Sustainable water management for Recycling & Reuse
Industrial wastewater, a valuable resource

In most industries, such as Microelectronics, Pulp & Paper, Power, Food & Beverage and Oil & Gas, the high volumes of water used during the overall manufacturing process represent a significant expense. Drawing upon its worldwide experience in industrial water cycle management, Veolia has developed standard solutions for water recycling and reuse.

Demand for water reuse

Water scarcity

Increased demand for water reuse

Costs

1. Water consumption costs
2. Discharge costs
3. Increase of production

Sustainable development

Regulations

1. Limitation of water intake
2. Discharge limits
3. Zero Liquid Discharge (ZLD)

Client benefits

Compliance with local regulations

Enhanced environmental image of company

Evaluation of carbon footprint assessment

Ensured constant water quality & supply

Sustainable water treatment solutions & optimized operational costs

Water quality for reuse and recycling

While the quality requirements vary for the different uses, there are general commonalities across most plants for industrial water, cooling water, process water and boiler feed water.

<table>
<thead>
<tr>
<th>Application for reuse and recycling</th>
<th>Common quality issues</th>
<th>Pollutants to be removed and/or controlled</th>
</tr>
</thead>
<tbody>
<tr>
<td>Industrial water</td>
<td>Dissolved solid content, iron and manganese content</td>
<td>TSS, Fe, Mn</td>
</tr>
<tr>
<td>Cooling make-up water</td>
<td>Corrosion, biological growth and scaling, disinfection in case of aerosol risk</td>
<td>BOD, TSS, Turbidity, silica, pathogens, legionella</td>
</tr>
<tr>
<td>Boiler make-up water</td>
<td>Thermal exchange limitation, steam quality reduction, scaling, corrosion</td>
<td>Dissolved solids, hardness, alkalinity, conductivity</td>
</tr>
<tr>
<td>Process water</td>
<td>pH, solids, silica, dissolved solids and chloride, pollutant concentration, bacteriology, compliance with process water specification</td>
<td>As appropriate to the application: pH control, dissolved solids, chloride, specific pollutant concentrations</td>
</tr>
</tbody>
</table>
Water recycling normally involves only one use, and the effluent is treated and redirected back into the same loop and for the same use. It can also be used when wastewater is treated and used again in the process.

Water reuse is the use of treated wastewater for beneficial purposes other than the initial use, such as cooling systems, boilers, process water, irrigation, cleaning or ground water recharge.

Zero liquid discharge is the total elimination of liquid waste discharge from a plant. In place of disposal, internal waste could be recycled, reused or reduced to achieve zero output of liquid waste.
There is not a single specific technology for water REUSE. The water reuse is very often obtained after association of several processes/technologies applied to each case such as clarification, reverse osmosis, evaporation and chemical treatment.

**Actiflo® Turbo - The ultimate clarifier**
- More than 870 references worldwide
- Over 60 Actiflo® references for reuse applications
- Equipped with coagulation tank, flocculation improved with Turbomix™, a hydraulically optimized settling tank with lamella, a hydro-cyclone for micro-sand recovery
- Increased rise rate: 80m/h for industrial process water, wastewater and seawater
- Cost effectiveness: more compact compared to conventional clarifiers, very short startup time
- Industrial applications
  - Process water: General use, CTMU, pre-treatment for boiler feed, etc.
  - Wastewater: TSS, F, heavy metals, O&G, leachates and reuse

**Actiflo® Softening Process - High rate softening solutions**
- Actiflo® Softening combines in a single compact treatment unit both clarification and softening operations to remove constituents such as calcium, silica, heavy metals, fluorides, suspended solids, while improving properties such as alkalinity, hardness and turbidity.
- Improve water quality and produce high quality water
- Very small footprint: Up to 10 times smaller than conventional softening processes
- High rise rate: up to 120 m/h
- Enhanced chemical precipitation with Turbomix™ reaction tank
- Minimize coagulant demand due to solids precipitation with calcium carbonates
- Sludge characteristics: up to 8% dry solids; can be easily thickened and dewatered
- Industrial applications: Power industries, water production for cooling tower make-up, water recycling for cooling tower side stream, treatment of produced water for Oil & Gas, SAGD (Steam Assisted Gravity Drainage) water treatment for reuse, wastewater treatment of flue gas desulfurization

