

NEWS



A Direct Path to Compliance

Impact of EPA's Boiler MACT in the United States Market

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Receives First U.S.
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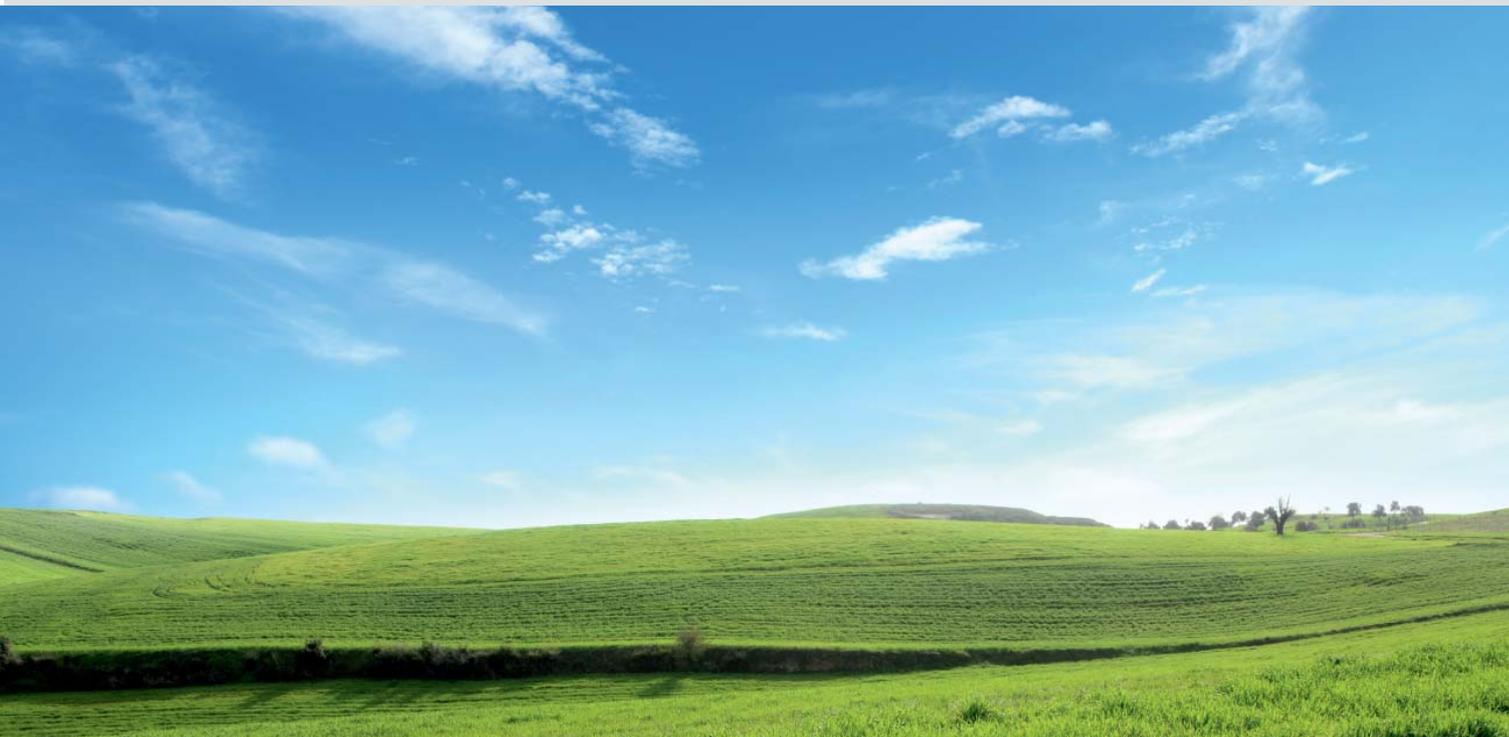
Welcome to our new designed newsletter of Clyde Bergemann Power Group with the look at the industry's big new stories for the global energy market. With our cover story "A Direct Path to Compliance" we are facing major challenges in the upcoming years. The main targets of today's environmental policy are the secure and sustainable energy supply.

The EU regulations are much publicised as "Energiewende" and the U.S. regulations as the new Mercury and Air Toxics Standards (MATS). Clyde Bergemann Power Group offers a comprehensive product portfolio to help your plant to meet all the stringent new regulations. We are a single source provider to address all emission control requirements in a cost-effective way. One of the biggest recent success story has been a \$180 Million contract for air pollution control equipment from a major U.S. Utility to achieve EPA MATS Rule Compliance.

