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# HAZARDS ANALYSIS

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**Keywords** Spiritual Safety, Process Safety, Chemical Engineering, Risk Assessment

## Learning Outcomes

- Outline the systematic steps for conducting a hazards analysis: Define process, Identify method, Identify top events, and Document findings.
- Compare and select appropriate analysis methods (e.g., What-If, HAZOP, FMEA, FTA) based on process complexity.
- Understand the importance of performing analysis early in the design phase to effectively reduce risk.

## Reading

- Foundations of Spiritual and Physical Safety: with Chemical Processes; Chapter 5, Sections 2 (Intro, up to Section 2.1)
- Job Hazards Analysis Template: <https://uolab.groups.et.byu.net/files/safety/JHATemplate.docx>

## 1 Effective Hazards Analysis Steps

Hazard Identification and Evaluation with Risk Analysis and Assessment

1. Define the process

This step can involve collecting documentation such as a process flow diagram (PFD), piping and instrumentation diagram (P&ID), operating procedure and other relevant information. It is also important to gather information about the process, such as the materials used, and the operating conditions among other things.

2. Identify the hazards analysis method to use

Hazards analysis methods include HAZOP, FMEA, and fault tree analysis (FTA). The choice of method will depend on the specific process and the goals of the analysis.

3. Identify the Hazardous Top Level Event and contributing factors with

- a Fault Tree Analysis (FTA)
  - Including deductive and inductive reasoning
- a HAZOP (Hazards and Operability Study)
  - Including guide words and deviations

4. Fill out a Hazards Analysis (HA) Table

For each failure mode (the lower level events in your fault tree analysis), fill out the hazards analysis table including the following information:

- Task description or process step
- Hazard type
- Hazard description
- Event consequence
- Safeguards currently present to mitigate the hazard
- Rank (1A to 5E) for severity and likelihood of the hazard
- Recommendations to reduce the risk of the hazard

5. Potentially complete a quantitative risk analysis for those hazards with a high risk ranking

6. Incorporate other PSM elements per the OSHA 1910.119 standard

## 2 Hazards Analysis Methods

Some of the possible methods that can be used include:

- Checklists
- What If
- Five (5) Why's
- Fishbone
- Bowtie
- JHA (Job Hazard Analysis)
- HAZOP (Hazard and Operability Study)
- FTA (Fault Tree Analysis)
- FMEA (Failure Mode and Effects Analysis)

# EFFECTIVE

## Hazard Identification & Evaluation with Risk Analysis & Assessment

- 1 - Define Process
- 2 - Identify Analysis Method
- 3 - Identify Top level Events  
and contributing factors using
  - Fault Tree Analysis with FMEA  
*Deductive w/ Inductive Logic*
  - HAZOP (Hazards & Operability Study)  
*Use Guide words @ P310*
- 4 - Complete Line Items on FMEA or  
HAZOP to identify:
  - Consequences      • Risk Rating      • Failure Mode
  - Safeguards          • Recommendations
- 5 - Potentially complete & Quantitative  
Analysis for highest hazards
- 6 - Incorporate other PSM factors  
to reduce risk (14 items)

Figure 1: Effective Hazards Analysis Steps



Figure 2: Bowtie Example

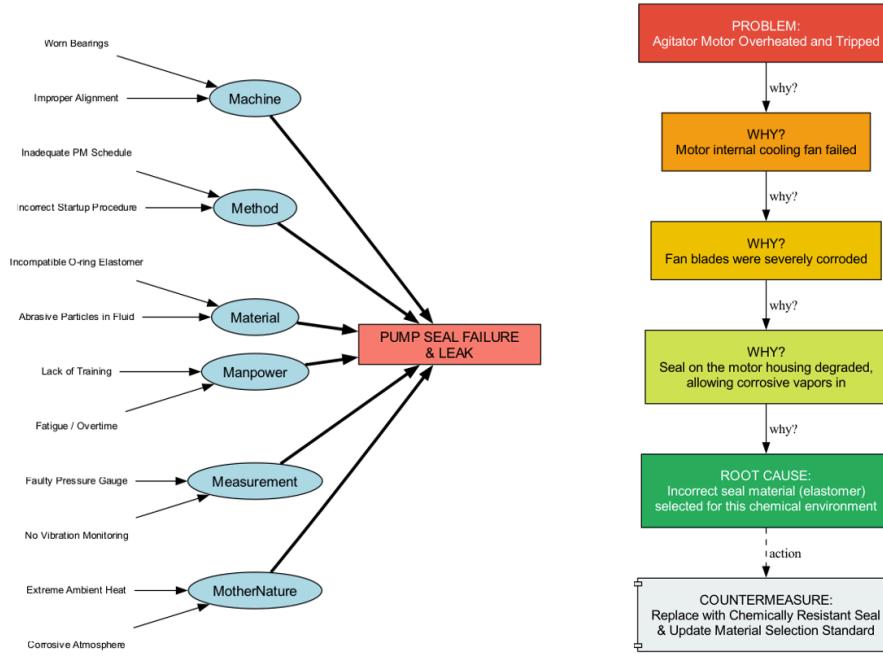


Figure 3: Fishbone and Five Why Example

## 2.1 Bowtie

## 2.2 Fishbone and Five (5) Why

## 3 Recommended Methods

The recommended methods for hazards analysis that we used effectively in evaluating explosive, pyrotechnic, and propellant based processes included:

- Fault Tree Analysis (FTA) with deductive and inductive reasoning followed by Failure Mode and Effects Analysis (FMEA) where the HA table is filled out for each failure mode.
- HAZOP (Hazards and Operability Study) with guide words and deviations

Figure 4: JHA Template

## 4 When Should you Conduct a Hazards Analysis? As early in the process as feasible.

Many complex processes have been designed and built prior to completion of a hazards analysis (FTA with a FMEA, or HAZOP). This makes integration of engineering controls into the process very difficult or costly or both. Ideally you complete a hazards analysis at the design stage and other stages including:

- Design (a Design Hazards Analysis)
- Construction and Startup
- Operation

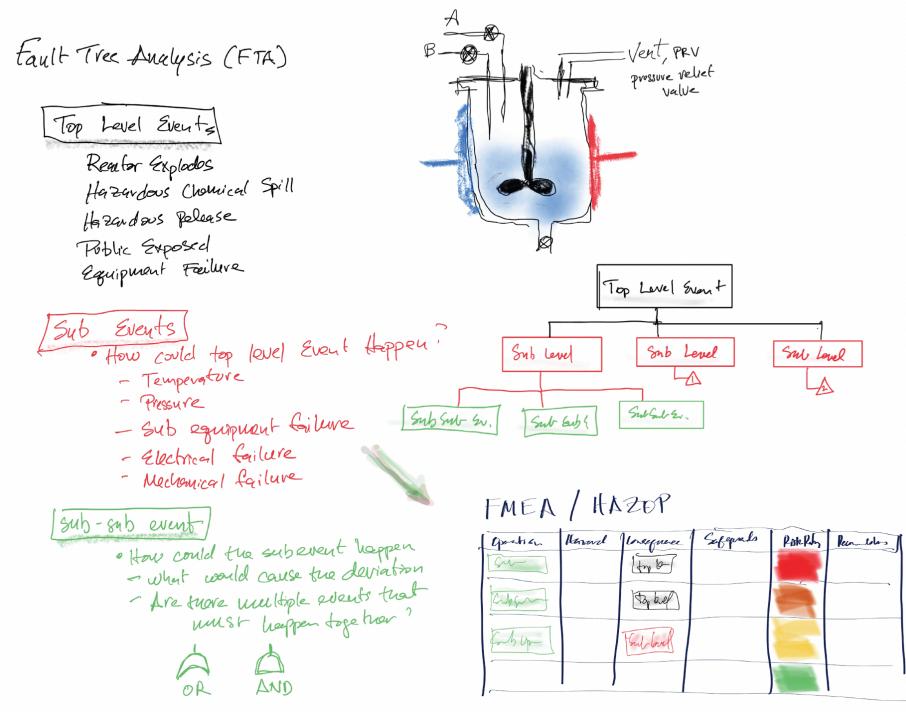


Figure 5: Fault Tree Analysis to Hazards Analysis Table

- Decommissioning
- Accident Investigation

## 5 Process Safety Information (PSI) is Critical

Process safety information including details of the process, the materials used, and the operating conditions is critical to completing a hazards analysis. We'll talk a lot more about PSI.

Other helpful graphics for hazards analysis and review download pdf: <physical/supportfiles/FTAwRev1.pdf>

### Action Items

1. Following the "Canning Green Beans Procedure," Example Scenario: Canning Green Beans complete a Hazards Analysis (HA) table for the first five steps of the process, identifying the hazard type, consequence, and current safeguards. Use this template <https://uolab.groups.et.byu.net/files/safety/JHATemplate.docx>
2. Explain why it is critical to conduct a hazards analysis as early as feasible in the design process. Write 1 or 2 complete sentences.

## NEEDED INFORMATION FOR EFFECTIVE HAZARDS ANALYSIS

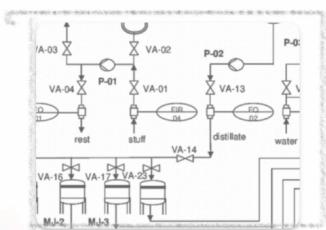
### Chemical Information

- Flammability
- Toxicity
- Reactivity



### Process Information

- PFD (Process Flow Diagrams)
- P&ID's (Piping & Instrumentation Diagrams)
- Equipment details
- Procedures
  - Start-Up
  - Operation
  - Shut Down



### Other Important Info

- Near Miss Details
- Accident History

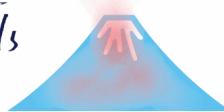


Figure 6: Needed Information for Effective Hazards Analysis