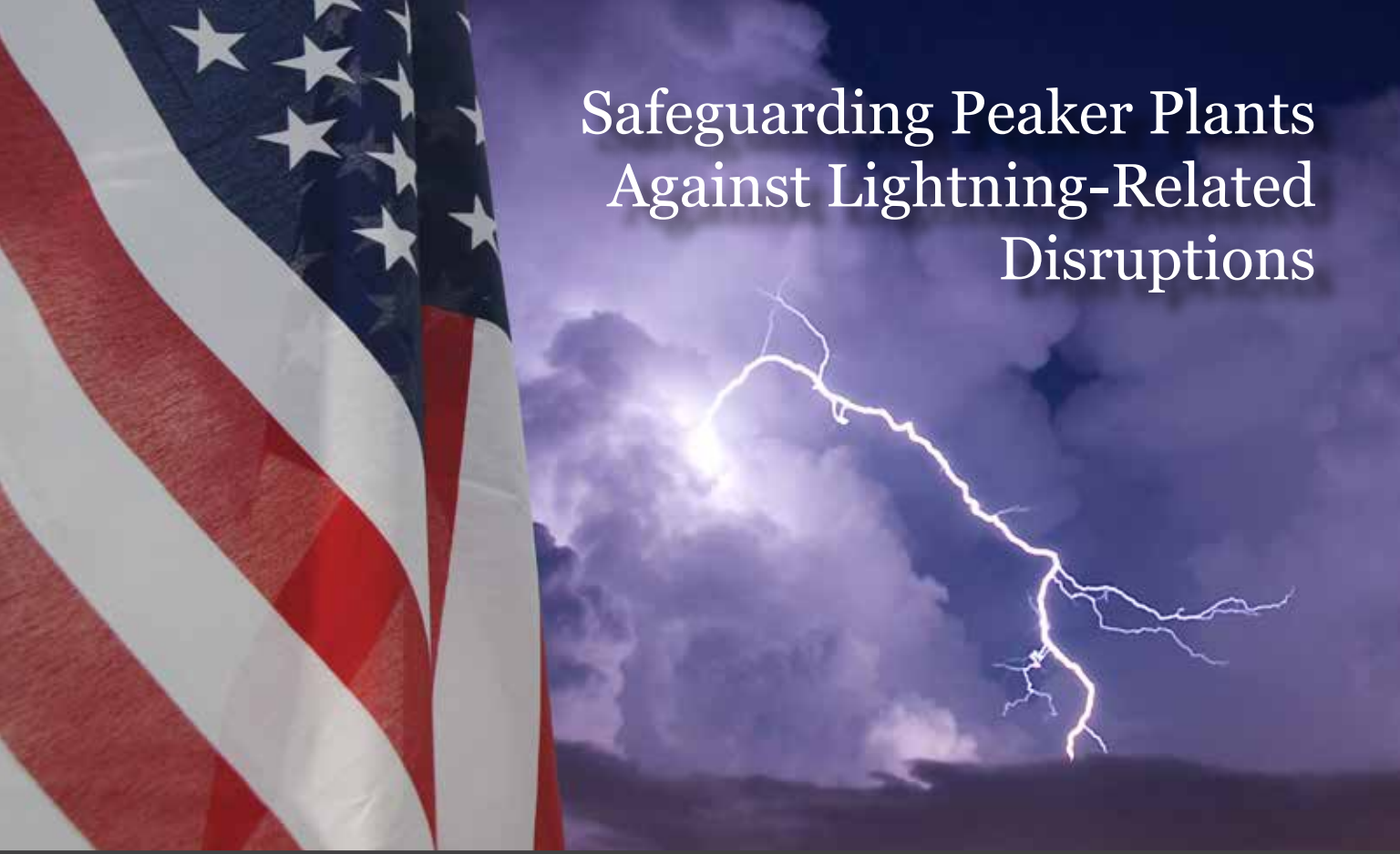
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Safeguarding Peaker Plants Against Lightning-Related Disruptions

Comprehensive lightning protection measures help keep peaker plants in a constant state of readiness, enabling them to deliver supplemental power at a moment's notice when electrical grids become overloaded

According to the latest federal data, the United States currently has just over one thousand peaking power plants in active service. Also known as peaker plants, these electric power generation facilities are designed to operate only during periods of high electricity demand. Their function is to supply additional grid support, activating when baseline utility power generators such as nuclear, coal, hydro-electric, or large combined cycle plants cannot meet short-term spikes in load.

