State of Washington Department of Ecology
General Order of Approval
Stationary and Portable Concrete Batch Plants

In the matter of approving a stationary or portable concrete batch air contaminant source in the counties listed below	))))	General Order of Approval No. 26AQ-GO-03

Project Summary

Any stationary or portable concrete batch plant (permittee) proposing to locate in one of the counties listed below or proposing to locate at a source that is regulated by Ecology may request coverage under this General Order. If a Coverage Order is granted, this general order is applicable to any stationary or portable concrete batch plant in: Adams, Asotin, Chelan, Columbia, Douglas, Ferry, Franklin, Garfield, Grant, Kittitas, Klickitat, Lincoln, Okanogan, Pend Oreille, Stevens, Walla Walla, and Whitman counties, or any source that is regulated by the Washington State Department of Ecology (Ecology).

Applicants must apply for coverage under this General Order by filling out the current General Order Application for concrete batch plants.

A concrete batch plant cannot obtain coverage under this Order if it is part of a Clean Air Act (CAA) Title I New Source Review (NSR) major stationary source or constitutes an NSR major modification to a major stationary source, which is subject to review under either the Prevention of Significant Deterioration Program or Nonattainment Program. The addition of the concrete batch plant to an existing source must not make the source subject to the CAA Title V major Air Operating Permit (AOP) program or require a modification in an existing AOP permit.

General Orders are subset of minor NSR permitting. The Permittee may generally be classified as any type of minor source. The terms of WAC 173-400-560 limit the ability to use a General Order for equipment if it is located at a facility that has a Title V permit. A temporary unit (365 days or less) may operate at a source classified as a Title V source. If the unit will be in place for more than 365 days, the Permittee cannot use this General Order if it is a Title V source.

This General Order is intended for concrete batch plants that store, convey, measure and discharge a combination of water, sand (fine aggregate), coarse aggregate, cement and supplementary cementitious materials into trucks for transport to a site. At some of these plants, materials are gravity fed from a weight hopper into mixer trucks where the concrete is mixed on route to a site. At other plants, concrete is mixed in a central mix drum before leaving the site.

This General Order is not subject to any NSPS or NESHAP requirements. However, if EPA applies any NSPS or NESHAP requirements to concrete batch plants, those requirements would be enforceable independent of this general order even if they are not listed in this general order.

This General Order applies to stationary and portable concrete batch plants.

- A stationary concrete batch plant is a plant that remains at the same location for longer than one year following start of operation.
- A portable concrete batch plant is a plant that remains at the same location (pit, quarry, or operating site) for less than or equal to 365 days following start of operations.

The provisions of WAC 173-400-035, Non-road engines, can be met by providing information on the power generators as required in the application and notification form required under this approval. This only applies to power generators with a total maximum aggregate rated capacity of between 500 and 2000 brake horsepower (bhp). Power generators with a total maximum aggregate rated capacity of over 2000 bhp shall obtain approval under WAC 173-400-035 prior to installing equipment at any location.

Within 30 days of receipt of an application for coverage under a General Order of Approval, Ecology shall notify the applicant in writing that the application is incomplete, approved, or denied. If an application is incomplete, Ecology shall notify the applicant of the information needed to complete the application. If an application is denied, Ecology shall notify the applicant of the reasons why the application is denied. Coverage under a General Order of Approval is effective as of the date of issuance of approval by Ecology as described in a Coverage Order which will be provided to the facility.

Project installation configurations and operations will vary, but most concrete batch plants will contain some or all of the following emission sources described in EPA AP-11.12 “Concrete Batching.”

Equipment / Emission Sources	Emissions (Process/ Fugitive)	Subject to Minor New Source Review?
Pre/post-production Equipment/Sources (haul roads, aggregate material handling and processes)	Yes	Yes
Production equipment (vented emissions, and production related fugitive emissions)	Yes	Yes

Legal Authority

This general order was prepared under the legal authority of Chapter 70A.15 RCW and satisfies the requirement for new source review under RCW 70A.15.2210 as implemented through the applicable rules and regulations adopted thereunder (including WAC 173-400-560 for General orders of approval). If operated as specified, facilities covered under this general order will be in accordance with applicable rules and regulations, as set forth in Chapters 173-400 WAC and 173-460 WAC and the operation thereof, within Ecology counties, will not result in ambient air quality standards being exceeded.

