05.  Hot-Dip Industry

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Japan Galvanizers Association
1. How to Use This Manual.............................................................................................................. 1
   1.1. PRTR Chemicals Related to the Industry ........................................................................ 1
   1.2. Example of Hot-Dip Process .......................................................................................... 2
   1.3. Flow Chart of Hot-Dip Galvanizing Process and Releases and Transfers
       of PRTR Chemicals (Fig. 1) ............................................................................. 3
   1.4. Notes ............................................................................................................................ 4
   1.5. Procedures for Calculating Releases and Transfers
       of PRTR Chemicals and Calculation Examples .............................................. 4
      1.5.1. Zinc Compounds (water-soluble) (Fig. 2) .......................................................... 4
      1.5.2. Xylene (Fig. 3) .................................................................................................... 11
      1.5.3. Chromium and Trivalent Chromium Compounds (Fig. 4) .......................... 16
      1.5.4. Hexavalent Chromium Compounds (Fig. 5) .................................................... 19
      1.5.5. Lead and Its Compounds (Fig. 6) ....................................................................... 23
      1.5.6. Hydrogen Fluoride and Its Water-Soluble Salts (Fig. 7) ................................. 29
1. **How to Use This Manual**

This is a manual to help facilities capture releases and transfers of Class I Designated Chemical Substances (referred to as “PRTR chemicals”) which started in April, 2001 and report on them which started in April 2002 both under the PRTR System.

1.1. **PRTR Chemicals Related to the Industry**

<table>
<thead>
<tr>
<th>Chemical Name</th>
<th>CAS Number</th>
<th>Country</th>
<th>Industry Sector</th>
<th>Impact Category</th>
<th>Reporting Requirement</th>
</tr>
</thead>
<tbody>
<tr>
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<td></td>
</tr>
</tbody>
</table>

An example table or list of PRTR chemicals related to the industry sector.
### 1.2. Example of Hot-Dip Process

This table outlines operations of hot-dip process. Users may refer to this manual when calculating the quantities of PRTR chemicals released and transferred.

<table>
<thead>
<tr>
<th>Operation</th>
<th>Description</th>
<th>Quantity of PRTR Chemicals Released</th>
<th>Quantity of PRTR Chemicals Transferred</th>
</tr>
</thead>
<tbody>
<tr>
<td>...</td>
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</tbody>
</table>

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1.3. Flow Chart of Hot-Dip Galvanizing Process and Releases and Transfers of PRTR Chemicals (Fig. 1)

The procedure for calculating quantities of PRTR chemicals released and transferred is shown in Fig. 1 to outline the entire flows of releases and transfers.

Fig. 1: Outline of hot-dip galvanizing process and releases and transfers of PRTR chemicals
1.4. Notes

The procedures described in this manual are given as examples for reference. Therefore, facilities are not obliged to follow the procedures described in this manual. They may report on chemical releases and transfers calculated based on other methods which they believe can produce more accurate results in an efficient manner.

1.5. Procedures for Calculating Releases and Transfers of PRTR Chemicals and Calculation Examples

1.5.1. Zinc Compounds (water-soluble) (Fig. 2)
Fluxing agents that contain zinc chloride are used mainly in plants which galvanize large items. However, plants for galvanizing small items involving a variety of manual operations, use only ammonium chloride and do not use zinc chloride for safety, because it is hygroscopic. Therefore plants which use only ammonium chloride for galvanizing small items may follow the steps marked with *.
[Calculation Example]

For carrying out calculations, convert the quantity of zinc compounds (water-soluble) to that of elemental zinc by using a conversion factor.

(1) Annual quantity of zinc chloride handled

\[
\text{(Annual quantity handled)} = \left( \frac{\text{Annual quantity of fluxing agents handled}}{100} \right) \times \text{(Conversion factor)}
\]

\[
= (58,000 \text{ kg/year}) \times (45.9\%/100 \text{ (mole ratio: 1:3)}) \times (0.480)
\]

\[
= 12,779 \text{ kg}
\]

(2) Releases to the air

(2.1) Releases from local exhaust gas system to the air

For the concentration of zinc chloride in the exhaust gas emissions from local exhaust gas system for flux tanks, the threshold limit value of “1 mg/Nm\(^3\)” for zinc chloride recommended by the ACGIH is applied as a constant. In case where companies have their own measured values, they may be also used.

\[
\text{(Releases from local exhaust gas system)} = \left( \frac{\text{Annual quantity of exhaust gas emissions}}{1,000,000} \right) \times \text{(Conversion factor)}
\]

\[
= (1,000 \text{ Nm}^3 \text{ per minute x 60 minutes x 200 hours x 2 shifts x 12 months}) \times (1 \text{ mg/Nm}^3/1,000,000) \times (0.480)
\]

\[
= 138 \text{ kg}
\]

(2.2) Releases from the surface of solutions to the air in working environment

Calculations are made on the assumption that the air within 2 m above the surface of flux solutions is ventilated 10 times per minute.

