

## INFORMATION SHEET

ORDER R5-2017-XXXX  
LEHIGH SOUTHWEST CEMENT COMPANY AND CALAVERAS CEMENT COMPANY  
CALAVERAS CEMENT PLANT

CLOSURE AS CORRECTIVE ACTION AND POST-CLOSURE MAINTENANCE,  
CALAVERAS COUNTY

Pursuant to California Code of Regulations Title 27 (CCR T27) this Waste Discharge Requirements (WDR) Order revision regulates:

1. Final closure of the remaining cement kiln dust pile as a corrective action program
2. Active mining of waste rock for saleable aggregate
3. Post-closure monitoring and maintenance of the entire facility

Lehigh Southwest Cement Company and Calaveras Cement Company (hereafter jointly Discharger or Lehigh), owns and operates the Calaveras Cement Company (site) located on a 250-acre property about 2.5 miles south of San Andreas, CA. The former cement company quarried limestone from an open pit mine (Quarry Pit) and produced cement for approximately 50 years. While the facility was in operation from 1926 to 1982, cement kiln dust (CKD) and waste rock were discharged to three cement kiln dust piles (CKD-1, CKD-2, CKD-3) and two waste rock piles (West Rock Storage Area & East Rock Storage Area). Currently, the facility consists of four mining units (CKD-1 closed in 1998, CKD-3 in corrective action, and East and West Waste Rock Storage Areas) and an active waste rock mining operation Calaveras Materials Inc., a subsidiary of Lehigh Hanson.

Highly alkaline cement kiln dust generated during the production of cement contains elevated metal concentrations including aluminum, copper, chromium, lead, and manganese, and has been classified as Group B mining waste pursuant to CCR T27. Cement kiln dust impacted the groundwater downgradient from CKD piles. Constituents of concern (COCs) include but are not limited to high pH, total dissolved solids, and high chemical oxygen demand and dissolved metals listed above. Closure of CKD-1 in 1998 with a low permeability cover and leachate removal and collection system (LCRS) served as corrective action and in time resulted in a significant decrease of concentrations of COCs in groundwater monitoring wells downgradient from the unit. CKD from CKD-2 was consolidated to CKD-1 prior to CKD-1 closure; the area was restored and regraded to natural contours. The investigations of volume and extent of CKD in CKD-3 were completed in 2015. Lehigh Hanson prepared a preliminary CKD-3 closure plan which includes a low permeability cover and leachate collection and removal system.

Quarry Pit has filled with groundwater and runoff/precipitation after the mining activities ceased and has been used for disposal for Group B leachate from CKD-1. This order discontinues the discharge of leachate from closed CKD units into the Quarry Pit and requires that Lehigh Hanson finds an alternate method for leachate disposal.

Calaveras Materials Inc. is mining waste rock classified as Group C mining waste and crushing it into a saleable aggregate. This facility also recycles some haul-back cement.