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Berrima Cement Works Community Liaison Group Meeting Minutes

Friday 10 December 2025

Berrima Cement Works meeting room, Taylor Avenue, New Berrima

ATTENDEES

Neighbours / Community Representatives

Clive West, Berrima resident and Berrima Resident Association representative

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 – 13 June 2025

Boral to obtain a quote for the fence to protect the habitat corridor.

Operational Update

Safety

- There were no serious incidents at the site.
- A major shutdown is scheduled in January 2025.
- A kiln mini maintenance shutdown was completed in July 2025 for 8 days.

Customers and people

- There were no supply or product quality issues.
- New employees:



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- Process Chemist Manisha Patel
- Quality Product Manager Emily Samapundo

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 was achieved.
- Blast furnace slag usage reduced due to availability.
- Continue to use cement fibreboard as raw material to replace shale in clinker manufacturing process.
- Received a government grant for front alternative fuel and raw materials.

Berrima is consented to produce up to 1.56mtpa of Clinker out of Kiln 6. Over the last 5 years the volume of clinker produced has varied and is dependent on demand. As with any cement kiln worldwide, kilns are designed to operate 24/7 and throughput will flex based on demand, lower production will by its nature be slightly less efficient.

As we have ramped up our SWDF usage over the last 5 years in line with our approved conditions of consent and licence requirements we are currently close to 50% usage of SWDF which has significantly reduced our coal demand.

The reduction in coal usage has also significantly reduced our CO2e intensity per ton of Clinker.

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.



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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.

This has now been approved by the EPA. Our Project Managers are working on a detailed schedule and timeline by February for works to commence in the second or third quarter of 2026.

Environmental Update

PAST 5 MONTHS (July – November)

- November 2025 - Annual Noise monitoring conducted. Confirmed we continue to comply with noise requirements
- September 2025 National Pollutant Inventory completed for Berrima
- June 2025 EPA EPL annual return submitted
- 2024-2025 Annual Environmental Review was issued and approved by DPHI on the 28th August 2025
- Truck number report uploaded to website as required by consent
- NSF Pollutant tracking reports submitted and approved.

NEXT 6 MONTHS (December – May)

- December 2025 – final report to the EPA re real time air monitoring network
- February 2026 – Berrima Shale Pit Annual report and Forward Program to be prepared and issued to Resource regulator
- March 2026 – Annual Independent audit to be undertaken on solid waste derived fuel suppliers



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- EPL annual return to be issued for the 2025 period
- 2025 AEMR to be prepared and issued to DPHI

All environmental monitoring for dust deposition and high volume air sampling was within limits.

EPA and DPHI

Discussions have been had 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. A Proof of Performance Trial Plan will need to be approved by the EPA and DPHI prior to commencing. Approval is pending on the submission of a Fire Safety report currently being reviewed by Fire Services NSW.

In May 2025 the Operational Environment management plan was updated as part of Modification 14 approval and the request to use AKF1. This was issued to DPHI for approval. Plan approval is pending the approval of the fire safety report by Fire Services NSW.

Planning Update

Prospective future projects

Modify State significant development consent DA401-11-2002-I to permit Kiln feed optimisation project (discussed in Operations Summary), including increase in maximum permitted proportion of granulated blast furnace slag (GBFS) raw material from current 150,000tpa. Federal government grant has been secured; project scope being finalised.

Modify Council development consent 23/0337 to permit retention and ongoing operation of carbon capture plant (by removal of consent condition specifying three-year time limited consent). Modification application to be submitted to Council before March 2026, to allow ample time for determination before consent would otherwise expire on 8 September 2026.

Current Local Matters / Community Issues

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

Remembrance Driveway restoration project committee has not held a meeting this year.

Boral will hold a community open day for the residents of New Berrima and staff families.

General Business

The next meeting will be held in June 2026.

Action Items

Meeting closed 11:30am.

Boral Berrima Cement contacts:

Reception 02 4860 2222



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