For the concentration of zinc chloride in the exhaust gas emissions from local exhaust gas system near the flux tanks in the working environment, the threshold limit value of “1 mg/Nm\(^3\)” for zinc chloride recommended by the ACGIH is applied as a constant. In case where companies have their own measured values, they may be also used.

\[
\text{(Releases from the surface of solutions)} = \left( \frac{\text{Length (m) x Width (m) x Height (2 m) x 10 times/minute x 60 minutes x 24 hours x 365 days}}{1,000,000} \right) \times \text{(Conversion factor)}
\]
(Conversion factor)
= \( (14 \times 2.5 \times 2 \times 10 \times 60 \times 24 \times 365) \times (1 \text{ mg/Nm}^3) \times (0.480)/1,000,000 \)
= 177 kg

(2.3) Releases from dust collectors to the air

The average collection efficiency of fume by dust collectors was assumed to be 90 percent. And the composition of chemical substances uncollected and released to the air was assumed to be equivalent to that of the collected ash.

For the quantity of zinc chloride contained in the dust collected, zinc compounds dissolved from the collected ash into solutions are regarded as zinc chloride, because zinc chloride is water-soluble.

Dissolved zinc is measured according to the “Dissolution test method for metals in waste (referred to as the analytical methods)” designated (in the Environment Agency Notice No. 14 dated February 17, 1973 – “Detection method of metals contained in waste to be used as landfill”, which is stipulated in Paragraph 1 of Article 5 of the Enforcement Ordinance for the Law Relating to the Prevention of Marine Pollution and Maritime Disaster) that is applied to mineral sludge to be used for marine reclamation. The arithmetic mean of the values measured by several member companies of this Association is applied as a constant. In case where facilities have their own measured values, they may be also used.

(Releases from dust collectors)
= \{((\text{Quantity of collected dust}/0.9) \times 0.1) \times (\text{Zinc content in collected dust measured by means of released metal content test (\%)}) \}
= \{((14,550 \text{ kg/year}/0.9) \times 0.1) \times (0.034\% /100) \} = 1 \text{ kg}

The zinc content in the collected dust measured by the dissolution test method (\%)
= (\text{Dissolved zinc mg/liter}) \times (1/\text{quantity of collected dust x } 1,000) \times 100
= (\text{dissolved zinc mg/liter}) \times (1/\text{quantity of collected dust})/10
The quantity of collected dust is 30 g.

(2.4) Releases
(Releases to the air) = 138 kg + 177 kg + 1kg
= 316 kg

(3) Releases from wastewater treatment equipment to water bodies
(Releases to water bodies)
= (\text{Quantity of wastewater used or quantity of wastewater released}) \times (\text{Concentration of zinc in wastewater})
The arithmetic mean of measurements with the in-house wastewater treatment equipment at respective facilities in accordance with the “JIS K 0102 Wastewater Test Methods – 1998” is used as the concentration of zinc in wastewater.

As a result of measurement stipulated in “Paragraph 53 “Zinc” of JIS K 0102,” the “measurements” mean:

[1] “regulated values” in case where “< regulated values” are recorded;
[2] “measurement result” in case where “measurement result” is recorded;
[3] “0.0 mg/liter” in case where “ND” is recorded.

\[
(97,000 \text{ m}^3) \times (2.5 \text{ mg/liter})/1,000 \\
= 243 \text{ kg}
\]

(4) Releases to the environment

\[\text{Releases to the environment} = (\text{Releases to the air}) + (\text{releases to water bodies})\]

\[= 316 \text{ kg} + 243 \text{ kg} \\
= 559 \text{ kg}\]

In case where wastewater is released to sewage, it is calculated as “transfers contained in waste,” not as “releases to the environment (releases to water bodies)” based on the following equation:

\[\text{Releases to the environment} = (\text{Releases to the air})\]

\[= 316 \text{ kg}\]

(5) Transfers contained in wastewater

\[\text{Quantity of zinc compounds (water-soluble) in wastewater} = (\text{Quantity of waste flux solutions}) \times (\text{Concentration of zinc chloride in wastewater})\]

(6) Transfers contained in waste/sludge

(6.1) Quantity of zinc mixed in ash

The quantity of zinc chloride in ash was measured in the same way with that of zinc chloride in the ash collected using the “Dissolutions Test Methods”.

