

KOPPERS SUSTAINABILITY REPORT

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MESSAGE FROM THE CEO

As I begin my tenure as Koppers CEO, I am pleased to share with you our progress on growing sustainably for the benefit of our customers, suppliers, shareholders, employees, and all of the communities where we operate.

Koppers strength has always been its people. This year, we welcomed new colleagues as a result of acquisitions that will significantly enhance our product and service offerings. Our new business segment, Performance Chemicals, greatly diversifies the markets we serve and geographies in which we operate and, as a result, provides greater stability to earnings. The Railroad Structures and Ashcroft acquisitions were complementary additions to our Railroad Products and Services segment and provide a broader base from which to serve our railroad customer base.

As we continue to integrate new employees into the Koppers culture, we believe we will realize tremendous value creation. The combination of new energy and ideas within an established framework and discipline will help us to further improve upon and extend our future sustainability activities.

Even as we grow, our employees continue to deliver excellent results with regard to safety, health, and environmental efforts. This past year, among other achievements, we:

- Completed Koppers initial rollout of the American Chemistry Council’s Responsible Care® initiative, with certification to begin in early 2015.
- Initiated Responsible Care® Product Safety Code implementation.
- Instituted safety and productivity improvements across our Carbon Materials and Chemicals business unit.
- Held two tank car safety training events in partnership with local communities and agencies.
- Significantly reduced municipal water use at Australian facilities.
- Achieved more than \$1.4 million in energy efficiency-related cost savings.

I appreciate the hard work and commitment of all our employees to build a culture based on safety and environmental responsibility. As we move forward as one global team, I invite you to provide us with feedback on our efforts.

Leroy Ball
 President and Chief Executive Officer
 Koppers Inc.

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OUR APPROACH TO SUSTAINABLE VALUE CREATION

A SUSTAINABLE FOUNDATION

Our values help guide us in managing risk, ensuring accountability to key stakeholders, and securing competitive advantage.

KOPPERS VALUES

- Accountability – own the choices you make and the results that follow
- Customer Focus – make exceptional service an ordinary occurrence
- Excellence – quality without compromise
- Innovation – find new answers to old problems
- Integrity – if it's not right, don't do it
- Respect – show it and earn it
- Simplicity – see it big but keep it simple
- Sustainability – take care of today without sacrificing tomorrow
- Teamwork – none of us is as smart as all of us
- Transparency – communicate openly and honestly

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- Completed Koppers initial rollout of the American Chemistry Council's Responsible Care® initiative, with certification to begin in early 2015.
- Initiated Responsible Care® Product Safety Code implementation.
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- Significantly reduced municipal water use at Australian facilities.
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SUSTAINABILITY AT KOPPERS

ABOUT KOPPERS

The Koppers mission: “To be the most valued supplier of quality products and services in the industries we serve, by providing unsurpassed personal attention to our customers and attaining total quality in everything we do.”

Koppers Inc. is an integrated global producer of carbon compounds, chemicals, and treated wood products and services for the aluminum, railroad, specialty chemical, utility, rubber, concrete, steel, residential lumber, and agriculture industries. Our products are used to support the production of building materials and the development of infrastructures around the world.

Koppers operates three major business units:

Carbon Materials and Chemicals (CMC) processes coal tar into a variety of chemical compounds used in the production of aluminum, steel, concrete, rubber, plastics, and materials used to pressure treat wood.

Railroad Products and Services (RPS) provides treated wood, maintenance-of-way supplies, and other products and services to the North American Class I, commercial, and regional railroads. The most recent addition to the business, Railroad Structures, is one of the largest railroad bridge rehabilitation and inspection providers in North America.

Performance Chemicals (PC) supplies commercial wood preservation products and technology services for residential, commercial, construction, and agricultural applications.

KOPPERS PERFORMANCE CHEMICALS

Koppers August 2014 acquisition of the Wood Preservation and Railroad Services businesses from Osmose Holdings, Inc. has opened a new door to innovation and customer service. In addition to rounding out our wood treatment and carbon materials businesses, Performance Chemicals brings global leadership in the development, manufacturing, and marketing of wood preservation chemicals and wood treatment technologies. The new business unit covers operations and sales in North America, Latin America, Europe, Australia, New Zealand, and Asia.

