

# Fact Sheet

## ConocoPhillips Billings Refinery Coke Drum Replacement Project

### Overview and timing:

The first of four coke drum shipments is slated to leave the Port of Lewiston at 10 p.m. on Tuesday, February 1. As with all of the shipments, it will travel no later than 5:30 a.m. the next day when it will pull off the road at pre-determined stopping points where it will remain until the next evening. The transporter is expected to travel approximately 40 miles per night.

The first transporter is expected to take four days to travel from Lewiston to the Montana border. The second shipment will leave the Port of Lewiston once the first shipment crosses the border into Montana.

Once the first two shipments reach Billings, the coke drums will be offloaded and the transporters disassembled and returned to Lewiston. This process will take approximately two weeks. The disassembled transporters will be shipped back to Lewiston on standard 18-wheeled trucks, and then reassembled to take the remaining two shipments to Billings. We expect the last two shipments to leave Lewiston at the end of March/early April.

ConocoPhillips has established a toll-free number to provide daily updates on the progress of the shipments. The number is: **1-866-535-0138.**

#### For more information:

John Roper:  
281-293-2073

Bill Stephens:  
281-827-3730

Rich Johnson:  
281-293-1286

Daily status info line: 1-866-535-0138

### Project Background and Transportation Logistics

#### About the project

As part of a scheduled maintenance plan for the Billings refinery, ConocoPhillips is replacing two vessels known as coke drums. Built only by a handful of overseas manufacturers, the new specialized drums were completed and transported about 5,200 miles by ocean freighter and 300 miles by river barge to Lewiston, Idaho. The manufacturer completed each drum in two sections to accommodate ground transportation for the final 700 road miles to Billings.

#### Focused on safety

Everything about this project is designed to focus on safety – from maintaining safe, reliable refinery operations, to selecting reputable companies to build and transport the drums, to working closely with all appropriate agencies and stakeholders on transportation logistics. State police will escort the transporters on the road, and emergency vehicle access will be maintained along the entire route.

#### Shipment statistics

Destination: ConocoPhillips refinery, Billings, Montana

Number of shipments: 4

Loaded transporter dimensions:

- Weight: Approximately 300 tons
- Length: 226 feet
- Width: 29 feet
- Height: 28 feet
- Number of axles: 24 per transporter
- Number of wheels: 96 per transporter

Type of vehicles in convoy: Heavy-haul trucks, traffic control vehicles, state police escorts, ambulance escort and utility trucks

Number of people supporting each convoy: Approximately 30

Hours of travel: 10 p.m. to 5:30 a.m. (6 a.m. in Montana)

Number of days to transit Idaho: 4

Number of days to transit from Idaho border to Billings, Montana: 14 over a 23-day period

Transportation company: Emmert International, headquartered in Clackamas, Oregon

Years in planning: 3+

Length of transportation plan: 700+ pages

#### Careful route selection

Many factors were taken into consideration before choosing the transportation route to Billings. These include road widths, conditions, traffic, intersections, weight and height restrictions, mileage, curves and turns, and potential obstacles. The selected route best met these criteria. The route was reviewed for permit compliance with the Idaho and Montana transportation departments. To protect this route and meet load weight regulations, the drums will travel on specialized road-friendly transporters that spread weight evenly over multiple axles and wheels.

#### Mindful of traffic

The travel plan was specifically designed to keep traffic flowing. All drum travel will take place between 10 p.m. and 5:30 a.m. when traffic is at its lightest. There are also plans in place for the transporter to pull over frequently, allowing the small number of vehicles that may be on the road to pass the slow-moving transporter and preventing lengthy traffic delays. Studies have been conducted to explore traffic impacts to motorists. For example, according to a detailed count by the Idaho Department of Transportation, traffic averages less than 20 vehicles per hour on US 12 between Lewiston, Idaho, and Lolo, Mont., during the times the drums will travel.

#### Investing in Montana and Idaho

In operation for more than 60 years, ConocoPhillips' Billings refinery has a workforce of more than 400 people. In addition to promoting safe, reliable operations for these employees, the drum replacement and other planned maintenance will also help the regional economy by employing another 1,700 people through contracted firms, and by purchasing significant goods and services. The project will also help ConocoPhillips continue to supply the people of Montana, Idaho and other nearby states with about 400 million gallons of motor and jet fuel per year.

#### What are coke drums?

Coke drums are the integral part of a refining unit known as a coker, which applies heat and pressure to convert heavier, less valuable components of crude oil into lighter, more useful petroleum products such as gasoline, diesel and jet fuel. This process also produces coke, a solid, black industrial fuel resembling charcoal.

#### Why replace these drums?

ConocoPhillips is replacing the coke drums currently operating at Billings because they are approaching the end of their useful life. Installing new drums and conducting other planned maintenance promote safe, reliable refinery operations and product supply to motorists in several states in the region.