This General Order of Approval Order rescinds and replaces the original concrete batch General Order of Approval No. 08-AQG-002 issued on June 18, 2008, as well as General Order of Approval No. 11AQ-GO-02 issued December 6, 2011.

However, according to WAC 173-400-560(3) modifications to general orders of approval "only take effect prospectively." Because this General Order is a modification of General Order of Approval No. 11AQ-GO-02, concrete batch plants that were covered under previous versions of this General Order are still in effect. But new applications for coverage under Ecology's concrete batch plant General Order of Approval starting with the issuance date on this General Order, must apply for coverage under this General Order using the application that was updated specifically for it.

Therefore, it is ordered that a concrete batch plant as described in the General Order application and more specifically detailed in plans, specifications, and other information submitted to the Washington State Department of Ecology (Ecology), is approved for construction and operation, provided that the following conditions are satisfied:

Approval Conditions

1. Emission Units/Activities

The general types of equipment listed in the Table above under the Project Summary heading are approved for construction. More specific information is provided in the individual general order permit applications.

2. Operational Limitations

a. Production/Operation Limits

i. The facility is limited to the following production/operating limitations:

Activity	Maximum Rates
Central Mix - primary concrete batch plant limit for stationary and portable facilities operating in a single location. ["Single location" such as a pit refers to the entire boundary of the facility operations even though there may be more than one actual pit within that boundary. Multiple adjacent pits are considered a single location. If a facility leaves a single location but returns during any consecutive 12-month period, the maximum limits are still in effect even for non-consecutive operations within that single location.]	495,000 tons (246,000 cubic yards) of concrete per year in any consecutive rolling 12-month period 9,050 tons (4,500 cubic yards) per any one calendar day

Activity	Maximum Rates
Truck (in-transit) Mix - primary concrete batch plant limit for stationary and portable facilities; operating in a single location. ["Single location" such as a pit refers to the entire boundary of the facility operations even though there may be more than one actual pit within that boundary. Multiple adjacent pits are considered a single location. If a facility leaves a single location but returns during any consecutive 12-month period, the maximum limits are still in effect even for non-consecutive operations within that single location.]	150,000 tons (74,500 cubic yards) of concrete per year in any consecutive rolling 12-month period 9,050 tons (4,500 cubic yards) per any one calendar day

b. Equipment/Activity Restrictions

i. Concrete batch plant emission units including the silos, fabric filter exhaust vent, the transfer of sand, aggregate, cement and cement supplement to the weigh hopper, and load-out operations must follow the minimum distances requirements below upon issuance of the coverage order.

A. Both central mix and truck mix plants must be at least 150 feet (45 meter) from the pit property boundary.

B. Truck mix plants must be at least 550 feet (170 meters) from any residence, occupied commercial building, school, hospital, nursing home or other sensitive receptor.

C. Central mix plants must be at least 450 ft (140 meters) from any residence, occupied commercial building, school, hospital, nursing home or other sensitive receptor.

ii. At no time may a plant exceed the maximum production rating of the installed equipment.

iii. Cement and cement supplement transfers to the silos must:

A. Use a fabric filter (baghouse) during silo filling

B. Not overflow into the baghouse during silo filling

C. Only occur if the silo has a level indicator alarm and/or lights that are installed and operational.

iv. The weigh hopper (for both truck mix and central mix operations) must be enclosed and vented to a baghouse.

v. Central mix operations must have the mixer enclosed and vented to a baghouse. The mixer must not operate unless the baghouse is in operation.

vi. The fabric filter must have a differential pressure gauge that measures pressure between the inlet and outlet of the baghouse.

vii. The fabric filters must be designed to achieve 0.005 grains per dry standard cubic feet of total particulate matter.

viii. Transit mixing operations must use a flexible boot or other flexible containment system that fits into or around the truck mixer.

