ADITYA BIRLA

UltraTech

UTCL/BKCW/ENV/43 **29th Aug'2023**

Member Secretary
Chhattisgarh Environment Conservation Board,
Paryavas Bhavan, North Block Sector - 19
Atal Nagar, Nava Raipur, Raipur(C.G.), 492002

Sub :- Environmental Statement for Cement Plant (Clinker 16.7 LTPA & Cement 24.0 LTPA) for the year 2022-23

Ref :- CTO condition no. 12 (Water) & 13 (Air) vide letter no. 2857 /TS/CECB/ 2021 Nava Raipur Atal Nagar, Dated 29/07/2021

Dear Sir,

With reference to the above, we are enclosing herewith, copy of Environmental Statement for **Cement Plant (Clinker 16.7 LTPA & Cement 24.0 LTPA)** for the financial year 2022-23. The statement has been prepared as per the format prescribed by the Board.

Kindly acknowledge the receipt.

Thanking you

Yours Faithfully
For UltraTech Cement Limited.
Unit: Baikunth Cement Works
(Formerly Known as Century Cement)

Debnath Guha
Unit Head

Encl. As above

Copy To
1. Regional office (MoEF, IRO) Aranya bhavan North Block, Sector19 Naya Raipur Atal Nagar Raipur (CG) 492002.
2. The Regional Officer, Chhattisgarh Environment Conservation Board, Commercial Complex Premises, Kabir Nagar Housing Society, Raipur (CG) - 492099.
3. The Regional Director (Central), CPCB, Parivesh Bhawan, Paryavaran Parisar, E-5, Arera Colony, Bhopal (M.P.) – 462016

ULTRATECH CEMENT LTD., UNIT-BAIKUNTH CEMENT WORKS

FORM V

(See rule 14)

Environmental Statement for the financial year 2022-23 ending on 31st March'2023

PART - A

1.	Name and address of owner/occupier of the industry operation or process	**Mr. Debnath Guha**, Unit Head UltraTech Cement Ltd., Unit-Baikunth Cement Works (Formerly Known as Century Cement) P.O. Baikunth, Dist. - Raipur Chhattisgarh – 493 116
2.	Industry Category	Red
3.	Production Capacity	Clinker 16.7 LTPA Cement 24.0 LTPA
4.	Year of Establishment	1974
5.	Date of the last environmental statement submitted	12th Sep'2022

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PART - B

Water & Raw Material Consumption

(i) Water Consumption (m^3/Day): -

Water Consumption	During the FY 2021-22	During the FY 2022-23
Process	Nil	Nil
Cooling / Spraying	1551	1465
Domestic	613	565

Note: Process water is not required as cement manufacturing is dry.

Sl no.	Name of product	Water consumption per MT of Product	
		During the FY 2021-22	During the FY 2022-23
1.	Portland Cement	413 Ltrs. /MT	398 Ltrs. /MT

(ii) Raw Material Consumption in Cement Plant

Name of Raw Materials	Name of Product	Consumption of Raw Material per ton of product	
		During the financial year 2021-22	During the financial year 2022-23
Limestone	Clinker	1.40	1.38
Iron Ore	Clinker	0.0046	0.0038
Coal	Clinker	0.1152	0.1129
Gypsum	Portland Cement	0.0268	0.0338
Fly Ash	PPC	0.3355	0.3474
Fly Ash	Composite Cement	NIL	0.3468
Slag	Composite Cement	NIL	0.2475
Slag	PSC	NIL	NIL

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PART – C
Pollution generated
Pollution Discharged to Environment / Unit of Output
(Parameters as specified in the consent issued)

(a) Water Pollution

Industrial

The wastewater generated from the DM plant and blowdown is being treated in a neutralization Pit, and the treated water is used in dust suppression.

Domestic

We have installed 3 Nos of MBBR technology-based Sewage Treatment Plants with a 2x250 KL/Day capacity and 60 KL/Day capacity. The treatment process/system employs thousands of polyethylene biofilm carriers operating in mixed motion within an aerated wastewater treatment basin. Each individual bio carrier increases productivity by providing a protected surface area to support the growth of heterotrophic and autotrophic bacteria within its cells. This high-density population of bacteria achieves high-rate biodegradation within the system while offering process reliability and ease of operation. The sludge generated can be used as manure.

