

## Closure Plan (Revision No. 1)

### Bottom Ash Pond

#### Sherburne County Generating Plant

April 27, 2021

## Introduction

This plan describes the steps necessary to close the Bottom Ash Pond (BAP) at the Sherburne County Generating Plant (Sherco) in Becker, Minnesota. The BAP is an existing coal combustion residual (CCR) surface impoundment. This document addresses the requirements of 40 CFR §257.102.

### §257.102 (b)(1) Written Closure Plan

*(i) A narrative description of how the CCR unit will be closed in accordance with this section*

On October 31, 2020, the BAP ceased receiving CCR, initiating closure in accordance with §257.102 (e)(1)(ii). BAP will complete closure activities by October 31, 2025 in accordance with §257.102 (f)(1)(ii).

This spring, Xcel will start to remove stop logs from the discharge structure to begin draining free water to the downstream Recycle Basin (incised, non-CCR pond). During the five-year closure window, Xcel will remove all free water and periodically excavate coarse bottom ash for beneficial use in lined CCR units.

Details of the maximum inventory, maximum area, schedule, final cover design, notification timelines, and certification can be found below.

*(ii) If closure of the CCR unit will be accomplished through removal of CCR from the CCR unit, a description of the procedures to remove the CCR and decontaminate the CCR unit*

The BAP will be closed by leaving the majority of CCR in-place.

*(iii) If closure of the CCR unit will be accomplished by leaving CCR in place, a description of the final cover system design in accordance with paragraph (d) of this section*

BAP will be closed in accordance with paragraph 257.102(d). A description of the design is provided below.

*(iv) An estimate of the maximum inventory of CCR ever on-site over the active life of the CCR unit.*

The estimated maximum inventory as of October 31, 2020 was 715,169 Cubic Yards on 10/9/1989.

*(v) An estimate of the largest area of the CCR unit ever requiring a final cover as required by paragraph (d) of this section at any time during the CCR unit's active life*

The BAP closure will consist of 18 acres.

*(vi) A schedule for completing all activities necessary to satisfy the closure criteria*

The final receipt of CCR occurred on October 31, 2020. Completion of closure activities will occur in 2025, five years after initiating closure.

A schedule of the activities necessary to satisfy closure has been prepared and attached to this plan.

There are no necessary approvals or permits that need to be obtained prior to commencing closure. CCR will be stabilized in accordance with §257.102(d)(2)(i) as described below. Once construction is complete, a construction certification report, signed by a qualified professional engineer, will be placed in the CCR operating record.

#### **§257.102 (c) Closure by Removal of CCR**

Not applicable, the BAP will be closed in-place.

#### **§257.102 (d)(1) Closure Performance Standard**

The owner or operator of a CCR unit must ensure that, at a minimum they:

*(i) Control, minimize, or eliminate, to the maximum extent feasible, post-closure infiltration of liquids into the waste and releases of CCR, leachate, or contaminated run-off to the ground*

Post closure infiltration will be minimized or eliminated by installing a Municipal Solid Waste Landfill-style final cover system as described in Minnesota Pollution Control Agency (MPCA) waste management facility rules. The final cover profile from bottom to top will consist of:

- 3-to-6-inch granular buffer layer free of large or angular rock to prevent CCR particles from damaging the geomembrane.
- 40 mil linear low-density polyethylene (LLDPE) geomembrane (alternative infiltration barrier layer)
- A minimum two-foot-thick soil cover (erosion layer) consisting of:
  - 12 inches of granular drainage layer (soil with a permeability of  $1 \times 10^{-3}$  centimeters per second or faster to promote subsurface drainage off the geomembrane)
  - 12 inches of topsoil (soil capable of sustaining vegetative growth)
- Vegetation

*(ii) Preclude the probability of future impoundment of water, sediment, or slurry*

All deposited CCR will be sufficiently stabilized to support the final cover system, as described in 257.102(d)(2)(ii) and will be graded to drain stormwater off the pond, preventing future impoundment.

Stormwater modeling software will be used to verify the performance of the final cover stormwater control system.

The slurry pipes will be removed prior to completion of closure activities.

*(iii) Include measures that provide for major slope stability to prevent the sloughing or movement of the final cover system during the closure and post-closure care period.*

The majority of the final cover system will be constructed at a 2 to 4% slope. The side slopes of the final cover system will be constructed at a 3:1 horizontal to vertical ratio (3H:1V) and will utilize textured LLDPE geomembrane. Granular drainage material located on the 3H:1V slopes will be placed from the toe of the slope upward. Drain tile will be installed in the drainage layer along draws or at the toe of slopes to reduce saturation and improve veneer stability.

*(iv) Minimize the need for further maintenance of the CCR unit*

Maintenance on the BAP final cover system will be minimized by establishing and supporting vegetation. Erosion control products appropriate for the slope and expected stormwater run-off velocity will be implemented to prevent soil erosion until vegetation is established. Areas of concentrated run-off will utilize riprap or turf reinforcement mat. Once vegetation is established, mowing will occur as needed to prevent growth of woody and deep-rooted vegetation.

