



Environmental Site Management Plan

# Raw Materials, Water and Waste Residue Efficiency Management Plan: Didcot STC



## Using this standard

This standard is controlled and managed by EMS & Air and Waste Permitting Teams, and a copy is held on SharePoint at the following location: [Environmental Management Systems](#)

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This standard works in combination with other corporate documents including the Asset Standards, Site Operating Manuals, site Odour Management Plans, Health and Safety Standards, and regulatory permits.

# Document Control & Procedures

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## 0 Document Confidentiality

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## 1 Glossary of Terms

TERM	DESCRIPTION
AD	Anaerobic Digestion
CHP	Combined Heat and Power
DEFRA	Department for Environment, Food and Rural Affairs
EA	Environment Agency
EMS	Environmental Management System
EPR	Environmental Permitting Regulations
FFT	Flow to Full Treatment
FIBC	Flexible Intermediate Bulk Container
IBC	Intermediate Bulk Container
ICA	Instrumentation Control & Automation
IED	Industrial Emissions Directive
OCU	Odour Control Unit
OMC	Operational Management Centre
OMP	Odour Management Plan
PFT	Picket Fence Thickener
PM	Process Manager
PS	Pumping Station
PST	Primary Settlement Tank
Receptors	Sensitive receptors are any fixed buildings or installations where odour annoyance may occur, such as residential homes, schools, hospital, offices, shops or garden centres. Open areas such as playgrounds and public footpaths should also be listed where these are known to have been affected by odour.
SAP	Thames Water's enterprise resource and planning system
SCADA	Supervisory Control and Data Acquisition
SOM	Site Operating Manual
STW	Sewage Treatment Works
TW	Thames Water
UWWTD	Urban Waste Water Treatment Directive

## 2 Executive Summary

In accordance with the consolidated IED Environmental Permit for Didcot; Waste BAT, specifically BAT3; and associated written management systems, this is the site management plan covering use of raw materials, water and residues. Thames Water Utilities Ltd is required to review and record at least every 4 years whether there are suitable alternative materials that could reduce environmental impact or opportunities to improve the efficiency of raw material and water use and to carry out a waste minimisation review.

The prime function of Didcot Sludge Treatment Centre (STC) at Didcot Sewage Treatment Works (STW) is to capture the energy potential from the treatment of sewage sludges. The plant is run 24/7 due to the continuous supply of sewage received at the treatment works either from the surrounding catchment, or via tanker discharge.

This document forms part of the Thames Water Environmental Management System (EMS) for the permitted STC within Didcot STW.

Thames Water is committed to continual environmental improvements, including materials management, water resources and waste management. This commitment is delivered through efficient control of processes, capital investments, and environmental training.

## 3 Process Responsibility

The Operational Manager for the site has overall responsibility for reviewing the processes on the site that use raw materials, raw water and create residual wastes. This document is reviewed 4-yearly, but the review process is ongoing as part of the regular performance monitoring for the site.

There are many drivers for reducing use of raw materials, and creation of wastes within our processes, including environmental, financial, and resourcing, so it is in our best interests to undertake these reviews regularly, and to include representatives across the full chain of specialist teams involved in the decisions. For example, from initial procurement processes, and contractor management, through to operations, alarms, and the regular maintenance of the installation. These all work together to ensure that the processes utilise the minimum amount of raw materials/water (such as overdosing of chemicals), and that wastes are minimised (such as worn parts or broken machinery).

## 4 Raw Materials and Water Management

There are a limited number of raw materials used in the process. All materials used at the installation are subject to storage and handling procedures, as laid out in relevant Asset / Essential Standard and the Site Operating Manual (SOM). There are no dusty or potentially wind conveyed materials used on the installation.

The use of raw materials is carefully monitored and benchmarked for cost reasons, and in many cases the correct quantity has to be precisely used for proper processing to take place, so there are controls in place through monitoring and optimisation of the process.

Regular maintenance of the installation, is carried out in accordance with the site's preventative maintenance programme, and the SOM. This ensures that there are minimal energy losses from worn parts, thereby maintaining its inherent efficiency.

## 4.1 Biogas

Biogas is used within the biomethane Gas-to-Grid plant, supplying upgraded biogas to the local gas network for off-site consumption. The generation and use of power and heat from a renewable biogas source represents a positive impact with respect to global warming potential.

Biogas is also used within the two boilers to provide heat input to the Primary Digester Tanks. The principal fuel used in the boilers is biogas resulting from the anaerobic digestion of sludge from the STC. Biogas generated within the Primary Digester Tanks is stored in the Biogas Storage holder within the installation boundary.

