

As Built Report Saline Effluent Treatment Plant (SETP) Upgrade

6526-680-132-REP-005

In Accordance with Licence 2AM-MEL1631 Part D, item 1 & 2

Prepared by:

Agnico Eagle Mines Limited – Meliadine Division

November 2021

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1 INTRODUCTION

1.1 SITE LOCATION AND ACCESS

Agnico Eagle Mines Limited (Agnico Eagle) is operating the Meliadine gold mine located approximately 25 km north of Rankin Inlet, and 80 km southwest of Chesterfield Inlet in the Kivalliq Region of Nunavut. The site is located on the peninsula between the East, South, and West basins of Meliadine Lake (63°01'23.8"N, 92°13'6.42"W). The area is accessible from the all-weather gravel road linking the Meliadine mine site with Rankin Inlet.

A general location of the SETP for the project is shown in Figure 1.

1.2 SITE FACILITIES

The current mine plan focuses on the development of the Tiriganiaq gold deposit which will be mined using both conventional open-pit and underground mining operations. Current mining facilities to support the Mine include a plant site and accommodations, tailings storage facility, waste rock storage facilities, ore storage pads, process plant, power plant, maintenance facilities, water management plants and supporting infrastructures.

Such infrastructures include water retention dikes, berms, culverts, channels, collection ponds, pumping stations, freshwater intake and water treatment plants are required to manage water during pre-production, operation, and interim mine closure. In 2019, the Saline Effluent Treatment Plant (SETP) was built to provide saline water treatment prior to discharge to Melvin Bay

To support the water management plan and to improve the treatment plant performance and reliability, upgrades to the SETP were required. The upgrades were completed within the same building as in 2019. No additional buildings were added to the existing facilities constructed in 2019.

1.3 PURPOSE OF DOCUMENT

As required by the Water License A (No. 2AM-MEL1631), this report summarizes the construction and commissioning work associated with the Saline Effluent Treatment Plant (SETP). Included in this report are:

- A description of the Process;
- Documentation on field decisions that deviate from the original plans;
- Building location; and
- Photographs.

The SETP equipment upgrade integrates the following components:

- Conversion of the lamella clarifier tank into a sand ballasted clarifier;
- Upgrade of chemical dosing skids for polymer, coagulant, sodium hypochlorite and caustic;
- Increase of chlorination tanks volume;
- Upgrade of dechlorination filters;
- Upgrade of pumps and piping;
- Upgrade of instrumentation; and
- Addition of an acid dosing skid to control pH.



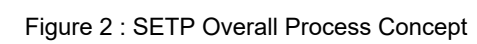
Figure 1 : General location plan

2 PROCESS DESCRIPTION

2.1 SETP SUMMARY

The Raw water feeding the SETP is pumped to be treated, first for TSS in an Actiflo® clarifier. The treated water overflows into a chlorination reactor where ammonia is oxidized into nitrogen gas by hypochlorite injection. The treated water from the Actiflo can also bypass the chlorination tank if necessary. The gasses generated by the chlorination treatment are vented to the atmosphere outside of the plant. Excess chlorine in the water is removed by granular activated carbon filters (GAC). The pH of the treated water is adjusted before discharging to the Saline Pond 3 (SP3). From SP3, the water is pumped into tanker trucks, transported to Itivia, and discharged to Melvin Bay through the diffuser. If treated water quality does not meet the desired criteria, water will be recirculated in Saline Pond 1 (SP1), instead of entering SP3.

The treatment concept is presented in Figure 2. The P&ID can be found in Appendix A.



2.2 ACTIFLO®

The main modification between the Multiflo® and Actiflo® units is the addition of two microsand recirculation circuits (one operating, one standby). Those circuits are designed with a recirculation pump and a hydrocyclone. A sludge recirculation tank is also added to control the sludge volume sent for disposal. Additional chemical skids are also required to meet the chemical requirement once the flow capacity is increased.

Actiflo® are sand-ballasted settling units with a high-rate coagulation/flocculation/sedimentation process that utilizes microsand as a seed for floc formation. The microsand provides a surface area that enhances flocculation and acts as a ballast or weight. The resulting floc settles very fast, allowing for compact clarifier designs with high overflow rates and short retention times. The use of microsand also permits the unit to perform well under changing flow rates without impacting final effluent quality.

