

**ENVIRONMENTAL PROTECTION AGENCY**

**BATNEEC GUIDANCE NOTE**

*Class 3.3*

***FERROUS METAL FOUNDRIES***

***(DRAFT 3)***

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## **1. INTRODUCTION**

This Guidance Note is one of a series issued by the Environmental Protection Agency and is designed to provide guidance to those applying for integrated pollution control licences under the EPA Act. It should also be read in conjunction with *Application Guidance Notes*, available under separate cover.

It should be noted at the outset, that noise is not included within the scope of this work and guidance on this parameter has been issued separately.

This Guidance Note is comprised of seven main sections and an appendix. Following this introduction, Section 2 contains a general note on the interpretation of BATNEEC. The industrial activity covered by the terms of this note is given in Section 3. In Section 4, the technologies to control emissions are tabulated and in Section 5 the specific emission limit values (ELVs) are given. Section 6 contains comments on compliance monitoring requirements, while the principal references are given in Section 7.

The Appendix gives the main sources of emissions, and the principal releases from such sources.

All applicants for Integrated Pollution Control licences, in the sector covered by this note, should carefully examine the information laid down in this Guidance Note, and should use this information to assist in the making of a satisfactory application for an Integrated Pollution Control licence to the Agency. It should be clearly understood that achieving the emission limit values does not, by itself, meet the overall requirements in relation to I.P.C. In addition to meeting such values the applicant will also be required to demonstrate that waste minimisation is a priority objective and to put in place particular abatement measures to reduce overall mass emissions and pollutant load where this is necessary to protect the ambient environment.

The technologies and the associated emission limit values (ELVs) identified in this Guidance Note are, at the time of writing, regarded as representing BATNEEC for new activities. BATNEEC is not a static quality and will change as technologies, environmental factors and costs alter with the passage of time. The Agency may amend or update the guidance contained in this note should such amendments seem appropriate. The information contained in this Guidance Note is intended to be used only as a tool to assist in determining the BATNEEC for an operation in this sector and should not be taken to be a definitive authority on the BATNEEC for this sector. This Note should not be considered as a legal document.

## **2. INTERPRETATION OF BATNEEC**

BATNEEC means '*the best available technology not entailing excessive costs*'. The technology in question should be **Best** at preventing pollution and **Available** in the sense that it is procurable by any person. **Technology** itself is taken as the techniques and the use of the techniques, including training and maintenance etc.

**NEEC** addresses the balance between environmental benefit and financial expense.

The objective of the Best Available Technology Not Entailing Excessive Costs (BATNEEC) Guidelines is to provide a list of technologies that will be used by the EPA to determine BATNEEC for a scheduled activity. The BATNEEC identified in this guideline is used as a basis for setting emission limit values. It is intended to update these Guidelines as required in order to incorporate technology advances as they occur.

In the identification of BATNEEC, emphasis is placed on pollution prevention techniques, including cleaner technologies and waste minimisation, rather than end-of-pipe treatment.

Technologies identified in the BATNEEC guidelines are considered to be the current best practice for the purposes of setting emission limit values. These technologies are representative of a wide range of currently employed technologies appropriate to particular circumstances. However, the guidance issued in this note in respect of the use of any technology, technique or standard does not preclude the use of any other similar techniques which may achieve the same emission. The entire range would not necessarily be appropriate in specific cases. The specific choice depends on a wide range of circumstances but the crucial factor is that the selected regime achieves BATNEEC. In applying BATNEEC, Environmental Quality Objectives (EQO's) must be respected where set. Measures such as in-plant changes, raw material substitution, process recycling and improved material handling and storage practices, may also be employed to effect reductions in emissions. As well as providing for the installation of equipment and the operation of procedures for the reduction of possible emissions, BATNEEC will also necessitate the adoption of an on-going programme of environmental management and control, which will focus on continuing improvements aimed at prevention, elimination and/or progressive reduction of emissions.

As described in the EPA Act of 1992, BATNEEC will be used to prevent, eliminate or where that is not practicable, limit, abate, or reduce an emission from an activity which is listed in the first schedule to the Act. The use of BATNEEC is construed in the Act to mean the provision and proper maintenance, operation, use and supervision of facilities which are the most suitable for the purposes.

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In determining BATNEEC for an activity, regard shall be had to :

- the current state of technical knowledge;
- the requirements of environmental protection;
- the application of measures for these purposes, which do not entail excessive costs, having regard to the risk of significant environmental pollution which, in the opinion of the agency exists.