Performance Chemicals employees are dedicated to providing customers with industry-leading engineering and plant technical support, marketing, and environmental services, as well as other customer-related support activities. Performance Chemicals employees work side by side with customers to carry out our commitment to responsible operations.

Our strong global commitment to research and development is evidenced by our large staff of scientists, researchers, and technicians who continually work on developing state-of-the-art wood preservative and wood enhancement technologies.

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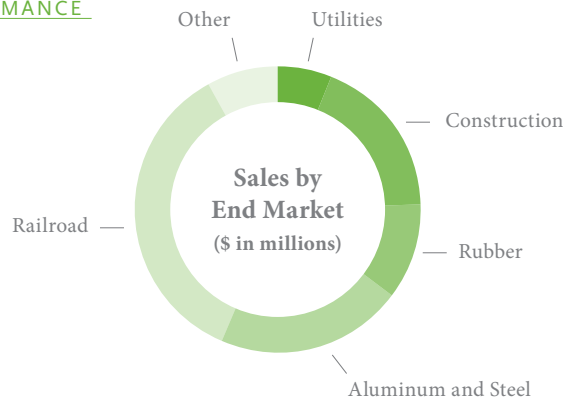
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FINANCIAL PERFORMANCE



Point of Sale (\$ in millions)	2014	2013	2012
North America	929	844	884
Australia	157	159	147
Europe	196	223	243
Emerging Markets	273	252	281
Number of Facilities	37	28	25

ETHICS AND COMPLIANCE

We expect every employee, manager, executive, and director of the company to uphold the highest standards of ethics, compliance and transparency. Our goal is to act with honesty and integrity, across our global operations and in all business dealings. These expectations are set forth in the [Koppers Code of Business Conduct and Ethics](#).

GOVERNANCE APPROACH

The duties and responsibilities of the Koppers Board of Directors are to:

- Ensure the legal, ethical and socially responsible behavior of the company;
- Develop effective performance measurement systems;
- Review the company’s long-term strategy; and
- Oversee risk management processes.

The charter of the Safety, Health, and Environmental Board committee reflects our membership in Responsible Care®. The committee is tasked with (1) assessing the company’s safety, health, environmental, security and sustainability policies, programs and initiatives in accordance with Responsible Care® principles, and (2) oversight of matters enhancing our global corporate stewardship and practices of conscientious corporate social responsibility and product safety.

Additional information can be found on our [corporate governance website](#).

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ENGAGING WITH OUR STAKEHOLDERS

Every day, our business operations bring us into contact with the many stakeholders sharing an interest in our company and with whom we seek to build strong, lasting relationships.

Through our stakeholder interactions, we aim to:

- Manage Change
- Promote the Greater Integration of Koppers Strategic Priorities
- Enhance Efficiency
- Maintain Positive Relationships
- Eliminate Barriers to Achieving Koppers Business Objectives
- Communicate Company Challenges and Achievements Internally and Externally

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OUR EMPLOYEES

We know that our success in international expansion and addressing market challenges relies on being able to work together effectively. We therefore invest significant resources in human resources management, employee engagement and communication. We place high value on activities such as global meetings and training sessions that heighten internal cohesion, and we strive to promote a collaborative and inclusive work environment across all of our international locations.

MANAGING KOPPERS TALENT

Our Human Resources Information System, implemented in 2013, provides managers with both past and current employee performance while also tracking retention, turnover and demographics. With this data, management can identify talent earlier and more accurately in order to encourage, train and promote the people we need to move forward.

Workforce by Region	2014	2013	2012
North America	1,482	1,084	1,166
Europe	262	230	231
Australia	197	164	164
South America	20	—	—
China	187	111	99
Total	2,148	1,589	1,660

ENSURING EMPLOYEE HEALTH AND WELLNESS

We rely on employees to do their jobs skillfully and efficiently, so we promote health and wellness to help everyone reach their full potential. Our workplace-based wellness programs improve the health of our employees while reducing absentee rates and health expenditures.

We held wellness screenings in 2014 at facilities and offices throughout the United States, Europe, and Australia. Screenings covered cholesterol, height, weight, and body mass index, blood pressure, and glucose levels. All participants were provided with counseling based upon the results of their screening.

