



Department
for Environment
Food & Rural Affairs

Report on measures for 2018 exceedance of the Target Value for Benzo[a]pyrene in Yorkshire and Humberside non-agglomeration zone (UK0034)

December 2020



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Any enquiries regarding this publication should be sent to us at

Air Quality and Industrial Emissions
Department for Environment, Food and Rural Affairs
Ground Floor, Seacole Building
2 Marsham Street
London, SW1P 4DF

Email: air.quality@defra.gov.uk

With technical input from Ricardo Energy & Environment

www.gov.uk/defra

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1. Introduction

1.1 Context

Under the EU Directive 2004/107/EC¹, the target value (TV) for Benzo[a]pyrene (B[a]P) is an annual mean concentration of 1 nanogram (one billionth of a gram (10^{-9})) per cubic metre (ng.m^{-3}) of ambient air or lower. The Directive requires that Member States report on measures in place to address the exceedance of the TV and that all reasonable measures that do not entail disproportionate cost should be taken to ensure this target is not exceeded.

The United Kingdom exited the European Union on 31 January 2020. Upon exit, the UK entered a Transition Period which will end on 31 December 2020. The UK was a Member State during the period this report covers, and the Directive requirements apply to the UK as part of its obligations during the Transition Period.

Once the Transition Period ends on 31 December 2020, the UK will continue to meet its reporting obligations through making this data available to the public to the same timescales.

Emissions of B[a]P fell significantly from 1990 to 2001, after which the reported emissions have either reached a plateau or fallen steadily depending on the location, reflecting the effect of environmental regulation and Best Available Techniques (BAT) for pollution control. In 2018 for the UK, data shows that there is a continuing, downward trend in emissions of B[a]P, which is reflected by ambient-air measurements both nationally and locally (see Table 2 of this report). However, in the Yorkshire and Humberside region, there was a measured exceedance at one of the five measurement locations in this zone.

After reviewing the monitoring data, followed by targeted monitoring and modelling to apportion the sources of the exceedances, the Environment Agency identified the exact processes that were significantly contributing to the target exceedances. The Environment Agency then directed the operator to determine the causes of the exceedances and put in place a compliance programme to better control the process and to minimise the likelihood of further exceedances.

The process causing the exceedances were two coke ovens at a steel works. During 2015, the performance of both coke oven plants were assessed as poor at the

¹ <http://eur-lex.europa.eu/LexUriServ/LexUriServ.do?uri=OJ:L:2005:023:0003:0016:EN:PDF>

installation. Following regulatory pressure to improve; inspections, assessing emissions against emission limits and a permit review to meet BRef requirements, the outcome was be a closure of one of the two plants. This led to effectively implementing the sector BAT Reference Document by the Industrial Emissions Directive (EU Directive 2010/75/EU), and then focused investment and engineering works in the remaining ACO coke-oven plant and Sinter plant.

Since 2016, the operator of the Appleby coke ovens has continued working through a recovery project with significant capital and revenue to improve their operational performance of their plant, with improved infrastructure to prevent and minimise emissions, specifically PAH and B[a]P emissions reductions associated with particulate matter and smoke emissions.

The sinter-plant stack at the installations is the other significant source of PAH and B[a]P emissions. This particular plant is subject to other specific Best Available Techniques (BAT) conclusions from the BRef under the Industrial Emissions Directive (EU Directive 2010/75/EU). On-going projects to improve abatement for compliance of specific BAT Conclusions are being implemented to reduce particulate and dioxin/furan emissions, these have secondary potential to minimise B[a]P emissions. The revised 2016 permit has six-monthly PAH monitoring for the main stack expressed as B[a]P emissions, to assess potential improvements.

Additionally, the revised IED EPR permit for the operator has conditions requiring an annual review and reporting on measures to prevent and minimise PAH emissions by the development of an Air Quality Management plan.

Exceedance of the TV were reported in 2013, 2014, 2015, 2016 and 2017 in the Yorkshire and Humberside non-agglomeration zone and a report on measures was published detailing the exceedance and the measures in place².

This document reports the progress in reducing emissions, together with any exceedances for 2018, reflecting the more recent assessment and updating the 2013, 2014, 2015, 2016 and 2017 report on measures.

1.2 Status of zone

This is the report on measures required for exceedances of the TV for B[a]P within the Yorkshire & Humberside zone identified within the 2018 UK air quality assessment. Exceedances within this zone were identified on the basis of model results providing supplementary information for the assessment in addition to the

² <https://uk-air.defra.gov.uk/library/bap-nickel-measures>

results from fixed monitoring stations. This exceedance was reported via e-Reporting dataflow G³ on attainment and Air Pollution in the UK⁴.

Table 1 summarises the spatial extent and associated resident population for the exceedances identified in this zone, as reported via e-Reporting.

