

TO: Recovery Boiler Managers, Steam Chiefs, Superintendents, Supervisors, AF&PA Recovery Boiler Program Members, and Other Recovery Boiler Professionals

**2025 AF&PA RECOVERY BOILER
OPERATIONAL SAFETY SEMINARS
& REVIEW OF AF&PA - BLRBAC GUIDELINES
BOTH VIRTUAL & IN-PERSON FORMATS**

Please Mark Your Calendar and Plan for Your Operators, Supervisors, Maintenance Professionals, and Engineers to Attend These Informative Seminars with Eight (8) New BLRBAC Incident Team Exercises for the 2025 Safety Seminars. Eight (8) all new case studies are used each year.

- **May 22, 2025 (7:15 am - 4:00 pm) Pacific Time – Online Virtual Format**
 - This is (10:15 am - 7:00 pm) in Eastern Time
- **September 18, 2025 (7:15 am - 4:00 pm) Pacific Time – Online Virtual Format**
 - This is (10:15 am - 7:00 pm) in Eastern Time
- **October 8-9, 2025, Eastern Time – Hilton Atlanta Airport Hotel – In-Person Format**
 - The October Safety Seminar Starts at 1:00 pm Wednesday October 8th, after the 2025 Fall BLRBAC Adjourns.
 - This Safety Seminar concludes at 12:00 noon on Thursday October 9th.

Unfortunately, a Recovery Boiler explosion occurred in North America in 2020, and 5 Dissolving Tank Explosions were reported in 2024. In 2024, there were 36 incidents in the USA and Canada reported to BLRBAC. Of these, 6 incidents were classified as critical. Some of these incidents were considered very serious and it was lucky there were no additional explosions. BLRBAC defines “critical” as meaning water could have entered the unit forward of isolating baffles, and there was a potential of an explosion. Training and reaction to the situations apparently saved the day in many cases. Learning to recognize the situation before it becomes critical is a big part of the battle. With the increased number of new people or less experienced people working in the Recovery Boiler area, companies are realizing the need for more training. Of the incidents reported last year, 78% were discovered by “walk-downs”, thus finding small problems before turning into large problems.

In addition to the 5 Dissolving Tank Explosions, there was also 1 significant Dissolving Tank incident reported last year. The AF&PA Recovery Boiler Committee feels there have been more upsets in this area that are not reported. Since 2015, 10 Dissolving Tank explosions have been reported to BLRBAC. AF&PA continues to study the Dissolving Tank explosion issue to reduce these upsets and to develop best practices to safely operate Dissolving Tanks.

Much is learned from the reported incidents. The Committee feels that more mills are realizing the need for people operating Recovery Boilers to further their knowledge and understanding of the safe operation of Recovery Boilers. As we see, most pressure part leaks are still found during Operator “walk-downs” which supports the conclusion that the Operators are more aware of what, where, and how to look for leaks, and to find them as early as possible. The greatest challenge we face in the Recovery Boiler operation is the recognition of major tube leaks followed by the Operator’s correct and timely reaction to the emergency. The Seminars focus on the proper training and handling of these upset situations to minimize exposure to personnel; reduce injuries; as well as down time and damage. The outstanding dialogue among attendees was again cited as a key factor in responses rating the Seminars as “Excellent.” The responses repeatedly

mentioned that the **main objective of the Seminars** - the need to **increase awareness in safely operating Recovery Boilers - as most important.**

Thus, with the above factors heard from the mills, there is greater emphasis for these Seminars. The cost for someone attending these Safety Seminars is rather small compared to the possible injuries and costs of an upset in a Recovery Boiler. Based on inquiries already received, we anticipate very good attendance from Operators, Supervisors, Superintendents, Maintenance Professionals, Engineers, Steam Chiefs, and Managers. The Safety Seminars are planned for active participation by each attendee.

