



2014 Annual Performance Report for

Lafarge Tarmac Cement & Lime Ltd

Aberthaw Works

January 2015

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Lafarge Cement UK Aberthaw Works

Introduction

Lafarge Tarmac Cement & Lime Ltd (the "Operator"), company registration number 66558, whose registered office is Portland House, Bickenhill Lane, Solihull, B37 7BQ operate a cement manufacturing installation at Aberthaw Cement Plant, East Aberthaw, Barry, CF62 3ZR.

The cement manufacturing activities carried out at the above installation are authorised by Permit EPR/BL3986ID issued by Natural Resources Wales which includes permission to burn waste derived fuels (WDFs).

Condition 4.2.2 of the Permit requires the Operator to submit an annual performance report on the functioning and monitoring of the process. This report gives an account of the running of the process and the emissions into air and water compared with the emission standards in the permit.

Plant Description

The main purpose of the activities at the installation is the production and grinding of cement clinker to produce various cement products. Lafarge Tarmac Cement & Lime operate one dry preheater process cement kiln at the Aberthaw site, which has the capacity to produce 565,000 tonnes of clinker per year. Lafarge Cement UK maintains registration to ISO14001 and EMAS environmental management systems. Certification ISO 50001 was achieved in November 2013.

Aberthaw Cement Plant uses traditional fossil fuels (coal and oil) and waste derived fuels (WDFs) (Meat and Bone Meal (MBM), end of life whole tyres and Solid Recovered Fuel (SRF). Meat and Bone Meal was first used as a fuel in 2005. Whole tyres were introduced in July 2012 and SRF was first used in February 2013.

Meat and Bone Meal and SRF are introduced into the kiln along with a pulverised coal via a firing pipe at the front end of the kiln. Whole tyres are burnt in the kiln at the back end via the pre-heater tower and kiln hearth.

The WDFs replace some of the fossil fuels that are traditionally used to produce cement clinker. The use of WDFs has a number of environmental benefits including:

- Practical solution to the disposal of waste products, which are currently disposed of via conventional waste disposal methods, whilst at the same time producing a valuable product;
- Reduction in the use of finite fossil fuels;
- Contribution towards carbon reduction commitments.

No additional residues are produced as a result of using WDFs at Aberthaw Works. The fuels are combusted at approximately 1450°C at which temperature all residues are incorporated into the cement clinker.

Plant Performance

Aberthaw Cement Plant has one cement kiln, which has run throughout the year in accordance with it's Environmental Permit to operate.

Planned maintenance and de-stocking stops were held in January and September 2014.

Fuel usage and the percentage substitution rate of WDFs are regularly monitored. This data is submitted to the NRW on the appropriate form quarterly as required by the Environmental Permit, and is summarised below. The table shows the tonnes used of fossil fuels and WDFs, and the relative thermal input of each WDF as a percentage.

Fuel	Quantity burned Tonnes	Relative thermal input of waste derived fuels
Coal	40511	
Petroleum coke	0	
Distillate fuel oil	295	
MBM	2	
Tyres	8327	15.0%
SRF	3312	12.5%

Plant Monitoring – Emissions to Air

Two types of air emission monitoring are carried out at the main release point (stack) from the kiln. Automatic instruments (CEMs) as required by the permit continuously monitor some emission species. A list of the CEMS used at the site is contained in Appendix I.

An independent accredited external test house monitors other emissions species every six months. The tables below summarise those species that are continuously monitored and those that are periodically monitored.

Pollutants measured	Continuously	Periodically
Particulates	x	
Oxides of Nitrogen	x	
Sulphur Dioxide	x	
Carbon Monoxide	x	
Total Organic Carbon	x	
Hydrogen Chloride	x	
Ammonia	x	
Mercury		x
Cadmium and Thallium		x
Group III Metals		x
Dioxins and Furans		x
Hydrogen Fluoride		x

Continuously monitored species are controlled to a limit based on the average of a 24-hour period (12:00-12:00). The daily averages are compared to the 24-hour limit and reported to NRW on a quarterly basis.

During the combustion of WDFs the continuous monitoring equipment at Aberthaw Works was operating normally for 100% of the kiln operating time.

Summary emissions data from the continuous monitoring system is attached as Appendix I; this is based on the same data that is supplied to NRW on a quarterly basis.

Periodically monitored species are tested using techniques and procedures that meet European and National Standards. These include all species listed above and also particulates on the cement mills. The results of this monitoring are compared directly to the limit prescribed in the permit and are reported to NRW. Routine extractive monitoring was carried out in April, November and December 2014 by independent, UKAS & MCERTS accredited third party organisations.

