Category		Title
NFR:	**2.C.7.a**	**Copper production**
SNAP:	**040309a**	**Copper production**
ISIC:	**2720**	**Manufacture of basic precious and non-ferrous metals**
Version	**Guidebook 2013**	

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1 Overview

This chapter presents information on atmospheric emissions during the production of copper (Cu), which includes primary and secondary copper. This chapter only addresses the process emissions of copper production, whereas emissions originating from combustion are discussed in source category 1.A.2.b.

More than 80 primary copper smelters around the world employ various conventional pyrometallurgical techniques to produce more than 90 % of the total copper production (Pacyna, 1989). Generally there are three steps in this process: roasting of ores to remove sulphur; smelting of roaster product to remove a part of the gangue for production of the copper matte; and converting the copper matte to blister copper. Atmospheric emissions of sulphur dioxide and heavy metals on fine particles occur during all the above mentioned processes.

Various trace elements from impurities are present in the copper ores, which are emitted during the production process. The process is a major source of atmospheric arsenic and copper (50 % of the global emissions of this element), indium (almost 90 %), antimony, cadmium and selenium (approximately 30 %) and nickel and tin (approximately 10 %) (Nriagu and Pacyna, 1998).

Secondary copper smelters produce about 40 % of the total copper production in the world (Pacyna, 1989). Pyrometallurgical processes are used to rework scrap and other secondary materials. As with primary copper production, final refining, where practised, is electrolytic. This chapter describes the methods to

estimate emissions of atmospheric pollutants during the secondary copper recovery.

2 Description of sources

2.1 Process description

2.1.1 Primary copper production

The traditional pyrometallurgical copper smelting process is illustrated in Figure 3.1 (US EPA, 1993). Typically, the blister copper is fire refined in an anode furnace, cast into ‘anodes’ and sent to an electrolytic refinery for further impurity elimination. The currently used copper smelters process ore concentrates by drying them in fluidised bed dryers and then converting and refining the dried product in the same manner as the traditionally used process (US EPA, 1993).

Concentrates usually contain 20–30 % Cu. In roasting, charge material of copper mixed with a siliceous flux is heated in air to about 650 °C, eliminating 20–50 % of sulphur and portions of volatile trace elements. The roasted product, calcine, serves as a dried and heated charge for the smelting furnace.

In the smelting process, calcines are melted with siliceous flux in a flash smelting furnace to produce copper matte, a molten mixture of cuprous sulphide, ferrous sulphide, and some trace elements. Matte contains usually 35–65 % of copper. Heat required in the smelting process comes from partial oxidation of the sulphide charge and from burning external fuel. Several smelting technologies are currently used in the copper industry, including reverberatory smelting, flash smelting (two processes are currently in commercial use: the INCO process and the Outokumpu process), and the Noranda and electric processes.

In the reverberatory process heat is supplied by combustion of oil, gas, or pulverised coal. The temperature in the furnace can reach 1500 °C. Flash furnace smelting combines the operations of roasting and smelting to produce a high grade copper matte from concentrates and flux. Most flash furnaces use the heat generated from partial oxidation of their sulphide charge to provide much or all of the energy required for smelting. The temperature in the furnace reaches between 1200 and 1300 °C. The Noranda process takes advantage of the heat energy available from the copper ore. The remaining thermal energy is supplied by oil burners, or by coal mixed with the ore concentrates. For the smelting in electric arc furnaces, heat is generated by the flow of an electric current in carbon electrodes lowered through the furnace roof and submerged in the slag layer of the molten bath (US EPA, 1993; UN ECE, 1994).

Concerning emissions of air pollutants from the smelting operations, all the above described operations emit trace elements. Flash furnace smelting produces offgas streams containing high concentrations of sulphur dioxide. Electric arc furnaces do not produce fuel combustion gases, so flow rates are lower and so are the sulphur dioxide concentrations.

