

## Stakeholder Engagement and Grievance mechanism

### How to Register a Grievance?

There are several ways to submit a grievance (complain, recommendation, suggestion, question) to Salonit Anhovo for registration and resolution:

➔ By sending a completed Grievance Form to our office: postal address: Anhovo 1, 5210 Deskle, Slovenija;

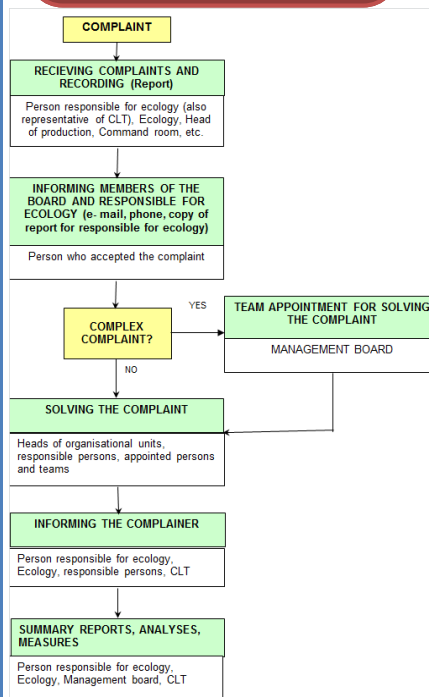
➔ By contacting our Liaison Team or Comand Room  
T: (05) 39 21 510 (Representative of the Liaison Team)

T: (05) 39 21 408 (Command Room—Internal Intervention Center)

➔ By sending an email to the following address: okolje@salonit.si

➔ By registration of grievance forms filled with contact details to the public authorities of Kanal and Anhovo-Deske Districts and Kanal ob Soči and Deskle municipalities (empty forms available in their offices).

### Grievance Procedure



Each grievance will be answered in maximum 7 days. In case the complexity of the grievance requires longer investigation, the complainer will be informed in writing about the progress of the assessment and an estimative time for providing an answer.

### How you can learn more about use of AF by Salonit Anhovo?

- ★ Participate to *Open day's* events by Salonit;
- ★ Send your opinion to Working Group members and Municipalities representatives;
- ★ Track the news in media (local newspapers, radio & TV, press conference, Naš list);

- ★ Read the documents and announcements posted on Salonit's website: [www.salonit.si](http://www.salonit.si);
- ★ Read the hard copies of the documents available at municipalities' offices;
- ★ Track the air measurements result displayed online in Kanal ob Soči and Deskle towns.

## Use of ALTERNATIVE FUELS (AF)

### Non-Technical Summary: Technological Upgrade to Enable Increased Share of Alternative Fuel Use

#### Background

In the early 2000s Salonit identified that the efficient use of resources is a vital condition to be met by the company in order to stay competitive and continue its activity as an important industrial operator in Slovenia and the region.

To achieve this, the company initiated an ambitious program of continuous improvement by investing in the latest technology. Today, the cement production line is one of the most efficient in Europe and allow the company to respect the environmental conditions and performance targets set by authorities, regulations and industry best practice.

Investments completed to date also resulted in the reduction of the air emissions, noise levels and wastewater discharges. Today the company is allowed to use annually up to 108.960 tonnes of different types of wastes.

A step in this continuous improvement program is the "3D Feed and Chlorine Bypass" Project scheduled in 2016 which will allow the company using alternative fuels more efficiently and in increased quantities.



#### AF Co-processing

★ The thermal utilization of specific wastes as alternative fuels started in cement plants approximately 30 years ago;

★ With co-processing of alternative fuels the share of fossil fuels is lowered – natural sources are preserved;

★ In cement plants the co-processing of is considered as energy and material recovery (recycling), because the rest of burning (mineral matter) is built into clinker and no additional waste is produced;

★ Improve process stability of the technological process with positive effects on the environmental performance;

★ Reduce of air emissions.

#### Fuels in industry

##### Fossil fuels:

- ☐ Coal
- ☐ Petrol coke
- ☐ Natural gas (for starting kiln preheating)

##### AF:

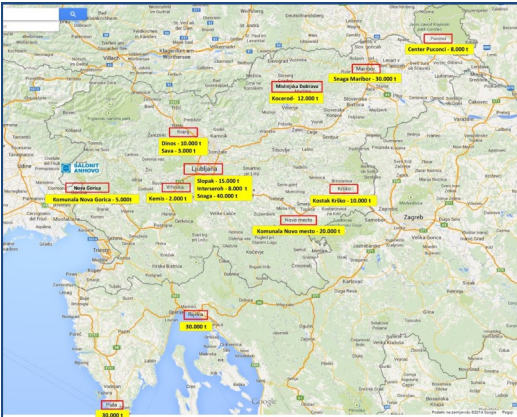
- ☐ Solid Recovered fuels (2D and 3D)
- ☐ Waste oil
- ☐ Waste tires
- ☐ Dried sewage sludge
- ☐ Animal meal



## Supply and storage of AF

Different types of non-hazardous and hazardous wastes are permitted for use at the facility. Salonit mainly uses end-of-life tyres, finely shredded wood, cardboard paper, textiles and plastic wastes, sewage sludge, animal meal and used oils. Construction of closed systems and buildings will ensure among others protection against odor emissions.

