



**The Member Secretary,
Odisha State Pollution Control Board,
A/118, Nilakanthanagar, Unit-VIII,
Bhubaneswar – 751 012, Odisha.**

*TSK/Env/C-05/ 33 /2023
Sept 20, 2023*

Dear Sir,

**Sub: Environmental Statement for the Year 2022-23 for Integrated Steel Plant at
Kalinganagar Industrial Complex, Tata Steel Limited.**

We are enclosing the “Environmental Statement” duly filled in Form V, for the year 2022-2023 for Integrated Steel Plant at Kalinganagar Industrial Complex by Tata Steel for your kind consideration.

We trust that you will find the above in order.

Thanking you.

Yours faithfully,

For Tata Steel Limited

Head, Environment
Tata Steel Kalinganagar.

Encl: a/a.

Copy to: Regional Officer, OSPCB, Kalinganagar

TATA STEEL KALINGANAGAR

Jajpur 755 026 India

Registered Office Bombay House 24 Homi Mody Street Fort Mumbai 400 001

Tel 91 22 66658282 Fax 91 22 66657724

Corporate Identity Number L27100MH1907PLC000260 Website www.tatasteel.com

**ENVIRONMENTAL STATEMENT
FOR THE YEAR 2022-23**

For

**INTEGRATED STEEL PLANT OF TATA STEEL AT
KLAINGANAGAR INDUSTRIAL COMPLEX, ODISHA**



**ENVIRONMENTAL DEPARTMENT
TATA STEEL KALINGANAGAR
Kalinga Nagar Industrial Complex,
Duburi- 755026, Dist- Jajpur, Odisha**

ENVIRONMENTAL STATEMENT FORM-V
(See rule 14)

Environmental Statement for the financial year 2022-23 ending with 31st March

Tata Steel Limited
8.0 MTPA Steel Plant at Kalinganagar Industrial Complex, Odisha
PART-A

i)	Name and address of the owner/ occupier of the industry, operation or process	:	Rajiv Kumar VP, Operations Tata Steel Limited, Block-2, General Admin office Kalinga Nagar Industrial Complex Duburi-755026 Orissa
ii)	Industry Category Primary/(STC code) Secondary (STC code)	:	Large Metallurgical Industry —
iii)	Production Capacity	:	8.0 MTPA Crude Steel
iv)	Year of Establishment	:	2016
v)	Date of Last Environmental /Audit Report submitted	:	29.09.2022

PART-B

WATER AND RAW MATERIAL CONSUMPTION

- i) **Water Consumption in m³/day**
- | | | |
|----------|---|-------|
| Process | : | 16461 |
| Cooling | : | 14011 |
| Domestic | : | 4672 |

Name of the products	Process water consumption per unit of products	
	During the previous Financial Year 2021-2022	During the Current Financial Year 2022-2023
Crude Steel	3.35 cum/MT	3.32 cum/MT

ii) Raw material consumption:

Name of Raw Material	Name of the Products	Consumption of raw material per unit of output (MT/ TCS)	
		During the previous Financial Year 2021-2022	During the Current Financial Year 2022-2023
Coal	Crude Steel	0.58	0.62
Iron Ore		1.49	1.39
Limestone		0.42	0.38
Dolomite		0.02	0.02
Metal & Ferro Alloys		0.02	0.02

PART-C

POLLUTION DISCHARGED TO ENVIRONMENT/ UNIT OF OUTPUT
(PARAMETERS AS SPECIFIED IN THE CONSENT ISSUED)

Pollutants	Quantity of pollutants discharged (mass/day)	Concentrations of pollutants in discharges (mass/volume)	Percentage of variation from prescribed standards with reasons*
	Kg/day	mg/Nm ³	
a) Water	No discharge of Process wastewater. CETP is in operation.		
b) Air			
1	Coke Oven Battery No.1		
PM	205.86	28.1	-43.89
2	Coke Oven Battery No. 1 De-dusting Chimney		
PM	95.7	14.3	-71.40
3	Coke Oven Battery No. 2		
PM	196.12	26.6	-46.90
4	Coke Oven Battery No. 2 De-dusting Chimney		
PM	87.90	13.1	-74.59
5	CPP Boiler-1		
PM	189.24	12.7	-74.59
SO ₂	951.33	63.9	-89.35
NOx	406.03	27.3	-90.91
6	CPP Boiler-2		
PM	211.88	13.7	-72.65
SO ₂	369.29	23.1	-96.03
NOx	194.99	12.6	-95.81
7	BF Cast House-1		
PM	486.42	25.0	-49.97
8	BF Cast House-2		
PM	486.10	25.4	-49.15
9	BF Stock House		
PM	589.91	28.6	-42.88
10	Blast Furnace Stove		
PM	83.00	4.4	-91.15
11	Lime Calcination Kiln-1		
PM	43.91	13.0	-91.31
12	Lime Calcination Kiln-2		
PM	47.66	12.9	-91.39
13	Sinter Plant Waste Gas Chimney		
PM	2070.82	40.6	-18.84
14	Sinter Plant De-dusting		
PM	394.52	20.6	-58.72
15	Stack attached to CDQ		
PM	115.27	21.8	-56.44
16	Stack attached to HSM Recuperator 1		
PM	97.88	15.1	-84.94
17	Stack attached to HSM Recuperator 2		
PM	87.20	13.2	-86.78
18	SMS		
PM	1242.03	21.5	-57.09