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OUR CUSTOMERS

The Koppers team endeavors to serve its global customers through close long-term partnerships. We listen carefully to customer needs during the sales process, upon product delivery, and during daily operational interactions. Our demonstrated commitment to the highest levels of environmental, social and governance performance assures customers that they can depend on us to be a safe, sustainable and reliable supplier.

ENHANCING CMC PRODUCT QUALITY

We have taken several steps to provide enhanced customer service with regard to Carbon Materials and Chemicals (CMC) product specifications and quality. We are continuing to apply the CMC Laboratory Information Management System (LIMS) and improve the Koppers Customer Care Extranet sites. LIMS, which will be implemented in all our plants, tracks customer specifications and alerts technicians to any products that do not conform to Koppers customer standards. Our Customer Care website provides customers with real-time product information, allowing production decisions to be made prior to receiving products.

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OUR SUPPLIERS

Building, maintaining and optimizing supply chains is a critical element of Koppers global expansion.

SOURCING AROUND THE WORLD

Koppers places great value on the relationships we have developed with our suppliers. By working together for long time periods, we are all better equipped to achieve our financial and sustainability objectives. We will continue to work with our suppliers to bring them into the Responsible Care® commercial partner program. We will also remain vigilant with regard to engaging in ethical and responsible supplier relationships, following the precepts of our anti-corruption policy.

“As a long-term supplier for Koppers, DTE Energy has realized substantial value from the stable, responsible and cooperative relationship the two companies have developed. In addition, the companies have gained a mutual respect and appreciation of one another on a basis of shared values regarding safety and environmental stewardship.”

—DTE Energy

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OUR COMMUNITIES

Around the world, Koppers facilities are key contributors to local economies by providing jobs and tax revenues to towns and municipalities. Additionally, we strive to be a responsible neighbor by engaging with communities to understand their concerns, communicating clearly about our operations, and supporting the causes most important to local needs.

CARING FOR OUR COMMUNITIES

Every year, Koppers outreach initiatives connect employee time and talent with local organizations. For example, in 2014, Koppers Wood Products employees donated materials, time, and skill to rebuild fencing at the Fraser Coast Wildlife Sanctuary in Queensland, Australia. The Sanctuary protects kangaroos, wallabies, and dingoes, among other animals.



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SAFETY, HEALTH, AND ENVIRONMENTAL STEWARDSHIP

Achieving excellence in Safety, Health, and Environmental (SHE) performance is vital for building a solid future for our company and meeting the rising performance expectations of regulators, customers, communities and investors.

KOPPERS SAFETY, HEALTH, AND ENVIRONMENTAL POLICY

The Koppers SHE policy requires all Koppers employees to consider the impact of our actions on the safety and health of people and on the environment. All of our business decisions are guided by this policy, which includes:

- Compliance with all applicable safety, health, environmental and security laws, regulations, and other requirements to which Koppers subscribes;
- Pollution prevention in order to preserve the environment for the health, productivity and enjoyment of future generations;
- Protection of people through the management of product, process and other safety risks;
- Continuous improvement of our safety, health, environmental, and security systems and performance; and
- Communication regarding our business operations and potential risks, both internally and externally, to promote openness with our stakeholders.

We have established ISO 14001-compliant policies, processes, and procedures that start from the premise that full compliance with all applicable legal requirements is the minimum level of performance. Each year, managers from across Koppers global operations convene at our annual SHE Conference to share best practices, set goals, and receive training on current issues.

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MANAGING FOR HEALTH AND SAFETY

The Koppers SHE management system sets forth our comprehensive approach to health and safety, with our main goal to prevent accidents and incidents before they occur. We firmly believe that no employee should be injured on the job, and we maintain high levels of vigilance and individual accountability for safe working conditions and practices.

In 2014, employees in our Carbon Materials and Chemicals business unit began implementation of PINNACLE, a new safety and productivity initiative. PINNACLE aims to:

- Instill a safety mindset and culture,
- Enhance process safety management through the voluntary adoption of the OSHA Process Safety Management code,
- Improve efficiency and productivity at facilities, and
- Increase productivity in the supply chain.

PINNACLE activities have helped us achieve increased efficiency in logistics, procurement, and other plant operations, and we expect to see improved safety performance as program implementation continues.