Franz Bartels | President & CEO

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Impact of EPA's Boiler MACT in the United States Market

Industrial Boiler MACT (IB MACT) is a pending U.S. regulation that will limit hazardous air pollutant (HAP) emissions from industrial, commercial, and institutional power boilers, including carbon monoxide, acid gases, mercury, and particulate matter.

The rule has been submitted to the Office of Management and Budget by the Environmental Protection Agency (EPA), and is expected to be published as a final rule in the Federal Register later this year.

The rule impacts nearly 15,000 industrial, commercial, and institutional boilers. However, Clyde Bergemann Power Group Americas' (CBAM) primary target will be the 1,000 solid fuel-fired industrial boilers. The other 14,000 boilers include 13,000 natural gas fired units that will require annual or biennial tune-ups only, and another 1,000 liquid fired units that may require acid gas and particulate control. Further breakdown of the solid fuel boilers indicates about a 50:50 split between biomass fired and fossil fuel fired units. CBAM is unique in its capability to offer a single source solution for all the HAPs this rule is addressing, i.e. single source solution, single source guarantee.

The EPA estimates the capital cost of implementing this rule at \$3 Billion to \$4 Billion,

whereas consultants for CIBO (Council of Industrial Boilers Owners) and AFPA (American Forest Products Association) estimate the market to be much larger – \$12 Billion to \$14 Billion for all boilers impacted. The solid fuel boilers account for roughly half of this estimate. A large discrepancy in this cost includes differences in control technology installed cost, plus ancillary equipment that will be installed with these upgrades. Typical add-ons include upgrading fuel feeders/stokers, fuel processing equipment, auxiliary burners, control system upgrades, and ash handling systems. CBAM evaluates all these value added opportunities with each installation, and also promotes upgrading/replacing outdated sootblowing systems with Clyde Bergemann's SMART Clean systems.

A key distinction between industrial boilers and utility boilers is the "pecking" order of capital expenditures. Modern utility boilers are the target of capital budgets and are very precisely controlled and maintained. Industrial boilers, on the other hand, take the

back seat in terms of capital which is typically allocated to modernize production facilities, thereby resulting in poorly controlled and maintained boilers. The modernization of this fleet will not only bring the boilers into compliance with the regulation, but will also improve the efficiency of the combustion operations.

Clyde Bergemann Hanover (CBHAN) was recently awarded a contract for a Stacked Air System (SAS) for carbon monoxide (CO) control at a Boise Cascade Plywood Facility. The boiler is a 100 kpph biomass fixed grate stoker burning primarily bark with supplemental firing via a sanderdust burner.

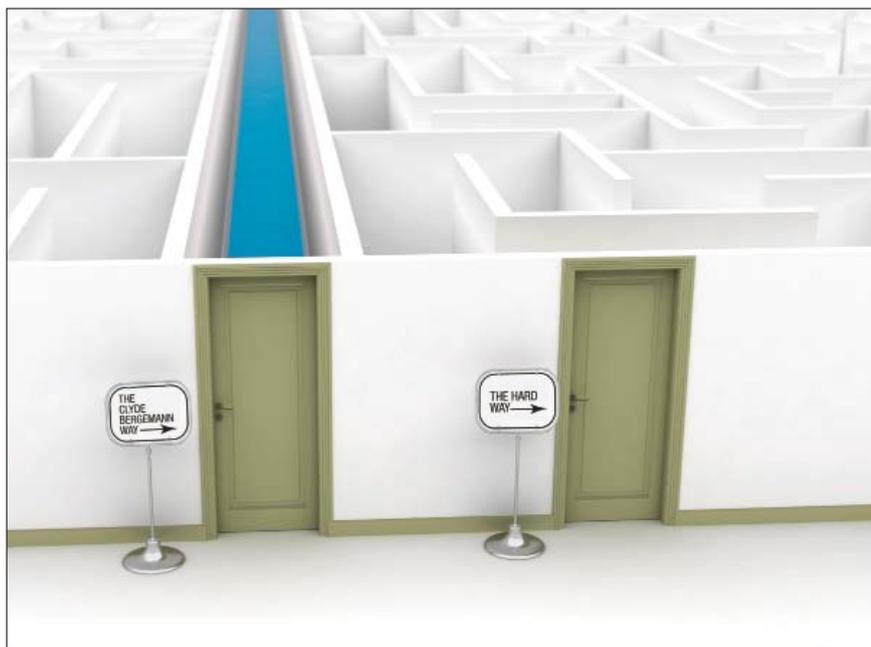
In addition to the air system, CBHAN will be utilizing Clyde Bergemann Malvern to provide bottom ash handling equipment to improve reliability and eliminate tramp air leakage to the boiler, which can short-circuit



combustion air control. Clyde Bergemann Atlanta will be providing the controls required for the new air system. Further, installation will be performed by CBHAN's construction group with the start-up scheduled for December.