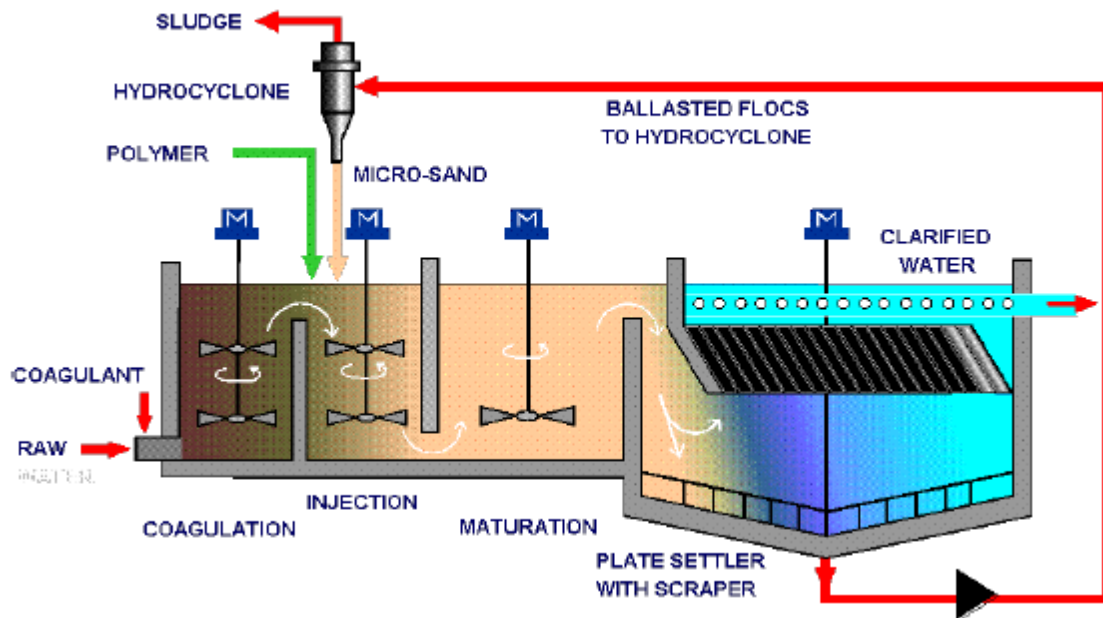


Figure 3 : Actiflo® Process

The slurry flows to the first basin, the coagulation chamber, where the reaction is optimized. The aluminum-based coagulant forms a floc of aluminum hydroxide ($\text{Al}(\text{OH})_3$) which acts as a bridge to tie colloidal particles together. The coagulated water then overflows to a second tank section called the injection tank. There, the microsand and flocculent aid polymer are added. The microsand provides a large contact area for floc attachment and acts as ballast, thereby accelerating the settling of the flocs. The flocculent aid polymer binds the destabilized suspended solids to the microsand particles by forming polymer bridges. From the injection tank, the water underflows to a third tank section called the maturation tank. In this section, the microsand and sludge flocs agglomerate and grow into high-density flocs known as microsand ballasted flocs. From the maturation zone, the water overflows to the settling section of the tank. In the settling zone, the microsand ballasted flocs settle quickly to the bottom of the unit. In the settling zone, the settling efficiency is further increased by the use of the lamella tubes. The

clarified water exits the system via a series of collection troughs or wires. The clarified water is monitored for turbidity.

The sand-sludge mixture settles to the bottom of the clarifier. Scrapers force the sludge collected at the bottom of the clarifier into a central cone from which is continuously withdrawn and pumped to a hydro cyclone where the sludge and microsand are separated by centrifugal force. After separation, the higher density microsand is discharged from the bottom of the hydro cyclone and reinjected into the process for reuse. The lighter density sludge is discharged from the top of the hydro cyclone and directed to the sludge storage tank and recirculated into the coagulation chamber or to the sludge storage location. A solid percentage of 2% is expected in the sludge tank purge.

2.3 BREAK POINT CHLORINATION

The water is then sent to two new reaction tanks in series where hypochlorite solution and an alkali (mix of NaOH/KOH) is added. The hypochlorite (ClO^- , chlorine) is a compound added to oxidize the ammonia (NH_4^+) into nitrogen (N_2) and nitrates (NO_3^-). The quantity of hypochlorite added is a function of the concentration of nitrites (NO_2^-) and ammonia concentration in the raw water. The chlorination tanks are agitated by recirculating water through eductors within each tank.

The hypochlorite solution injected in the water produces hypochlorous acid (HOCl). The hypochlorous acid is a weak acid, and part of the hypochlorous acid is decomposed in water into hypochlorite ions (ClO^-), depending on the pH of the water. The pH can be adjusted to optimize the chlorine dosage using the alkali. An addition of sulfuric acid is possible in the second reactor for pH adjustment if required.

The hypochlorous acid and hypochlorite ions in solution will first be consumed by reducing agents and organic matter contained in the water. When more chlorine is added in solution and there is a presence of ammonia, the ammonia will react to form chloramines, specifically monochloramines (NH_2Cl). When the quantity of chlorine is sufficient, the monochloramines will be destroyed, and depending on the concentration, will be transformed into dichloramines (NHCl_2) or trichloramines (NCl_3) and then finally into nitrogen (N_2). If the quantity of chlorine injected is sufficient, a breakpoint is reached where all chloramines and ammonia are converted into nitrogen.