ix. Fuel-fired water heaters or boilers must use natural gas, propane, liquified petroleum gas (LPG), gasoline, kerosene, or ultra-low sulfur (less than or equal to 15ppm sulfur) diesel fuel. The total heating capacity of the related combustion device(s) must be less than or equal to the following:

   A. Four million Btu/hour for natural gas, propane, and LPG.

   B. One million Btu/hour for gasoline, kerosene, or ultra-low sulfur diesel.

x. The facility must have speed limitations for site vehicles with procedures to maintain and enforce speed restrictions to minimize fugitive dust emissions from haul roads and vehicle access areas.

xi. Fugitive dust from any onsite emission source must be controlled by water application at a rate dependent on the ability to comply with the visible emissions limits of this permit:

   A. Haul roads must be maintained in an adequately moist/wet condition at all times so that dust is not visible leaving the property boundary.

   B. A water truck must be on site at all times the concrete batch plant is in operation, unless the water truck is obtaining water or other arrangements have been made with the permitting agency.

xii. Concrete batch operations cannot begin at any location until Ecology issues an initial coverage order to the applicant allowing use of this general order.

xiii. Additional restrictions for Portable operations

   A. SEPA review must be conducted for each site where the concrete batch plant will be operated and environmental impacts of concrete batch processing at the site must be analyzed as part of that review. If satisfactory SEPA review has not been conducted for the site by another lead agency and no other agency has a permit to issue, the source must submit a SEPA environmental checklist to Ecology together with the Air Quality Notification Form for Portable Sources. Approval to operate the concrete batch plant in any location is not valid until SEPA has been completed.

B. All portable operations must completely fill out, be able to comply with, and submit to the permitting authority the current Air Quality Notification Form for Portable Sources at least 10 days prior to beginning operations at each new site.

C. If operations are anticipated past the end date on a previously submitted notification, the applicant must notify the permitting authority before the end date listed on the original notification.

D. For portable operations that plan to stay at the same location for longer than 365 days:

I. The permittee must submit to Ecology, the Air Quality Notification Form for Portable Sources. This form will be used to notify Ecology that the concrete batch plant intends to operate as a stationary source. Notification under this condition needs to be completed before the end of the one-year period from which operations started as a portable concrete batch plant.]

II. Power generators and other nonroad engines cannot remain at the same location for longer than one year.

III. This general order is no longer valid without meeting the requirements for a stationary concrete batch plant listed in this General Order of Approval. An exception to this is for Title V facilities, which cannot use this general order after 365 days even for a stationary concrete batch plant.

xiv. Additional restrictions for stationary operations:

A. SEPA review must be conducted for the stationary site where the concrete batch plant will be operated and environmental impacts of concrete batch processing at the site must be analyzed as part of that review. If satisfactory SEPA review has not been conducted for the site by another lead agency and no other agency has a permit to issue, the source must submit a SEPA environmental checklist to Ecology as part of the general order application for Concrete batch Plants. Approval to operate the stationary concrete batch plant is not valid until SEPA has been complied with for that site.

B. All stationary concrete batch plant equipment must use line power or must have a Notice of Construction Approval Order before operating as a stationary concrete batch plant.

C. For stationary operations that plan to relocate and operate as a stationary or portable source, the permittee must submit to Ecology the current Air Quality Notification Form for Portable Sources. This form will be used to notify Ecology that the concrete batch plant intends to move and operate as a stationary or portable source, and an updated coverage order may be

required. On the form, check the boxes that say “New Location” and ” Stationary source notification”

c. Emission Limits

Visible emissions for the fabric filter vent must be less than or equal to five percent opacity averaged over six minutes as measured by EPA Method 9.

3. Operation and Maintenance

a. An operations and maintenance (O&M) manual must be developed by the Permittee for each emission unit and process.

i. The O&M manual must include the following, at a minimum:

A. Normal operating parameters for emissions units and processes.

B. A maintenance schedule for emissions units and processes:

I. The O&M manual must also include a maintenance schedule/log of inspections including daily notes that all equipment including but not limited to all air pollution control equipment is working appropriately and what actions were taken to address any malfunction.

