



Ref. No. FAMD/FAPJ/716/FY24

Dated: 23/09/2022.

**The Member Secretary
State Pollution Control Board, Odisha
Paribesh Bhavan
A/118, Nilakantha Nagar, Unit-VIII
Bhubaneswar-751012**

Sub: Submission of Environmental Statement of Ferro Manganese Plant, Joda for the period of 2022-23.

Dear Sir,

We are submitting one set of Annual Environmental Statement in FORM-V dully filled in for the year 2022-2023 in respect of M/s Ferro Manganese Plant, Joda by Tata steel for your kind consideration.

We wish to maintain that necessary control measures have been installed and adopted to minimize the impact on environment.

We look forward to further your guidance which shall certainly help us in endeavoring further improvements in our Environmental Management Practices.

Thanking you,

Yours faithfully,

For: TATA STEEL LTD.

Head & Factory Manager
Ferro Manganese Plant,
Joda

Encl: as above.

Copy to - Regional Officer, OPCB, At-Baniapatt, College Road, Keonjhar - with enclosure.

TATA STEEL LTD.
Ferro Alloys & Minerals Division
Ferro Manganese Plant, Joda
Joda – 758034, Odisha, India
Tel: 09238100945, e-mail –head.office@tatasteel.com
Regd. Office: Bombay House, 24 Homi Mody Street, Mumbai – 400 001



ENVIRONMENT STATEMENT

FOR THE FINANCIAL YEAR 2022-23

Submitted to SPCB under Rule 14 of The Environment (Protection) Rules 1986

TATA STEEL LIMITED
FERRO MANGANESE PLANT
JODA, KEONJHAR

ENVIRONMENTAL STATEMENT

OF

**FERRO MANGANESE PLANT
(TATA STEEL LIMITED)
JODA, KEONJHAR**

FOR THE YEAR 2022-2023

**PREPARED BY
THE DEPARTMENT OF SAFETY & ENVIRONMENT**

**FERRO MANGANESE PLANT
TATA STEEL LIMITED
JODA, DIST. KEONJHAR**

INTRODUCTION

Ferro Manganese plant, Joda was installed in 1958 as a captive source of supply of Manganese Alloys to steel Works, Jamshedpur with a capital investment of 1.58 Crores. The plant was set up in technical collaboration with M/s. ELKEM, Norway, one of the world pioneers in smelting technology. JODA Valley was selected as the plant site because of its close proximity to the Mn Mines of TSL from where major raw materials were to be procured. The plant was set up with an installed capacity of 30,000 MT of Fe-Mn per year from two Furnaces of 9 MVA.

Considering the changed market scenario, one of the two furnaces was modified in the year 1989 to increase the capacity from 9 MVA to 15 MVA. In the year 1995, further modification was carried out in the furnace configuration as well as pit side facilities.

M/S Tata steel limited (hereinafter termed as TSL) is presently operating with two submerged arc furnaces to produce a total of 0.06 MTPA Fe-Mn.

ABOUT THE PLANT

Plant Location and Accessibility

The site of the Ferro Manganese Plant is located at Joda, Tehsil- Barbil, District-Keonjhar, State-Odisha and it is a part of Survey of India Topo Sheet No. 73-F/8 bounded by the latitudes 22° 01' 01.181" N to 22° 01' 25.922" N and longitudes 85° 25' 48.671" E and to 85° 25' 48.671" E and the plant site is at a distance of 1.95 km from NH-215. The nearest Southeastern Railway line is at a distance of 1.0 km from plant, in East direction. The nearest airport is at Bhubaneswar at a distance of about 196 km in South-east direction. Nearest port is Paradeep at a distance of 232 km. The nearest township is Barbil which is 10.2 Km in North-West direction.

ENVIRONMENTAL STATEMENT FORM – V

(See rule 14)

ENVIRONMENTAL STATEMENT FOR THE FINANCIAL YEAR ENDING ON 31ST MARCH 2023

FERRO MANGANESE PLANT, TATA STEEL LIMITED, JODA

PART - A

1. Name and address of the Owner/occupier of the Industry, operation or process. : Mr. T.V. Narendran
MD, Tata Steel India & SEA
AT/PO- 5c Road, Jamshedpur
2. Name and address of the Factory Manager : Mr. Sarbeshwar Nayak
Head, Ferro Manganese Plant
AT/PO- Joda
3. Industry Category : Large
4. Production Capacity of Ferro Alloys. : 60,000 Tonnes/Annum
5. Year of establishment : 1958
6. Date of submission of previous Environmental Statement : 29th September 2022

PART – B

Water and Raw Material Consumption

A. Water consumption:

<u>Consumption Head</u>	2021-22 (in cu.m/Year)	2022-23 (in cu.m/Year)
Industrial Cooling	168468	234546
Process	18795	21000
Domestic	3196	2170
Name of the product(s)	Process water consumption per unit of products	
High Carbon FeMn	4.15	5.6

*The colony of FAP Joda is situated outside the plant area.

