DATE OF REPORT: 10TH DECEMBER 2018



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TEST REPORT No. NOV18207.1

AIR EMISSION TESTING CONDUCTED ON CEMENT MILL EXHAUST STACKS 1, 2 & 3 AT MORGAN CEMENT INTERNATIONAL IN PORT KEMBLA

DATE OF TESTING: 20TH NOVEMBER 2018

ACCREDITATION:



This laboratory is accredited by the National Association of Testing Authorities (NATA). NATA Accredited Laboratory No. 15463.

Accredited for compliance with ISO/IEC 17025:2005.

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EXECUTIVE SUMMARY

AirLabs Environmental Pty Ltd was commissioned by Morgan Cement International Pty Ltd to monitor stack emissions from Mills 1, 2 & 3 Exhaust Stacks. All sampling was conducted by Airlabs Environmental on the 20th November 2018.

Analysis was undertaken by Airlabs Environmental and the National Measurement Institute (NMI) in accordance with our terms of NATA accreditation. Unless otherwise indicated, the methods cited in this report have been performed without deviation.

The following results comparison table shows that the concentrations of all analytes were below the limits set by the NSW DEHP (refer to Licence No. -12643, issued on 06^{th} September 2016).

Table 1: Comparison of Test Results with NSW DEHP Limits

Release Point	Parameter	Concentration (mg/m³)	NSWEPA Concentration Limit (mg/m³)
	Total solid particles (TSP)	2.4	20
Mill 1	Fine particulates (PM ₁₀)	2.0	N/A
	Type 1 & 2 Substances	0.016	1.0
	Total solid particles (TSP)	2.7	20
Mill 2	Fine particulates (PM ₁₀)	2.3	N/A
	Type 1 & 2 Substances	0.022	1.0
	Total solid particles (TSP)	1.1	20
Mill 3	Fine particulates (PM ₁₀)	0.93	N/A
	Type 1 & 2 Substances	0.025	1.0

INTRODUCTION

Airlabs Environmental Pty Ltd was commissioned by Morgan Cement International Pty Ltd to conduct air emissions monitoring of the exhaust ducts leaving Cement Mills 1, 2 and 3 for the following parameters:

- Gas velocity and volume flow rate
- Temperature
- Concentration of water vapour (moisture content)
- Concentration of oxygen and carbon dioxide
- Dry molecular weight & density of gases
- Concentration and mass emission rate of:
 - total solid particles
 - fine particulates (PM₁₀).
 - type 1 & 2 substances.

All sampling was conducted on 20th November 2018.

TEST METHODS

All sampling was undertaken by Airlabs Environmental. Airlabs Environmental is NATA accredited for all sampling undertaken for this project (NATA Accredited Laboratory No. 15463). Analysis was undertaken by Airlabs Environmental in accordance with our terms of accreditation. Specific details of the test methods used are available upon request.

Table 2: Summary of Test Methods

		Method	Estimated	NATA Accredited	
Test Parameter	Test Method	Detection Limit	Measurement Uncertainty	Sampling	Analysis
Sample plane criteria	NSWEPA TM-1	NA	NA	√	NA
Gas velocity	NSWEPA TM-2	3 m/s	± 10%	√	NA
Temperature	NSWEPA TM-2	273K (0°C)	± 1%	√	NA
Moisture content	NSWEPA TM-22	0.2% v/v	± 5%	√	√
Oxygen & carbon dioxide	NSWEPA TM-24 & TM-25	0.1% v/v	± 2%	✓	✓
Dry molecular weight & gas density	NSWEPA TM-23	NA	± 5%	√	✓
Total solid particulates	NSWEPA TM-15	$0.5~\mathrm{mg/m^3}$	± 15%	√	✓
Fine Particulates	NSWEPA OM-5	0.5 mg/m ³	± 15%	√	✓
Type 1 & 2 Substances	NSW EPA TM- 12, 13 & 14	0.05 mg/m3	± 17%	√	√ ¹

1. Type 1 & 2 Substances analyses were performed by NMI, with results included in their Report No. RN1216444.

QUALITY STATEMENT

AirLabs Environmental is committed to providing the highest quality data to all our clients, as reflected in our ISO 17025 (NATA) accreditation. This requires strict adherence to and continuous improvement of all our processes and test work. Our goal is to exceed the QA/QC requirements as set by our clients and appropriate governmental entities and to ensure that all data generated is scientifically valid and defensible.