Like the case for the collected dust, the arithmetic mean of measurements made by several member companies of this Association is applied as a constant. In case where facilities have their own measured values, they may be also used.

\[\text{Quantity of zinc in ash} = (\text{Quantity of ash}) \times (\text{Zinc content in ash measured by the Dissolutions Test (\%))} \\
= (494,700\text{kg/year}) \times (0.123\%/100)\]
(6.2) Quantity of zinc in collected dust
(Quantity of zinc in collected dust)
= (Quantity of collected dust)
  x (Content of zinc collected dust measured by the Dissolutions Test (%))
= (14,550 kg) x (0.034%/100)
= 5 kg

(6.3) Quantity of zinc in sludge
(Quantity of zinc in sludge)
= (Quantity of sludge)
  x (Zinc content in sludge measured by the Dissolutions Test (%))
= (194,000 kg) x (0.004%/100)
= 8 kg

(6.4) Transfers
(Transfers contained in waste/sludge)
= (Quantity of zinc mixed in ash) + (Quantity of zinc in dust collected)
  + (Quantity of zinc in sludge) + (Transfers to sewage)
= 608 kg + 5 kg + 8 kg + 0 kg
= 621 kg

(7) Quantity of zinc chloride delivered to the galvanizing step by adhering to items to be galvanized

Fluxing is carried out in order to facilitate the contact between the surface of steel to be galvanized and molten zinc to produce nondefective galvanized layers.

Zinc chloride in flux agents reacts with basic ferric salts adhering to items to be galvanized in the molten zinc baths and zinc oxide on the surface of zinc baths to become black molten chloride and separates them from the surface of the galvanized items.

The black melt chloride is collected before products are pulled up from the zinc baths. Then, it is oxidized to become zinc oxide. However, the zinc oxide contains unoxidized zinc chloride.

The quantity of zinc chloride delivered to galvanizing step by adhering to items to be galvanized varies depending on conditions such as the surface area and surface roughness of items to be galvanized, concentration and temperature of fluxing solutions, and surface tension. For this reason, it is very difficult to measure it independently.

Therefore, as shown in the following equations, the quantity calculated by
subtracting the releases to the environment, the transfers contained in wastewater, and the transfers contained in sludge from the quantity handled is regarded as the quantity delivered.

(Quantity delivered to galvanizing step)
= (Quantity of zinc chloride handled) – (Releases from fluxing tank to air)
– (Releases to water bodies) – (Transfers contained in wastewater)
– (Transfers contained in sludge)
= 12,779 kg – (177 + 138) kg – 243 kg – 0 kg – 8 kg
= 12,213 kg

(8) Transfers of zinc contained in waste acids after removal of galvanized layers
(Transfers of zinc contained in waste acids after removal of galvanized layers)
= (Quantity of waste acids) x (Content of zinc in waste acids (%))
= (25,700 kg) x (11.7%/100)
= 3,007 kg

For the quantity of zinc contained in waste acids after removal of galvanized layers, values measured by respective facilities are used because their target zinc concentrations are considered to be different.

(9) Transfers
(Transfers)
= (Transfers of zinc contained in waste/sludge) + (Transfers of zinc contained in waste acids)
= 621 kg + 3,007 kg
= 3,628 kg

In case where wastewater is released to sewage, it is calculated as the “transfers contained in waste” using the following equation:
(Transfers to sewage)
= 243 kg + 621 kg + 3,007 kg
= 3,871 kg
1.5.2. Xylene (Fig. 3)
[Calculation Procedure]
[Calculation Example]

Two kinds of paints; spray type and brush type, are used for repairing galvanized layers in galvanizing plants. Calculation procedures for these two types are shown below:

