

LANCE R. LEFLEUR  
DIRECTOR



KAY IVEY  
GOVERNOR

Alabama Department of Environmental Management  
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Montgomery, Alabama 36130-1463  
(334) 271-7700 ■ FAX (334) 271-7950

September 24, 2021

**CERTIFIED MAIL NO.: 9489 0090 0027 6294 9226 42**  
**RETURN RECEIPT REQUESTED**

Mr. Victor Cifuentes  
Plant Manager  
Holcim (US) Inc.  
P.O. Box 649  
Theodore, AL 36590

Re: **Final Consent Order**  
Holcim (US) Inc.  
Theodore, Alabama  
Facility No. 503-8026

Dear Mr. Cifuentes:

Please find enclosed ADEM Consent Order No. **21-093-CAP**, which requires Holcim (US) Inc. to take certain actions in regard to alleged violations of the Alabama Air Pollution Control Act. This Order has been issued with the consent of Holcim (US) Inc. and the Department. Please note that the payment is due within 45 days of receipt of the Order.

If you have any questions concerning this matter, please contact Skyler Sanderson at (334) 270-5647 in Montgomery.

Sincerely,

A handwritten signature in black ink, appearing to read "RWG", is written over a light gray rectangular background.

Ronald W. Gore, Chief  
Air Division

Executed: 09-24-2021

Mailed: 09-24-2021

RWG/MSS

Enclosure

cc: Shawn Sibley, Office of General Counsel

Birmingham Branch  
110 Vulcan Road  
Birmingham, AL 35209-4702  
(205) 942-6168  
(205) 941-1603 (FAX)

Decatur Branch  
2715 Sandlin Road, S.W.  
Decatur, AL 35603-1333  
(256) 353-1713  
(256) 340-9359 (FAX)



Mobile Branch  
2204 Perimeter Road  
Mobile, AL 36615-1131  
(251) 450-3400  
(251) 479-2593 (FAX)

Mobile-Coastal  
3664 Dauphin Street, Suite B  
Mobile, AL 36608  
(251) 304-1176  
(251) 304-1189 (FAX)

ALABAMA DEPARTMENT OF  
ENVIRONMENTAL MANAGEMENT

IN THE MATTER OF:

Holcim (US) Inc.

Theodore, Mobile County, Alabama

ADEM Air Facility ID No. 503-8026

CONSENT ORDER NO. 21-093-CAP

PREAMBLE

This Special Order by Consent is made and entered into by the Alabama Department of Environmental Management (“the Department” or “ADEM”) and Holcim (US) Inc. (“Permittee”) pursuant to the provisions of the Alabama Environmental Management Act, Ala. Code §§ 22-22A-1 to 22-22A-17, *as amended*, the Alabama Air Pollution Control Act, (“AAPCA”), Ala. Code §§ 22-28-1 to 22-28-23, *as amended*, and the regulations promulgated pursuant thereto.

STIPULATIONS

1. The Permittee operates a cement manufacturing facility (“Facility”) located in Theodore, Mobile County, Alabama (ADEM Air Facility ID No. 503-8026).
2. The Department is a duly constituted department of the State of Alabama pursuant to Ala. Code §§ 22-22A-1 to 22-22A-17, *as amended*.
3. Pursuant to Ala. Code § 22-22A-4(n), *as amended*, the Department is the state air pollution control agency for the purposes of the federal Clean Air Act, 42 U.S.C. 7401 to 7671q, *as amended*. In addition, the Department is authorized to administer and enforce the provisions of the AAPCA.

4. The Permittee operates cement manufacturing equipment at the Facility pursuant to the authority of Major Source Operating Permit No. 503-8026 ("Permit").

5. The Raw Mill and Raw Mill Silos (Area 26), Land Silos and Loadout (Area 51), Marine Silos and Loadout (Area 53), and Coal Processing (Area 95) are subject to a weekly instantaneous visible emissions monitoring requirement. If any visible emissions greater than 10% opacity are observed during the weekly observations, the facility must conduct six minutes of opacity observations in accordance with Method 9 of 40 CFR Part 60, Appendix A, within 1 hour and initiate corrective actions within 2 hours of the visible emissions observation. A follow-up instantaneous visible emissions observation must be conducted after corrective action to ensure that visible emissions have been reduced.