Airlabs Environmental is NATA accredited for all sampling undertaken for this project. Analysis was undertaken by the Airlabs Environmental in accordance with our terms of accreditation.

SUITABILITY OF SAMPLING PLANE

The criteria for sampling planes as specified in AS4323.1-1995 'Stationary Source Emissions, Method 1: Selection of Sampling Provisions' states that, in the absence of cyclonic flow activity, ideal sampling plane conditions are found to exist at the positions given in Table 3 below:

Table 3: Criteria for the Selection of Sampling Planes

Type of flow disturbance	Minimum distance upstream from disturbance, diameters (D)	Minimum distance downstream from disturbance, diameters (D)
Bend, connection, junction, direction change	>2D	>6D
Louvre, butterfly damper (partially closed or closed)	>3D	>6D
Axial fan	>3D	>8D (see Note)
Centrifugal fan	>3D	>6D

NOTE: The plane should be selected as far as practicable from a fan. Flow straighteners may be required to ensure the position chosen meets the check criteria listed in Items (a) to (f) below.

Section 4.1 of AS 4323.1-1995 (Ideal Sampling Positions) states that the location of the sampling plane shall be such that it meets the following criteria:

- (a) The gas flow is basically in the same direction at all points along each sampling traverse.
- (b) The gas velocity at all sampling points is greater than 3 m/s.
- (c) The gas flow profile at the sampling plane shall be steady, evenly distributed and not have a cyclonic component which exceeds an angle of 15° to the duct axis, when measured near the periphery of a circular sampling plane.
- (d) The temperature difference between adjacent points of the survey along each sampling traverse is less than 10% of the absolute temperature, and the temperature at any point differs by less than 10% from the mean.
- (e) The ratio of the highest to lowest pitot pressure difference shall not exceed 9:1 and the ratio of highest to lowest gas velocities shall not exceed 3:1. For isokinetic testing with the use of impingers, the gas velocity ratio across the sampling plane should not exceed 1.6:1.
- (f) The gas temperature at the sampling plane should preferably be above the dewpoint.

SUITABILITY OF SAMPLING PLANE Continued

When the criteria in Table 3 cannot be met, a greater number of sampling points is used in order to retain as much accuracy as is practicable, as outlined in Section 4.2 of AS 4323.1-1995 (Non-Ideal Sampling Positions). The sampling plane details and required number of sampling points for Cement Mills 1, 2 and 3 are given in Tables 4, 5 and 6 below:

Table 4: Sampling Plane Details for the Cement Mill 1 Exhaust Duct Figure 1: Cement Mill 1 Exhaust Duct

Parameter	
Stack Shape	Circular
Actual Stack Internal Diameter (m)	0.850
Direction of Air Flow	Vertical
Type of Disturbance, Upstream	Bend
Distance from Upstream Disturbance	4 D (< 6D)
Type of Disturbance, Downstream	Butterfly damper
Distance to Downstream Disturbance	1 D (< 3 D)
Compliance with AS 4323.1, Ideal Conditions	No
Standard No. of Sampling Points per Traverse	6
Number of Traverses	2
Correction Factor	1.265
Corrected No. of Sampling Points per Traverse	8
Total No. of Sampling Points	16
Stratified	No
Cyclonic	No (< 15°)
Velocity Difference	1.2:1 (< 1.6:1)
Absolute Temperature Difference (K)	< 10%
Minimum Velocity at any Sample Point (m/s)	> 3

Table 5: Sampling Plane Details for the Cement Mill 2 Exhaust Duct Figure 2: Cement Mill 2 Exhaust Duct