B. Raw material Consumption: -

The raw material consumption for the production of FeMn is as follows:

Name of raw materials	Name of Products	Consumption of raw material per unit of Output (KG/ MT or (MWH)	
		During the previous Financial Year (2021-2022) (in KG)	During the current Financial Year (2022-2023) (in KG)
Manganese Ore	Fe-Mn	2200 KG/tFeMn	2000 KG/tFeMn
Coke	Fe-Mn	540 KG/tFeMn	450 KG/tFeMn
Dolomite	Fe-Mn	230 KG/tFeMn	198 KG/tFeMn
Power Consumption	Fe-Mn	2.84 MWH/tFeMn	2.85 MWH/tFeMn
High MnO Slag	Fe-Mn	262 KG/tFeMn	248 KG/tFeMn
Quartzite	Fe-Mn	70 KG/tFeMn	40 KG/tFeMn

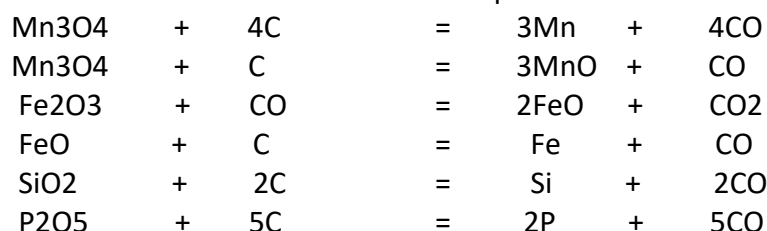
PART-C

POLLUTION DISCHARGED TO ENVIRONMENT/ UNIT OF OUTPUT **(Parameters as specified in consent issued)**

Basically, the plant produces air pollution, and the causes can be attributed to the process which has been briefed as follows: -

Brief description of the process producing FeMn:

During the smelting process, oxides of Iron, Manganese, Silicon, Sulphur and Phosphorous are reduced and the reactions involved in the above process are as follows: -



The Sulphur goes into the Slag and also escapes to the atmosphere through the stack as SO₂.

A. Water Pollutants:

The water used for cooling several parts of the Furnaces as well as scrubbing the flue gas in the Gas Cleaning Plants is re-circulated to the system and is not discharged outside the Plant. However, during rainy season discharge of storm water is a natural process.

B. Air Pollutants: Due to the effective operation of Gas Cleaning Plant. (Avg. data of the Year)

SI No.	Stack details	Pollutants	Quantity of Pollutants discharged (mass/day) (Ton/day)	Concentration of Pollutants discharged (mass/volume) (mg/Nm ³)	Percentage of variation from prescribed standard with reasons
1	Furnace 1	PM (mg/Nm ³)	0.0069	58.06	-41.94
2	Furnace 2		0.0061	51.64	-48.36

PART – D

HAZARDOUS WASTES
(AS SPECIFIED UNDER THE HAZARDOUS WASTES)

As specified under the Hazardous & Other Waste (Management & Trans boundary Movement) Rules, 2016 and amendment thereof)

HAZARDOUS WASTES	TOTAL QUANTITY GENERATED	
	DURING THE PREVIOUS YEAR (2021- 2022)	DURING THE CURRENT YEAR (2022- 2023)
I) FROM PROCESS		
a. Used transformer oil	8130 Lt.	9840 Lt
b. Waste oil	2000 Lt.	200 Lt.
c. Waste batteries	96 nos.	28 nos.
II) FROM POLLUTION CONTROL FACILITY		
Flue gas cleaning residue (GCP sludge)	3000 MT (approx.)	5311 MT (approx.)

PART – E

SOLID WASTES

Solid wastes from FAP Joda have been categories in two parts i.e., Fe-Mn Slag which is generated during smelting operations and Sludge generated from Wet scrubber of Gas cleaning plant. Slags are processed in slag crusher & sold to Si-Mn plant and/or some percentage reused as raw material in the process. GCP sludge is stocked in designated place inside the plant premises for making briquette. However, other solid waste (such as scrap material, used conveyor belts etc.) is also being generated.