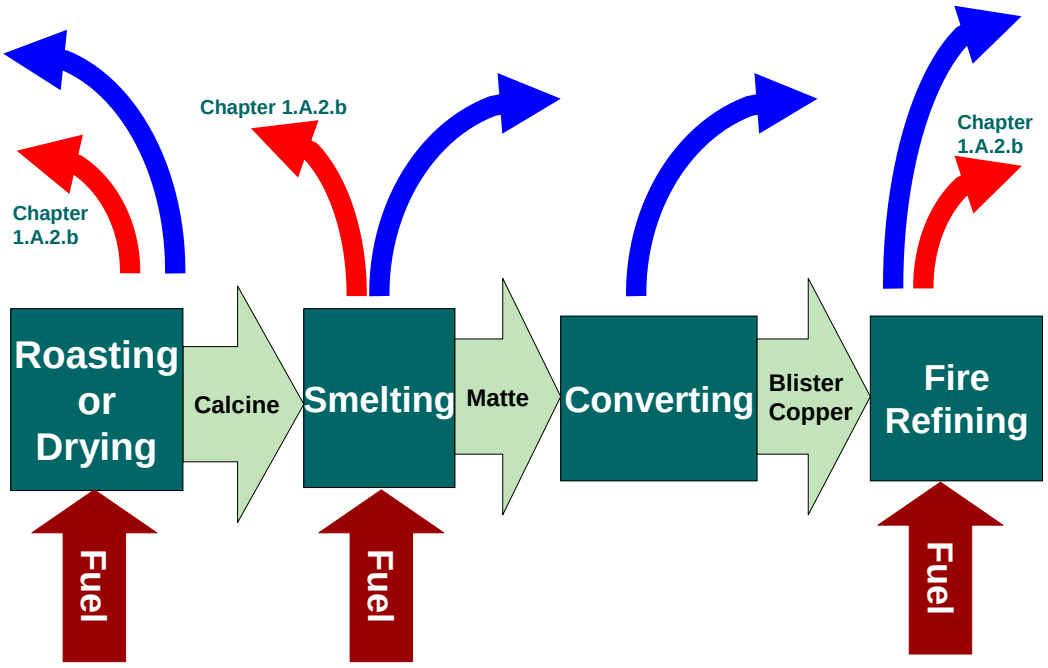

Figure 2.1 Schematic description of a typical copper smelter process, using ore concentrate with silica fluxes as input for the roasting/drying, and anode copper as output from the fire refining process.

The final step in the production of blister copper is converting. The remaining iron and sulphur in the matter is removed in this process leaving molten blister copper. Blister copper usually contains between 98.5 and 99.5 % pure copper with the rest consisting of trace elements, such as gold, silver, antimony, arsenic, bismuth, iron, lead, nickel, selenium, sulphur, tellurium, and zinc. There are various converting technologies applied in the copper production. The temperature in the converting furnace reaches 1100 °C.

2.1.2 Secondary copper production

A secondary copper smelter is defined as any plant or factory in which copper-bearing scrap or copper-bearing materials, other than copper-bearing concentrates (ores) derived from a mining operation, is processed by metallurgical or chemical process into refined copper and copper powder (a premium product).

The recycling of copper is the most comprehensive among the non-ferrous metals. The copper metal scrap can be in the form of:

- copper scrap, such as fabrication rejects, wire scrap, plumbing scrap, apparatus, electrical systems or products from cable processing;
- alloy scrap, such as brass, gunmetal, bronze, in the form of radiators, fittings, machine parts, turnings or shredder metals;
- copper-iron scrap like electric motors or parts thereof, plated scrap, circuit elements and switchboard units, telephone scrap, transformers and shredder materials.

Another large group of copper-containing materials is composed of oxidised materials, including drosses, ashes, slags, scales, ball mill fines, catalysts as well as materials resulting from pollution control systems.

The copper content of scrap varies from 10 to nearly 100 % (UN ECE, 1994). The associated metals that have to be removed are mainly zinc, lead, tin, iron, nickel and aluminium as well as certain amounts of precious metals.

Depending on their chemical composition, the raw materials of a secondary copper smelter are processed in different types of furnaces, including:

- blast furnaces (up to 30 % Cu in the average charge);
- converters (about 75 % Cu);
- anode furnaces (about 95 % Cu).

The blast furnace metal (‘black copper’) is treated in a converter, the converter metal is refined in an anode furnace. In each step additional raw material with corresponding copper content is added.

In the blast furnace , a mixture of raw materials, iron scrap, limestone and sand as well as coke is charged at the top. Air that can be enriched with oxygen is blown through the tuyeres, the coke is burnt and the charge materials are smelted under reducing conditions. Black copper and slag are discharged from tapholes.

The converters used in primary copper smelting, working on mattes containing iron sulfide, generate surplus heat and additions of scrap copper are often used to control temperature. The converter provides a convenient and cheap form of scrap treatment but often with only moderately efficient gas cleaning. Alternatively, hydrometallurgical treatment of scrap, using ammonia leaching, yields to solutions which can be reduced by hydrogen to obtain copper powder (Barbour *et al*., 1978). Alternatively, these solutions can be treated by solvent extraction to produce feed to a copper-winning cell.

Converter copper is charged together with copper raw materials in an anode furnace operation. For smelting the charge, oil or coal dust is used , mainly in reverberatory furnaces. After smelting, air is blown on the bath to oxidise the remaining impurities.