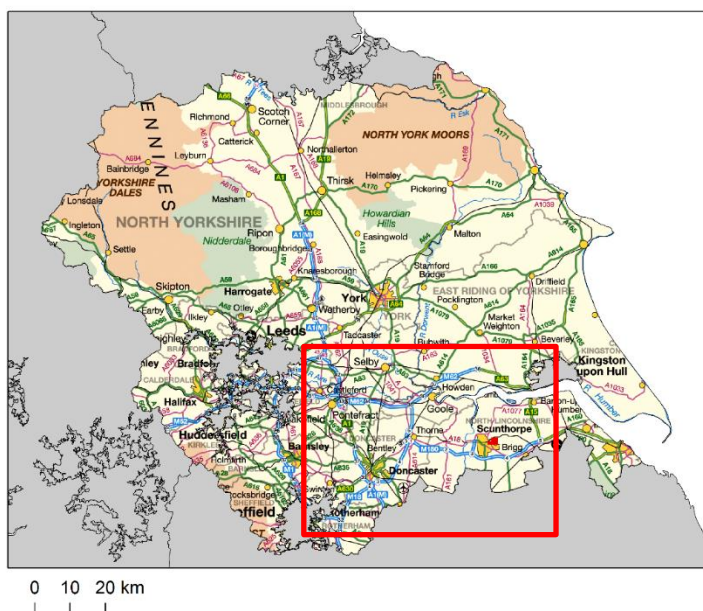
Table 1. Area exceeding B[a]P target value in 2018 and associated population for zone UK0034

Zone code	Zone Name	Area exceeding TV (km ²)	Population exceeding TV
UK0034	Yorkshire & Humberside	5	1679

Figure 1a shows the locations of the exceedances in the context of the zone as a whole. Figure 1b shows the part of the zone including the exceedances in more detail.

Figure 1. Location of exceedance of the B[a]P target value during 2018 in zone UK0034 Yorkshire & Humberside. Areas of the zone in exceeding grid squares are marked red.

a) The whole zone



³ <http://cdr.eionet.europa.eu/gb/eu/aqd>

⁴ <http://uk-air.defra.gov.uk/library/annualreport/index>

b) The exceedance locations at higher spatial resolution



An initial source apportionment was carried out and this analysis identified one exceedance situation within this zone

- Yorkshire and Humberside [B[a]P_UK0034_2018_1] related to industrial emissions (area of exceedance 5 km²)

This following section details the exceedance situation in the zone including a description of the exceedance situation, maps, information on source apportionment and a list of measures already taken or to be taken. Information on measures is reported within e-Reporting dataflow K⁵.

⁵ <http://cdr.eionet.europa.eu/gb/eu/aqd>

2 Exceedance situation Yorkshire and Humberside [B[a]P_UK0034_2018_1] related to industrial emissions

2.1 Description of exceedance

This exceedance situation is an area of exceedance 5 km² to the north east of Scunthorpe in Lincolnshire. Figure 2 shows the location of the exceedance situation in detail. The exceeding grid squares are numbered in Figure 2 and in subsequent tables for easy reference. The resident population associated with this exceedance situation is 1679. The majority of this population is in the grid cell labelled 2. Most of the grid squares have no resident population and are largely or wholly within the steelworks industrial complex area.

Table 2 lists the measured concentrations of B[a]P in this zone since 2008. The fixed monitoring stations at Scunthorpe Town and Scunthorpe Low Santon are within the exceedance situation. The TV was exceeded at the Scunthorpe Town monitoring station in 2018. The measured concentration at Scunthorpe Low Santon was below the TV in 2018. The modelled concentration at this location is above the TV.

Table 2. Measured annual mean B[a]P concentrations in Yorkshire and Humberside zone UK0034 from 2008 to 2019 (ngm⁻³). (Percentage data capture is shown in brackets).

Station (Eol code)	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019
High Muffles (GB0014R)	0.14 (95)	0.09 (62)	0.07 (94)	0.06 (87)	0.07 (91)	0.07 (87)	0.07 (98)	0.07 (98)	0.05 (100)	0.04 (100)	0.04 (99)	0.04 (97)
Royston (GB0940A)	2.6 (95)	1.0 (95)	1.1 (84)	0.84 (96)	0.89 (99)	0.85 (100)	0.92 (100)	0.41 (100)	0.52 (100)	0.34 (99)	0.38 (99)	0.38 (98)
Scunthorpe Low Santon (GB1004A)	6.0 (95)	2.4 (99)	1.8 (94)	3.0 (91)	2.9 (100)	3.4 (100)	3.6 (92)	3.5 (99)	1.1 (99)	0.83 (100)	0.78 (100)	0.75 (84)
Scunthorpe Town (GB0841A)	3.2 (99)	1.8 (99)	1.3 (80)	1.3 (86)	1.4 (98)	3.9 (98)	3.5 (90)	1.3 (92)	1.1 (100)	0.80 (99)	1.7 (100)	1.9 (96)
South Hiendley (GB0942A)	1.3 (97)	0.89 (94)	0.63 (91)	0.68 (83)	0.54 (100)	0.35 (91)	0.44 (99)	0.26 (95)	0.31 (100)	0.19 (100)	0.23 (100)	0.31 (94)

Figure 2 also shows the locations of the monitoring sites associated with the exceedance situation and the locations of the key industrial sources. Dispersion modelling up to and including 2017 applied site level coordinates derived from the National Atmospheric Emissions Inventory (NAEI) for the sinter plant stack, which is about 850 m distant from the stack. The specific location of the sinter plant stack has been used for the 2017 and 2018 assessments. The specific location of the sinter plant is shown in Figure 2.

