


6. APPENDICES

Appendix 1: North Capel Annual Audit Compliance Report (AACR)

		Government of Western Australia Department of Water and Environmental Regulation	
Annual Audit Compliance Report Form <i>Environmental Protection Act 1986, Part V Division 3</i>			
Once completed, please submit this form either via email to info@dwer.wa.gov.au , or to the below postal address:			
Department of Water and Environmental Regulation Locked Bag 10 Joondalup DC WA 6919			
Section A – Licence details			
Licence number:	L4557/1986/19	Licence file number:	DER2014/000051-1
Licence holder name:	Iluka Resources Limited		
Trading as:	Iluka Resources Limited		
ACN:	34 008 675 018		
Registered business address:	Level 17, 240 St Georges Terrace, Perth WA, 6000		
Reporting period:	01 / 01 / 2023 to 31 / 12 / 2023		
Section B – Statement of compliance with licence conditions			
Did you comply with all of your licence conditions during the reporting period? (please tick the appropriate box)			
<input type="checkbox"/> Yes – please complete: <ul style="list-style-type: none"> • section C; • section D (if required); and • sign the declaration in Section F. 			
<input checked="" type="checkbox"/> No – please complete: <ul style="list-style-type: none"> • section C; • section D (if required); • section E; and • sign the declaration in Section F. 			
Section C – Statement of actual production			
Provide the actual production quantity for this reporting period. Supporting documentation is to be attached.			
Prescribed premises category		Actual production quantity	
8 Mineral Sands mining or processing		420,960 t (Ilmenite)	
31 Chemical manufacturing		259,543 t (Synthetic Rutile)	
37 Char manufacturing		15,776 t (Activated Carbon)	
<small>IR-F34 v4.0 (February 2019)</small>			

Department of Water and Environmental Regulation

Section D – Statement of actual Part 2 waste discharge quantity

Provide the actual Part 2 waste discharge quantity for this reporting period. Supporting documentation is to be attached.

Prescribed premises category	Actual Part 2 waste discharge quantity
31 Chemical manufacturing	20,760 t (Bitterns)
31 Chemical manufacturing	16,660 t (Inert Waste)

Section E – Details of non-compliance with licence condition

Please use a separate page for each condition with which the licence holder was non-compliant at a time during the reporting period.

Condition no:	2.2.2	Date(s) of non-compliance:	17/11/2023
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Details of non-compliance:

Ektimo were contracted to undertake the second round of six monthly stack testing as per Condition 4.2.1. This allowed compliance monitoring to occur prior to the scheduled North Capel Operations Major Maintenance Outage. Standard operational process conditions were experienced, leading up to the emissions monitoring.

Ektimo conducted SR1 (A15) H2 Compliance Stack emissions monitoring on the 29 September 2023. Sampling time: 10:30am to 12:55pm. This monitoring event was opportunistic, to gather the H2 analysis, prior to ceasing operations for a Major Maintenance Outage (MMO), whilst remaining outside the 45 day criteria between CGA/RATA events.

Elevated TPM levels were observed with high Carbon monoxide (CO) levels within the kiln and scrubber process. High CO levels are a result of elevated kiln pressures which reduce oxygen flow, impacting combustion of CO and particulates.

Draft results were received from Ektimo on the 16th November 2023 11:58am, stating the elevated average total particulate emission levels of 310mg/m³. The exceedance was investigated, and reported to DWER on 17/11/2023 07:20am (Lodgment ticket ID 0105862).

The SR1 kiln commenced shutdown from 2nd October 2023, and is currently under a Major Maintenance Outage (MMO) and Operational Hold. No other opportunity for a validation monitoring event was possible.

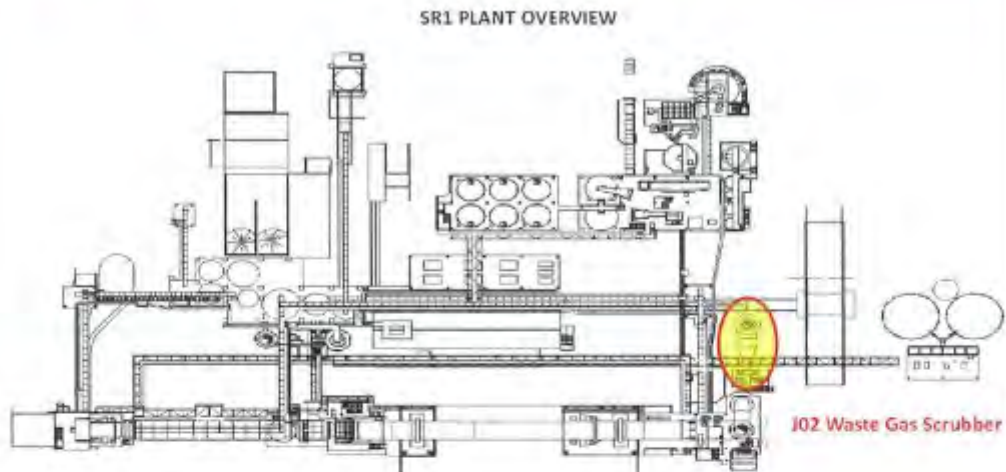
Section E – Details of non-compliance with licence condition

What was the actual (or suspected) environmental impact of the non-compliance?