A. Spray type of paint for repairing

1. Solvents ingredients

(1) Annual quantity of xylene handled

\[
\text{(Annual amount handled)} = (\text{Annual amount of spray type paints handled}) \times (\text{Xylene content %})
\]

\[
= (5,285 \text{ pcs.} \times 300 \text{ ml} \times \text{Density}1.2 \text{ g/cm}^3) \times (5.1\% / 100) / 1,000
\]

= 97 kg

(2) Transfers contained in waste containers

Waste containers of spray type of paints are drilled, when disposing, to prevent them from exploding. As a result, residues in the waste containers are entirely released to the air. Therefore residues in waste containers are assumed to be zero when carrying out calculations.

\[
\text{(Transfers)} = (\text{Annual quantity of xylene handled}) \times (\text{Residue in waste containers})
\]

\[
= (97 \text{ kg}) \times (0.0\% / 100)
\]

= 0 kg

= 0 kg

(3) Maximum potential releases to the environment

\[
\text{(Maximum potential releases to the environment)} = (\text{Annual quantity handled}) - (\text{Transfers})
\]

= 97 kg - 0 kg

= 97 kg

(4) Releases to the air

\[
\text{(Releases to air)} = (\text{Maximum potential releases to the environment})
\]

= 97 kg

2. Pigments ingredients

PRTR chemicals are not contained in the pigments.

B. Brush type paints for repairing galvanized layers

1. Solvents ingredients

(1) Annual quantity of xylene handled

\[
\text{(Annual quantity handled)} = (\text{Annul quantity of brush type paints handled}) \times (\text{Xylene content %})
\]
+ (Annual quantity of thinners for brush type of paints) x (Xylene content (%))
= (650 kg) x (19.6%/100) + (870 kg) x (90.1% /100)
= 911 kg

(2) Transfers contained in waste paints

The amount of waste paint generated is assumed to be 5% of the quantity of paints used. And the solvents in waste paints were considered to remain in the same content. The thinner is considered not to be contained in the waste paints but entirely consumed.

(Transfers)
= (Annual quantity of waste paints generated) x (Xylene content (%) in paints)
= (650 kg x 5%/100) x (19.6%/100)
= 6 kg

When a large amount of paints are disposed of, calculations shall be made separately following the above example.

(3) Maximum potential releases to the environment
(Maximum potential releases to the environment)
= (Annual quantity handled) - (Transfers)
= 911 kg - 6 kg
= 905 kg

(4) Releases to the air
(Releases to air)
= (Maximum potential releases to environment)
= 905 kg

2. Pigments ingredients
PRTR chemicals are not contained in the pigments.

C. Releases to the air and transfers in waste
1. Releases to the air
= 905 kg + 97 kg
= 1,002 kg

2. Transfers contained in waste
= 6 kg
<table>
<thead>
<tr>
<th>項目</th>
<th>内容</th>
<th>数値</th>
</tr>
</thead>
<tbody>
<tr>
<td>項目1</td>
<td>内容1</td>
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</tr>
<tr>
<td>項目2</td>
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</tr>
<tr>
<td>項目4</td>
<td>内容4</td>
<td>数値4</td>
</tr>
</tbody>
</table>

[Reference]:
1.5.3. Chromium and Trivalent Chromium Compounds (Fig. 4)
[Calculation Example]

There are cases where chromium is detected and removed from the wastewater treatment equipment, although chromating solutions are not released through the chromating equipment. These are chromium and trivalent chromium compounds which dissolve from stainless steel to be galvanized or jigs used in the preparation. The amount of these substances cannot be managed at hot-dip galvanizing plants.

For the case where chromium and trivalent chromium compounds are removed in a large amount and facilities are required to report them as transfers, calculations shall be made based on the calculation examples shown in this manual.

If the amount of chromium handled is needed for reporting, the “amount of removed” shall be used as the “amount handled” because it is not actually available.

(1) Releases of chromium from wastewater treatment equipment to water bodies
(Releases to water bodies)
= (Quantity of wastewater used or quantity of wastewater)
  x (Chromium concentration in wastewater)

For the chromium concentration in wastewater, the arithmetic mean of measurements of wastewater with in-house wastewater treatment equipment at respective facilities may be used. The “measurements” here refer to the following:

As a result of measurement stipulated in “JIS K 0102 Paragraph 65.1 Chromium,” the “measurements” mean:

[1] “regulated values” in case where “< regulated values” are recorded;
[2] “measurement result” in case where measurement result” is recorded.
[3] “0.0 mg/liter” in case where “ND” is recorded.