The heat is used to regulate the anaerobic digester operational temperature and also supplies the site buildings with central heating. The heat produced by the boilers allows the digestion process to be optimised in order to maximise biogas production. This allows a greater efficiency in converting sludge to biogas.

The generation and use of heat from a renewable biogas source represents a positive impact with respect to global warming potential.

## 4.2 Natural Gas

Natural gas is used in the installation as a back-up fuel to the site boilers in the event there is not sufficient biogas available. This happens rarely in practice.

## 4.3 Water

Water used on the installation is mains water, for three purposes:

- General use;
- Make up of polymer; and the
- Heating loop and boiler system.

Water within the heating loop and boiler systems are treated with dosing chemicals under the management of a specialist subcontractor. It is in closed loop system which only requires minimal top up and inhibitor chemicals addition. This is to decrease water hardness that can cause scale build up within the heat exchangers. The system is inspected for leaks, particularly where excess water has to be added to top up the system.

A review has been undertaken of water use within the site, to see if lower grade water, specifically final effluent from the works can be used to replace any potable water. Savings have been identified and implemented, for example, where water is used for washing down purposes within the site, for example if a spillage of sludge occurs, this water is final effluent from the works.

## 4.4 Other Raw Materials

The site Odour Management Plan gives details of contractor performance and maintenance checks, so these are not covered further here.

Table 4.1 below lists all the raw materials used on site followed by Table 4.2 that gives their composition and fate.

Raw material use is subject to change as a result of internal procurement requirements in order to identify opportunities for change (for economic, environmental, operational resiliency and market forces). The current list reflects raw materials used at the STC at the time of writing the application.

**Table 4.1 - Raw Material List**

<b>Description of raw material and composition</b>	<b>Maximum storage amount (tonnes or as stated)</b>	<b>Annual throughput (tonnes per annum or as stated)</b>	<b>Description of the use of the raw material</b>
SAS Thickening Plant polymer (liquid) Product name: Flopam EM840HIB	2,000 litres stored in 1,000 litre IBCs on portable bunds.	1,500 litres	Agent used in sludge thickening process.
Digested Sludge Dewatering polymer (powder) Product name: Flopam FO4650MPM	4 tonnes stored in bulk bags within a building	12 tonnes	Agent used in sludge dewatering process.
Anti-foam Product name: Flofoam H16	1,000 litres stored in 1,000 litre IBCs on portable bunds	1,000 litres	Agent used to control foaming within digester tanks
Liquid propane Product name: Propane (liquified gas)	6 tonnes within three 2 tonne propane tanks	Approx 4 tonnes	Product used within biomethane Gas to Grid plant to balance CV of the gas (quality requirement)
Granular Activated Carbon	One tank for H <sub>2</sub> S filtration (approx. 2.5 tonne tank) and one tank for siloxane filtration (approx. 2 tonne tank)	Approx 20 tonnes	To filter raw biogas of contaminants prior to removal of CO <sub>2</sub> at the biogas upgrader
Tertiarybutylmercaptane and Dimethylethylsulphide blend	50 litres, stored in gas bottle	Approx 20 litres	Added to the biomethane to odourise the gas, as required for safety and to enter the gas distribution network
Helium	100 litres, stored in gas bottles	Approx 2,500 litres	Calibration of sampling equipment on biomethane plant
Nitrogen, other inert gas mixtures	Minimal quantities, stored in gas bottles	Minimal	Calibration of sampling equipment on biomethane plant