2.4 CARTRIDGE FILTRATION

Before being fed to the GAC filter, water is filtered through three cartridge filters which can be operated in parallel or in series. These filters will vary in hole size (from 5 μm to 50 μm) depending on the operation requirement. This step limits the clogging risk within the GAC filter.

2.5 GRANULAR ACTIVATED CARBON (GAC) FILTER

The water will then be pumped to four lines of two pressure filters filled with Granulated Activated Carbon (GAC) which can be operated in series or in parallel. As a result of the pressure from the pump, the water is forced to pass through the filters where it is exposed to the GAC, removing residual chlorine and chlorine byproducts. The filtered water is then monitored for total chlorine.

The activated carbon specifications are 12x40 SAW (Acid washed, Continental Carbon) and possesses a capacity of chlorine removal higher than required for summer operation of the SETP (no requirement to change the GAC during the operating season). The carbon is considered as a consumable.

2.6 PH ADJSUTMENT TANK

Treated waters (both from GAC filters and Actiflo) flow into the pH adjustment tank where pH is adjusted. Sulfuric acid is used for pH adjustment in this reactor.

2.7 POLISHING FILTRATION

A polishing filtration is implemented prior to filling up the tanker used for transportation of treated water to the final discharge location. To do so, five filtration vessels are placed in parallel between the pumps located in SP3 and the truck loading station. Mesh of the filter is optimized in the field depending on operation consideration, but 10 um is expected to be used most of the time.

2.8 REAGENTS

The following reagents will be used at the SETP:

- Coagulant: Hydrex 6240 (Veolia) or equivalent
- Anionic polymer: Hydrex 6105 (Veolia) or equivalent
- Caustic blend: Hydrex 9501 (Veolia) or equivalent
- Actisand (Veolia) or equivalent
- Sodium hypochlorite 12%
- Sulfuric Acid 93%

2.9 SERVICE WATER SYSTEM

The service water system consists of two multimedia filters in parallel (one operating, one standby), one heater, one filtered water tank and one service water pump. Service water is used for polymer makeup system and for on-line polymer dilution. Contact water is used to produce service water. Depending on the quality of the contact water, the multimedia filters can be bypassed.

3 CONSTRUCTION AND COMMISSIONINGSUMMARY

3.1 CONSTRUCTION SCHEDULE

The construction upgrade and commissioning of the SETP was initiated in June 2020 and the ended in August 2021. Activities were completed according to the milestone dates shown in Table 1.

Table 1: Construction and Commissioning Milestone

Activities	Timeline
Start Construction	June 1 st 2020
End of commissioning Actiflo	August 3 rd 2020
All main equipment in place	December 31 st 2020
End of commissioning Break Point chlorination	August 19 th 2021
End of process commissioning & construction (piping completion and modification completed)	August 19 th 2021

3.2 FIELD DECISIONS THAT DEVIATE FROM ORIGINAL DESIGN

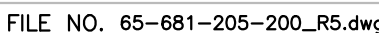
No major variation from the original design were noted during the construction and modification of the SETP. Minor piping modification occurred to adjust to the field situation. A recirculation line from the GAC filters to SP1 was installed to commission the system.

