



Pollution Prevention Pays!

Nexen Chemicals Canada Limited Partnership ***Process Modifications / Chemical Producers***

DESCRIPTION OF PROJECT:

Nexen Inc, (formerly Canadian Occidental Petroleum Ltd.) is a global energy and chemicals company with core assets and targeted exploration programs worldwide including Western Canada, the Gulf of Mexico, Yemen, Nigeria, Australia, Brazil, Columbia and Indonesia. Our employees give Nexen Inc. its competitive advantage by collectively providing the energy to outperform.

Nexen Chemicals is one of the lowest-cost producers of sodium chlorate and the Brandon plant is the most efficient of the seven manufacturing facilities operated by Nexen Chemicals. The Brandon facility began operation in 1968 manufacturing sodium chlorate, chlorine, hydrochloric acid and caustic soda. In 1978, all but the sodium chlorate production was terminated. In the early 80's, the employees undertook an aggressive campaign to eliminate liquid discharge to the Assiniboine River. Since 1982, the plant has operated a closed looped water system in which all process discharges are collected and recycled back into the brine system, the process starting point.

Recent changes in pulp bleaching technologies have eliminated the use of cell liquor, which historically had acted as an impurity purge for chlorate producers. In addition, quality specifications on crystal chlorate are getting tighter and tighter, putting even more pressure on the management of impurities. The closed loop forced the Brandon Plant to deal with this in 1982, giving this plant somewhat of a head start in responding to this challenge.

BENEFITS:

Environmental: Since 1982, there have been no discharges from the plant to the Assiniboine River.

Economic: Approximately \$2000/month of reusable chemicals previously discharged are recovered.

Social: This enhanced employee awareness of commitment to continuously improve operations beyond minimum acceptable standards.

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The purpose of this sheet is to give recognition to this specific activity in pollution prevention. Environment Canada does not per se endorse the company.