**Table 4.2 - Composition and Fate of Raw Materials**

Raw Material	Composition	Fate	Viable Alternative
<b>Biogas</b>	Methane (57.2%) Carbon dioxide (41.6%) Other (1.2%)	Heat energy Air emissions of carbon monoxide, carbon dioxide, sulphur dioxide and nitrogen oxides	No Alternatives: Boilers require biogas fuel.
SAS Thickening Plant polymer (liquid) Product name: Flopam EM840HIB	Hydrocarbons, C12-C15, n-alkanes, isoalkanes, cyclics, <2% aromatics (20 – 30%) Isotridecanol, ethoxylated (<5%)	Absorption into sludge. Leftover polymer returned to head of works via filtrate liquors.	No viable alternative.
Digested Sludge Dewatering polymer (powder) Product name: Flopam FO4650MPM	Adipic acid (<= 2.5%) Sulphamidic acid (<= 2.5%)	Absorption into cake. Leftover polymer returned to head of works via filtrate liquors.	No viable alternative.
Anti-foam Product name: Flofoam H16	1. 1-Hexanol, 2-ethyl-, manufacture of, by-products from, distillation residues (<10%) Distillates hydrotreated light paraffinic (DMSO <3%) (<10%) Petroleum distillates, hydrotreated heavy naphthenic (<10%) Petroleum distillates, hydrotreated light naphthenic (<10%) Petroleum distillates, hydrotreated heavy paraffinic (<10%) White mineral oil (petroleum) (<10%) Distillates (Fischer-Tropsch), heavy, C18-50-branched, cyclic and linear (<10%)	Very small quantities dosed into sludge and adsorbed into the sludge. Waste product to be recycled.	No viable alternative.
Liquid propane Product name: Propane (liquified gas)	Propane and Propene (99-100%) Ethyl mercaptan (<0.01%) Methanol (<0.1%) Butadiene (<0.1%)	Use as a product. Blended with biogas to produce biomethane generated for injection into gas grid.	No viable alternative.

Raw Material	Composition	Fate	Viable Alternative
Granular Activated Carbon (GAC)	Activated carbon (100%)		
Tertiarybutylmercaptane and Dimethylethylsulphide blend	2-(2-butoxyethoxy)ethanol (5-15%) Triethanolamine (5-15%) Isotridecanoethoxylate (<5%) Ethanol (<5%) PEG-15 cocamine (<5%)	Use as a product. Absorption into biomethane generated for injection into gas grid	No viable alternative.
Helium	Helium (100%)	Vented via GEU process vents	Safety requirement
Nitrogen, other inert gas mixtures	Nitrogen (100%)	Vented via GEU process vents	Safety requirement

## 5 Waste Gas and Water

### 5.1 Waste Gas Streams

Waste gases are generated in a limited number of locations within the site, primarily the air emission points associated with the biogas handling, storage and utilisation system.

Biogas comprises a mixture of approximately 40% carbon dioxide and 60% methane; with low levels of other volatile organic compounds and Hydrogen Sulphide and entrained moisture. Moisture is removed using moisture traps within the biogas handling system, so both the exact composition and volume of biogas handled at the site vary dependent upon the precise location where sampling occurs. This contains four main potential sources:

- Pressure relief valves;
- Boiler emissions; and
- Ground Flare stack.

There are potentially low volumes of waste gases not captured from the open Secondary Digester Tanks and Dewatering Feed Buffer Tank at the site and from digested sludge cake at the open cake pad area at the site.

Pressure relief valves, if operated, will release raw biogas.

The boilers and the flare stack combust biogas, so will release primarily CO<sub>2</sub>, and NO<sub>x</sub> with low volumes of SO<sub>2</sub>, volatile organic compounds (VOCs) and CO.

The two boilers are too small to be considered as 'existing' combustion plant and therefore fall outside of the scope of the Medium Combustion Plant Directive (MCPD). The boilers will have no emission testing requirements but are subject to routine maintenance. The ground flare is not monitored unless its operational hours exceed 10% of the year.

There are also low volume emissions from the odour control units on site, although the full composition of these is not analysed.

### 5.2 Waste Water Streams

Waste water is returned to the STW inlet from operational areas of the site via the site's drainage system. Waste water is then treated through the UWWTD stream. Where such transfers leave the permitted area for the digestion process, these are marked on the site plan.

Waste water arises from a number of sources within the STC. These include:

- SAS Thickening Plant Liquors
- Primary Thickening Plant Liquors;
- Sludge Dewatering Plant Liquor;
- Biogas Condensate;
- OCU Waste Water
- Gas-to-Grid Waste Waters
- Site surface rain run-off; and,
- Washdown for maintenance and cleaning.

The majority of surface water drainage is rainfall related, however most rainwater, which falls on site is absorbed by soakaways and does not enter the drainage system.

At present, waste water returns to the works inlet are not metered or measured directly. Waste water liquor monitoring proposals will be developed in line with the requirements of the applicable IC in the permit draft proposals have been provided in a separate document, which has been submitted to the Environment Agency. Refer to this proposal for full details.

## 5.3 Waste Water Drainage

Note that the drainage system at the works includes both process waters and surface water drainage within the same system. This reduces the risk of any spillages being released into a separate surface water drainage system and diverted directly to the adjacent water body. Instead, all water in the drainage system is captured and returned to the STW inlet for processing within the UWWTD stream at the site. Where drainage leaves the installation permit boundary, it may include waste waters from within areas of the site which sit outside of the installation permit boundary, due to the design and configuration of the drainage system within the STW.