The Scunthorpe Steel works operator has also invested in and operated their own PaH B[a]P ambient monitoring as equivalent to the AURN monitoring network. The same equipment operated to the same standards and accredited laboratory analysis at an Iron & Steel Research and Technology centre at Rotherham. Following a review of locations (originally 3), this is now reduced to High Santon Farm location where typical running costs are ~£80k p.a. In contrast to the Defra AURN network, measuring a daily sample monthly composite as a mean data value, their monitor measures a 3-day sample composite and report mean data values. The objective was to provide more dynamic emission trending and higher emissions resolution as an investigational tool for the Operator downwind (prevailing NW) of the site. Emissions are not dominated by the now closed Dawes Lane coke oven. Using wind sector analysis, plant emission sources and BaP spikes are being assessed.

Dawes Lane coke ovens closed in March 2016. The exceeding grid squares within this exceedance situation are numbered and the numbers correspond to those in subsequent tables. Table 3 lists the exceeding grid squares and the resident population.

Figure 2. Exceedance situation Yorkshire and Humberside [B[a]P_UK0034_2018_1]. Exceeding grid squares are marked red. Locations of coke works at Appleby and sinter plant at Scunthorpe are also shown as well as the two monitoring sites at Scunthorpe Town and Scunthorpe Low Santon.

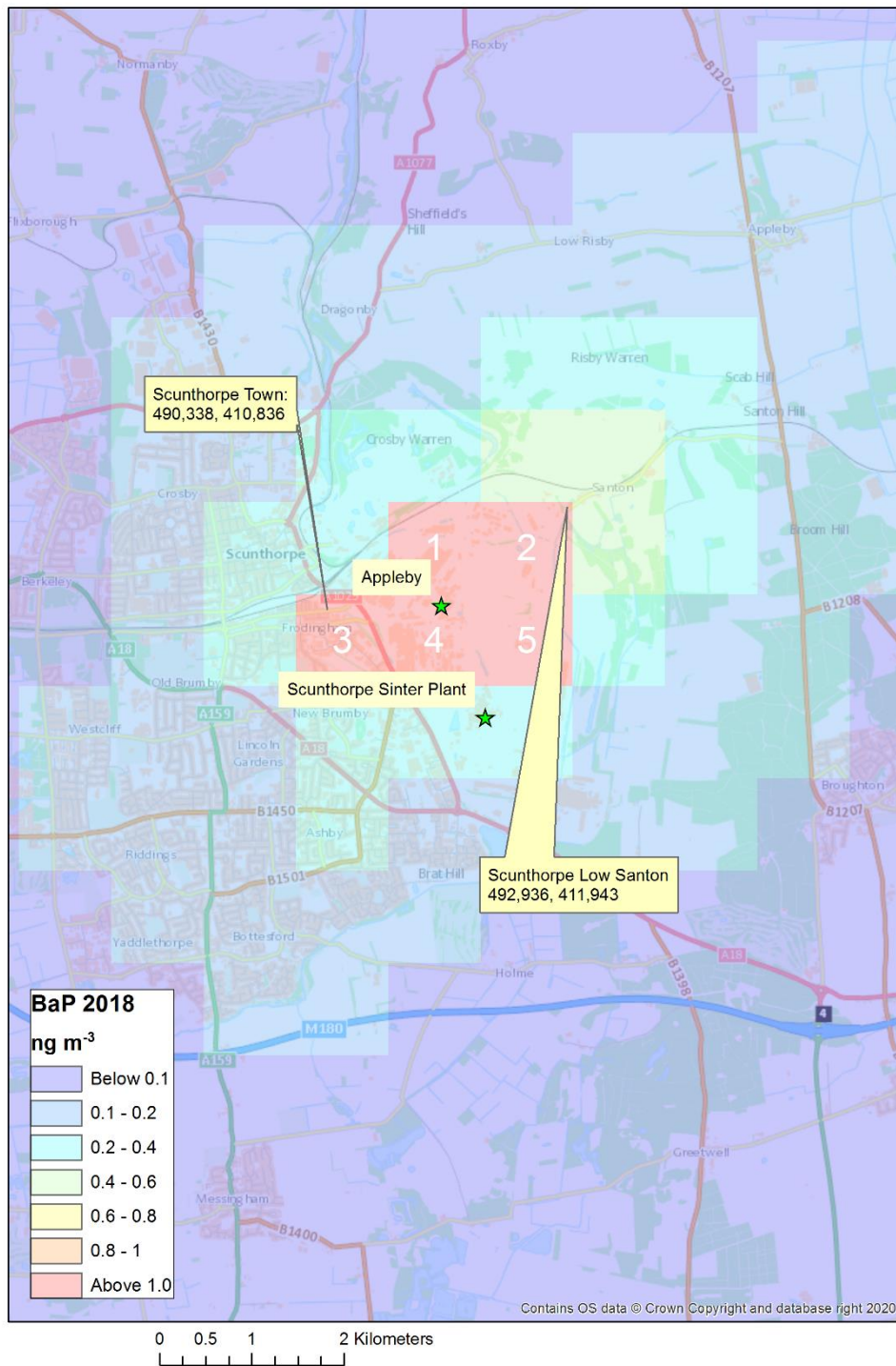


Table 3. Exceeding grid squares for exceedance situation BaP_UK0034_2018_1.