Parameter	
Stack Shape	Circular
Actual Stack Internal Diameter (m)	0.850
Direction of Air Flow	Vertical
Type of Disturbance, Upstream	Bend
Distance from Upstream Disturbance	4 D (< 6D)
Type of Disturbance, Downstream	Butterfly damper
Distance to Downstream Disturbance	1 D (< 3 D)
Compliance with AS 4323.1, Ideal Conditions	No
Standard No. of Sampling Points per Traverse	6
Number of Traverses	2
Correction Factor	1.265
Corrected No. of Sampling Points per Traverse	8
Total No. of Sampling Points	16
Stratified	No
Cyclonic	No (< 15°)
Velocity Difference	1.3:1 (< 1.6:1)
Absolute Temperature Difference (K)	< 10%
Minimum Velocity at any Sample Point (m/s)	> 3



SUITABILITY OF SAMPLING PLANE Continued

Table 6: Sampling Plane Details for the Cement Mill 3 Exhaust Duct

Parameter Stack Shape Rectangular Actual Duct Internal Diameter (m) 1.77 * 0.800 Direction of Discharge to Air Horizontal Type of Disturbance, Upstream Centrifugal Fan Distance from Upstream Disturbance 3.4D (< 6D)**Duct Exit** Type of Disturbance, Downstream Distance to Downstream Disturbance $4.9 \, D \, (> 2 \, D)$ Compliance with AS 4323.1, Ideal Conditions Nο Standard No. of Sampling Points per Traverse 2 **Number of Traverses** 3 Correction Factor 1.15 Corrected No. of Sampling Points per Traverse 3 9 Total No. of Sampling Points Stratified Nο Cyclonic No ($< 15^{\circ}$) Velocity Difference 1.1:1 (< 1.6:1) Absolute Temperature Difference (K) < 10% Minimum Velocity at any Sample Point (m/s) > 3

Figure 3: Cement Mill 3 Exhaust Duct



DEFINITIONS

'NSWEPA' New South Wales Environment Protection Authority.
'USEPA' United States Environmental Protection Agency.

'NA' Not applicable.

'Am³' Actual gas volume at stack conditions.

'STP' Standard temperature and pressure (0°C and 101.3 kPa).

"
% v/v" Percent, volumetric basis.

'm³' Normalised gas volume in dry cubic metres at STP.

'mg/m 3 ' Milligrams (10- 3 grams) of substance per dry cubic meter of gas at STP.

'g/sec' Grams of substance discharged per second.

RESULTS

Company Morgan Cement International Pty Ltd

Site Foreshore Rd, Port Kembla

Date of Test 20th November 2018

Source Tested Cement Mill 1 Exhaust Duct – EPA ID No.4

Sampling Period 08:18 - 11:01

Testing Officers I Brash & A. Aitharaju

Sampling Position Two 110 mm flanges in a circular metal duct

Table 7: Sampling Conditions for the Cement Mill 1 Exhaust Duct on 20th November 2018

Sampling Conditions		
Duct dimensions at sampling plane (m)	0.850	
Average gas temperature (K)	343 (70°C)	
Average gas velocity (m/s)	15.9	
Actual gas flow rate (Am ³ /sec)	9.03	
Average moisture content (%v/v)	0.44	
Barometric pressure (mB)	1008.0	
Static pressure (mB)	-23.5	
Stack pressure (mB)	984.5	
Average gas flow rate at STP, dry (m ³ /sec)	7.16	
Average oxygen concentration (%v/v)	20.9	
Average carbon dioxide concentration (%v/v)	0.050	
Dry gas density of stack gas (kg/m³)	1.287	
Dry molecular weight of stack gas (g/g mole)	28.85	
Wet molecular weight of stack gas (g/g mole)	28.80	

Table 8: Test Results for Cement Mill 1 Exhaust Duct on 20th November 2018

Parameter	Concentration (mg/m³)	NSWEPA Limit (mg/m³)	Emission Rate (g/sec)
Total solid particles (TSP)	2.4	20	0.017
Fine particulates (PM ₁₀)	2.0	N/A	0.014
Type 1 & 2 substances	0.016	1.0	0.00011

Type 1 & 2 substances include As, Be, Cd, Cr, Co, Hg, Mn, Ni, Pb, Sb, Se, Sn, V & their compounds (refer to Table 9 & 10).