Although simpler in infrastructure and more compact than traditional power generation facilities, peaker plants are among the most vulnerable to operational disruptions caused by direct lightning strikes and their secondary effects.

Peaker plants are particularly susceptible to lightning effects for several reasons. They often include prominent structures such as exhaust stacks, transmission towers, and open-air substations, all of which act as likely lightning strike collection points. Within the facility, large amounts of electrically conductive equipment are directly tied into the grid. Generating units, power transformers, switchgear lineups, control platforms, and communications networks operate under high electrical stress and are susceptible to transient overvoltage.



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Even in areas with infrequent thunderstorms, severe lightning events can still occur, leading to catastrophic damage, injury, downtime, fines, and negative impact to corporate reputation. When this occurs, the financial consequences can be devastating. A single strike can ignite fires, destroy valuable assets, and lead to costly downtime and environmental damage.

The secondary effects of lightning are also significant. Ground potential rise and electromagnetic energy coupling into control and instrumentation cabling can disrupt plant functions or damage sensitive hardware where grounding, bonding, surge protection, and shielding are not in place.

The operating profile of a peaking facility adds another layer of exposure. These units run only when supplemental capacity is needed and are designed for rapid startup, which often means long periods offline. Insulation systems, grounding networks, and related protective features must therefore remain dependable despite long periods of inactivity and cold equipment conditions.

Lightning-induced surges can introduce hidden degradation that may not appear during routine maintenance and inspections but later interferes with startup when the unit is urgently required for peak demand or grid support. The impact is considerable because these plants are called upon during periods of system grid stress.

For these reasons, peaker plants typically incorporate comprehensive lightning protection measures, including air terminals, which are designed to attract lightning and will only protect structures. Low-impedance grounding grids and transient voltage surge protection devices are also

included in the lightning protection measures. Lightning avoidance technologies may also be utilized, such as Charge Transfer technologies. A Charge Transfer System not only protects structures but allows reliable operation of the control and monitoring automation through the storm.

“Rather than offering a one-size-fits-all solution, lightning protection and mitigation recommendations should be tailored to a facility’s unique vulnerabilities, whether that involves direct strike avoidance, secondary damage caused by a nearby strike, or grounding improvements,” says Peter Carpenter, Director of Applied Engineering at Lightning Eliminators & Consultants, Inc. (LEC), a pioneer in the field of lightning protection since 1971.

LEC’s solutions protect critical operations and structures for some of the world’s most recognized companies, including Tennessee Valley Authority (TVA) nuclear facilities, Exelon, Constellation Energy, Duke Energy, and Consumers Energy, Federal Express, UPS, Marathon Petroleum, Chevron, ExxonMobil, and thousands of others.

Prevention is the Best Defense

According to Carpenter, the most effective defense is to prevent a lightning strike from occurring.

“This is a far superior solution than a lightning rod-based system that attracts lightning to the protected site and then attempts to manage the strike,” explains Carpenter.

Lightning occurs when the difference in potential between storm clouds and the earth reaches a critical level, triggering an electrical discharge. For lightning to strike, it requires a connection be-

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tween a downward leader from the cloud and an upward streamer from the ground.

The Dissipation Array System (DAS®) from LEC is designed to prevent direct lightning strikes within its designated protection area by lowering the electric field to levels below those required for lightning to form.

“DAS prevents these connections by using point discharge technology, which neutralizes the charge differential before a strike can occur. Through a system of well-grounded points, DAS facilitates the exchange of ions between the air and the ground, disrupting the conditions necessary for a lightning strike,” says Carpenter.

DAS can be integrated with a wide range of structures, including buildings, towers, tanks, and stacks. Since its inception, over 4,500 DAS installations have been deployed worldwide, accumulating more than 100,000 system-years of effective performance. Testimonials from industry leaders confirm its effectiveness, with companies reporting significant reductions in downtime, maintenance costs and improved reliability.