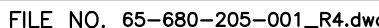
3.3 AS BUILT DRAWINGS AND PHOTOGRAPHS

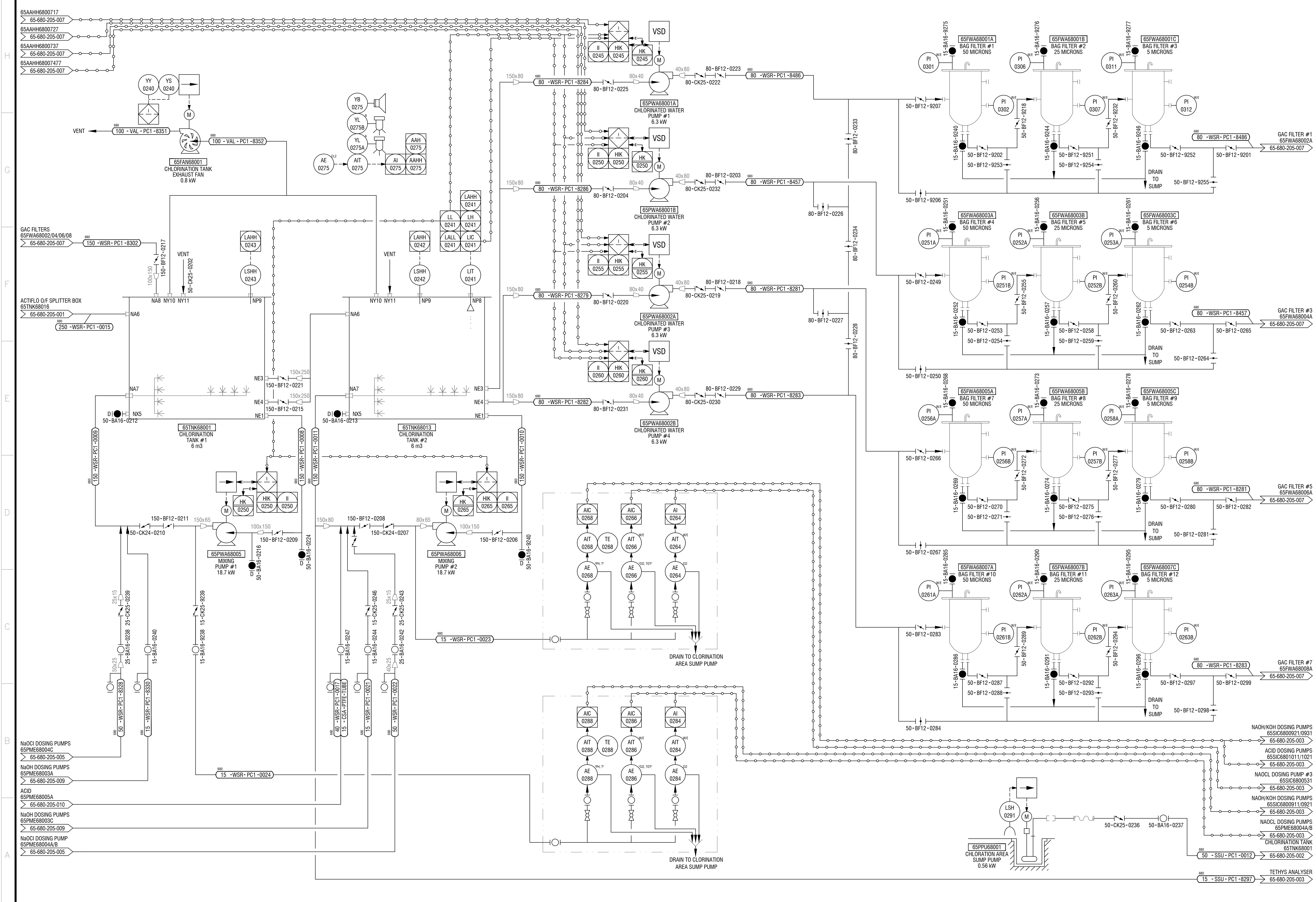
As-built documentation is presented in Appendices A and B:

- As Built Drawings;
- Photographs.

APPENDIX A – As built drawings







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KEY PLAN

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AS BUILT

DATE : 2021-07-15

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1 2019-07-31 AS BUILT S.P. E.L.

0 2019-04-11 ISSUED FOR CONSTRUCTION S.P. E.L.

A 2019-03-21 PRELIMINARY J.L. S.P.

REV. DATE DESCRIPTION DWG/REV APP. CLIENT

REVISIONS

TITRE / TITLE
AGNICO EAGLE - MELIADINE DIVISION
680 - SALINE EFFLUENT TREATMENT PLANT
205 - PIPING & INSTRUMENTATION DIAGRAM
CHLORINATION TANKS

