



**Building
something
great**

Berrima Cement Works Community Liaison Group Meeting Minutes

Friday 13 June 2025

Berrima Cement Works meeting room, Taylor Avenue, New Berrima

ATTENDEES

Neighbours / Community Representatives

Clive West, Berrima resident and Berrima Resident Association representative

Mayor Fitzpatrick, Wingecarribee Shire Council

Cr Rachel Russell, Wingecarribee Shire Council

Cr Sara Moylan, Wingecarribee Shire Council

Cr Jim Farrell, Wingecarribee Shire Council

Ruby Ardren, Wingecarribee Shire Council

Morwenna Zabaks, Wingecarribee Shire Council

Jan Campbell, Economic Development Manager, Regional Development, Department of Primary Industries and Regional Development

Boral

Waqas Ali, Operations Manager Berrima

Gabriel Paicu, Technical Manager Berrima

Sharon Makin, Environmental Business Partner South Coast and Southern Highlands

Roland Wong, Senior Planning and Approvals Manager NSW/ACT

Kate Woodbridge, Stakeholder Relations Manager Northern Region

Apologies

Andrew Wood, New Berrima resident

Barry Arthur, Wingecarribee Shire Council

Meeting commenced at 10am

Matters arising from the last meeting – 12 November 2024

Nil

Operational Update

Safety

- There were no serious incidents at the site.
- A major shutdown was executed in January 2025 with one medically treated injury.
- A kiln mini maintenance shutdown will occur in July 2025 for 8 days.



**Building
something
great**

Customers and people

- There were no supply or product quality issues.
- New employees:
 - Automation/ Process Engineer Masha Rahimi
 - Quality Product Manager Rebacca Jordan
 - Tactical Buyer Liz Monroy

Production and performance

- Clinker and cement volumes as per market demand.
- Energy costs continue to be a significant head wind (coal & electricity). Stopping of raw mills and cement mills to save electricity consumption during peak hours.
- Plant reliability has improved across all main assets.
- FY25, alternate fuels budget is 85kt vs actual 100kt.
- Blast furnace slag usage reduced due to availability.
- Received a government grant for front alternative fuel and raw materials.

Powering the Regions Funding grant

- The grant is from the Federal Government's Powering the Regions Fund.
- The kiln feed optimisation project at our Berrima Cement Works will play a key role in our decarbonisation by reducing process emissions.
- The project will allow us to significantly reduce our CO2 emissions from cement manufacturing by up to 100,000 tonnes per annum, based on predicted production rates.
- The integration of the specialised grinding circuit will help us substantially increase the proportion of alternative raw materials in kiln feed to up to 23 per cent, up from its current 9 per cent capability, and subsequently lower the amount of limestone used.
- As an added benefit, alternative raw materials also require lower heating temperatures and therefore, lower energy intensity.
- We have plans to use a range of by-products from the steel manufacturing process and industrial waste rejections, including granulated blast furnace slag, steel slag, cement fibre board, fly ash, and fine aggregates from recycled concrete.
- The funding will allow our teams to progress to the next phase of detailed process designs for front-end engineering, followed by procurement, construction, installation, and commissioning. It is expected to be fully operational in 2028.

Berrima Cement annual shutdown

- Each year, our Berrima site undergoes an intensive annual shutdown. A critical operation that ensures the plant runs efficiently, safely, and reliably for the year ahead.
- This complex event involves months of planning, precise execution, and the combined efforts of hundreds of people from diverse teams in Berrima and across the business.
- The planning involves developing a list of tasks to be completed in the shutdown based on previous shutdowns, our routine maintenance schedules, or any emerging issues identified through inspections throughout the year.



**Building
something
great**

- The project includes major equipment overhauls, refractory work in our cement kiln, mechanical and electrical upgrades, and capital project installations. This year, for example, we had planned to replace 48 metres of kiln brick lining, with inspections of the kiln lining status, meaning that might extend to a further 10 metres. Major capital work took place to replace the alternative fuel feeding system bin by using 500-tonne crane.
- Duration 23 days (including cooling down and commissioning), with daily meetings to review prior day and set plans for day ahead.)
- Contractors on site around 300 but up to 500 at peak times.
- A video is available here [**Million-Dollar-A-Day Shutdown of our Berrima Cement Kiln**](#)

Colliery pit top treatment and pipeline

Boral has been working for the last few years on a plan to:

Install a water treatment system at Berrima Colliery pit top, to treat mineralised groundwater; and

- Construct an underground pipeline, within an easement held by Boral, to transfer treated water to the Berrima cement works for production purposes.