**EVALED™ - Evaporation technologies**
- Low energy consumption
- Recycling of high quality distillate from heavily polluted wastewater
- High separation level
- Ideal to achieve ZLD (Zero Liquid Discharge) in combination with RO plants
- Three types of models (series)
  - EVALED™ PC
    - Vacuum heat pump evaporators (150 kWh/ton)
  - EVALED™ AC
    - Hot/cold water vacuum evaporators (Cogeneration)
  - EVALED™ RV
    - MVR evaporators (30-50 kWh/ton)
**SIRION™ Mega - Reverse Osmosis systems**

- Production of high purity water
- From 5 to 30 m³/h
- Lower operating pressure, cost savings due to low energy consumption membranes
- 1 or 5 μm pre-filtration included
- Appropriate recirculation rinsing reduces membrane fouling
- Applications:
  - Boiler feed
  - Industrial process water
  - Cooling water
  - Reuse / recycling
  - Healthcare
  - Biotechnologies
  - Electronics
  - Hospitals
  - Chemical industry
  - Primary metals

**OPUS® Process - Reverse Osmosis membranes for high water recovery**

- High Water Recovery Rates
- Effective Fouling/Scaling Control
- Ability to Handle Variations in Feed Water Quality
- High Salt Rejection; Silica > 99.9%, Boron > 99.4%, TOC > 99%
- Continuous Clean-In-Place(CIP) Process
- Low Energy Consumption
- Long Membrane Life
- Applications:
  - Oil & Gas
    - Produced water treatment, refinery wastewater
  - Mining, industrial wastewater reuse
  - ZLD Application
  - Power
    - Cooling tower blow-down treatment, make-up water

**HYDREX™ Chemicals - Water treatment chemical solutions**

- Protect water treatment systems against scale deposition, corrosion, fouling, etc.
- Reduce unnecessary downtime
- Ensure optimum productivity
- Prevention and reduction of environmental risks
- Energy saving
- Applications:
  - 1000 series: Total boiler water treatment chemicals
  - 2000 series: Cooling water treatment chemicals
  - 4000 series: RO water treatment chemicals (Effective membrane antiscalants and cleaners approved by major membrane manufacturers)
  - 6000 series: Drinking water and wastewater treatment chemicals
  - 7000 series: Biocides control chemicals
### General Motors Pontiac, Michigan, USA
- Zero Liquid Discharge process design, basic engineering and equipment supply
- High quality water for reuse
- High recovery rate with low waste volume (convert 90% of the tertiary wastewater into reusable water)
- Operation and maintenance of the new wastewater treatment plant since 2001 (DBOOM)
- Environmental regulation compliance

### General Motors Cactus Plant in San Luis Potosi, Mexico
- Out-sourcing of the wastewater treatment facilities for the meatpacking house
- Biological treatment for grease/oil removal
- Wastewater biological treatment with aeration
- Sludge-thickening unit on a gravity table, designed to achieve 6-7% dryness

### LG/Lotte Petrochemicals, Daesan, Korea
- 20 years of the long-term partnership, the largest reverse osmosis units in Asia with 84,000 m³/day capacity
- Demi water: 41,120 m³/day, cooling water supply: 1,861,224 m³/day (circulation rate basis), potable water: 5,235 m³/day

### Sabim, Sablé-sur-Sarthe, France
- Significant cost savings (KOH recovery of 85% to 90%)
- Environmental benefit and recognition: the project won the ‘Governor’s award for Environmental Excellence for the State of Pennsylvania’

### Dongbu steel, Dangjin, and Incheon, Korea
- Supplying sufficient quantity of high quality cooling water for production of steel products for 15 years
- Implementing on-line monitoring of operation to assure stable operation and quality
- Cooling water: 511,872 m³/day, treated wastewater: 5,376 m³/day, demi water: 883 m³/day
- Reusing over 50% of process water to protect the environment and reduce costs

### L’Oreal BeautyCos production factory, based in Suzhou, China
- Reduction of greenhouse gas emissions, water consumption and discharged transportable waste by 50% by 2015
- Energy and chemical consumption are reduced.
- Sludge production is significantly decreased.
- Stabilization of the effluent quality and optimization allowing tertiary treatment and reuse
- The water impact index is reduced by 35%.
- By implementing a reuse system, the overall water consumption of the factory could be further reduced by 32%

