Workshop UNECE Air Convention with Focus on Countries in the EECCA Region

Inspection and Monitoring according European Industrial Emissions Directive (IED) using an Example from the Cement Industry in Bavaria

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Air Quality Control in Plants
Agenda

- Cement Plants in Germany / Focus of Inspections
- General Aspects: IED Inspection
- Example Cement Plant: IED Inspection
- New Bavarian Approach on Inspection
Cement Plants in Germany / Focus of Inspections

- **Cement plants in Germany**
  - 42 plants (6 plants in Bavaria)
  - 37 rotary kilns with cyclone preheaters (dry process)
  - production capacity: typically 3000 – 4000 t\(_{\text{clinker}}\)/day
  - use of alternative fuels: ca. 65 % of total fuel energy demand (average 2017)

- **Sources of Emissions**
  - waste gas of rotary kiln
  - 100 – 200 stationary emissions sources (dust)
  - different diffuse emissions
  - different sources of noise, like mills

- **Focus of Inspections**
  - emissions to the air, especially dust
  - noise
  - waste co-incineration (quality control)

Note: ca. 25 % of dust emissions are kiln born, ca. 75 % are from other sources!!
Focus of Inspections of Cement Plants

Diffuse dust emissions: e.g. road transport, material transport and delivery

Channelled dust emissions, other than kiln dusty operations, cooling and milling processes

Sources of Noise: e.g. raw meal mills, cement mills, etc.

Channelled emissions kiln
- waste gas kiln firing
  - dust
  - NOx
  - SOx
  - CO
  - HCl / HF
  - VOC
  - Heavy Metals
  - PCDD/F

CO trips in case of electric precipitators

Reference: JRC Reference Report BAT 2013 Production of Cement, Lime Magnesium Oxide
Waste Gas Cleaning and Emission Monitoring (Bavarian Kiln)

**Continuous Emission Monitoring**

**Clean gas kiln**
- Dust
- NO\textsubscript{x}
- SO\textsubscript{x}
- TO\textsubscript{C}
- CO
- Mercury
- NH\textsubscript{3}
- V, T, p, humidity

**Clinker cooler, mills**
- Dust

**Yearly Measurements**
- HCl, HF
- heavy metals
- PCDD/f

**Every three years**
- Dust (other sources)

**NO\textsubscript{x} Reduction**
Selective catalytic reduction (SCR)
NO\textsubscript{x} < 200 mg/m\textsuperscript{3} (daily mean value)
NH\textsubscript{3} < 10 mg/m\textsuperscript{3}

**Dust Precipitation**
Fabric filters (cooler and kiln)
Dust << 10 mg/m\textsuperscript{3} (daily mean value)

Production capacity: 3500 t\textsubscript{clinker} / day
Bavarian Cement Plant

(Will be provided during presentation)

Picture of the Cement Mill
SCR Technique Bavarian Kiln

- Pictures

(Will be provided during presentation)

View into a catalytic module
General Aspects: IED Inspection

- Environmental Inspections (Art. 3, Nr. 22 IED)

All actions **to check and promote compliance of installations conditions** and, where necessary, to monitor their environmental impact, including

- site visits
- monitoring of emissions
- checks of internal reports and follow-up documents
- verification of self-monitoring
- checking of the techniques used (Best Available Techniques)
- adequacy of the **environment management** of the installation

**=> very comprehensive inspection and monitoring approach of the IED**
General Aspects: IED Inspection

- **Environmental Inspections (Art. 23 IED)**
  - **Frequency of site visits** (based on a systematic approach of the environmental risks)
    - in Bavaria all cement plants: **yearly**
  - **Competent authority for Inspection of cement plants**
    - in Bavaria: **regional authority** -> Inspection by environmental engineers
      - **coordination with** -> water protection, occupational safety, nature protection
  - **Inspection Reports**
    - reports with the relevant findings are **published via internet** on the homepage of the competent regional authority

- **Public Information Emission Monitoring (Art. 55 IED)**
  - -> Internet or gazettes
    - **Bavarian Example**: [https://www.heidelbergcement.de/de/lengfurt/emissionen](https://www.heidelbergcement.de/de/lengfurt/emissionen)
General Aspects: IED Inspection

- **Scope of Site Visits**
  - **Plant identity**: conformity of the realized plant with permission
  - Conformity of the plant with the obligations of the permit
    -> e.g. emission limit values, emission monitoring, quality control of waste, noise monitoring
  - **Permanent conformity with emission limit values**
    -> availability of maintenance and self monitoring programmes for all dust filters / waste gas treatments (documentation)
  - **Suitability of environmental management**
    -> environmental company organisation, policy
    -> environmental responsibilities
  - **Best Available Techniques**
    -> Inline with BAT-Conclusions “Production of Cement, Lime and Magnesium oxid (CLM)”
Example Cement Plant: IED Inspection

- **Procedure of Inspection: Documents and reports**

- **Preparation and checks of documents and reports**
  - all permits
  - if so, reconsider with regard to BAT Conclusions „CLM“
  - current flow charts of the whole plant
  - scheme of all emissions sources
  - reports:
    - periodical measurement air emissions (all sources)
    - continuous measurements reports, functional and kalibration reports
    - noise
  - CO – trips, when using electric precipitator (< 30 h / Jahr, see BAT-Conclusions „CLM“)
  - in case of co-incineration of waste: quality assurance system
  - last but not least: Are there complaints?
Continuous Air Emission Monitoring (Stack kiln)

- Mercury Continuously
- Sampling point for periodic measurements
- Continuously: multi components NOx, SO2, CO, TOC, NH3

all photos: Ebertsch
Example Cement Plant: IED Inspection

- **Procedure of Inspection: Site Visit (1)**

  - **Check Plant Identity**
    - gap of existing components of the plant with the permit (-> flow chart)?
    - real clinker production capacity

  - **Check neuralgic points:**
    - Diffuse emissions (see BAT-Conclusions)
      - Enclosure /encapsulation of dusty operations, such as grinding, screening and mixing, conveyors, elevators
      - Use flexible filling pipes for dispatch and loading processes
      - tidiness of transport roads, pavement, etc.

    - Noise
      - Enclosure of noisy operations (e.g. mills)
      - soundproofed buildings, noise protection walls, closed doors etc.

    - Waste quality control: results of analytics from waste to be used as fuel
Example Cement Plant: IED Inspection

- **Procedure of Inspection: Site Visit (2)**

  - **Check neuralgic points (ff):**
    - Functional Control of dust filters (exemplary)
      - Self - control of the operator, check maintenance book; check operational instructions

  - **Operational room (control panel)**
    - production capacity
    - waste feed
    - continuous emission monitoring

  - **Site visit stack**
    - Function control of continuous emission monitoring analysers
    - suitability of measuring points for periodic measurements
Bavarian Approach on Inspections

- **New approach: Achieving a Reliable Operators Behavior**

  - **Pilot project „systematic approach inspection“ for a cement plant**

    -> documentation with all necessary documents for inspection (folder) developed by competent authority and operator commonly

    e.g. all permits, flow charts, scheme of emission sources, etc.

    -> the documentation includes the self monitoring of the operator and the environmental management of the plant

    -> The documentation will be updated frequently

- **Advantages**

  -> reduction of the extent of the inspections

  -> extension of inspection period (2 years)

  -> suitable for long term use
Thank you for your attention