The CEMs were subject to an Annual Surveillance Test (AST), which is performed to verify the continuing validity of the calibration function. Should the CEM fail the AST then appropriate corrective action would be taken and a full re-calibration (QAL2) test would be repeated. The CEMs passed their AST in April 2014 (particulate) and December 2014 (gaseous).

Zero and span checks (QAL3) are made at site level on a weekly and monthly basis to ensure that the analysers are performing within the specified ranges and that they are continue to operate effectively. Trained personnel conduct these checks and the records are kept on site.

Plant Monitoring – Emissions to Water

Monthly samples of water are taken from the site's operational discharge point (W1) and are sent to an external UKAS accredited laboratory for analysis for suspended solids, pH and oils and greases. The results of the analysis are compared to the ELVs specified in the permit.

Plant Compliance

Aberthaw cement plant maintained compliance with the WID requirements, there were no confirmed breaches of any emission limit values relating to discharges to air or water in 2014. There were isolated, localised incidents relating to fugitive dust from site.

Availability of Information

Copies of this report may be requested from Lafarge Tarmac by contacting Robert Fairless, Environment Coordinator on telephone number 01446 752300 (option 1) or via email at aberthaw@lafargetarmac.com

Further information can be requested directly from Natural Resources Wales by calling the general enquiries line, 0300 065 3000.

Public Registers are available online at The Environment Agency Online Public Registers website:

<http://www.environment-agency.gov.uk/research/library/publicregisters/default.aspx>

Information on Lafarge Tarmac can be found on the company website:

<http://www.lafargetarmac.com/>

Appendix I
Continuous Emissions Monitors

**LAFARGE CEMENT UK ABERTHAW WORKS – ENVIRONMENTAL PERMIT
EPR/BL3986ID**

SUMMARY OF CEMS

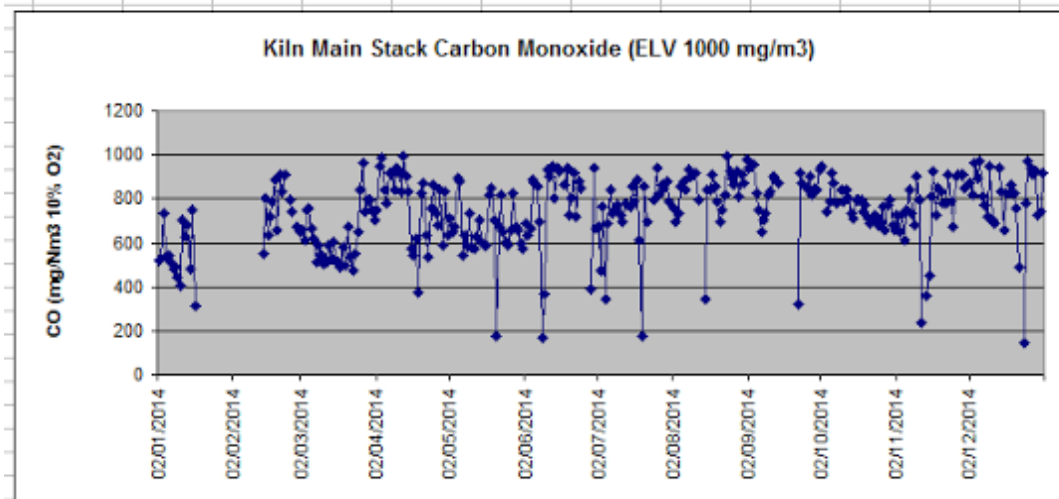
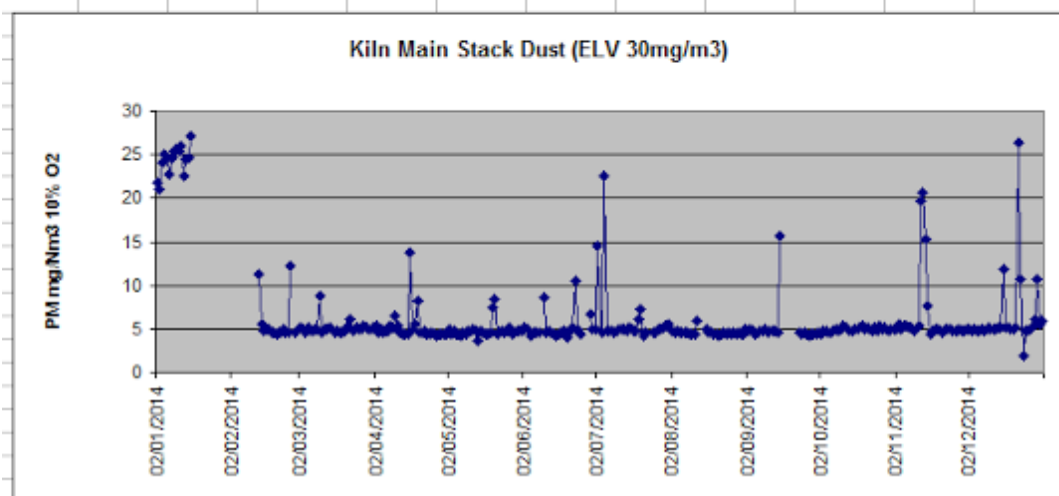
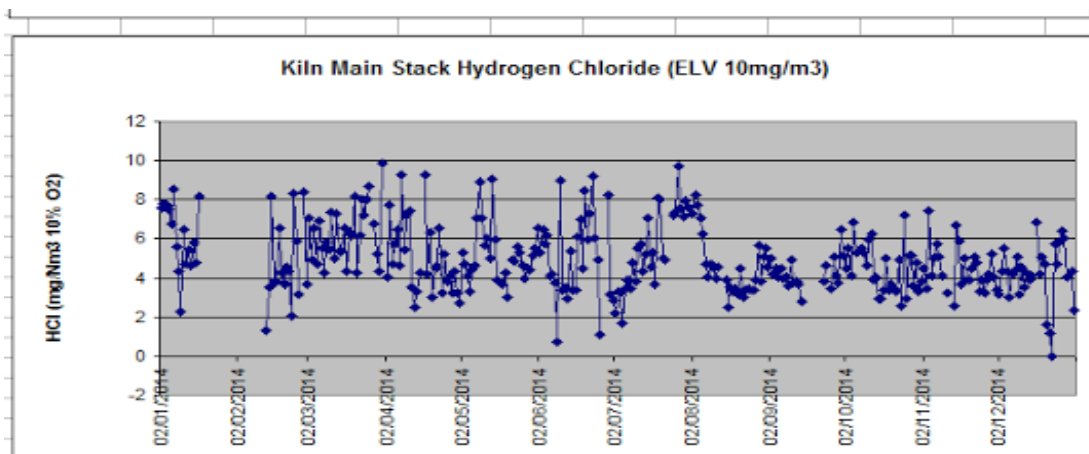
LOCATIO N	MAKE	MODEL	MCERTS CERTIFICATE	STATUS
A1 (KILN)	ABB Automation Products (Duty Gaseous CEM)	Advance CEMAS FTIR-NT (ACF-NT)	Sira MC 030016/09	QAL2 completed Dec 2012 and May 2013 AST passed Oct 2013, Dec 2014
	ABB Automation Products (Standby Gaseous CEM)	Advance CEMAS FTIR-NT (ACF-NT)	Sira MC 030016/09	QAL2 completed Dec 2012 and May 2013 AST passed Oct 2013, Dec 2014