*(v) Be completed in the shortest amount of time consistent with recognized and generally accepted good engineering practices*

BAP closure will be completed within five years of initiating closure activities. The five-year window allows for removal of free water and periodic excavation of bottom ash for beneficial use within lined areas of the plant, primarily for Pond 3 interior diking and final closure grades.

## **§257.102(d)(2) Drainage and Stabilization**

*(i) Free liquids must be eliminated by removing liquid wastes or solidifying the remaining wastes and waste residues*

The majority of free liquids will be eliminated by removing stop logs from the discharge structure, lowering the water level. The remaining free water may have to be removed by siphoning or pumping water over the stop logs at the bottom of the discharge structure that have cemented in over time. All free water will be drained to a lined facility.

*(ii) Remaining wastes must be stabilized sufficient to support the final cover system*

Once the free liquids are removed from the BAP, coarse bottom ash deposits from the east end of the BAP will be pushed west to create a uniform surface. Once the CCR is graded, embankment material will be used to shape the BAP and promote drainage off the final cover system. Coarse bottom ash and embankment material will be compacted to 95% of Standard Proctor density during placement to ensure the CCR is stable enough to support the final cover system.

### **§257.102(d)(3)(i) Final Cover System**

The final cover system will be designed and constructed to meet the criteria in paragraphs §257.102(d)(3)(i) and §257.102(d)(3)(ii) (Alternative Final Cover System) and is described herein.

*(A) The permeability of the final cover system must be less than or equal to the permeability of any bottom liner system.*

The BAP base liner is constructed with 18-inches of compacted clay liner and is deemed unlined in accordance with §257.71. The final cover system will feature a polyethylene geomembrane which is less permeable than 18-inches of clay.

Final cover geomembrane installation will be continuously monitored by on-site construction quality assurance staff to verify that construction is performed in accordance with specifications and that testing is conducted in accordance with the Geosynthetic Institute standard specifications for LLDPE geomembrane (GM17) or geomembrane seams (GM19).

Once the final cover geomembrane is installed, tested, and all quality control documentation is complete, a GPS-guided dozer utilizing as-built geomembrane elevation data will place the granular drainage layer over the geomembrane.

*(B) The infiltration of liquids through the closed CCR unit must be minimized by the use of an infiltration layer that contains a minimum of 18 inches of earthen material*

An alternative infiltration layer will be used in accordance with §§257.102(d)(3)(ii)(A) through (C)

*(C) The erosion of the final cover system must be minimized by the use of an erosion layer that contains a minimum of six inches of earthen material that is capable of sustaining native plant growth.*

As stated above, the BAP erosion layer will consist of 24 inches of earthen material. The bottom 12 inches of the erosion layer will consist of a granular drainage material and the top 12 inches will be topsoil, capable of sustaining native plant growth.

*(D) The disruption of the integrity of the final cover system must be minimized through a design that accommodates settling and subsidence.*

The final cover system utilizes a 40 mil LLDPE geomembrane, which can elongate more than 800% before breakage occurs. This accommodates settling and subsidence, while maintaining the integrity of infiltration barrier.

### **§257.102(d)(3)(ii) Alternative Final Cover System Design**

*(A) The design of the final cover system must include an infiltration layer that provides equivalent reduction in infiltration as the infiltration layer specified in §257.102(d)(3)(i)(B)*

The BAP will feature a 40 mil LLDPE geomembrane infiltration barrier layer and a 24-inch erosion layer in lieu of 18 inches of earthen material and six inches of erosion layer. The permeability of 40 mil LLDPE is less than the BAP base liner.

*(B) The design of the final cover system must include an erosion layer that provides equivalent protection as specified in §257.102(d)(3)(i)(C)*

The final cover erosion layer exceeds the requirements for §257.102(d)(3)(i)(C) as described above.

*(C) The disruption of the integrity of the final cover system must be minimized through a design that accommodates settling and subsidence*

The integrity of the final cover system meets the requirements for §257.102(d)(3)(i)(D) as described above.

### **§257.102(d)(3)(iii) Certification**

Certification for the entire closure plan under §257.102 can be found at the end of this compliance report.

### **§257.102(e) Initiation of Closure Activities**

The last known receipt of CCR occurred on October 31, 2020, initiating closure activities per §257.102(e)(1)(i).

### **§257.102(f) Completion of Closure Activities**

Completion of closure activities will occur by October 31, 2025, five years from initiating closure per §257.102(f)(1)(ii).

### **§257.102(g) Notification of Intent to Close**

A notice of intent (NOI) was placed in the CCR operating record following the initialization of closure. The NOI includes the certification of a qualified professional engineer for the design of the final cover system in accordance with §257.102(d)(3)(i) or (ii).

### **§257.102(h) Notification of Closure**

Within 30 days of completion of the final phase of closure, the owner or operator will place notification of closure in the operating record. The notification of closure will be signed by a qualified professional engineer.