6. General Proviso No. 21(b) of the Permit states: "Deviations from permit requirements shall be reported within 48 hours or 2 working days of such deviations, including those attributable to upset conditions as defined in the permit. The report will include the probable cause of said deviations, and any corrective actions or preventive measures that were taken. [Regulation] ADEM Admin. Code r. 335-3-16-.05(c)(3)"

7. The Kiln (Area 29) is subject to the applicable requirements of 40 CFR Part 63, Subpart LLL, "*National Emissions Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry*". According to 40 CFR Part 63, Subpart LLL, §63.1343(b), existing kilns are subject to a dioxins/furans (D/F) limit of 0.2 ng/dscm (toxicity equivalents, or TEQ). If the average temperature at the inlet to the first PM control device during a D/F performance test is 400 °F or less, this limit is changed to 0.40 ng/dscm (TEQ).

### DEPARTMENT'S CONTENTIONS

8. On January 22, 2021, the Department received an Annual Compliance Certification ("ACC") covering the period from November 28, 2019, to November 27, 2020, that stated several weekly instantaneous visible emissions observations were not conducted as required during the reporting period.

9. On February 4, 2021, the Permittee conducted a stack test for D/F on the main kiln stack (P-29-01) in accordance with Method 23 of 40 CFR Part 60, Appendix A.

10. On February 25, 2021, the Department was notified that the emissions during the dryers off condition of the stack test exceeded the allowable limit.

11. On March 19, 2021, additional ACC information was provided to the Department detailing the specific dates and emissions sources for which weekly visible emissions observations were not conducted. The report stated that visible emissions observations were not conducted for a total of eleven weeks for Area 26 and Area 95 and two weeks for Area 51 and Area 53. Notification of these deviations was not provided within 48 hours or 2 working days of their occurrence or discovery.

12. On March 25, 2021, the Department received the stack test report stating that the average emissions during the dryers off condition was 0.45 ng/dscm (TEQ).

13. Pursuant to Ala. Code § 22-22A-5(18)c., *as amended*, in determining the amount of any penalty, the Department must give consideration to the seriousness of the violation, including any irreparable harm to the environment and any threat to the health or safety of the public; the standard of care manifested by such person; the economic benefit which delayed compliance may confer upon such person; the nature, extent and degree of success of such person's efforts to minimize or mitigate the effects of such

violation upon the environment; such person's history of previous violations; and the ability of such person to pay such penalty. Any civil penalty assessed pursuant to this authority shall not exceed \$25,000.00 for each violation, provided however, that the total penalty assessed in an order issued by the Department shall not exceed \$250,000.00. Each day such violation continues shall constitute a separate violation. In arriving at this civil penalty, the Department has considered the following.

A.     SERIOUSNESS OF THE VIOLATION: The Department considers the Permittee's failure to conduct required monitoring and demonstrate compliance with an emissions limit to be serious violations. However, the Department is not aware of any irreparable harm to the environment resulting from these violations.

B.     THE STANDARD OF CARE: The Permittee failed to manifest a sufficient standard of care by failing to conduct monitoring and demonstrate compliance with an emissions limit required by the Permit.

C.     ECONOMIC BENEFIT WHICH DELAYED COMPLIANCE MAY HAVE CONFERRED: The Department is not aware of any evidence indicating that the Permittee received any significant economic benefit from these violations.

D.     EFFORTS TO MINIMIZE OR MITIGATE THE EFFECTS OF THE VIOLATION UPON THE ENVIRONMENT: The Department is not aware of any efforts by the Permittee to minimize or mitigate the effects of these violations on the environment.

E.     HISTORY OF PREVIOUS VIOLATIONS: The Department's Air Division records indicate that a similar violation occurred for which the Department took enforcement action against the Permittee within the past year.