RESULTS - Continued

Table 9: Concentration of Type 1 Substances and their Compounds - 20th November 2018

Metal/Metal Compound	Concentration (mg/Nm³)	Emission Rate (g/sec)
Antinomy (Sb) & its compounds	<0.0002	<0.000001
Arsenic (As) & its compounds	<0.0002	<0.00001
Cadmium (Cd) & its compounds	0.000033	0.00000024
Lead (Pb) & its compounds	0.0018	0.000013
Mercury (Hg) & its compounds	0.000015	0.00000011
Total Type 1 substances & their compounds	0.0018	0.000013

Table 10: Concentration of Type 2 Substances and their Compounds - 20th November 2018

Metal/Metal Compound	Concentration (mg/Nm³)	Emission Rate (g/sec)
Beryllium (Be) & its compounds	<0.0002	<0.000001
Chromium (Cr) & its compounds	0.0019	0.000014
Cobalt (Co) & its compounds	<0.0002	<0.00001
Manganese (Mn) & its compounds	0.0048	0.000035
Nickel (Ni) & its compounds	0.0065	0.000047
Selenium (Se) & its compounds	0.00025	0.0000018
Tin (Sn) & its compounds	<0.0002	<0.00001
Vanadium (V) & its compounds	0.00013	0.00000095
Total Type 2 substances & their compounds	0.014	0.000097

RESULTS Continued

Company Morgan Cement International Pty Ltd

Site Foreshore Rd, Port Kembla

Date of Test 20th November 2018

Source TestedCement Mill 2 Exhaust Duct – EPA ID No.2

Sampling Period 11:37 – 14:19

Testing Officers I Brash & A. Aitharaju

Sampling Position Two 110 mm flanges in a circular metal duct

Table 11: Sampling Conditions for the Cement Mill 2 Exhaust Duct on 20th November 2018

Sampling Conditions		
Duct dimensions at sampling plane (m)	0.850	
Average gas temperature (K)	349 (76°C)	
Average gas velocity (m/s)	13.1	
Actual gas flow rate (Am ³ /sec)	7.44	
Average moisture content (%v/v)	0.70	
Barometric pressure (mB)	1005.7	
Static pressure (mB)	- 11.9	
Stack pressure (mB)	993.8	
Average gas flow rate at STP, dry (m ³ /sec)	5.78	
Average oxygen concentration (%v/v)	20.9	
Average carbon dioxide concentration (%v/v)	0.055	
Dry gas density of stack gas (kg/m³)	1.287	
Dry molecular weight of stack gas (g/g mole)	28.85	
Wet molecular weight of stack gas (g/g mole)	28.78	

Table 12: Test Results for the Cement Mill 2 Exhaust Duct on 20th November 2018

Parameter	Concentration (mg/m³)	NSWEPA Limit (mg/m³)	Emission Rate (g/sec)
Total solid particles (TSP)	2.7	20	0.016
Fine particulates (PM10)	2.3	N/A	0.013
Type 1 & 2 substances ^b	0.022	1.0	0.00012

b Type 1 & 2 substances include As, Be, Cd, Cr, Co, Hg, Mn, Ni, Pb, Sb, Se, Sn, V & their compounds (refer to Table 13 & 14).



