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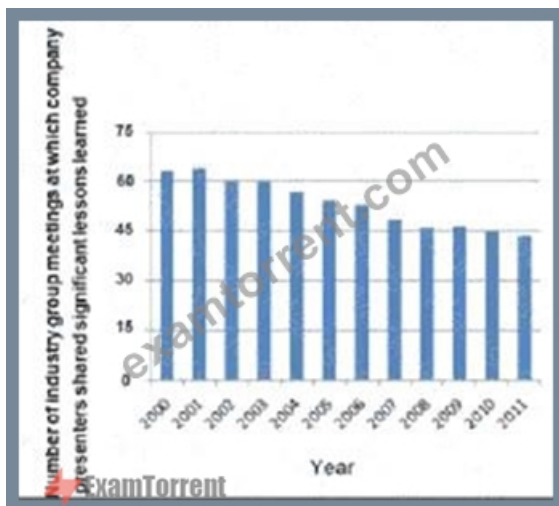
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## AIChE CCPS Process Safety Professional Certification Sample Questions (Q92-Q97):

NEW QUESTION # 92



The X/Y/Z Corporation decides to track an activity as shown in the diagram. They interpret the results to indicate a possible deteriorating performance in one of their process safety management elements.

The chart shows a declining trend in the number of industry group meetings at which company presenters shared significant lessons learned over several years.

Which of the following RBPS elements is MOST directly reflected by this activity?

- A. Workforce Involvement
- B. Stakeholder Outreach
- C. Compliance with Standards
- D. Measurement and Metrics
- E. Process Safety Competence

**Answer: B**

Explanation:

The correct answer is C. Stakeholder Outreach because the activity being measured is the number of industry group meetings where company representatives share significant lessons learned. According to CCPS Risk- Based Process Safety (RBPS), Stakeholder Outreach focuses on communication and knowledge sharing with external parties such as industry peers, professional organizations, regulators, and the public. This includes contributing lessons learned, participating in industry forums, and promoting transparency to improve overall process safety performance beyond the organization.

The declining trend shown in the chart indicates that the company is reducing its engagement with external stakeholders, which may reflect weakening commitment to sharing knowledge and learning across the industry. CCPS emphasizes that proactive sharing of incident learnings helps prevent similar events across organizations and strengthens collective safety performance.

Other options are less appropriate: Measurement and Metrics refers to tracking performance internally but not the specific nature of the activity; Workforce Involvement relates to internal employee participation; Process Safety Competence concerns training and skills; and Compliance with Standards relates to adherence to regulations. The key distinguishing factor is external communication and collaboration, which directly aligns with Stakeholder Outreach.

#### NEW QUESTION # 93

A material had been oxidized many times, without incident, under an oxygen atmosphere in a small pilot plant vessel. While scaling up to a larger vessel, the plant engineers decided they could improve gas/liquid contact by using a more efficient feed dispersing system. This dispersing system filled the reactor's vapor space with a fine combustible mist. Several hours after startup, the vessel was ruptured by an internal mist explosion. The source of ignition was a small amount of catalyst left over from an earlier set of experiments. This was a phenomenon that the engineers had not considered. Which of the following risk based process safety elements could have helped prevent this incident? (Select all that apply)

- A. Management of Change
- B. Process Knowledge Management
- C. Contractor Management
- D. Emergency Management
- E. Measurement and Metrics

**Answer: A,B**

Explanation:

The correct answers are B (Management of Change) and D (Process Knowledge Management) because this incident was caused by unrecognized hazards introduced during scale-up and process modification .

Option B (Management of Change - MOC) is critical because the engineers introduced a new feed dispersing system , which significantly altered the process by creating a combustible mist in the vapor space . According to CCPS, any change in equipment, process conditions, or technology must undergo a formal MOC review to identify new hazards, evaluate risks, and implement safeguards before startup. A proper MOC would likely have identified the explosion risk associated with mist formation in an oxygen-rich environment.

Option D (Process Knowledge Management - PKM) is also essential because the hazard resulted from insufficient understanding of the process chemistry and physical behavior , particularly mist explosibility and catalyst ignition potential. PKM ensures that organizations maintain accurate knowledge of chemical reactivity, flammability limits, and scale-up effects.

Options A , C , and E are not directly related to preventing this type of incident. Measurement and metrics track performance, contractor management is irrelevant here, and emergency management focuses on response rather than prevention.