Grid square number	Resident population	Notes
1	0	Steelworks industrial complex
2	7	Mostly steelworks industrial complex, 3 houses in Low Santon
3	1671	Scunthorpe Town, industrial estate
4	0	Mostly steelworks industrial complex
5	0	Steelworks industrial complex

2.2 Source apportionment

Table 4 provides a breakdown of the main emission sources (source apportionment) that have contributed to the grid squares in this exceedance situation, highlighting the significant contribution from industrial sources. The penultimate column is the total from all emission sources. The values in this column have been rounded to 1 decimal place for consistency with the values used in the compliance assessment. The values in the other columns have not been rounded. The other shaded columns are the subtotals for the regional, urban background and local contributions. Table 5 gives a more detailed source apportionment indicating how the separate industrial processes contribute to the total industrial figure. This shows that the coke ovens at Appleby is the main source associated with this exceedance situation (note Dawes Lane coke ovens closed in March 2016). As the modelling is getting closer to the monitoring values, there is scope to further investigate refining the source terms for input into the modelling. The Appleby Coke Ovens has a mixture of fugitive emissions, point source emissions, use of emission factors and more random process safety pressure relief emissions (point sources) that form the total annual B[a]P emissions.

Table 4. Source apportionment for exceedance situation Yorkshire and Humberside [B[a]P_UK0034_2018_1]. Annual mean B[a]P concentration (ngm⁻³)

Grid square number	OS easting (m)	OS Northing (m)	Zone	a) Regional background: Total	b) Urban background increment: Total	Urban background increment: Traffic	Urban background increment: Industry including heat and power	Urban background increment: commercial and residential	Urban background increment: Shipping	Urban background increment: Off road mobile machinery	Urban background increment: Other	c) Local increment: Total	Local increment: Industry including heat and power production	Total for all emission sources (a+b+c)	Resident population
1	491500	411500	34	n/a	0.042	0.001	0.018	0.017	0.000	0.001	0.006	4.317	4.317	4.4	0
2	492500	411500	34	n/a	0.033	0.001	0.013	0.013	0.000	0.001	0.006	1.745	1.745	1.8	7
3	490500	410500	34	n/a	0.099	0.001	0.045	0.044	0.000	0.002	0.008	1.624	1.624	1.7	1671
4	491500	410500	34	n/a	0.050	0.001	0.021	0.020	0.000	0.001	0.006	3.738	3.738	3.8	0
5	492500	410500	34	n/a	0.035	0.001	0.014	0.013	0.000	0.000	0.006	1.428	1.428	1.5	0

Table 5. Detailed source apportionment for industrial sources only, for exceedance situation Yorkshire and Humberside [B[a]P_UK0034_2018_1]. Annual mean B[a]P concentration (ngm⁻³)

Grid square number	OS easting (m)	OS Northing (m)	Zone	Appleby coke ovens	Scunthorpe, other plant	Local increment: Industry including heat and power production
1	491500	411500	34	4.313	0.004	4.317
2	492500	411500	34	1.739	0.006	1.745
3	490500	410500	34	1.621	0.003	1.624
4	491500	410500	34	3.735	0.003	3.738
5	492500	410500	34	1.423	0.005	1.428

A revised modelling methodology incorporating a finer spatial scale for dispersion modelling of all coke ovens in the UK and revision to the emissions rate for the coke ovens at Scunthorpe have been adopted for the 2016, 2017 and 2018 compliance assessment for B[a]P.

2.3 Measures

The main overview report contains more information on how industrial sites are regulated. There are no specific Best Available Techniques (BAT) conclusions designed to reduce B[a]P under the Industrial Emissions Directive (EU Directive 2010/75/EU). However, there are some narrative and specific BAT Conclusions to minimise particulate emissions, indirectly reducing B[a]P emissions. Permit conditions transposed these into the EPR permit in February 2016 and focused on the Coke Ovens and Sinter plant which are the main sources of this pollutant. BAT Reference Document (BREF)⁶ contains stringent requirements for iron and steel

⁶ http://eippcb.jrc.ec.europa.eu/reference/BREF/IS_Adopted_03_2012.pdf

works to significantly reduce their fugitive emissions, including Polycyclic Aromatic Hydrocarbons (PAH) (B[a]P is a pollutant from this chemical group).