The Safety Seminars are being offered in **BOTH** remote **Virtual Online**, and **In-Person** Formats. Seminars are also offered in both **North American Eastern Time** and **North American Pacific Time** to accommodate multiple time zones. Registration forms and agendas for each Safety Seminar are enclosed.

Note: Registration is limited to members of Companies and Mills that operate Recovery Boilers.

For the Virtual Online Safety Seminars (May 22, 2025 & September 18, 2025), the registration fee for the Recovery Boiler Operational Safety Seminars is **only \$250 per person** for AF&PA Recovery Boiler Program Member Companies (\$400 per person for Non-Member Companies).

Please complete an enclosed registration form indicating which Safety Seminar you wish to attend and return it to me along with your registration fee made payable to "AF&PA". The attached Registration Forms can be completed and returned to me as soon as you know by email or sent by mail to the address indicated on the form. To register by phone, call: Wayne Grilliot at (937) 602-1892.

The Virtual Online Operational Safety Seminars will be conducted online using Webex Video and Audio Conferencing. You do not need to subscribe to Webex to join the Safety Seminars. To use Webex, you can either download the Webex software to your computer when prompted in the pop-up after clicking the Webex Link that will be provided, or you can choose to use the Browser option which is listed under the Download option in the pop-up. With the Browser option, you do not need to download the Webex software. Please check with your IT Group to make sure the Webex software is allowed on your company computers. If the Webex software is not allowed on your company computers, you will need to use the Browser option. Both options are usually straightforward and normally do not require anything special, but it is best to test it prior to the Seminar. There is no download or connection fee from Webex to participate. A computer with an internet connection and microphone & speaker enabled are required to participate in the Safety Seminars. A computer camera enabled is preferred, but not required. I will be available if you wish to test the Webex connection with your computer & conference room equipment prior to the session, just contact me at wayne_grilliot@afandpa.org or (937) 602-1892 to set up a time.

The Seminars will start with everyone in one large group (the Main Seminar Session). For the Recovery Boiler BLRBAC Incidents Team Exercises, the participants will automatically be grouped into smaller, pre-assigned Breakout Team Sessions. After the scheduled Breakout Team Session time, all participants will automatically rejoin the Main Seminar Session to report out and discuss their team's findings & recommendations with the other participants. The transition between sessions should happen seamlessly for the participants. Additional details and Seminar materials will be provided to the registrants prior to the Safety Seminars.

For the **In-Person Safety Seminar (October 8-9, 2025)**, the registration fee for the Recovery Boiler Operational Safety Seminars is **only \$500 per person** for AF&PA Recovery Boiler Program Member Companies (\$800 per person for Non-Member Companies).

Note: The Safety Seminar registration fee does not include the BLRBAC Meeting attendance fee, which requires a separate registration through: <https://blrbac.net>

The October 8-9, 2025, (In-Person) Safety Seminar will be held at the Hilton Atlanta Airport Hotel, 1031 Virginia Ave, Atlanta, Georgia 30354, the same hotel as the 2025 Fall BLRBAC Meeting. This Safety Seminar starts at 1:00 pm Wednesday, October 8th, after the BLRBAC Meeting adjourns, and concludes at 12:00 noon Thursday, October 9th.

Information on hotel reservations for the (October 8-9, 2025) In-Person Safety Seminar will be provided later.

If there are any questions concerning these Recovery Boiler Safety Seminars, please do not hesitate to contact me at: wayne_grilliot@afandpa.org or (937) 602-1892. Thank you.

Attachments:

- **Virtual Online Safety Seminar Registration Form** (May 22, 2025, & September 18, 2025)
- **In-Person Safety Seminar Registration Form** (October 8-9, 2025)
- **Virtual Safety Seminar Agendas** (May 22, 2025, & September 18, 2025)
- **In-Person Safety Seminar Agenda** (October 8-9, 2025)
- Operating Problems Discussion Suggestion Sheet



REGISTRATION FORM
FOR THE (VIRTUAL ONLINE) SAFETY SEMINARS
2025 OPERATIONAL SAFETY SEMINARS &
REVIEW OF AF&PA AND BLRBAC GUIDELINES

These 2 Virtual Safety Seminars are scheduled in North American Pacific Time.
For Multiple Participants from a single location, registration fees are based on per participant.

