

# Report for the Periodic Monitoring of Emissions to Atmosphere

Stack Emissions Test Report Commissioned by: Trademark Yorkshire Ltd

## Trademark Yorkshire Ltd

### EP2 - Master Etch LEV 07

Permit No: N/A  
Installation: ITM Power Ltd (Sheffield)  
Monitoring Dates: 25th - 26th July 2023  
Site Address: ITM Power Ltd, 22 Atlas Way, Sheffield, S4 7QQ

Report Number:	ES-1429	Version:	1	Visit:	1 in 2023
Date of Report:	17th August 2023				
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MCERTS No:	MM 20 1592	MCERTS Level:	2 (TE1, TE2, TE3, TE4)		
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# Contents

Executive Summary	
Monitoring Objectives	3
Monitoring Results	4
Operating Information	5
Monitoring Deviations	5
Supporting Information	
Appendix 1: General Information	6
Appendix 2: Results and Calculations	7 - 11

# Executive Summary

## Monitoring Objectives

Envirocare Technical Consultancy were contracted by Trademark Yorkshire Ltd to carry out emissions monitoring, to determine the release of prescribed pollutants at EP2 - Master Etch LEV 07. There are no emission limits set for any of the pollutants at this time. The methodologies utilised and the results obtained form the basis of this report.

The substances requested for monitoring are listed below.

## Emission Point Identification

Substances to be Monitored	EP2 - Master Etch LEV 07
Sulphuric Acid	✓
Chloride (as HCl)	✓
Water Vapour	✓
Volumetric Flow	✓

Special requirements: none

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# Executive Summary

## Monitoring Results

where MU = Measurement Uncertainty associated with the result (95% Confidence)

Substance	Limit (mg/m <sup>3</sup> )	Concentration			Reference Conditions	Mass Emission			Sampling Date	Sampling Times
		Result (mg/m <sup>3</sup> )	Measurement Uncertainty (MU) +/-	Limit (g/hr)		Result (g/hr)	Measurement Uncertainty (MU) +/-			
Chloride (as HCl)	R1	-	22.6	1.8	273k, 101.3kPa, Wet Gas	-	51.7	4.8	25/07/2023	13:10-14:10
Sulphuric Acid	R1	-	0.34	0.03	273k, 101.3kPa, Wet Gas	-	0.77	0.07	25/07/2023	13:10-14:10
Water Vapour	R1	-	1.7%	-	As Measured	-	-	-	-	-
Volumetric Flow (Actual)	R1	-	2,496 m <sup>3</sup> /h	113	As Measured	-	-	-	25/07/2023	11:50-11:55
Volumetric Flow (REF)	R1	-	2,292 m <sup>3</sup> /h	104	273k, 101.3kPa, Wet Gas	-	-	-	25/07/2023	11:50-11:55

Reference conditions (REF) are: 273k, 101.3kPa, Wet Gas

# Supporting Information

## Appendix 1: General Information

### Operating Information

Parameter	Process Details
Process Type	Macro Etch
Continuous or Batch Process	Batch
Operating Status	Normal
Feedstock	Various metal Components and Solvents
Normal Load, Throughput or Continuous Rating	20 plates
Abatement System	N/A
Abatement System Status	N/A
Process Fuel	N/A
Plume Appearance	None

### Monitoring Deviations

Parameter	Run	Deviation
H2SO4	Run 1	The absorption efficiency was less than the required 95%, however, it should be noted that the results were of a low order.