= (97,000 m³) x (0.2 mg/liter)/1,000
= 19 kg

(2) Releases to the environment
(Releases to environment)
= (Releases to water bodies)
= 19 kg

(3) Transfers contained in waste acids/sludge
For the chromium concentration in waste acids/sludge, the arithmetic mean of measurements made by respective facilities may be used.
(Transfers contained in waste acids)  
= (Quantity of waste acids generated) x (Content (%) of chromium in waste acids)  
= (436,000 kg/year) x (0.005%/100)  
= 22 kg  

(Quantity of chromium in sludge)  
= (Quantity of sludge generated) x (Content of chromium (%) in sludge)  
= (194,000 kg) x (0.003%/100)  
= 6 kg  

(4) Calculating transfers  
(Calculating transfers of chromium)  
= (Transfers contained in waste acids/sludge)  
= 22 kg + 6 kg  
= 28 kg  

In case where wastewater is released to sewage, it is calculated as “transfers contained in waste,” not as “release to the environment (release to water bodies)” using the following equation:  
= 28 kg + 19 kg  
= 47 kg
1.5.4. Hexavalent Chromium Compounds (Fig. 5)
(1) Calculating the quantity of handled PRTR chemicals contained in chromating solutions
[Calculation Example]
When making calculations, convert the quantity of hexavalent chromium compounds to that of a metallic element (Cr.).

(1) Annual quantity of hexavalent chromium compounds handled

\[
\text{(Annual quantity handled)} = (\text{Annual quantity of sodium dichromate handled}) \times \left(\frac{100\%}{100}\right) \times \text{(Conversion factor)}
\]

\[
= (1,100 \text{ kg/year}) \times (0.397)
\]

\[
= 437 \text{ kg}
\]

When the content (%) of these chemical compounds are 95% or more, it should be regarded as 100 mass % for calculations.

In the chromate treatment carried out for corrosion prevention by member companies of this Association, the chromium concentrations of 0.01 – 0.1% have been used.

The OEL for hexavalent chromium in the work environment has been set at 0.1 mg/Nm\(^3\). However measurements in the work environment near the chromate treatment tanks have not found chromium.

Recycling and regeneration (from trivalent chromium into hexavalent chromium) are carried out in the closed systems which use ion exchange resin.

As a result, there is no chromating solutions directly contained in wastewater treatment equipment.

(2) Releases to the air

Since measurements did not show chromium in the work environment, releases to the air are assumed as zero. Therefore releases from local exhaust gas systems and the surface of solutions are as follows:

(Releases to the air) = 0 kg

(3) Releases to the environment

(Releases to the environment) = (Releases to the air)

Since the substance is not released through wastewater treatment equipment, there is no release of this substance to water bodies.

= 0 kg
(4) Transfers contained in waste chromating solutions

Trivalent chromium other than hexavalent chromium is also contained in waste solutions. However, it should be calculated as hexavalent chromium for the purpose of facilitating calculations.

\[
\text{(Quantity of hexavalent chromium in waste solutions)} = (\text{Quantity of waste chromating solutions}) \times (\text{Concentration of chromium in waste solutions})
\]

In case where chromate treatments waste solutions are processed by the ion exchange resin and in wastewater treatment equipment, releases to water bodies are calculated by the following equations:

\[
\text{(Transfers adhered to iron exchange resin)} = (\text{Quantity of waste chromating solutions}) \times \{(\text{Chromium concentration in waste solutions}) - (\text{Chromium concentration after the ion exchange processing})\}
\]

(5) Calculating the carried out quantity adhered to products

(Carried out quantity of hexavalent chromium adhered to products)

\[
= (\text{Quantity of hexavalent chromium compounds handled}) - (\text{Releases of hexavalent chromium compounds to the environment}) - (\text{Transfers in waste chromating solutions})
\]

\[
= (437 \text{ kg}) - (0 \text{ kg}) - (0 \text{ kg})
\]

\[
= 437 \text{ kg}
\]

Quantity (%) of hexavalent chromium per ton of products

\[
= \{(\text{Carried out quantity of the substance adhered to products})/\text{Quantity of products to be chromated}\} \times 100
\]

\[
= \{(437 \text{ kg})/1,000/(48,500 \text{ tons} \times 60\%)/100\} \times 100
\]

\[
= 0.002\%
\]

In case where the content is 1 percent or more, it is necessary to issue an MSDS. Therefore, an MSDS is not required for the above case.