Before March 2016, diffuse emissions at the coke ovens at Appleby and Dawes Lane continued to be the main sources associated with the exceedance in this zone. However, whilst the Sinter Plant has a significant mass emission, it is a 107m high stack point emission and highly dispersed. For March 2016, the Environment Agency completed an IED review of the EPR permit HP3736AW, the Operator was known as British Steel Ltd (formerly Longs Steel UK Ltd). The IED review of the EPR permit considered the Operator's proposed techniques and comparison against other relevant techniques by the European Commission establishing Best Available Techniques (BAT) conclusions for Iron and Steel Production as detailed in the document reference 2012/135/EU (BRef) published on 8 March 2012. Following an operational strategic review, the then owners of the steelworks announced in October 2015 their intention to close Dawes Lane Coke Oven (DLCO). DLCO subsequently closed on the first compliance day for IED (8th of March 2016).

Following closure of DLCO Plant, there was to be a focused investment in the Appleby Coke Ovens (ACO). Since 2016, the steelworks has continued working through a significant capital and revenue project. The Appleby Recovery project was to improve operational performance on both the coke oven Batteries and the By-products plant with improved infrastructure to prevent and minimise emissions, specifically PAH and subsequently B[a]P emissions reductions associated with particulate matter emissions. A rebuild of Battery 3 was completed, operated on hot idle (no coke making) from December 2015 to August 2016. During 2018, further works have continued on the refurbishment of Batteries 1, 2 and 4 and the associated By-products plant. As such, the reported measures in previous reports on "Measures for Dawes Lane Coke Ovens" can now be discounted.

Since 2017, Appleby Coke Ovens (4 batteries) have continued with a programme of remedial works. Partial rebuilds of individual ovens on Battery 2 have been completed and improvements to Battery 1 with deeper end flue rebuilds and further remedial work during 2018. N° 7 primary cooler on the by-products was replaced enabling better by-product plant cooling operations to increase plant operational stability (reduce emissions). Improvements in the by-products plant and construction of a new Coke Oven Gas fuel holder is an enabler to reduce process gas back-pressure on the batteries to prevent and minimise doors and tops leakage. This would reduce risk of raw coke oven gas emissions from the process safety pressure relief systems where abatement flares are not initially ignited (process safety). This leads to unplanned and variable BaP emissions, seen as spikes in monitoring data.

The sinter-plant stack at the installations is the other significant source of PAH and B[a]P emissions. It is a point source release and emissions are highly dispersed via its 107m high stack. This particular plant is subject to other specific Best Available Techniques (BAT) conclusions from the BRef under the Industrial Emissions Directive (EU Directive 2010/75/EU). On-going projects to improve abatement for compliance of specific BAT Conclusions are being implemented to reduce particulate and dioxin/furan emissions, these have secondary potential to minimise B[a]P emissions. The revised 2016 permit has six-monthly PAH monitoring for the main stack expressed as B[a]P emissions, to assess potential improvements.

The Environment Agency set out a permit condition in the 8 Feb 2016 EPR permit HP3736AW to annually review and report on measures to prevent and minimise PAH emissions and provide a PAH AQ Management plan. This contributes to this report such the measures set out in Table 6 to prevent and minimise PAH for the 2018 reporting year.

Table 6 sets out the measures that are being taken for reporting year 2018 or are to be taken (planned) for 2019 through the ACO Battery Recovery project.

Table 6. Table of measures taken or to be taken at Scunthorpe industrial site

Measure code	Description	Classification	Implementation dates	Other information		Comment		
1	Polycyclic Aromatic Hydrocarbon (PAH) Improvement Plan; The operator shall submit a written plan, to the Environment Agency (the regulator) for approval, of the measures to be taken to minimise PAH emissions (IARC Group 1, 2a & 2b), particularly the marker PAH; Benzo [a] Pyrene (B[a]P) and Volatile Organic Compounds as fugitive releases from existing Appleby and Dawes Lane coke oven battery plants	Permit systems and economic instruments: IED permits	Start: 2012	Source affected:	Industry including heat and power production	Superseded by AQMP Condition 3.7 in 8 Feb 2016 issued EPR permit HP3736AW		
			Expected end: 2024					
			Status: Implementation					
			Spatial scale:				Local	An improvement condition on the Scunthorpe site permit BL3838IW V007 9 May 2012. The measures described in column 1 of this table (Measure codes); Appleby Coke Ovens 1 -20 and Dawes Lane 1 are from the PAH improvement Plan. This PAH Improvement Plan forms part of a wider
			Cost:				Unknown, Operator information	
Indicator:	Reduction in ambient B[a]P concentration							
Target emissions reduction:	Not available							

						Coke Oven Battery Recovery Project.
2	PAH measurement and analysis; The operator undertakes B[a]P monitoring to AURN monitoring location standards with time resolution as low as 1 day. PAH measurements at two locations, using pollution rose analysis to identify key sources. Emission factors to be calculated.	Permit systems and economic instruments: IED permits	Start: 2012 Expected end: None Status: Implementation	Source affected: Spatial scale: Cost: Indicator: Target emissions reduction:	Industry including heat and power production Local Unknown, Operator information Not available Not available	COMPLETED 2012 improvement. 2017 Update - Moved to measuring ambient PAH as B[a]P at one location, with time resolution now at 3 days (averaging period). Measurements and analysis indicate that the coke ovens at Appleby (and previously Dawes Lane) are the key sources for this exceedance situation. Emission factors calculated for each plant by reverse modelling methodology (Measure No. 4).