Sewage Treatment Plants (STP 1 and 2) - 2 x 250 KL/Day

Sewage Treatment Plant (STP 3) - 60 KL/Day

Treated effluent is being used for plantation and dust suppression, and treated water is being used for horticulture.

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Pollutants	Quantity of Pollutants discharged/generated (mass/day)	Concentration of pollutants in discharges (mass/volume)	Percentage of variation from prescribed standards with reasons
Given in Table (1)			

Table 1: - Sewage Treatment Plant – Outlet Water Quality - 2022-23

Month	**STP-1 (Near Worker Colony)**				**STP-2 (Near Temple)**				**STP-3 (Plant)**			
	pH	**SS**	**COD**	**BOD**	**pH**	**SS**	**COD**	**BOD**	**pH**	**SS**	**COD**	**BOD**
Unit		**mg/l**	**mg/l**	**mg/l**		**mg/l**	**mg/l**	**mg/l**		**mg/l**	**mg/l**	**mg/l**
Limit	**5.5-9.0**	**100.0**	**250**	**30**	**5.5-9.0**	**100.0**	**250**	**30**	**5.5-9.0**	**100.0**	**250**	**30**
Average	7.35	45.37	35.16	12.16	7.82	56.88	41.18	13.43	7.51	42.61	41.05	13.04
Minimum	7.34	42.00	33.00	9.30	7.66	52.00	33.00	11.20	7.36	40.20	39.00	12.00
Maximum	7.74	48.00	37.00	14.00	7.97	59.40	44.00	14.10	7.65	46.54	43.00	15.00

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(b) Air Pollutants

(i) **Stack Emission**

Sl. No.	Dust Collector attached to unit	Limit, as per CTO,	Emissions Level		
			Average	Min	Max
	Unit-----→	mg/Nm3			
1.	Raw Mill No. 1	30	18.38	17.65	19.16
2.	Raw Mill No. 2	30	18.34	15.21	20.12
3.	Raw Mill No. 3	30	18.78	17.68	20.24
4.	Raw Mill No. 4	30	18.66	17.12	20.02
5.	Kiln No. 1 (K-Line)	30	19.58	18.63	20.53
6.	Kiln No. 1 (C-Line)	30	20.49	19.24	21.17
7.	Cooler ESP-1	30	18.46	17.26	20.13
8.	Kiln No. 2 (K-Line)	30	20.73	19.97	22.53
9.	Kiln No. 2 (C-Line)	30	19.00	15.21	20.76
10.	Cooler ESP-2	30	19.00	14.83	22.01
11.	Coal Mill No. 1	30	19.65	18.25	21.08
12.	Coal Mill No. 2	30	18.46	17.55	20.04
13.	Coal Mill No. 3	30	19.11	17.75	20.71
14.	Coal Mill No. 4	30	19.54	17.64	20.92
15.	Cement Mill No. 1	30	18.83	16.31	20.65
16.	Cement Mill No. 2	30	19.70	17.18	21.26
17.	Cement Mill No. 3	30	20.00	18.75	21.04
18.	Cement Mill No. 4	30	20.42	19.15	21.29
19.	Cement Mill No. 5	30	19.91	18.98	20.44

(ii) **AMBIENT AIR QUALITY**

Ambient Air Quality Data during 2022-23

Location →	Near 132 KV Sub Station			Behind Workshop			Near Fabrication Yard			Near Canteen		
Parameters ↓	Min	Max	Avg	Min	Max	Avg	Min	Max	Avg	Min	Max	Avg
	All values are in µg/m³.											
PM10	44.30	65.41	54.98	40.19	63.92	55.19	45.27	68.75	51.91	44.89	64.45	53.98
PM2.5	23.91	37.05	31.06	21.36	36.05	30.61	24.85	38.55	31.12	24.68	35.26	30.71
SO2	9.35	13.03	10.73	8.18	11.06	9.94	8.11	11.01	9.78	9.23	11.03	10.06
NO2	18.90	24.15	21.56	16.16	23.01	20.43	19.23	23.26	20.94	19.74	25.12	22.80

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The dust emission level from all the main stacks and ambient air quality (SPM in ambient air) in the Plant are below the prescribed limits. The performance of all pollution control equipment (Dust collectors, Bag Houses, ESPs, etc.) is satisfactory. All the Pollution control equipment is well maintained through preventive maintenance and operates effectively. The environment in the Plant and Colony, in general, is very neat and clean.