Leaded brasses, containing as much as 3 % lead, are widely used in various applications and recycling of their scrap waste is an important activity. Such scrap usually contains much swarf and turnings coated with lubricant and cutting oils. Copper-containing cables and motors contain plastic or rubber insulants, varnishes, and lacquers. In such cases, scrap needs pretreatment to remove these non-metallics. The smaller sizes of scrap can be pretreated thermally in a rotary kiln provided with an after-burner to consume smoke and oil vapors (the so-called Intal process). There are also various techniques available to remove rubber and plastic insulations of cables (Barbour *et al.*, 1978; UN ECE, 1994).

2.2 Techniques

The descriptions of the different processes used in the process of producing primary and secondary copper are given in section 2.1. In the converting process during primary copper production, two techniques can be distinguished:

- batch converting: blowing an air/oxygen mixture through the matte recovered from the smelting operation;
- continuous converting, of which three types exist. the Mitsubishi and Noranda converters receive molten feed for conversion, while in the Kennecott/Outokumpu process the matte from the smelting furnace is first granulated in water, crushed and dried.

More information about these techniques can be found in the section on copper production in the Reference Document on Best Available Techniques (BREF) in the Non Ferrous Metal Industries (European Commission, 2001) as well as the draft BREF (European Commission, 2009) with expected adaptation in 2013 ([1]).

2.3 Emissions

Pollutants released are sulphur oxides (SO_x), nitrogen oxides (NO_x), volatile organic compounds (non-methane VOC and methane (CH_4)), carbon monoxide (CO), carbon dioxide (CO_2), nitrous oxide (N_2O), trace elements, and selected persistent organic pollutants (POPs). The main relevant pollutants are sulphur dioxide (SO_2) and CO, according to CORINAIR90 and selected trace elements. The POPs are mostly dioxins and furans, which are emitted from shaft furnaces, converters, and flame furnaces.

Copper smelters are a source of sulphur oxides (SO_x). Emissions are generated from the roasters, smelting furnaces and converters (see Table 3.1 below). Fugitive emissions are generated during material handling operations. Remaining smelter operations use material containing very little sulphur, resulting in insignificant SO_2 emissions (US EPA, 1995). Here only emissions from combustion processes with contact are relevant.

Table 2-1 shows typical average SO_2 concentrations from the various smelter units. It can be assumed that the SO_2 concentrations given in the table take into account emissions from fuel sulphur and ore sulphur.

([1])The BREF document for non-ferrous metals industries is presently under review. A finalised version is expected to be adopted in 2013. Information concerning the status of BREF documents is available at http://eippcb.jrc.es/reference/.

Table 2-1 Typical sulphur dioxide concentrations in off-gas from copper smelting sources (US EPA, 1995)

Process unit	SO_2 concentration [vol.-%]
Multiple hearth roaster	1.5 - 3
Fluidized bed roaster	10 - 12
Reverberatory furnace	0.5 - 1.5
Electric arc furnace	4 - 8
Flash smelting furnace	10 - 70
Continuous smelting furnace	5 - 15
Pierce-Smith converter	4 - 7
Hoboken converter	8
Single contact H_2SO_4 plant	0.2 - 0.26
Double contact H_2SO_4 plant	0.05

Copper production requires energy in most stages, the energy use of the electrolytic process is most significant. The production energy (nett) requirement for a number of processes using copper concentrate is in the range 14 – 20 GJ/t of copper cathode. The exact figure depends mainly on the concentrate (% S and Fe), but also on the smelting unit used, the degree of oxygen enrichment and the collection and use of process heat. Comparative data based solely on the type of smelter are therefore liable to inaccuracies. The utilisation of the energy content of the concentrate is more important and smelters that achieve autogenic operation have lower energy use (European Commission, 2001).

The energy consumed by the electro-refining stage of copper production is reported to be 300 - 400 kWh per tonne of copper. The type of blank cathode used (stainless steel or copper) mainly influences the efficiency of tank house and this can range from 92 to 97% in terms of current efficiency (European Commission, 2001).

2.4 Controls

2.4.1 Primary copper production

Emission controls on primary copper smelters are employed for controlling sulphur dioxide and particulate matter emissions resulting from roasters, smelting furnaces, and converters. Control of sulphur dioxide emissions is achieved by absorption to sulphuric acid in the sulphuric acid plants, which are commonly a part of copper smelting plants. Reverberatory furnace effluent contains minimal SO_2 and is usually released directly to the atmosphere with no SO_2 reduction. Effluents from the other types of smelter furnaces contain higher concentrations of SO_2 and are treated in sulphuric acid plants before being vented. Single-contact sulphuric acid plants achieve 92.5 to 98 % conversion of SO_2 from plant effluent gas. Double-contact acid plants collect from 98 to more than 99 % of the SO_2. Absorption of the SO_2 in dimethylaniline solution has also been used in US-American smelters to produce liquid SO_2. (US EPA, 1995).