For existing facilities, additional regard shall be had to :

- the nature, extent and effect of the emission concerned;
- the nature and age of the existing facilities connected with the activity and the period during which the facilities are likely to be used or to continue in operation, and
- the costs which would be incurred in improving or replacing these existing facilities in relation to the economic situation of activities of the class concerned.

The technologies and the associated emission limit values (ELVs) identified in this Guidance Note are regarded as representing BATNEEC. It is generally envisaged that these emission limit values will gradually be extended to existing facilities. However the specific licence requirements and associated time frames will be identified when the licence is processed. Additional and more stringent requirements may be specified on a site-specific basis.

Where an operator of an existing facility predicts that it will be difficult to meet the emission limit value within the specified time-frame, he will be required to satisfy the Agency as to the reasons why the requirements cannot be met. The applicant will be required to submit an environmental management plan which will give consideration to the following, in order of priority:

- waste reduction/source elimination;
- waste recovery;
- Proposed and alternative treatment technologies and predicted performance data;
- Proposed and alternative waste disposal options.

This management plan must propose a revised time-frame for the achievement of emission limit values as set out in this Guidance Note.

The BATNEEC Guidelines are not the sole basis on which licence emission limit values are to be set, since information from other sources will also be considered, including site-specific environmental and technical data, plant financial data and other relevant information.

### **3. SECTOR COVERED BY THIS GUIDANCE NOTE**

This Guidance Note covers SECTOR 3.3 of the activities specified in the First Schedule to the EPA Act 1992. These are:

***3.3. The production, recovery, processing or use of ferrous metals in foundries having melting installations with a total capacity exceeding 5 tonnes.***

## 4. CONTROL TECHNOLOGIES

### 4.1 INTRODUCTION

As explained in Section 2, this Guidance Note identifies BATNEEC for a new activity, but obviously does so in the absence of site-specific information. Accordingly it represents the minimum requirements expected of any new activity covered by the Note, but does not exclude additional requirements which may form part of the granting of a licence for a specific site.

The approach to be used in selecting BATNEEC is based on the following hierarchy:

- Process design / redesign changes to **eliminate** emissions and wastes that might pose environmental problems.
- **Substitution** of materials (e.g. non-solvent degreasing agents) by environmentally less harmful ones.
- Demonstration of waste **minimisation** by means of process control, inventory control and end-of-pipe technologies etc.

The existing or possible measures for reducing and controlling emissions are described in this section. These range from relatively simple containment measures to sophisticated recovery and "end-of-pipe" technologies and include:

- (i) Load Minimisation
- (ii) Containment
- (iii) Recovery/recycle
- (iv) Emission reduction
- (v) Waste treatment & disposal

The measures listed below are all in place in existing plants in Europe. At the very least, therefore, the technical feasibility of the measures has been demonstrated. These, used singly or in combination, represent BATNEEC solutions when implemented in the appropriate circumstances. The circumstances depend on plant scale, materials used, nature of the products made etc. A summary of the treatments for various emissions is given at the end of the section.

Note that where flammable/explosive vapours or dusts are handled, safety procedures (acceptable to HSA) should be adopted and nothing in this note should be construed as advice to the contrary.

#### **4. 2 TECHNOLOGIES FOR LOAD MINIMISATION**

(No priority ranking is intended, and the appropriate selection in a particular case will depend on the specifics of the process concerned and environmental site constraints).

- Use of high quality scrap of known composition. (No radioactive materials).
- Bunding of all stored materials with separate bunding for incompatibles.
- Inventory control.
- Optimisation of water recirculation and reuse.
- Dry equipment cleaning and dry vacuum systems, where feasible.
- Separation of cooling water, storm water and abatement/recovery process effluents of different origin in order to permit appropriate treatment options.
- Design of fume arrestment plant to avoid possibility of overload during high temperature operation.
- Selection of dry filtration is preferred to wet scrubbing.
- Cupola/furnace off-gases (e.g. H<sub>2</sub>, CO, H<sub>2</sub>S, VOCs) to be burnt at post-combustion stage, prior to final filtration.
- Use of non-aqueous sand reclamation techniques (e.g. abrasive etc.)
- Continuous desulphurisation during pouring is preferred (fully enclosed with extraction and dry filtration).
- Heat treatment furnace burner design for low NO<sub>x</sub> emissions.
- Dry gas cleaning and dry sand reclamation preferred.

#### **4. 3 CONTAINMENT OF EMISSIONS:**

(No priority ranking is intended, and the appropriate selection in a particular case will depend on the specifics of the process concerned and environmental site constraints).