### **§257.102(i) Deed Notations**

Following closure of the BAP, a notation on the deed to the property, or some other instrument that is normally examined during title search, will be recorded in accordance with §257.102(i)(1) and (2).

Within 30 days of recording a notation on the deed to the property, the owner or operator will place the notation in the operating record.

### **§257.102(k) Criteria to Retrofit an Existing CCR Surface Impoundment**

The BAP will not be retrofitted.

## Certification

I hereby certify under penalty of law that this report was prepared under my direction or supervision in accordance with a system designed to assure that qualified personnel properly gather and evaluate the information submitted. Based upon my inquiry of the person or persons who manage the system, or those persons directly responsible for gathering the information, the information submitted is, to the best of my knowledge and belief, true, accurate, and complete. I am aware there are significant penalties for submitting false information, including the possibility of fine and imprisonment.



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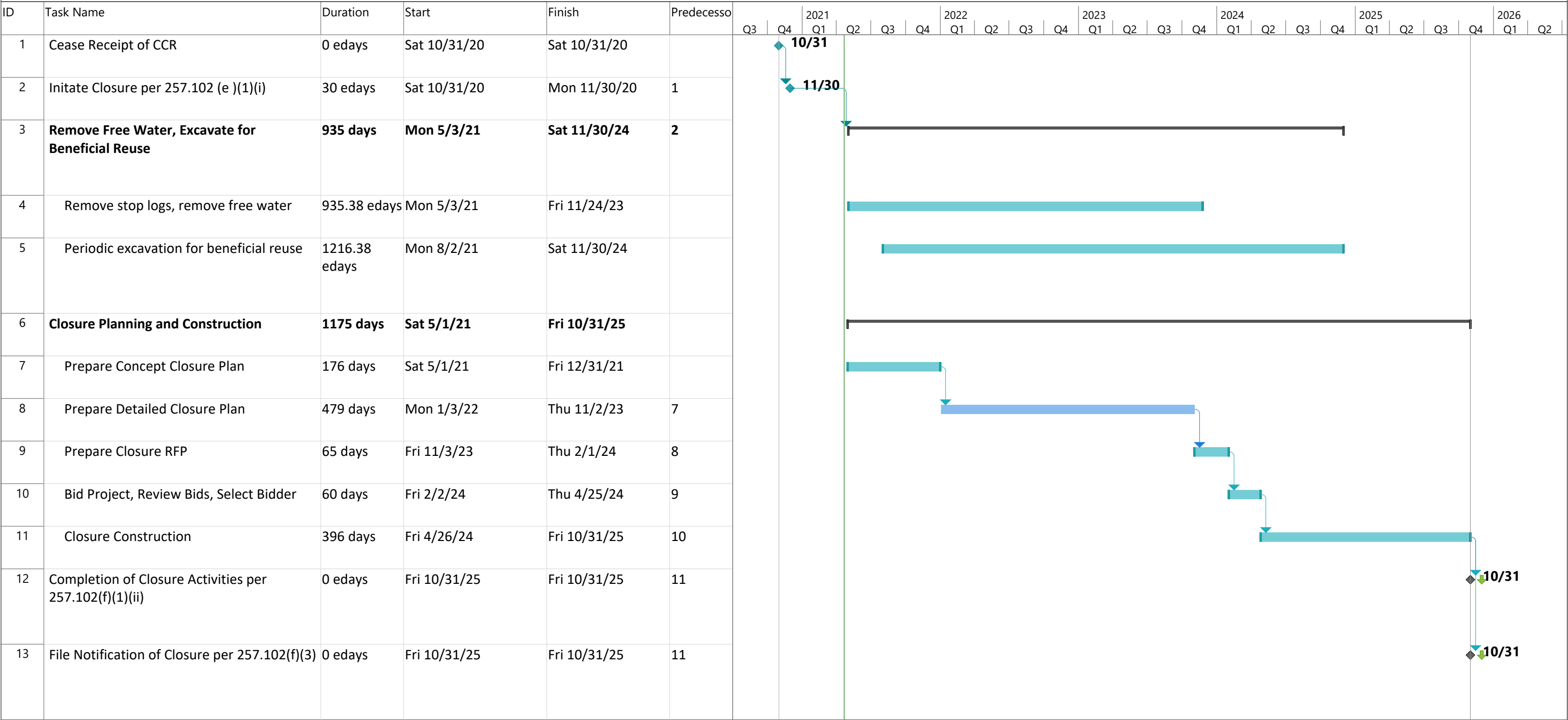
Daniel J. Riggs, PE  
License No. 49559

April 27, 2021  
Date

Preliminary Closure Schedule

Bottom Ash Pond

Sherburne County Generating Station



Project: BAP Closure Plan Gantt Chart

Date: Thu 4/22/21

Task

Split

Milestone

Summary

Project Summary

Inactive Task

Inactive Milestone

Inactive Summary

Manual Task

Duration-only

Manual Summary Rollup

Manual Summary

Start-only

Finish-only

External Tasks

External Milestone

Deadline

Progress

Manual Progress