F. THE ABILITY TO PAY: The Permittee has not alleged an inability to pay the civil penalty.

G. OTHER FACTORS: It should be noted that this Special Order by Consent is a negotiated settlement and, therefore, the Department has compromised the amount of the penalty in this matter in the spirit of cooperation and the desire to resolve this matter amicably, without incurring the unwarranted expense of litigation.

14. The Department has carefully considered the six statutory penalty factors enumerated in Ala. Code § 22-22A-5(18)c., *as amended*, as well as the need for timely and effective enforcement and, based upon the foregoing and attached contentions, has concluded that the civil penalty herein is appropriate (*See* "Attachment A", which is hereby made a part of the Department's Contentions).

15. The Department neither admits nor denies Permittee's Contentions, which are set forth below. The Department has agreed to the terms of this Consent Order in an effort to resolve the alleged violations cited herein without the unwarranted expenditure of State resources in further prosecuting the above violations. The Department has determined that the terms contemplated in this Consent Order are in the best interests of the citizens of Alabama.

#### PERMITTEE'S CONTENTIONS

16. The Permittee neither admits nor denies the Department's Contentions. The Permittee consents to abide by the terms of this Consent Order and to pay the civil penalty assessed herein.

ORDER

THEREFORE, the Permittee, along with the Department, desires to resolve and settle the compliance issues cited above. The Department has carefully considered the facts available to it and has considered the six penalty factors enumerated in Ala. Code § 22-22A-5(18)c., *as amended*, as well as the need for timely and effective enforcement, and the Department has determined that the following conditions are appropriate to address the violations alleged herein. Therefore, the Department and the Permittee agree to enter into this Consent Order with the following terms and conditions:

A. The Permittee agrees to pay to the Department a civil penalty in the amount of \$75,000.00 in settlement of the violations alleged herein within forty-five days from the effective date of this Consent Order. Failure to pay the civil penalty within forty-five days from the effective date may result in the Department's filing a civil action in the Circuit Court of Montgomery County to recover the civil penalty.

B. The Permittee agrees that all penalties due pursuant to this Consent Order shall be made payable to the Alabama Department of Environmental Management by certified or cashier's check and shall be remitted to:

Office of General Counsel  
Alabama Department of Environmental Management  
P.O. Box 301463  
Montgomery, Alabama 36130-1463

C. The Permittee agrees to comply with all requirements of ADEM Administrative Code div. 335-3 and the Permit immediately upon the effective date of this Order and continuing every day thereafter.

D. The parties agree that this Consent Order shall apply to and be binding upon both parties, their directors, officers, and all persons or entities acting under or for them.

Each signatory to this Consent Order certifies that he or she is fully authorized by the party he or she represents to enter into the terms and conditions of this Consent Order, to execute the Consent Order on behalf of the party represented, and to legally bind such party.

E. The parties agree that, subject to the terms of these presents and subject to provisions otherwise provided by statute, this Consent Order is intended to operate as a full resolution of the violations which are cited in this Consent Order.

F. The Permittee agrees that it is not relieved from any liability if it fails to comply with any provision of this Consent Order.

G. For purposes of this Consent Order only, the Permittee agrees that the Department may properly bring an action to compel compliance with the terms and conditions contained herein in the Circuit Court of Montgomery County. The Permittee also agrees that in any action brought by the Department to compel compliance with the terms of this Agreement, the Permittee shall be limited to the defenses of *Force Majeure*, compliance with this Agreement and physical impossibility. A *Force Majeure* is defined as any event arising from causes that are not foreseeable and are beyond the reasonable control of the Permittee, including its contractors and consultants, which could not be overcome by due diligence (i.e., causes which could have been overcome or avoided by the exercise of due diligence will not be considered to have been beyond the reasonable control of the Permittee) and which delays or prevents performance by a date required by the Consent Order. Events such as unanticipated or increased costs of performance, changed economic circumstances, normal precipitation events, or failure to obtain federal, state, or local permits shall not constitute *Force Majeure*. Any request for a modification of a deadline must be accompanied by the reasons (including documentation) for each

extension and the proposed extension time. This information shall be submitted to the Department a minimum of ten working days prior to the original anticipated completion date. If the Department, after review of the extension request, finds the work was delayed because of conditions beyond the control and without the fault of the Permittee, the Department may extend the time as justified by the circumstances. The Department may also grant any other additional time extension as justified by the circumstances, but it is not obligated to do so.