### Pfizer Nutrition, Suzhou Industrial Park, Jiangsu, China
- Full scope of performance guarantees and expertise in O&M of the wastewater treatment plant
- Innovative solution based on sludge composting and recycling for land application
- Secure a constant quality of treated effluent to allow reuse as cooling tower make-up
- Wastewater: 2,400 m³/day
<table>
<thead>
<tr>
<th><strong>Mining</strong></th>
<th><strong>CONSOL Energy Inc., mine water treatment facility, Mannington, West Virginia</strong></th>
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<tbody>
<tr>
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<td>- Zero liquid waste discharge acid mine drainage water treatment facility in Northern West Virginia</td>
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<td></td>
<td>- 10 year operations period, with 5 year renewal options of DBO project</td>
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<td>- Chemical precipitation, reverse osmosis and thermal technologies</td>
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<td>- Applying the water impact index to the mine water treatment facility to maximize the recovery of clean water</td>
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<th><strong>E.D.F, Civeaux Nuclear Power Plant, France</strong></th>
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<td></td>
<td>- Partnership with Électricité de France (EDF), the one of the largest electricity producers in the world</td>
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<td>- 2 generating units, Production: 7 billion kWh/year</td>
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<td>- Temporary solutions for the upgrading of feeding demineralization units (secondary loop)</td>
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<td>- Rental of mobile units, staff for the operations and maintenance, guarantee of the production levels</td>
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<th><strong>Micro-electronics</strong></th>
<th><strong>SK hynix, Icheon - Cheongju - Gumi, South Korea</strong></th>
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<td>- Ultra-pure water, potable water, wastewater treatment services</td>
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<td>- Reducing costs and protecting the environment: An average of 40% and up to 60% of the process water is recycled</td>
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<td>- Operating state-of-the-art wastewater treatment facilities to meet legal standards on the quality of treated wastewater</td>
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<th><strong>Oil &amp; Gas</strong></th>
<th><strong>SHELL Qatar, Pearl GTL complex, Qatar</strong></th>
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<td>- Design and build contract for an effluent treatment plant</td>
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<td>- Treatment of the cooling water blow-down for reuse in the process</td>
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<td>- Optimization of water cycle management and Zero Liquid Discharge</td>
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<td>- Sludge treatment using evaporation and crystallization processes which allow low volume production of dewatered sludge and salt crystals</td>
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<td>- The more efficient water reuse is guaranteed by the improved water quality and the increased recycled water volume</td>
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<td>- Increased the salt removal capacity and reduced the salinity of Lake Liddell</td>
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<td>- Capacity 2,640 MW (power station), 120 ML/day (WTPs)</td>
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<th><strong>Smurfit-Stone Container Corporation, Hopewell, USA</strong></th>
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<td></td>
<td>- Design and build of the new evaporator system</td>
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<td>- Production: 300,000 tons/year</td>
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<th><strong>Oil and Gas, Pulp and Paper SAPREF refinery, Mondi paper mill Durban, South Africa</strong></th>
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<td>- Municipal wastewater reuse for process and cooling water production</td>
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<th><strong>Oil &amp; Gas</strong></th>
<th><strong>Showa Denko HD Singapore</strong></th>
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<td>- Water management capabilities: ultrapure water, reclaim water, wastewater, utilities</td>
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<td>- Guarantee the consistent, high-quality and sufficient water supply</td>
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<td>- A special facility was constructed for recycling reclaim water, and within two years of operations, the plant now uses 50% of reclaim water.</td>
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<td>- Supply of high quality water (40,000 m³/d) from municipal wastewater treatment (Cost effective solution compared to seawater desalination and transportation)</td>
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Over 400 water recycling & reuse projects around the world by Veolia!

- **America**: 93 projects
- **Middle East**: 155 projects
- **Europe**: 44 projects
- **Asia**: 75 projects
- **Africa**: 12 projects
- **Mexico**: 11 projects
- **Australia**: 29 projects
Veolia Korea Water Reuse References

Waste Water Reuse Project, LG Siltron

Key figures
- Client: LG Siltron
- Capacity: 40m³/hour
- Technology: Actiflo® / Hydrotech® Disc Filter / MF and Reverse Osmosis (RO)-combined system
- Scope: Design, construction and commissioning
- Guaranteed water quality:
  - Turbidity < 0.1NTU, Conductivity <50μs/cm

Background
Veolia constructed Actiflo® Package, Hydrotech® Disc Filter, Micro Filter(MF) and Reverse Osmosis (RO)-combined system for the semiconductor silicon wafer manufacturing processes in LG Siltron, Ltd.