PART-D

HAZARDOUS WASTES

[AS SPECIFIED UNDER THE HAZARDOUS & OTHER WASTE (MANAGEMENT AND TRANSBOUNDARY MOVEMENT) RULES, 2016]

Hazardous Waste	Total Quantity			
	Generation During the financial year 2021-22	Generation During the financial year 2022-23	Disposal During the financial year 2022-23	Mode of disposal
From Cement manufacturing	Nil	Nil	Nil	Nil
From Pollution Control Activities	Nil	Nil	Nil	Nil
From Plant machinery, TPP machinery & mines vehicle – Used / Spent oil (schedule-I, Cat.No. 5.1)	7585 Ltrs	4100 Ltrs	4100 Ltrs	Sold to authorized recycler (Columbia Petro Chemicals, Raipur)
From TPP - Spent Ion exchange resin containing toxic metal (Schedule-I, Cat. No. 34.2)	0.140 MT	0.140 MT	0.140 MT	Co-processed in Cement kiln

Note: During cement manufacturing, hazardous waste is not generated from the process or pollution control facilities.

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PART-E

SOLID WASTE

There is little amount of solid waste generated from the cement manufacturing process. The powder material (Limestone / Clinker / Cement) generated during the process is almost fully arrested by pollution control equipment and is recycled back into the system.

Solid Waste	Total Quantity Generated		Total Quantity Disposed
	During the financial year 2021-22	During the financial year 2022-23	During the financial year 2022-23
a) From Process	NIL	NIL	NIL
b) From Pollution Control Facilities	NIL	NIL	NIL
c) Fly Ash / Bed Ash generated from TPP reutilized within the unit in manufacturing of Portland Pozzolana Cement / Disposed in a lying area within the plant premise.	50,471 MT	40,875 MT	40,875 MT (Fully reused in Cement Plant)

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PART-F

Please specify the characteristics in terms of concentration and quantum of Hazardous as well solid wastes and indicate disposal practices adapted for both these categories of wastes.

There is no scope for generating any Hazardous & Solid wastes in the cement manufacturing process (except used oil and spent resin), as the pollution control equipment restrains the emission and the entrapped solid wastes are recycled completely.

The solid, powdery material generated at various points in the process is non-hazardous, and the same is collected in the pollution control equipment installed in the various sections. The collected materials (Raw Meal / Clinker / Cement) are fully recycled into the process.

However, Cement Plants / TPP/Mining machinery generates small waste and used oil. Used/spent lubricating oil recovered from various machineries of Cement Plant / Power Plant / Mines is filled in barrels of 210 liters' capacity and sold to outside parties authorized to handle hazardous waste from SPCB and registered with MoEF.

Spent ion exchange resin of quantity 0.140 MT generated from the Power Plant during F/Y 2022-23 is disposed of through co-processing in a cement kiln as per the authorization of Hazardous and Other Waste (Management & Transboundary Movement) Rules, 2016.