						DLCO closed in March 16. Coke production has reduced which will also affect emission levels.	
3	Emission measurements; Direct emissions measurements using flameproof blanket fixed over oven doors to create a chimney. Bespoke monitoring to establish improved emission factors.	Permit systems and economic instruments: IED permits	Start:	2007	Source affected:	Industry including heat and power production	COMPLETED: Analysis indicates that B[a]P emission dominated by door leakage (>98% of total). Emission rates consistent with estimates at other similar plants across Europe
			Expected end:	2008			
			Status:	Complete			
			Spatial scale:	Local			
			Cost:	Unknown, Operator information			
			Indicator:	Not available			
Target emissions reduction:	Not available						

4	Reverse Dispersion Modelling; To provide an independent estimate of emission rates, based on ambient measurements	Permit systems and economic instruments: IED permits	Start:	2014	Source affected:	Industry including heat and power production	COMPLETED: Results reasonably consistent with emissions estimates from direct measurements. Indicates that coke ovens are the main source.
			Expected end:	2015			
			Status:	Complete			
			Spatial scale:	Local			
			Cost:	Unknown, Operator information			
Indicator:	Not available						
			Target emissions reduction:	Not available			
Appleby Coke Ovens 01	Replacement of Door seals; Regular door maintenance is necessary to ensure the maintenance of good	Permit systems and economic instruments: IED permits	Start:	2012	Source affected:	Industry including heat and power production	ON-GOING: 2018 update - ACO continued to replace/repair doors as and when
			Expected end:	Ongoing			
			Status:	Implementation			

	seals and a programme to overhaul doors on a daily basis is ongoing.	
Appleby Coke Ovens 02	Door extractor adjustments; New door extractor as a trial to increase flexibility in door adjustments. Once the optimum position for each door has been ascertained then sealing each individual door will	Permit systems and economic instruments: IED permits

Start: 2013
Expected end: 2018
Status: Implementation

Spatial scale:	Local	necessary under a maintenance regime. Door cleaning jettors are being repaired continuously on an ongoing basis. 2019 plan - Refurbishment of battery 1 planned to include refurbished doors, new door seals and new frames.
Cost:	Operator information	
Indicator:	Not available	
Target emissions reduction:	Not available	
Source affected:	Industry including heat and power production	2018 update - A new torque meter has been made specifically for ACO which allows dedicated engineering personnel to check the torque settings of the door machines
Spatial scale:	Local	
Cost:	Operator information	

	become easier and more consistent				Indicator:	Not available	and make necessary adjustments.
					Target emissions reduction:	Not available	2019 plan Carry out major maintenance work on pusher machines. This will include structural repairs to No 4 and No 3 pusher and modular changes. Ram beam change to be planned in for No 4 pusher.
Appleby Coke Ovens 03	Machine alignments; The development of a cross-battery interlock system, using lasers to accurately line up pusher and coke machines, is under consideration.	Permit systems and economic instruments: IED permits	Start: 2015 Expected end: 2018 Status: Implementation	Source affected:	Industry including heat and power production		ON-GOING: The project to install cross-battery interlock system is ongoing. Update – Issues due to battery movement have prevented implementation to date, but it is anticipated that this
				Spatial scale:	Local		
				Cost:	Operator information		

				Indicator:	Not available	can be fitted to each battery. This is still on the plan to complete.
				Target emissions reduction:	Not available	
Appleby Coke Ovens 04	Access to carry out door maintenance; There are issues with working at height on the battery bench level to manually plug leaks. Very constrained in meeting Health and Safety requirements as the design is a shallow concrete foundation bench.	Permit systems and economic instruments: IED permits	Start: 2012 Expected end: 2018 Status: Implementation	Source affected:	Industry including heat and power production	COMPLETED 4 new EZ bonding lines in place. These will allow for quicker access. An alternative option and design developed to implement on the Pusher side; a lanyard and running rail system. Trial successful full engineering design developed. EZ line installed of B4. New Heras fencing installed in floors on
				Spatial scale:	Local	
				Cost:	Not available	
				Indicator:	Not available	
				Target emissions reduction:	Not available	

						all batteries to enable safe access. This issue has now been resolved and will not be progressed further.	
Appleby Coke Ovens 05	New Doors and Frames; Where damage to doors and frames is such that repairs cannot be affected in-situ then a programme of replacement is required. Develop a schedule for door and frame replacement as required at Appleby, subject to the outcome of the capital expenditure plan.	Permit systems and economic instruments: IED permits	Start:	2015	Source affected:	Industry including heat and power production	ON-GOING: Included in the PAH / coke oven recovery capital expenditure plan. Recovery plan is ongoing and will continue through 2019/20.
			Expected end:	Ongoing			
			Status:	Implementation			
			Spatial scale:	Local			
			Cost:	Unknown, Operator information			
Indicator:	Not available						
Target emissions reduction:	Not available						