The Boise Cascade contract is CBAM's first IB MACT compliance order and will be our first stacked air system on a biomass fired boiler in the U.S. Many lumber products facilities have similar sized and configured boilers and are prime targets for CO control. This boiler is small compared to large utility boilers, but this size is common in the wood products industry, which makes up approximately 25 % of the targeted IB MACT market. The IB MACT environmental regulations create a very large growth opportunity for the CBAM collective companies, particularly in the areas of combustion optimization for CO control; sorbent injection systems for acid gas and mercury control; and particulate control via electrostatic precipitators and fabric filters.

To ensure CBAM maximizes on being the single source solution and meets customer needs, a task force was formed last year targeting the IB MACT regulation. The IB MACT Task Force includes representation from several key areas in the organization. The members are: Edmundo Vasquez (Combustion Optimization), James Fisher (Sorbent Injection), Dennis Shanahan (Particulate Control), Nichole Douglas (Regional Sales), Stacy Gentry (Marketing), and Mark Miller (Business Development and Task Force Chair).



A Direct Path to Compliance

Getting through all the new Utility Boiler MACT and Cross State Air Pollution requirements can be disorienting or even catastrophic. Clyde Bergemann Power Group offers a streamlined solution to get you completely through this maze of levels, dates and regulations. Let us make it easy for you.

Clyde Bergemann Power Group offers a single source compliance solutions guarantee. With over 60 years experience and hundreds of installations across all industries, we are the single source to address your emission control requirements on an equipment-only or full turnkey basis. Let us help you optimize capital, maximize the value of operating and maintenance expenses, while meeting required emission standards.

Call 1.888.882.2314 or email info@us.cbpg.com
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Clyde Bergemann Power Group Americas Receives First U.S. Major Utility's Order to Achieve EPA MATS Rule Compliance

Clyde Bergemann Power Group Americas (CBAM), part of global Clyde Bergemann Power Group (CBPG), has recently been awarded a \$ 180 Million contract for air pollution control equipment from a major U.S. Utility.

CBAM will engineer, supply and commission a total of twelve Pulse Jet Fabric Filters for particulate control, twelve Powder Activated Carbon Injection systems for mercury mitigation and six dry sorbent injection systems for sulfuric acid mist mitigation for twelve coal fired boilers with a combined 5,000 MW of generating capacity.

This order makes CBAM the leading supplier of fabric filters and dry sorbent injection systems to U.S. power plants for compliance with the Environmental Protection Agency's (EPA) new Mercury and Air Toxics Standards (MATS). The MATS rule will require existing power plants to meet reduced emissions of toxic air pollutants such as mercury, particulate matter, and acid gases.

"We are very pleased with receiving this important order" said Hans Schwade, CBAM President and CEO. "CBAM's comprehensive offerings of emissions control solutions and our highly talented team allowed us to meet



all of this important project's requirements. We look forward to a continued, mutually beneficial project together with our customer."

Engineering work for the project has already begun with material delivery scheduled to start in spring of 2013. Fabrication will take place in Clyde Bergemann's new 165,000 square foot plant in Jesup, GA where the

company will generate some 70 new jobs. More detailed information about this new facility will be forthcoming in a separate press release.

Franz Bartels, CBPG President and CEO congratulated the CBAM team and said "This is a major success for the entire Clyde Bergemann Power Group. The order confirms our

strategy to invest heavily into innovative air pollution control technologies and people in the U.S. market as well as expand domestic manufacturing."

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Coletto Creek PSI Testing

Clyde Bergemann Atlanta has been working with various clients in the reduction of flue gas emissions in coal fired power generating facilities.

Additional reductions in emissions are required to comply with new proposed U.S. clean air standards. Clyde Bergemann Americas is utilizing the injection of dry sorbents directly in to the flue gas stream. The testing program consists of bringing Clyde Bergemann's test equipment to a customer's facility, injecting different sorbents at varying loads, and measuring the reduction of pollutants at a customer's specific facility. After completion of the test program Clyde Bergemann will provide the customer with a detailed report of the results along with recommendations for future changes in the facility. Clyde Bergemann can also provide permanently installed systems as a solution to our clients' long term needs.