(6) Calculating transfers

(Calculating the transfers of hexavalent chromium)

\[
= (\text{Transfers contained in waste solutions})
\]

\[
= (0 \text{ kg})
\]

\[
= 0 \text{ kg}
\]

In case where wastewater is released to sewage, it is calculated as “transfers contained in waste” using the following equation.

\[
= (0 \text{ kg}) + (0 \text{ kg})
\]

\[
= 0 \text{ kg}
\]
1.5.5. Lead and Its Compounds (Fig. 6)
[Calculation Example]

(1) Annual quantity of lead handled

\[
\text{(Annual quantity of lead handled)} = \text{(Annual quantity of lead metal handled)} + \text{(Annual quantity of distilled zinc metal handled)} \times \text{(Lead content \(\%\))}
\]
\[
= (0 \text{ kg/year}) + (2,429,850 \text{ kg/year}) \times (1.12\%/100)
\]
\[
= 27,214 \text{ kg}
\]

The constant of 1.12\% is used as the lead content in the distilled zinc metal.
Zinc is distilled at two refineries in Japan. Therefore, we use the average lead content in the distilled zinc based on the data which have been provided by the two refineries for one year.

(2) Releases from dust collectors to the air

The average collection efficiency of fume with dust collectors is assumed to be 90 percent. And the composition of substances that are released to the air without being collected is considered equivalent to that of the dust collected.

For the quantity of lead contained in the dust collected, the arithmetic mean of measurements obtained by several member companies of this Association is applied as a constant.

Facilities that have their own measured values, they may be also used.

\[
\text{(Releases from dust collectors)} = \left\{ \left(\frac{\text{Quantity of dust collected}}{0.9}\right) \times 0.1 \right\} \times \text{(Lead content in dust collected \(\%\))}
\]
\[
= \left\{ \left(\frac{14,550 \text{ kg}}{0.9}\right) \times 0.1 \right\} \times (2.46\%/100)
\]
\[
= 40 \text{ kg}
\]

(3) Releases from wastewater treatment equipment to water bodies

For the lead content in wastewater, the arithmetic mean of measurements with in-house wastewater treatment equipment at respective facilities is used.

As a result of measurement stipulated in “JIS K 0102 Paragraph 54 Lead,” the “measurements” mean:

[1] “regulated values” in case where “< regulated values” are recorded;
[2] “measurement result” in case where \(\square \square\) “measurement result” is recorded.
[3] “0.0 mg/liter” in case where “ND” is recorded.

\[
\text{(Releases to water bodies)} = \left( \text{Quantity of wastewater used or quantity of wastewater released} \right) \times \text{(Lead content in wastewater)}
\]
\[
= (97,000 \text{ m}^3) \times (0.1 \text{ mg/liter})/1,000
\]
\[
= 10 \text{ kg}
\]
(4) Releases to the environment

(Releases to the environment) = (Releases to the air) + (Releases to water bodies)
= 40 kg + 10 kg
= 50 kg

In case where wastewater is released to sewage, it is calculated as “transfers contained in waste,” not as “release to the environment (release to water bodies)” based on the following equation:
(Releases to the environment) = (Releases to the air)
= 40 kg

(5) Transfers contained in waste/sludge

When the dross and ash are carried out as valuables, the amount is not included in the transfers because they are not listed as the target PRTR chemicals under the PRTR system.

However, in case where they are carried out as waste, they should be calculated according to the following procedure.

The lead contents (%) in dross/ash (valuables) and in the dust collected/sludge vary depending on the operating temperatures of the hot-dip galvanizing baths, because the content of lead which dissolves in zinc is different.

Therefore the lead content (%) was set depending on the differences in the operating temperature.

The arithmetic mean of lead contents (%) applied here has been obtained from measurements at some plants which galvanize small items and large items respectively selected among the member companies of this Association.

Facilities that have their own measured values, those may be also used.