- Fumes from desulphurisation process to be directed back to cupola/furnace.
- Local extraction to capture dust and vapour releases during mould preparation.
- Bag filtration to be used on local extraction for vibrating table knock-out.
- Overground pipelines and transfer lines.
- Totally enclosed belt conveyors.
- Enclosure with local extraction to dust arrestment (of materials, storage, handling and transfer).
- Use of granular raw materials preferred to fine powders.
- No dry sweeping or washing of spillages - vacuum systems preferred.
- Overfilling protection on bulk storage tanks.
- Prevention of rain ingress, wind entrainment etc. for stored materials, where appropriate (e.g. hydrocarbon contaminated scrap).
- Secondary fume containment by full or partial sealing of furnace building roof with high level extraction.
- Cupola emission to be controlled by cyclone, post combustion system, heat exchanger and bag filter.
- Moulds should move under a pouring station, which can be more easily extracted (rather than a moving ladle).



- Shot-blasting to be carried out in a totally enclosed system extracted to a filter unit.

#### **4. 4 TECHNOLOGIES FOR RECOVERY AND RECYCLE:**

(No priority ranking is intended, and the appropriate selection in a particular case will depend on the specifics of the process concerned and environmental site constraints).

- Heat recovery.
- Sand recycle and reuse (with fines removal).
- Reuse of metal wastes (finishing etc.) in furnace/cupola.
- Recycle of water as make up for core, mould and chemical preparation.

#### **4. 5 SPECIFIC TECHNOLOGIES FOR TREATING AIR EMISSIONS:**

(No priority ranking is intended, and the appropriate selection in a particular case will depend on the specifics of the process concerned and environmental site constraints).

- Cyclones (T1).
- Filtration (fabric filters normally adequate) (T2).
- Electrostatic precipitators (T3).
- Incineration (subject to separate Guidance Note) (T4).
- Adsorbers (carbon adsorption or peat beds) (T5).

#### **4. 6 SPECIFIC TECHNOLOGIES FOR TREATING WATER EMISSIONS**

(No priority ranking is intended, and the appropriate selection in a particular case will depend on the specifics of the process concerned and environmental site constraints).

- Coagulation/flocculation/precipitation (F1).
- Sedimentation/filtration/flotation (F2).
- pH correction/neutralisation (F3).
- Activated carbon (F4).

**4.7 SPECIFIC TECHNOLOGIES FOR THE TREATMENT AND DISPOSAL OF WASTES:**

(No priority ranking is intended, and the appropriate selection in a particular case will depend on the specifics of the process concerned and environmental site constraints).

**4.7.1. Sludge Treatment**

- Dewatering.
- Filtration.
- Centrifugation.

**4.7.2. Disposal**

- Waste encapsulation
- Engineered landfill of wastes
- Solidification

**Table 4. 1 - Summary of Technologies for Treating Emissions to Air**

<b>Emissions</b>	<b>Treatment</b>
Particulate, Metals, Metal Oxides.	T1, T2, T3
Organic compounds	T4, T5
Sulphur Oxides	Fuel and Raw Material Selection
Nitric Oxides	Burner/Furnace Technology
H <sub>2</sub> , CO, H <sub>2</sub> S	T4
Odour	T4, T5

**Table 4. 2 - Summary of Technologies for Treatment of Water Emissions**

<b>Emission</b>	<b>Treatment</b>
Particulates	F1, F2, F3
Resins, binders, etc.	F1, F4

## **5. EMISSION LIMIT VALUES**

### **5.1 REFERENCE CONDITIONS**

The reference conditions for concentrations of substances in emissions to air from contained sources are:

Temperature 273 °K; Pressure 101.3 kPa; no correction for water vapour content.

These units and reference conditions may not be suitable for continuous monitoring methods and may, by agreement with the Agency, be converted for day to day control purposes into values more suitable for the available instrumentation.

### **5.2 INTERPRETATION OF COMPLIANCE**

#### **5.2.1 Emissions to Air**

For **continuously monitored** emissions, the following will be required for compliance with measurements based on 30 minute mean values (unless otherwise stated):

- (i) 97% of all 30 minute mean measurements shall be below 1.2 times the emission limit.
- (ii) No 30 minute mean measurement shall exceed 2.0 times the emission limit.
- (iii) All daily mean values shall be less than the emission concentration limit.

Where **periodic monitoring** is used to check compliance, all samples should meet the consent conditions.

#### **5.2.2 Emissions to waters**

The limit values for discharges to water are based on 24 hour flow proportional composite samples taken over a representative production period.

### 5.3 EMISSIONS TO AIR

Emissions to air under normal operation, including start-up and shutdown, should be free from visible smoke and should not give rise to a nuisance odour detectable beyond the site boundary. Table 5.1 contains the emission limit values.

