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# ArcelorMittal Coke Oven Clean Gas and Water Project: External Environmental Performance Assessment

## Audit Report

**FINAL**

**10 April 2019**

**ArcelorMittal South Africa Limited**

**GCS Project Number: - 19-0029**

**Client Reference: PO 450616638**

**GDACE Reference: GAUT 002/02-03/138**



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## ArcelorMittal - External Environmental Performance Assessment - Audit Report

**FINAL****10 April 2019**

ArcelorMittal South Africa Limited

19-0029

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## EXECUTIVE SUMMARY

ArcelorMittal South Africa (ArcelorMittal) Vanderbijlpark Works was established in 1942 and commenced production in 1952. ArcelorMittal South Africa Vanderbijlpark Works (Vanderbijlpark Works) is one of the largest steel producers in South Africa. The Vanderbijlpark Works manufacture steel products by charging raw materials such as iron ore, coke and dolomite into blast furnaces to produce liquid iron. The liquid iron is refined in basic oxygen furnaces to produce liquid steel. The liquid steel is further processed into various rolled and coated steel products.

ArcelorMittal operates five coke batteries to produce metallurgical coke for the Blast Furnaces on site. Coke is an important input material into the iron making process. During the coke making process, gas and other by-products are formed. The Coke Batteries were built between 1945 and 1985 and the gas and water cleaning technologies were considered out dated and could not deliver clean gas, which resulted in various maintenance issues and other implications. ArcelorMittal commenced with the Coke Oven Clean Gas and Water (COCGW) Project in the early 2000s in order to install new technology that would enable them to clean the coke oven gas for re-use in the works as fuel gas and also to comply with Environmental Best Practice Standards internationally.

The construction of the plant commenced in 2005 and was commissioned in 2010 at the cost of more than R 330 million. The project faced numerous delays and challenges. In 2010 the plant ran successfully and proved significant sulphur reduction in terms of emissions. Unfortunately, the plant was shut down at the end of 2010 due to technical and mechanical difficulties. From 2011, ArcelorMittal repaired the identified faults in the process and then attempted to re-commission the facility on a few occasions. The plant has not run for more than a few days at end without interruption. Currently the gas is only partially cleaned but no sulphur removal is taking place. The major concern is that the plant is not fully operational and ArcelorMittal is not removing sulphur from the coke oven gas which leads to the release of emissions (particularly Sulphur Dioxide (SO<sub>2</sub>)) from the facility to the environment. Despite numerous attempts to ensure operations of the current sulphur recovery facilities, the long-term operation of this failing equipment was no longer feasible. Hence the decision to replace the current equipment with state-of-the-art equipment, at a cost of close to R1 billion, for the cleaning of coke oven gas. The order for manufacturing of this equipment was placed on the 19<sup>th</sup> March 2019. Commissioning of these components is expected to commence 2.5 years from this date.

A Record of Decision (RoD) was issued to ArcelorMittal for the COCGW Project (RoD number: GAUT 002/02-03/138) in terms of Regulations 1182 and 1183 and promulgated under Sections

21, 22, 26 and 28 of the Environmental Conservation Act, 1989 (Act No. 73 of 1989) (ECA). The RoD was issued by the Gauteng Department of Agriculture, Conservation and Environmental (GDACE), now Gauteng Department of Agriculture and Rural Development (GDARD) in 2004. In order to remain compliant with the conditions of the RoD, ArcelorMittal is required to appoint an external auditor to conduct bi-annual external Environmental Performance Assessment (EPA) Audits for the Vanderbijlpark Works.

GCS Water and Environment (Pty) Ltd. (GCS) was contracted by ArcelorMittal to conduct the first 2019 annual external EPA audit carried out against all conditions included in the RoD.

Accordingly, the following activities were undertaken as part of the EPA Audit:

- Assessment and comparison of the current site activities with those described in the approved RoD;
- Comparison of environmental mitigation measures implemented on site to those required and committed to in terms of the approved RoD in order to assess whether these comply with the management objectives committed to in the RoD;
- Assessment of monitoring requirements to current monitoring practices;
- Assessment of relevant documentation pertaining to various compliance aspects; and
- Identification of current activities and facilities at the Vanderbijlpark Works, which are not specifically included in the approved RoD.

The audit findings, detailed in the report, include practical recommendations whereby the various non-compliance issues can be corrected. All findings were ranked according to the following criteria:

- Compliant;
- Minor non-compliance;
- Moderate non-compliance; and
- Major non-compliance.

Currently the overall compliance with the Record of Decision (RoD) (GAUT 002/02-03/138) is noteworthy. Overall there was one (1) incident of minor non-compliance, three (3) incidents of moderate non-compliance, and zero (0) incidents of major non-compliance observed for the audit period. The instances of non-compliance weren't considered to be directly associated with significant environmental degradation.

### H<sub>2</sub>S Content in Gas

Condition 3.2(g)(i) states that “The concentrations of the various constituents of the cleaned Coke Oven Gas must be monitored before and after combustion in the coke ovens. The results are to be graphically represented and included in the bi-annual audit report. The H<sub>2</sub>S content of the gas must be between 0.8 and 1.5 g/Nm<sup>3</sup>. ”

*Observation:*

The latest monitoring results indicate the H<sub>2</sub>S content of the gas exceeded the maximum limit of 1.5 mg/Nm<sup>3</sup>. The current reading is averaging at around 5 mg/Nm<sup>3</sup>. The non-compliance is linked to the Sulphur plant not being operational resulting in only partially cleaned gas being flared when there is no use for it in the rest of the works as an energy source. The Claus reactor has been non-operational for an extended period of time due to equipment failure and significant repairs and replacements are required. ArcelorMittal has prioritised this problem and the order for the refurbishment was placed in March 2019.

*Recommendation:*

ArcelorMittal should continue with the prioritisation of the refurbishment of the gas plant in order to recommission the sulphur plant.

**Plan for Achieving Reduced Fugitive Emissions**

Condition 3.2(g)(iii) states that “A plan for door maintenance/replacement of all the coke batteries (No.) and progress in achieving reduced fugitive emissions has to be developed. The plan must be supported by the results of personal monitors, and actual measurements at representative areas of the coke ovens.”

*Observation:*

Battery doors are inspected on a daily basis and a maintenance schedule has been created. Repairs are done continuously. The fugitive emissions are monitored according to the internationally accepted standards and recorded. It was observed during the site visit that the occasional door is still burning and smoking. The commitment from the facility was however also observed to repair and maintain the equipment as far as possible. Exposure monitoring at the batteries indicates that additional fugitive emission mitigation measures are required, above that already implemented. This can however not be attributed only towards doors but rather the fugitive battery emissions as a cumulative source. ArcelorMittal has however implemented management and mitigation measures such as specialised face masks and other measures to protect employees and reduce exposure. Other measures include battery tightening, end-flue repairs and charge emission reduction projects. The effectiveness of these measures should be assessed to determine whether it is sufficient to mitigate fugitive emissions.

*Recommendation:*

It is recommended that the effectiveness of these measures should continuously be assessed to determine whether it is sufficient to mitigate fugitive emissions.

**Plan for Achieving Reduced SO<sub>2</sub> Emissions**

Condition 3.2(h) states that “The flaring of uncleaned gas at the relevant flares is only permissible during upset conditions when the Claus Reactor is shut down for inspection/maintenance for 3 weeks every three years, and must be undertaken at temperatures and atmospheric mixing conditions conducive to maximum dispersion of pollutants.”

*Observation:*

The sulphur plant is not operational and therefore only partially cleaned gas is flared when there is no use for it in the rest of the works as an energy source. The Claus reactor has been non-operational for an extended period of time due to equipment failure and significant repairs and replacements are required. Flaring of uncleaned gas is taking place on a more regular basis than 3 weeks every 3 years. However, this issue has been reported on and ArcelorMittal is continuously aware that urgent intervention is needed.

*Recommendation:*

ArcelorMittal must continue monitoring air quality within the Works to maintain a baseline of emission results. The design, construction and operation of the sulphur plant should be prioritised as it is only through this plant’s operation that the flaring of uncleaned gas can be controlled.

## CONTENTS PAGE

<b>1</b>	<b>INTRODUCTION .....</b>	<b>1</b>
<b>2</b>	<b>AUDIT PROCESS.....</b>	<b>3</b>
2.1	STEP 1: WHAT IS THE OBJECTIVE OF THE AUDIT? .....	3
2.2	STEP 2: SCOPE OF THE AUDIT .....	3
2.3	STEPS 3: INFORMATION REQUIRED TO CONDUCT THE AUDIT .....	4
2.4	STEPS 4: CONDUCTING THE AUDIT .....	4
2.5	STEPS 5: EVALUATING THE AUDIT RESULTS.....	4
2.6	STEP 6: PRESENTING THE AUDIT RESULTS.....	5
2.7	STEP 7: DECISION-MAKING BASED ON AUDIT RESULTS .....	6
2.8	STEP 8: INSTITUTING CORRECTIVE ACTION .....	6
<b>3</b>	<b>DETAILS OF THE AUDITOR .....</b>	<b>6</b>
3.1	PROJECT TEAM.....	6
3.2	ASSUMPTIONS AND LIMITATIONS.....	7
<b>4</b>	<b>AUDIT SCORING RESULTS: 2019 ROD EPA AUDIT .....</b>	<b>7</b>
<b>5</b>	<b>AUDIT FINDINGS – 2019 ROD EPA AUDIT.....</b>	<b>8</b>
<b>6</b>	<b>CONCLUSION AND RECOMMENDATIONS .....</b>	<b>23</b>

## LIST OF FIGURES

Figure 4-1: 2019 External EPA Audit Results for the COCGW Project. ....	8
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## LIST OF TABLES

Table 2.1: Process to obtain audit information .....	4
Table 2.2: Ranking criteria and colour coding scores. ....	5
Table 3.1: GCS Team.....	7
Table 5.1: Scoring Results of the EPA Audit in respect of conditions of the COCGW RoD (audit undertaken in March 2019).....	9

## LIST OF APPENDICES

APPENDIX A: DECLARATION OF AUDITOR INDEPENDENCE .....	26
APPENDIX B: H <sub>2</sub> S IN COKE OVEN GAS DATA.....	29
APPENDIX C: DOOR INSPECTION AND MAINTENANCE PLAN.....	33
APPENDIX D: CUMULATIVE PARTICULATE MATTER EMISSION REDUCTION.....	38
APPENDIX E: QUARTERLY PROGRESS REPORT. ....	40
APPENDIX F: UPDATED WORKS WATER BALANCE .....	64
APPENDIX G: COKE PLANT WATER BALANCE .....	66
APPENDIX H: DISCHARGE VOLUMES.....	68
APPENDIX I: ABSTRACTION VOLUMES .....	71
APPENDIX J: COKE PLANT AIR QUALITY MONITORING PLAN .....	73
APPENDIX K: COKE BATTERY STACK DUST EMISSIONS.....	94
APPENDIX L: GROUNDWATER QUALITY RESULTS .....	97
APPENDIX M: WASTE STREAM QUANTITIES .....	103
APPENDIX N: EXAMPLE OF A RECENT JOB CARD .....	106

## 1 INTRODUCTION

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The project scope is technical and complex and included various improvements and changes to the existing plant as well as the installation of new infrastructure. The project aimed to improve the current controls at the batteries, improve the gas collecting mains, upgrade of the primary cooling to improve naphthalene removal, installation of a new chiller plant, installation of a distillation plant and a sulphur removal plant. The water portion included the installation of new tar decanters, a gravel filter plant and scrubbers.

The construction of the plant commenced in 2005 and was commissioned in 2010 at the cost of more than R 330 million. The project faced numerous delays and challenges. In 2010 the plant ran successfully and proved significant sulphur reduction in terms of emissions. Unfortunately, the plant was shut down at the end of 2010 due to technical and mechanical difficulties. From 2011, ArcelorMittal repaired the identified faults in the process and then attempted to re-commission the facility on a few occasions. The plant has not run for more than a few days at end without interruption. Currently the gas is only partially cleaned but no sulphur removal is taking place. The major concern is that the plant is not fully operational and ArcelorMittal is not removing sulphur from the coke oven gas which leads to the release of emissions (particularly Sulphur Dioxide (SO<sub>2</sub>)) from the facility to the environment. Despite numerous attempts to ensure operations of the current sulphur recovery facilities, the long-term operation of this failing equipment was no longer feasible. Hence the decision to replace



the current equipment with state-of-the-art equipment, at a cost of close to R1 billion, for the cleaning of coke oven gas. The order for manufacturing of this equipment was placed on the 19<sup>th</sup> March 2019. Commissioning of these components is expected to commence 2.5 years from this date.

A Record of Decision (RoD) was issued to ArcelorMittal for the COCGW Project (RoD number: GAUT 002/02-03/138) in terms of Regulations 1182 and 1183 and promulgated under Sections 21, 22, 26 and 28 of the Environmental Conservation Act, 1989 (Act No. 73 of 1989) (ECA). The RoD was issued by the Gauteng Department of Agriculture, Conservation and Environmental (GDACE), now Gauteng Department of Agriculture and Rural Development (GDARD) in 2004.

The following conditions are requirements of the RoD in terms of the ECA as issued by the GDACE:

- Condition 3.4 (b): A bi-annual Environmental Performance Audit conducted by an independent, accredited auditor must be submitted to the Department for review, the first audit being due 6 (six) months after commissioning of the COG and water cleaning project, and every 6 (six) months thereafter.

GCS Water and Environment (Pty) Ltd. (GCS) was contracted by ArcelorMittal to conduct an independent Environmental Performance Assessment (EPA) Audit for the Vanderbijlpark Works. The EPA audit was carried out against all conditions included in the EA and the audit assessment was undertaken by Ms. Fatima Matlou who has experience in mining and industrial projects; and Ms Elizabeth Mosepele an Environmental intern, both from GCS.

A one (1) day site visit was undertaken at the Vanderbijlpark Works site on the 05 March 2019. The site visit was initiated with a project kick-off meeting during which GCS met with Mr. Terrence Wilson, ArcelorMittal's Environmental Control Officer (ECO) for this project. Following the kick-off meeting, a comprehensive review of the RoD documentation and associated checklists was undertaken. This assessment monitored compliance in terms of document control, systems and procedures. Following the checklist audit and documentation review, the remaining time was spent on site observing and inspecting the activities being conducted.

Accordingly, the following activities were undertaken as part of the EPA Audit:

- Assessment and comparison of the current site activities with those described in the approved RoD;

- Comparison of environmental mitigation measures implemented on site to those required and committed to in terms of the approved RoD in order to assess whether these comply with the management objectives committed to in the RoD;
- Assessment of monitoring requirements to current monitoring practices;
- Assessment of relevant documentation pertaining to various compliance aspects; and
- Identification of current activities and facilities at the Vanderbijlpark Works, which are not specifically included in the approved RoD.

## **2 AUDIT PROCESS**

The following steps formed the basis of the EPA Audit.

### **2.1 Step 1: What is the objective of the audit?**

The objectives of any audit should be clearly defined and settled before either an internal or external audit begins. The setting of objectives is important, as it is against these objectives that ArcelorMittal will be reviewed and expected to improve.

The following objectives formed the basis for the EPA Audit:

- Ensuring legal compliance in terms of the approved RoD;
- Checking that the environmental management tools to achieve compliance are used correctly and efficiently;
- To check whether the environmental management tools are effectively fulfilling their intended purpose of environmental compliance;
- Ensuring environmental performance on a continuous basis, i.e. throughout the life cycle of the Vanderbijlpark Works site;
- Reducing environmental liability;
- To facilitate the transference of information or best practice between operating units;
- To increase environmental awareness among the employees; and
- To track the environmental accountability of managers.

### **2.2 Step 2: Scope of the audit**

The conditions of the RoD stipulate that bi-annual performance assessments need to be undertaken to ensure compliance with the prescribed conditions as contained in the said documents.

This EPA Audit is taken to mean a regular, systematic, documented verification of whether ArcelorMittal is in compliance with the conditions of the approved RoD; the provisions of the ECA and the National Environmental Management Act, 1998 (Act No. 107 of 1998) (NEMA), which superseded the ECA; and whether environmental performance objectives and targets are being met.

### 2.3 Steps 3: Information required to conduct the audit

Table 2.1 sets out the procedures that were used to obtain the audit information.

**Table 2.1: Process to obtain audit information**

ACTION	DESCRIPTION
Inspection	Inspection consists of examining records and documents. Inspection of records and documents provides audit evidence of varying degrees of reliability depending on their nature and source and the effectiveness of internal controls over their processing.
Observation	Observation consists of on-site observation of the activities being conducted on site.
Enquiry	Enquiry consists of seeking information of knowledgeable persons inside the organisation.
Confirmation	Confirmation consists of making enquiries to corroborate information contained in the RoD.
Computation	Computation consists of checking the accuracy of source documents and the site's records or performing independent checks of information relating to environmental aspects and impacts.

### 2.4 Steps 4: Conducting the audit

The audit consisted of comparing the information gathered during on-site interviews, from reports as well as assessing on-site activities with the conditions of the RoD. A checklist was developed based on the RoD conditions and used as an auditing tool to establish the audit results.

### 2.5 Steps 5: Evaluating the audit results

The results of the audit are presented and the auditor assesses the final compliance in relation to the realistic representation of on-site activities; taking into account South African Environmental Legislation. Through such an assessment, the auditor should determine whether the final compliance is a true representation of on-site activities and a final recommendation should be made regarding actual compliance.

## 2.6 Step 6: Presenting the audit results

The findings of the Audit are included in **Table 5.1** of this Report. The audit findings also include practical recommendations whereby the various non-compliance issues can be corrected.

All findings were ranked according to the criteria indicated in **Table 2.2**. The colour coding assigned to the rankings is used to visually indicate areas of compliance, minor non-compliance, moderate non-compliance, and major non-compliance. Furthermore, to indicate which conditions are not applicable to the on-site activities and which are repeat conditions that have already been scored. Each colour coding has a value (score) attached to it.

**Table 2.2: Ranking criteria and colour coding scores.**

RANKING	SCORE
Compliant	2
Minor non-compliance	1
Noted/Not Applicable	0
Repeat Condition	-
Moderate non-compliance	-1
Major non-compliance	-2

All findings were ranked according to the following criteria:

**Noted/Not-Applicable:**

- The specific condition is not relevant to the current on-site activities.

**Repeat Condition:**

- The specific condition is a repeat of a previous condition.

**Compliant:**

- ArcelorMittal complies with the conditions as stated in the RoD.

**Non-compliance:**

- **Minor Non-compliance:**
  - Isolated observations demonstrating that full compliance to the environmental requirements on site have not been, or will not be, fully achieved.
- **Moderate Non-compliance:**
  - There is a substantial failure to meet the environmental requirements for the project, there is a possibility of substantial environmental degradation and/or pollution, and/or objective evidence was observed raising doubt as to the integrity of data or records inspected.
- **Major Non-compliance:**

- There is a critical failure against legal requirements or management response that presents an immediate or significant risk that could result in prosecution and/or adverse legal findings due to failure to meet regulatory requirements; result in immediate injury or serious injury; result in prolonged business outage; and/or could result in serious damage to the project's reputation.

It must be noted that duplicate conditions are not scored due to the fact that this will negatively influence the scoring results. Duplicate conditions are marked as a Repeat Condition.

## **2.7 Step 7: Decision-making based on audit results**

Decision-making, based on the audit results, must have the following objectives; to improve the present situation and to institute fair and reasonable corrective action. ArcelorMittal should make decisions based on the significance of the problem or non-compliance and the resources required to improve the situation.

## **2.8 Step 8: Instituting corrective action**

It is recommended that an environmental action plan be implemented to address the Audit recommendations. The plan may include:

- Goals;
- Strategies;
- Performance indicators;
- Responsibilities; and
- A timetable for achievement.

An EPA audit is an effective management tool on condition that the recommendations, as identified in this Audit, are considered and implemented. The audit provides a basis for recommending actions to correct any deficiencies and to address any areas of environmental non-compliance recorded as part of the audit findings.

## **3 DETAILS OF THE AUDITOR**

GCS, appointed by ArcelorMittal to conduct an external EPA audit, has more than 30 years of experience and expertise in undertaking and compiling compliance audits.

### **3.1 Project Team**

The EPA Audit was undertaken by the GCS team presented in **Table 3.1**.

**Table 3.1: GCS Team**

NAME	DESIGNATION	RESPONSIBILITY
Elizabeth Mosepele <ul style="list-style-type: none"> <li>BSc Honours Geography and Environmental Studies</li> <li>IAIA</li> </ul>	Environmental Intern	<ul style="list-style-type: none"> <li>Site visits</li> <li>Compilation of Audit Report</li> </ul>
Fatima Matlou <ul style="list-style-type: none"> <li>National Diploma Environmental Management</li> <li>ELA (Reg. No. 2017/235/GP)</li> </ul>	Senior Environmental Consultant	<ul style="list-style-type: none"> <li>Overall Legal Compliance</li> <li>Site visits</li> <li>Liaison with Client and Project Management</li> <li>Environmental Legal Assessment</li> <li>Compilation of Audit Report</li> </ul>

### 3.2 Assumptions and Limitations

The findings, results, observations, conclusions and recommendations given in this audit are based on the Auditor's best legal and professional knowledge as well as available information.

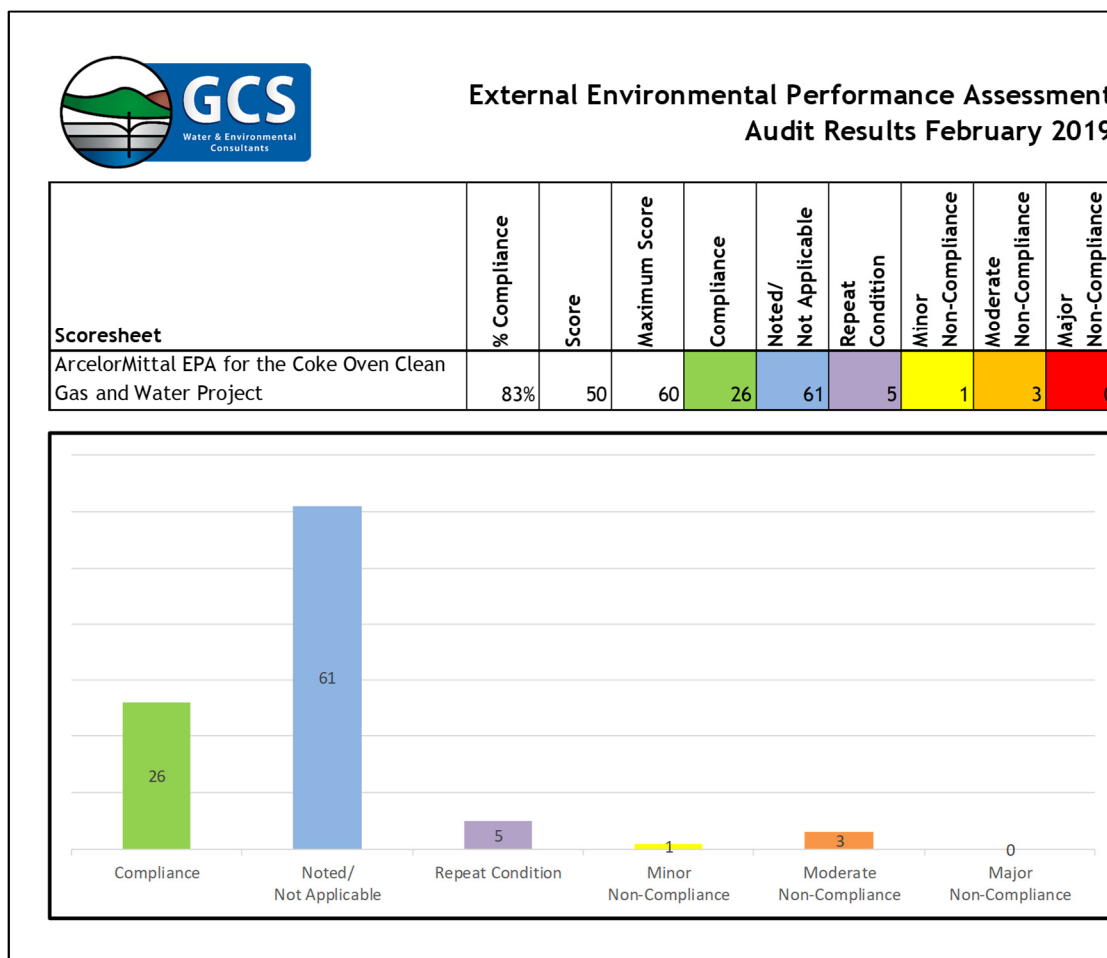
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Refer to **Appendix A** for the Declaration of Independence of the Auditor.