### Monitoring Organisation Staff Details

Personnel	Position	MCERTS Level	MCERTS Number
Mr R Bromwell	Team Leader	2 (TE1, TE2, TE3, TE4)	MM 20 1592
Mr J Doyle	Team Leader	Trainee	MM 22 1757

## Monitoring Methods

Pollutant Species	Standard	Technical Procedure	Testing MCERTS	Analysis Laboratory	Analytical Procedure	Analytical Technique	Analysis MCERTS
Volumetric Flow	BS EN ISO 16911-1	ETC-SE-24a	Yes	Pitot Tube and Thermocouple			
Chloride (as HCl)	BS EN 1911	ETC-SE-05	Yes	RPS	C27(U)	IC	Yes
Sulphuric Acid	US EPA M8	ETC-SE-31	No	RPS	EPA M8	IC	No
Water Vapour	BS EN 14790	ETC-SE-11	Yes	ENV	ETC-SE-11	Gravimetric	Yes

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## Equipment Checklist

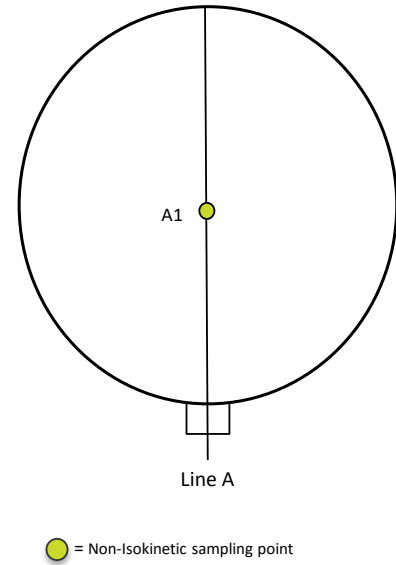
Extractive Sampling		Instrumental Analysers		Miscellaneous Items	
Equipment Type	Equipment I.D.	Equipment Type	Equipment I.D.	Equipment Type	Equipment I.D.
Control Box DGM	8.09	Horiba PG-250	12.04	Tape Measure	17.12
Box Thermocouples	2.01a	Horiba PG-250 SRM	-	Bevel Box	-
Box Thermocouple In	3.35	Horiba PG-350	-	Stopwatch	10.01
Box Thermocouple Out	3.36	JCT JCC Cooler	3.40b	Barometer	11.1
Control Box Timer	10.01a	MAK10 Cooler	-	Digital Manometer	24.04
Umbilical	2.01a	Horiba PS200 Cooler	-	Digital Temperature Meter	24.04
Oven Box	9.07	M&C PSS Gas Preparation	-	Dual Channel Heat Controller	6.04
Heated Probe (1)	4.07	Gasmet DX4000 FTIR	-	1m Heated Line	-
Heated Probe (2)	4.22	Gasmet Sampling System	-	3m Heated Line	-
Stack Thermocouple (1)	1.07	SK-Thermo FID	13.04	5m Heated Line	-
Stack Thermocouple (2)	-	Bernath 3006 FID	-	10m Heated Line	5.08
S-Type Pitot (1)	10-17-19-8	Testo 350XL	-	20m Heated Line	-
S-Type Pitot (2)	8.10(b)	M&C PSP 4000	-	30m Heated Line	7.04
L-Type Pitot	20.05L	Easylogger EN-EL-12 Bit	-	Impinger Arm Thermocouple (1)	3.04
Site Balance	18.09	Hioki 5043 (V)	-	Impinger Arm Thermocouple (2)	-
500g Check Weight	18.09a	Analyser Temperature Logger	19.1	Dioxins Kit Thermocouple	-
1KG Check Weight	18.09b	-	-	Sample Temperature Logger	-
Digital Callipers	16.08	-	-	Laboratory Balance	SE--

## Appendix 2: EP2 - Master Etch LEV 07 Results and Calculations

Picture of the sampling location



Sampling Points Diagram



### Duct Characteristics

Parameter	Units	Value
Type	-	Circular
Depth	m	0.24
Width	m	-
Area	m <sup>2</sup>	0.05
Port Depth	cm	10.0
Orientation of Stack / Duct	-	Horizontal
Sampling Port Size	-	4" BSP
Number of Ports	-	1

Manual Sampling Points	Used / Required
Number of Sampling Lines	1 / 1
Number of Sampling Points	1 / 1
Instrumental Sampling Points	Used / Required
Number of Sampling Lines	1 / 1
Number of Sampling Points	1 / 1

