

Meeting Notes

Berrima Cement Works

Meeting date	29 July 2022
Meeting location	Berrima Cement Works
Community attendees	<ul style="list-style-type: none"> • Clive West, Berrima resident and Berrima Resident Association representative • Barry Arthur, Environment Manager, Wingecarribee Shire Council • Slavica Zivkovic, New Berrima resident
Boral attendees	<ul style="list-style-type: none"> • Dean Beltrame, Operations Manager Berrima • Greg Johnson, Environmental Sustainability Manager, Boral Cement • Ben Williams, Environmental Sustainability Manager, Boral Cement • Rachel Snape, Senior Planning and Approvals Manager NSW/ACT • Jason Chandler, Head of Innovation Research and Development • Kate Woodbridge, Stakeholder Relations Manager NSW/QLD/ACT
Apologies	<ul style="list-style-type: none"> • Andrew Wood, New Berrima resident
Distribution	<p>Boral Cement Works Berrima website (www.boral.com.au/locations/boral-cement-works-berrima)</p> <p>Email to members</p>
Disclaimer	<p>These notes are taken from presentations and conversations which formed part of this meeting. The content of this document, while reflecting an accurate summary of proceedings, should not be taken to represent exact dialogue unless specifically minuted as such.</p>

Meeting commenced 10am

Welcome Participants were welcomed to the meeting.

Matters arising from previous meeting

- Facilitate access to Boral-owned land in Remembrance Driveway Grove for tree inventory –Berrima Residents Association will be setting up a plant management committee and Clive will update the group once the meeting has been held.
- Boral to provide Clive with a copy of the lease boundary that shows Borals river footprint and weir – completed.
- Boral to provide an update regarding future site development – ongoing.
- Discuss with Council including Benedicts in the Council's Sustainable Us video series on the SWDF replacement video being developed with Boral cement works – completed.
- Barry requested if Jan Campbell the economic development coordinator at Council could also attend the CLG meetings as an observer – completed.
- Kate to arrange another EOI to try and fill the vacancy on the committee – completed.
- Kate will also see if we can amend the meeting times so all members are able to attend the meeting – completed.

Operations summary

We achieved a significant milestone at the cement works when the site achieved 1000 consecutive days as injury free, but unfortunately in November we had a fall from height accident, that employee is currently recovering. There have been a further two incidents involving contractors on site. These events remind us that safety should always be at the forefront of our minds while we are at work.

There has been some industrial action at our Southern Highlands sites while the current enterprise agreement was being negotiated. That action has now been withdrawn; we are hopeful an enterprise agreement will be finalised shortly.

We have received a lot of pro-active communication from our community partners which has been appreciated, it means that when we have any issues at the site they can be resolved as quickly as possible.

There are seven long standing employees who have resigned this year, these staff have no less than 35 years of service and one with almost 50 years continued employment at Boral.

In terms of volume, it was a strong year on cement with 1.32Mt of clinker production for the year, we broke the record for production two months in a row. The cost of operating this year was \$25 million higher than previous years mainly due to increased energy costs for coal and electricity.

In 2023 the site will be looking for apprentices and will have some vacant positions to be filled.

Boral is currently undertaking significant restructuring across the business.

Work at the cement works is always continuing to improve ventilation and dust collection systems on site.

Environmental works update

The EPA Annual Return (our reporting period goes from 1 May to 30 April) was submitted on 20 June 2022. The report is publicly available and discloses non compliances and license variations. All monitoring limits were complied with. 5 complaints were received during the year, including one directly to EPA resulting in an official caution.

Two non-compliances were reported, the first was for monitoring frequency for PM10 particulates which are required every 6 days at point 2. This equates to 61 samples every year but only 59 samples were able to be collected due to an extreme rain event in February restricting access to the monitor.

An open door/hatch near Cement Mill TS-03 dust collector was unable to close due to a buildup of cement dust. An official caution was received from EPA.