## 4 AUDIT SCORING RESULTS: 2019 ROD EPA AUDIT

**Figure 4-1** presents the percentage compliance of ArcelorMittal for the first 2019 external EPA audit for the COCGW Project in tabular and graphic format.



**Figure 4-1: 2019 External EPA Audit Results for the COCGW Project.**

The graph within the table shows the number of non-compliances observed as well as the number of conditions repeated, noted or not applicable. It can be seen from the graph that ArcelorMittal is compliant with the majority of the RoD conditions. Most of the conditions were observed to be not applicable or noted due to the fact that various changes were made regarding the facility construction and operation, which have been approved by GDARD. During the previous audit it was reported that the last outstanding items to be constructed is towards improving the works water balance and does not influence the plant's operability. This finding is still valid.

## 5 AUDIT FINDINGS - 2019 ROD EPA AUDIT

Table 5.1 overleaf represents the conditions, observations and recommendations, found at the ArcelorMittal COCGW Project, first 2019 audit.

Table 5.1: Scoring Results of the EPA Audit in respect of conditions of the COCGW RoD (audit undertaken in March 2019).

No	Conditions	Status	Score	Observations	Recommendations
3.1	<b>Description and extent of the activity</b>				
1.1	The authorisation applies in respect of the upgrading and operation of the coke oven gas (COG) and water cleaning systems at the existing coke ovens, as detailed In Sections 10-12 (p. 77-94) of the Process Review specialist study conducted by EBS cc., and In Section 4.12 9 p.39-44) of the Scoping Report by SEF (Pty) Ltd. The activity falls within the ambit of sub regulations 1 c(ii), 8 and 9 of Government Notice R.1182 (as amended), promulgated under section 21 of the Act. The extent of the project is summarised as follows:	Noted/Not Applicable	0	This condition is noted. The authorisation pertains to the Coke Oven and Clean Gas and Water (COCGW) Project.	No applicable recommendations.
3.1.1	<b>PROJECT SCOPE</b>				
(a)	<b>Proposed changes to coke ovens by-products plant</b> Upgrade and re-use of existing Gas Cleaning Plants, combining gas lines, and the upgrading of the coke oven gas (COG) collecting mains.	Compliant	2	Upgrades have been made to the Gas Cleaning Plant, as authorised by GDARD. The plant was upgraded in 2005 and is currently operational.	No applicable recommendations.
(b)	<b>Proposed changes to gas cleaning line</b> The 3 basic mechanisms of cleaning COG - condensation by cooling, separation by gravity, and absorption of components onto absorption media will remain the same.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Improving naphthalene removal and scrubbing conditions by reducing gas temperature.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Conversion and installation of equipment to function as final coolers and provide chilled water.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Improving NH <sub>3</sub> removal/absorption by upgrading existing scrubbers converting benzole scrubbers to NH <sub>3</sub> scrubbers, and converting circulation to closed loop systems.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Installing two new distillation columns treatment of ammonia scrubbing water and one as de-acidifier to generate the required scrubbing media for H <sub>2</sub> S removal, and treatment of NH <sub>3</sub> , H <sub>2</sub> S, HCN and CO <sub>2</sub> vapour in the ammonia and H <sub>2</sub> S plant.	Noted/Not Applicable	0	This condition is noted. Infrastructure construction and installation has not yet been completed. Once the final infrastructure has been completed the water will tie in with the overall water balance for the Works resulting in cleaner water being used for quenching. Funds have been approved for the construction and installation required for the remaining upgrade of the project. The design has been finalised and will include the refurbishment of the sulphur plant and the installation of other infrastructure such as the ammonia stripper.	No applicable recommendations.
	Discontinuing ammonium sulphate manufacture and installation of a new plant to convert H <sub>2</sub> S to elementary sulphur.	Noted/Not Applicable	0	This condition is noted. Refer to the observations made in condition 3.1.1(b), point 5.	No applicable recommendations.
	<b>Cleaning of excess process water</b> The basic mechanisms of cleaning coke oven process water are	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.



No	Conditions	Status	Score	Observations	Recommendations
	separation by gravity, mechanical sludge removal, filtration and distillation. Ammonia, H <sub>2</sub> S and HCN removed from water will be cracked to H <sub>2</sub> , N <sub>2</sub> and CO <sub>2</sub> and elementary sulphur formed.				
	Improving the handling of various condensate streams by the handling of high and low tar containing streams.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Improving the operation of tar decanting systems, mainly through continuous discharge of crude tar together with constant water content.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Improving the efficiency of operation of the gravel filters, and replacing filters with a single unit of equal capacity.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Improving H <sub>2</sub> S and NH <sub>3</sub> scrubbing efficiency, mainly through supporting desulphurisation with a quantity of de-acidified water, reducing ammonia content by means of stripped water, maintaining optimum scrubbing temperature, and integrating the two scrubbing systems.	Noted/Not Applicable	0	This condition is noted. Refer to the observations made in condition 3.1.1(b), point 5.	No applicable recommendations.
	Improving in H <sub>2</sub> S and NH <sub>3</sub> stripping efficiency by modifying existing equipment to handle flows from all gas cleaning plants by the coal water stripper for free and fixed ammonia, free ammonia stripper (NH <sub>3</sub> scrubbing liquor), and de-acidifier (de-acidified water for H <sub>2</sub> S removal). Equipment will be designed to treat all excess coal water and scrubbing liquor streams.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a) and condition 3.1.1(b), point 5.	No applicable recommendations.
<b>3.1.2</b>	<b>CONSTRUCTION/ UPGRADE/ DECOMMISSIONING ACTIVITIES</b>				
(a)	<b>Modification of Gas Line 1</b>				
	Connection of excess coal water to primary cooler.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Modification of the tar discharge and re-collection system.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Separating scrubbing liquor from coal water stream.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
(b)	<b>Primary Coolers - Gas Lines 3&amp;4, and Gas Lines 6-9</b>				
	Gas Lines 3&4: Installation of a new primary cooler, and new chilled water station including cooling tower upgrade, improvements to the tar separation area (removal of the existing gas tar tank from line 4), and modifications to two existing primary coolers, and decommissioning of the primary coolers for gas line 3.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Gas Lines 6-9: installation of 2 new primary coolers, followed by the modification of 3 existing coolers, and Improvements to the condensation plant.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
(c)	<b>Chilled Water Station/Cooling Water Supply Facilities</b>				
	Installation of a new chilled water station and chilled water plant. Removal of old wash-oil tanks.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.

No	Conditions	Status	Score	Observations	Recommendations
(d)	<b>Installation of a New Pre-Decanter/Modification of Tar Decaners</b> Upgrading tar separation facilities (lines 8&9), and removal of existing tar collecting tank.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Installation of a new pre-decanter, followed by the modification of tar decaners.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
(e)	<b>Installation of a Gravel Filter Unit</b> Re-use of two tanks as coal water tanks, and Installation of a new gravel filter.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
(f)	<b>Upgrading of the Existing Ammonia Stills</b> Integrating 3 of the 4 distillation columns, and modifying the existing acid storage tank into a caustic soda tank, including unloading and feeder pumps.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
(g)	<b>Installation of the New Stripper/ De-acidifier System</b> Installation of new distillation columns with corrosion resistant materials, and pipes and heat exchangers to tie-in the new stripping columns.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Integration of existing tanks, and installation of one new tank for de-acidified water.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
(h)	<b>Scrubbing Facilities - Gas Lines 3&amp;4</b> Modification of 2 existing ammonia scrubbers, and installation of a new H <sub>2</sub> S scrubber, including a final cooling stage.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Conversion of existing naphthalene scrubber to a final cooler together with installation of new heat exchangers.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
(i)	<b>Scrubbing Facilities - Gas Lines 6-9</b> Demolition of the existing and Installation of a new H <sub>2</sub> S scrubber, and upgrading one existing ammonia scrubber.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
	Installation of heat exchangers and a new gas line.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
(j)	<b>Elementary Sulphur Plant combined with NH<sub>3</sub> Cracking</b> Installation of a combined plant for the production of elementary sulphur and cracking of nitrogen components,	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
(k)	<b>Control System</b> The installation of a new system to control scrubbing and conversion units.	Noted/Not Applicable	0	Refer to the observations made in condition 3.1.1(a).	No applicable recommendations.
3.2	<b>Specific Conditions</b>				
a)	An updated project schedule with time-frames must be submitted to the Department 30 (thirty) calendar days prior to the commencement of construction activities. The schedule must clearly indicate the different phases of construction and commissioning and	Noted/Not Applicable	0	This condition was adhered to in 2004 and is not applicable until additional construction activities are initiated.	ArcelorMittal must ensure that the GDARD is informed of the proposed commencement of construction activities thirty (30) days prior to such commencement.

No	Conditions	Status	Score	Observations	Recommendations
	decommissioning (i.e. expected dates of commissioning of specific completed parts of the COG and water treatment systems).				
b)	The Department must be informed of both the start of construction and the start of commissioning at least 30 (thirty) calendar days prior to the commencement thereof.	Noted/Not Applicable	0	This condition was adhered to in 2004 (construction) and 2010 (commissioning) and is not applicable until additional construction/commissioning activities are initiated.	ArcelorMittal must ensure that the GDARD is informed of the proposed commencement of construction activities thirty (30) days prior to such commencement.
c)	A detailed Environmental Management Plan (EMP) for the implementation of the project must be submitted to the Department for approval 30 (thirty) calendar days prior to the commencement of construction activities. The EMP must specifically include, inter alia:	Noted/Not Applicable	0	This condition was adhered to in 2008 (construction EMP) and in 2012 (operational EMP). The construction EMP was approved by the GDARD. ArcelorMittal have not received approval of the operational EMP from the GDARD, although the GDARD has acknowledged receipt of the operational EMP.	No applicable recommendations.
i.	An auditable plan for monitoring all facets of the COG and water cleaning project implementation and operation, including decommissioning of all underground sumps, piping (underground and overhead), obsolete machinery, plants e.g. the benzol plant ammonium sulphate plant, tar separators etc., as well as taking of soil samples to indicate the levels of remediation required, and any remedial measures to be implemented.	Compliant	2	The operational EMP contains auditable elements relating to the COCGW Project. No deviations were noted.	No applicable recommendations.
ii.	A proposed surface and groundwater monitoring regime, which will be in line with the DWAF Water License. The graphically represented results of this monitoring are to be included in a bi-annual audit, which must be submitted to this Department for review to determine if the remedial measures have been successful or if further remediation is required.	Compliant	2	Surface water monitoring is being undertaken in line with the requirements of the Water Use License (WUL) issued to ArcelorMittal Vanderbijlpark Works.	No applicable recommendations.
iii.	Proposed methods of reducing spillages at the quench tower.	Compliant	2	The operational EMP addresses the spillages at the quench towers. ArcelorMittal reportedly installed an alarm system at all the quench towers to warn operators of high sump levels.	No applicable recommendations.
iv.	The EMP must include an air quality monitoring program based on the requirements of Condition 3.2(g).	Compliant	2	An air quality monitoring programme, which meets the requirements set out by the condition 3.2 (g), was submitted together with the operational EMP.	No applicable recommendations.
v.	A diagram indicating all unpaved surface areas, including bunds and storm-water channels, and any areas identified for storm-water and surface water management. Plans must be developed to ensure that all surface areas are protected from spillage and erosion, and that dust in the area of the coke ovens is reduced.	Noted/Not Applicable	0	This condition was adhered to in 2010 as the diagram was submitted together with the first bi-annual Environmental Performance Audit (June 2010) to the GDARD.	No applicable recommendations.
vi.	A proposal to address significant pollution from cooling tower sumps.	Compliant	2	General operating procedures are covered in the operational EMP. Further, the whole area is bunded and sumps are placed strategically within these bunded areas. A bio-dosing program is also in place to reduce potential microbial health risks.	No applicable recommendations.

No	Conditions	Status	Score	Observations	Recommendations
vii.	Handling procedures of sulphur and other by-products produced.	Compliant	2	Kindly note that currently no sulphur is generated. Further, the EMP was updated to include the handling of all by-products, including coke breeze.	No applicable recommendations.
viii.	A waste management plan pertaining to any waste from the treatment process not reused or sold as by-products, including expected volumes and classification, the disposal thereof, and waste manifest system.	Compliant	2	The operational EMP addresses waste management. In addition, ArcelorMittal also has a site wide Waste Management Procedure.	No applicable recommendations.
d)	A copy of the detailed HAZOP study to be conducted during the detail design phase of the project must be submitted to the Department 30 (thirty) calendar days before commissioning commences. The HAZOP must specifically include risks related to commissioning or decommissioning of any equipment, failure of treatment systems due to inefficient operation etc., emergencies and shutdowns, incidents such as spills, and potential discharges to the environment (air, water and land), and must propose operational and emergency procedures accordingly.	Noted/Not Applicable	0	This condition was adhered to in 2003 and again in 2004.	No applicable recommendations.
e)	An auditable Preventative Maintenance Plan must be developed to ensure that all water systems and environmentally critical equipment such as exhausters, ESP's, scrubbers and strippers are maintained as required. This plan must be auditable and must be externally verified on commissioning of the new plant. The management of IVS are to commit to the budget to undertake the required preventative maintenance. A discussion on the implementation of and compliance with the maintenance plan must be included in the bi-annual audit reports.	Compliant	2	An amendment application for the external verification of the Preventative Maintenance Plan (PMP), dated 29 July 2009, was submitted on 7 August 2009. Amendment to this condition was granted in November 2009.	No applicable recommendations.
f)	Final design plans for new and upgraded containment areas (sumps, tar decanters etc.), buffer tanks and chemical storage tanks, as well as proof of the Department of Water Affairs and Forestry's (DWAF) approval thereof as applicable, must be provided 30 (thirty) calendar days prior to the commencement of construction thereof. The above design plans must include information on specific pollution prevention measures (e.g. bunding & liners), compliance with relevant SABS standards (specifically tanks), the sourcing of particular materials as required (e.g. clay for liners), time-frames for construction, and exact location on site.	Noted/Not Applicable	0	This condition was adhered to in 2014. ArcelorMittal has, on many occasions, resubmitted the plans to the Department of Water and Sanitation (DWS) for approval which is, to date, outstanding. Updated designs will be submitted to DWS again in order to obtain the Departments written approval thereof.	ArcelorMittal must ensure that updated designs are submitted to the DWS as and when required.
g)	The following air quality management, monitoring and reporting regime must be implemented and reported on in the bi-annual environmental performance audits as applicable. Note that emission sampling (as applicable) is not required for each of the seven coke	Compliant	2	The facility has chosen representative stacks for some sampling based on the age and performance of the battery. Battery 4, 8 and 9 was chosen as the current Coke Strategy for the Works indicates that these 3 batteries will most likely be	No applicable recommendations.

No	Conditions	Status	Score	Observations	Recommendations
	oven stacks, but may be conducted on a single stack representative of the whole plant (a short motivation for using a particular stack in terms of physical and gas flow characteristics, similarity to other stacks, differences between stacks etc. must however be provided). Note that conditions relevant to the coke ovens themselves are applicable to all the coke oven batteries on site (i.e. no. 1, 3, 41 6, 7, 8, 9):			in operation for longer opposed to the other batteries with a shorter remaining life span. The facility argued that they wish to collect data on the remaining batteries which will remain in operation in order to have a long term trend for these batteries, both approaches are reasonable.	
i.	The concentrations of the various constituents of the cleaned Coke Oven Gas must be monitored before and after combustion in the coke ovens. The results are to be graphically represented and included in the bi-annual audit report. The H <sub>2</sub> S content of the gas must be between 0.8 and 1.5 g/Nm <sup>3</sup>	Moderate compliance non-	-1	The latest monitoring results indicate the H <sub>2</sub> S content of the gas exceeded the maximum limit of 1.5 mg/Nm <sup>3</sup> . The current reading is averaging at around 5 mg/Nm <sup>3</sup> (refer to <b>Appendix B</b> ). The non-compliance is linked to the Sulphur plant not being operational resulting in only partially cleaned gas being flared when there is no use for it in the rest of the works as an energy source. The Claus reactor has been non-operational for an extended period of time due to equipment failure and significant repairs and replacements are required. ArcelorMittal has prioritised this problem and the order for the refurbishment was placed in March 2019, with a total cost of close to R1 billion.	ArcelorMittal should continue with the prioritisation of the refurbishment in order to recommission the sulphur plant.
ii.	The emissions from the stacks of the coke ovens must be analysed for dioxin and furan emissions within 6 months of decommissioning of the benzole plant. The results of this monitoring must be reported in the bi-annual audit.	Noted/Not Applicable	0	This condition was adhered to in 2006 and is no longer applicable.	No applicable recommendations.
iii.	A plan for door maintenance/replacement of all the coke batteries (No.) and progress in achieving reduced fugitive emissions has to be developed. The plan must be supported by the results of personal monitors, and actual measurements at representative areas of the coke ovens.	Moderate compliance non-	-1	Battery doors are inspected on a daily basis and a maintenance schedule has been created. Repairs are done continuously. The fugitive emissions are monitored according to the internationally accepted standards and recorded. It was observed during the site visit that the occasional door is still burning and smoking. The commitment from the facility was however also observed to repair and maintain the equipment as far as possible. Exposure monitoring at the batteries indicates that additional fugitive emission mitigation measures are required, above that already implemented. This can however not be attributed only towards doors but rather the fugitive battery emissions as a cumulative source. ArcelorMittal has however implemented management and mitigation measures such as specialised face masks and other measures to protect employees and reduce exposure. Other measures include battery tightening, end-flue repairs and charge emission reduction projects. The effectiveness of these	It is recommended that the effectiveness of these measures should continuously be assessed to determine whether it is sufficient to mitigate fugitive emissions.

No	Conditions	Status	Score	Observations	Recommendations
				measures should be assessed to determine whether it is sufficient to mitigate fugitive emissions. Refer to <b>Appendix C</b> for the Door Inspection and Maintenance Plan.	
iv.	The assumptions regarding improved air quality made with respect to this project must be confirmed by actual ambient air quality monitoring. The improvements achieved must be discussed in the bi-annual environmental performance audit reports. Attention must be paid to the recommendation contained in the air quality report to install additional PM <sub>10</sub> and gaseous samplers within the zone of impact directly south of the IVS site.	Noted/Not Applicable	0	Ambient air quality monitoring is conducted however, since the plant is not fully operational, actual ambient air quality improvements for the completed project are still to be verified. ArcelorMittal is aware of the requirement for actual ambient air quality information.	No applicable recommendations.
v.	The following monitoring must be undertaken within 6 months of the commissioning of the various treatment plants. Results must be included in the first bi-annual environmental audit report, together with a plan for remediation should these emissions be significant. - Monitoring for ammonia and hydrogen sulphide fumes from the tar decanters and liquid sumps and storage tanks. - Monitoring for benzene must be undertaken at the flushing liquor storage tanks. - Sampling frequency and parameters for sampling of the cooling tower water is to be determined. Based on the understanding obtained from this sampling, emissions in the steam must be anticipated and sampling of steam must be undertaken to determine the impact on the environment of the present cooling process, determine if mitigation measures are required, and to develop reduction plans accordingly.	Noted/Not Applicable	0	This condition was adhered to previously and is not applicable to this audit period.	No applicable recommendations.
vi.	The composition of the approximately 15% of treated COG that would be flared, as well as the gas flare temperature, must be determined and reported on in the first bi-annual environmental audit. A discussion on the effective treatment of gas through flaring, and a plan to reduce the need for flaring the remaining 15% of COG must also be provided in the first audit.	Noted/Not Applicable	0	This condition was adhered to previously with the gas quality being reported on in the first bi-annual audit report. As such this condition is not applicable at this stage.	No applicable recommendations.
vii.	Based on the assumptions made in the air quality report, and the results of actual isokinetic sampling and personal monitoring, a plan must be developed with proposals on future emission sampling, including the frequency thereof and the constituents to be sampled for. This work must be undertaken by an external expert and a report with recommendations must be submitted with the first bi-annual audit. In order to ensure early detection of issues to be addressed and ensure the efficiency of treatment equipment, relevant air	Noted/Not Applicable	0	Airshed Planning Professionals was commissioned in 2011 to conduct the required assessment and develop the air quality monitoring plan for the Coke Ovens. The report was submitted as required, as such this condition is noted as not applicable at this stage.	No applicable recommendations.



No	Conditions	Status	Score	Observations	Recommendations
	quality monitoring of COG must be undertaken after each step of commissioning a specific treatment technology.				
viii.	Based on emission results further emission reduction programs may have to be developed. These plans must consider international standards and best practice, such as the US EPA's <i>Final rule to reduce toxic emissions from coke ovens</i> (February, 2003), and <i>NESHAP for Coke Ovens: Pushing, Quenching and Battery Stacks - Background information for proposed standards</i> (February 2001 ).	Compliant	2	ArcelorMittal has developed a Coke Strategy for the short, medium and long term. The facility also implements additional Emission Reduction Plans in line with the various site-specific Atmospheric Emissions Licenses (AEL). Further strategies for emission reductions are continuously investigated. The implementation of the plans, including the establishment of the Ammonia stripping plant, reportedly depends on resource availability. Funds have now been approved for the refurbishment and installation of the Sulphur plant and ammonia stripper, and the order for the manufacturing portion was placed in March 2019. Refer to <b>Appendix D</b> for the Cumulative Particulate Matter reduction from the Works.	No applicable recommendations.
h)	The flaring of uncleaned gas at the relevant flares is only permissible during upset conditions when the Claus Reactor is shut down for inspection/maintenance for 3 weeks every three years, and must be undertaken at temperatures and atmospheric mixing conditions conducive to maximum dispersion of pollutants.	Moderate compliance non-	-1	The Sulphur plant is not operational and therefore only partially cleaned gas is flared when there is no use for it in the rest of the works as an energy source. The Claus reactor has been non-operational for an extended period of time due to equipment failure and significant repairs and replacements are required. Flaring is taking place on a more regular basis than just 3 weeks every 3 years. However, this issue has been reported on and ArcelorMittal is continuously aware that urgent intervention is needed.	ArcelorMittal must continue monitoring air quality within the Works to maintain a baseline of emission results. The design, construction and re-operation of the sulphur plant should be prioritised as it is only through this plant's operation that the flaring of uncleaned gas can be controlled.
i)	Detailed and up to date records must be kept of all incidents and complaints pertaining to the COG and water cleaning project, how these were managed, and the recurrence thereof prevented. These records must be made available to the Department within 14 (fourteen) calendar days upon written request by the Department.	Compliant	2	Incident and complaints registers are available at the main gate. Incidents are also recorded and saved on the internal reporting system and/or noted in ECO reports/incident register. The facility has an electronic incident management system (PIVOT) which manages the incidents. The system facilitates the investigation and mitigation measures between different responsible parties. No incidents related to the project were recorded during the audit period.	No applicable recommendations.
j)	This Department and the Department of Water Affairs and Forestry must be informed of any major environmental and pollution incidents relating to the COG and water cleaning project within 24 (twenty four) hours of such incidents occurring.	Noted/Not Applicable	0	No major or emergency incidents were reported in the reporting period and as such this condition is not applicable.	No applicable recommendations.
k)	The use of the existing Maturation Dams for the storage or disposal of any effluent/sludge/waste is prohibited as from 6 months after commissioning of the completed coke oven by-products plant. An application for authorisation and draft plan for decommissioning and	Noted/Not Applicable	0	The Department of Environmental Affairs (DEA) issued a Waste Management License (WML) for the decommissioning of the maturation ponds in February 2012. As such the facility implemented various process changes in order to cease the use	No applicable recommendations.