Electrostatic precipitators (ESPs) are the common particulate matter control devices employed at copper smeltering facilities. The control efficiency of ESPs often reaches about 99 %. It should be added that most of the trace elements are condensed on very fine particles, e.g. <1.0 µm diameter, and the control efficiency for these particles is lower, reaching about 97 % (Pacyna, 1987).

A detailed description of control techniques and Best Available Techniques for the copper production is available in UN ECE (1994).

2.4.2 Secondary copper production

Controls in secondary copper production should include effective dust collecting arrangements for dust from both primary exhaust gases and fugitive dust emissions. Fabric filters can be used reducing the dust emissions to below 10 mg/m³ (UN ECE, 1994).

3 Methods

3.1 Choice of method

Figure 3.1 presents the procedure to select methods for estimating process emissions from copper production. The basic idea is as follows.

- If detailed information is available: use it.
- If the source category is a key category, a Tier 2 or better method must be applied and detailed input data must be collected. The decision tree in Figure 3.1 directs the user in such cases to the Tier 2 method, since it is expected that it is more easy to obtain the necessary input data for this approach than to collect facility level data needed for a Tier 3 estimate
- The alternative of applying a Tier 3 method using detailed process modelling is not explicitly included in this decision tree. However, detailed modelling will always be done at facility level and results of such modelling could be seen as ‘facility data’ in the decision tree.

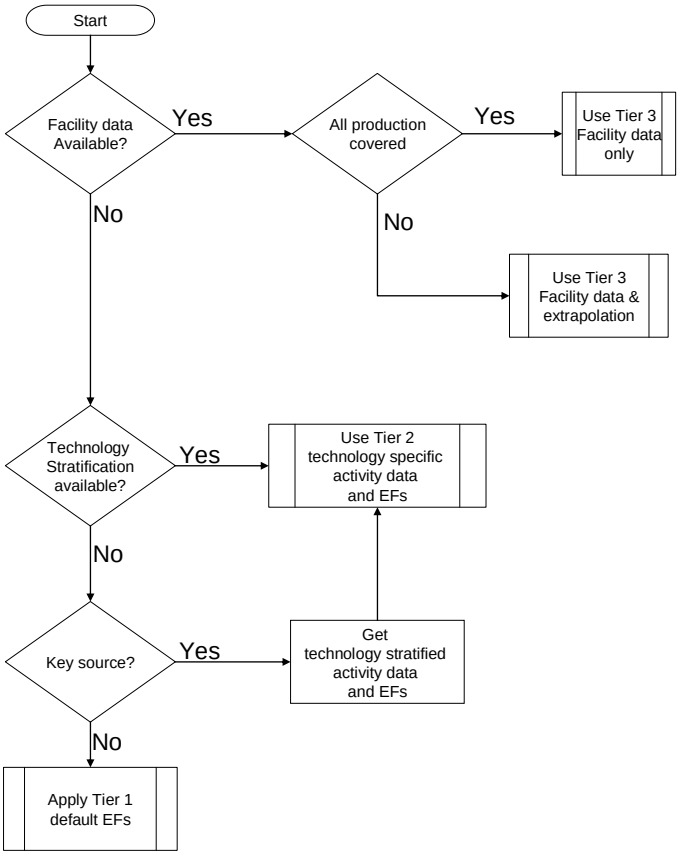

Figure 3.1 Decision tree for source category 2.C.7.a Copper production

3.2 Tier 1 default approach

3.2.1 Algorithm

The Tier 1 approach for process emissions from copper production uses the general equation:

$$E_{pollutant} = AR_{production} \times EF_{pollutant} \quad (1)$$

Where:

$E_{pollutant}$ = the emission of the specified pollutant

$AR_{production}$ = the activity rate for the copper production

$EF_{pollutant}$ = the emission factor for the pollutant

This equation is applied at the national level, using annual national total copper production. Information on the production of copper, suitable for estimating emissions using the simpler estimation methodology (Tier 1 and 2), is widely available from United Nations statistical yearbooks or national statistics.

The Tier 1 emission factors assume an 'averaged' or typical technology and abatement implementation in the country and integrate all different sub-processes in the production of

copper, from the treatment of the ore concentrate until after the fire refining, producing anode copper.

In cases where specific abatement options are to be taken into account a Tier 1 method is not applicable and a Tier 2 or Tier 3 approach must be used.

3.2.2 Default emission factors

The Tier 1 approach needs emission factors for all relevant pollutants. These default emission factors as given in Table 3.1 have been derived from various references. The emission factors for total suspended particulate matter (TSP) is from the BREF document for the non-ferrous metal industry (European Commission, 2001), while PM_{10} and $PM_{2.5}$ are interpreted from the profile used in the Coordinated European Particulate Matter Emission Inventory Program (CEPMEIP) study (Visschedijk *et al.*, 2004) for a conventional plant. Other values are taken from the 'Estimation of willingness-to-pay to reduce risks of exposure to heavy metals and cost-benefit analysis for reducing heavy metals occurrence in Europe' (Espreme) project (Theloke *et al.*, 2008) for plants with limited control. To estimate Tier 1 emission factors it is assumed that about 75 % of the copper production is primary copper and 25 % is secondary copper (Althaus, 2003).