C. A description of the monitoring procedures.

D. Monitoring and record keeping requirements.

ii. The O&M manual must be developed within 30 days of commencing operation of each emission unit and process.

b. Emission units and processes must be operated and maintained in accordance with the O&M manual.

c. The Permittee must assess all complaints received. The Permittee must initiate corrective action in response to a complaint within three calendar days of receipt of the complaint.

d. Instrumentation to monitor operating parameters for air pollution control and processing equipment.

4. Monitoring and Recordkeeping

a. The O&M manual must be reviewed annually.

i. The date of each review and the person performing each review must be documented in the O&M manual.

ii. The O&M manual must be updated to reflect any modifications to emission units or processes.

b. O&M records must be kept on premises in hard copy or readily available on-site electronically.

c. For all air-quality related complaints, the following records must be kept:

   i. A written record of the complaint received by the Permittee or forwarded to the Permittee.

   ii. The Permittee's action to investigate the validity of the complaint, any corrective action that was taken in response to the complaint, and the effectiveness of the remedial action.

d. Daily concrete batch production records summed and calculated as a 12-month rolling total showing amount of concrete batch produced.

e. Weekly record of the pressure differential for the baghouse(s).

f. Daily water usage log shall be maintained including:

   i. The date and amount of water used;

   ii. The frequency of water application (example: two times a day, three times a day, four times day etc.);

   iii. The reasons why water is not applied for each day that this occurs.

g. Fuel consumption records for the concrete batch plant water heaters or boilers for each calendar year. Records must demonstrate that each supplier's fuel conforms to the specifications contained in this General Order.

h. Keep maintenance records for all equipment including but not limited to baghouse and dust control and include actions taken to address any malfunction. The date, time, duration, and cause of any periods where control technology equipment is out of service must be documented and maintained.

i. All data required by this General Order must be maintained in a readily retrievable manner for a period of five years and must be made available to authorized representatives of Ecology upon request.

5. Testing

a. When information obtained by Ecology indicates the need to quantify emissions, Ecology may require the Permittee to conduct material analysis or air emission testing under WAC 173-400-105. This testing requirement is in addition to any testing required by Ecology in this General Order, other permits, or other state or federal requirements.

6. Reporting

a. All notifications, plans, reports, and other submittals must be submitted in a manner approved by Ecology.

   i. Ecology Eastern Regional Office - Air Quality Program 4601 N. Monroe St. Spokane, WA 99205-1295; AQ Reception 509-329-3452; ecyaqciero@ecy.wa.gov

ii. Ecology Central Regional Office - Air Quality Program 15 W. Yakima Ave. Ste 200 Yakima, WA 98902; 509-454-7845; ecyaqciewa@ecy.wa.gov

b. The Permittee must notify Ecology within two business days of the receipt of any complaint.

c. The Permittee must submit annual production records to Ecology on an annual basis. Results must be submitted to Ecology within 30 days of request or by January 31 of each year if not specifically requested.

d. The Permittee must notify Ecology within 30 days of the following events:

i. Commencement of construction of the project.

ii. Completion of the construction of the project.

iii. If construction or operation has been discontinued for more than 18 months.

7. General Conditions

a. **Activities Inconsistent with this Order** - Any activity undertaken by the Permittee, or others, in a manner that is inconsistent with the data and specifications submitted as part of the general order application or this general order, must be subject to Ecology enforcement under applicable regulations.

b. **Availability of Order** - Legible copies of this General Order and any O&M manual(s) must be available to employees in direct operation of the equipment described in the general order application and must be available for review upon request by Ecology.

c. **Compliance Assurance Access** - Access to the source by representatives of Ecology or the United States Environmental Protection Agency (EPA) must be permitted upon request. Failure to allow access is grounds for enforcement action under the federal Clean Air Act or the Washington State Clean Air Act and may result in revocation of this General Order.

d. **Discontinuing Construction** - Approval to construct or modify a stationary source becomes invalid if construction is not commenced within eighteen months after receipt of the approval, or if construction is discontinued for a period of eighteen months or more. The permitting authority may extend the 18-month period upon a satisfactory showing by the permittee that an extension is justified.