SL No	SOURCES	TOTAL QUANTITY	
		DURING THE PREVIOUS FINANCIAL YEAR (2021- 2022)	DURING THE CURRENT YEAR (2022- 2023)
a	From Process	32670 MT of FeMn Slag	33466 MT of FeMn Slag
b	From Pollution Control Facility.	3000 MT (Approx.) of GCP Sludge	5311 MT of GCP Sludge approx..
c	1. Quantity recycled or Reused within the unit (FeMn Slag)	11557.11 MT	10334.34 MT
	2. Quantity sold (FeMn Slag)	17629.80 MT	30470 MT
	3. Quantity disposed (FeMn Slag)	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
FeMn Slag	MnO = 26% to 35% SiO ₂ = 20% to 30% R ₂ O ₃ * = 18% to 21% CaO = 6 % to 10% MgO = 4 % to 8%	During smelting operation High MnO slag generated as a by - product, which is partly used in Fe-Mn Process and partly sold to Si-Mn Plant.
GCP Sludge	MnO = 46% to 48% C = 3% to 4% R ₂ O ₃ = 10% to 12% CaO = 3% to 5% MgO = 6% to 7.5%	The sludge after being conveyed to the sludge drying beds from the thickener is allowed to dry sufficiently and the dry sludge is then transported to the earmarked sludge dumping site (a Co's low-lying leasehold area) for making briquette. In order to prevent the sludge getting into the water body flowing in proximity, a retaining wall of size 250Mtrs x 2.5 Mtrs x 0.5 Mtr as well as a garland drain encircling the total sludge dumping site and a 2-stage settling pit have been constructed around the dumping site adjoining the water body as pollution prevention measures.
Used Transformer Oil	Hydrocarbons	Sold to authorized recycler.
Waste batteries	lead and used acids.	Buy back to supplier

PART - G

IMPACT OF THE POLLUTION ABATEMENT MEASURES TAKEN ON CONSERVATION OF NATURAL RESOURCES AND ON THE COST OF PRODUCTON:

M/s Ferro Manganese Plant, Joda has spearheaded the pursuit for Environmental Protection by implementing an effective environmental management system. To this effect, the Plant has undertaken the following measures:

- i. Annual maintenance of all the four GCPs including power consumption and sludge transportation is Rs. 45 Lakhs (Approx.)
- ii. Annual maintenance of High velocity mobile type rotary water sprinkler including diesel consumption which incurred cost of Rs. 1.5 Lakhs.
- iii. Annual Maintenance of Fume Extraction System including power consumption is Rs. 0.5 Lakhs (Approx.)
- iv. Plantation in and around the Plant for which the annual expenditure of approx. Rs. 0.5 lakh was incurred.
- v. Environmental monitoring and annual maintenance cost incurred was Rs. 11.50 lakhs (approx.)
- vi. Cost of Rs. 1.5 lakhs incurred in maintenance of fixed sprinklers installed on internal roads.
- vii. Annual STP operation for which the annual expenditure of Rs.3.6 lakhs were incurred.
- viii. Effluent Treatment Plant of 30 m³ per hour capacity installed in a budget of 5 crore approx.

PART – H

ADDITIONAL MEASURES/ INVESTMENT PROPOSAL FOR ENVIRONMENTAL PROTECTION INCLUDING ABATEMENT OF POLLUTION, PREVENTION OF POLLUTION

- New tapping fume extraction system with bag filter installed for both the furnace. This will suction all the fumes generated during molten metal tapping.
- Completed 30 m³/hr ETP inside the plant premises to treat the effluent water & reuse.
- Gas Cleaning Plant overhauling done.
- Sludge Briquette Plant commissioned and started to utilize GCP Sludge in Briquette form as a raw material to Furnace.
- Tree plantation will continue in the year 2023-24.

PART – I

ANY OTHER PARTICULARS FOR IMPROVING THE QUALITY OF THE ENVIRONMENT

- Ferro Alloys Plant of TATA Steel Ltd. is certified for the Integrated Management System (ISO-9001:2015, ISO-14001:2015 & OHSAS-45001:2018 and SA:8000) from last two decades. The unit has obtained various prestigious accolades from various agencies.
- Various awareness programs throughout the year conducted in the area which included celebration of World Environment Day, Ozone Day, Earth Day, Sustainability Month etc. in which environment awareness programs, competitions are conducted every year.
- All above efforts make the plant clean - green and sustainable.