No	Conditions	Status	Score	Observations	Recommendations
	rehabilitation of the existing Maturation Dams must be submitted to the Department within 120 (one hundred and twenty) calendar days of commissioning of the COG and water cleaning project.			of the dams. The dams were taken out of operation in 2008, two years before the COCGW project was commissioned. The remediation of the maturation ponds are progressing very well. The dam consisted out of 3 dams of which the remediation of Dams 2 and 3 is 100% complete and Dam 1 about 60% complete. Soil is being remediated in-situ. This condition is therefore noted as not applicable to the audit period.	
l)	Planning with respect to addressing existing groundwater contamination identified in the Coke Plant area must continue. Confirmation of, or plans for the abstraction and/or treatment of contaminated groundwater or specific pollutants, including the feasibility of abstracting contaminated groundwater from the aquifer underlying the site as a source of water supply to the process, needs to be considered. Progress with respect to this matter must be reported on in the quarterly progress reports and bi-annual environmental performance audits thereafter.	Compliant	2	A contaminated land assessment in terms of the National Environmental Management: Waste Act, 2008 (Act No. 59 of 2008) (NEM:WA) (Part 8), which encompassed the entire Works, was recently finalised. The contaminated land assessment report, including groundwater assessment, and associated remediation plan was submitted to the Department of Environmental Affairs (DEA) on 7 June 2018. ArcelorMittal Vanderbijlpark Works was issued with a Remediation order on 16 November 2018 and is currently addressing the issues of the directive.	No applicable recommendations.
m)	The recommendations contained in the specialist studies submitted in support of the application for authorisation of the COG and water cleaning project are regarded as an extension of the conditions of this authorisation. Implementation of or compliance with these recommendations must be discussed as part of the quarterly progress reports and bi-annual environmental performance audits thereafter.	Compliant	2	These recommendations have been included in the EMP and are also assessed as part of the internal reports. Refer to <b>Appendix E</b> for the most recent quarterly report.	No applicable recommendations.
n)	An Independent Environmental Control Officer (ECO) with an understanding of the coke oven operational and treatment processes must be appointment for the duration of construction and commissioning, to monitor and report on compliance with the conditions of this authorisation.	Compliant	2	Mr Terrence Wilson was appointed as the ECO for the ArcelorMittal site on 27 January 2010.	No applicable recommendations.
<b>3.3</b>	<b>General Conditions</b>				
a)	Any changes to, or deviations from, the project description set out in this letter must be approved, in writing, by the Department before such changes or deviations may be effected. In assessing whether to grant such approval or not, the Department may request such information as it deems necessary to evaluate the significance and impacts or such changes or deviations.	Noted/Not Applicable	0	This condition is noted. No changes to, or deviations from, the project description were made during the audit period.	No applicable recommendations.
b)	This Department may review the conditions contained in this letter from time to time and may, by notice in writing to the applicant, amend, add or remove a condition.	Noted/Not Applicable	0	This condition is noted.	No applicable recommendations.



No	Conditions	Status	Score	Observations	Recommendations
c)	The applicant must notify the Department, in writing, at least 30 (thirty) days prior to the change of ownership, project developer or the alienation of any similar rights for the activity described in this letter. The applicant must furnish a copy of this document to the new owner, developer or person to whom the rights accrue and inform the new owner, developer or person to whom the rights accrue that the conditions contained herein are binding on them.	Noted/Not Applicable	0	This condition is noted.	No applicable recommendations.
d)	Where any of the applicant's contact details change, including the name of the responsible person, the physical or postal address and/or telephonic details, the applicant must notify the Department as soon as the new details become known to the applicant.	Noted/Not Applicable	0	This condition is noted.	No applicable recommendations.
e)	Authorisation for the activity is granted in terms of the Environment Conservation Act, 1989 (Act 73 of 1989) only and does not exempt the holder from compliance with other relevant legislation.	Noted/Not Applicable	0	This condition is noted. ArcelorMittal has a legal register in place with sufficient legal advisors to ensure they are aware of their legal requirements. The register is updated as required.	No applicable recommendations.
f)	The applicant shall be responsible for ensuring compliance with the conditions contained in this letter by any person acting on his behalf, including but not limited to, an agent, servant, or employee or any person rendering a service to the applicant in respect the activity, including but not limited to, contractors and consultants.	Compliant	2	An ECO has been appointed to ensure compliance with conditions of the authorisation and ensure contractors are informed of requirements.	No applicable recommendations.
g)	Departmental officials shall be given access to the property referred to in 1 above for the purpose of assessing and/ or monitoring compliance with the conditions contained in this document at all reasonable times.	Noted/Not Applicable	0	This condition is noted.	No applicable recommendations.
h)	The applicant must notify the Department within 24 (twenty four) hours if any condition of this authorisation cannot, or is not, adhered to. The notification must be supplemented with reasons for non-compliance.	Noted/Not Applicable	0	This condition is noted.	No applicable recommendations.
<b>3.4</b>	<b>Reporting requirements</b>				
a)	A summarised quarterly progress report on the implementation of the COG and water cleaning project must be submitted to the Department, the first report being due 90 (ninety) calendar days after construction commences, and every 90 (ninety) calendar days thereafter. These progress reports must address, inter alia, the following:	Compliant	2	ArcelorMittal compiles quarterly progress reports and is only required to submit these reports to GDARD upon request. Refer to <b>Appendix E</b> for the most recent quarterly report.	No applicable recommendations.
i.	Up to date scheduling of implementation and associated time-frames.	Noted/Not Applicable	0	This condition is noted as a reporting requirement.	No applicable recommendations.
ii.	Records of any major incidents (see 3.2(i) above).	Noted/Not Applicable	0	This condition is noted as a reporting requirement.	No applicable recommendations.
iii.	Decommissioning of infrastructure.	Noted/Not Applicable	0	This condition is noted as a reporting requirement.	No applicable recommendations.

No	Conditions	Status	Score	Observations	Recommendations
iv.	Rehabilitation and disposal of contaminated waste material (soil, decommissioned equipment etc.), including the quantity and classification (general/hazardous) thereof.	Noted/Not Applicable	0	This condition is noted as a reporting requirement.	No applicable recommendations.
v.	Commissioning of any treatment infrastructure.	Noted/Not Applicable	0	This condition is noted as a reporting requirement.	No applicable recommendations.
vi.	Results on the monitoring of the efficiency of commissioned treatment infrastructure.	Noted/Not Applicable	0	This condition is noted as a reporting requirement.	No applicable recommendations.
vii.	Monitoring of activities in terms of the environmental management plan (see 3.2 (c) above).	Noted/Not Applicable	0	This condition is noted as a reporting requirement.	No applicable recommendations.
viii.	Any steps taken to rectify areas of non-compliance with environmental requirements.	Noted/Not Applicable	0	This condition is noted as a reporting requirement.	No applicable recommendations.
b)	A bi-annual Environmental Performance Audit conducted by an independent, accredited auditor must be submitted to the Department for review, the first audit being due 6 (six) months after commissioning of the COG and water cleaning project, and every 6 (six) months thereafter. The bi-annual audit must include, inter alia, the following (results in graph format as applicable):	Compliant	2	The previous external EPA was conducted by GCS in August 2018.	No applicable recommendations.
i.	Volume of water treated, volume re-used, volume discharged, and reduction in volume of fresh water intake achieved, i.e. updated water balance for the site.	Compliant	2	ArcelorMittal Vanderbijlpark Works is a zero effluent discharge facility as required in terms of the WUL. The updated water balance for the Works is attached as <b>Appendix F</b> , whilst the water balance for the Coke Plant is attached as <b>Appendix G</b> . Prior to becoming a zero discharge facility treated effluent was discharged from the Works through the Rietspruit canal into the Rietspruit River which flows into the Vaal River. Effluent discharge qualities and volumes are presented in <b>Appendix H</b> and freshwater abstraction volumes are presented in <b>Appendix I</b> . An average 65% reduction in water abstraction has been achieved since 2005.	No applicable recommendations.
ii.	Results of improvements in air and water quality achieved.	Compliant	2	ArcelorMittal is committed to improving air and water quality results for the Works. Refer to <b>Appendix B</b> , <b>Appendix D</b> , <b>Appendix H</b> and <b>Appendix I</b> .	No applicable recommendations.
iii.	Air quality monitoring and reporting as required by Condition 3.2(g).	Compliant	2	Ambient air quality and fugitive emissions monitoring, management and reporting for the Works is undertaken in accordance with the Atmospheric Emissions License (AEL) and the Air Quality Monitoring Plan produced by Airshed Planning Professionals in 2011 (refer to <b>Appendix J</b> ). The ambient air quality around the Works is monitored by ArcelorMittal at four pre-determined locations. Fugitive emissions by nature are a difficult element to monitor. The monitoring system that has been put in place by ArcelorMittal is noteworthy and the	No applicable recommendations.

No	Conditions	Status	Score	Observations	Recommendations
				different sources of fugitive emissions are assessed in the fugitive emissions monitoring plan which includes the doors, pipes and charging times, and smoke observed. The Coke Battery Stack dust emissions are attached as <b>Appendix K</b> . Occupational health monitoring, undertaken in terms of the Occupational Health and Safety Act, can also be used as a monitoring program in order to determine the effectiveness of the mitigation measures implemented at the Works. Furthermore, as noted in the quarterly progress reports ( <b>Appendix E</b> ), ambient air quality monitoring results from stations operated by the DEA, indicate that SO <sub>2</sub> limits were not exceeded in the Vaal Triangle Airshed Priority Area during the first quarter of the year.	
iv.	Discussion on groundwater treatment (volumes, pollution stabilisation etc.).	Compliant	2	ArcelorMittal have established remedial actions to address historic groundwater contamination and avoid groundwater contamination from current operations. A contaminated land assessment was undertaken in 2017/2018 and the report and associated remediation plan was submitted to the DEA on 7 June 2018. This assessment and remediation plan, together with remodelled groundwater information for the Works, will be used to assess the success rate of the remedial actions implemented to date. ArcelorMittal Vanderbijlpark Works was issued with a Remediation order on 16 November 2018 and is currently addressing the issues of the directive.	No applicable recommendations.
v.	Discussions on the implementation (or not) of recommendations as contained in the Scoping Report and Specialist Studies.	Compliant	2	The recommendations as contained in the scoping report and specialist reports have been included into the operational EMP and monitoring plans for the project.	No applicable recommendations.
vi.	Results of ground and surface water monitoring as provided for in the EMP.	Minor non-compliance	1	The Works is operated as a zero-discharge facility, however in the event of process upset conditions at the coke plant, contaminated surface water can be diverted to the Coke Plant sump which is a buffer dam where water from the dam can be reclaimed for re-use as and when there is sufficient capacity in the system. The levels of the coke plant sump are managed and measured to ensure the sump does not overflow. Storm water from the coke plant is measured at the coke plant storm water drain and is subsequently combined with other areas inflows. The flow is measured continuously and the Electrical Conductivity is also monitored. Sporadic discharge into the Rietspruit has taken place few months after the audit of 2018, with no discharge during January and February 2019 as per the	No applicable recommendations.

No	Conditions	Status	Score	Observations	Recommendations
				data at the time of conducting the audit (refer to <b>Appendix H</b> ). Groundwater monitoring and management is conducted according to the ArcelorMittal WUL. A contaminated land assessment in terms of the National Environmental Management: Waste Act, 2008 (Act No. 59 of 2008) (NEM:WA) (Part 8), which encompassed the entire Works, was recently finalised. The contaminated land assessment report, including groundwater assessment, and associated remediation plan was submitted to the Department of Environmental Affairs (DEA) on 7 June 2018. ArcelorMittal Vanderbijlpark Works was issued with a Remediation order on 16 November 2018 and is currently addressing the issues of the directive. The groundwater monitoring graphs and results are attached as <b>Appendix L</b> .	
vii.	Quantities and handling of all by-products produced (sulphur, tar etc.).	Compliant	2	The Coke Ovens generates coke breeze, liquid raw tar and tar sludge as by-products and waste streams. The various waste stream quantities are presented in <b>Appendix M</b> . Liquid tar generated by the coke ovens are pumped to the tar plant for further processing. Tar sludge is generated and mixed with coal dross at a temporary storage area from where it is collected and disposed by Enviroserv (Holfontein H:H Waste Disposal site). Safe disposal certificates are kept for the loads as removed. ArcelorMittal reported that the facility has constructed a plant to recycle and re-use a portion of the tar sludge back into the coke battery plant. The tar sludge is captured by the existing carousels system and is transported with the forklift to the new tar sludge recycling plant. The tar sludge is mixed in with the coal and used in the coke making process again. The recycling facility has been commissioned with the anticipated outcome of a reduction of the disposal of hazardous waste. No liquid sulphur has been generated during the audit period as the plant is off line. Coke breeze is generated during the quenching process. Water is sprayed onto the hot coals when it is pushed out of the ovens. The coke breeze collects at the base of the quench tower. The majority of the coke breeze is transported by railway to the sinter plant for recycling.	No applicable recommendations.
viii.	Report on the success of the carousel system being implemented for the collection of tar from tar decanters (first audit only), as well as the method used to return the tar to the coke ovens. A mechanism	Noted/Not Applicable	0	This condition is not applicable for the audit period.	No applicable recommendations.

No	Conditions	Status	Score	Observations	Recommendations
	to collect spillages from the carousal must be discussed, as well as the implementation of an alarm to indicate when the collection vessels are full.				
ix.	Discussion on the implementation of and compliance with the Preventative Maintenance Plan (see 3.2(e) above).	Repeat Condition	-	Critical maintenance requirements are continuously identified and are captured on the SAP system for tracking and action. A job cards is created and managed on this internal system. Refer to <b>Appendix N</b> for an example of a job card. This condition is scored according to condition 3.2 (e).	No applicable recommendations.
x.	Records of any major incidents (see 3.2(i) above),	Repeat Condition	-	Refer to the observations made in condition 3.2(i).	No applicable recommendations.
xi.	Quantity of waste generated, and the classification and management thereof.	Repeat Condition	-	Refer to the observations made in condition 3.2(vii).	No applicable recommendations.
xii.	Reporting on compliance with the provisions of this authorisation and the environmental management plan, and steps taken to rectify non-compliance.	Compliant	2	This report serves as the first bi-annual external EPA report for 2019.	No applicable recommendations.
xiii.	Monitoring of relevant boreholes with respect to detecting any leaks/pollution from all facets of the COG and water cleaning.	Compliant	2	A borehole improvement plan has been undertaken. Upgrade of the monitoring borehole network completed in 2010 and supplementary monitoring boreholes have been equipped with caps. New boreholes were drilled to replace the damaged boreholes. A new borehole was installed to replace the previously damaged CO-3D. Refer to the groundwater monitoring results in <b>Appendix L</b> .	It is recommended that the WUL be amended to include the new boreholes.
xiv.	Details of any failures in the treatment system an how these were managed.	Repeat Condition	-	Refer to the observations made in condition 3.2(i).	No applicable recommendations.
xv.	Details on the quality and quantity of any discharge (air, water and land), and reasons for discharge, how these were managed, and the recurrence thereof prevented.	Repeat Condition	-	Refer to the observations made in condition 3.4(b)(ii).	No applicable recommendations.
<b>3.5</b>	<b>Duration of authorisation</b>				
	If the activity authorised by this letter does not commence within 6 (six) months from the date of signature of this letter, the authorisation will lapse and the applicant will need to re-apply for authorisation in terms of the above legislation or any amendments thereto.	Noted/Not Applicable	0	This condition is not applicable for the audit period.	No applicable recommendations.
		<b>Total Findings</b>	<b>96</b>		

## 6 CONCLUSION AND RECOMMENDATIONS

By conducting an EPA, ArcelorMittal recognises the importance of authorisation in regulating processes related to the project.

Currently the overall compliance with the Record of Decision (ROD) (GAUT 002/02-03/138) is noteworthy. Overall there was one (1) incident of minor non-compliance, three (3) incidents of moderate non-compliance, and zero (0) incidents of major non-compliance observed for the audit period. ArcelorMittal is compliant with the relevant conditions of the ROD that apply to the current status of the project.

### H<sub>2</sub>S Content in Gas

Condition 3.2(g)(i) states that “The concentrations of the various constituents of the cleaned Coke Oven Gas must be monitored before and after combustion in the coke ovens. The results are to be graphically represented and included in the bi-annual audit report. The H<sub>2</sub>S content of the gas must be between 0.8 and 1.5 g/Nm<sup>3</sup>. ”

#### *Observation:*

The latest monitoring results indicate the H<sub>2</sub>S content of the gas exceeded the maximum limit of 1.5 mg/Nm<sup>3</sup>. The current reading is averaging at around 5 mg/Nm<sup>3</sup>. The non-compliance is linked to the Sulphur plant not being operational resulting in only partially cleaned gas being flared when there is no use for it in the rest of the works as an energy source. The Claus reactor has been non-operational for an extended period of time due to equipment failure and significant repairs and replacements are required. ArcelorMittal has prioritised this problem and the order for the refurbishment was placed in March 2019.

#### *Recommendation:*

ArcelorMittal should continue with the prioritisation of the refurbishment of the gas plant in order to recommission the sulphur plant.

### Plan for Achieving Reduced Fugitive Emissions

Condition 3.2(g)(iii) states that “A plan for door maintenance/replacement of all the coke batteries (No.) and progress in achieving reduced fugitive emissions has to be developed. The plan must be supported by the results of personal monitors, and actual measurements at representative areas of the coke ovens.”

#### *Observation:*

Battery doors are inspected on a daily basis and a maintenance schedule has been created. Repairs are done continuously. The fugitive emissions are monitored according to the

internationally accepted standards and recorded. It was observed during the site visit that the occasional door is still burning and smoking. The commitment from the facility was however also observed to repair and maintain the equipment as far as possible. Exposure monitoring at the batteries indicates that additional fugitive emission mitigation measures are required, above that already implemented. This can however not be attributed only towards doors but rather the fugitive battery emissions as a cumulative source. ArcelorMittal has however implemented management and mitigation measures such as specialised face masks and other measures to protect employees and reduce exposure. Other measures include battery tightening, end-flue repairs and charge emission reduction projects. The effectiveness of these measures should be assessed to determine whether it is sufficient to mitigate fugitive emissions.

*Recommendation:*

It is recommended that the effectiveness of these measures should continuously be assessed to determine whether it is sufficient to mitigate fugitive emissions.

**Plan for Achieving Reduced SO<sub>2</sub> Emissions**

Condition 3.2(h) states that “The flaring of uncleaned gas at the relevant flares is only permissible during upset conditions when the Claus Reactor is shut down for inspection/maintenance for 3 weeks every three years, and must be undertaken at temperatures and atmospheric mixing conditions conducive to maximum dispersion of pollutants.”

*Observation:*

The sulphur plant is not operational and therefore only partially cleaned gas is flared when there is no use for it in the rest of the works as an energy source. The Claus reactor has been non-operational for an extended period of time due to equipment failure and significant repairs and replacements are required. Flaring of uncleaned gas is taking place on a more regular basis than 3 weeks every 3 years. However, this issue has been reported on and ArcelorMittal is continuously aware that urgent intervention is needed.

*Recommendation:*

ArcelorMittal must continue monitoring air quality within the Works to maintain a baseline of emission results. The design, construction and operation of the sulphur plant should be prioritised as it is only through this plant’s operation that the flaring of uncleaned gas can be controlled.

The instances of non-compliance weren't considered to be directly associated with significant environmental degradation.



## **APPENDIX A: DECLARATION OF AUDITOR INDEPENDENCE**

I, **Fatima Matlou**, declare that:

- I act as the independent environmental auditor in this assessment;
- I will perform the work relating to the assessment in an objective manner, even if this results in views and findings that are not favourable to the authorisation holder;
- I declare that there are no circumstances that may compromise my objectivity in performing such work;
- I have expertise in conducting environmental auditing, including knowledge of the Act, Regulations and any guidelines that have relevance to the proposed activities;
- I will comply with the Act, Regulations and all other applicable legislation;
- I will take into account, to the extent possible, the matters listed in Regulation 34 of the Regulations when preparing this assessment and any report relating it;
- I have no, and will not engage in, conflicting interests in the undertaking of this assessment;
- I undertake to disclose to the holder and the competent authority all material information in my possession that reasonably has or may have the potential of influencing - any decision to be taken with respect to the application by the competent authority; and the objectivity of any report, plan or document to be prepared by myself for submission to the competent authority;
- I will ensure that information containing all relevant facts in respect of the assessment is distributed or made available to interested and affected parties and the public and that participation by interested and affected parties is facilitated in such a manner that all interested and affected parties will be provided with a reasonable opportunity to participate and to provide comments on documents that are produced to support the assessment;
- I will ensure that the comments of all interested and affected parties are considered and recorded in reports that are submitted to the competent authority in respect of the application, provided that comments that are made by interested and affected parties in respect of a final report that will be submitted to the competent authority may be attached to the report without further amendment to the report;
- I will provide the competent authority with access to all information at my disposal regarding the assessment, whether such information is favourable to the holder or not;
- All the particulars furnished by me in this form are true and correct;
- I will perform all other obligations as expected from an environmental auditor in terms of the Regulations; and
- I realise that a false declaration is an offence in terms of Regulation 48 of the Regulations and is punishable in terms of section 24F of the Act.

Disclosure of Vested Interest

- I do not have and will not have any vested interest (either business, financial, personal or other) in the proposed activity proceeding other than remuneration for work performed in terms of the Environmental Impact Assessment Regulations, 2014.