PART-D

HAZARDOUS WASTES

(AS SPECIFIED UNDER HAZARDOUS WASTES (MANAGEMENT, HANDLING AND TRANS BOUNDARY MOVEMENT RULES, 2016)

Hazardous Wastes	Total Quantity (Kg)	
	During the previous Financial Year 2021-2022	During the Current Financial Year 2022-2023
1. From Process		
Sludge and filters Contaminated with Oil (Schedules-I Stream-3.3)	Nil	Nil
Used or spent oil (Schedules-I Stream-5.1)	31060	169960
Wastes / Residues containing oil (Schedules-I Stream-5.2)	74510	76240
Used grease / Greased sludge (Schedules-I Stream-5.2)	159590	119040
Oil-soaked jute / cotton (Schedules-I Stream-5.2)	~ 10 MT (by Volume)	~ 10 MT (by Volume)
Acid from used Batteries (Schedules-I Stream-9.3)	Nil	Nil
Acid & Alkaline residues, spent acid and Alkali (Schedules-I Stream-12.1 & 12.2)	Nil	Nil
Coal Tar sludge (Schedules-I Stream-13.4)	245000	305000
Tar tank, Storage sludge / residues (Schedules-I Stream-13.5)	Nil	Nil
CO gas pipeline waste & residue from CO gas tap (Schedules-I Stream-13.6)	Nil	Nil
Cleaning solvent sludge (Schedules-I Stream-20.4)	Nil	Nil
Empty containers of hazardous chemical (Schedules-I Stream-33.1)	1750	100
Exhaust air or gas cleaning residue (Schedules-I Stream-35.1)	Nil	Nil
Spent Ion exchange resins (Schedules-I Stream-35.2)	Nil	Nil
Sludge from wastewater treatment (Schedules-I Stream-35.3)	386170	360350
Oil and grease skimming residue Schedules-I Stream-35.4	Nil	Nil
Waste cartridge from CETP, WWTP Schedules-I Stream-36.2	Nil	Nil
Evaporation residue from CETP (Schedules-I Stream-37.3)	Nil	Nil
Insulation Material (Schedules-II Class-C)	Nil	68250

Containers of oil/ grease - were used for storage of same material and the hazardous wastes (used oil/used grease/waste oil etc.) were sold to authorised recyclers along with the containers.

PART-E
SOLID WASTE

Sl. No.	Solid waste	Total Quantity (Kg)	
		During the previous financial year 2021-22	During the current financial year 2022-23
a.	From process	1454113 MT of BF Slag 624652 MT of LD Slag	1432297 MT of BF Slag 670678 MT of LD Slag
b.	From Pollution Control facilities	37758 MT of Flue Dust	26441 MT of Flue Dust
c.	1) Quantity recycled/reutilised within the unit	<u>Utilised Inhouse</u> 33203 MT of Flue Dust 499573 MT of LD Slag 36862 MT of BF Slag	<u>Utilised Inhouse</u> 28354 MT of Flue Dust 519135 MT of LD Slag 58842 MT of BF Slag
	2) Sold	1450909 MT of BF Slag 128429 MT of LD Slag	1390645 MT of BF Slag 152775 MT of LD Slag
	3) Disposed	Nil	Nil

PART-F

Please specify the characteristics (in terms of concentration and quantum) of hazardous as well as solid wastes and indicate disposal practice adopted for both these categories of wastes.