This scenario highlights how scale-up changes can introduce new hazards , requiring both strong MOC and robust process knowledge.

#### NEW QUESTION # 94

A facility has implemented a program of tracking the rate of submittals of process safety related employee suggestions. Which Risk Based Process Safety element does this program demonstrate?

- A. Management of Change
- B. Operating Procedures
- C. Hazard Identification and Risk Analysis
- **D. Workforce Involvement**

**Answer: D**

Explanation:

The correct answer is A. Workforce Involvement because the program specifically tracks employee participation in process safety through suggestion submittals , which is a key indicator of workforce engagement.

CCPS defines Workforce Involvement as the active participation of employees in improving process safety systems. This includes mechanisms that encourage workers to contribute ideas, report concerns, and provide feedback. Tracking the rate of employee suggestions is a way to measure how engaged the workforce is in identifying hazards and improving safety performance. It reflects both participation and the effectiveness of communication channels.

While this program uses a metric (tracking rate) , the underlying purpose is not simply measurement-it is to promote and evaluate employee involvement , making Workforce Involvement the most appropriate RBPS element.

Option B (Operating Procedures) relates to how tasks are performed safely, not employee engagement. Option C (Hazard Identification and Risk Analysis) involves formal hazard studies like HAZOP, not suggestion tracking. Option D (Management of Change) deals with controlling changes to processes and equipment.

Thus, this program demonstrates how organizations can encourage and monitor workforce participation , which is essential for building a strong process safety culture.

#### NEW QUESTION # 95

A combined pressure/vacuum inerting procedure is being used to reduce oxygen in a vessel prior to introducing a flammable gas. Which of the following statements is correct?

- **A. Less inert is used if the vacuum is applied first.**
- B. The same amount of inert is required using either approach.
- C. Less inert is used if the pressure is applied first.

**Answer: A**

Explanation:

The correct answer is A because applying vacuum first is more efficient and reduces the amount of inert gas required , as explained in CCPS guidance on inerting and purging methods.

In a vacuum-first approach , a portion of the vessel's original gas (containing oxygen) is removed before introducing nitrogen. This immediately lowers the oxygen concentration without consuming inert gas. When nitrogen is subsequently added, it starts from a lower oxygen baseline, meaning fewer purge cycles and less total nitrogen are required to reach the target oxygen concentration.

In contrast, if pressure purging is applied first , nitrogen is added to a vessel still filled with air, and oxygen reduction occurs through dilution. This requires more nitrogen , since each cycle only partially reduces oxygen concentration.

Option C is incorrect because the sequence does affect efficiency, and B is incorrect because pressure-first is less efficient. CCPS emphasizes that combined vacuum/pressure purging is the most efficient inerting method, but the sequence matters. Starting with vacuum maximizes oxygen removal before dilution, minimizing inert gas consumption and improving operational efficiency, especially for large vessels.

#### NEW QUESTION # 96

The accumulation for a relief device is:

- A. The pressure increase over the MAWP expressed as a percentage of the MAWP
- B. The pressure increase over the MAWP expressed as a percentage of the set pressure
- C. The pressure increase over the set pressure expressed as a percentage of the MAWP
- **D. The pressure increase over the set pressure expressed as a percentage of the set pressure**

**Answer: D**

Explanation:

The correct answer is C because accumulation is defined (per CCPS and industry standards such as ASME) as the pressure increase above the relief device set pressure, expressed as a percentage of the set pressure.

When a relief device (such as a safety valve or rupture disc) activates, the system pressure is allowed to rise above the set pressure during discharge. This temporary pressure increase is called accumulation. It reflects the system's ability to safely handle overpressure while the relief device is relieving excess energy or material.

Mathematically, accumulation is calculated as:

Option A is incorrect because accumulation is not referenced to MAWP. Option B describes pressure relative to MAWP, which is not the definition of accumulation. Option D is also incorrect because it mixes MAWP and set pressure improperly.

Mathematically, accumulation is calculated as:

$$\text{Accumulation (\%)} = \frac{\text{Relieving Pressure} - \text{Set Pressure}}{\text{Set Pressure}} \times 100$$

CCPS emphasizes understanding accumulation as part of pressure relief system design, ensuring that vessels can tolerate the maximum allowable accumulation (often 10% for single relief devices under many codes) without exceeding safe limits.

#### NEW QUESTION # 97

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