**Table 5.1 - Emission Limit Values for Emissions to Air**

Substance	Concentration
Particulate matter (mg/m <sup>3</sup> )	20
Metals	As per T.A. Luft 1986
VOCs	As per T.A. Luft 1986
Dioxins (as TEQ) (ng/m <sup>3</sup> )	1.0

**NOTE 1:** Achievement of ELV concentration by the introduction of dilution air is not permitted

#### **NOTE FOR TABLE 5.1**

1. Where organic substances of several classes are present, in addition to the above limit, the sum of Classes 1 & 2 shall not exceed the Class 2 limit and the sum of Classes 1, 2 & 3 shall not exceed the Class 3 limit etc.
2. Fugitive solvent emissions should comply with the requirements of proposed E.C. Solvent Directive or licence as appropriate.
3. It should be noted that at the time of licensing - emissions which fall below the Mass Emission threshold may be considered to minimise these as much as possible.

### 5.4 RELEASES TO WATER

Effluent should be minimised by recycling and re-use wherever practicable. The use of lower quality water may be possible for some parts of the process rather than fresh water.

All releases to waters are subject to a licence from the Agency. However any discharge to sewer will require the consent of the local authority or sewerage undertaker. BATNEEC to minimise the release of substances will generally include minimisation at source and either specific treatment of contaminated waste streams to remove particular substances or co-treatment of combined effluent

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streams or both. The Emission Limit Values for effluent discharges to waters are set out in Table 5. 2.

**Table 5.2 - Emission Limit Values for Discharges to Water\***  
(These values apply prior to any dilution with e.g. uncontaminated stormwaters or cooling waters)

<b>Constituent Group or Parameter</b>	<b>Limit Value</b>	<b>Notes</b>
pH	6 - 9	3
BOD (mg/l )	25	3
Number of Toxicity Units	1	1,3
Total Ammonia (mg/l as N)	5	3
Mineral Oil (interceptors) (mg/l)	20	3
Phenols (mg/l)	1.0	3
Cadmium (µg/l monthly average)	10	3
Fish Tainting	No tainting	2
Mercury (µg/l monthly a	5	3
EC. List 1	As per 76/464/EC and amendments	
Other Parameters	As per Licence dependent on Resins and Binders used.	

\* All values refer to daily averages, except where otherwise stated to the contrary, and except for pH which refers to continuous values.

**Notes for Table 5. 2:**

1. The toxicity of the effluent shall be determined on an appropriate aquatic species. The number of Toxicity Units (TU) = 100/96 hr LC50 in percentage vol/vol. so that higher TU values reflect greater levels of toxicity. For each TU at least 20 dilutions of the effluent volume must be available in the receiving system.
2. No substance shall be discharged in a manner which, or at a concentration which, following initial dilution causes tainting of fish or shellfish, interferes with normal patterns of fish migration or which accumulates in sediments or biological issues to the detriment of fish, wildlife or their predators.
3. Consent conditions for these parameters for discharge to municipal treatment plants can be established with the Licensing Authority, and different values may apply.

## **6. COMPLIANCE MONITORING**

The methods proposed for monitoring the emissions from these sectors are set out below.

### **6.1 EMISSIONS TO AIR**

1. Continuous particulate monitoring on cupola emissions.
2. Periodic monitoring, (taking account of the nature, magnitude and variability of the emission) of particulates from dust arrestment plant, and of VOCs, HCN, NH<sub>3</sub>, H<sub>2</sub>S, HCHO, dioxins etc. from mould preparation, ovens etc.
3. Weekly maintenance inspections of all air handling plant (including pressure drop tests across filters).

### **6.2 WASTE WATER DISCHARGES:**

1. Establish existing conditions prior to start-up, of key emission constituents and salient flora and fauna.
2. Daily monitoring of flow and volume, continuous monitoring of pH. Monitoring of other relevant parameters as deemed by the Agency.
3. Monitoring of influent and effluent from the waste water treatment plant to establish an early warning of any difficulties in waste water treatment plant, or unusual loads.
4. Periodic fish tainting and toxicity tests where appropriate, taking account of the nature, magnitude and variability of the emission and the reliability of the controls.

### **6.3 SOLID WASTE MONITORING:**

1. The recording in a register of the types, quantities, date and manner of disposal of all wastes.
2. Leachate testing of sludges and other material as appropriate being sent for landfilling.

## **7. REFERENCES**

### **7.1 IRELAND**

7.1.1 Air Pollution Act, 1987.

7.1.2 Environmental Protection Agency Act, 1992.

7.1.3 Local Government (Water Pollution) Acts 1977 and 1990.

### **7.2 U.K. H.M.I.P. CHIEF INSPECTORS GUIDANCE TO INSPECTORS**

7.2.1 Industry Sector Guidance Note IPR 2/2 (Draft - 14/2/94)  
(Iron and Steel Making Processes - Ferrous Foundry Processes).