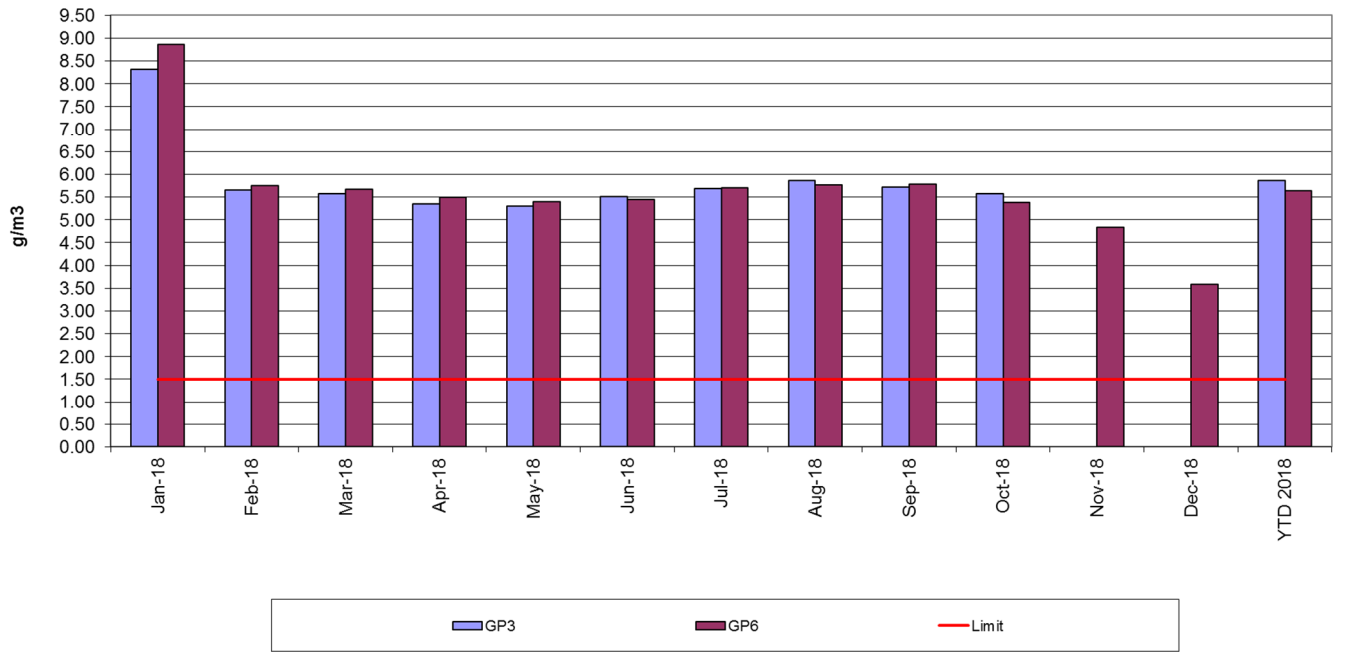


Signature of the environmental auditor

15 March 2019

## **APPENDIX B: H<sub>2</sub>S IN COKE OVEN GAS DATA**

### H2S in Coke Oven Gas



## **APPENDIX C: DOOR INSPECTION AND MAINTENANCE PLAN**

DOOR SPARES STOCK LIST'

DATE: 21/01/2019

<u>SPARE DOORS AT REPAIR</u>	SPARE DOORS		DOOR TO BE DEMOLISH		DOORS TO BE SERVICE		DOORS OUT FOR DRYING	
	P/S	C/S	P/S	C/S	P/S	C/S	P/S	C/S
	12	9	10	12	0	0	0	0
							DOORS TO BE SEND FOR DRY	
							P/S	C/S
							0	1

<u>SPARE DOORS ON BATT</u>	SPARE DOORS ON BATT		DOORS TO REMOVE	
	P/S	C/S	P/S	C/S
	3	4	3	4

DEVIATIONS ON INSPECTIONS OF BATTERY DOORS

	P/S	DOORS	HEADS	CHECK/D	KLIETS	SADDLES	DOOR HOOKS	GUN LINTELS	APRONS	C/S	DOORS	KLIETS	SADDLES	DOOR HOOKS	GUN LINTELS	APRONS
<u>4 BATT INSPECTION'</u>	P/S	0	0	11	1	0	1	0	0	C/S	0	5	0	3	0	0
<u>6 BATT INSPECTION'</u>	P/S	1	3	6	3	7	1	4	0	C/S	1	6	2	0	22	1
<u>7 BATT INSPECTION'</u>	P/S	0	5	17	2	1	2	3	1	C/S	0	13	0	0	10	4
<u>8 BATT INSPECTION '</u>	P/S	0	9	24	3	2	1	26	0	C/S	0	4	1	1	4	0
<u>9 BATT INSPECTIONS'</u>	P/S	0	3	39	2	2	1	15	0	C/S	0	1	0	0	6	5
TOTAL DEVIATIONS	P/S	1	20	97	11	12	6	48	1	C/S	1	29	3	4	42	10

Deliveries outstanding from foundry

ITEM	QTY	ORDER Nr	SAP DELIVERY	PARTIAL DEL	OUTSTANDING	UNIT PRICE	Total order
P/S DOOR	15	4520619611	2019.04.04	0	15	R 70 637.00	R 1 059 555.00
C/S DOOR	10	4520606697	2019.03.28	0	10	R 54 951.00	R 549 510.00
L/FRAME	6	4520594200	2019.02.28	0	6	R 23 497.00	R 140 982.00
L/FRAME	15	4520611686	2019.03.29	0	15	R 23 497.00	R 352 455.00
CHECK DOOR	20	4520617851	2019.03.22	0	20	R 2 219.00	R 44 380.00
SADDLE P/S	30	4520570346	2019.01.22	0	30	R 4 790.00	R 143 700.00
SADDLE P/S	30	4520629153	2019.04.15	0	30	R 4 790.00	R 143 700.00

R 2 434 282.00

Start Date		01/01/2019	End date		06/03/2019	Months	3
Doors From Batteries PS	#VALUE!	PS	Doors From Batteries CS		#VALUE!	CS	
Doors To Batteries PS	#VALUE!		Doors To Batteries CS		#VALUE!		



Door Equipment Failures				Deviations	
Equipment damaged	QTY	Price/ Unit	Total Cost	Type of Deviations	QTY
BUSH LONG	#VALUE!	R 145.00	#VALUE!	Crack at bottom door body	#VALUE!
BUSH SHORT	#VALUE!	R 69.95	#VALUE!	Crack at middle door body	#VALUE!
CHECK DOOR PS	#VALUE!	R 2 071.00	#VALUE!	Crack at top door body	#VALUE!
COVER + FIXED NUT	#VALUE!	R 150.00	#VALUE!	Safety Latch broken or bend	#VALUE!
DOOR ASSEMBLIES CS	#VALUE!	R 47 842.00	#VALUE!	Door hooks broken	#VALUE!
DOOR ASSEMBLIES PS	#VALUE!	R 52 981.00	#VALUE!	Check Door broken	#VALUE!
FRAME LEVELLER ASSY[HEAD] PS	#VALUE!	R 24 656.00	#VALUE!	Refractories Broke	#VALUE!
HINGE WISH BONE PS	#VALUE!	R 2 325.00	#VALUE!	Crack leveller Head or Broken	#VALUE!
LATCH PS	#VALUE!	R 264.96	#VALUE!	Leveller Head bend/Seal on check door bad	#VALUE!
LATCH SAFETY [ LONG]	#VALUE!	R 3 975.00	#VALUE!	Liners scraped	#VALUE!
LATCH SAFETY [ SHORT]	#VALUE!	R 1 217.00	#VALUE!	Saddle CS Scraped	#VALUE!
LINERS CS	#VALUE!	R 1 454.00	#VALUE!	Saddle PS Scraped	#VALUE!
LINERS PS	#VALUE!	R 1 600.00	#VALUE!	Spring of Check door Scraped	#VALUE!
SADDLE CS	#VALUE!	R 1 177.10	#VALUE!	Hinge for wish bone broken	#VALUE!
SADDLE PS	#VALUE!	R 4 045.00	#VALUE!		
SPRING PS	#VALUE!	R 45.00	#VALUE!		
STRAP PS	#VALUE!	R 372.00	#VALUE!		
			#VALUE!		

## Door Equipment Failures

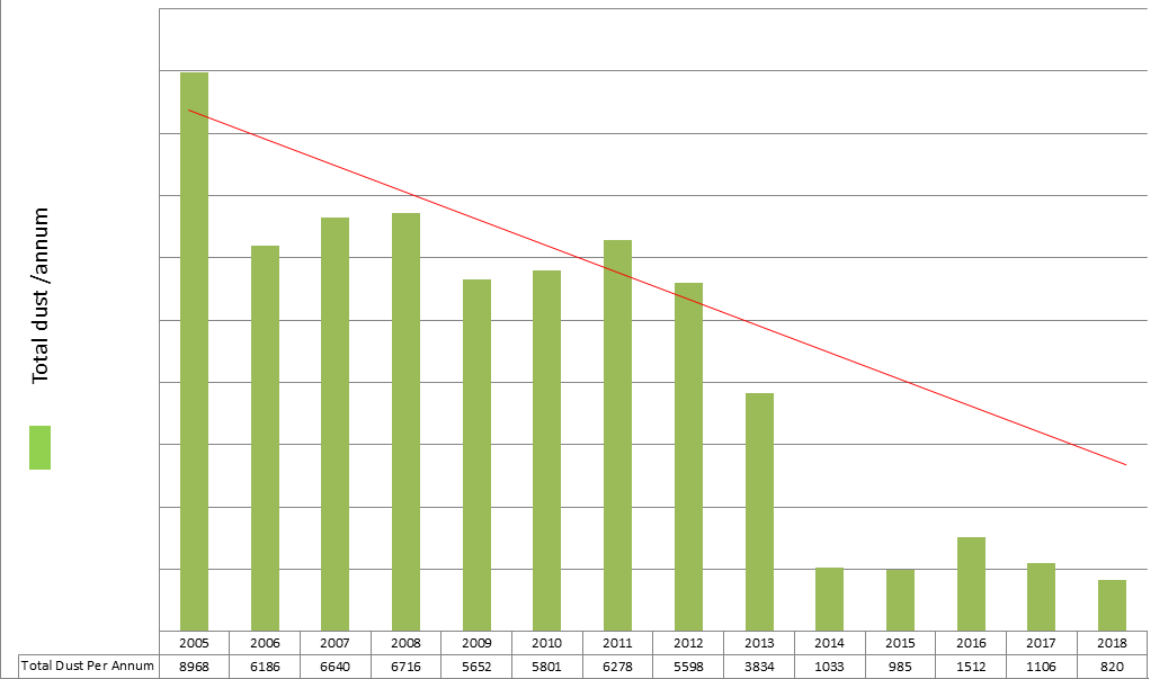


## Deviations



## **APPENDIX D: CUMULATIVE PARTICULATE MATTER EMISSION REDUCTION**

ArcelorMittal South Africa Vanderbijlpark Works Total Dust



## **APPENDIX E: QUARTERLY PROGRESS REPORT.**

ArcelorMittal South Africa

Vanderbijlpark Works

Cleaning of Coke Oven Gas and Water

Quarterly Progress Report (December 2018)



## Contents

# **ArcelorMittal South Africa Vanderbijlpark Works Cleaning of Coke Ovens Gas and Water Project**

- A. Scheduling of implementation and time frames
- B. Records of major incidents
- C. Decommissioning of infrastructure
- D. Rehabilitation and disposal of contaminated material
- E. Commissioning
- F. Results on the monitoring of efficiency of commissioned plants
- G. Monitoring of construction activities in terms of the EMP
- H. Steps taken to rectify areas of non-compliance with environmental requirements
- I. Specialist recommendations
- J. RoD compliance table summary
- K. Conclusion

## A. Scheduling of implementation and time frames

### 1. Cleaning of Coke Ovens gas and water

The major Milestone Dates on the project are reflected below in Table 1: Milestone Summary.

**Table 1: Milestone Summary**

Item	Milestone Description	Planned Date	Forecast Date	Actual Date
1.	All contract Award Dates	04/10/29	04/10/29	Oct 04
2.	Primary cooling unit & scrubbing facilities GP3	06/06/28	06/07/28	July 06
3.	Primary cooling unit & scrubbing facilities GP6	06/07/12	06/08/30	Sept 06
4.	Chilled water station with cooling tower	06/06/28	06/08/30	Dec 06
5.	Ammonia stills & de-acidifier	06/07/19	06/08/30	Aug 08
6.	Elementary sulphur plant	06/07/19	07/02/28	Jan 10
7.	Process control system	06/06/07	07/02/28	Jan 10
8.	Project completion	06/10/31	07/03/05	Jan 10
9.	Installation of the Gravel Filter	08/12/31	08/12/31	Aug 12 (Note 1)
10.	Installation of ammonia strippers and caustic dosing facilities	15/12/31	Note 2	

**Note 1:** Commissioning of Gravel Filter unit commenced on 3 September 2013.

**Note 2:** CAPEX originally budgeted for 2<sup>nd</sup> phase of coal water treatment in 2016. However, due to integrated operations, the decision was made to incorporate the ammonia strippers into the broader by-products plant upgrade, scheduled for implementation in 2019.

#### 1.1 Status

One of the specialist recommendations transpiring from the EIA process for the project was that plans for addressing the existing groundwater contamination in the Coke Plant area must continue. All known active sources from the area have been eliminated and since inception of remedial actions, around 2007, which formed part of the original groundwater management plan, significant progress has been made in this regard. As such, it was decided to remodel the groundwater dynamics for the entire site to assess the success of remedial actions undertaken in the past decade. This modelling will tie in with the greater contaminated land assessment for the Works, which will dictate possible contaminated land and groundwater initiatives going forward. The first phase of the contaminated land assessment was completed in September 2017. The contaminated land assessment report and associated remediation plan was submitted to the Department of Environmental Affairs on the 7<sup>th</sup> June 2018. Subsequent to this, the content of these documents was presented to the Department on the 27<sup>th</sup> August 2018. A Remediation Order was issued to ArcelorMittal Vanderbijlpark Works on the 16<sup>th</sup> November 2018 which prescribes groundwater remedial actions for the entire site.

On the 15<sup>th</sup> March 2012, the Department was informed of the progress of the unanticipated shut-down of the Elementary Sulphur Plant, which is an integral component of the coke oven gas cleaning facilities at the Works. The Department has requested feedback on the progress of start-up of the Plant, in a letter dated 3 May 2012, which will be provided once ArcelorMittal has performed all the necessary repairs and is in a position to safely operate the Plant. Feedback on the status of the Plant has been communicated to the Department via external audit reports submitted on a bi-annual basis. The compliance and enforcement section of the provincial authority requested a meeting and site visit to discuss the status of the Plant. In the meeting held on the 23<sup>rd</sup> November 2016, the history of Plant failures and challenges were



presented to the Department officials, together with the extensive actions implemented over the years in an attempt to reinstate operation of the Plant. A pre-compliance notice was also issued by the GDARD on the 10<sup>th</sup> May 2018 concerning this issue. ArcelorMittal's response was subsequently submitted. Subsequently, a compliance notice was issued which acknowledges that the Plant will be commissioned 2.5 years after order placement.

The Projects Department has evaluated tenders from specialists to conduct integrity checks of the gas plant equipment, including vessels, heat exchangers, pipes, trestles, exhausters etc. An enquiry for the technical design required for implementation of the actions identified as part of the specialist assessment to determine the deficiencies of the Plant has also been issued, with quotes received. Tender negotiations for the engineering and procurement component of the upgrade project are currently underway. The total project value is in the region of R1 billion.

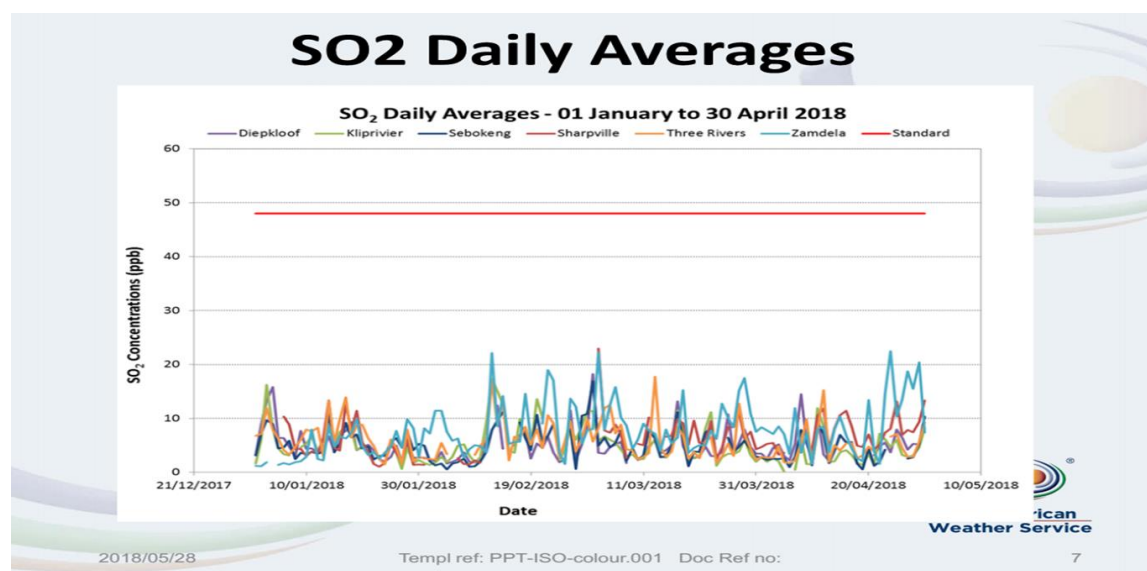
As previously reported, the Gravel Filter Plant was commissioned on 3 September 2013. Consequently, significant improvements in water quality (in terms of suspended solids and tar particles) have been achieved. Due to integrated operations of the gas plant infrastructure, the decision was made to incorporate the ammonia strippers into the broader by-products plant upgrade.

The tar sludge recycling project has been commissioned and has been rolled out to all batteries on site.

The last bi-annual, external, environmental performance audit was conducted in August 2018.

## B. Records of major incidents

Although extended downtime of the Elementary Sulphur Plant remains a concern, no major environmental incidents have occurred during the last quarter. Despite the Elementary Sulphur Plant not being operational, a significant sulphur emission reduction has still been achieved at the Works. Over the past 6 years, there has been a 22% reduction in total SO<sub>2</sub> emissions from the Works with a 74% reduction in flaring of un-cleaned gas with 2004 as baseline. Although problems have been experienced with operation of the Plant, Vanderbijlpark Works remains within compliance to SO<sub>2</sub> standards prescribed in the AEL for sources which utilise coke oven gas as a fuel for combustion processes. National Ambient Air Quality Standards for SO<sub>2</sub> are also not exceeded in the Priority Area in which Vanderbijlpark Works is located, based on the monitoring results obtained from the various stations in the area. The graph below illustrates recent monitoring results for SO<sub>2</sub> at the various locations in the Priority Area.



### **C. Decommissioning of infrastructure**

No further demolition work performed.

### **D. Rehabilitation and disposal of contaminated material**

All equipment, tanks, vessels, and pipes that contained process liquids were flushed into the existing By-products process. The steel scrap was recycled back into the steel making process.

As per condition 3.2 k) the use of the maturation ponds was to cease 6 months after the commissioning date. Although the use of the maturation ponds is directly related to the commissioning of the Coke Oven Clean Gas and Water project, with changes to the water balance of the Works, the maturation ponds' usage ceased in March 2008.

The Maturation Ponds Rehabilitation Plan has been submitted to, and approved by, the Department of Water Affairs and Forestry (DWAF). Application for environmental authorisation to decommission the Maturation Ponds, in terms of the 2010 EIA Regulations, was submitted to the authorities. The application was transferred from the provincial authority to the national authority as mandated by the Waste Act, which delayed the issuing of the authorisation. ArcelorMittal subsequently received the Waste Management License from DEA for the decommissioning and remediation of the Maturation Ponds on 13 February 2012.

### **E. Commissioning**

Commissioning of the Project was completed in January 2010. Concerted effort is being placed on actions associated with restitution and start-up of the Elementary Sulphur Plant after extended down-time. Overseas experts were sourced to identify the root cause of equipment failure experienced to date and provide feasible recommendations to resume operation of the Plant. Technical evaluations of the proposals were conducted to assess the feasibility of the various alternatives suggested in the specialist reports. Tender negotiations for the engineering and procurement component of the upgrade project are currently in process.

### **F. Results on the monitoring of efficiency of commissioned plants**

Results submitted to authorities.

### **G. Monitoring of construction activities in terms of the Environmental Management Plan (EMP)**

The Environmental Management Plan (EMP) was submitted and formed part of all the contractors' Site Safety Management Plans. ECO audits were conducted during the construction phase. An ECO audit, and follow-up inspections, was conducted during commissioning of the Project. The Gravel Filter Plant has been installed and has been commissioned. Regular inspections were undertaken to ensure that no breach of environmental regulations (legislation and authorisation) occur.

### **H. Steps taken to rectify areas of non-compliance with environmental requirements**

Regular RoD audits are scheduled to ensure outstanding issues are resolved and potential future non-compliances are avoided.

Shut-down of the sulphur plant is receiving all the necessary attention. Getting the Elementary Sulphur Plant operational remains a level 1 priority. To date, in excess of R20 million, over and above the initial investment of around R300 million, has been spent in an attempt to get the Sulphur Plant operational again. Significant CAPEX has recently been sourced to refurbish the gas cleaning plant.

Due to the complexity of the gas cleaning process, overseas experts in process engineering were recruited to identify shortcomings and recommend corrective actions for re-operation of the Sulphur Plant.