RESULTS - Continued

Table 13: Concentration of Type 1 Substances and their Compounds - 20th November 2018

Metal/Metal Compound	Concentration (mg/Nm³)	Emission Rate (g/sec)
Antinomy (Sb) & its compounds	<0.0001	<0.000008
Arsenic (As) & its compounds	<0.0001	<0.000008
Cadmium (Cd) & its compounds	0.000028	0.00000016
Lead (Pb) & its compounds	0.0019	0.000011
Mercury (Hg) & its compounds	0.000012	0.000000069
Total Type 1 substances & their compounds	0.0019	0.000011

Table 14: Concentration of Type 2 Substances and their Compounds - 20th November 2018

Metal/Metal Compound	Concentration (mg/Nm³)	Emission Rate (g/sec)
Beryllium (Be) & its compounds	<0.0001	<0.000008
Chromium (Cr) & its compounds	0.0019	0.000011
Cobalt (Co) & its compounds	<0.0001	<0.000008
Manganese (Mn) & its compounds	0.015	0.000089
Nickel (Ni) & its compounds	0.0024	0.000014
Selenium (Se) & its compounds	0.00018	0.0000010
Tin (Sn) & its compounds	<0.0001	<0.000008
Vanadium (V) & its compounds	0.00017	0.0000098
Total Type 2 substances & their compounds	0.020	0.00031

RESULTS Continued

Company Morgan Cement International Pty Ltd

Site Foreshore Rd, Port Kembla

Date of Test 20th November 2018

Source Tested Cement Mill 3 Exhaust Duct – EPA ID No.3

Sampling Period 14:38 - 17:02

Testing Officers I Brash & A. Aitharaju

Sampling Position Three 4" sockets in a rectangular metal duct

Table 15: Sampling Conditions for the Cement Mill 3 Exhaust Duct on 20th November 2018

Sampling Conditions		
Duct dimensions at sampling plane (m)	1.77 x 0.800	
Average stack gas temperature (K)	351 (78°C)	
Average gas velocity (m/s)	20.8	
Actual gas flow rate (Am ³ /sec)	29.5	
Average moisture content (%v/v)	1.03	
Barometric pressure (mB)	1003.2	
Static pressure (mB)	1.9	
Stack pressure (mB)	1005.1	
Average gas flow rate at STP, dry (m ³ /sec)	22.7	
Average oxygen concentration (%v/v)	20.9	
Average carbon dioxide concentration (%v/v)	0.055	
Dry gas density of stack gas (kg/m3)	1.287	
Dry molecular weight of stack gas (g/g mole)	28.85	
Wet molecular weight of stack gas (g/g mole)	28.74	

Table 16: Test Results for the Cement Mill 3 Exhaust Duct on 20th November 2018

Parameter	Concentration (mg/m³)	NSWEPA Limit (mg/m³)	Emission Rate (g/sec)
Total solid particles (TSP)	1.1	20	0.025
Fine particulates (PM10)	0.93	N/A	0.021
Type 1 & 2 substancesc	0.025	1.0	0.00056

Type 1 & 2 substances include As, Be, Cd, Cr, Co, Hg, Mn, Ni, Pb, Sb, Se, Sn, V & their compounds (refer to Table 17 & 18).



RESULTS - Continued

Table 17: Concentration of Type 1 Substances and their Compounds - 20th November 2018

Metal/Metal Compound	Concentration (mg/Nm³)	Emission Rate (g/sec)
Antinomy (Sb) & its compounds	<0.0001	<0.00003
Arsenic (As) & its compounds	<0.0001	<0.00003
Cadmium (Cd) & its compounds	0.000016	0.00000037
Lead (Pb) & its compounds	0.00075	0.000017
Mercury (Hg) & its compounds	0.000014	0.00000032
Total Type 1 substances & their compounds	0.00078	0.000018

Table 18: Concentration of Type 2 Substances and their Compounds - 20th November 2018

Metal/Metal Compound	Concentration (mg/Nm³)	Emission Rate (g/sec)
Beryllium (Be) & its compounds	<0.0001	<0.00003
Chromium (Cr) & its compounds	0.00094	0.000021
Cobalt (Co) & its compounds	<0.0001	<0.00003
Manganese (Mn) & its compounds	0.022	0.00050
Nickel (Ni) & its compounds	0.00094	0.000021
Selenium (Se) & its compounds	<0.0001	<0.00003
Tin (Sn) & its compounds	<0.0001	<0.00003
Vanadium (V) & its compounds	<0.0001	<0.000003
Total Type 2 substances & their compounds	0.024	0.00054