Platform Type and Location	
Platform Type - Permanent / Temporary	Temporary
Location - Inside / Outside	Inside

EA Technical Guidance Note M1 Platform Requirements		
Load Baring Capacity	Load baring capacity of platform sufficient to fulfil the measurement objective	Yes
Position & Work Space	Sufficient work area to manipulate probe & operate the measurement instruments	Yes
	Depth of work area > internal diameter of stack and wall thickness plus 1.5m	Yes
	Ports on vertical ducts 1.2m to 1.5m above platform floor	No
	Platform has chains / self closing gates at top of ladders	N/A
Fall Prevention	Platform has adequate drainage to prevent accumulation of free-standing water	N/A
	Platform has 2 levels of handrails (approx. 0.5m & 1.0m high)	N/A
	Gaps between handrails not >0,5m	N/A
Access	Platform has vertical base boards (approx. 0.25m high)	N/A
	Access to sampling ports unhindered by obstructions	Yes
	Easy & safe access and egress available	Yes

### Sampling Location / Platform Recommendations

The Sampling location meets all the requirements specified in Environment Agency Guidance Note M1 and BS EN 15259, and no improvement actions are required.

## Flow Criteria Measurements

Duct Diameter (m)	Cross Sectional Area (m <sup>2</sup> )	Barometric Pressure (mbar)	Ambient Temperature (°C)	Mean Oxygen (%)	Mean Carbon Dioxide (%)	Mean Water Vapour (%)	Stack Gas Molecular mass (g/mol)	Pitot Coefficient
0.24	0.05	1010	20.0	20.9	0.50	1.7	28.7	0.994

Sample Line	Traverse Point	Position (cm)	Differential Pressure Reading (Pa)				Stack Velocity (m/s)	Stack Temp (°C)	Angle of Swirl
			1	2	3	Av. (cmH <sub>2</sub> O)			
A	A1	12.0	140	140	140	1.4	15.3	23	1

Parameter	Mean Duct Velocity	Velocity Ratio (Max:Min)	Mean Stack Temperature	Mean Stack Temperature	Stack Gas Volume Flow	Stack Gas Volume Flow (STP Wet)	Stack Gas Volume Flow (REF)
Value	15.3	1.0:1	23.4	296	2496	2292	2292
Units	m/s	-	°C	K	m <sup>3</sup> /hr	Nm <sup>3</sup> /hr	Nm <sup>3</sup> /hr



## Sulphuric Acid - Run 1 Calculations

Sampling Details		
Meter Box Number	8.09	-
Gas Meter Coefficient	0.998	-
Pitot Coefficient	0.994	-
Stack Gas Molecular Weight	28.8	g/mole
Static Pressure in Stack	1.1	cmH <sub>2</sub> O

Analysis Details		
Collection Media	De-ionised Water	
1st Collector Reference	Imp A&B	
1st Collector Concentration	151.47	µg
2nd Collector Reference	Imp C	
2nd Collector Concentration	36.63	µg
Blank Concentration	0.032	mg/Nm <sup>3</sup>
Has breakthrough occurred?	Yes	-

Isokineticity Details		
Nozzle Diameter	-	mm
Average Gas Meter Temperature	22.8	°C
Average Stack Temperature	23.5	°C
Average Stack Velocity	15.2	m/s
Isokineticity	-	%

Date	Operators
25/07/2023	RB / JD

Parameter	Before	After	Unit
Barometric Pressure	1010	1010	mbar
Ambient Temperature	22.0	22.0	°C
Leak Check	0.04	0.03	L/min
Time	13:10	14:10	-