Emission factors in the BREF documents are mostly given in ranges. Where these emission factors are used in the table below, the range is interpreted as the 95 % confidence interval, while the geometric mean of this range is chosen as the value for the emission factor.

Emissions of NO_x, SO_x and CO are assumed to originate mainly from combustion and are discussed in chapter 1.A.2.b. All other emissions are assumed to originate primarily from the process and are therefore discussed in the present chapter.

Table 3.1 Tier 1 emission factors for source category 2.C.7.a Copper production.

Tier 1 default emission factors					
	Code	Name			
NFR source category	2.C.7.a	Copper production			
Fuel	NA				
Not applicable	HCH				
Not estimated	NO_x, CO, NMVOC, SO_x, NH_3, Se, Zn, Benzo(a)pyrene, Benzo(a)fluoranthene, Benzo(k)fluoranthene, Indeno(1,2,3-cd)pyrene, HCB,				
Pollutant	Value	Unit	95 % confidence interval		Reference
			Lower	Upper	
TSP	400	g/Mg copper	100	1 000	European Commission (2001)
PM_{10}	320	g/Mg copper	80	800	Visschedijk et al. (2004) applied on TSP
$PM_{2.5}$	240	g/Mg copper	60	600	Visschedijk et al. (2004) applied on TSP
BC	0.1	% of $PM_{2.5}$	0.05	0.2	US EPA (2011, file no.: 91158)
Pb	160	g/Mg copper	100	280	Theloke et al. (2008)
Cd	11	g/Mg copper	9	19	Theloke et al. (2008)
Hg	0.023	g/Mg copper	0.016	0.039	Theloke et al. (2008)
As	39	g/Mg copper	26	53	Theloke et al. (2008)
Cr	16	g/Mg copper	11	22	Theloke et al. (2008)
Cu	70	g/Mg copper	8	250	European Commission (2001)
Ni	14	g/Mg copper	8.7	22	Theloke et al. (2008)
PCBs	0.9	g/Mg copper	0.6	1.5	Note
PCDD/F	5	µg I-TEQ/Mg copper	0.01	800	UNEP (2005)

Note: The EF for PCB may be revised int eh future based on new information from UNEP: *Toolkit for Identification and Quantification of Releases of Dioxins and Furans and Other Unintentional POPs*: http://chm.pops.int/Implementation/ToolKit/Meetings/7thExpertMeeting2012/tabid/2906/mctl/ViewDetails/EventModID/876/EventID/326/xmid/9376/Default.aspx.

3.2.3 Activity data

Information on the production of copper in primary smelters, suitable for estimating emissions when using Tier 1 or Tier 2 is widely available from the United Nations statistical yearbooks or national statistics.

3.3 Tier 2 technology-specific approach

3.3.1 Algorithm

The Tier 2 approach is similar to the Tier 1 approach. To apply the Tier 2 approach, both the activity data and the emission factors need to be stratified according to the different techniques that may occur in the country.

The Tier 2 approach is as follows:

Stratify the copper production in the country to model the different product and process types occurring in the national copper industry into the inventory by:

- defining the production using each of the separate product and/or process types (together called 'technologies' in the formulae below) separately; and
- applying technology specific emission factors for each process type:

$$E_{pollutant} = \sum_{technologies} AR_{production,technology} \times EF_{technology,pollutant} \quad (2)$$

where:

$AR_{production,technology}$ = the production rate within the source category, using this specific technology

$EF_{technology,pollutant}$ = the emission factor for this technology and this pollutant

A country where only one technology is implemented will result in a penetration factor of 100 % and the algorithm reduces to:

$$E_{pollutant} = AR_{production} \times EF_{technology,pollutant} \quad (3)$$

where:

$E_{pollutant}$ = the emission of the specified pollutant

$AR_{production}$ = the activity rate for the copper production

$EF_{pollutant}$ = the emission factor for this pollutant

The emission factors in this approach will still include all sub-processes within the industry from the feeding of raw materials until the produced copper is shipped to the customers.

3.3.2 Technology-specific emission factors

This subsection provides specific emission factors for primary and secondary copper production.

For the Tier 1 approach, emissions of NO_x, SO_x and CO are assumed to originate mainly from combustion and are discussed in chapter 1.A.2.b. All other emissions are assumed to originate primarily from the process and are therefore discussed in this chapter.