After a stellar effort by the Clyde Bergemann Atlanta shop, supported by engineering and

other groups in various locations, in building the two Portable Sorbent Injection (PSI) equipment trains, the equipment was shipped to Coletto Creek Power Generating Facility in Fannin, Texas. Fannin is located approximately 90 miles north of Corpus Christi, Texas.

The service group arrived on site with the equipment and proceeded to connect the Clyde Bergemann test rigs to the client's boiler ductwork. The actual testing began on the client's desired start date of July 9. Testing included use of 3 different sorbents, trona, sodium bicarbonate, and hydrated lime at varying plant loads. Clyde Bergemann had personnel on site 24 hours per day for the full test period. Actual testing occurred at night with day shift workers making system modifications and preparations for the subsequent evening's scheduled testing.

The total effort from building the units on an arduous schedule all the way through the completion of testing was a complete success. The client is very pleased with the performance of our team and they are pleased with the initial indications that the testing data represents. Preliminary information from the test data indicates removal of approximately 70% of the target acid gas components in the flue gas at full station load. A final report will be submitted in the next couple of weeks to the client including our recommendations.

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▶ PSI Test Equipment in place for the test program



▶ Spiders and hoses at nozzle injection location

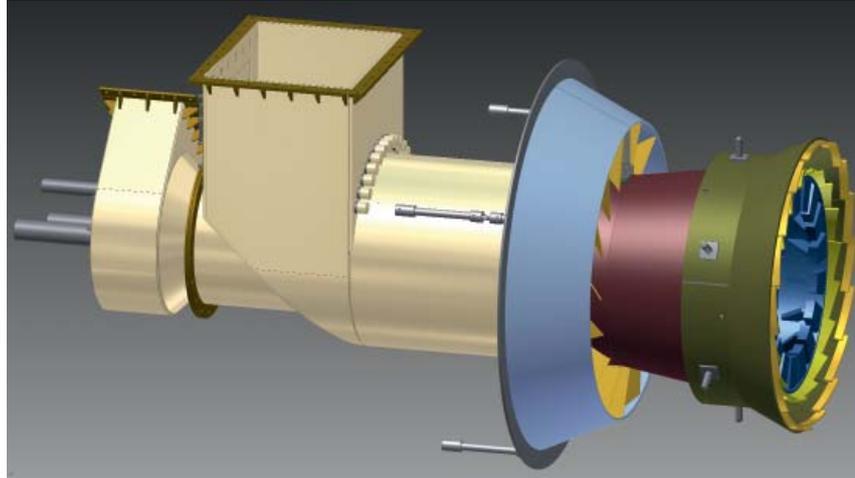
Low NOx Burner Modification in China

In "The 12th Five-Year Plan", the China government has established stringent regulations for NOx emissions.

It is required that from Jan 1st of 2012 the NOx emission for newly built power units should reach $<100 \text{ mg/Nm}^3$, and the existing units should reach $<100 \text{ mg/Nm}^3$ before July 1st of 2014. Compare to pure SCR gas treatment behind the boiler, the "SCR plus LNB (Low NOx Burner) modification" DeNOx technique is more economical and popular. Hence the modification of Low-NOx firing system has become a new business opportunity in China and it would be a possible good entry point of the retrofitting market for Clyde Bergemann.

In order to grasp this business opportunity, in May of 2012, Clyde Bergemann has received the authorization of LNB license (for opposed firing boiler) from Steinmüller Engineering GmbH, a subsidiary of Siemens AG in Germany.

In June of 2012, the 1st technical training about LNB design principle for the engineers from Clyde Bergemann Shanghai has been finished in Gummersbach of Germany where Steinmüller Engineering GmbH is located. The 2nd training about Low NOx firing system detail design and project execution will be conducted within this year. Marketing and technical preparations are now simultaneously conducted.



▶ Side section of Low NOx Burner to meet emission requirements

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Clyde Bergemann Receives Third Order for Modernisation of the Russian 1.148 MW Coal-Fired Power Plant Berezovskaya GRES



Since 2010 the coal-fired power plant Berezovskaya GRES has been modernized within the scope of an investment programme of E.ON Russia (formerly Großerzeugergesellschaft OGK 4). At 2 of 3 thermal power units, Clyde Bergemann has already installed high-quality boiler cleaning systems, 2 x 800 MW, to the perfect satisfaction of all involved parties. The further order for the new unit, 1 x 800 MW, is an important step to forcefully grow the business in the Russian market.