LEC even offers a “No-Strike” warranty for all supervised installations, ensuring complete protection when the system is properly maintained and inspected.

The effectiveness of DAS is enhanced when combined with a comprehensive lightning protection system that includes a low-impedance grounding system, transient voltage surge suppression, and modular strike prevention devices. Together, these components ensure optimal protection against both direct strikes and secondary electrical surges.

Lightning Risk Assessments

Due to the wide range of available technologies, mounting an effective defense against lightning-related threats typically requires a tailored strategy that integrates multiple solutions, each having its own specific purpose for minimizing damage or avoiding it altogether. The optimal combination depends on the specific site conditions and the nature of the operation.

Carpenter says the appropriate combination of solutions can only be determined through a comprehensive evaluation of each facility’s current protection measures, grounding systems, and overall risk exposure.

“Understanding a peaker plant’s past issues, vulnerabilities, and protection goals helps determine whether the solution should focus on grounding enhancements, surge protection, direct strike avoidance, secondary damage from a nearby strike, or a combination of all three,” says Carpenter.

By conducting a thorough site assessment, LEC helps facilities identify vulnerabilities and implement customized mitigation strategies, whether that means improving grounding, adding targeted surge protection, or implementing direct strike mitigation solutions.

This proactive step not only safeguards critical infrastructure and personnel but also helps prevent costly disruptions and reinforces a facility’s long-term resilience against lightning-related threats.

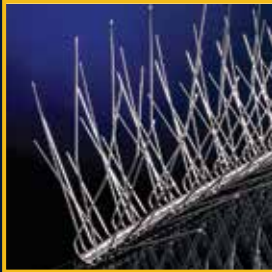
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Functional Safety at Scale: Safeguarding One of the World's Largest Ethylene Plants



Inside Chevron Phillips Chemical's pursuit to build not just the largest, but the safest ethylene and polyethylene facilities in the world.

When you design and build one of the world's largest ethylene and polyethylene facilities, size amplifies everything: throughput, complexity, and operational risk. For Chevron Phillips Chemical (CPCChem) and QatarEnergy's Golden Triangle Polymers Project, that reality kept safety at the forefront of every decision. The objective was to build big, operate safely, and sustain it for decades.

"Safety isn't just a goal; it is a foundational principle that guides every decision we make," says John Bergen, Process Control Engineer for the ethylene unit, who oversees all aspects of process control, including the plant's safety shutdown systems. "To achieve that, we ensure every process is designed and managed so that materials stay safely contained. We want to ensure that all our employees and contractors go home safely at the end of the day."

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ethane cracker and two 1,000 KTA high-density polyethylene units. The total cost of the project is expected to be around \$8.5 billion.

With a greenfield complex of this scale, CPChem wanted to ensure nothing was overlooked. That's why the company viewed Functional Safety Assessments (FSAs) not only as critical to safety but also as an economic decision. Performing Stages 1 and 2 correctly reduces overall project costs by preventing expensive redesigns, delays, and rework later in the process.

"CPChem conducted comprehensive internal risk assessments in collaboration with our design contractor," explains Bergen. "To strengthen the integrity of our safety approach, we also engaged an independent third party to perform an FSA. Their role is to validate our assessments and design specifications, ensuring nothing is overlooked and that we meet or exceed all applicable safety standards."

From risk to readiness

An FSA is an independent, evidence-based review of a plant's instrumented protection layers against recognized safety standards. It confirms that hazards are correctly identified, required safety functions and Safety Integrity Levels (SIL) are defined, and the design will deliver the performance the risk analysis demands.

Stages 1 and 2 lay the foundation for the entire safety lifecycle. Stage 1 tests the quality of the hazard and risk work, while Stage 2 scrutinizes the detailed design.

To provide that independent perspective, CPChem engaged SIS-TECH, a Houston-based engineering firm specializing in process safety management, instrumentation, and electrical systems. These early stages are more than technical exercises; they are financial safeguards.

"Stages 1 and 2 ensure a high-quality design everyone agrees on," explains Angela Summers,

President and CEO of SIS-TECH and a licensed professional engineer with over 30 years of experience in process safety. "If issues are found early, they're just changes to a document.