We plan to have the following number of people participate in the 2025 Online Virtual Safety Seminars.

May 22, 2025 (number of people) _____ September 18, 2025 (number of people) _____
Online: 7:15 am – 4:00 pm Pacific Time **Online: 7:15 am – 4:00 pm Pacific Time**
○ 10:15 am – 7:00 pm in Eastern Time ○ 10:15 am – 7:00 pm in Eastern Time

Registration fee \$250 (USD) per person for AF&PA Recovery Boiler Program Member Companies.
Registration fee for Non-Member Companies is \$400 (USD) per person.

Attendees (Attendee substitutions, due to mill scheduling changes or any reason, can be made any time)

Names: _____
Titles: _____
Emails: _____
Telephones: _____
Cell Phones: _____
Company: _____
Mill: _____
Address: _____

Date: _____

Let us know of any special requests: _____

Please return this form and payment by Email or Mail to:

**AF&PA Recovery Boiler Program
C/O: Program Excellence, LLC
Attn: Wayne Grilliot, Manager
712 Murrell Drive
Kettering, Ohio 45429**

Email: wayne_grilliot@afandpa.org

**To register by phone, call:
Wayne Grilliot (937) 602-1892**

Please make checks payable to: AF&PA

Name: _____
Email: _____
Telephone: _____
Mobile: _____

Call Wayne Grilliot at (937) 602-1892, if you prefer to provide your credit card information by phone.

If paying by credit card (please provide the following)

Type of credit card: _____
Credit card number: _____
Card verification code (CVC): _____
Card expiration date: _____
Full Name on the card: _____
Amount to be charged to credit card: _____

Let me know if you have questions. Thank you!



REGISTRATION FORM
FOR THE (IN-PERSON) SAFETY SEMINAR
2025 OPERATIONAL SAFETY SEMINAR &
REVIEW OF AF&PA AND BLRBAC GUIDELINES

This In-Person Safety Seminar is scheduled for 2 Half-Day Sessions. The Day #1 session starts at 1:00 pm Wednesday, after the BLRBAC Meetings adjourn and is scheduled from 1:00 pm to 5:00 pm (Eastern Time). The 2nd Day sessions are scheduled from 8:00 am to 12:00 Noon (Eastern Time).

We plan to have the following number of people participate in the 2025 In-Person Safety Seminar.

October 8-9, 2025 (number of people) _____
Hilton Atlanta Airport Hotel

Registration fee \$500 (USD) per person for AF&PA Recovery Boiler Program Member Companies.
Registration fee for Non-Member Companies is \$800 (USD) per person.

Attendees (Attendee substitutions, due to mill scheduling changes or any reason, can be made any time)

Names: _____
Titles: _____
Emails: _____
Telephones: _____
Cell Phones: _____
Company: _____
Mill: _____
Address: _____

Date: _____

Let us know of any dietary restrictions or special requests: _____

Please return this form and payment by Email or Mail to:

AF&PA Recovery Boiler Program
C/O: Program Excellence, LLC
Attn: Wayne Grilliot, Manager
712 Murrell Drive
Kettering, Ohio 45429

Email: wayne_grilliot@afandpa.org

To register by phone, call:
Wayne Grilliot (937) 602-1892

Please make checks payable to: AF&PA

Name: _____
Email: _____
Telephone: _____
Mobile: _____

Call Wayne Grilliot at (937) 602-1892, if you prefer to provide your credit card information by phone.