#### I. Feedback on implementation of specialist recommendations

RECOMMENDATION FROM SPECIALIST STUDIES	FEEDBACK
<b>Process</b>	
Balancing tanks to be installed prior to battery process water treatment facilities	Upgraded 4 x 1000 m <sup>3</sup> settling tanks prior to battery process water treatment. This will give sufficient buffer capacity to balance any process upsets in front of the treatment process – Completed
Monitor concentrations of cleaned COG and report.	Results reported in the first bi-annual report.
Monitor ambient levels of NH <sub>3</sub> , H <sub>2</sub> S and benzene, and take appropriate actions (as described in EIR) if found to be significant.	Results reported in the first bi-annual report.
The effluent stream sent to the Blast Furnaces should not be heated to the point where the NH <sub>3</sub> is stripped and released to atmosphere.	Investigation completed.
All tar sludge should be returned to the coke ovens with the coal charge, using mechanical means and not by hand.	The tar sludge recycling project has been commissioned to address this point.
All solid waste should be classified according to the Minimum Requirements and disposed of accordingly. Records should be maintained of all waste sent offsite.	Implementation completed.
Scheduled preventative maintenance plan on all water systems to ensure segregation of process water, rainwater and indirect cooling water streams.	PMP implemented for all environmentally critical equipment.
<b>Groundwater</b>	
The feasibility of abstracting contaminated groundwater from the aquifer underlying the site, as a source of water supply to the process should be investigated.	All known active sources from the area have been eliminated and since inception of remedial actions, around 2007, which formed part of the original groundwater management plan, significant progress has been made in this regard. As such, it was decided to remodel the groundwater dynamics for the entire site to assess the success of remedial actions undertaken in the past decade. This modelling will tie in with the greater contaminated land assessment for the Works, which will dictate possible contaminated land and groundwater initiatives going forward. The contaminated land assessment report and associated remediation plan was submitted to the Department of Environmental Affairs on the 7 <sup>th</sup> June 2018. Subsequent to this, the content of these documents was presented to the Department on the 27 <sup>th</sup> August 2018. A Remediation Order was issued to ArcelorMittal Vanderbijlpark Works on the 16 <sup>th</sup> November 2018 which prescribes groundwater remedial actions for the entire site.
The option of development of drains in the form of trenches to abstract the contaminated groundwater from the shallow perched aquifer system as part of the foundation design and groundwater containment/remediation options should be investigated.	Same as above.
The water in the cooling tower sumps should be sampled and analysed to determine the quality.	Done – results available
The existing monitoring boreholes should be properly capped to prevent contamination from	Upgrade of monitoring borehole network completed in 2010. Supplementary monitoring

RECOMMENDATION FROM SPECIALIST STUDIES	FEEDBACK
surface soils and dust with samples that are taken in the boreholes.	boreholes have been equipped with caps. Damaged boreholes throughout the site have been repaired to reinstate monitoring from these particular boreholes.
The construction of the monitoring boreholes should be reviewed to confirm whether the borehole construction material influences the values for iron and manganese in the groundwater in the Coke Ovens area.	Completed. Golder Associates Africa (Pty) Ltd conducted a study to assess the monitoring network.
The resident groundwater pollution should be managed.	Investigation underway. All known active sources from the area have been eliminated and since inception of remedial actions, around 2007, which formed part of the original groundwater management plan, significant progress has been made in this regard. As such, it was decided to remodel the groundwater dynamics for the entire site to assess the success of remedial actions undertaken in the past decade. This modelling will tie in with the greater contaminated land assessment for the Works, which will dictate possible contaminated land and groundwater initiatives going forward. The contaminated land assessment report and associated remediation plan was submitted to the Department of Environmental Affairs on the 7 <sup>th</sup> June 2018. Subsequent to this, the content of these documents was presented to the Department on the 27 <sup>th</sup> August 2018. A Remediation Order was issued to ArcelorMittal Vanderbijlpark Works on the 16 <sup>th</sup> November 2018 which prescribes groundwater remedial actions for the entire site.
A numerical groundwater flow and contaminant transport model should be developed.	Remodelling for entire site planned for 2018 – order placed.
<b>Surface water</b>	
The mitigating measures for the construction and operational phase, as proposed in the document, should be made binding on ArcelorMittal South Africa Vanderbijlpark Works, its employees and external contractors.	Noted.
A detailed Environmental Management Plan covering <i>inter alia</i> surface water management should be drafted and made binding on ArcelorMittal South Africa Vanderbijlpark Works.	EMP submitted to GDACE. EMP updated as per Air Quality Monitoring Plan recommendations and submitted to authorities for approval. EMP has been submitted on numerous occasions in the past for approval. However, to date, no correspondence has been received from authorities. The EMP was re-submitted once again in March 2012, as per recommendation in January 2012 external audit report, for approval. No feedback has been received, thus assuming the EMP has been approved (as stated in March letter). GDARD did however acknowledge receipt of the EMP on 23 April 2012.  As per recommendation from the July 2015 external audit report, the EMP was aligned with the requirements stipulated in the relevant EIA regulations (4 Dec 2014).
The existing Coke and Gas Cleaning Plant surface water-monitoring programme should continue.	Monitoring programme will continue as per the Water Use Licence.
The process and products associated with the recycling of surplus water from the Coking Plant to the Blast Furnace need to be further	Surplus water is to be re-used in the coke making process. Should the need arise to direct surplus water to the Blast Furnaces, these items

RECOMMENDATION FROM SPECIALIST STUDIES	FEEDBACK
investigated, in order to determine any potential negative impacts.	will be investigated.
<b>Air Quality</b>	
Install an additional PM10 and gaseous sampler (SO <sub>2</sub> , NO <sub>x</sub> and H <sub>2</sub> S) within the zone of impact directly south of the MSVS site to monitor the impact on the surrounding communities.	Completed. Two ambient air monitoring stations were installed south and south-east of ArcelorMittal Vanderbijlpark Works during 2004. The third monitoring station at the northern boundary of the site was installed in 2007.
The monitoring of H <sub>2</sub> S should act as a performance indicator to monitor the reductions in ambient H <sub>2</sub> S concentrations.	Results reported in the first bi-annual report.  It must be noted that it is expected to have a reduction of SO <sub>2</sub> rather than H <sub>2</sub> S. This is because the H <sub>2</sub> S contained in the gas used as a fuel at the Works will be transformed to SO <sub>2</sub> emissions when burned.
The emission rates of the most significant pollutants need to be measured.	Results reported in the first bi-annual report.
<b>Recommendations from Air Quality Monitoring Plan</b>	
Monitoring of fugitive emissions from Batteries i.t.o. EPA Method 303. Accreditation of in-house training to be investigated subsequent to the Department of Environmental Affairs (DEA's) finalization of an emission monitoring accreditation scheme.	Investigate training accreditation subsequent to finalization of DEA's emission monitoring accreditation scheme.
Measurement of volatiles in accordance with OHS Act to continue.	Occupational Hygiene Department to ensure that these measurements are conducted.
Measurement of H <sub>2</sub> S before and after gas cleaning to be conducted on a quarterly basis to verify conformance to RoD Condition 3.2(g).	Currently conducted on an ad-hoc basis due to the sulphur plant being on shut-down. Regular monitoring has been arranged when Plant is operational.
Weekly analysis of quench water quality for comparison with future Minimum Emission Standards	Samples analysed on a weekly basis.

## J. RoD compliance table summary

RoD Cond. #	Requirement	Status	Comply	Partial	Non-compliance	Comments	Action Plan
3.2 (a)	Updated project schedule with time-frames 30 calendar days prior to construction begins	Completed	X				
(b)	Inform about start of construction and commissioning	Completed	X				
(c)	Environmental Management Plan	Completed	X			Operational EMP submitted to authorities once again in March 2012 for approval. No feedback received, hence assuming approval as stated in cover letter. GDARD did however acknowledge receipt of the EMP on 23 April 2012.	
(d)	Hazop study	Completed	X				
(e)	Preventative Maintenance Plan	Completed	X			Amendment Application concerning external verification of PMP, dated 29 July 2009, was submitted on 7 Aug 2009	Condition amended. Compliance now possible
(f)	Final design plans for new and upgraded containment areas	Completed	X			Design plans re-submitted to DWA for approval	
(g)	Air quality management, monitoring and reporting	Completed	X			Air Quality Management Plan developed by air quality specialist. Results to be reported in Bi-annual Environmental Performance Audits	
(h)	Flaring of un-cleaned gas at Flare 5	Completed			X	Sulphur Plant shutdown extended due to issues mentioned above	Expedite order placement for refurbishment and start-up of Sulphur Plant
(i)	Records of incidents	Ongoing	X			Incidents are registered in the Work's internal reporting system and/or noted in ECO reports/incident register	

<b>RoD Cond. #</b>	<b>Requirement</b>	<b>Status</b>	<b>Comply</b>	<b>Partial</b>	<b>Non- compliance</b>	<b>Comments</b>	<b>Action Plan</b>
(j)	Inform about major incidents	Ongoing	X			No major or emergency incidents to date	
(k)	Use of maturation dams to cease 6 months after commissioning	Completed ahead of schedule.	X			Application for Environmental Authorisation for decommissioning and remediation of dams submitted. Waste Management License for decommissioning and remediation of dams received on 13 Feb 2012.	
(l)	Groundwater contamination plans	Continuing	X			All known active sources from the area have been eliminated and since inception of remedial actions, around 2007, which formed part of the original groundwater management plan, significant progress has been made in this regard. As such, it was decided to remodel the groundwater dynamics for the entire site to assess the success of remedial actions undertaken in the past decade. This modelling will tie in with the greater contaminated land assessment for the Works, which will dictate possible contaminated land and groundwater initiatives going forward. The contaminated land assessment report and associated remediation plan was submitted to the Department of	

RoD Cond. #	Requirement	Status	Comply	Partial	Non-compliance	Comments	Action Plan
						Environmental Affairs on the 7 <sup>th</sup> June 2018. Subsequent to this, the content of these documents was presented to the Department on the 27 <sup>th</sup> August 2018. A Remediation Order was issued to ArcelorMittal Vanderbijlpark Works on the 16 <sup>th</sup> November 2018 which prescribes groundwater remedial actions for the entire site.	
(m)	Recommendations from specialist studies		X			See table above	
(n)	Independent Environmental Control Officer during construction and commissioning		X			ECO appointed	
<b>Reporting requirements</b>							
3.4 (a)	Quarterly Progress Report		X				
(b)	Bi-annual Environmental Performance Audit		X				



## **K. CONCLUSIONS**

Quarterly progress reporting will continue in terms of Condition 3.4(a). However, as per letter from the authority, dated 8 February 2010, these progress reports are only required to be submitted upon request by GDARD. The first external audit report was submitted in July 2010, with subsequent reports submitted bi-annually.

---END---

## **APPENDIX F: UPDATED WORKS WATER BALANCE**

MAIN INDEX

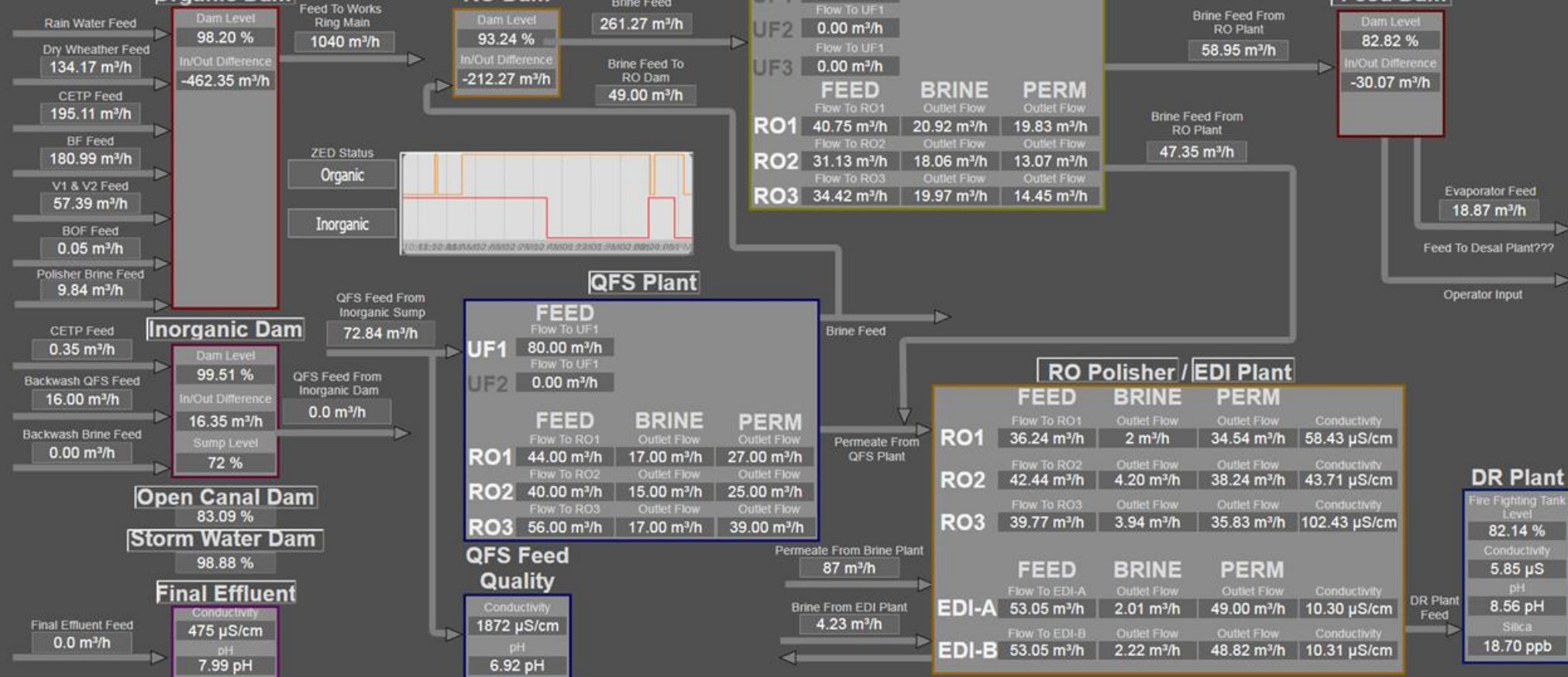
## MTP - ZED

## RO/UF Brine Plant

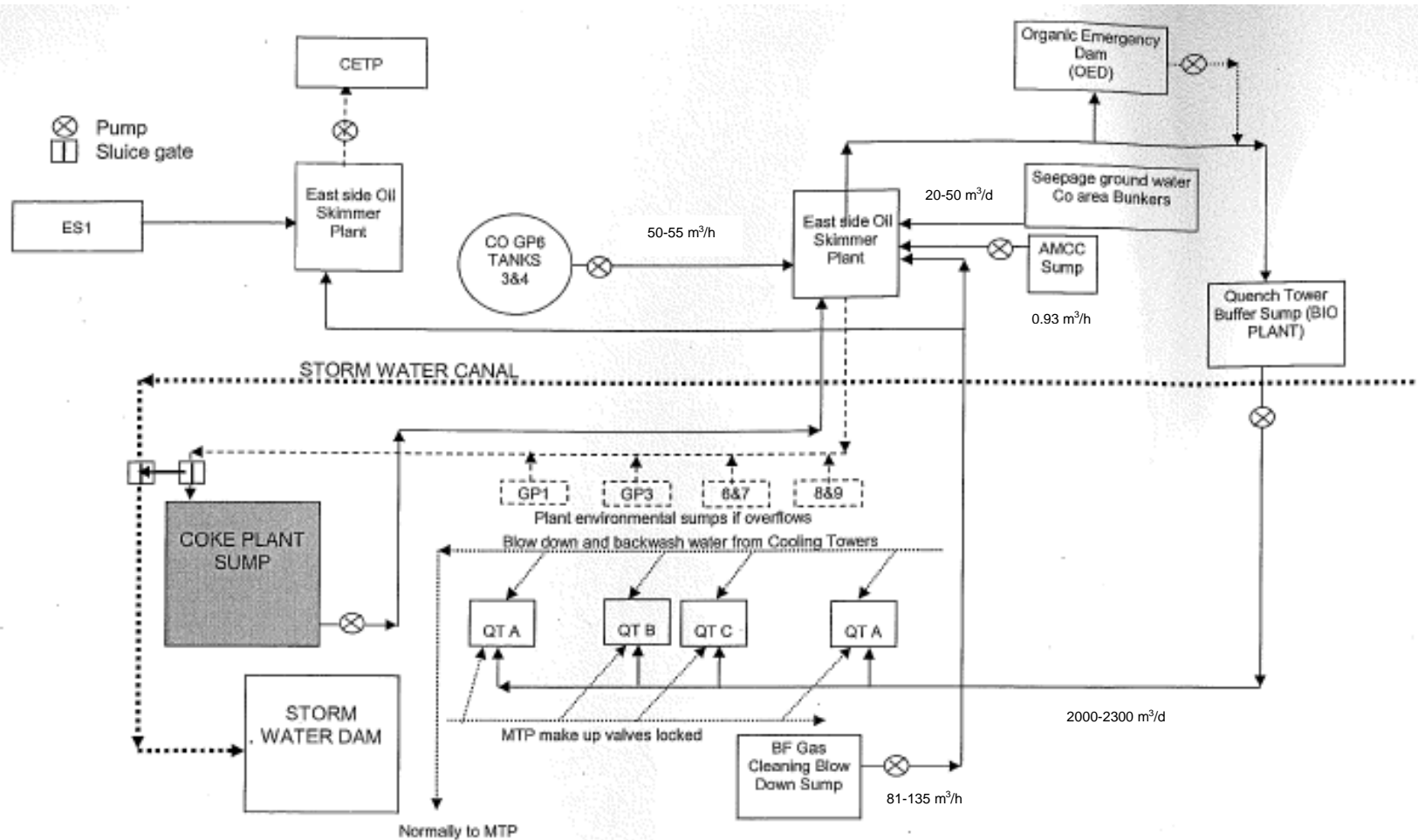
## Organic Dam

## RO Dam

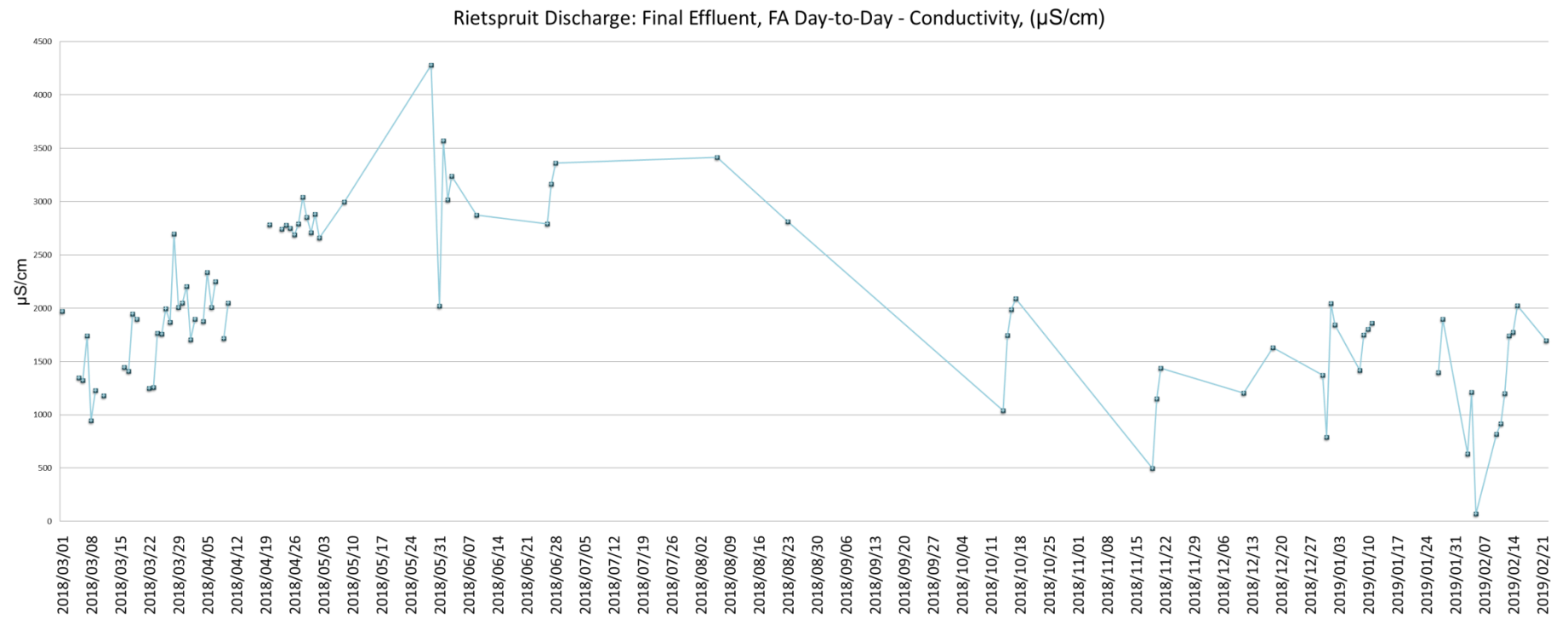
## Evaporator Feed Dam



## **APPENDIX G: COKE PLANT WATER BALANCE**

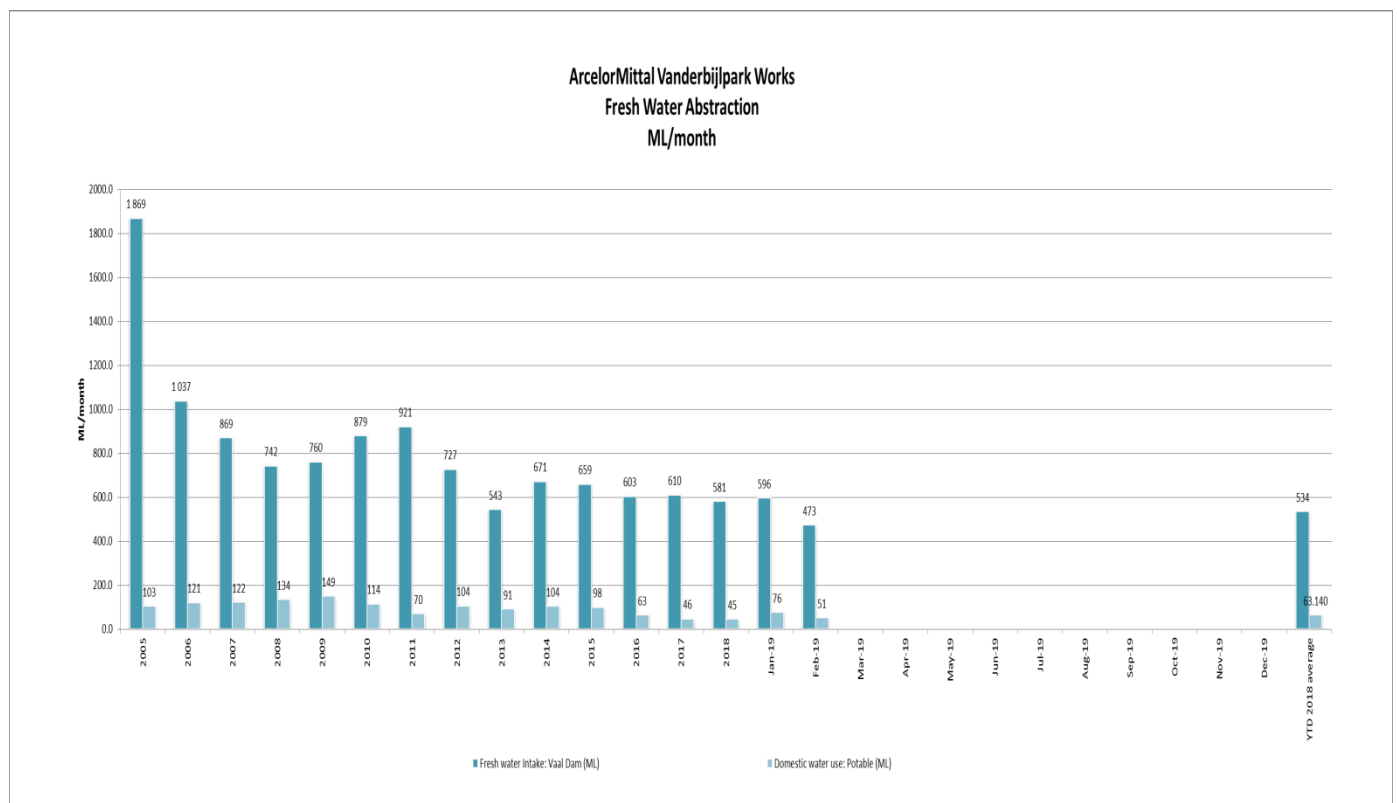
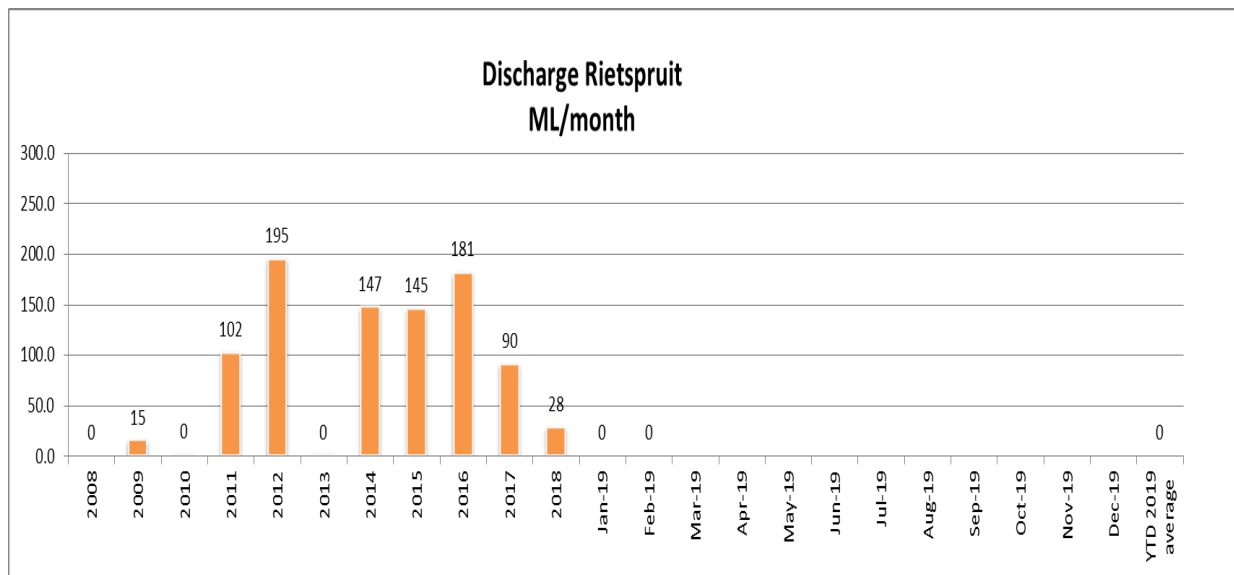


## **APPENDIX H: DISCHARGE VOLUMES**



## **APPENDIX I: ABSTRACTION VOLUMES**





## **APPENDIX J: COKE PLANT AIR QUALITY MONITORING PLAN**

***Project done on behalf of***

***ArcelorMittal South Africa***

***Vanderbijlpark Works***

**AIR QUALITY MONITORING PLAN FOR THE  
ARCELOR MITTAL VANDERBIJLPARK  
COKE OVENS**

**Report No.: APP/10/AMSA-01 Rev1.1**

***JANUARY 2011***

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## REPORT DETAILS

<b>Reference</b>	APP/10/AMSA-01
<b>Status</b>	Revision 1.1
<b>Report Title</b>	Air Quality Monitoring Plan for the ArcelorMittal Vanderbijlpark Coke Ovens
<b>Date Submitted</b>	January 2011
<b>Client</b>	ArcelorMittal South Africa(Pty) Ltd
<b>Prepared by</b>	Gerrit Kornelius Pr Eng BEng (Hons) MBA PhD (Chemical Engineering) (University of Pretoria)
<b>Notice</b>	Airshed Planning Professionals (Pty) Ltd is a consulting company located in Midrand, South Africa, specialising in all aspects of air quality, ranging from nearby neighborhood concerns to regional air pollution impacts. The company originated in 1990 as Environmental Management Services, which amalgamated with its sister company, Matrix Environmental Consultants, in 2003.
<b>Declaration</b>	Airshed is an independent consulting firm with no interest in the project other than to fulfil the contract between the client and the consultant for delivery of specialised services as stipulated in the terms of reference.
<b>Copyright Warning</b>	Unless otherwise noted the copyright in all text and other matter (including the manner of presentation) is the exclusive property of Airshed Planning Professionals (Pty) Ltd. It is a criminal offence to reproduce and/or use, without written consent, any matter, technical procedure and/or technique contained in this document
<b>Acknowledgements</b>	Mr Terence Wilson rendered valuable assistance in gathering and providing data.