Hazardous/ Solid Wastes	Characteristics	Method of disposal
Wastewater Sludge / Filter cake from CETP	Cr(T)- 99.69; Pb (T)- 10.44, Ni (T)-60.20; Zn(T)- 46.59, Cu(T)- 29.38 <i>(unit- mg/Kg)</i>	Disposed through CHWTSDF Sukinda
Coal Tar sludge	C-90-95; Moisture- 1.3, S- 0.3-0.7; CV-8800 Kcal/Kg, Sp. Gr. – 1.2, Ash- 0.04-0.05	Mixed with coal and used in coke plant.
LD Slag	CaO- 49.00; Fe ₂ O ₃ -32.95; SiO ₂ -10.44; MgO-2.09; P ₂ O ₅ -1.95; MnO-1.20; TiO ₂ -1.09; Al ₂ O ₃ -0.73; Cr ₂ O ₃ -0.17; V ₂ O ₅ -0.16; SO ₃ -0.13; SrO-0.03; Nb ₂ O ₅ -0.02; K ₂ O-0.02; Na ₂ O- 0.02	<ul style="list-style-type: none"> • Metal recovery • Utilised in sinter plant • Non-metallic portion used in construction and low-lying area filling inside premises.

BF Slag (Solid Waste)	SiO ₂ -33.71; CaO-25.09; Fe ₂ O ₃ - 5.06; Al ₂ O ₃ -14.84; MgO-6.60; TiO ₂ -1.18; K ₂ O- 1.02; SO ₃ -0.79; MnO-0.75; Na ₂ O-0.33; Cr ₂ O ₃ -0.17; BaO-0.15; P ₂ O ₅ -0.11; ZrO ₂ - 0.07; SrO-0.06; ZnO-0.02; PbO-0.01; Cl- 0.01; Y ₂ O ₃ -0.01; NiO-0.01; Nb ₂ O ₅ -0.01; Rb ₂ O-0.01; CuO-0.01	Sold to cement industries
Mill Scale (Solid Waste)	Fe(T)- 72-75; MnO- <0.5, SiO ₂ - < 0.5; Al ₂ O ₃ - <0.5; MgO- 0.1; Oil- 10-12	Used in Sinter plant
Lime Fines (Solid Waste)	CaO- 66.5; Al ₂ O ₃ - 0.26, SiO ₂ - 1.53; MgO- 5.68	Used in Sinter plant

PART-G

Impact of the pollution control measures taken on conservation of natural resources and consequently on the cost of production.

- Pollution control equipment are effective and efficiently operated at all units.
- By-product gases generated in Coke plant, Blast Furnace and Steel melting shop are recovered and clean gas is used as fuel in power generation and other units, thus reducing coal consumption.
- Zero Liquid Discharge (ZLD) recirculation system is under stabilization to maintain ZLD during non-rainy days.
- Centralised Effluent Treatment Plant (CETP) in operation to maximize reuse and recovery of treated wastewater from different plant units.
- 2 Nos. of Mechanised Road sweeping machine are deployed to maintain housekeeping of plant roads.
- To suppress fugitive dusts on roads and other areas, truck mounted water tankers are used for water sprinkling.
- TSK has achieved 33% Greenbelt Development & has planted 7.41 lakh plantations in 456 ha in & around TSK.
- Investment of more than Rs. 1993.07 Crores has been made for pollution control equipment and other environmental protection measures.
- ISO 14001:2015 and ISO 45001: 2018 certification obtained in Sep'2020 and valid till August 2026.
- Tyre Washing facility installed at MRP and Ore & Flux Yard is in operation.

PART-H

Additional measures/investment proposal for environmental protection including abatement of pollution.

- Environmental Laboratory facilities being upgraded.
- Installation of Flow, Temperature, Pressure and Moisture at all stacks w.r.to CPCB OCEMS revised guidelines.
- Investment for installation of additional 4 nos of Tyre washing facilities is in progress.
- Greenery development programme will continue in the year 2024.
- CETP Upgradation is in advance stage of completion from existing capacity of 660 m3/hr to 830 m3/hr.
- Floating solar panel installation at raw water reservoir is in progress.

PART-I

MISCELLANEOUS:

Any other particulars in respect of environmental protection and abatement of pollution.