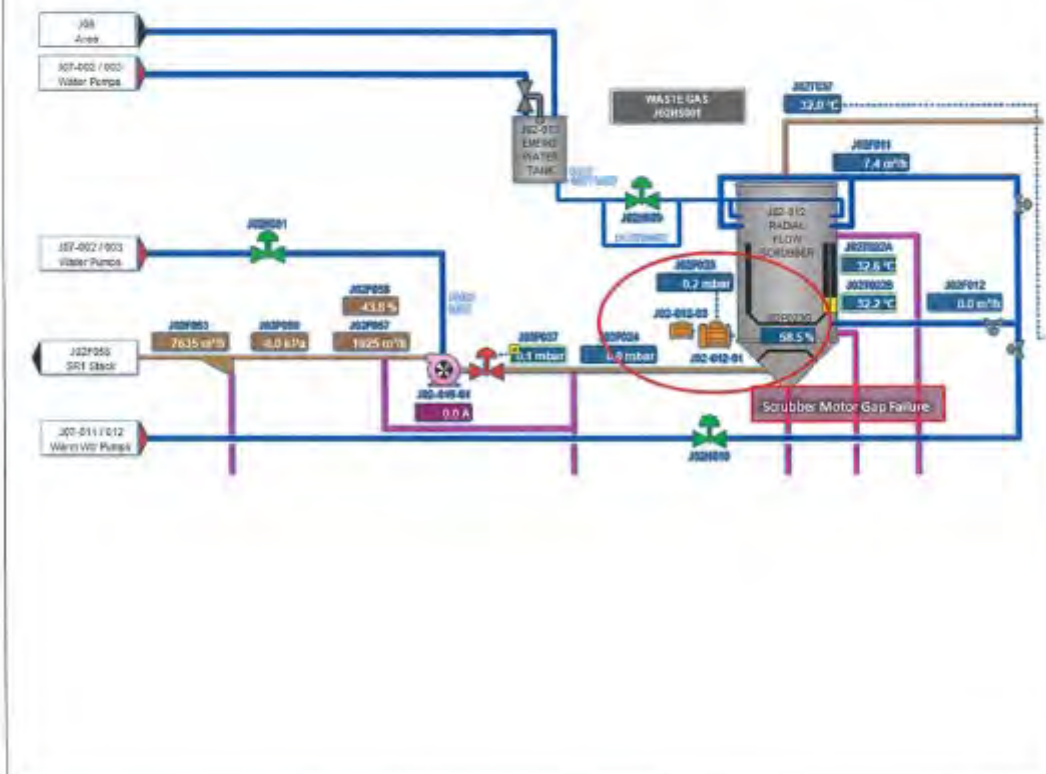
NOTE – please attach maps or diagrams to provide insight into the precise location of where the non-compliance took place.



Section E – Details of non-compliance with licence condition



Uniformance Operations Control View – J02_012 Radial flow Scrubber Gap Adjuster

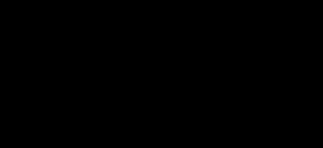
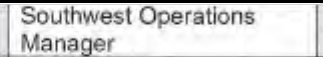


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Section F – Declaration

I / We declare that the information in this Annual Audit Compliance Report is true and correct and is not false or misleading in a material particular¹.

I / We consent to the Annual Audit Compliance Report being published on the Department of Water and Environmental Regulation's (DWER) website.

Signature ² :		Signature:	
Name: (printed)		Name: (printed)	
Position:	Southwest Operations Manager	Position:	
Date:	13/03/2024	Date:	
Seal (if signing under seal):			

¹ It is an offence under section 112 of the *Environmental Protection Act 1986* for a person to give information on this form that to their knowledge is false or misleading in a material particular.

² AACRs can only be signed by the licence holder or an authorised person with the legal authority to sign on behalf of the licence holder.

Department of Water and Environmental Regulation

Section E – Details of non-compliance with licence condition

Cause (or suspected cause) of non-compliance:

28th to 30th September 2023: Prior to the H2 AR1 Monitoring event, the Processing team were working to stabilise kiln pressure fluctuations caused by previous kiln feed trips and blockages.

The scrubber gap can normally be altered via the control room to adjust kiln pressures and scrubber throughflow. However adjustments were not responding to control prompts. A technician was sent to verify scrubber gap operation, and it was discovered that the scrubber gap motor had failed.

The scrubber gap motor was repaired on 30th September. Post the repair, kiln pressure control improved significantly and stack emissions returned to target levels.

Action taken to mitigate any adverse effects of non-compliance and prevent recurrence of the non-compliance:

The scrubber gap motor was repaired on 30th September.

Process operators have real time access to Plant controls including CO emissions, kiln pressures and feed rates. Any spikes in CO levels are addressed as they occur, to maintain process efficiency. Alarm settings have been tightened, to alert the operators of possible adverse conditions leading to inefficient scrubber operations.

Was this non-compliance previously reported to DWER?

Yes, and

Reported to DWER verbally

Date: / /

Reported to DWER in writing

Date: 17 / 11 / 2023