The scope of delivery of this state-of-the-art power plant solution consists of 14 SMART CANNON water lance blowers, the optimizing system SMART Furnace-FACOS and sootblowers (RK series) for the superheater. The main cleaning principle, using water as factor of success, has globally proven itself as an efficient method to clean the combustion chamber. The results are very convincing due to the intelligent analyses of the slagging and - based thereupon - the optimized, targetted boiler cleaning. This project underlines the trend to use state-of-the-art technique in regard to efficiency and environmental issues.

The projects general contractor is the Russian company "Energoprojekt". The contract was signed during POWER-GEN Europe 2012.

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Waste Heat Recovery Solutions for the Brazil Offshore Oil and Gas Production Using the Global Clyde Bergemann Power Group Supply Chain

Clyde Bergemann Australia (CBA) secured an order in April 2012 from SBM Offshore in The Netherlands for the supply of Three Waste Heat Recovery Units (WHRU) for a Floating Production Offloading and Storage (FPSO) vessel to be located in Brazil waters. This order brings the total number of WHRU's supplied to the FPSO market to 27 in only four years.

The difference in this new order is the value add three Clyde Bergemann Power Group (CBPG) companies offer to the customer. CBA is the centre of competence for ER products and will design, engineer and project manage the contract from Sydney. Clyde Bergemann Shanghai (SCB) will manufacture the pressure parts (Steel 'H'® finned tubing) required for the contract in China and Clyde Bergemann do Brazil (CBdB) will project manage the remaining components of the WHRU which include inlet and outlet casings, silencers, expansion joints and dampers to be manufactured in Brazil.

The ability to supply this solution is due to CBA and CBdB working together for the past year to develop a process of manufacture that satisfies Brazil local content laws.

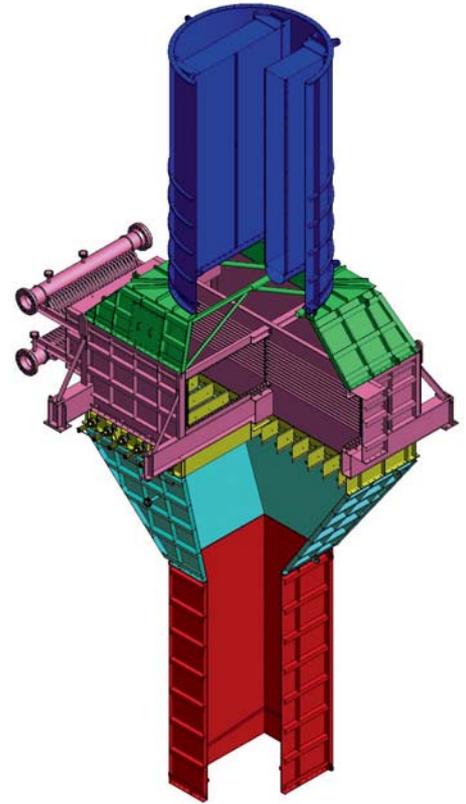
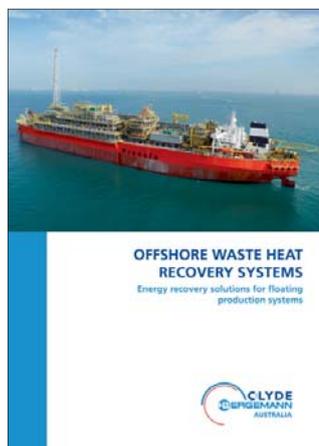
The FPSO is called Cidade de Ilhabela and will operate in an oil field owned by Petrobras. Petrobras currently has the highest planned growth rate when compared to all supermajors (Exxon Mobil, BP, Shell and Chevron). From 2010 until 2014 Petrobras plans to invest up to US\$224 Billion to strengthen its market position. Of the US\$224 Billion 95% will be invested in local Brazil projects. This project is strategically very important to demonstrate to Petrobras that CBPG can supply ER solutions locally in Brazil.

The WHRU's will be delivered in December 2012 and were selected due to a number of advantages over CBA's competitors. CBA WHRU has an integral bypass which reduces the footprint required for installing a WHRU on an offshore vessel. The heating surface is made from a robust Steel 'H'® surface. CBA can also supply all the required equipment from outlet of the gas turbine exhaust

flange to the top of the WHRU stack making it less complex for the customer to manage a single contract for supply of these components.