Emissions Calculations		
Total Sampling Time	60	min
Gas Meter Difference	599	L
Corrected Gas Meter Volume	598	L
Mean Sampling Rate	10.0	L/min
Gas Meter Volume (STP Dry)	0.550	Nm <sup>3</sup>
Gas Meter Volume (REF)	0.559	Nm <sup>3</sup>
Stack Gas Water Vapour Content	1.6	% v/v
Stack Gas Oxygen Content	N/A	% v/v
Emission Limit Value	-	mg/Nm <sup>3</sup>
Concentration (REF)	0.34	mg/Nm <sup>3</sup>
Mass Emissions (REF)	0.77	g/hr

Reference conditions (REF) are: 273k, 101.3kPa, Wet Gas

## Chloride (as HCl) - Run 1 Calculations

Sampling Details		
Meter Box Number	8.10(b)	-
Gas Meter Coefficient	0.939	-
Pitot Coefficient	0.994	-
Stack Gas Molecular Weight	28.8	g/mole
Static Pressure in Stack	1.1	cmH <sub>2</sub> O

Analysis Details		
Collection Media	De-ionised Water	
1st Collector Reference	Imp A&B	
1st Collector Concentration	12994.8	µg
2nd Collector Reference	Imp C	
2nd Collector Concentration	71.176	µg
Blank Concentration	< 0.025	mg/Nm <sup>3</sup>
Has breakthrough occurred?	No	-

Isokineticity Details		
Nozzle Diameter	-	mm
Average Gas Meter Temperature	24.3	°C
Average Stack Temperature	23.5	°C
Average Stack Velocity	15.2	m/s
Isokineticity	-	%

Date	Operators
25/07/2023	RB / JD

Parameter	Before	After	Unit
Barometric Pressure	1010	1010	mbar
Ambient Temperature	22.0	22.0	°C
Leak Check	0.01	0.01	L/min
Time	13:10	14:10	-

Emissions Calculations		
Total Sampling Time	60	min
Gas Meter Difference	661	L
Corrected Gas Meter Volume	621	L
Mean Sampling Rate	10.3	L/min
Gas Meter Volume (STP Dry)	0.568	Nm <sup>3</sup>
Gas Meter Volume (REF)	0.579	Nm <sup>3</sup>
Stack Gas Water Vapour Content	1.8	% v/v
Stack Gas Oxygen Content	N/A	% v/v
Emission Limit Value	-	mg/Nm <sup>3</sup>
Concentration (REF)	22.6	mg/Nm <sup>3</sup>
Mass Emissions (REF)	51.7	g/hr

Reference conditions (REF) are: 273k, 101.3kPa, Wet Gas

## Uncertainty

### Uncertainty of Sulphuric Acid - Run 1

Parameter	Value	Unit
Emission Limit Value (ELV)	-	mg/m <sup>3</sup>
Mean Sampling Rate	10.0	L/min
Leak Rate	0.04	L/min
Barometric Pressure	1010	mbar
Average Stack Temperature	23.5	°C
Sampled Stack Gas Volume	599	L

Parameter	Value	Unit
Mean Emission Concentration	0.34	mg/m <sup>3</sup>
Monitoring Duration	60	min
Console ID	8.09	-
Temperature Uncertainty	0.24	°C
Gas Meter Uncertainty	0.37	%
Barometer Uncertainty	1.0	mbar

Source of Uncertainty	ASD*	CEN/TS 17340		Certified Value	Units	% Actual Value	Source Uncertainty u	Combined Uncertainty u <sup>2</sup>
		Uncertainty Criteria	Max. Value					
Analysis Procedure	Std	-	-	7.9	%	4.0	0.01	0.0002
Leak Rate	Rect	<2% of sampling rate	0.20	0.04	L/min	0.35	0.0007	0.0000005
Time	Std	1sec in 1hour = 0.028%	2.0	1.0	sec	0.03	0.00009	0.00000009
Gasmeter Volume	Std	<2% actual volume	12.0	2.2	L	0.37	0.001	0.000002
Temperature	Std	<1% absolute temperature	0.23	0.24	k	1.0	0.003	0.00001
Pressure	Std	<1% absolute pressure	10.1	1.0	mbar	0.10	0.0003	0.0000001
<b>Total</b>								0.0002
<b>Combined Standard Uncertainty [(sum u<sup>2</sup>)<sup>0.5</sup>]</b>								0.01
<b>Expanded Total Uncertainty as a % of emission conc. (95% confidence)</b>								8.2
<b>Expanded Total Uncertainty (mg/m<sup>3</sup>) (95% confidence)</b>								0.03
<b>Expanded Total Uncertainty as a % of emission limit value (95% confidence)</b>								-