If paying by credit card (please provide the following)

Type of credit card: _____
Credit card number: _____
Card verification code (CVC): _____
Card expiration date: _____
Full Name on the card: _____
Amount to be charged to credit card: _____

Let me know if you have questions. Thank you!

AF&PA RECOVERY BOILER PROGRAM
VIRTUAL OPERATIONAL SAFETY SEMINAR &
REVIEW OF AF&PA AND BLRBAC GUIDELINES

May 22, 2025

7:15 am – 4:00 pm (PDT)

(International Coordinated Universal Time Zone: -7 hours)

Online Safety Seminar

Pacific Daylight Saving Time

AGENDA

- 7:15 – 7:30 am Sign-in / Verify Computer Connections & Seminar Materials
- Wayne Grilloit – AF&PA Recovery Boiler Program
- 7:30 am Welcome, Opening Remarks, AF&PA Antitrust Policy, Process, Introductions
Explanation and Outline of Seminar / Review Format by Monitors
- John Andrews
 - Former BLRBAC ESP Subcommittee Chairman
 - Boiler Services & Inspection, LLC (BSI)
 - Dean Clay
 - BLRBAC ESP Subcommittee Secretary
 - Boiler Services & Inspection, LLC (BSI)
- 7:40 am BLRBAC 2024 Incident Summary Review
- John Andrews
- 8:10 am Interlocks and Interlock Bypassing – Dean Clay
- Purpose of interlocks
 - Major interlock systems on Recovery Boilers
 - Specific procedures employed when interlocks are not functioning
- 8:25 am Review of ESP Subcommittee Learnings from Reported Incidents
- John Andrews
- 8:55 am Recovery Boiler BLRBAC Incidents 1, 2, 3, & 4 – Breakout Team Assignments
- 35 Minutes
- 9:30 am 10 Minute Break
- 9:40 am Team Report Outs and Open Discussions of BLRBAC Incidents 1, 2, 3, & 4
- 11:20 am Recovery Boiler Explosion History – Prevention (Part 1)
Pyrolysis Gas, Recovery Boiler Safety Audits, BLRBAC and AF&PA Resources
- Dean Clay
- 11:30 am 30 Minute Break

AF&PA RECOVERY BOILER PROGRAM
VIRTUAL OPERATIONAL SAFETY SEMINAR &
REVIEW OF AF&PA AND BLRBAC GUIDELINES

May 22, 2025

7:15 am – 4:00 pm (PDT)

(International Coordinated Universal Time Zone: -7 hours)

Online Safety Seminar

Pacific Daylight Saving Time

AGENDA / (cont.)

12:00 Noon	Questions from the morning session? / Explanation of afternoon's activities
12:05 pm	Recovery Boiler Explosion History – Prevention (Part 2) Pyrolysis Gas, Recovery Boiler Safety Audits, BLRBAC and AF&PA Resources <ul style="list-style-type: none">• Dean Clay
12:40 pm	Analysis of Dissolving Tank Explosions - Prevention <ul style="list-style-type: none">• John Andrews
1:00 pm	Recovery Boiler BLRBAC Incidents 5, 6, 7, & 8 – Breakout Team Assignments <ul style="list-style-type: none">• 35 Minutes
1:35 pm	10 Minute Break
1:45 pm	Team Report Outs and Open Discussions of BLRBAC Incidents 5, 6, 7, & 8
3:15 pm	Leak Detection Systems – Dean Clay What are the signs of a leak in the control room? <ul style="list-style-type: none">• Indications of a Pressure Part Leak• Decision Time• Best Practices and use of Decision Charts
3:35 pm	Opportunities to Improve Recovery Operations - Summary and Discussion <ul style="list-style-type: none">• John Andrews
3:45 pm	Review of Submitted “Operating Problems - Discussion Suggestion Sheets” and any other Questions.
3:55 pm	Closing Remarks
4:00 pm	Adjourn