## REVISION HISTORY

Revision no	Date	Detail
Rev 0	25 October 2010	Original
Rev 1	15 December 2010	Client comments processed
Rev 1.1	3 January 2011	Editorial corrections

Air quality monitoring plan for the ArcelorMittal Vanderbijlpark coke ovens	
Report no APP/10/AMSA-01 rev 1	p2

## Table of contents

<b>1. Background .....</b>	<b>4</b>
<b>2. Legal Requirements, Standards and Guidelines .....</b>	<b>5</b>
2.1 Legal requirements according to the Air Quality Act No.39 of 2004 .....	5
2.1.1 Ambient air quality standards .....	6
2.1.2 Workplace standards .....	7
2.1.3 Emission standards .....	7
2.1.4 Specific monitoring requirements .....	8
<b>3 Conformance with RoD conditions.....</b>	<b>10</b>
3.1 Composition of cleaned coke oven gas and flue gas (after combustion) .....	10
3.2 Ambient measurements .....	10
3.2.1 “Fenceline” background measurements.....	10
3.2.2 In-plant measurements .....	14
3.3 Conclusions from monitoring programme .....	16
3.3.1 Gas plant performance. ....	16
3.3.2 Flue gas composition. ....	16
3.3.3 “Fenceline” ambient monitoring results .....	16
3.3.4 “In-plant” measurements.....	17
3.3.5 Other RoD requirements.....	<b>Error! Bookmark not defined.</b>
<b>4 Recommendations .....</b>	<b>18</b>
4.1 “Fenceline” ambient monitoring. ....	18
4.2 In-plant atmospheric monitoring .....	18
4.3 Process monitoring .....	18
<b>5.References.....</b>	<b>20</b>

## 1. BACKGROUND

ArcelorMittal South Africa Vanderbijlpark Works has undertaken a project for the cleaning of coke oven gas and water at their Vanderbijlpark works. From an air quality point of view, the project entailed:

- Improvement of naphthalene recovery by improved gas cooling.
- The improvement of ammonia recovery by upgrading of scrubbers, the conversion of benzene scrubbers to ammonia scrubbers and the provision of a closed loop circulation system.
- The installation of two new distillation columns for the treatment of ammonia scrubbing water and one stripping/de-acidification column for the generation of scrubbing medium for hydrogen sulphide removal.
- Modification of existing ammonia scrubbers and the installation of a new hydrogen sulphide stripper.
- The conversion of hydrogen sulphide to elemental sulphur and the decommissioning of the ammonium sulphate plant.

A record of decision (RoD) was received from the Gauteng Department of Agriculture, Conservation and Environment (GDACE, now the Gauteng Department of Agriculture and Rural Development GDARD) on 21 March 2004.

Airshed Planning Professionals (Pty) Ltd ("APP") was commissioned by ArcelorMittal South Africa Vanderbijlpark Works to develop an air quality monitoring plan to meet the requirements set by GDACE/GDARD in the RoD.

### 1.1 Study Approach and Methods

A summary of the values obtained by ArcelorMittal South Africa Vanderbijlpark Works as a result of the measurement programme to meet RoD requirements is presented. These are compared to legal requirements for ambient air quality and stack emissions.

Based on the comparison, recommendations are made regarding a future monitoring programme/protocol for the coke ovens and associated gas cleaning plant.

## 2. LEGAL REQUIREMENTS, STANDARDS AND GUIDELINES

Prior to assessing the requirements for monitoring of the gas plant upgrade at the Vanderbijlpark site, reference needs be made to the environmental regulations and guidelines governing the emissions and impact of such operations.

Air quality guidelines and standards are fundamental to effective air quality management, providing the link between the source of atmospheric emissions and the user of that air at the downstream receptor site. The ambient air quality guideline values indicate safe daily exposure levels for the majority of the population, including the very young and the elderly, throughout an individual's lifetime. Air quality guidelines and standards are normally given for specific averaging periods. These averaging periods refer to the time-span over which the air concentration of the pollutant was monitored at a location. Generally, five averaging periods are applicable, namely an instantaneous peak, 1-hour average, 24-hour average, 1-month average, and annual average. The application of these standards varies, with some countries allowing a certain number of exceedances of each of the standards per year.

### 2.1 Legal requirements according to the Air Quality Act No.39 of 2004

Under the (now defunct) Atmospheric Pollution Prevention Act (Act No 45 of 1965) (APPA) the focus was mainly on sourced based control with Registration Certificates issued for Scheduled Processes. Scheduled processes, referred to in the Act, are processes which emit more than a defined quantity of pollutants per year, including combustion sources and smelting. Best Practicable Means (BPM), on which the Registration Certificate requirements are based, represents an attempt to restrict emissions while having regard to local conditions, the prevailing extent of technical knowledge, the available control options, and the cost of abatement. The Department of Environmental Affairs and Tourism (DEAT) was responsible for the administration of this Act with the implementation thereof charged to the Chief Air Pollution Control Officer (CAPCO).

Although emission limits and ambient concentration guidelines were published by DEAT, no provision was made under the APPA to publish formal ambient air quality standards or emission standards. The decision as to what constitutes the best practicable means for each individual case was reached following discussions with the industry. A registration certificate, containing maximum emission limits specific to the industry, was then issued.

The APPA was outdated and not in line with international best practice. It also proved inadequate to facilitate the implementation of the principles underpinning the National Environmental Management Act (NEMA) and the Integrated Pollution and Waste Management (IP&WM) white paper. In this light, the National Environmental Management: Air Quality Act (Act no. 39 of 2004) was drafted, shifting the approach from source based control to decentralised air quality management through an effects-based approach.

The new National Environmental Management: Air Quality Act has shifted the approach of air quality management from source-based control only to the reduction of impact on the receiving environment. The Act has also placed the responsibility of air quality management on the local authorities (district and metropolitan municipalities) who will be tasked with baseline characterisation, management and operation of ambient monitoring networks, licensing of listed activities, and emissions reduction strategies. The main objective of the act is to ensure the protection of the environment and human

health through reasonable measures of air pollution control within the sustainable (economic, social and ecological) development framework.

### 2.1.1 Ambient air quality standards

The Air Quality Act (AQA) makes provision for the setting of ambient air quality standards and emission limits at national level, which provides the objective for air quality management. More stringent ambient standards may be implemented by provincial and metropolitan authorities. National ambient standards were published on 24 Dec 2009 (GG 32816) as per table 2-1 below.

**Table 2-1: National Ambient Air Quality Standards**

Averaging Period	Concentration	Allowed Frequency of	Compliance Date
<b>Sulphur Dioxide (SO<sub>2</sub>)</b>			
10 minutes	500µg/m <sup>3</sup> (191ppb)	526	Immediate
1 hour	350µg/m <sup>3</sup> (134ppb)	88	Immediate
24 hours	125µg/m <sup>3</sup> (48ppb)	4	Immediate
1 year	50µg/m <sup>3</sup> (19ppb)	0	Immediate
<b>Nitrogen Dioxide (NO<sub>2</sub>)</b>			
1 hour	200µg/m <sup>3</sup> (106ppb)	88	Immediate
1 year	40µg/m <sup>3</sup> (21ppb)	0	Immediate
<b>Particulate Matter (PM<sub>10</sub>)</b>			
24 hours	120µg/m <sup>3</sup>	4	Immediate- End 2014
24 hours	75µg/m <sup>3</sup>	4	1 January 2015
1 year	50µg/m <sup>3</sup>	0	Immediate-End 2014
1 year	40µg/m <sup>3</sup>	0	1 January 2015
<b>Ozone (O<sub>3</sub>)</b>			
8 hours (running)	120µg/m <sup>3</sup> (61ppb)	11	Immediate
<b>Benzene (C<sub>6</sub>H<sub>6</sub>)</b>			
1 year	10µg/m <sup>3</sup> (3.2ppb)	0	Immediate-end 2014
1 year	5µg/m <sup>3</sup> (1.6ppb)	0	1 January 2015
<b>Lead (Pb)</b>			
1 year	0.5µg/m <sup>3</sup>	0	Immediate
<b>Carbon Monoxide (CO)</b>			
1 hour	30mg/m <sup>3</sup> (26ppm)	88	Immediate
8 hour (calculated from 1	10 mg/m <sup>3</sup> (8.7ppm)	11	Immediate
Air quality monitoring plan for the ArcelorMittal Vanderbijlpark coke ovens			
Report no APP/10/AMSA-01 rev 1		p6	



### 2.1.2 Workplace standards

Some workplace measurements were carried out by ArcelorMittal South Africa (Pty) Ltd during June 2010. For the organic compounds measured, the relevant SA workplace standards (Government notice R 1179 of 25 August 1995) are as follows:

**Table 2-2: Occupational exposure concentrations (mg/m<sup>3</sup>)**

Benzene	16
Naphthalene	50
Phenols	19
Cresols	22
Coal tar pitch volatiles (not measured)	0.14
Hydrogen sulphide	14

### 2.1.3 Emission standards

Listed activities were identified by the Minister and include all activities regarded to have a significant detrimental effect on the environment, including health. Emission limits are established at national level for each of these activities (GG 33064 of 31 March 2010) and an atmospheric emission licence will be required in order to operate. With the decentralisation of power to provincial and local authority level, district and metropolitan municipalities will be responsible for the issuing of licences for listed activities. An air quality officer appointed by local authorities and responsible for the issuing of atmospheric emission licences may require a company or person to submit atmospheric impact reports in order to determine the impact of the proposed emissions on ambient air quality.

Emissions from the coke ovens and by-products recovery units are covered by subcategories 3.1 (Combustion installations not used primarily for steam raising or electricity generation) and subcategory 3.2 (Coke production and coal gasification) of the abovementioned regulations as per tables 2.3 and 2.4 below. For plants operating at the date of the notice, these requirements become applicable on 1 April 2015.

**Table 2.3: Subcategory 3.1: Combustion installations**

<b>Description:</b>		Combustion installations not used primarily for steam raising or electricity generation.	
<b>Application:</b>		All combustion installations (except test or experimental).	
Substance or mixture of substances		Plant status	mg/Nm <sup>3</sup> under standard conditions of 10% O <sub>2</sub> , 273 Kelvin and 101.3 kPa.
Common Name	Chemical Symbol		
Particulate matter	Not applicable	New	50
		Existing	100
Oxides of nitrogen	NO <sub>x</sub> expressed as NO <sub>2</sub>	New	700
		Existing	2000
Total volatile organic	Not applicable	New	40

Air quality monitoring plan for the ArcelorMittal Vanderbijlpark coke ovens	
Report no APP/10/AMSA-01 rev 1	p7

compounds (from non-coke oven operations)		Existing	90
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(a) The following special arrangements shall apply

(i) Sulphur-containing compounds to be recovered from gases to be used for combustion with a recovery efficiency of not less than 90% or remaining content of sulphur-containing compounds to be less than 100 mg/Nm<sup>3</sup> measured as hydrogen sulphide, whichever is strictest.

**Table 2.4: Subcategory 3.2: Coke production and coal gasification**

<b>Description:</b>	Coke production, coal gasification and by-product recovery from these operations.		
<b>Application:</b>	All installations.		
Substance or mixture of substances		Plant status	mg/Nm <sup>3</sup> under standard conditions of 10% O <sub>2</sub> , 273 Kelvin and 101.3 kPa.
Common Name	Chemical Symbol		
Hydrogen sulphide	H <sub>2</sub> S	New	7 <sup>(i)</sup>
		Existing	10 <sup>(i)</sup>

(a) The following special arrangements shall apply

(i) Charging must be carried out "on the main" with additional draught in the ascension or riser pipes produced by high-pressure water jets in the goosenecks. Even coal feeding must be ensured using screw feeders or rotary valve feeders. Telescopic seals are to be used around the charging holes. Visible emissions are limited to 12 sec per charge

(ii) For pushing, evacuation from the coke guide and the quench car using stationary ducting and gas cleaning or any other technology yielding the equivalent or better results is required.

(iii) For quenching, the quench tower must have suitable baffles; quench water must have less than 50 mg/liter suspended solids and no floating oil.

(iv) A battery and door frame maintenance system approved by the licensing authority must be operated. No more than 4% of doors may show visible leaks; no more than 2.5% of gas off-take pipes may show visible leaks.

(v) Measurement/ inspection procedures for visible leaks from doors, standpipes and from charging shall be carried out weekly for each battery using method EPA 303 from table 1 and records submitted to the licensing authority on a quarterly basis.

(b) The licensing authority may set alternative standards and/or control measures for the reduction of hydrogen sulphide emissions.

#### **2.1.4 Specific monitoring requirements**

In addition, the RoD sets certain air quality-related monitoring and reporting requirements that are specific to this project (section 3.2 (g) of the RoD). The introductory paragraph implies that, where stack sampling from the battery combustion stacks is required, representative measurement on a single stack will be accepted provided a motivation is included indicating why that stack should be regarded as representative. The specific requirements are:

- Bi-annual measurements of the composition of cleaned coke oven gas before and after combustion in batteries. This is taken to mean the composition of the coke oven gas after cleaning and the composition of the combustion off-gas.

Air quality monitoring plan for the ArcelorMittal Vanderbijlpark coke ovens	
Report no APP/10/AMSA-01 rev 1	p8

- Dioxin and furan content of the coke oven stack gas; this is required once only within six months of the decommissioning of the benzole plant.
- Proof must be provided, in the form of personal monitor results and other representative measurements that the door maintenance plan and fugitive emission reduction plan is yielding results.
- Assumptions on the impact of the emissions on ambient air quality made in the specialist air quality report produced during the EIA (Liebenberg-Enslin *et al* 2003) must be confirmed by ambient measurements. The specialist report recommended the installation of additional monitors for particulate matter less than 10 µm diameter (PM<sub>10</sub>), hydrogen sulphide (H<sub>2</sub>S), sulphur dioxide (SO<sub>2</sub>) and the combined oxides of nitrogen (NO<sub>x</sub>) to the south of the ArcelorMittal site. Results of the measurement must be included in the bi-annual audit report.
- Once-off measurements for the concentration of the following must be included in the first bi-annual report, with remediation proposals should the values prove to be excessive:
  - Ammonia and hydrogen sulphide from the tar decanters, liquid sumps and storage tanks.
  - Benzene at the flushing liquor storage tanks
  - Sampling of cooling tower air/vapour and a prediction of the impact of emissions to atmosphere due to its composition to be included in the first bi-annual audit report together with mitigation measures if the impact is found/estimated to be excessive.
  - Composition of flared coke oven gas and the temperature of the flare to be reported
  - Based on the correspondence between the results predicted in the specialist report and those actually measured (emission and ambient monitoring), consultants are to be appointed to propose a future emission monitoring protocol. The present report is the result of this requirement.
- An independent Environmental Control Officer is to be appointed during construction and commissioning to monitor and report on compliance with the conditions set in the RoD.

### 3 CONFORMANCE WITH ROD CONDITIONS.

#### 3.1 Composition of cleaned coke oven gas and flue gas (after combustion)

Sampling was done on no 3 and 6 gas plants during June 2010. Results are given in table 3-1 below.

**Table 3-1: Results of gas plant performance measurement.** (3 samples, average  $\pm$  standard deviation)

	No 3 plant	No 6 plant
H <sub>2</sub> S inlet concentration	6173 $\pm$ 1996 mg/Nm <sup>3</sup>	2474 $\pm$ 384 mg/Nm <sup>3</sup>
H <sub>2</sub> S outlet concentration	960 $\pm$ 1211 mg/Nm <sup>3</sup>	226 $\pm$ 158 mg/Nm <sup>3</sup>
Efficiency based on averages	84.4%	90.8%

Tests for the pollutant content of the flue gas were carried out on 23 June 2010 on two batteries. Results are given in table 3-2 below.

**Table 3-2: Results of flue gas concentration measurements.** (3 samples, average  $\pm$  standard deviation)

	H <sub>2</sub> S (mg/Nm <sup>3</sup> )		NH <sub>3</sub> (mg/Nm <sup>3</sup> )		
No 4 stack	26.1 $\pm$ 12.4		Less than detection limit of 1.2		
No 9 stack	14.1 $\pm$ 9.2		Less than detection limit of 1.2		
Overall average	20.1 $\pm$ 11.8		Less than detection limit of 1.2		
	CO (ppm)	NO as NO <sub>2</sub> (ppm)	NO <sub>2</sub> (ppm)	NOx as NO <sub>2</sub> (ppm)	SO <sub>2</sub> (ppm)
No 4 stack	5404 $\pm$ 541	50 $\pm$ 4	20 $\pm$ 4	76 $\pm$ 8	0
No 9 stack	1072 $\pm$ 168	112 $\pm$ 6	15 $\pm$ 5	127 $\pm$ 7	0

#### 3.2 Ambient measurements

##### 3.2.1 "Fenceline" background measurements

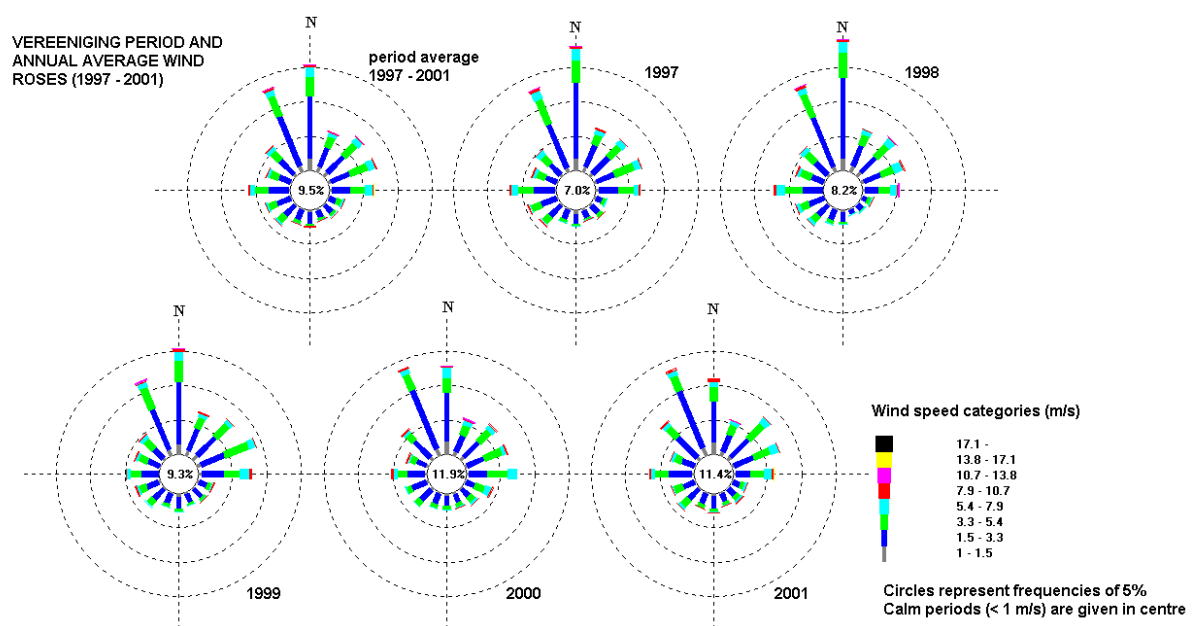
ArcelorMittal South Africa Vanderbilpark Works operates a number of real-time ambient monitoring stations located close to the fence line of the factory. The location of these monitoring stations is

Air quality monitoring plan for the ArcelorMittal Vanderbilpark coke ovens	
Report no APP/10/AMSA-01 rev 1	p10

given in figure 3-2 overleaf. In view of the prevailing wind directions in the area (see figure 3-1 below), the “south” and “east” stations are most likely to be affected by coke oven emissions. These will also be the stations at which impacts on the adjoining residential areas (Vanderbijlpark to the South and Boipatong to the East) are best reflected.

The results obtained at these stations for SO<sub>2</sub>, NO<sub>x</sub> and PM<sub>10</sub> are given in Table 3-3 overleaf. The “07/08” values are for the period 1 Jan 2007 to 31 Dec 2008, whereas the “09/10” values are for 1 Jan 09 to 30 Apr 2010. It should be noted that the Northern station was only installed during 2009.