At present, no direct monitoring of site drainage is carried out where it leaves the permit boundary, with regards to chemical composition; loading; volume or variability. All process returns within the drainage system originate within the incoming sludge derived from the main STW flow. Sampling and analysis of waste water drainage will be developed in line with the requirements of the applicable IC in the permit. Draft proposals have been provided in a separate document, which has been submitted to the Environment Agency. Refer to this proposal for full details.

## 6 Inventory

### 6.1 Water usage

At present, water usage is not metered at the site.

### 6.2 Biogas

Biogas production is not subject to direct measurement, due to the difficulty of measuring volumes with or without moisture content. Thames Water operate an ISO50001 Energy Management System, with the aim of continuous improvement. Energy reviews occur frequently, with energy performance reports being produced weekly and monthly.

Boiler use is monitored by output over time and use is recorded. Ground Flare use is monitored and recorded, and an allowance made for biogas based on flare capacity.

As the production is dependent upon sewage inputs and flows, the volume produced in any month varies.

## 7 Residue Management

This section outlines the measures Thames Water take to:

- Minimise the generation of residues arising from the treatment of waste;
- Optimise handling of wastes in accordance with the waste hierarchy; and
- Ensure the proper treatment, recycling, or disposal of residues.

A residue is defined as the solid waste generated by the permitted waste treatment activity. With that definition, this document does not focus on the general wastes created from activities outside the scope of the permit, for example office buildings even if they are collocated on the same site, or on gaseous emissions from the processes. Nor does it include the solid sewage cake produced by dewatering digested sewage sludge, which is removed from site, following checks to determine its quality and adherence to appropriate requirements, and spread to land in accordance with the Sludge Use in Agriculture Regulations 1989 (SUiAR) and the Biosolids Assurance Scheme (BAS).

There are only a limited number of residue streams that require off-site disposal, treatment or recycling because this STC is co-located with Thames Water's STW.

The residues are stored within designated areas.

Oil filters and some contaminated maintenance wastes are hazardous and are, therefore, segregated from non-hazardous wastes for disposal in line with appropriate legislation.

Where waste is required to be sent offsite, it is sent to a suitably permitted facility for disposal / treatment by approved third party waste management contractors.

A Waste Management Framework Contract ensures that approved contractors have been pre-vetted and helps ensure they have the relevant expertise, competency and access to appropriately permitted facilities appropriate to each transferred waste stream. Our waste contractors will supply us with a Waste Transfer Note (WTN) and/or Waste Consignment Note (WCN) - dependant on what type of waste is being removed from site. All waste documentation for the installation is retained for the appropriate length of time at the site (two years for WTN and three years for WCN).

The residues produced by the permitted processes including management in line with the waste hierarchy and areas for potential improvement and future review are detailed in Table 7.1 below:

**Table 7.1 - Residue List**

<b>Residue Type</b>	<b>Current Measures</b>	<b>In line with Waste Hierarchy</b>	<b>Potential Improvements</b>
Biogas condensate	Condensate is removed from the biogas lines using moisture traps. Released to site drainage and returned to works inlet for processing within the UWWTD stream	Disposal following treatment	No improvement opportunities foreseen. Current route considered to be BAT
Oily rags, oil filters, air filters	Stored within appropriate segregated containers in the waste storage area. Disposed of (as hazardous waste) by specialist contractor.	Disposal	No improvement opportunities foreseen. Current route considered to be BAT
Filter media from OCU	Removed from OCU during servicing for regeneration. Offsite recovery at appropriately permitted facility.	Recovery	No improvement opportunities foreseen, as returned to manufacturer for refreshing. Current route considered to be BAT
Grit and screenings from digester cleansing	As much grit and screenings as possible are screened out during earlier processes (outside the scope of this permit) to minimise that entering anaerobic digestion process.	Grit: Landfill	No improvement opportunities foreseen.

Residue Type	Current Measures	In line with Waste Hierarchy	Potential Improvements
		Screenings: Landfill	Current route considered to be BAT.  Grit / screenings fate reviewed on a periodic basis to identify alternative routes for this waste stream

## 8 Summary and Recommendations

Currently, there are no additional techniques or raw material alternatives known, which could be implemented on site to reduce environmental impact or improve the efficiency of raw materials or water usage.

Where raw, potable, water can be replaced with lower grade water on site, for example for washing down small spillages, this has already been implemented.

Due to the small number and type of residue streams, there was very little scope for further reduction of those generated on site.