CBA General Manager Sales & Marketing, Gerard Grant, comments: "It was the ability of the CBPG group companies to work together to develop a superior commercial manufacturing solution that satisfied not only local content rules in Brazil but kept critical elements within the process under CBPG control. CBA, SCB and in particular local development work carried out by CBdB made it possible to ultimately not only win this order but lay a foundation to ensure CBPG is well positioned in Brazil to share in the huge growth potential the offshore Brazil oil and gas market offers".

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An updated **brochure** of the Offshore Waste Heat Recovery Systems by Clyde Bergemann Australia has just been released.

Clyde Bergemann Poland Awarded a Contract from GdF Suez Energia

In June 2012 Clyde Bergemann Polska (CBP) was awarded a contract from GdF Suez Energia Polska for delivery of sootblowers and water cannons installations for 7 x 225 MW coal and biomass fired units at Polaniec PS, Poland.



It is the biggest contract ever in CBP history with a value of 23,4 Million PLN (5,7 Million EUR) and the job will be executed within 2012-2014 with option for 2015.

The contract includes complete, turn-key delivery and erection of on-load boiler cleaning installations and is a result of a long, successful development of cooperation between CBP and Polaniec PS since the 90's.

The CBP job is a part of a big modernization project called "Phoenix" with a budget exceeding 1,0 bln PLN, which includes apart of boiler cleaning installations also turbines upgrade, pressure part replacement and SCR installations.

The "Phoenix" project should extend the lifetime of the 33 years old Polaniec PS for another 20 years.

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TeenTech Event by Clyde Bergemann Doncaster

Clyde Bergemann Doncaster took part in a national technology event at Doncaster Racecourse on 10th July designed to inspire teenager students to what the world of technology, engineering and science has to offer.

The "TeenTech" event utilised local and national companies to offer students a range of interactive experiences through events which are relevant, up to date and alert them not only to the career opportunities that exist in science, engineering and technology but to the skills they require to embark on such career.

Aida Hidalgo and Daniel Young from CBD prepared and presented a pneumatic conveying challenge for the event; the students were required to build the best possible pipe route around set obstacles to convey material successfully into a reception silo. Using straws, rubber bends and couscous as conveying material the winner would achieve the highest mass transfer in five minutes. Results appeared on a score board for all to see!

The students were given different real life roles designing, installing and commissioning their system. During this experiment, they could experience similar problems our engineers face in the real world, from pipe blockages through to organisational and interpersonal issues.

As well as the basics of pneumatic conveying, the students learned that through teamwork and cooperation they could achieve the best results by combining their ideas and then together making their design work! The challenge succeeded to show that science can be fun, inspiring our engineers of the future and further raising CBD's profile in the community.

More information about the TeenTech Event can be found at www.teentechevent.com



► TeenTech collaboration – Young students get the opportunity to experience and to find the best technical solution

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Clyde Bergemann Termotec Continues to Grow

The Air-Cooled Condenser team of Clyde Bergemann Termotec (CBT) has been further strengthened by an experienced construction manager and additional staff. CBT is now very well positioned for larger, international projects.

The in-house developed special design program for Air-Cooled Condensers with following cost accounting has passed its test, runs very well and allows a fast response to customer inquiries.

For the supply of the "State of the Art – Single Row Fin Tube Bundles" an experienced team in China was found. The international quality standards for this product has been implemented on site.

The first fin tube bundles have already been ordered. To comply with the requirements of quality, there are permanent in-house inspectors from Germany.

The thermal hydraulic data of the finned tube bundles system were determined to test in a wind tunnel of the Technical University of Dresden. The quality of the soldering of the ribs and the overall strength of the finned tubes has been tested not only by generally customary pressure tests, but also by much more meaningful, cyclic vacuum experiments in the own laboratory of CBT.



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Clyde Bergemann Power Group Targets the Highest Standard in the Field of Anti-Corruption and Anti-Bribery

Clyde Bergemann Power (CBPG) is a global business active in the energy engineering market and it is an essential target for the company to have implemented the highest standards of 'Corporate Governance'. Therefore CBPG will also stick to highest standards in the field of Compliance.

Initially the focus is on the prevention of corruption and bribery. Other areas will be integrated successively into the Compliance programme.

Since the 1st of July 2011 the most stringent anti-corruption law is in force, the UK Bribery Act. Long before the new law became

effective CBPG had decided to prepare the organisation for the new law and to implement the necessary processes and procedures group-wide. The project for the development of the new Compliance guidelines started already at the end of 2010 and was planned and executed with a renowned British consultancy firm.

On the 11th of March 2012 the President & CEO of the CBPG, Mr. Franz Bartels, put into force the new Anti-Corruption and Anti-Bribery Compliance Policy guidelines.