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PART-G

IMPACT OF POLLUTION CONTROL MEASURES ON THE CONSERVATION OF NATURAL RESOURCES AND CONSEQUENTLY ON THE COST OF PRODUCTION

1. We are producing OPC, PPC, PSC, and composite Cement and utilizing substantial quantities of fly ash, Gypsum, and slag, reducing limestone consumption per ton of cement and ultimately reducing greenhouse gas emissions. Total Fly Ash (Fly ash dry outside + Fly ash TPP Generated) quantity 417978 MT & Chemical gypsum quantity 34596 MT consumed during F/Y 2022-23.
2. The whole quantity of fly ash generated in the captive thermal power plant is conveyed through a dense phase conveying system to the plant and used to manufacture Portland Pozzolana Cement and Portland Composite Cement.
3. Recovery of usable limestone from contaminated benches was done through dry beneficiation, i.e., through a wobbling cum screening plant. Thus, the rejection of the usable limestone was reduced to almost nil.
4. High-efficiency bag filters (Fiber Glass Membrane, Anti-Static, Anti Adhesive, and Holo-polymer bags are being used, which have high dust collection efficiencies. The dust collected in the bag's filters is being recycled; therefore, there are no dust emission losses, which helps conserve resources.
5. Waste water is being collected and reused in horticulture by adopting the Zero Discharge principle to reduce fresh water consumption, thereby conserving natural resources.
6. Rainwater harvesting- The firm has constructed total eight (8) numbers of rainwater harvesting structures at surrounding of School building, near the Club house, and the colony of the plant complex located at the out-flow point of the storm water drains. Two numbers RWH structure constructed near mine office. 15,40,325 m^3/year runoff is being generated from the mine, plant and colony complex which can be considered for groundwater recharge.

   Solar Power :- We have installed solar plant of 6×100 KWp and 1×102 KWp SPVPP capacity. No new solar plant was installed during 2022-23 & total electricity generated from Solar Power Plant for the Fy'22-23 were

   (i) 600 Kwp – 549653.1 Kwh
   (ii) 102 Kwp – 62453.6 Kwh
   (iii) 11.05 MWp – 13061500 Kwh
   Total – 136473606.7 Kwh

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PART-H

ADDITIONAL INVESTMENT PROPOSAL FOR ENVIRONMENTAL PROTECTION INCLUDING ABATEMENT OF POLLUTION

For environmental protection and abatement of pollution, we have taken the following steps to maintain a clean and healthy environment in the Mines, Plant, & Colony: -

1. High-Efficiency Pulse Jet Dust Collector has been installed in place of old shaking-type Bag Dust Collectors in different plant sections, i.e., Crushers, Raw Mills, Cement Mills, Packing Plants, etc. High-efficiency filter bags, i.e., Homo-polymer acrylic, are being used.
2. 4 no's of Reverse Air Bag Houses have been installed for both kilns. 2 no's of Electrostatic Precipitators (ESP) have been installed for de-dusting the cooler vent gases of kilns no. 1 & 2 in place of Multiclone Dust Collector originally installed. Fiber glass membrane type bags are being used in RABH. The emission from all the stacks is almost nil.
3. Water spray arrangement has been provided over the hoppers of Primary and Secondary Crushers, Limestone Belt No. 1, 2, 3, and clinker belts to control fugitive emissions generated locally.
4. Sprinklers have been provided on the roads inside the Plant and Mines area to minimize the fugitive emission generated due to the movement of vehicles.
5. To maintain cleanliness in the individual department, vacuum cleaners have been provided for cleaning elevator pits and the surrounding areas of the Packing Plant and Cement Mills.
6. A truck-mounted mobile vacuum cleaner has also been procured to clean the spillage powdery materials in dust free manner.
7. Larger capacity exhaust fans have been provided in different sections like Crusher, Raw Mill, Cement Mill, Packing Plant, etc. for good ventilation.
8. Almost all the roads inside the plant are pucca.
9. Three nos. of road sweepers costing Rs.60 lac has been procured to maintain cleanliness in the plant.
10. For dust free handling of dry fly ash, a steel bunker having capacity of 500 MT has been constructed to store dry fly ash. Dry fly ash received in closed tankers are being unloaded in the bunker pneumatically. At the bottom of the bunker feeding arrangements have been made so that fly ash could be fed to cement mills. The whole system is totally enclosed and dust-free. Also, 2 no's of RCC silos having capacity of 2000 Tonnes each have been constructed for storage of dry fly ash in emission free manner.
11. To avoid the spillage of lubricating oil, separate containments have been provided at the lubricant oil storage in the departments.