						side to improve, full new set of tie rods, new coke side bench and all coke side buckstays to be replaced.
Appleby Coke Ovens 06	New inspection hatch door seals; Inspection hatches are provided in the oven top to allow temperature and visual checks to be made. The hatch seals can become degraded owing to repeated movement and require replacement. A programme of replacements is ongoing, 132 seals are to be replaced.	Permit systems and economic instruments: IED permits	Start: 2013 Expected end: 2015 Status: Complete	Source affected:	Industry including heat and power production	132 hatches fitted, all COMPLETED .
				Spatial scale:	Local	
				Cost:	Operator information	
				Indicator:	Not available	
				Target emissions reduction:	Not available	

Appleby Coke Ovens 07	Replacement spigot jointing compound; A seal is provided around the ascension pipe spigot to allow emission-free collection of coke oven gas from each oven.	Permit systems and economic instruments: IED permits	Start:	2013	Source affected:	Industry including heat and power production	COMPLETED: The replacement spigot compound is now being used. Although it is not as reliable as the previously used compound (in terms of deterioration), it is better quality and it is the best available on the market. No further actions.
			Expected end:	2014			
			Status:	Complete			
			Spatial scale:	Local			
			Cost:	Operator information			
Indicator:	Not available						
			Target emissions reduction:	Not available			
Appleby Coke Ovens 08	Pullman valve replacements; A programme of valve replacements, to combat a design issue, is ongoing.	Permit systems and economic instruments: IED permits	Start:	2009	Source affected:	Industry including heat and power production	ON-GOING: 2018 Update: Routine maintenance of the Pullman valves is ongoing. This will continue as "Business as Usual". There is no
			Expected end:	Ongoing			
			Status:	Implementation			
			Spatial scale:	Local			

					Cost:	Operation information	longer a significant issue related to these valves.
					Indicator:	Not available	
					Target emissions reduction:	Not available	
Appleby Coke Ovens 09	Tie rod replacements; Periodical surveys are carried out to inspect tie rod integrity and a programme of replacement has commenced and is expected to continue until 2015	Permit systems and economic instruments: IED permits	Start: 2013 Expected end: Ongoing Status: Implementation	Source affected:	Industry including heat and power production	ON-GOING: 2018: Battery 1 hot idle was slightly delayed. Work continues during 2018/2019 to replace all tie rods on battery 1 as required during the programmed hot idle period in late 2018/early 2019. 2019 Plan	
				Spatial scale:	Local		
				Cost:	Operator Information		
				Indicator:	Not available		

					Target emissions reduction:	Not available	Continue to replace tie rods where necessary for structural stability of the coke ovens/batteries.
Appleby Coke Ovens 10	Repairs to battery refractories; A programme of silica welding and end flue repairs to seal oven wall cracks has begun and is expected to continue throughout the remaining operational lifetime of the coke oven plant	Permit systems and economic instruments: IED permits	Start: 2013 Expected end: 2024 Status: Implementation	Source affected:	Industry including heat and power production	ON-GOING: 2018 - Battery 1 refurbishment was ongoing and is anticipated to be completed by September 2019. 2019 Plan Battery 1 - All pusher side end flue repairs, all coke side end flue repairs. Business as usual maintenance ongoing on all other batteries.	
					Spatial scale:		Local
					Cost:		Operator information
					Indicator:		Not available
					Target emissions reduction:		Not available

Appleby Coke Ovens 11	Replacement of battery refractories; Where repairs to battery refractories are ineffectual or not practically possible, and where the continued operation of the oven will cause excessive emissions, the oven in question is taken out of operation minimising pollution.	Permit systems and economic instruments: IED permits	Start:	2013	Source affected:	Industry including heat and power production	ON-GOING: A significant Battery Recovery Programme was initiated during 2014 and subject to a capital plan proposal put forward. Mainly end wall and flue repairs. This continued through 2017, including hot idling of battery 3, and will continue into 2018, when battery 1 will be hot idled.
			Expected end:	2024			
			Status:	Implementation			
			Spatial scale:	Local			
			Cost:	Subject to Capital plan proposal			
Indicator:	Not available						
Target emissions reduction:	Not available						
Appleby Coke	Pressure stabilisation system; A linkage pipe has been placed on either side of the gas	Permit systems and economic	Start:	2012	Source affected:	Industry including heat and	COMPLETED.
			Expected end:	2013			

Ovens 12	booster station, providing a pressure feedback loop.	instruments: IED permits	Status: Complete		power production	
				Spatial scale:	Local	
				Cost:	Operator information	
				Indicator:	Not available	
				Target emissions reduction:	Not available	
Appleby Coke Ovens 13	New Gas Holder to improve pressure control. Beneficial effects in reducing pressure fluctuations and hence emissions from the batteries caused by high positive pressure.	Permit systems and economic instruments: IED permits	Start: 2015 Expected end: 2017 Status: Planning	Source affected:	Industry including heat and power production	ON-GOING: The new gas holder was commissioned in September 2018.
				Spatial scale:	Local	
				Cost:	Operator Information	