DESSINÉ PAR
DRAWN BY JONATHAN LAVOIE DATE 2019-03-21

VERIFIÉ PAR
CHECKED BY SÉBASTIEN PERRON 2019-03-21

APPROUVÉ PAR
APPROVED BY ÉRIC LAVOIE, P. Eng. 2019-04-11

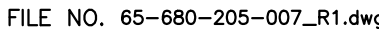
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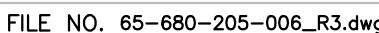
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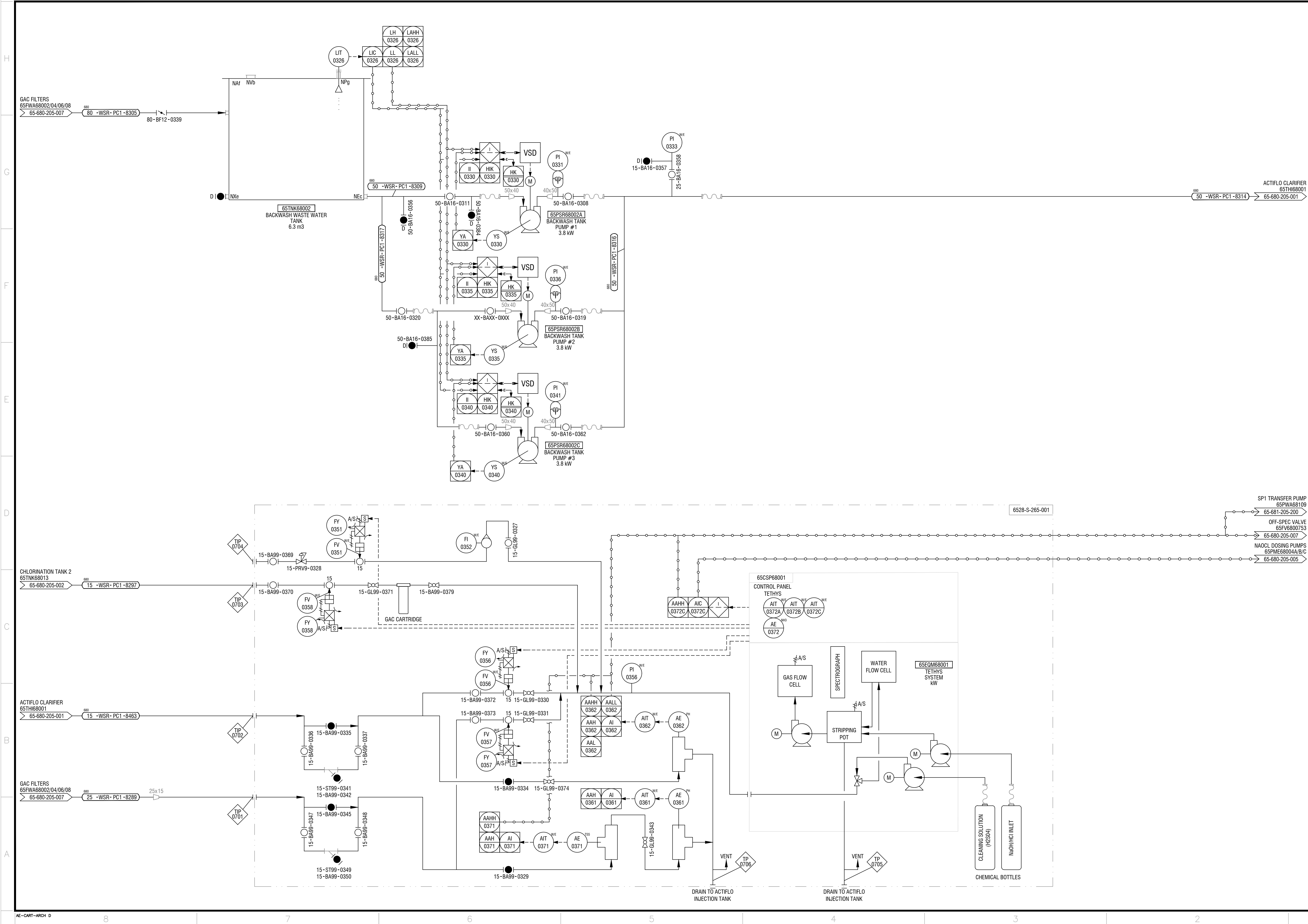
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PROJECT NO. 6526