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12. Separate hand pumps are provided in the lubricant oil drums to avoid oil spillage during oil transfer.
13. Used batteries are stored on at covered pucca floor lined with acid-proof tiles and sold to authorized recyclers only.
14. Installation of LED lights in place of conventional light fitting.
15. To mitigate the NOx notified standards, the Tertiary air duct was modified & Low NOx duct was installed. Installation of Fuel split in calciner.
16. To eliminate the spillage of lubricant oil, a Total Lubrication Management Room has been constructed, and centralized oil distribution is ensured.
17. **Co-processing: -** Utilization of AFR, an AFR feeding system has been installed, and Co-processing has been just started.
18. **Green Belt Development -** Green belt development and tree plantation is an ongoing process. Every year, we are planting new plantations to increase the density of existing green belt areas. Our plant, colony & miner's area is approx. 587.119 Ha, out of which we have developed 284 Ha are under plantation, including nearby areas and achieve 48% greenery. Total Saplings 2737 (Karanj 1315 no's, Kesia samiya 900 no's and Fruit bearing plants 522 no's) planted in 1.1 Ha area during 2022-23.
19. **Rehabilitation-** The old mined-out pit has been converted to a water reservoir in order facilitate recharge the ground water in the area in addition to use of water for the Cement plant. The capacity of mine water reservoir is 757082.35 m^3.
20. **Rain Water Harvesting-** The firm has constructed total eight (8) numbers of rainwater harvesting structures at surrounding of School building, near to the Club house & colony of the plant complex located at the out-flow point of the storm water drains. Two numbers RWH structure constructed near mine office. 15,40,325 m^3/year runoff is being generated from the mine, plant and colony complex which can be considered for ground water recharge.

    Solar Power -. We have installed solar plant of 6×100 KWp & 1×102 KWp SPVPP capacity. No new solar plant installed during 2022-23 & total electricity generated from Solar Power Plants for the Fy'22-23 were

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    Total – 136473606.7 Kwh

As per CPCB Guidelines following measures has been implemented in the Cement Plant to control the generation of fugitive emissions: -

- Enclosures are being provided for unloading operations.
- All transfer point locations are being fully enclosed.
- Bag filters are being installed at all transfer points to reduce fugitive dust emissions.
- Atomized water spraying system is being provided on raw material unloading hoppers.

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- Water Spray on roads and other areas by mobile tanker/water sprinklers.
- All the Roads inside the plant premises are being concreted.
- Regular sweeping of all the roads and floors are being done.
- Dust collected from air pollution control equipment is being totally recycled in the process.
- Fly ash is being pumped directly from the tankers to silos pneumatically in closed loop or mechanically such that fugitive emissions do not occur.
- Dry fly ash is being transported into closed system.
- The packing machine is being equipped with dust extraction arrangement. Dust is being captured in bag filters.
- The recurring Cost for the Environmental Pollution Control Measures during 2022-23 was Rs. 487.87 Lakhs.
- Expenditure in CSR activity during 2022-23 was Rs 238.51 Lakhs.

S.No.	Expenditure incurred on Environment Management Activities	Expenses incurred 2021-22 in lacs (In Rs.)	Expenses incurred 2022-23 in lacs (In Rs.)
(i)	Environment related Expenses	52.0	51.93
(ii)	Horticulture related Expenses	72.84	69.05
(iii)	Depreciation on Pollution control equipment	286.95	240.43
(iv)	Salary Environment manpower	10.0	12.0
(v)	Power consumption cost for running major pollution control equipment	130.62	114.46
Total		**552.41**	**487.87**

S.No.	Expenditure in CSR Activities	Expenditure in Lacs (In Rs.)
(i)	Education	117.24
(ii)	Health Care	0.38
(iii)	Sustainable Livelihood	21.32
(iv)	Infrastructure Development	77.76
(v)	Social Cause	7.5
(vi)	Protection of Heritage/Art/Culture	9.15
(vii)	Others (including building up of CSR capabilities	5.16
Total		**238.51**

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PART-I

Any other particular for improving the quality of the Environment

Continuous Ambient Air Quality Monitoring System: - For Continuous Monitoring of Pollutant including gases like Sulphur dioxide, nitrogen dioxide, carbon monoxide, and particulate matter below 10 microns and below 2.5 microns size we have Installed three no's Thermofisher Make Continuous Ambient Air Monitoring stations and the same is working satisfactorily. 2 Nos display board one each at Plant & Mines respectively has been provided.