**Figure 3-1: Wind direction frequency Vereeniging 1997-2001**



**Figure 3-2: Ambient monitoring locations.** (Image ArcelorMittal South Africa Vanderbijlpark Works)



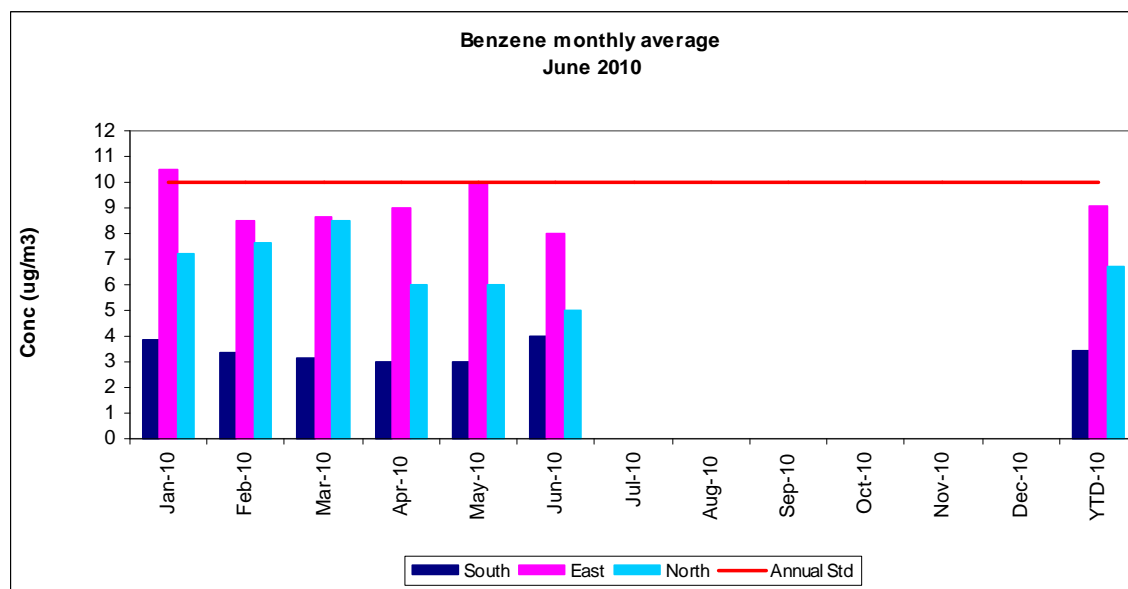
**Table 3-3: “Fence line” ambient monitoring results**

Component	Location and period	Concentration $\mu\text{g}/\text{m}^3$	Data availability %
NO <sub>x</sub>	E 09/10	20.7	84.8
	S 09/10	29.9	80.5
	W 09/10	8.0	29.4
	N 09/10	18.8	63.3
SO <sub>2</sub>	E 07/08	34.3	93.7
	E 09/10	22.5	88.1
	S 07/08	24.8	89.1
	S 09/10	45.2	87.2
	W 07/08	9.1	71.1
	W 09/10	8.8	46.2
	N 07/08	ND	
	N 09/10	21.4	61.9
PM <sub>10</sub>	E 07/08	82.3	86.9
	E 09/10	90.3	82.1
	S 07/08	75.4	85.9
	S 09/10	71.4	47.4
	W 07/08	45.1	61.4
	W 09/10	24.7	29.3
	N 07/08	ND	
	N 09/10	55.4	59



In addition, monthly average benzene values were measured at the above stations. The results for 2010 are given in figure 3-3 below.

**Figure 3-3: Monthly fence line benzene values.**



### 3.2.2 In-plant measurements

In addition to the fence line measurements for which the results are given above, ArcelorMittal South Africa Vanderbijlpark Works carried out a number of measurements in the plant area during June 2010. The results are provided in table 3-4 below.

**Table 3-4. Measurements carried out in the coke plant area.** ( $\mu\text{g}/\text{m}^3$ , value  $\pm$  standard deviation)

(ND = not determined, BDL = below detection limit)

Gas plant 3, 2 samples each	Ammonia ( $\text{NH}_3$ )	Benzene ( $\text{C}_6\text{H}_6$ )	Hydrogen sulphide ( $\text{H}_2\text{S}$ )
Background	$322 \pm 52$	$918 \pm 353$	$392 \pm 144$
Tar decanter	$809 \pm 394$	$5976 \pm 7341$	$755 \pm 460$
Environmental sump	$487 \pm 561$	$2373 \pm 2929$	$181 \pm 78$
Sump	$695 \pm 118$	$382 \pm 252$	$513 \pm 250$
Gas plant 6, single samples			
Control	202	292	553



	Ammonia (NH <sub>3</sub> )	Benzene (C <sub>6</sub> H <sub>6</sub> )	Hydrogen sulphide (H <sub>2</sub> S)
Tar decanter	87	47	102
Environmental sump	807	950	689
Tar separator	1359	ND	199

Gas plant 3, single samples except as noted	Naphthalene	Acenaphtylene	Phenols	Cresols
Background	209.9 ave of 3	BDL	20.5 ave of 3	BDL
Cooling tower	BDL	BDL	9.6 ave of 3	BDL
Environmental tank	482.2	7.8	48.7	22.2
Submerged tank	255.1	1.1	90.1	24.0
Sump	94.0	BDL	7.7	1.0
Environmental sump	79.9	BDL	1.8	BDL
Tar decanter	1718.8	50.6	79.6	58.1
Gas plant 6, single samples				
Control	94.2	BDL	34.3	6.2
Cooling tower	BDL	BDL	BDL	BDL
Tar decanter	37.6	BDL	5.9	BDL
Gas plant 6, single samples				
Environmental sump	671.1	BDL	30.9	2.3
Tar separator	433.4	BDL	21.0	8.9

### 3.3 Conclusions from monitoring programme

#### 3.3.1 Gas plant performance.

The gas plants meet the RoD requirements in the sense that the clean gas concentration values are below  $1.5 \text{ g/Nm}^3$ . Based on the averages of the inlet and outlet compositions, only plant 6 meets the requirements set in the regulation on Minimum Emission Standards (90% removal efficiency or less than  $1000 \text{ mg/Nm}^3 \text{ H}_2\text{S}$  in the outlet, whichever is strictest), but these requirements only become mandatory 5 years after publication of the regulation, i.e 1 April 2015.

#### 3.3.2 Flue gas composition.

Measurements meet the requirement for  $\text{NO}_x$  concentrations comfortably. Hydrogen sulphide concentrations exceed the future Minimum Emission Standards, but again these need to be met only from 1 April 2015. Attention is drawn to the large standard deviations from the small number of measurements.

#### 3.3.3 “Fence line” ambient monitoring results

- $\text{NO}_x$

None of the values measured in 2009/10 exceed the annual average SA ambient standard.

The annual average measured values for 2009/10 correspond remarkably well with the corresponding values for “Coke ovens and other Iscor sources” in the 2003 report. The exception is the “North” station, where the predicted value is slightly less than  $10 \text{ } \mu\text{g/m}^3$  against the measured value of  $18.8 \text{ } \mu\text{g/m}^3$ . This may be due to the impact of domestic fuel use in the residential areas to the north of the plant area, which due to the low level of emission sources and the prevailing wind direction may impact directly on the “North” station.

- $\text{SO}_2$

None of the values measured in 2007/8 or 2009/10 exceed the annual average SA ambient standard. There is no clear trend over time, as the “East” values have declined from 2007/8 to 2009/10 while the “North” values increased considerably over the same period. Values are generally slightly higher than those predicted due to “Coke plant and other Iscor sources” in 2003, with considerably higher values than the predicted ones for the “North” station ( $21.4 \text{ } \mu\text{g/m}^3$  measured against less than  $10 \text{ } \mu\text{g/m}^3$  predicted). This is probably not due to under-prediction of the impact of the Iscor sources, but to the impact of low-level sources to the north of the plant as described above.

- PM<sub>10</sub>

Values for the “East” and “South” stations exceed or approach the SA annual average standard valid until the end of 2014, and considerably exceed the standard valid from 2015 onwards. There is no clear temporal trend, except for the “West” values declining by 55% between the two periods – data availability in the second period is however only 29%.

Values for the “North”, “East” and “West” stations are considerably higher than those predicted in 2003, with the “South” values being only slightly higher. This again indicates the impact of sources to the north and west of the plant, which for PM<sub>10</sub> may include, in addition to the domestic fuel sources mentioned earlier, vehicle movement on unpaved roads both on the site and in the residential areas to the north, burning of waste in the residential areas and farming activities.

- Benzene

Fence line values are marginally within the present South African annual average standard, but values to the east and north exceed the future SA annual average standard. An anomaly seems to exist in that “North” value is higher than the “South” values in spite of the prevailing winds being from the north to the south.

Values also exceed the predicted values by a considerable margin.

The above leads to the conclusion that a hitherto unidentified source of benzene, or a prevalent high background concentration, is present in the area. Alternatively or additionally, fugitive sources of benzene may be present which were not identified in the 2003 study, where only the batteries themselves were taken into account as benzene sources.

#### **3.3.4 “In-plant” measurements**

None of the measured values exceed the legal requirements under the OSH Act. It should however be taken into account that considerably more stringent standards have been adopted internationally, especially for benzene as a known human carcinogen.

## 4 RECOMMENDATIONS

### 4.1 “Fence line” ambient monitoring.

- ArcelorMittal South Africa Vanderbijlpark Works is to be commended for the useful data obtained from the fence line monitors in terms of community impact and it is recommended that the programme (including determination of benzene levels) be continued.
- It is however clear from even a rudimentary analysis of the data that this programme alone cannot provide confirmation of the success or otherwise of door maintenance and/or other fugitive dust management programmes in the coke oven area.

### 4.2 In-plant atmospheric monitoring

- It is therefore recommended that visible leaks from doors, standpipes and charging operations be monitored. Method EPA 303, which is the prescribed method in terms of the Minimum Emission Standards regulation, provides guidance on the protocol (including observation frequency), and in-house training has been carried out by ArcelorMittal South Africa Vanderbijlpark Works. Method 303 prescribes EPA-conducted training, which is obviously not applicable to the local situation. The Department of Environmental Affairs has informally indicated that an accreditation scheme for emission monitoring is being investigated. It is proposed that ArcelorMittal South Africa Vanderbijlpark Works communicate with DEA in this regard, and considers accreditation of the in-house training when these accreditation requirements have been finalised. The results of the method 303 observations will be supported by a trend analysis of the personal monitoring in the coke battery and gas plant area in terms of the OHS Act.
- The required once-off measurements for the concentrations of benzene, ammonia and hydrogen sulphide have shown conformance to legal (in-plant or occupational exposure) limits and it is submitted that repeating these measurements is not necessary.
- Continued regular measurements of these compounds (and coal tar pitch volatiles (CTPV)) for purposes of employee exposure need to be continued as part of the industrial hygiene monitoring programme required by the OSH Act and incidentally, by the analysis of temporal trends, to monitor the management of the fugitive emissions programme.

### 4.3 Process monitoring

- In view of the wide margin by which the present measurements meet the requirements of the Minimum Emission Standards regulation for these pollutants, annual measurement of the

Air quality monitoring plan for the ArcelorMittal Vanderbijlpark coke ovens	
Report no APP/10/AMSA-01 rev 1	p18

PM<sub>10</sub>, NO<sub>x</sub> and SO<sub>2</sub> emissions from a representative stack per battery stacks under representative operating conditions should be sufficient.

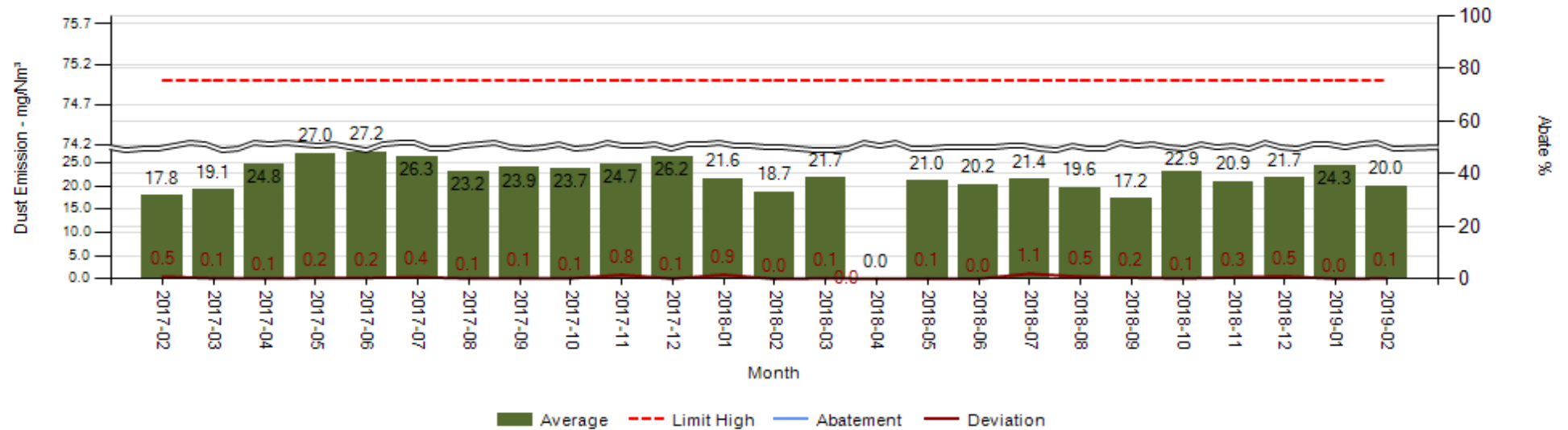
- It will however be noted from the standard deviation that large variations occurred during the measurements of hydrogen sulphide at the gas plant inlet and outlet and with the small number of analyses no final conclusion can be made. It is clear from the high standard deviations of the measurements that either the composition or the measurement method has a high variability. In view of the fact that the plant does potentially not meet the legal requirements applicable from April 2015, these measurements initially need to be repeated at a higher frequency than that specified in the RoD (bi-annually) until the issues of both the measurement variability and the plant performance have been satisfactorily settled and a valid statistical analysis is possible. It is proposed that this be done on a project basis as soon as resources can be made available. Either EPA method 11 (sampling/iodometric).or method 15 (sampling/gas chromatography) could be used.
- Once-off measurement of dioxin and furan in a representative battery stack were done in 2005. Results are low compared to emission standards for other incineration plants and no further action seems to be indicated. .
- Monitoring of quench water quality (and comparison to the requirements of the Minimum Emission Standards regulation) as most probably intended by the RoD requirements should be carried out on a regular basis. As the analytical requirements are not stringent and can probably be met with present in-house facilities, weekly analysis is recommended.
- With regards to the requirement to measure the composition of flared treated gas and the temperature of the flare, it is recommended that an argument be submitted to the authorities that this is a superfluous requirement based on the following:
  - The composition of the flared treated gas is the same as measured under the first bullet in this sub-section, and resolution of the measurement requirements as proposed there will also resolve the question of the composition of the flared gas.
  - Although the fare temperature could be measured thermographically, the information would not add value as oxidation of hydrogen sulphide to sulphur dioxide occurs at quite low temperatures. For purpose of dispersion modelling, a sufficiently accurate estimate of flare temperature to determine its buoyancy can be made without measurement.

## 5.REFERENCES.

Liebenberg-Enslin, H *et al.* (2003): *Air quality assessment of the Iscor coke oven gas and water cleaning plant upgrade in Vanderbijlpark, with addendum dd 2 July 2003.* Airshed Planning Professionals (Pty) Ltd report number APP/03/SEF-01 Rev 3. Halfway House

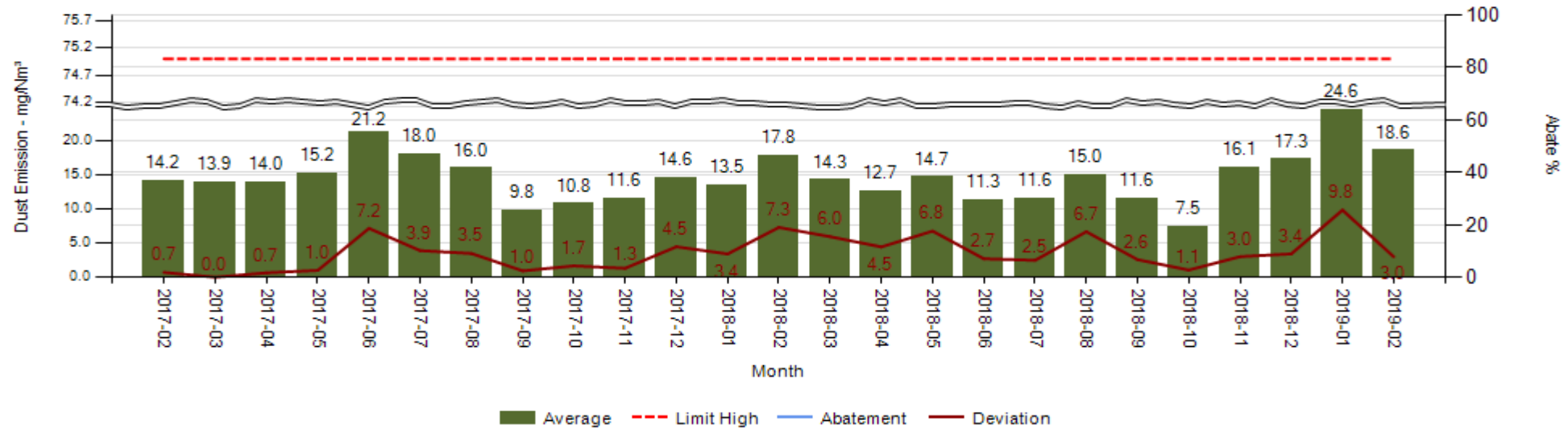
## **APPENDIX K: COKE BATTERY STACK DUST EMISSIONS**

Manual History - Coke Production - Battery 4



Coke Making | Coke Production | Battery 6 | Dust | mg/Nm³

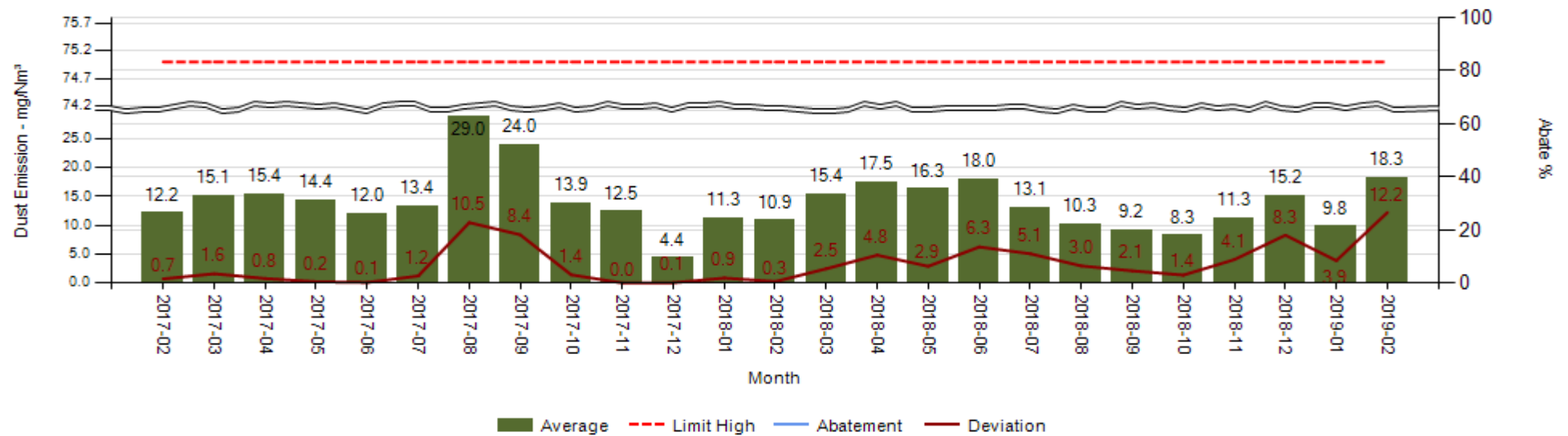
Manual History - Coke Production - Battery 6



Coke Making | Coke Production | Battery 7 | Dust | mg/Nm³

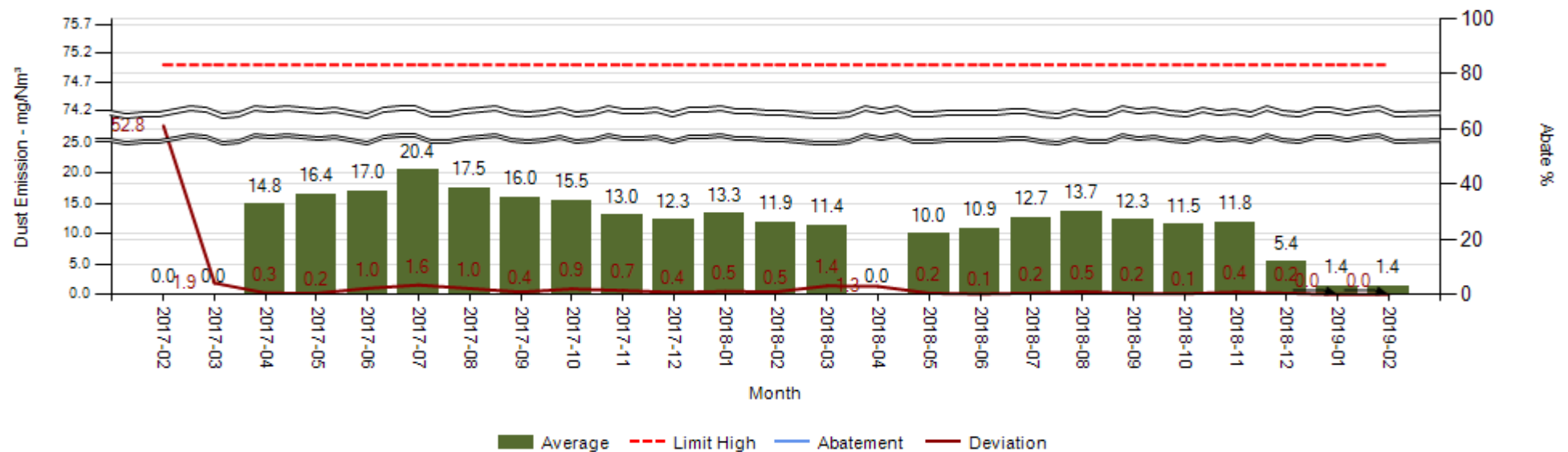


Manual History - Coke Production - Battery 7



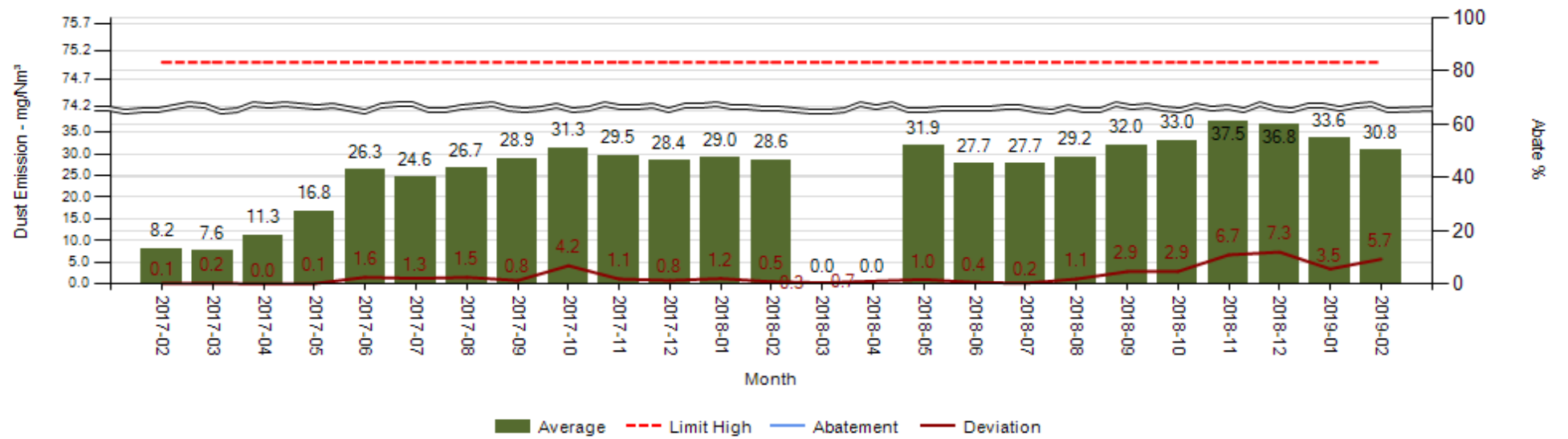
Coke Making	Coke Production	Battery 8	Dust	mg/Nm³
-------------	-----------------	-----------	------	--------