Emission factors in the BREF documents are mostly given in ranges. The range is interpreted as the 95 % confidence interval, while the geometric mean of this range is chosen as the value for the emission factor in the tables below.

Table 3.2 Tier 2 emission factors for source category 2.C.7.a Copper production, primary copper.

Tier 2 default emission factors					
	Code	Name			
NFR source category	2.C.7.a	Copper production			
Fuel	NA				
SNAP (if applicable)	040309a Copper production				
Technologies/Practices	Primary copper production				
Region or regional conditions					
Abatement technologies					
Not applicable	HCH				
Not estimated	NO_x, CO, NMVOC, SO_x, NH_3, Se, Zn, PCBs, Benzo(a)pyrene, Benzo(a)fluoranthene, Benzo(k)fluoranthene, Indeno(1,2,3-cd)pyrene, HCB				
Pollutant	Value	Unit	95 % confidence interval		Reference
			Lower	Upper	
TSP	400	g/Mg copper	160	1 000	European Commission (2001)
PM_{10}	320	g/Mg copper	130	800	Visschedijk et al. (2004) applied on TSP
$PM_{2.5}$	240	g/Mg copper	100	600	Visschedijk et al. (2004) applied on TSP
BC	0.1	% of $PM_{2.5}$	0.05	0.2	US EPA (2011, file no.: 91158)
Pb	170	g/Mg copper	120	290	Theloke et al. (2008)
Cd	15	g/Mg copper	12	23	Theloke et al. (2008)
Hg	0.031	g/Mg copper	0.021	0.052	Theloke et al. (2008)
As	51	g/Mg copper	35	70	Theloke et al. (2008)
Cr	21	g/Mg copper	15	29	Theloke et al. (2008)
Cu	90	g/Mg copper	30	250	European Commission (2001)
Ni	19	g/Mg copper	12	29	Theloke et al. (2008)
PCDD/F	0.01	µg I-TEQ/Mg copper	0.003	0.03	UNEP (2005)

Table 3.3 Tier 2 emission factors for source category 2.C.7.a Copper production, secondary copper.

Tier 2 default emission factors					
	Code	Name			
NFR source category	2.C.7.a	Copper production			
Fuel	NA				
SNAP (if applicable)	040309a Copper production				
Technologies/Practices	Secondary copper production				
Region or regional conditions					
Abatement technologies					
Not applicable	HCH				
Not estimated	NO_x, CO, NMVOC, SO_x, NH_3, Hg, Cr, Se, Zn, Benzo(a)pyrene, Benzo(a)fluoranthene, Benzo(k)fluoranthene, Indeno(1,2,3-cd)pyrene, HCB,				
Pollutant	Value	Unit	95 % confidence interval		Reference
			Lower	Upper	
TSP	320	g/Mg copper	100	1 000	European Commission (2001)
PM_{10}	260	g/Mg copper	80	800	Visschedijk et al. (2004) applied on TSP
$PM_{2.5}$	190	g/Mg copper	60	600	Visschedijk et al. (2004) applied on TSP
BC	0.1	% of $PM_{2.5}$	0.05	0.2	US EPA (2011, file no.: 91158)
Pb	110	g/Mg copper	57	230	Theloke et al. (2008)
Cd	2.3	g/Mg copper	1.1	4.6	Theloke et al. (2008)
As	1.4	g/Mg copper	0.57	2.1	Theloke et al. (2008)
Cu	28	g/Mg copper	8	100	European Commission (2001)
Ni	0.13	g/Mg copper	0.057	0.17	Theloke et al. (2008)
PCBs	3.7	g/Mg copper	2.4	6	Note
PCDD/F	50	µg I-TEQ/Mg copper	0.03	800	UNEP (2005)

Note: The EF for PCB may be revised in the future based on new information from UNEP: *Toolkit for Identification and Quantification of Releases of Dioxins and Furans and Other Unintentional POPs*: http://chm.pops.int/Implementation/ToolKit/Meetings/7thExpertMeeting2012/tabid/2906/mctl/ViewDetails/EventModID/876/EventID/326/xmid/9376/Default.aspx.

The BC EF for secondary cupper production is assumed to be the same as for primary production.

3.3.3 Abatement

A number of add-on technologies exist that are aimed at reducing the emissions of specific pollutants. The resulting emission can be calculated by replacing the technology specific emission factor with an abated emission factor as given in the formula:

$$EF_{technology,abated} = (1 - \eta_{abatement}) \times EF_{technology,unabated} \quad (4)$$

Where

$EF_{technology,\ abated}$ = the emission factor after implementation of the abatement

$\eta_{abatement}$ = the abatement efficiency

$EF_{technology,\ unabated}$ = the emission factor before implementation of the abatement

Table 3.4 presents default abatement efficiencies for particulate matter and heavy metal emissions. The particulate matter (PM) efficiencies are calculated from the CEPMEIP emission factors for particulate matter (Visschedijk, 2004) with respect to the older plant, with limited control of fugitive sources. The values for a conventional plant are the same as the Tier 1 default emission factors for copper production. The table also provides default abatement efficiencies for heavy

metals. These are related to the emission factors in Tier 1 and assume an abated situation (not further specified).