History

- Since late 2017 we have been treating groundwater within the mine to precipitate iron and manganese minerals prior to release into the Wingecarribee River.
- Learning from our experience underground, we have developed a proposal to manage this process more effectively at the pit top.

The proposal

- The proposed pit top system will treat groundwaters by pumping them to the surface and through a system which will consist of a number of dams that will rely on aeration, limestone bedding and gravity, enabling the naturally occurring minerals such as iron and manganese to precipitate out.
- The project will provide a safer and more viable option for continued treatment of underground waters being discharged to the river.
- The surface water treatment system is expected to produce a modest improvement in water quality on a more consistent basis than the current underground limestone treatment bed.
- Most of the water from the treatment system will be released back into the Wingecarribee River near the mine access bridge, as a new Environmental Protection Agency (EPA) licenced discharge point.
- A portion of the treated water will be made available to be piped to the cement works at New Berrima for operational purposes and drought-proof the cement works operation in drier times.

Have your say

- The proposal is supported by a Review of Environmental Factors (REF) document, which is an Environmental Impact Assessment that is required to be completed by the EPA.
- The REF is publicly available for interested parties to make any submissions to Boral by 15 June 2025.
- A copy of the REF can be found at www.boral.com.au/boral-berrima-medway-colliery-and-mine.

Environmental Update

- November 2024 - Annual Noise monitoring conducted. Confirmed we continue to comply with noise requirements
- December 2024 – real time air monitoring network installed with trial on alerts being implemented
- February 2025 – Berrima Shale Pit Annual report and Forward Program issued to Resource regulator



**Building
something
great**

- March 2025 – Annual Independent audit undertaken on solid waste derived fuel suppliers to ensure compliance with standards and specifications. All found to be in compliance
- May 2025 - Operational Environment management plan has been updated as part of Modification 14 approval and the request to use AKF1. Plan has been issued to DPHI for approval

EPA and DPHI

- June 2025 – Progress Report issued to EPA on the real time air monitoring network
- Discussions are continuing with EPA and DPHI in regard to the use of Refined Heavy Fuel oil as an AKF1 fuel. (AKF1 is defined as a "non standard Fuel being liquid oily residues comprising of recovered oil from the treatment of wash waters, oils, dewatered sludges..")
- Use of AKF1 is allowed under the consent. We are currently working with the EPA and DPHI on approving the Proof of Performance Trial Plan prior to commencing.

Planning Update

Modification 14 – solid waste derived fuels (SWDF)

The NSW Department of Planning and Environment (DPE) approved Modification 14 on 28 November 2023, permitting:

- An increase in the maximum quantities of solid waste derived fuels (SWDF) permitted to be received at the site and used as a fuel in Kiln 6.
- Construction of a new site access road from Old Hume Highway for increased kiln fuel truck deliveries.
- Expansion of current SWDF storage and handling facilities.
- An increase in SWDF delivery hours to 24/7 operations.

Project link:

<https://www.planningportal.nsw.gov.au/major-projects/projects/modification-14-swdf-increase-delivery-variation-site-access>

Prospective future projects

Modify SSD consent DA85-4-2005 (Cement Mill 7) to align noise management conditions of the ball mill consent with approved site wide noise management plan – currently on hold.

Waste thermal energy recovery project – scope and planning pathway to be finalised.

Modify SSD consent DA401-11-2002-1 (Kiln 6) to increase maximum permitted granulated blast furnace slag (GBFS) raw material from 150,000tpa to 350,000tpa. Currently on hold pending review of current allowances.

Current Local Matters / Community Issues

Habitat corridor project is waiting on fence quotes to keep the cattle away from the tree planting area.

General Business

The next meeting will be held in December 2025.

Action Items

Meeting closed 11:30am.



**Building
something
great**

Boral Berrima Cement contacts:

Reception

02 4860 2222

Kate Woodbridge Stakeholder Relations Manager

0401 893 815/ kate.woodbridge@boral.com.au

www.boral.com.au/berrimacement

community@boral.com.au

Like us on Facebook: @ Boral Australia