Based on the present market situation and future projections for **Slovenian market** there is a long-term availability of solid waste materials that could be used by Salonit (109,000 t/year).



The wastes delivery is based on written agreements specifying suppliers' responsibilities regarding wastes shipment to Salonit. Clearly defined procedures for assessment and approval of all new materials and fuels are in place and responsibilities clearly defined and allocated.

The procedural steps for approval of a new AF supplier are the following: Collection and assessment of potential new fuel/waste material; Visit of production site, assessment of reliability of supplier and quality of waste; Internal approval; Assessment of all information collected during; Preparation of fuel acceptance criteria with limit values and technical specification requested; Final approval of new material/fuel.

## Regulating use of AF

→ The EU's Waste Incineration Directive strictly regulates the use of AF in the cement manufacturing industry.

→ Environmental (IPPC) Permit valid by October 2020, which permits the use of AF and regulates implementation of the technological upgrades to enable increased share of AF. The impact assessment for increased use of AF was assessed and approved during the procedure of issuance the IPPC Permit. (no separate EIA required and no Natura2000 natural protected areas affected).

→ Best Available Techniques (BAT) Reference Document for the Production of Cement. European Commission, Joint Research Centre, 2013.

→ Technical guidelines on the environmentally sound co-processing of hazardous waste in cement kilns" adopted by the Basel

**Note:** Cement kiln in Salonit is designed for safe and efficient utilization of alternative fuels (AF). The design respects all the relevant guidelines for safe utilization of AF.

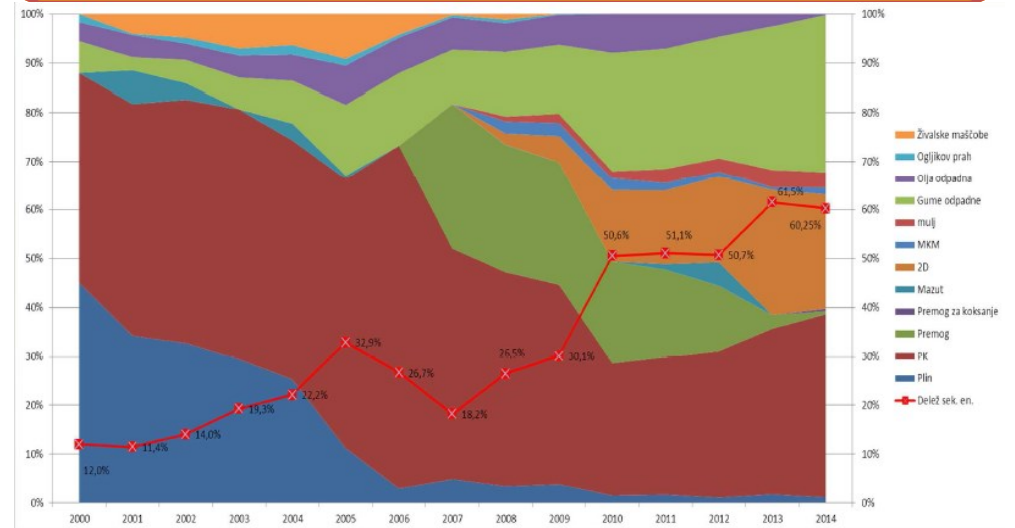
**Salonit has all the necessary permits for AF co-processing including planned extension of the system. In the process of permit issuing the system for AF utilization was checked several times by different competent authorities.**

## AF use shares

**Today:** 63% of the heat for cement manufacturing from AF

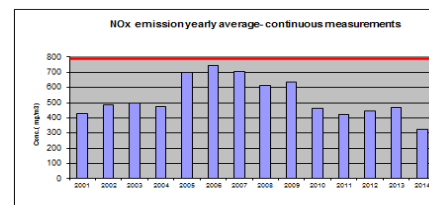
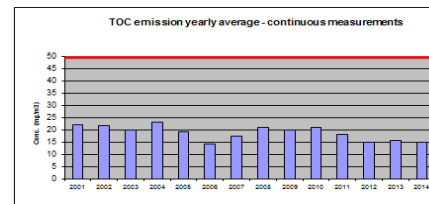
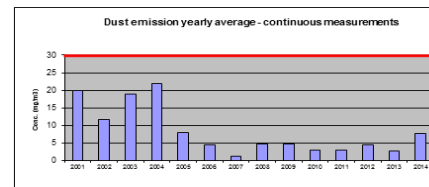
**Proposed:** increase up to 75%

## Use of fuels in Salonit Anho



**Legend:** Mazut = heavy oil; Plin = gas; zivalske mascebe = animal fat; ogljikov prah = carbon powder; olja odpadna = used oil; gume odpadne = used tires; mulj = sludges; premog za koksanje = coking coal; delez sek en = Alternative fuels share

## Evolution of air emissions values at certain parameters in Salonit



## PM10 in ambient

★ Air quality around Salonit cement plant is better than in most other areas in Slovenia and Europe and represents no or negligible health risks (according to WHO reference levels).

★ Although AF substitution rate was increased in the past years emissions were decreased and outdoor air quality was improved.