Safety Statistics (aggregate, all regions)	2014	2013	2012
Days Away Case Rate	0.76	0.90	0.72
DART Rate	2.03	1.69	1.66
Total Recordable Rate	3.91	3.71	3.99
Fatalities	0	0*	0

*There was one contractor fatality in Europe in 2013.

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EMERGENCY PREPAREDNESS

In addition to our global SHE policy, each Koppers facility develops and maintains written emergency response, preparedness and prevention plans. These plans, created with input from local community members and emergency responders, address potential emergency scenarios and describe how the facility will respond. We test and coordinate our planning with local authorities and community organizations.

In addition to communicating our emergency preparedness plans, we engage on a regular basis with community members and local organizations via Community Advisory Panels (CAPs), participation in local emergency planning and response activities, open houses, postings on the Koppers website, and support for local volunteer efforts.

TRAINING TOGETHER TO OPERATE TANK CARS SAFELY

Koppers provides on-site instruction in all aspects of tank car functionality and safety during training sessions conducted both in the classroom and hands-on with a tank car. As part of our Responsible Care® outreach mandate, Koppers invites the participation of other local companies, emergency planning committees, law enforcement, Homeland Security, the Coast Guard and other responders, who contribute information concerning their specific safety and preparedness priorities.

Koppers hosted two tank car safety training events in 2014 with our partners from the Canadian National and BNSF Railroads at our Stickney, Illinois and Somerville, Texas facilities in the United States.

At the Somerville event, 237 individuals participated in classroom and hands-on training regarding hazardous material rail shipments, tank cars, emergency response, and railroad procedures. The participants represented groups including the Federal Railroad Administration, Transportation Security Administration, Department of Homeland Security, Coast Guard, law enforcement, emergency responders, fire personnel, and other local chemical shippers.

These events provide a forum for enhancing community awareness and emergency responders' knowledge of tank car operations, tank car anatomy, and emergency response strategies when responding to railroad incidents. As a host, Koppers benefits from first responders becoming more familiar with our operations and plant management teams, enabling them to react more quickly in the event of an incident.

“As Grimes County’s emergency manager, this training is essential towards helping me understand the nature of risks inherent in hazardous materials traveling by rail. Ensuring the safety of my county requires a team effort with all members actively engaged in planning and training for incidents—reducing the likelihood that incidents will occur at all.”

—David Lilly, Emergency Management Coordinator, Grimes County, Texas

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ENVIRONMENTAL PERFORMANCE

Koppers employees are charged with eliminating inefficiencies and waste, whether of time, money, or materials. At each of our facilities around the world, we seek to identify and implement those initiatives that will allow us to operate efficiently and optimize our use of natural resources. The examples below demonstrate some of the many ways we are delivering on our commitment to be responsible stewards of the environment.

ENERGY AND GHG EMISSIONS

Koppers recognizes the importance of reducing our energy use and greenhouse gas emissions to lower our costs as well as reduce the company’s environmental impacts. In 2014, we partnered with the Industrial Assessment Center at West Virginia University and the Industries of the Future—West Virginia program to assess and implement energy-saving measures. The cost savings for our 14 U.S. locations added up to more than \$1.4 million, earning us the West Virginia Governor’s Award for Excellence in Industrial Energy Efficiency.

Direct Energy Consumption (in GJ)	2014	2013	2012
Renewables			
Wood Chips	415,438	422,380	476,191
Used Ties	N/A	672,671	914,770
Non-renewables			
Gasoline	10,293	15,575	14,795
Diesel	114,511	110,809*	108,710*
Fuel Oil #6	366,350	377,347	433,821
Solvent	249,459	370,693	475,782
Coal	N/A	N/A	N/A
Coke Oven Gas	674,474	576,169	583,571
Natural Gas	2,765,726	2,738,004	2,499,427
Kerosene	938	2,013	758
Propane	3,796	1,505	1,136
Total Direct Energy Consumption	4,600,985	5,287,166*	5,508,961*
Energy Sold	95,123	229,648	219,117

*Figures restated to correct calculation error in conversion of diesel fuel to gigajoules.