- Tree plantation is undertaken in and around the site. Details of tree saplings planted: -

FY	Plantation (Nos.)	FY	Plantation (Nos.)
2009-10:	792	2016-17:	77335
2010-11:	1130	2017-18:	100701
2011-12:	4800	2018-19:	28072
2012-13:	12622	2019-20:	103212
2013-14:	29888	2020-21:	12415
2014-15:	35437	2021-22:	203841
2015-16:	78730	2022-23:	82176

Avenue plantation is being taken up at Jajpur town, Kalinganagar and Bhubaneswar

- To maintain housekeeping of plant roads, mechanised road sweeping machines is operated.
- Regular Environmental Monitoring is carried out. Please refer to **Annexure-I**.
- Seven Nos. of Online AAQM stations commissioned along with Environmental Display Board and data linkage provided for continuous display of data. 19 nos. of CEMS, 2 nos. of CEQMS, 3 nos Surveillance IP Cameras have been installed and connected to the server of the OSPCB and CPCB.
- Consent to Operate (CTO) for integrated steel plant granted by OSPCB which is valid till 31.03.2024.
- About 10000 Sq. meter of Garden has been developed in FY 23. 1.47 Lakh sq. meter of garden landscape are being maintained in & around Kalinganagar.

- Miyawaki plantation methodology has been adopted at 5 locations CETP, IBMD, Sinter plant and 2 locations at HSM to create denser plantation in short span of time.
- In FY 2023, 17.80 MT of e- wastes were collected and deposited to authorised e- waste collection centre of M/s Sani clean Pvt Ltd., Bhubaneswar, M/s J. S. Pigments Pvt. Ltd and M/s Earthbox Ventures Pvt Ltd.
- In CY 2022, 90.36 Kgs of Biomedical wastes generated in plant's First Aid centre were segregated, collected, and disposed through Authorised Biomedical waste disposal facility of M/s Sani clean Pvt Ltd, Bhubaneswar.
- In FY 2023, 0.1 Ton of chemically contaminated bottles were disposed through authorised party M/s Eco resource.

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Annexure-1

Ambient Air Quality Monitoring at TSK

Location	PM10 (or size <10 µm) µg/m ³	PM2.5 (or size <2.5µm) µg/m ³	SO ₂ (µg/m ³)	NO _x (µg/m ³)	CO (mg/m ³)
Gate No. 1	77.3	38.1	8.8	38.6	0.6
Coke Plant	82.3	42.8	9.6	40.1	0.7
SMS	70.8	35.1	7.6	35.3	0.5
HSM	69.2	35.6	7.8	33.7	0.5
Gate No. 4	78.5	39.3	8.8	39.4	0.6
Sinter Plant	79.0	37.6	8.3	37.1	0.6
BF Area	74.2	37.8	8.9	40.2	0.6
Standard	≤ 100	≤ 60	≤ 80	≤ 80	≤ 4.0

TREATED EFFLUENT QUALITY

Frequency:		Daily Average							
Outlet No.	Description of Outlet	pH	TSS (mg/l)	Phenol (mg/l)	BOD (mg/l)	COD (mg/l)	Cyanide (mg/l)	Ammoniacal Nitrogen (mg/l)	O&G (mg/l)
OSPCB Standard		6.0-8.0	100	1	30	250	0.2	50	10
1	BOD Plant Outlet	7.1	14.4	0.3	7.5	125.8	0.1	6.1	7.1

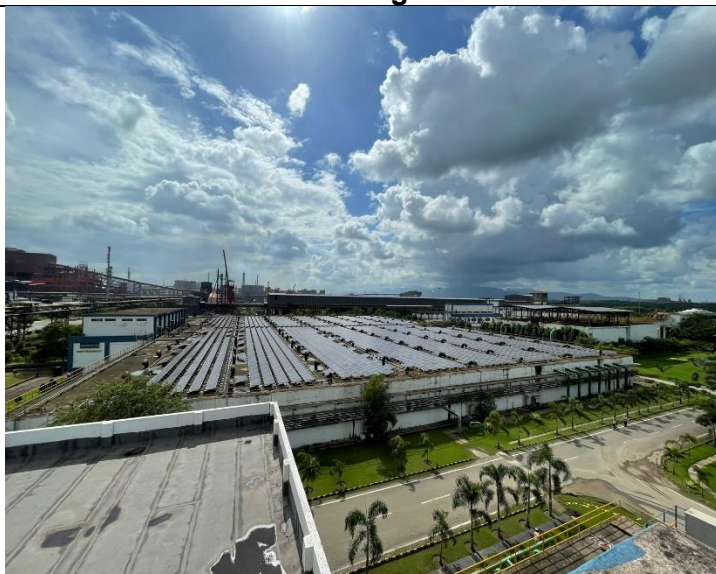
Some Photographs of Tata Steel Kalinganagar



Barrel Storage Shed



Tyre Washing Facility



1 MW Solar Panels installed at RWTP



Mechanised road dust sweeping



Water Treatment Complex at TSK



Plant Aesthetic view