Table 3.4 Abatement efficiencies ($\eta_{abatement}$) for source category 2.C.7.a Copper production

Tier 2 Abatement efficiencies					
	Code	Name			
NFR Source Category	2.C.7.a	Copper production			
Fuel	NA	not applicable			
SNAP (if applicable)	040309a	Copper production			
Abatement technology	**Pollutant**	**Efficiency**	**95% confidence interval**		**Reference**
		Default Value	**Lower**	**Upper**	
Modern plant (BAT): fabric filters for most emission sources	particle > 10 µm	95%	85%	98%	Visschedijk (2004)
	10 µm > particle > 2.5 µm	84%	53%	95%	Visschedijk (2004)
	2.5 µm > particle	60%	0%	87%	Visschedijk (2004)
Conventional installation: ESP and settling chambers; moderate control of fugive sources	particle > 10 µm	88%	64%	96%	Visschedijk (2004)
	10 µm > particle > 2.5 µm	68%	4%	89%	Visschedijk (2004)
	2.5 µm > particle	28%	0%	76%	Visschedijk (2004)
Abatement in place	As	97%	91%	99%	Pacyna (2002)
	Cd	99%	96%	100%	Pacyna (2002)
	Cr	90%	70%	97%	Pacyna (2002)
	Cu	94%	81%	98%	Pacyna (2002)
	Hg	0%	0%	67%	Pacyna (2002)
	Ni	97%	90%	99%	Pacyna (2002)
	Pb	95%	85%	98%	Pacyna (2002)
	Se	85%	55%	95%	Pacyna (2002)
	Zn	80%	40%	93%	Pacyna (2002)

3.3.4 Activity data

Information on the production of copper, suitable for estimating emissions using the simpler estimation methodology (Tier 1 and 2), is widely available from United Nations statistical yearbooks or national statistics.

For a Tier 2 approach these data need to be stratified according to technologies applied. Typical sources for these data might be industrial branch organisations within the country or from specific questionnaires to the individual copper production sites.

3.4 Tier 3 emission modelling and use of facility data

3.4.1 Algorithm

Two different emission estimation go beyond the technology-specific approach described above:

- detailed modelling of the copper production process;
- facility-level emission reports.

3.4.1.1 Detailed process modelling

A Tier 3 emission estimate using process details will make separate estimates for the consecutive steps in the production process of copper:

- roasting/drying
- smelting
- converting

- fire refining

3.4.1.2 Facility-level data

Where facility-level emissions data of sufficient quality (see the guidance chapter on QA/QC in Part A of the Guidebook) are available, it is good practice to indeed use these data. There are two possibilities:

- facility reports cover all copper production in the country;
- facility-level emission reports are not available for all copper plants in the country.

If facility level data cover all copper production in the country, it is good practice to compare the implied emission factors (reported emissions divided by the national copper production) with the default emission factor values or technology-specific emission factors. If the implied emission factors are outside the 95 % confidence intervals for the values given below, it is good practice to explain the reasons for this in the inventory report

If the total annual copper production in the country is not included in the total of the facility reports, it is good practice to estimate the missing part of the national total emissions from the source category, using extrapolation by applying:

$$E_{Total,pollutant} = \sum_{Facilities} E_{Facility,pollutant} + \left(National\ \ Production - \sum_{Facilities} Production_{Facility} \right) \times EF \qquad (5)$$

Where:

$E_{total,pollutant}$	=	the total emission of a pollutant for all facilities within the source category
$E_{facility,pollutant}$	=	the emission of the pollutant as reported by a facility
$Production_{total}$	=	the production rate in the source category
$Production_{facility}$	=	the production rate in a facility
$EF_{pollutant}$	=	the emission factor for the pollutant

Depending on the specific national circumstances and the coverage of the facility-level reports as compared to the total national copper production, it is good practice to choose the emission factor (EF) in this equation from the following possibilities, in decreasing order of preference:

- technology-specific emission factors, based on knowledge of the types of technologies implemented at the facilities where facility level emission reports are not available;
- the implied emission factor derived from the available emission reports:

$$EF = \sum_{Facilities} E_{Facility,pollutant} \Big/ \sum_{Facilities} Production_{Facility} \qquad (6)$$

- the default Tier 1 emission factor: this option should only be chosen if the facility level emission reports cover more than 90 % of the total national production.