(5.1) Transfers of lead contained in dross

(Lead content in dross) = (Annual quantity of dross generated) x (Lead content in dross (%))
= (218,250 kg) x (0.98%/100)
= 2,139 kg

(5.2) Transfers of lead contained in ash

(Lead content in ash) = (Annual quantity of ash generated) x (Lead content in ash (%))
= (494,700 kg) x (4.51%/100)
= 22,311 kg
(5.3) Transfers of lead contained in the dust collected

(Lead content in dust collected)
= (Annual quantity of dust collected) x (Lead content in dust collected (%))
= (14,550 kg) x (2.46%/100)
= 358 kg

(5.4) Transfers of lead contained in sludge

(Lead content in sludge)
= (Annual quantity of sludge generated) x (Lead content in sludge (%))
= (194,000 kg) x (0.14%/100)
= 272 kg

(5.5) Transfers contained in waste/sludge

(Transfers contained in waste/sludge)
= (Lead content in dross) + (Lead content in ash) + (Lead content in dust collected) + (Lead content in sludge)
= 2,139 kg + 22,311 kg + 358 kg + 272 kg
= 25,080 kg

In case where wastewater is released to sewage:

(Transfers contained in waste/sludge)
= (Lead content in dross) + (Lead content in ash) + (Lead content in dust collected) + (Lead content in sludge) + (Transfers of lead contained in wastewater)
= 2,139 kg + 22,311 kg + 358 kg + 272 kg + 10 kg
= 25,090 kg

(6) Transfers contained in waste acids after removal of galvanized layers

(Transfers contained in waste acids)
= (Quantity of waste acids generated after removal of galvanized layers) x (Lead content in waste acids (%))
= (25,700 kg) x (0.054%/100)
= 14 kg
Since the target quantities of dissolved zinc are considered to be different depending on the facilities, the lead content in waste acids (%) which was obtained from measurements by respective facilities is used instead of a constant.

(7) Transfers
(Calculation of transfers)
= (transfers contained in waste/sludge) + (Transfers contained in waste acids)
= 25,080 kg + 14 kg
= 25,094 kg

In case where wastewater is released to sewage, the transfers are calculated as “transfers in waste” using the following equation:
= 25,090 kg + 14 kg
= 25,194 kg

(8) Quantity of lead contained in galvanized layers on products
(Quantity of lead contained in galvanized layers)
= (Annual quantity of lead handled) – (Releases to the environment) – (Transfers contained in waste/sludge/waste acids)
= 27,214 kg – 50 kg – 25,094 kg
= 2,070 kg

(Percentage of lead contained in galvanized layers on products)
= \{(2,070 kg/1,000)/48,500 tons (production)\} x 100
= 0.004%

In case where the content is 1 percent or more, it is necessary to issue an MSDS. Therefore an MSDS is not required for the above case.
1.5.6. Hydrogen Fluoride and Its Water-Soluble Salts (Fig. 7)
[Calculation Example]

The concentrations of “hydrogen fluoride” in the working environment and of “fluoride” in wastewater are regulated under the related laws.

Under the PRTR system, these chemicals need to be calculated as “fluorine”. Therefore the calculated values as “hydrogen fluoride” are converted to values using conversion factor of 0.950.

(1) Annual quantity of hydrogen fluoride handled

\[
\text{(Annual quantity fluoride handled)} = \text{(Annual quantity of aqueous solutions of hydrogen fluoride)} \times \left(\frac{\text{Hydrogen fluoride content (%)}}{100}\right)
\]

\[
= (11,380 \text{ kg/year}) \times \left(\frac{55\%}{100}\right) = 6,259 \text{ kg}
\]

Fluorine

\[
= (6,259 \text{ kg}) \times (0.950)
\]

\[
= 5,946 \text{ kg}
\]

(2) Releases to the air

(2.1) Releases from local exhaust gas systems to the air

For the concentration of fluorine compounds released to air from local exhaust gas systems placed near the pickling tanks of aqueous solution of hydrogen fluoride, 0.8 mg (F\(^{-}\))/Nm\(^3\) has been obtained by members companies from measurements using the analytical methods based on the JIS L 0105 “Methods for determination of fluorine compounds in flue gas (Spectrophotometric Method of Fluoride with Lanthanum/Alizarin Complexone)”. Therefore this value is used as a constant for the calculations.