Veolia’s Technology and System Overview

- Actiflo® for reuse applications
  - Actiflo® applied for the purpose of pre-processing in the reuse system.
  - High removal of SS from waste water through coagulation with the addition of metallic salt (Al3+, Fe3+, etc.) and ballasted flocculation.
  - SS of waste water subject to reuse to be removed by over 90% and supplied as raw water to reduce loads on the following treatment processes.

- Benefits
  - Reduction in water costs with the reuse of waste water generated from silicon cutting and polishing process.
  - Turbidity, dissolved solids and electric conductivity were assured above the required water quality, proving excellent performance of Actiflo® and reuse water processing facilities.

C3 Organic Waste Water Reuse, SK Hynix

Key figures
- Client: SK Hynix
- Year of Contract: 2010
- Capacity: 2,000m³/day
- Recovery rate: 98.5%
- Scope of project: BOT

Background
Veolia has designed, installed and managed the operations of the sand filter, activated carbon, UV sterilizer, reuse tanks, additional pumps, etc. to reuse the treated and segregated organic waste water from WWTP C3 (2,000m³/day) as scrubber water on the site of Cheongju, SK Hynix, Veolia’s client.

System Overview

- New Facility Installed for Reuse
  - 750m³/day used as scrubber water by reuse facilities treating organic treated water.
  - Quality of water processed for reuse: Below the quality of organic waste water (TOC 3 ppm↓, CODCr 3 ppm↓, and Turbidity 1 NTU↓), prevention of increase of microorganisms.

Process

Benefits

Through the successful implementation, SK Hynix committed to improving local environment by reducing raw water, saving costs, and minimizing discharge organic waste water.
BG Waste Water Reuse Project, SK Hynix

Key figures
- Client: SK Hynix
- Capacity: 3,000m³/day
- Scope of project: BOT

Background
In accordance with the plan of SK Hynix to reduce raw water, Veolia has constructed a reuse water system for 4 months from April to July, 2013 to reuse a segregated waste water generated by P&T3 Back Grinding Fab.

- Saving cost to produce UPW (Ultra Pure Water) necessary for semiconductor manufacturing processes
- Reducing operating costs of waste water treatment facilities
- Resolving a challenge involving increase of burden on local water treatment plants resulting from increased use of water on SK Hynix Cheongju site

System Overview
- Process: TMF (SS: 0.5ppm↓ / SiO2: 10ppm), RO (SiO2: 3.68ppm)
- Guaranteed Water Quality for particular and soluble SiO2 removal

<table>
<thead>
<tr>
<th>Item</th>
<th>Unit</th>
<th>BG Raw W.W.</th>
<th>Design</th>
<th>Average</th>
</tr>
</thead>
<tbody>
<tr>
<td>SiO2</td>
<td>ppm</td>
<td>100~1,000</td>
<td>3.68↓</td>
<td>1.34</td>
</tr>
</tbody>
</table>

Benefits
- Veolia aims to improve client satisfaction by saving costs on industrial process water, waste water treatment utility (steam, cooling water) and etc..
- Solving problems with increase of burden on water resources, resulting from an increase in use of raw water on SK Hynix Cheongju site.
- Reducing environmental pollution and contribution to low-carbon green growth.
- Improving operation condition of the existing UPW system in accordance with supply of high-quality reused water.

Reuse Pilot Test, Samsung Electronics

Key figures
- Client: Samsung Electronics
- Capacity: 5m³/hr
- Scope: Pilot test for pre-treatment of reuse facilities
- Contract: July 2011 ~ October 2011 (round-the-clock, 3 months)

Background
Actiflo® Pilot Plant was selected by Samsung Electronics on its Giheung Campus for reuse at WTP. The pilot was maintained for three months for the purposes to secure adequacy of Actiflo® facility-applied design, optimum amount of chemicals to be injected, estimated construction costs, and estimation of site area and operating costs.

Veolia’s Technology and System Overview
- SS Design standard: SS 2,000ppm
- SS Required quality of treated water: <20ppm

Benefits
- With an aim to confirm adequacy of pre-processing by using waste water arising from the WTP, Giheung Campus, Samsung Electronics, Actiflo® was test-run. Over this period, SS concentration remained at 20ppm or below stably even when very high SS (23,340ppm) is introduced at the feed during exceptional conditions.
- The test operation shall have Veolia’s Actiflo® facility recognized in its performance, establishing a foundation for Samsung Electronics to develop green sustainable business in the future without more water resources withdrawn from the environment.