REVISION 3

FEUILLE / SHEET 1 / 1







PLAN CLE
KEY PLAN

NOTES GÉNÉRALES / GENERAL NOTES

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T. GENTY
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L4751
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OFF-SPEC VALVE 65FV6800753	---
65-680-205-007	---
NAOCL DOSING PUMPS 65PME68004A/B/C	---
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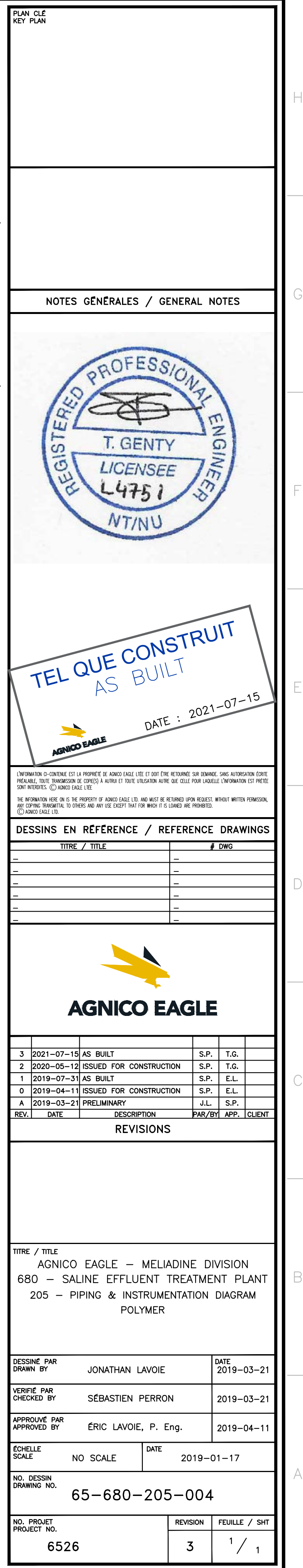
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680 - SALINE EFFLUENT TREATMENT PLANT