H. The Department and the Permittee agree that the sole purpose of this Consent Order is to resolve and dispose of all allegations and contentions stated herein concerning the factual circumstances referenced herein. Should additional facts and circumstances be discovered in the future concerning the facility which would constitute possible violations not addressed in this Consent Order, then such future violations may be addressed in Orders as may be issued by the Director, litigation initiated by the Department, or such other enforcement action as may be appropriate, and the Permittee shall not object to such future orders, litigation or enforcement action based on the issuance of this Consent Order if future orders, litigation or other enforcement action address new matters not raised in this Consent Order.

I. The Department and the Permittee agree that this Consent Order shall be considered final and effective immediately upon signature of all parties. This Consent Order shall not be appealable, and the Permittee does hereby waive any hearing on the terms and conditions of same.

J. The Department and the Permittee agree that this Order shall not affect the Permittee's obligation to comply with any Federal, State, or local laws or regulations.

K. The Department and the Permittee agree that final approval and entry into this Order are subject to the requirements that the Department give notice of proposed Orders to the public, and that the public have at least thirty days within which to comment on the Order.

L. The Department and the Permittee agree that, should any provision of this Order be declared by a court of competent jurisdiction or the Environmental Management Commission to be inconsistent with Federal or State law and therefore unenforceable, the remaining provisions hereof shall remain in full force and effect.

M. The Department and the Permittee agree that any modifications of this Order must be agreed to in writing signed by both parties.

N. The Department and the Permittee agree that, except as otherwise set forth herein, this Order is not and shall not be interpreted to be a permit or modification of an existing permit under Federal, State or local law, and shall not be construed to waive or relieve the Permittee of its obligations to comply in the future with any permit.

Executed in duplicate, with each part being an original.

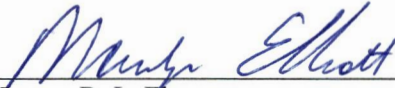
HOLCIM (US) INC.

ALABAMA DEPARTMENT OF  
ENVIRONMENTAL MANAGEMENT

  
(Signature of Authorized Representative)

Victor C. Santos  
(Printed Name)

Plant Manager  
(Printed Title)

  
Lance R. LeFleur  
Director

Date Signed: 07/20/21

Date Executed: 9/29/21

# Attachment A

Holcim (US) Inc.  
Theodore, Mobile County

ADEM Air Facility ID No. 503-8026

Violation*	Number of Violations*	Seriousness of Violation*	Standard of Care*	History of Previous Violations*	Total of Three Factors
Failure to conduct periodic monitoring	13 7**	\$15,000.00	\$10,000.00	\$50,000.00	\$75,000.00
Failure to meet emissions limit	1	\$20,000.00	\$5,000.00	-	\$25,000.00
<b>TOTAL PER FACTOR</b>		<b>\$35,000.00</b>	<b>\$15,000.00</b>	<b>\$50,000.00</b>	<b>\$100,000.00</b>

Adjustments to Amount of Initial Penalty	
Mitigating Factors (-)	
Ability to Pay (-)	
Other Factors (+/-)	-\$25,000.00
<b>Total Adjustments (+/-)</b>	<b>-\$25,000.00</b>

Economic Benefit (+)	
<b>Amount of Initial Penalty</b>	\$100,000.00
<b>Total Adjustments (+/-)</b>	-\$25,000.00
<b>FINAL PENALTY</b>	<b>\$75,000.00</b>

## Footnotes

\* See the "Department's Contentions" portion of the Order for a detailed description of each violation and the penalty factors.

\*\* Follow-up information from the facility explained that some of the reported failure to monitor incidents occurred during weeks when the units were not operating.