e. **Equipment Operation** - Operation of the facility must be conducted in compliance with all data and specifications submitted as part of the general order application and in accordance with O&M manuals, unless otherwise approved in writing by Ecology.

f. **Registration** - Periodic emissions inventory and other information may be requested by Ecology as part of Registration Program requirements listed in WAC 173-400-099 through 173-400-105. The requested information must be submitted within 30 days of receiving the request, unless otherwise specified. All fees must be paid by the date specified.

g. **Violation Duration** - If the Permittee violates an approval condition in this General Order, testing, recordkeeping, monitoring, or credible evidence will be used to establish the starting date of the violation. The violation is presumed to continue until testing, recordkeeping, monitoring, or other credible evidence indicates compliance. A violation of an approval condition includes, but is not limited to, failure of air pollution control equipment, failure of other equipment resulting in increased emissions, or a failed source test indicating an exceedance of an emission limit.

h. **Obligations Under Other Laws or Regulations** - Nothing in this General Order must be construed so as to relieve the Permittee of its obligations under any state, local, or federal laws or regulations.

i. **Maintaining Compliance** - It must not be a defense for the Permittee in an enforcement action that it would have been necessary to halt or reduce the operations in order to maintain compliance with the conditions of this General Order.

j. **Visible Emissions** - No visible emissions from the source are allowed beyond the property line, as determined by 40 C.F.R. Part 60, Appendix A, Test Method 22.

k. **Changes in Operations** - Changes in operation, discontinued operation, or inadequate maintenance plans, may require a new or amended coverage under this General Order.

Authorization may be modified, suspended, or revoked in whole or part for cause, including, but not limited to, the following:

- Violation of any terms or conditions of this authorization.
- Obtaining this authorization by misrepresentation or failure to disclose all relevant facts.

The provisions of this authorization are severable and, if any provision of this authorization or application of any provision to any circumstance is held invalid, the application of such provision to other circumstances, and the remainder of this authorization, must not be affected thereby.

Your Right to Appeal

You have a right to appeal this General Order to the Pollution Control Hearings Board (PCHB) within 30 days of the date of receipt. The appeal process is governed by RCW 43.21B and WAC 371-08. “Date of receipt” is defined in Chapter 43.21B.001(2) RCW.

To appeal, you must do all of the following within 30 days of the date of receipt of this General Order:

- File your notice of appeal and a copy of this General Order with the PCHB (see filing information below). “Filing” means actual receipt by the PCHB during regular business hours as defined in Chapter 371-08-305 WAC and -335. “Notice of appeal” is defined in Chapter 371-08-340 WAC.

- Serve a copy of your notice of appeal and this General Order on the Department of Ecology by mail, in person, or by email (see addresses below).

You must also comply with other applicable requirements in Chapter 43.21B RCW and 371-08 WAC.

Address and Location Information

Filing with the PCHB

For the most current information regarding filing with the PCHB, visit: https://eluho.wa.gov/ or call: 360-664-9160.

Service on Ecology

Street Address:

Department of Ecology
Attn: Appeals Processing Desk
300 Desmond Drive SE
Lacey, WA 98503

Mailing Address:

Department of Ecology
Attn: Appeals Processing Desk
PO Box 47608
Olympia, WA 98504-7608

Email Address:

ecologyappeals@ecy.wa.gov

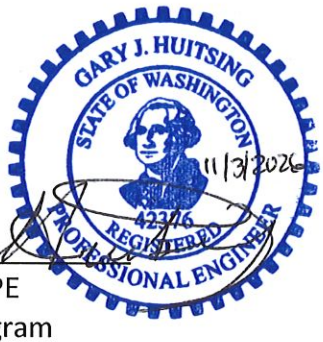
Americans with Disabilities Act Information

Accommodation Requests

To request an ADA accommodation, email aqpubs@ecy.wa.gov, call (360) 407-6800, or dial 711 to call through the Washington Telecommunications Relay for services like text telephone (TTY). Visit Ecology.wa.gov/ADA for more accessibility information.

Dated on November 3, 2026.

Prepared by:



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