Key messages are zero tolerance and extensive due diligence on potential business partners – especially agents and specific suppliers – before doing any business with them.

The new guidelines proof a logical and consequent development as Compliance has always had high significance within the group. Since many years the group has anti-corruption guidelines in place and publishes the group values on its official website.

All employees have received a briefing already. Selected employees have in addition been participating in trainings where the focus is on dealing with case studies regarding typical risk scenarios in business transactions and exercising how to use the new guidelines, procedures and forms. The responsible manager and point of contact is the Compliance Director of the CBPG, Mr Michael Falk.

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New Boiler Fault Diagnosis System for Lippendorf Coal Power Station's 820 MW Unit

Vattenfall Europe AG is replacing the existing boiler fault diagnosis system using a solution from Clyde Bergemann.

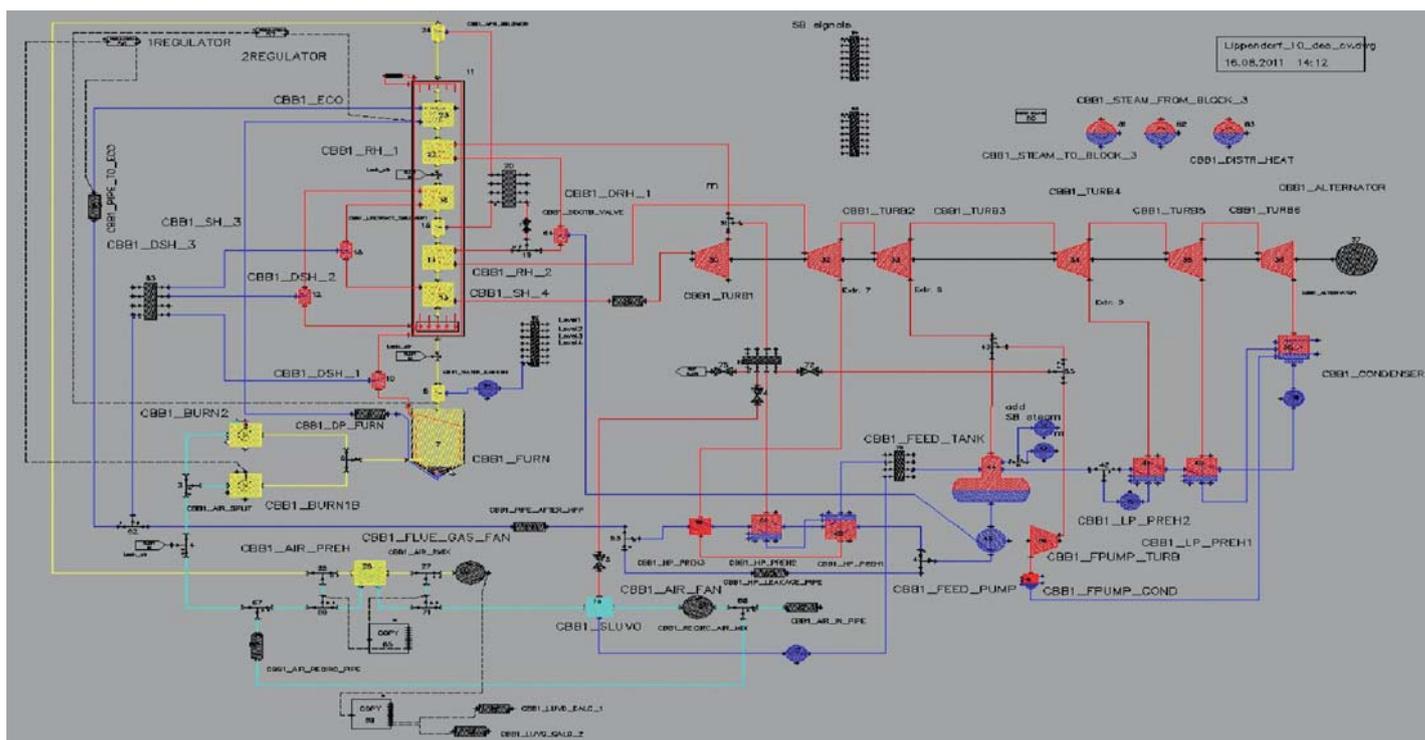
The Lippendorf plant, with a net efficiency of 43 %, is one of the world's most modern lignite power plants. Process control in the convective part of the lignite fired boiler will be transformed by a diagnostic system with integrated CEOS thermodynamic balance in block R.