Indirect Energy Consumption (in GJ)	2014	2013	2012
Electricity	689,550	677,012	677,554
Steam	860,540	831,377	819,495
Total Indirect Energy Consumption	1,550,090	1,508,389	1,497,049

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GREENHOUSE GAS (GHG) EMISSIONS (METRIC TONS OF CO₂E)

Scope 1 Greenhouse Gas Emissions	2013	2012	2011
Stationary Source Combustion	418,212	420,613	433,935
Mobile Sources	11,588	11,823	11,232
Process/Fugitive	69,687	122,421	170,559
Refrigerant	617	505	685
Total Scope 1 Greenhouse Gas Emissions	500,104	555,362	616,411

Scope 2 Greenhouse Gas Emissions	2013	2012	2011
Electricity	112,814	124,092	138,206
Purchased Steam	78,241	101,868	112,838
Total Scope 2 Greenhouse Gas Emissions	191,055	225,960	251,044

REDUCING ENERGY USE IN AUSTRALIA

At the Koppers Mayfield plant in Australia, energy usage per unit produced was reduced by 23 percent over five years. Important elements contributing to the success of this major energy use reduction included:

- Establishing an Energy Management Plan to review usage and energy projects.
- Identifying the optimal operational rate of running as close to 100 percent capacity as much as possible.
- Implementing specific energy savings projects, including: installing variable speed drives on fans and pumps, replacing inefficient air compressors, improving combustion control and recovering heat from boilers and heaters, upgrading insulation, fixing and replacing steam leaks and traps, and upgrading lighting.

RECYCLING RAILCAR RESIDUE

When our chemical products are shipped in railcars, a heavy residue can build up in the cars over time. Accordingly, we clean all railcars on a ten-year cycle to remove residue and requalify the railcars for use. Cars may also be cleaned prior to maintenance or repair. To minimize the environmental impacts of railcar cleaning, Koppers uses contractors to recycle 100 percent of residues recovered from the cars rather than sending the material for hazardous waste disposal.

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REUSING WATER IN AUSTRALIA

In Australia, Koppers employees are contributing to drought-alleviation efforts by conserving local water supplies.

- At our Takura plant in Queensland, a new pump and filter station and reuse of stormwater has significantly reduced the amount of water we purchase from the municipal water supply, from 3,104 kiloliters (kl) in 2013 to 792 kl in 2014.
- At our Bunbury facility in Western Australia, we have continued to increase the amount of rain and storm water we reuse by using a filtration system, a set of storage tanks, sumps, and a concrete dam.

<u>BUNBURY FACILITY</u>	<u>2014</u>	<u>2013</u>	<u>2012</u>	<u>2011</u>
Rain and storm water reuse (kl)	6,872	6,665	5,203	1,210

- At the Longford treatment plant in Tasmania, a new solar-powered pump, installed in 2013, allows the facility to meet 100 percent of its water needs through water collected on-site. The facility uses municipal supplies only when there has not been a sufficient amount of rain.
- Koppers Grafton facility in New South Wales utilizes a rooftop rainwater collection system to reduce its dependency on the municipal water supply. During 2014, the facility reused approximately 770,000 liters of rain water collected from shed roofs.

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RESPONSIBLE CARE IMPLEMENTATION

At Koppers, we focus on providing excellent product quality, safety and reliability. In 2014, we continued our roll-out of Responsible Care® across the company’s global operations. Developed by the chemical industry in the mid-1980s, Responsible Care® is a large-scale performance initiative that seeks to improve chemical companies’ product stewardship, safety, and disclosure activities through an integrated management and performance platform.

Responsible Care® will impact all facets of the company and inform our interactions with value-chain partners. As a model of our safety, health, and sustainability goals, Responsible Care® represents a significant commitment by senior management to drive product and process improvements, raise industry standards, and foster growth.

We completed initial implementation in 2014 and will begin audits and certification in 2015. We are especially proud of employees’ efforts to reach out to commercial partners and communicate Responsible Care® principles. We have connected with vendors, transportation partners, and others to communicate how to mitigate risks and safely manage the chemicals and products we manufacture.

We also began implementing the Responsible Care® Product Safety Code by taking the following steps:

- Demonstrating a leadership commitment, by setting and communicating our product safety policies and programs, establishing targets, and incorporating this information into facility-level strategic planning.
- Developing a product safety organizational model, defining roles, creating training programs, setting governance reviews, and measuring against business-specific goals.
- Prioritizing products to determine which warrant the most detailed risk assessments, utilizing stakeholder input and American Chemistry Council® (ACC) tools.