We have a State Significant Development approval for Kiln 6 and Cement Mill 7 and every year we need to submit an Annual Environmental Management Report which summarizes all our operations for noise, dust and water monitoring and we have to demonstrate that we have complied with our consent conditions. The reporting period aligns with our environmental protection license. The report was submitted and accepted by DPE in June 2022. A copy of the report is available on Boral Berrima Cement webpage.

We are required to conduct two stack emission monitoring tests each year, we have done four during the last reporting period, with all tests being compliant. Continuous particulate data was also compliant.

Environmental dust data recorded from May 2018 – April 2022 shows improvements in the last few years, even with challenging weather conditions including drought, bushfires and the most recent wet weather.

To mitigate dust there are two sweepers that clean roads constantly and also a water carting truck that sprays water onto the road. This is done every few days. Weather is discussed each day at the morning meetings and a decision is made about dust mitigation each day in line with conditions.

Clive mentioned that the Wingecarribee River is a hot spot for platypus and the population is monitored twice a year by 30 volunteers, in the past there have been two to three sightings and then after the recent floods there were no sightings which was concerning. The NSW University came and did some further monitoring and they have identified six to seven separate sightings which is good news and shows the health of the river is quite good.

Proof of Performance Trials (PoPT) of high-rate refuse-derived fuel and wood waste have been undertaken on the Solid Waste Derived Fuel (SWDF) process. We are permitted by consent to use 50% by volume of fuel but we are currently limited to 40% as the original PoPT only covered SWDF at that rate. The final report is due soon and all emissions were compliant during trial.

Boral has been approved to use tyre chips as a fuel up to 30,000 tonnes per year which works at a feed rate of 4.5 tonnes an hour. We have a condition in our development application to do a trial to test feeding infrastructure into the kiln.

A total of 103 tonne of tyre chips was used in four trial runs (2 in January and 2 in July) and were undertaken at feed rates of 1t/hr, 2t/hr and 4.5t/hr. The final report is pending, however results were positive which will support our MOD to permit external storage and new feeding infrastructure.

One tonne of tyre chips can replace 1.2 tonne of coal as there is more energy in tyre chips.

Boral is looking at hydrogen as a longer-term option for fuel replacement at the site. The Cement Industry Federation and the

CCAA recently put out a report on carbon abatement for cement and concrete. With 50 – 60% of emissions due to calcination from limestone during the clinker making process and the remainder is fuel. To reduce the effects of calcination we can look at carbon capture or change the use of raw materials. The other option is fuel replacement, and we can reduce our emissions by 40% per gigajoule by changing from coal to natural gas, but it takes two years to get on the gas pipeline at this site and gas prices are not currently favorable. At the moment Boral is focused on SWDF as a replacement fuel with hydrogen being a possibility down the track.

Boral has a shale pit on site that supplies our cement works as part of the raw material that makes cement. There has been a change in regulations and as of 1 August 2022, Rehabilitation Management Plans (RMP) replace Mine Operations Plans. A RMP has been prepared and is available on the Boral Cement website. The Environmental Rehabilitation Objectives have been lodged with the Resources Regulator for approval.

Planning and projects

Project Name - Modification 14 SWDF increase, delivery variation and site access.

The project objective is to increase the volume of SWDF from 100,000tpa to 250,000tpa and an expansion of existing SWDF storage and handling facilities. The construction of an alternate access to the site from the Old Hume Highway which will run parallel but South of the Taylor Avenue entrance that we currently use. It includes an increase of 13 truck movements per day and is seeking a permit for 24 hour delivery of materials.

The modification including the Environmental Impact Statement has been lodged with the Department of Planning and was put on public exhibition from 14 to 27 April 2022 with no community submissions received. Eight agency comments seeking further information to address water, fire management and intersection design were received and we are currently working on a response to those submissions with anticipated lodgement being September – October 2022.

Project link [Modification 14 SWDF Increase, Delivery Variation & Site Access | Planning Portal - Department of Planning and Environment \(nsw.gov.au\)](#)

Project Name - Modification 15 – Tyre chip storage & feed system

The project objective is to permit a new permanent outdoor storage and feed system to support use of tyre chips as a kiln fuel. Tyre chip use is already permitted under the Kiln 6 development consent, there is no change in volume stored or used, and no increase in trucks or hours of operation.

