



ENCOURAGING
Environmental
EXCELLENCE

Encouraging Environmental Excellence Achievement Level Recognition

February 7, 2017

The Ohio EPA Encouraging Environmental Excellence Program targets those who reduce waste, improve efficiency and work to continuously improve as an environmental steward. The program has a four-level approach to provide recognition to Ohio businesses and other organizations completing environmentally beneficial activities. Higher levels of recognition are for those who exceed regulatory requirements or commit to future environmental stewardship efforts. The Achievement Level recognizes any applicants completing environmentally beneficial activities. Any business, trade association, professional organization or local government in Ohio may apply. Achievement Level participants must demonstrate significant progress in one of eight environmental stewardship criteria: Impact to the environment; pollution prevention; energy efficiency; renewable energy; renewable, recovered or recycled materials; green building; recycling programs or organics diversion. Achievement Level participants must also demonstrate some level of progress in at least six additional environmental stewardship criteria and indicate they are in compliance with environmental laws and regulations.

Ohio EPA is recognizing the following organization that successfully met the criteria for the Achievement Level of the Encouraging Environmental Excellence Program. Below is a summary of their efforts.

Marathon Petroleum – Canton: The Marathon Petroleum Company Ohio Refining Division (Marathon) operates the Canton Refinery with approximately 360 employees. The facility is capable of converting 100,000 barrels of crude oil per day into gasoline, diesel fuel, kerosene, propane, sulfur, asphalt, roofing flux, home heating oil, and/or No. 6 industrial fuel oil. The facility's environmental policy commits them to pollution prevention practices and resource conservation.

Marathon uses the American Chemistry Council's Responsible Care program as its environmental management system. It has a Pollution Prevention and Waste Minimization Program to reduce air emissions, water releases and wastes generated at the refinery. New capital projects are reviewed to determine if they can reduce waste generation. Its "No Oil to the Sewer" (NOTS) and "No Solids to the Sewer" policies, both referred to as NOTS, guides daily operation of the facility. Marathon estimates that the NOTS policies has decreased the facility's wastewater treatment plant sludge by 48% over the last 6 years (4,744 tons in 2008 to 2,476 tons in 2015) resulting in \$400,000 annual savings. The Responsible Care audit teams are made up from employees from a variety of departments.

Marathon's recycling program allows for the collection of cardboard, plastic bottles, aluminum cans, office paper, batteries, and industrial metals, plastics, wood, and aerosol cans. Over 30 tons of office paper and cardboard is recycled annually. In 2015 over 868 tons of materials were diverted from the landfill through the recycling program. Marathon also sends their used catalytic cracking fluid and spent caustics to recycling facilities. Additives are used in their processes to reduce SOx and NOx emissions. Changes to their sampling systems help to stop purging hydrocarbons to the atmosphere. Improvements to their control equipment, monitoring, and changing their heater fuel has resulted in reduced emissions

as well. Marathon's Title V emissions of criteria pollutants have been reduced to half of their 2002 levels while maintaining their level of refining. In 2015, Marathon began sending lime slurry from its refinery to another company for use in brick manufacturing.

Marathon is one of 44 refineries in the US to have received Energy Star certification. They achieved this certification through optimizing their heater effluent streams, optimizing steam usage, regular maintenance of their heat exchangers and steam traps, and the installation of heater tube seals. Employee volunteers have begun to convert three acres of nearby land into a wildlife habitat with a focus on pollinators. Their Environmental Department also sponsors an annual household hazardous waste collection event for its employees and contractors.

The recognition of Marathon Petroleum Company LP - Ohio Refining Division at the E3 Achievement Level results from our ongoing efforts within the Division of Environmental and Financial Assistance to expand E3 recognition beyond manufacturing facilities traditionally recognized by the program. This facility produces various types of fuels and joins the widening array of organizations recognized by the E3 program that also include communities, universities, and wastewater treatment plants.

For more information about the Encouraging Environmental Excellence Program and the four levels of recognition, visit www.epa.ohio.gov/ohioE3.aspx or call (800) 329-7518.