We will now move into the Information and Safety Management phase of the Responsible Care® Product Safety Code to deepen our understanding of risks and better manage for product safety.

Koppers signed the Responsible Care® Global Charter in early 2015, further committing ourselves to strengthening the program worldwide.

More information regarding Responsible Care® can be found on the [ACC website](#).

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APPROACH TO PRODUCT RESPONSIBILITY

Koppers provides its customers with products that can be used safely and in compliance with all applicable regulations. We adhere to applicable quality standards and to the ISO 14001 standards in the production and disposal of our products. Our [Safety Data Sheets](#) (SDS) provide information on our products' composition, properties, safety precautions, environmental impact, and other data.

We are committed to working with regulators, industry groups and suppliers to meet regulatory requirements. We also contract with an external party to provide customers with emergency response support.

RIDE-TIGHT® PROGRAM

Launched in Koppers North American facilities in March 2013, the Ride-Tight® program is a proactive safety initiative addressing the proper closure and sealing of chemical-transporting railcars. The goal of the program is to reduce and preferably eliminate the unintentional release of hazardous materials during transport.

We have conducted training classes with employees at all Koppers North American facilities. We are bringing customers onboard as well. A new railcar checklist that expands upon Ride-Tight® principles is already producing significant improvements.

KOPPERS HONORED WITH TRANSPORTATION SAFETY AWARDS

Koppers is recognized annually by several major North American railroads for its outstanding transportation safety record. In 2014, Koppers received awards from the BNSF Railroad and the Canadian National Railroad for excellence in chemical-transportation safety performance during 2013.

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INNOVATION

Koppers core products are the foundation of a complex and diversified value chain. We continually challenge ourselves to capture new opportunities for product customization to fulfill the evolving needs of our customers. Our capacity to do so was further expanded with the August 2014 acquisition from Osmose Holdings of our Performance Chemicals unit, which has long experience supporting customers through trainings, technical support, and developing health and safety best practices.

RESEARCHING NEW MATERIALS AT KOPPERS GLOBAL TECHNOLOGY CENTER

Researchers at the Koppers Global Technology Center (KGTC) create and test new forms of carbon pitch and other chemical products, both to extend our product line into new uses and markets, and at the request of customers. Located at the University of Pittsburgh Applied Research Center, KGTC—often in collaboration with outside entities—provides Koppers with key laboratory research capabilities and access to a local talent pool with the chemical engineering skills essential to our growth.

EXTENDING CROSSTIE LIFESPAN WITH BORATE TREATMENT

Railroads have long used creosote-treated crossties to enhance the durability of their infrastructure. While creosote protects wood from external environmental elements, internal degradation from rot and insect damage has limited the lifespan of creosote-treated ties in high-decay zones.

Koppers customers—particularly those located in humid high-decay zones—have responded positively to the way our dual-treated borate and creosote products, as approved by the American Wood Protection Association, address these issues.

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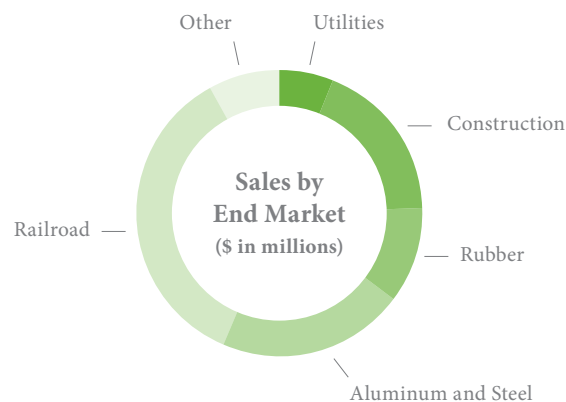
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The Koppers 2014 Performance Tables are a comprehensive set of indicators and metrics regarding the company’s economic, social and environmental performance. The data reflects the results of Koppers business operations during 2012, 2013 and 2014 and has been collected from across the company’s global facilities.