The combustion chamber will also be monitored by Clyde Bergemann's SMART InfraScan to optimize boiler cleaning. SMART InfraScan infrared cameras contin-

ously measure the surface temperature to calculate temperature distribution. The information gathered in the furnace is monitored and evaluated by SMART Furnace, the intelligent software module. The program analyses the degree of fouling of the boiler and determines when cleaning is necessary. Based on this information, cleaning can be focussed where it is most needed. This is a more efficient approach than cleaning at set time intervalls. Clyde Bergemann is responsible for the delivery of the design as well as

procurement, commissioning and user training. SMART InfraScan uses infrared cameras developed by CMV Systems GmbH.

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Clyde Bergemann Limited (Glasgow) Celebrates Success in the RoSPA Awards 2012

Clyde Bergemann Limited (Glasgow), has had its approach to the prevention of accidents and ill health recognised in the RoSPA Occupational Health and Safety Awards 2012. The Silver award was presented at a ceremony at the Hilton Glasgow on Thursday, September 20.

Dating back to 1956, the RoSPA Occupational Health and Safety Awards scheme is the largest and longest-running programme of its kind in the UK. It recognises commitment to accident and ill health prevention and is open to businesses and organisations of all types and sizes from across the UK and overseas. The scheme does not just look at accident records, but also entrants' overarching health and safety management systems, including important practices such as strong leadership and workforce involvement.

David Rawlins, awards manager at RoSPA, said: "The RoSPA Awards programme provides well-deserved recognition for the winners and spurs on other organisations

to raise their standards of accident and ill health prevention. We congratulate Clyde Bergemann Ltd (Glasgow) on its success and encourage it, and all our other winners, to remain committed to safety and health, an approach that is well recognised to be good for workers and the bottom line."

Michael Peoples, General Manager of Clyde Bergemann Scotland commented "This is an excellent recognition of the hard work and effort that goes into keeping a facility operating safely and ensuring that we promote a safe working environment for all of our staff. The award recognises this continued focus of everyone in our business and their vigilance to make sure we maintain our safe

workplace. Special thanks should be noted to Diane Bainbridge for coordinating our application for this recognition award, however – as Diane would say – it is thanks to everyone for their awareness of the need to promote our safe working environment and it is a team effort will maintain our standard of safe working."

RoSPA's awards mark achievement at merit, bronze, silver and gold levels.

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Clyde Bergemann Atlanta Continues to Expand the Shower Cleaning System Market with Wheelabrator Order

Following a seven month effort, a purchase order was received from Wheelabrator Technologies for the supply and installation of the Eastern United State's region's first Shower Cleaning System (SCS).

The contract is not only the first for the region, but is also the first unit sold to be developed in Atlanta as an introduction to the US market from at least the controls perspective.

A critical component of this success was the close group collaboration between the Atlanta and Wesel Clyde Bergemann offices to introduce the Shower Cleaning System in the United States. CBAT was also helped by the presence of the Product Manager from Wesel, Marc Tirkschleit in Atlanta. Marc had prior experience with the technology in Europe and was able to give important advice to the engineering team in Atlanta. This enabled Clyde Bergemann Atlanta to transfer

this knowledge and adapt it to the US market quickly.

Following the successful start-up and performance of this system, it is expected that the other two units at the Bridgeport site will follow, as well as several other Wheelabrator Plants. With our first two systems then established within the two largest waste-to-energy providers in the US, Covanta and Wheelabrator, it is further expected that the SCS System will become more commonplace in the US Waste to Energy market as it has in Europe.

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► Instrument module SCS USA

Personnel Developments



Ralf Belka

He joined Clyde Bergemann Africa as the new Managing Director.



Ralf Pettersson

He took over the position as Managing Director of CB Scandinavia. He follows Pertti Ekdahl, who has gone into the his well-earned retirement.



Michael Falk

He took over the new Group position "Group Compliance Director". He has the responsibility for the introduction of the new "Global Anti-Bribery and Anti-Corruption Compliance Policy". Behind this he also still covers the position "Group Director Risk Management".



Claudia Denninger

She joined the Clyde Bergemann Power Group as Global Marketing Manager.



Philip Randal

He took over the position as Manager Production of the new production facility in Jessup, Georgia (USA).

Events Diary

DECEMBER

December 11-13, 2012

POWER-GEN International

Orlando, FL
CBPG Americas exhibits

FEBRUARY

February 4-6, 2013

POWER-GEN Middle East

Doha, Qatar