### **7.3 GERMANY**

7.3.1 T.A. Luft 1986.



## **Appendix 1**

### **MAIN EMISSIONS**

#### **1 INTRODUCTION:**

In this section, the major sources of emissions to air and water are identified, as are the principal sources of waste from the sector. It should be borne in mind that the identified list of sources is not all encompassing, nor will every plant falling within an individual sector have every one of the emissions which are associated with the sector as a whole.

For each subsector, emissions to air and water are considered under two headings, the first covering fugitive and unscheduled emissions and the second specific process emissions. Some of the latter are considered to have little potential environmental significance and these are designated as minor (m) and are not assigned emission limit values. A summary of the constituents of each significant release is given at the end of the section.

#### **2 SOURCES OF EMISSION TO AIR FROM:**

##### **2.1 Fugitive and Unscheduled Emissions**

- Fugitive emissions of particulate matter from loading, unloading, storage and handling of solid materials.
- Vapour and odour losses during storage, filling and emptying of bulk binder, resin etc. tanks and bunds, including hose decoupling.
- Leakages from flanges, pumps seals, valve glands etc..
- Building losses, through windows, open doors, vents.
- Workplace losses through ventilation.
- Slag and waste handling.

## **2.2 Process Emissions (Symbols refer to Table A1)**

- Furnace/cupola emissions (S1).
- Desulphurisation of molten iron (S2).
- Core and mould preparation (S3).
- Casting (S4).
- Knock-out and reclamation (S5).
- Finishing (S6).

## **3 SOURCES OF EMISSIONS TO WATER FROM: (SYMBOLS REFER TO TABLE A2)**

### **3.1 Spills and Diffuse Sources**

- Bund drainage.
- Spillages.
- Leakages from flanges, pump seals, glands etc.
- Contamination of surface water through outdoor storage..
- Pipework leaks.

### **3.2 Processes Emissions**

- Mould preparation (E1).
- Effluent from abatement systems (e.g. wet scrubbers etc.) (E2).
- Sand Reclamation (E1).
- Laboratory effluent (m).

**4. SOURCES OF WASTE FROM: (SYMBOLS REFER TO TABLE A3)**

- Desulphurisation slag and dust (W1).
- Mould waste (W2).
- Refractory linings (W3).
- Cupola arrestment sludge (W4).
- Cupola/furnace slag (W5).
- Contaminated drums, filters, equipment, packaging and protective clothing(W6).
- Sand (W2).
- Finishing wastes (W5).

## **5 RELEASES**

The substances most likely to be present in the release to the environment and of principal concern in the processes covered by this note are given below. A licence applicant should identify and quantify all environmentally significant emissions (including heat discharges) from the process.

**Table A1 - Summary of Sources and Emissions to Air**  
(Symbols refer to Section 2 in Appendix)

<b>Source</b>	<b>Emission</b>
S1	SO <sub>x</sub> , NO <sub>x</sub> , CO <sub>2</sub> , CO, H <sub>2</sub> , iron oxides, Al <sub>2</sub> O <sub>3</sub> , CaO, ZnO, particulates (incl. Cd, Pb) VOCs (incl. dioxins), H <sub>2</sub> S.
S2	SO <sub>x</sub> (minor), CO <sub>2</sub> , CO, iron oxides, Al <sub>2</sub> O <sub>3</sub> , CaO, ZnO, particulates
S3	Particulates, odours, NH <sub>3</sub> , HCN, amines, amides, VOCs, acid vapours, furnace gases (SO <sub>x</sub> , NO <sub>x</sub> , etc.)
S4	Particulates (iron oxides, Al <sub>2</sub> O <sub>3</sub> , CaO, ZnO,) odour (amines, amides, VOCs (incl. dioxins) acids)
S5	CO, particulates, VOCs (minor)
S6	Particulates, over/furnace off gases (from gas or oil firing)

**Table A2 - Summary of Sources and Emissions to Water**  
(Symbols refer to Section 3 in Appendix)

<b>Source</b>	<b>Emission</b>
E1	Resins, binders, etc.
E2	Iron, metal oxides, metals

**Table A3 - Summary of Other Releases**  
(Symbols refer to Section 4 in Appendix)

<b>Source</b>	<b>Emission</b>
W1	Calcium sulphide
W2	Sand, phenolics, binders etc.
W3	Brickwork
W4	Zn, Pb, alkali metal chlorides, etc.
W5	Metal oxides, iron
W6	Process chemicals