205 - PIPING & INSTRUMENTATION DIAGRAM
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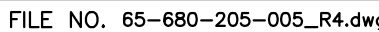
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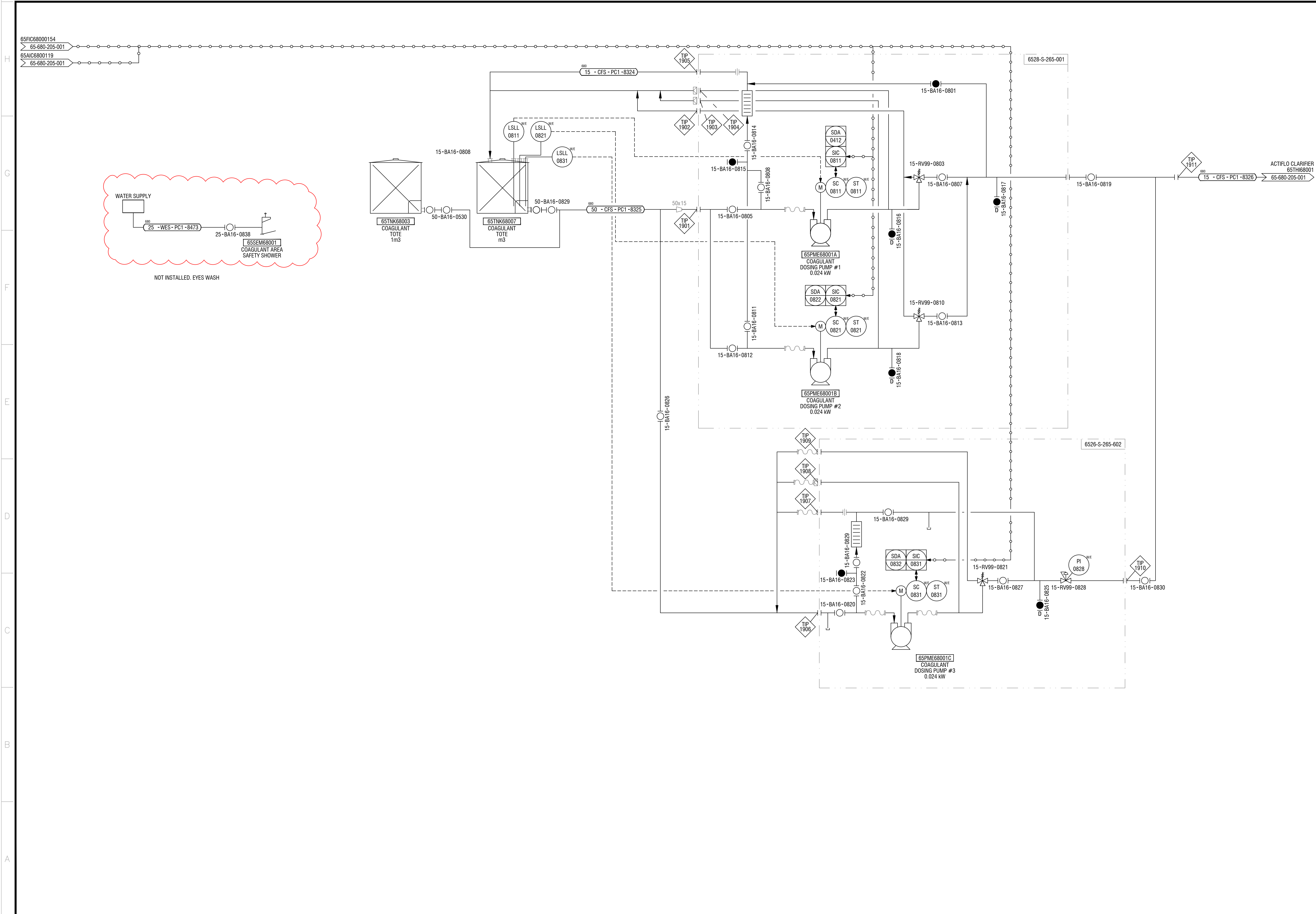
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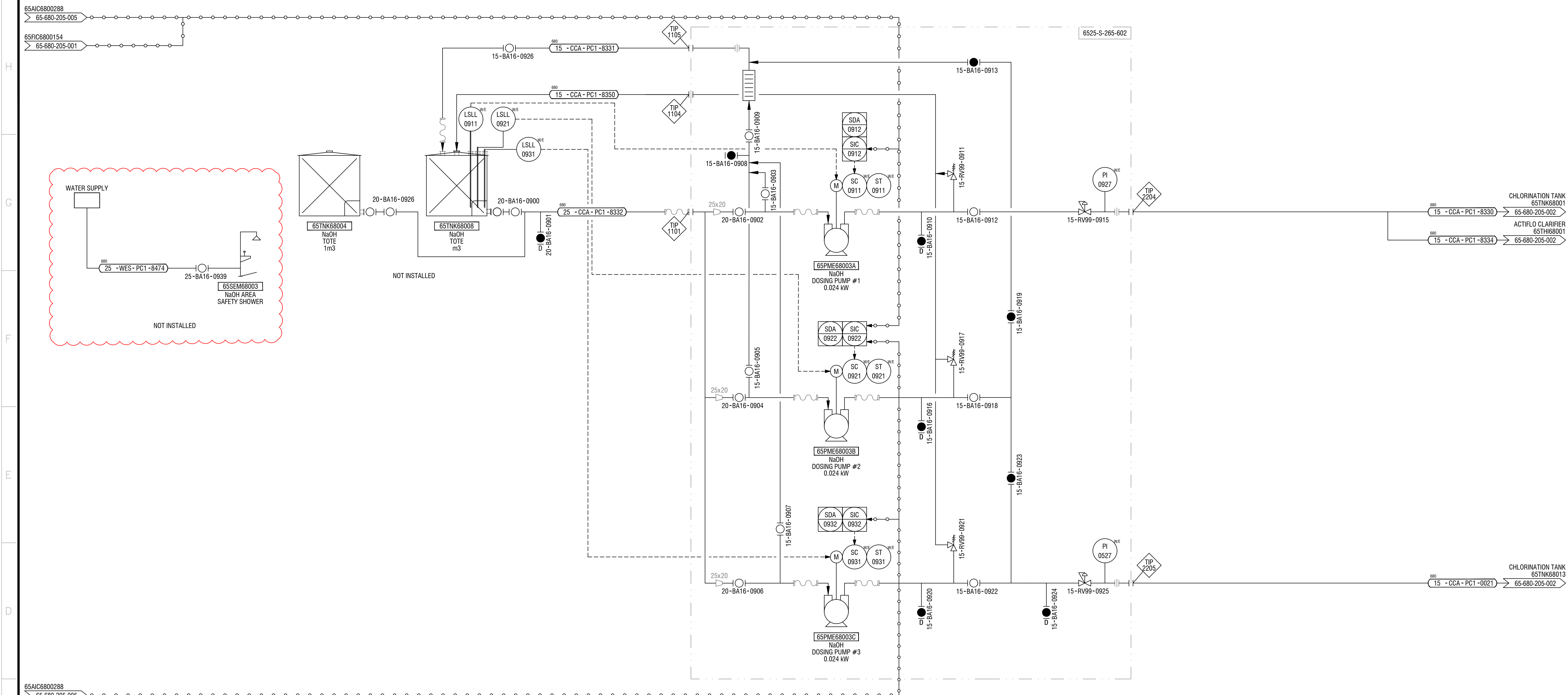
TITRE / TITLE
AGNICO EAGLE - MELIADINE DIVISION
680 - SALINE EFFLUENT TREATMENT PLANT
205 - PIPING & INSTRUMENTATION DIAGRAM
COAGULANT