Once you get to Stage 3, when the equipment is already installed, the cost and delay can skyrocket."

Stage 3, which is underway now, will provide the ultimate confirmation: ensuring that what's installed in the field matches the design and performs exactly as intended before startup.

Stage 1: getting the hazard picture right

Stage 1 focused on the initial hazard and risk analysis. The goal is clarity: understanding which operational and business risks exist, what protection layers are required, and whether the assumptions behind those layers are sound.

Eloise Roche, a senior consultant at SIS-TECH, led the Stage 1 assessment. She describes the process as a "cold eyes" review that follows strict rules for identifying and describing instrumented protection layers.

"It's about confirming the risk assessment truly matches the process, and that the instrumented protections are independent, fully described, and aligned with the standard," says Roche.

Both Roche and Summers bring a unique perspective to these reviews. As long-time members of the ISA 84 committee and contributors to the international IEC 61511 safety standard, they don't just interpret the rules; they help write them.

"There is a big difference between trying to interpret the rules and being part of the multi-year process of crafting them," says Summers. "It's important to know the intent behind the standard and how to apply it across different regulatory environments worldwide."

For a mega-project of this scale, that rigor is es-



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sential. Multiple companies contribute to the design and execution, and responsibilities can blur. Clear documentation of roles and responsibilities is critical; without it, vital tasks can slip through the cracks. Bergen, from CPChem, has seen the challenge firsthand.

"We're building on proven designs from previous facilities, which gives us confidence in the overall concept," he says. "However, scaling up introduces complexity, more systems, more interfaces and more opportunities for risk. That's why we place a strong emphasis on detailed planning, thorough documentation and proactive risk mitigation strategies. The larger the project, the more critical it becomes to be deliberate and precise in how we manage safety."

Summers adds that this isn't just about safety, it's about protecting the business itself.

"When you're building bigger, you are also producing more," notes Summers. "If there's a disruption, the financial impact can escalate quickly: from lost production to missed delivery commitments. That's why early assessments matter so much."

Roche points to three factors that strengthen an assessment team:

Human performance: looking beyond hardware and logic to policies, procedures, and training and focusing on the people who will use and maintain the systems.

Seniority and experience: assessors who have seen enough projects, and enough problems, to recognize subtle inconsistencies that can cause trouble years later.

Standards competence: deep familiarity with the current SIS standard and related guidance, plus awareness of revisions on the horizon.

Stage 2: proving the design will deliver

With the hazard basis established in Stage 1, Stage 2 shifted focus to determining whether the detailed design could deliver the required level of safety performance. This phase is where SIL verification, voting architectures, diagnostics, and proof-test intervals are scrutinized against the hazard analysis. It's also where human factors and long-term maintainability begin to shape the design.

Stage 2 also laid the groundwork for safe, consistent plant operations once the facility is turned over. Procedures, proof-test methods, and train-

ing materials had to be aligned with the design so that operations and maintenance teams inherit a system they can sustain for decades.

"We believe that knowledge sharing is the most powerful safety tool," Bergen says. "If someone doesn't understand how a system works, or why it works a certain way, they're more likely to make mistakes. Our goal is to make it easier to succeed and harder to fail."

Stage 3: prove it in the field

Construction is now well underway. As sections of the plant are completed and turned over, Stage 3 will provide the ultimate confirmation: ensuring that what's been installed matches the design and performs as intended.

Summers notes that Stage 3 also aligns closely with regulatory requirements under OSHA's Process Safety Management (PSM) and the EPA's Risk Management Plan (RMP).

"It's the final check to ensure everything is installed, tested, and ready before a plant can safely start up," she says. "It includes inspecting hardware, reviewing test results, and confirming that operations and maintenance procedures, along with training, align with the design."

When functional safety systems work, potential issues are managed seamlessly, and operations continue without disruption.

For Bergen and the team at the Golden Triangle Polymers Project, they have their own way of measuring success.

"While this facility is rightfully recognized for its size, we want it to be known for its safety," Bergen concludes. "High production capacity and high safety standards are not mutually exclusive; they go hand in hand. Safety is embedded in our design philosophy, our work processes and our culture. It's not something we add on; it's something we build in from the start." •



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