### Uncertainty of Chloride (as HCl) - Run 1

Parameter	Value	Unit
Emission Limit Value (ELV)	-	mg/m <sup>3</sup>
Mean Sampling Rate	10.3	L/min
Leak Rate	0.01	L/min
Barometric Pressure	1010	mbar
Average Stack Temperature	23.5	°C
Sampled Stack Gas Volume	661	L

Parameter	Value	Unit
Mean Emission Concentration	22.6	mg/m <sup>3</sup>
Monitoring Duration	60	min
Console ID	8.10(b)	-
Temperature Uncertainty	0.24	°C
Gas Meter Uncertainty	0.37	%
Barometer Uncertainty	1.0	mbar

Source of Uncertainty	ASD*	BS EN 1911		Certified Value	Units	% Actual Value	Source Uncertainty u	Combined Uncertainty u <sup>2</sup>
		Uncertainty Criteria	Max. Value					
Analysis Procedure	Std	<2.5% of measured value	-	7.9	%	4.0	0.91	0.83
Leak Rate	Rect	<2% of sampling rate	0.21	0.01	L/min	0.10	0.01	0.0002
Time	Std	1sec in 1hour = 0.028%	2.0	1.0	sec	0.03	0.006	0.00004
Gasmeter Volume	Std	<2% of measured value	13.2	2.4	L	0.37	0.08	0.007
Temperature	Std	<2.5K cal. uncertainty	0.23	0.24	°C	1.0	0.23	0.05
Pressure	Std	1% of absolute pressure	10.1	1.0	mbar	0.10	0.02	0.0005
<b>Total</b>								0.89
<b>Combined Standard Uncertainty [(sum u<sup>2</sup>)<sup>0.5</sup>]</b>								0.94
<b>Expanded Total Uncertainty as a % of emission conc. (95% confidence)</b>								8.2
<b>Expanded Total Uncertainty (mg/m<sup>3</sup>) (95% confidence)</b>								1.8
<b>Expanded Total Uncertainty as a % of emission limit value (95% confidence)</b>								-

Uncertainty of Volumetric Flow - Run 1

Parameter	Value	Unit
Measured Volumetric Flow Rate Actual	2496	m <sup>3</sup> /hr
Performance Characteristics & Source Value		
Standard Uncertainty - Pitot tube Coefficient	0.005	-
Standard Uncertainty - Mean Local Dynamic Pressure	1.1	Pa
Standard Uncertainty - Molar Mass of Stack Gas	0.00003	-
Standard Uncertainty - Stack Gas Temperature	0.50	K
Standard Uncertainty - Absolute Pressure in Duct	176	Pa
Standard Uncertainty - Density of Stack Gas	0.03	-
Standard Uncertainty - Mean Velocity	0.18	m/s
<b>Expanded Uncertainty Mean Velocity (95% confidence)</b>	0.36	m/s
<b>Expanded Uncertainty Mean Velocity (95% Confidence), Relative</b>	2.3	%
<b>Standard Uncertainty - Volumetric Flow Rate</b>	57.7	-
<b>Standard Uncertainty - Volumetric Flow Rate (95% Confidence)</b>	113	m <sup>3</sup> /hr
<b>Standard Uncertainty - Volumetric Flow Rate (95% Confidence), Relative</b>	4.5	%
95% confidence interval factor - 1.96		

Document Version Number	Record of change within different version numbers
V1	Original version of the document issued to client.