Facilities that have their own measured values, those may be also used.

\[
\text{(Releases from local exhaust gas systems)} = \text{(Annul amount of exhaust gas generated)} \times \text{(Fluorine concentration in exhaust gas emissions)}
\]

\[
= (19,900 \text{Nm}^3/\text{hour} \times 167 \text{ hours} \times 1 \text{ shift} \times 12 \text{ months}) \times \left(\frac{0.8 \text{ mg/Nm}^3}{1,000,000}\right)
\]

\[
= 32 \text{ kg (F}^{-}\text{)}
\]

(2.2) Releases from solutions surface to the air in the working environment

It was assumed that the air 2 m above the surface of the aqueous solutions of hydrogen fluoride in the picking tanks is ventilated 10 times per minute.

Facilities that have their own measured values, they may be also used.

For the concentrations of hydrogen fluoride near the picking tanks of aqueous solution of hydrogen fluoride in the work environment, 0.3 cm\(^3\)/Nm\(^3\) has been obtained by members companies from measurements using the analytical method (Spectrophotometric Method of Fluoride with Lanthanum/Alizarin Complexone)".
Therefore this value is used as a constant for the calculations.
Facilities that have their own measured values, those may be also used.

(Releases from solutions surface to the air)
= (Length x Width x Height x 10 times/minute x 60 minutes
x 24 hours x 365 days) x (Number of tanks)
x (Hydrogen fluoride concentration in the working environment)
Since no cover is put on the tanks, hydrogen fluoride is assumed to constantly
diffuse to the air.
= (2.6 m x 1.9 m x 2 m x 10 x 60 x 24 x 365) x (3) x (0.3 cm³/Nm³/1,000,000)
= 46.74 Nm³ (HF)

Converting the weight of hydrogen fluoride gas to that of fluorine.
(Fluorine weight)
= (Annual releases)/(Volume at 1 kmol HF 25 °C, atmospheric pressure)
x (HF 1kmol) x (Conversion factor)
= 46.7Nm³/22.4 Nm³ x (273 + 25) °C/273 °C) x 20 kg x (0.950)
= 36 kg

(2.3) Releases to the air
(Releases to the air) = 32 kg + 36 kg
= 68 kg

(3) Releases from wastewater treatment equipment to water bodies
For the fluorine concentration in wastewater, the arithmetic mean of
“measurements” with in-house wastewater treatment equipment at respective
facilities using the analytical methods based on the “JIS K 0102 Testing methods
for industrial wastewater” is used.
(Releases to water bodies)
= (Quantity of wastewater used or wastewater)
x (Fluorine concentration in wastewater)
= (52,063m³) x (2mg/litre)/1,000
= 104 kg

(4) Releases to the environment
(Releases to environment)
= (Releases to air) + (Releases to water bodies)
= 68 kg + 104 kg
= 172 kg
In case where wastewater is released to sewage, the releases to the environment
(5) Transfers contained in sludge
For the content of fluorine in sludge, the arithmetic mean of measurements obtained by respective facilities is used. 

\[
\text{(Quantity of fluorine in sludge)} = (\text{Quantity of sludge generated}) \times (\text{Content of fluorine in 1 kg of sludge}) \\
= (195,840 \text{ kg}) \times \frac{(100,000 \text{ mg/kg dry sludge}) \times (100\% - \text{Water content 77.7\%})}{100}/1,000,000 \\
= 4,367 \text{ kg}
\]

(6) Transfers contained in wastewater
The typical measurements for fluorine contained in wastewater and in sediments in wastewater tanks are 14,000 mg/kg (in wastewater) and 44,000 mg/kg (in sediments), respectively. 

However, the sediments in the tanks are not always separated from wastewater before being sent to contractors for treatment. For this reason, these values may not reflect the actual state if used for the calculations in this manual. 

Therefore when releases to environment and transfers contained in sludge are identified, the transfers in wastewater are calculated using the following equations:

\[
\text{(Transfers contained in wastewater)} = (\text{Annul quantity handled}) - (\text{Releases to environment}) \\
- (\text{Transfers contained in sludge}) \\
= 5,946 \text{ kg} - 172 \text{ kg} - 4,367 \text{ kg} \\
= 1,407 \text{ kg}
\]

(7) Calculating transfers
\[
\text{(Transfers)} = (\text{Transfers in sludge}) + (\text{Transfers in wastewater}) \\
= 4,367 \text{ kg} + 1,407 \text{ kg} \\
= 5,774 \text{ kg}
\]

In case where wastewater is released to sewage, they are calculated as transfers in waste using the following equation:

\[
= 4,367 \text{ kg} + 1,407 \text{ kg} + 104 \text{ kg} \\
= 5,878 \text{ kg}
\]