DESSINÉ PAR DRAWN BY	DATE 2020-05-12
SÉBASTIEN PERRON	
VERIFIÉ PAR CHECKED BY	DATE 2020-05-12
ÉRIC LAVOIE, P.Eng.	
APPROUVÉ PAR APPROVED BY	DATE 2020-05-12
THOMAS GENTY, P.Eng.	

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NOTES GÉNÉRALES / GENERAL NOTES

CHLORINATION TANK
65TNK68001

ACTIFLO CLARIFIER
65THI68001

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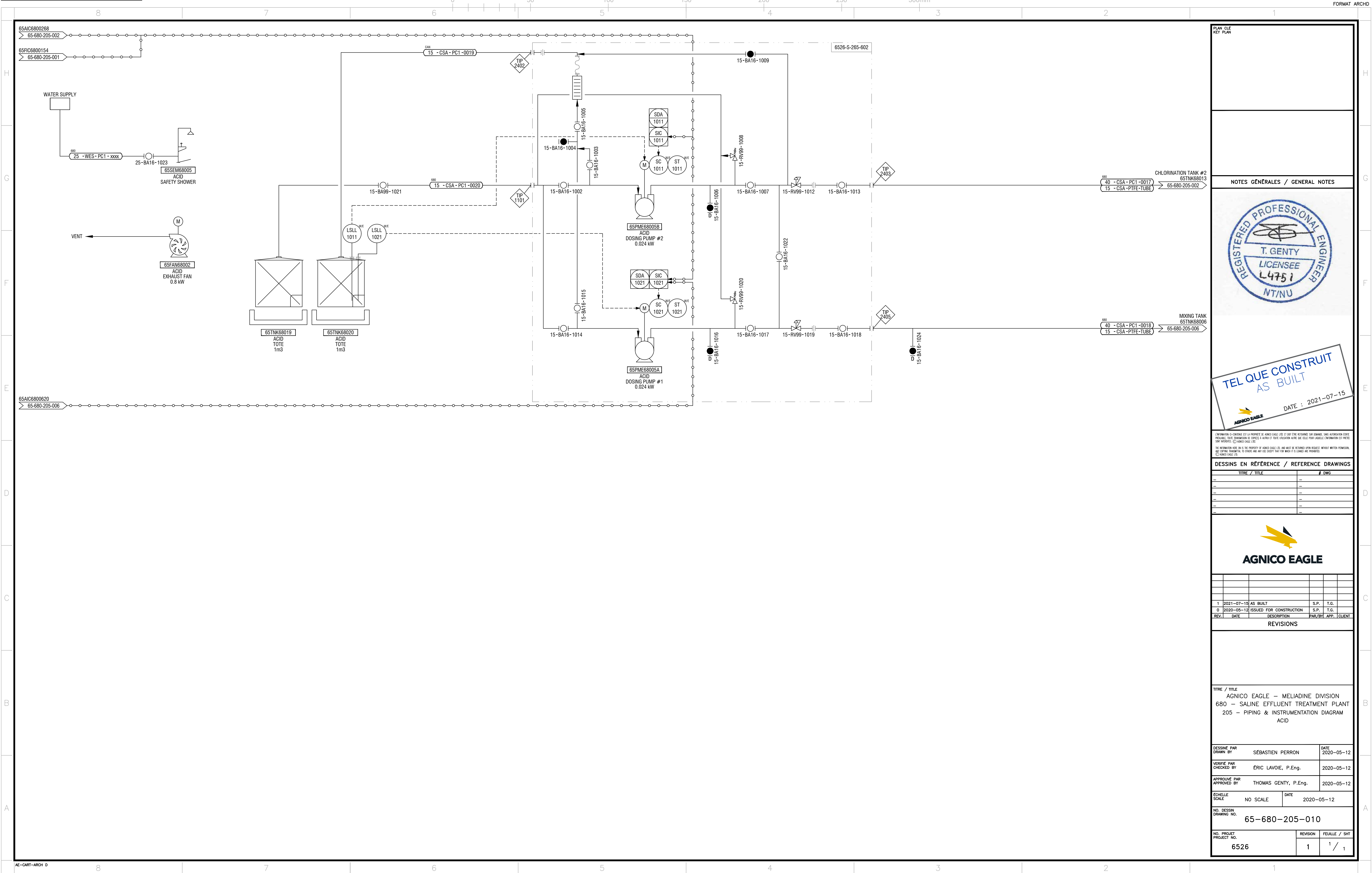
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680 - SALINE EFFLUENT TREATMENT PLANT
205 - PIPING & INSTRUMENTATION DIAGRAM
NaOH/KOH

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APPROUVÉ PAR APPROVED BY	2020-05-12
THOMAS GENTY, P.Eng.	
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DESSINS EN RÉFÉRENCE / REFERENCE DRAWINGS

TITRE / TITLE		#	DWG
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TITRE / TITLE		DATE			
1	2021-07-15 AS. BUILT	S.P.	T.G.		
0	2020-05-12 ISSUED FOR CONSTRUCTION	S.P.	T.G.		
REV.	DATE	DESCRIPTION	PAR/BY	APP.	CLIENT
REVISIONS					

TITRE / TITLE
AGNICO EAGLE – MELIADINE DIVISION
680 – SALINE EFFLUENT TREATMENT PLANT
205 – PIPING & INSTRUMENTATION DIAGRAM
ACID

DESSINÉ PAR DRAWN BY		DATE	
SÉBASTIEN PERRON		2020-05-12	
VÉRIFIÉ PAR CHECKED BY		DATE	
ÉRIC LAVOIE, P.Eng.		2020-05-12	
APPROUVÉ PAR APPROVED BY		DATE	
THOMAS GENTY, P.Eng.		2020-05-12	
ÉCHELLE SCALE		DATE	
NO SCALE		2020-05-12	
NO. DESSIN DRAWING NO.			
65-680-205-010			
NO. PROJET PROJECT NO.		REVISION	FEUILLE / SHIT
6526		1	1 / 1

Appendix B - Pictures



Actilfo



Recirculation pumps



Splitter box and
chlorination
reactors



Bag Filters





GAC Filters

Treated water sea can





Treated water tank



Coagulant dosing Skids



Polymer makedown and dosing skid



Caustic dosing Skid



Acid dosing skid



Hypochlorite dosing skids



Process water tank and filters