3.4.2 Tier 3 emission modelling and use of facility data

Copper plants are major industrial facilities and emission data for individual plants might be available through a pollutant release and transfer registry (PRTR) or another emission reporting scheme. When the quality of such data is assured by a well developed quality assurance/quality control (QA/QC) system and the emission reports have been verified by an independent auditing scheme, it is good practice to use such data. If extrapolation is needed to cover all copper production in the country either the implied emission factors for the facilities that did report, or the emission factors as provided above could be used.

No generally accepted emission models are available for the copper industry. Such models could be developed, however, and used in national inventories. If this happens, it is good practice to compare the results of the model with a Tier 1 or Tier 2 estimate to assess the credibility of the model. If the model provides implied emission factors that lie outside the 95 % confidence intervals indicated in the tables above, it is good practice to include an explanation for this in the documentation with the inventory and preferably reflected in the Informative Inventory Report.

3.4.3 Activity data

Since PRTRs generally do not report activity data, such data in relation to the reported facility level emissions are sometimes difficult to find. A possible source of facility level-activity might be the registries of emission trading systems.

In many countries national statistics offices collect production data on facility level but these are in many cases confidential. However, in several countries, national statistics offices are part of the national emission inventory systems and the extrapolation, if needed, could be performed at the statistics office, ensuring that confidentiality of production data is maintained.

4 Data quality

4.1 Completeness

Care must be taken to include all emissions, from combustion and processes. It is good practice to check, whether the emissions, reported as ‘included elsewhere’ (IE) under chapter 2.C.7.a are indeed included in the emission reported under combustion in chapter 1.A.2.b.

4.2 Avoiding double counting with other sectors

Care must be taken that the emissions are not double counted in processes and combustion. It is good practice to check that the emissions reported under chapter 2.C.7.a are not included in the emission reported under combustion in chapter 1.A.2.b.

4.3 Verification

4.3.1 Best Available Technique emission factors

This section provides some typical concentrations for best available technique (BAT)-associated facilities. More information is provided in the BREF document for the non-ferrous metal industry (European Commission, 2001).

Table 4.1 BAT-associated emission factors for source category 2.C.7.a Copper production, primary fire refining and melting processes

	Code	Name		
NFR Source Category	2.C.5.a	Copper production		
Fuel	N/A	not applicable		
Pollutant	**Value**	**Unit**	**95% confidence interval**	
			Lower	**Upper**
Dust	1 - 5	mg/Nm3		
SO2	<50-200	mg/Nm3		
NOx (low NOx burner)	<100	mg/Nm3		
NOx (oxy-fuel burner)	<100-300	mg/Nm3		
TOC (as C) (afterburner)	<5-15	mg/Nm3		
TOC (as C) (optimised combustio	<5-50	mg/Nm3		
Dioxins	<0.1-0.5	ng TEQ/Nm3		

4.4 Developing a consistent time series and recalculation

No specific issues.

4.5 Uncertainty assessment

No specific issues.

4.5.1 Emission factor uncertainties

No specific issues.

4.5.2 Activity data uncertainties

No specific issues.

4.6 Inventory quality assurance/quality control (QA/QC)

No specific issues.

4.7 Gridding

National emission estimates can be disaggregated on the basis of production, population or employment statistics.

4.8 Reporting and documentation

No specific issues.

5 Glossary

$AR_{production, technology}$	The production rate within the source category, using s specific technology
$AR_{production, technology}$	The production rate within the source category, using s specific technology
$AR_{production}$	The activity rate for the copper production
Combustion process with contact	Is a process in which the hot flue gases from a combustion process are directly injected into the reactor where the chemistry and physics take place converting the raw materials into the product. Examples are • Primary iron and steel • Cement • …
$E_{facility, pollutant}$	The emission of the pollutant as reported by a facility
$E_{pollutant}$	The emission of the specified pollutant
$E_{total, pollutant}$	The total emission of a pollutant for all facilities within the source category
$EF_{country, pollutant}$	A country specific emission factor
$EF_{pollutant}$	The emission factor for the pollutant
$EF_{technology, abated}$	The emission factor after implementation of the abatement
$EF_{technology, pollutant}$	The emission factor for this technology and this pollutant
$EF_{technology, unabated}$	The emission factor before implementation of the abatement
ESP	Electrostatic precipitator: dust emissions abatement equipment
FF	Fabric filters: dust emissions abatement equipment
$Penetration_{technology}$	The fraction of production using a specific technology
$Production_{facility}$	The production rate in a facility
$Production_{total}$	The production rate in the source category
$\eta_{abatement}$	The abatement efficiency

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7 Point of enquiry

Enquiries concerning this chapter should be directed to the relevant leader(s) of the Task Force on Emission Inventories and Projection's expert panel on Combustion and Industry. Please refer to the TFEIP website (www.tfeip-secretariat.org) for the contact details of the current expert panel leaders.