A scoping report has been submitted and Secretary's Environmental Assessment Requirements (SEARs) were provided in June 2022. A planning report and technical assessment is currently being prepared, with lodgement anticipated in August 2022. There will be no public exhibition required due to its minimal impact assessment level.

Project link: [Berrima Cement Mod-15 - Tyre Chip Storage & Feed Infrastructure | Planning Portal - Department of Planning and Environment \(nsw.gov.au\)](#)

Project Name - Carbon Capture Pilot Plant

The project objective includes a 3 year trial to research carbon emissions reduction associated with the production/manufacture of cement. The importation of 2,000 tonnes of recycled materials (aggregate & sand). The installation of a prefabricated plant to trial sequestration of carbon into aggregates & sand. Research will focus on residence time, temperature, & water demands.

An application will be made to Council with meetings to be held with the Environment Protection Authority & Wingecarribee Council. Planning & technical reports are currently being prepared with lodgement anticipated in August 2022.

Planned applications

Ball Mill Consent (DA85-4-2005)

Modification to align noise management conditions of the ball mill consent with approved site wide noise management plan

Timing is late 2022.

Communications update Media relations – ongoing communication and announcements will be managed by Kate Woodbridge.

Local community website – Meeting minutes will be posted for 1 April 2022 meeting once accepted today.

There are currently no new community support requests or upcoming events identified but I am meeting with Council shortly to discuss any over the horizon activities

Community engagement – Kate recently met with a resident of New Berrima to discuss weed management, removal of broken signage and general care and maintenance of gardens. Kate will keep the resident updated on progress on the items identified as they occur.

A letterbox drop was done for residents in New Berrima and next week Berrima regarding the pit top treatment and pipeline in case people want more information about the project.

General business Habitat corridors along the riparian zones on Boral land – (Clive West)

Clive would like to progress the corridor development due to the time the trees can take to mature (up to 100 years) so planning needs to be commenced in the Stony Creek area.

Boral had a consultant on site in the last week to do an ecological study of vegetation for existing vegetation at the cement works and the colliery to determine a baseline of current native vegetation. That will form part of planning on the site and future works.

Boral has done significant planting at the cement works over the last decade and those plantings have progressed quite well.

Slavica would like to see more planting for screening on the New Berrima side of the cement works. Some of the pines were recently damaged in a recent storm.

Boral advised that Council has notified that it will be building a road along the boundary side of the property but there is no firm timing from Council about when that might be done.

Clive advised that the Berrima Residents Association will be lobbying for a new access from the Hume Highway to take traffic off Taylor Avenue, this is a major strategic change in the future of the shire, the residents association is concerned about increased traffic movements

over coming decades with the proposed industrial area development. Boral advised that as part of its latest Modification 15 we propose a new access road from the Old Hume Highway into the cement works to try and remove some truck movements off the public road.

A community member asked who to call when there is a noise complaint and was advised that the main office number would be best to quickly try and resolve the issue. The operations manager advised that he had received two proactive calls from neighbours during recent kiln maintenance. The site agreed that in future when there is maintenance work happening Boral will forewarn residents via email and a notice at the Post Office to people know there might be short term unusual noise with a contact number for people to use if they have any further questions or concerns.

Clive asked about support for the local Landcare network to provide tube stock for planting biodiversity corridors. A quote was provided to Boral previously for consideration. That request will be sent to the property development team to consider in the broader future master plan and we have as an action item a representative being sent an invitation to the next meeting and can revisit the request after that presentation.

Next meeting 21 October 2022
 Meeting close 10:45am

Action items arising from meeting

Action Number	Details	Responsibility	Due
1	Develop an email distribution list for alerts regarding unusual noise or maintenance that will include contact details for community enquiries.	Kate Woodbridge and CLG members	
2	Invite the Boral Property Development team to discuss the future Berrima site development plan.	Kate Woodbridge	