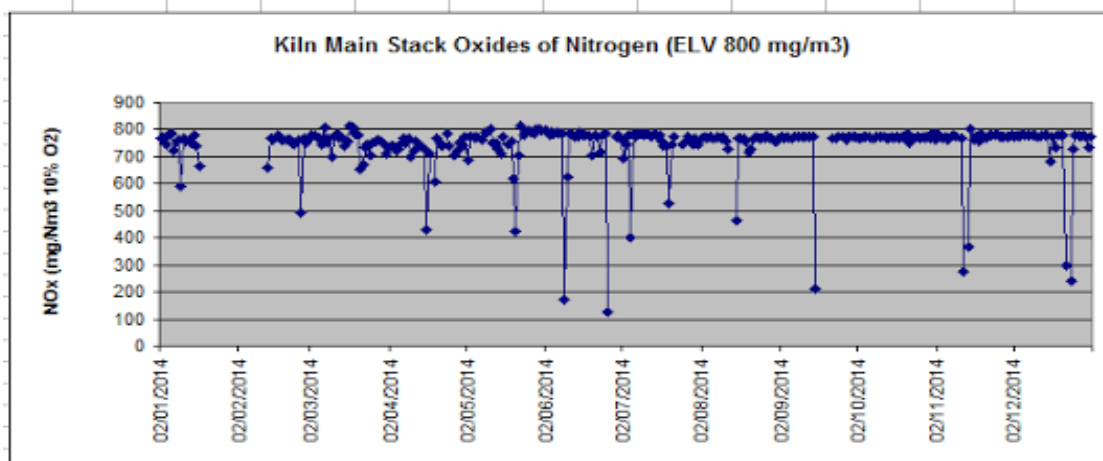
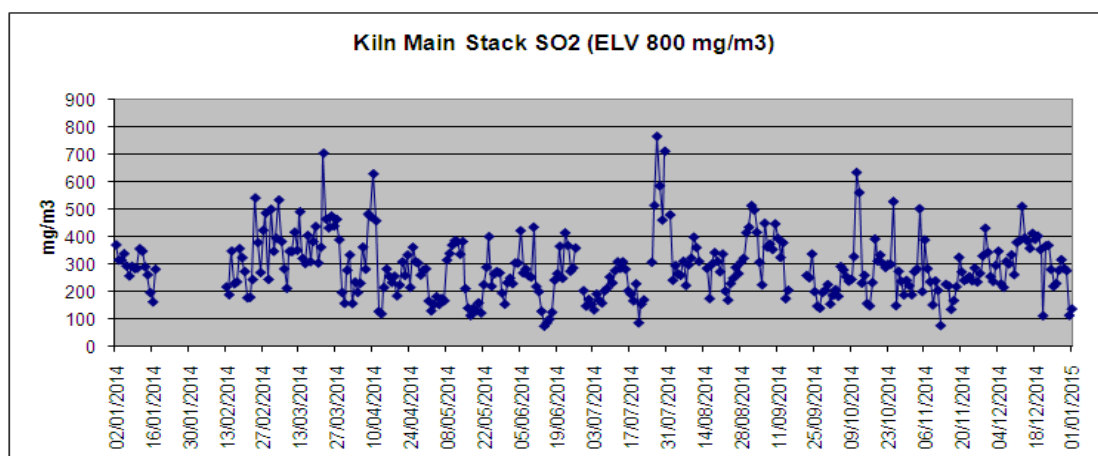
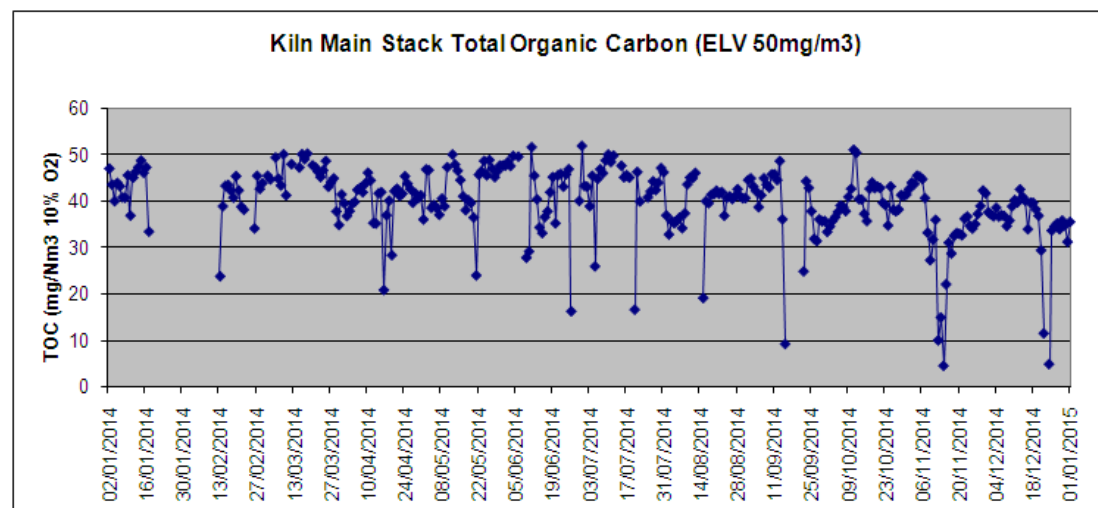
	SICK MAIHAK GmbH Particulate CEM	RM210	Sira MC 040043/01	QAL2 completed April 2010 AST passed April 2011, March 2012, April 2013, April 2014*
A2 (CEMENT MILL)	PCME Particulate CEM	DT990	Sira MC 050049/03	Compliance check completed April/November 2014
A3 (CEMENT MILL)	SICK MAIHAK GmbH Particulate CEM	FW101	Sira MC 040041/02	Compliance check completed April/November 2014