Online Continuous Stack Emission Monitoring Systems: -For continuous emission monitoring of the gaseous emission 6 stack have been equipped with OCEMS analyzer for the measurement of SO2 & NOx. For Particulate matter emission 21 stacks have been equipped with OCEMS PM analyzers. Online data are being shared with CPCB & CECB server.

Remote Calibration System: -As per the CPCB guideline Remote calibration system have been provided.

Environmental Management System ISO 14001: -Our management is fully aware about the responsibility towards preventing the pollution from the factory and are making lot of efforts not only for controlling the pollution but also for betterment of total environment. In this direction, our organization has effectively implemented the Environmental Management System ISO 14001-2015 in our Cement Plant, Mines & Thermal Power Plant. The certification for the system (ISO 14001) had been granted to us and is valid up to Nov'2023.

Implementation of PAT: To ensure the unit more Energy efficient we are putting our best effort through Intended nationally determined contributions (INDCs); we have adopted the PAT scheme.

Others:-Baikunth Cement Works has always been in the forefront of social services and humanitarian causes like Health programme, Medical Hygiene, Education facility, Sustainable livelihood, infrastructure development, Social Empowerment and welfare, Heritage / Art / Culture protection, Drinking water supply etc.. The detailed is tabulated below:-

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1496 students enrolled in school and college and ensure quality education. Baikunth have created learning ecosystem where children can able to improve their ability and knowledge.	95 students are harnessing their skills, knowledge, ability, confidence and market behaviour at the centre. (50 Electrical, 30 Diesel Mechanic & 15 Home Appliances)
	
Skill Training Program: People institutions is always playing a pivotal role of development. We are promoting skill based institution so computer training programs organized.	Under the support of **NABSKILL NABARD** program we have organized special training program on ' Solar PV Installation – Electrical and Fabrication ' duration 90 days for 90 trainees. Out of which **62% trainees** has been placed in different enterprises and earned monthly in a range between **Rs 12000 to Rs 19000.** **46 aspiration young girls** were trained on 'Industrial Sewing and Machine Operator', out of which **19 trainees** has been placed in **SHAHI Pvt Ltd**. located at Bangalore and Hydrabad. Earned monthly **Rs 12700/-**
 	
Health Care :- **Oral hygiene awareness –** Prevention of Dental diseases – 147 students **Diagnostic camp –** Hepatitis B and C – 91 persons **Eye refraction test–** 48 persons (truck drivers) **Ortho Camps –** 10 persons **Deworming (under National Deworming program) –** 1220 students **ENT Camps –** 10 persons	**Sustainable Livelihood -** Under our sustainable agriculture practices the Turmeric Rhizomes are planting in Jalso and Kirna Gothans by village women groups.

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<table>
<tr><td colspan="2">    </td></tr>
<tr><td colspan="2">Sustainable Livelihood - In collaboration with NABARD we have constructed MODEL RURAL HAAT at Bahesar village with an intention to provide adequate market space for marginal farmers and arctician groups.
Facilities provided 3 Platforms , Courtyard, Toilets Men and Female, Waste segregation pits, Drinking water, Electricity.</td></tr>
<tr><td>  </td><td>  </td></tr>
<tr><td>Infrastructure: -
Village internal roads have a significance contribution towards social- economic growth. Based on need assessment we have constructed length of 970 meters as resulted above 12000 population got benefitted.</td><td>Social Cause: -
Awareness sessions were organized on different aspects rights of women, financial literacy, personal hygine, home safety etc.</td></tr>
<tr><td>  </td><td> 
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<tr><td>we have increased skill of above 75 female in a cluster approach as resulted they earned additional income at their door step by using of the skill.</td><td>Media Coverage</td></tr>
</table>

Date: 29-08-2023

For UltraTech Cement Limited
Unit: Baikunth Cement Works