AF&PA RECOVERY BOILER PROGRAM
VIRTUAL OPERATIONAL SAFETY SEMINAR &
REVIEW OF AF&PA AND BLRBAC GUIDELINES

September 18, 2025

7:15 am – 4:00 pm (PDT)

(International Coordinated Universal Time Zone: -7 hours)

Online Safety Seminar

Pacific Daylight Saving Time

AGENDA

- 7:15 – 7:30 am Sign-in / Verify Computer Connections & Seminar Materials
- Wayne Grilloit – AF&PA Recovery Boiler Program
- 7:30 am Welcome, Opening Remarks, AF&PA Antitrust Policy, Process, Introductions
Explanation and Outline of Seminar / Review Format by Monitors
- John Andrews
 - Former BLRBAC ESP Subcommittee Chairman
 - Boiler Services & Inspection, LLC (BSI)
 - Dean Clay
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- 7:40 am BLRBAC 2024 Incident Summary Review
- John Andrews
- 8:10 am Interlocks and Interlock Bypassing – Dean Clay
- Purpose of interlocks
 - Major interlock systems on Recovery Boilers
 - Specific procedures employed when interlocks are not functioning
- 8:25 am Review of ESP Subcommittee Learnings from Reported Incidents
- John Andrews
- 8:55 am Recovery Boiler BLRBAC Incidents 1, 2, 3, & 4 – Breakout Team Assignments
- 35 Minutes
- 9:30 am 10 Minute Break
- 9:40 am Team Report Outs and Open Discussions of BLRBAC Incidents 1, 2, 3, & 4
- 11:20 am Recovery Boiler Explosion History – Prevention (Part 1)
Pyrolysis Gas, Recovery Boiler Safety Audits, BLRBAC and AF&PA Resources
- Dean Clay
- 11:30 am 30 Minute Break

AF&PA RECOVERY BOILER PROGRAM
VIRTUAL OPERATIONAL SAFETY SEMINAR &
REVIEW OF AF&PA AND BLRBAC GUIDELINES

September 18, 2025

7:15 am – 4:00 pm (PDT)

(International Coordinated Universal Time Zone: -7 hours)

Online Safety Seminar

Pacific Daylight Saving Time

AGENDA / (cont.)

12:00 Noon	Questions from the morning session? / Explanation of afternoon's activities
12:05 pm	Recovery Boiler Explosion History – Prevention (Part 2) Pyrolysis Gas, Recovery Boiler Safety Audits, BLRBAC and AF&PA Resources <ul style="list-style-type: none">• Dean Clay
12:40 pm	Analysis of Dissolving Tank Explosions - Prevention <ul style="list-style-type: none">• John Andrews
1:00 pm	Recovery Boiler BLRBAC Incidents 5, 6, 7, & 8 – Breakout Team Assignments <ul style="list-style-type: none">• 35 Minutes
1:35 pm	10 Minute Break
1:45 pm	Team Report Outs and Open Discussions of BLRBAC Incidents 5, 6, 7, & 8
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3:35 pm	Opportunities to Improve Recovery Operations - Summary and Discussion <ul style="list-style-type: none">• John Andrews
3:45 pm	Review of Submitted “Operating Problems - Discussion Suggestion Sheets” and any other Questions.
3:55 pm	Closing Remarks
4:00 pm	Adjourn

AF&PA RECOVERY BOILER PROGRAM
IN-PERSON OPERATIONAL SAFETY SEMINAR &
REVIEW OF AF&PA AND BLRBAC GUIDELINES

October 8, 2025

1:00 pm – 5:00 pm (Eastern Time)

Hilton Atlanta Airport Hotel

Grand D Room

AGENDA (In-Person Safety Seminar)