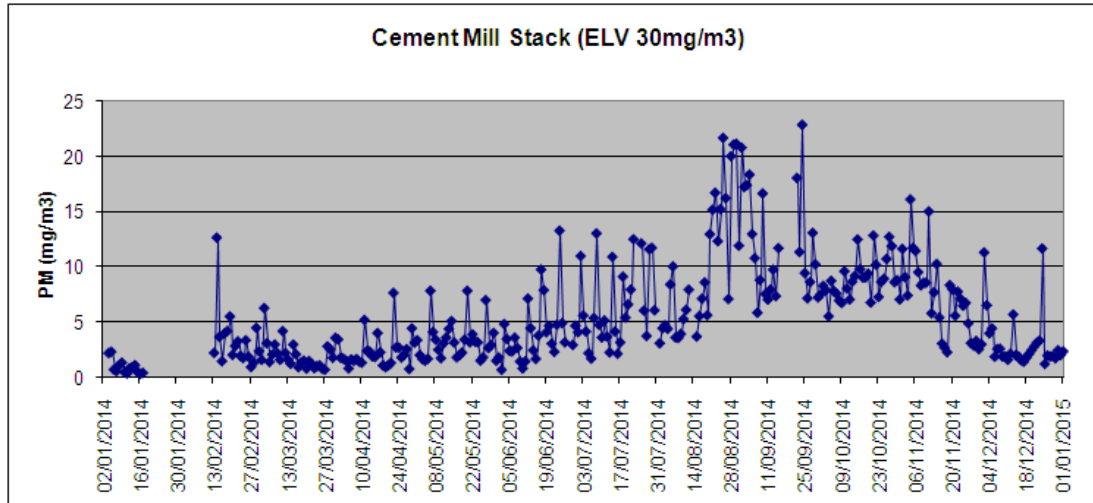
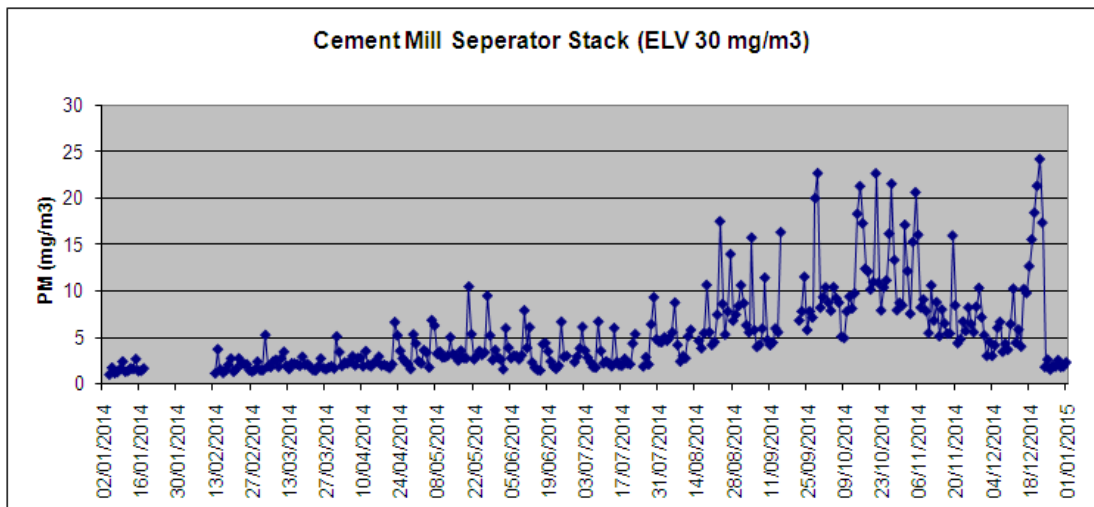
*Following the particulate QAL 2 performed on the kiln stack (A1) in 2010 and in accordance with Technical Guidance Note M20 section 3.7, the particulate emission profile remains below 30% of the Emission Limit Value, the emission profile is currently too low to derive a valid calibration function and an AST is performed annually instead of a QAL 2 exercise.

Appendix II

Continuous Emissions Monitor Results







*Note the future ELV for NO_x will be 500mg/Nm³ following completion of the current SNCR/NH₃ baseline trials

Appendix III
Periodic Monitoring Results

Species	Limit mg/m3	Kiln 1 Test 1 mg/m3	Kiln 1 Test 2 mg/m3
Mercury	0.05	0.001	0.00044
Cadmium and Thallium	0.05	0.002	0.018
Group III Metals	0.5	0.029	0.082
Hydrogen Fluoride	1	0.22	0.27
Dioxins and Furans	0.1*	0.0013*	0.0039*

* Dioxin and Furan results in ng/m3 TEQ