				Indicator:	Not available	
				Target emissions reduction:	Not available	
Appleby Coke Ovens 14	Underfiring Changeover Timings; Reversal of the heating cycle in the coke ovens at Appleby and Dawes Lane now timed not to coincide	Permit systems and economic instruments: IED permits	Start: 2013 Expected end: 2013 Status: Complete	Source affected:	Industry including heat and power production	COMPLETED.
				Spatial scale:	Local	
				Cost:	Not available	
				Indicator:	Not available	
				Target emissions reduction:	Not available	

Appleby Coke Ovens 15	New benzole plant; The benzole plant will be replaced. This will minimise pressure increase at the batteries, and secondly, prevent naphthalene in burner flues and leading to cold spots on oven walls, and eventual refractory damage caused by inconsistent heating.	Permit systems and economic instruments: IED permits	Start:	2014	Source affected:	Industry including heat and power production	ON-GOING: The new benzole plant was successfully commissioned in 2017 and is now running a stable operation.
			Expected end:	2017			
			Status:	Implementation			
			Spatial scale:	Local			
			Cost:	Operator information			
Indicator:	Not available						
Target emissions reduction:	Not available						
Appleby Coke Ovens 16	Coke machine 'inching' facility; The facility to 'inch' the position of the machines will allow better alignment and less	Permit systems and economic instruments: IED permits	Start:	2015	Source affected:	Industry including heat and power production	COMPLETED. New operator panels fitted to all three pushing machines. Systems fitted to four
Expected end:	2016	Status:	Complete				

	damage to the battery metalwork and fabric	
Appleby Coke Ovens 17	Automated leveller control; An automated leveller control system is currently being considered as part of a management of change exercise.	Permit systems and economic instruments: IED permits

Start: 2015
Expected end: 2018
Status: Planning

Spatial scale:	Local	of the six machines. Trial unsuccessful on pusher machines, implemented on all 3 guide machines in use.
Cost:	Operator information	
Indicator:	Not available	
Target emissions reduction:	Not available	
Source affected:	Industry including heat and power production	2018 - See action Appleby Coke Ovens 03. This work will follow interlock system installation, which will be progressed over the coming years.
Spatial scale:	Local	
Cost:	Not available	
Indicator:	Not available	

					Target emissions reduction:	Not available	
Appleby Coke Ovens 18	New venting lids; A new 'venting lid' has been developed to allow burn off of carbon deposits. The build-up of carbon deposits on the roof of the oven can also cause pressure issues within the oven by blocking the free passage of coke oven gas leading to door / tops leakage.	Permit systems and economic instruments: IED permits	Start:	2013	Source affected:	Industry including heat and power production	COMPLETED.
			Expected end:	2013			
			Status:	Complete			
			Spatial scale:	Local			
			Cost:	Operator information			
Indicator:	Not available						
					Target emissions reduction:	Not available	
Appleby Coke	Primary cooler replacement; When primary coolers are not effective, the pressure of	Permit systems and economic	Start:	2013	Source affected:	Industry including heat and	ON-GOING:
			Expected end:	2019			

Ovens 19	the by-products plant is increased, and this is translated to the batteries and door / tops leakage.	instruments: IED permits	Status: Implementation		power production	<p>2018 No 3 primary cooler was upgraded during this period.</p> <p>2019 Plan:</p> <p>No. 2 primary cooler to be refurbished, no. 4 saturator to build and no. 3 saturator to be refurbished.</p>
				Spatial scale:	Local	
				Cost:	Operator information	
				Indicator:	Not available	
				Target emissions reduction:	Not available	
Appleby Coke Ovens 20	Heating system checks; The original analysis of waste gas emissions from individual oven flues was completed. This was to provide information on the operation of each individual oven in terms of heating uniformity and	Permit systems and economic instruments: IED permits	Start: 2013 Expected end: Ongoing Status: Implementation	Source affected:	Industry including heat and power production	<p>COMPLETED:</p> <p>External consultants have completed a heating survey since the initial trials. Additional resources put in place to carry out the recommendations of</p>
				Spatial scale:	Local	

	emissions. No benefit from the trial and engaged an external company.				Cost:	Not available	this survey. Reviewed 6 monthly. Extra resource allocated as part of new recovery plan. This is now business as usual, rather than an improvement.
					Indicator:	Not available	
					Target emissions reduction:	Not available	
Dawes Lane Coke Ovens 01	Closure of Dawes Lane Coke Ovens	Permit systems and economic instruments: other	Start: 2016 Expected end: 2016 Status: Complete		Source affected:	Industry including heat and power production	Dawes Lane Coke Ovens closed 8 March 2016
					Spatial scale:	Local	
					Cost:		
					Indicator:		
					Target emissions reduction:		