- 1:00 pm Register / Team Assignments / Seminar Materials
- Wayne Grilliot – AF&PA Recovery Boiler Program
- 1:10 pm Welcome, Opening Remarks, AF&PA Antitrust Policy, Process, Introductions
Explanation and Outline of Seminar / Review Format by Monitors
- John Andrews
 - Former BLRBAC ESP Subcommittee Chairman
 - Boiler Services & Inspection, LLC (BSI)
 - Dean Clay
 - BLRBAC ESP Subcommittee Secretary
 - Boiler Services & Inspection, LLC (BSI)
- 1:20 pm BLRBAC 2024 Incident Summary Review
- John Andrews
- 1:50 pm Interlocks and Interlock Bypassing – Dean Clay
- Purpose of interlocks
 - Major interlock systems on Recovery Boilers
 - Specific procedures employed when interlocks are not functioning
- 2:05 pm Review of ESP Subcommittee Learnings from Reported Incidents
- John Andrews
- 2:30 pm Recovery Boiler BLRBAC Incidents 1, 2, 3, & 4 – Breakout Team Assignments
- 35 Minutes
- 3:05 pm 10 Minute Break
- 3:15 pm Team Report Outs and Open Discussions of BLRBAC Incidents 1, 2, 3, & 4
- 4:50 pm Recovery Boiler Explosion History – Prevention (Part 1)
Pyrolysis Gas, Recovery Boiler Safety Audits, BLRBAC and AF&PA Resources
- Dean Clay
- 5:00 pm Adjourn
- 6:00 pm Dinner – Red Eye Private Dining Room

AF&PA RECOVERY BOILER PROGRAM
IN-PERSON OPERATIONAL SAFETY SEMINAR &
REVIEW OF AF&PA AND BLRBAC GUIDELINES

October 9, 2025

7:00 am – 12:00 Noon (Eastern Time)

Hilton Atlanta Airport Hotel

Grand D Room

In-Person Safety Seminar

AGENDA / (cont.)

7:00 am	Continental Breakfast
8:00 am	Questions from the yesterday's session? / Explanation of today's activities
8:05 am	Recovery Boiler Explosion History – Prevention (Part 2) Pyrolysis Gas, Recovery Boiler Safety Audits, BLRBAC and AF&PA Resources <ul style="list-style-type: none">• Dean Clay
8:40 am	Analysis of Dissolving Tank Explosions - Prevention <ul style="list-style-type: none">• John Andrews
9:00 am	Recovery Boiler BLRBAC Incidents 5, 6, 7, & 8 – Breakout Team Assignments <ul style="list-style-type: none">• 35 Minutes
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11:35 am	Opportunities to Improve Recovery Operations - Summary and Discussion <ul style="list-style-type: none">• John Andrews
11:45 am	Review of Submitted “Operating Problems - Discussion Suggestion Sheets” and any other Questions.
11:55 am	Closing Remarks
12:00 Noon	Adjourn

OPERATING PROBLEMS

DISCUSSION SUGGESTION SHEET

Please take a moment to share your thoughts!!!
Just jot down some things you would like to have discussed!!!

SUCCESSES	CHALLENGES	QUESTIONS	ISSUES

POSSIBLE TOPICS: Precipitators, carbon steel, sootblowers, steam outs, instrumentation, ID fan, green liquor, FD fan, burner management, hoppers, superheater, water wash, cyclone evaporator, egress, insurance, spout cooling, qualification, plugging, generating bank, density, lagging, corrosion, combustibles, ESP, blowdown, pumps, capacity, agitators, metal spray, NDE, scaffolding, refractory temperature, agitators, drum level, air heater, emergency, personnel, atomizing steam, nozzles, sarco strainer, safety shut/off valves, smelt, near drum corrosion, double valve and tell-tale, refractory temperature, metal spray, flame detector, studs, fire protection, sprayer plates.

Completed forms may be submitted prior to the Seminar. Send to: wayne_grilliot@afandpa.org
Questions may also be submitted any time during the Safety Seminar.

Also, please offer your suggestions on how to improve these Recovery Boiler Operational Safety Seminars.
Thank you.