Manual History - Coke Production - Battery 8

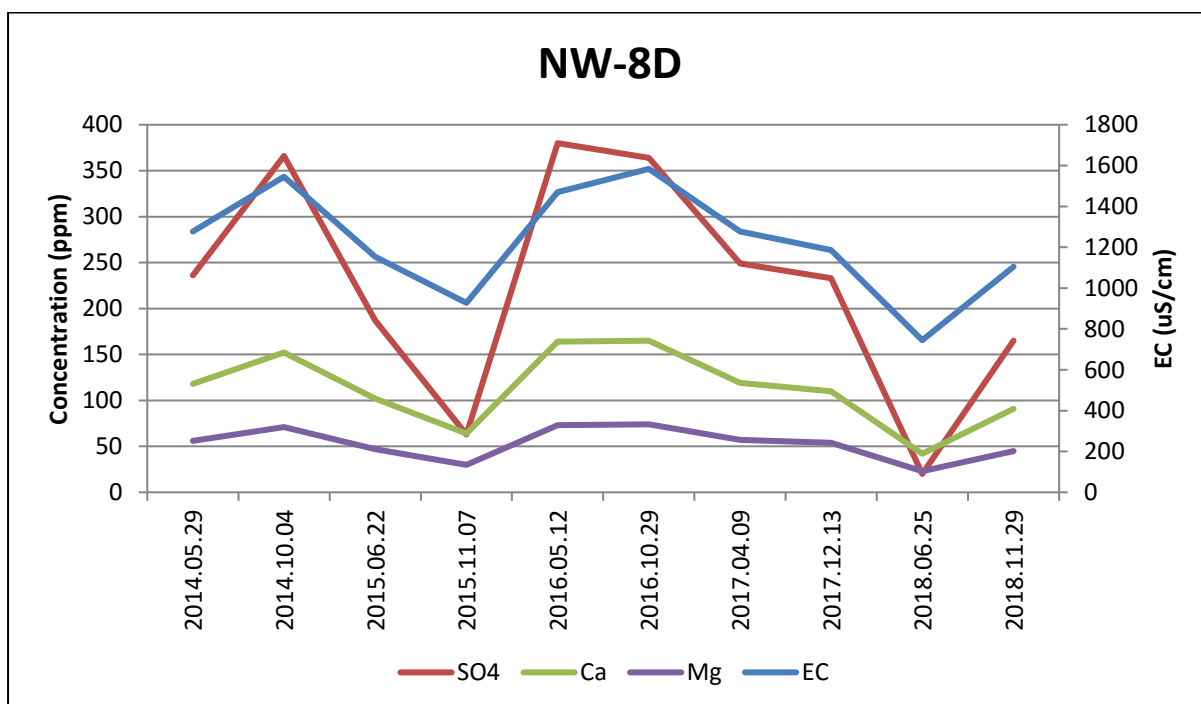
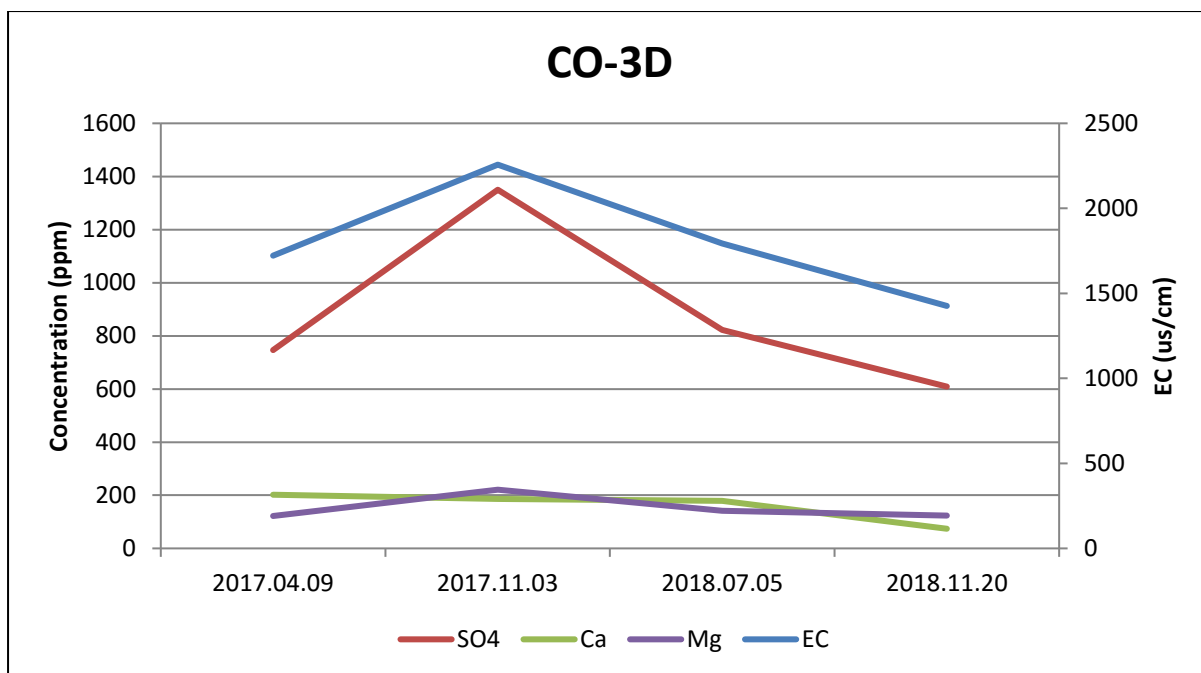


Coke Making	Coke Production	Battery 9	Dust	mg/Nm³
-------------	-----------------	-----------	------	--------

Manual History - Coke Production - Battery 9



## APPENDIX L: GROUNDWATER QUALITY RESULTS



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Registration Number 1974/001476/07 VAT Number 4780103505  
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CONFIDENTIAL

### Certificate/Report

Laboratory Number	H005507	H005508	H005509
Sampled Date			
Sample Marks	CO_03D		
Determinand	Result	Result	Result
VOC BY GC/MS FOLLOWING PURGE & TRAP TECHNIQUE BASED ON EPA 8260C & 5030B			
Benzene(ug/l)	BDL		
Toluene(ug/l)	BDL		
Ethylbenzene(ug/l)	BDL		
m, p-Xylene(ug/l)	BDL		
Styrene(ug/l)	BDL		
o-Xylene(ug/l)	BDL		

Gavin Linford

BDL - Below Detection Limit

\* Denotes test method not accredited to ISO 17025

# Denotes test method is outsourced

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### Certificate/Report

Laboratory Number	H005241	H005242	H005243
Sampled Date	2018-10-16	2018-10-16	2018-10-16
Sample Marks	CO_03D Middle		
Determinand	Result	Result	Result
SVOC BY GC/MS BASED ON EPA 8270C & 3510C			
Dibenzofuran(ug/l)*	BDL		
Naphthalene(ug/l)*	BDL		
Phenol(ug/l)*	BDL		
2-Methylphenol(ug/l)*	BDL		
4-Methylphenol(ug/l)*	BDL		
2,4 Dimethylphenol(ug/l)*	BDL		
2-Methylnaphthalene(ug/l)*	BDL		
Fluorene(ug/l)*	BDL		
Phenanthrene(ug/l)*	BDL		

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Registration Number 1974/001476/07 VAT Number 4780103505

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## Certificate/Report

Laboratory Number	H005419	H005420	H005421
Sampled Date			
Sample Marks	CO_03D BOTTOM		
Determinand	Result	Result	Result
SVOC BY GC/MS BASED ON EPA 8270C & 3510C			
Dibenzofuran(ug/l)*	BDL		
Naphthalene(ug/l)*	BDL		
Phenol(ug/l)*	BDL		
2-Methylphenol(ug/l)*	BDL		
4-Methylphenol(ug/l)*	BDL		
2,4 Dimethylphenol(ug/l)*	BDL		
2-Methylnaphthalene(ug/l)*	BDL		
Fluorene(ug/l)*	BDL		
Phenanthrene(ug/l)*	BDL		

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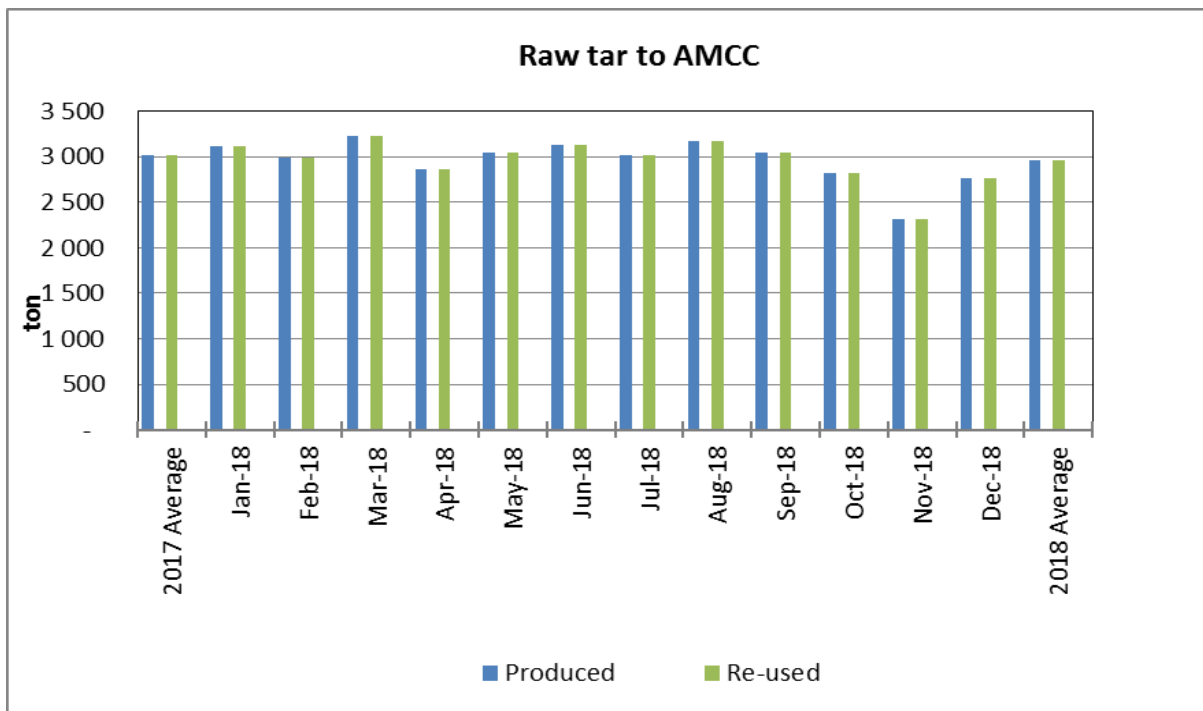
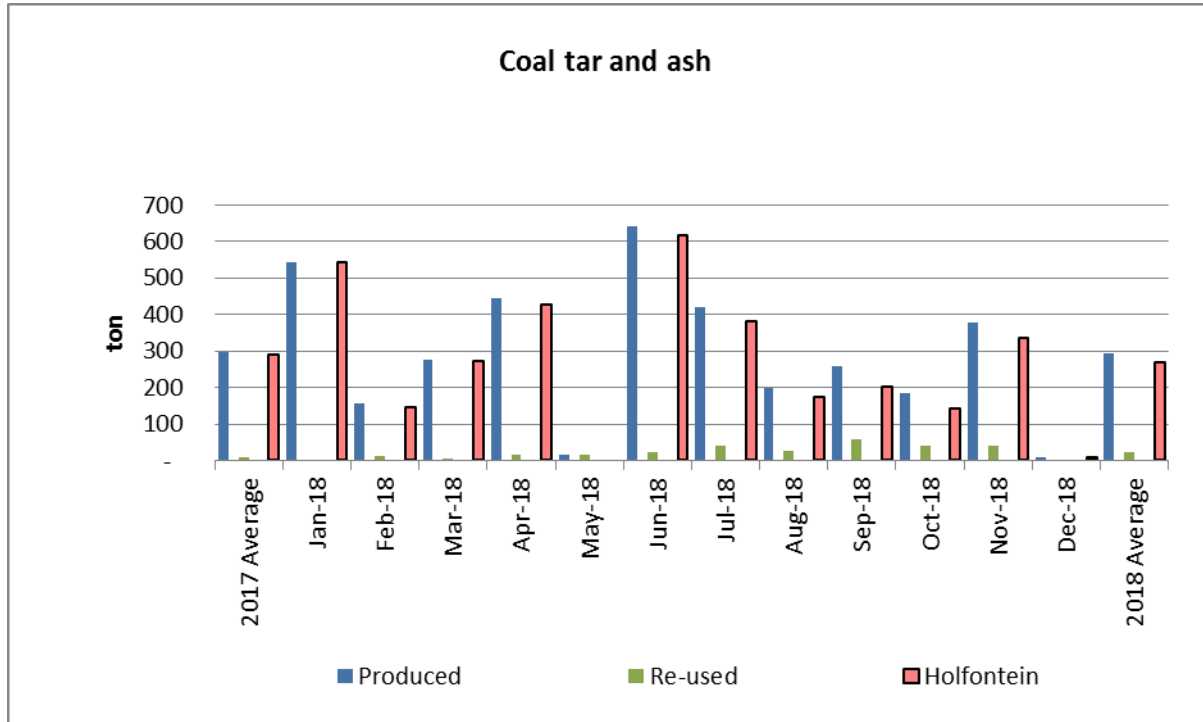
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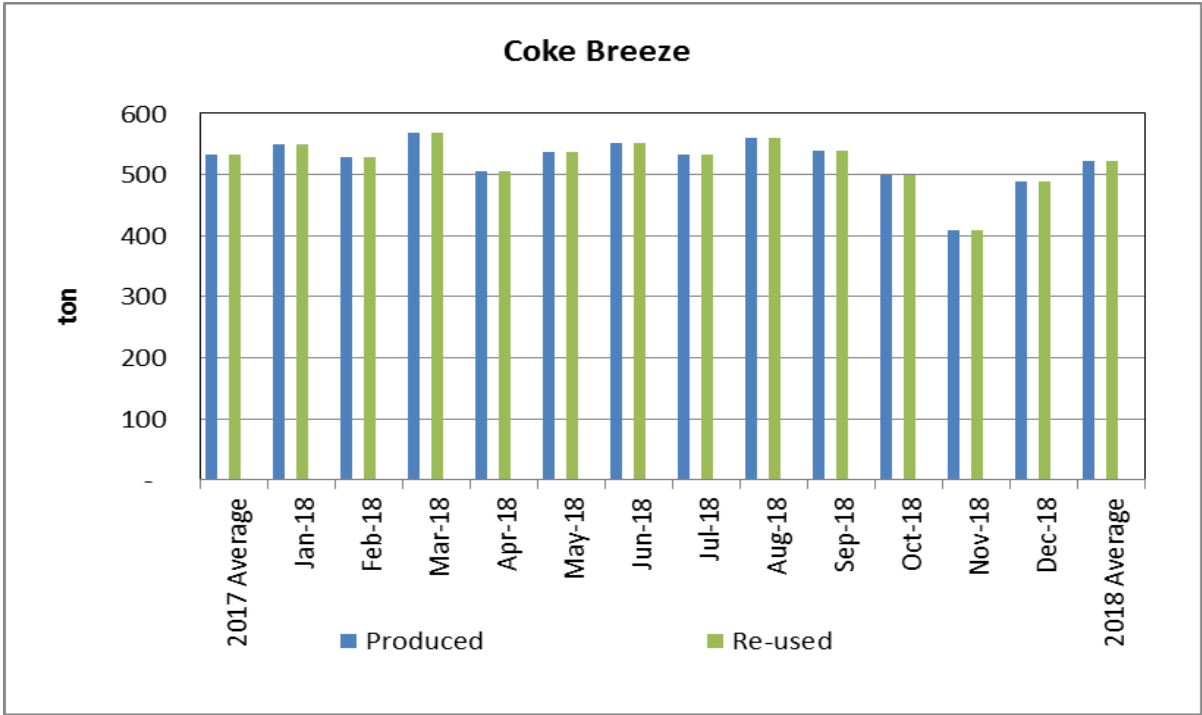
T0040

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## APPENDIX M: WASTE STREAM QUANTITIES







## **APPENDIX N: EXAMPLE OF A RECENT JOB CARD**

927786459

0010

Planning Plant: SF01

AMSA - Vanderbijlpark Works

ArcelorMittal

**BEFORE STARTING THE JOB, ASK YOURSELF THE FOLLOWING QUESTIONS**

- I Is the equipment isolated? (Mechanical, Electrical, Area)  
 W Am I wearing the correct P.P.E., What else should I use?  
 O What other party must know we are working here?  
 R Are the right tools available and safe for use?  
 K Have I discussed the known hazards with the team?  
 S What in the area could endanger our safety?  
 A Are specific procedures or instructions applicable?  
 F What can go wrong or fail during the job?  
 E Have I communicated effectively with the team?

Does this job have an Environmental impact? (Y/N)

If "Y" describe impact .....

What precautions will be put in place to prevent/limit the impact?  
 .....

Maint Plant: SFKN Coke Oven By-products

Date Printed: 2019.02.06

Plant Maintenance Work Order Header

Printed By: 10011375

Copy: 1

M/Plan Nr: 59391

Order Nr: 927786459

Notification Nr:

W/O Type: PM02

Funct Loc:

03-S

IFS South Works

ABC IND: C

LOW IMPACT

03-S-FKN

Coke Oven By-products

ABC IND: C

LOW IMPACT

03-S-FKN-853

GAS PLANT 3

ABC IND: C

LOW IMPACT

03-S-FKN-853-03

GP3 ELECTRO DETARRER SYSTEM

ABC IND: A

HIGH IMPACT

Equip:

Object List:

Funct Loc:

Equipment:

Description: (Short)

T MOKOENA - Inspect all Detarrer insulat

T MOKOENA - Inspect all Detarrer insulat

T MOKOENA - Inspect all Detarrer insulators

Lerato - Inspect all Detarrer insulators

Planning Related Information

PM Planner grp: MCA

Main work centre: ICMS1ELE SF01

System Condition: 5

Priority: 2

Status:

Activity Type: INS

Basic Start Date: 2019.02.13

Basic Start Time: 07:00:00

Byproducts A-block

Electrician

Standing

Sched - Future Med

REL CSER NMAT PRC SETC

Inspection

Basic End Date: 2019.02.13

Basic End Time: 10:00:00

TND - BIZZY WITH 6 B DETARRER

Equipment Installed/Dismantled:

Equipment Number Dismantled:  
Equipment Number Installed:

Operations Detail

Operation number: 0010  
Status: REL  
Work Centre: ICNS2  
Personnel Nr:  
Number Capacities: 1  
Earliest Start: 2019.02.13  
Control Key: PMIN  
System Condition: 5  
Frequency (Package): 01  
Inspect all Detarrer insulators  
SF01 Superintendent By-Products B-BLOCK  
Planned Duration: 3.0 HR  
Latest Finish: 2019.02.13  
PMIN Plant Maintenance Internal  
Standing  
1 Weekly

Material # Description	Reservation #	Purchase Order #	Quantity
---------------------------	---------------	------------------	----------

PRT Number:	Description:	Quantity Required:
COKE OVENS MINI HIRA	Hazard Identification and Risk	1.000

Confirmation number: 0055465222

Operations Long Text

R=Right  
W=Wrong  
C=Corrected

Inspect all Detarrer insulators

Detarrer: 3A I 3B I 4A  
Insulator temp. ....I.....I.....Deg.C  
Doors closed. ....I.....I.....  
Is temp. visible ....I.....I.....  
4A Insulator teperatures:1:....., 2:....., 3:.....

ARTISAN TO COMPLETE

Confirmation Sheet:

StDate/Time	End Date/Time	Act.Dur	Emp.Nr	Sign	Descrip	Rem.Work
13-02-2019						

07:30 07:35 5 MIN 1007127

0010

Additional work identified?				Trade responsible:			Estimated duration:		
<b>Reason for operation delay/ not completed</b>									
<b>Delay</b>		<b>Delay Duration</b>			<b>Not Done</b>				
<input type="checkbox"/> Travel & no transport					<input type="checkbox"/> Travel & no transpor				
<input type="checkbox"/> Breakdown					<input checked="" type="checkbox"/> Breakdown				
<input type="checkbox"/> Personnel Late					<input type="checkbox"/> No Personnel				
<input type="checkbox"/> Support Equipment Late					<input type="checkbox"/> No Support Equipment				
<input type="checkbox"/> PTO / Training					<input type="checkbox"/> PTO / Training				
<input type="checkbox"/> Planning not practical					<input type="checkbox"/> Planning not practic				
<input type="checkbox"/> Unplanned Leave					<input type="checkbox"/> Unplanned Leave				
<input type="checkbox"/> Addnl/Unforeseen work					<input type="checkbox"/> Material Unavailable				
<input type="checkbox"/> Material Late					<input type="checkbox"/> Material Quality				
<input type="checkbox"/> Material Quality					<input type="checkbox"/> Material Incorrect				
<input type="checkbox"/> Material Incorrect					<input type="checkbox"/> Equipment Unavailabl				
<input type="checkbox"/> Equipment Late					<input type="checkbox"/> Prep Incomplete				
<input type="checkbox"/> Prep Incomplete					<input type="checkbox"/> Unsafe Condition				
<input type="checkbox"/> Unsafe Condition					<input type="checkbox"/> Assistance Unavailab				
<input type="checkbox"/> Assistance Late					<input type="checkbox"/>				
<p style="text-align: center;"><b>Sign-Off</b></p> <p>Supt Sign: _____ Emp. Nr: _____ Date: _____</p> <p style="text-align: center;">08 MAR 2019</p> <p style="text-align: center;"><b>Artisan Additional Feedback</b></p>									