FINANCIAL PERFORMANCE

\$ in millions	2014	2013	2012
Net Sales, by business segment	1,555	1,478	1,555
Carbon Materials and Chemicals	834	906	1,000
Railroad & Utility Products	598	572	555
Performance Chemicals	123	0	0
Total Debt	851	303	296
Total Equity	84	190	168
Operating Profit	33.2	100.3	126.6
Net (Loss) Income (to Koppers)	(32.4)	40.4	65.6

Point of Sale (\$ in millions)	2014	2013	2012
North America	929	844	884
Australia	157	159	147
Europe	196	223	243
Emerging Markets	273	252	281
Number of Facilities	37	28	25



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SOCIAL PERFORMANCE

WORKFORCE DATA

Workforce by Region	2014	2013	2012
North America	1,482	1,084	1,166
Europe	262	230	231
Australia	197	164	164
South America	20	—	—
China	187	111	99
Total	2,148	1,589	1,660

Workforce by Region and Gender	Total	Female	Male
North America	1,482	158	1,324
Europe	262	47	215
Australia	197	36	161
South America	20	2	18
China	187	30	157

Employment Type (U.S. workforce only)	Total	Female	Male
Salaried (Full-time)	456	107	349
Hourly (Full-time)	989	38	951
Part-time	14	7	7

Workforce Breakdown (U.S. workforce only)	Total	Female	Male
Management	189	24	165
Employee	1,270	128	1,142
Supervised Worker	0	0	0

Employment Contract (U.S. workforce only)	Total	Female	Male
Permanent	1,452	150	1,302
Temporary	7	2	5

Employee Turnover	2014	2013	2012
Global Employee Turnover (in %)	17	10	13.65

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SAFETY DATA

Safety data includes only Koppers employees and supervised workers; independent contractors are not included unless otherwise noted.

Safety Statistics (aggregate, all regions)	2014	2013	2012
Days Away Case Rate	0.76	0.90	0.72
DART Rate	2.03	1.69	1.66
Total Recordable Rate	3.91	3.71	3.99
Fatalities	0	0*	0

Safety Statistics (by region)	Days Away Case Rate		DART Rate		Total Recordable Rate		Fatalities	
	2014	2013	2014	2013	2014	2013	2014	2013
Total (company-wide)	0.76	0.90	2.03	1.69	3.91	3.71	0	0
United States	0.88	1.12	2.71	2.16	5.19	4.88	0	0
Europe	0.00	0.81	0.00	1.21	0.43	1.21	0	0*
Australia	0.56	0.00	0.56	0.00	1.12	1.14	0	0
China	0.00	0.00	0.54	0.00	0.54	0.00	0	0

Safety Statistics (by gender)	Days Away Case Rate		DART Rate		Total Recordable Rate		Fatalities	
	2014	2013	2014	2013	2014	2013	2014	2013
Total	0.76	0.90	2.03	1.69	3.91	3.71	0	0*
Female	0	0	0	0	0.05	0.05	0	0
Male	0.76	0.90	2.03	1.69	3.86	3.66	0	0*

*There was one contractor fatality in Europe in 2013.

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ENVIRONMENTAL PERFORMANCE

MATERIALS USE*

RUPS	2014	2013	2012
Non-renewable materials (steel strapping— used in shipments) (in lbs.)	730,616	682,226	686,023
Renewable materials (wood) (in ft ³)	36,541,434	46,471,131	45,438,565
Materials used that are recycled inputs (in %)	0	0	0

CMC	2014	2013	2012
Coal tar, distilled (globally)	1,661,109	1,651,251	1,716,000
Petroleum, distilled (North America)	29,466	94,441	66,000
Petroleum, distilled (Uithoorn)	141	1,117	1,890
Naphthalene to PAA (North America)	44,438	55,550	54,366
Orthoxylene to PAA (North America)	17,878	7,729	17,790
Benzol heavy distillate (Uithoorn)	0	0	3,436
Xylene	127	403	361
Sulphuric acid	13,497	16,614	15,014

*Materials use data does not include Australian operations.

GREENHOUSE GAS (GHG) EMISSIONS (METRIC TONS OF CO₂E)

Scope 1 GHG Emissions	2013	2012	2011
Stationary Source Combustion	418,212	420,613	433,935
Mobile Sources	11,588	11,823	11,232
Process/Fugitive	69,687	122,421	170,559
Refrigerant	617	505	685
Total Scope 1 GHG emissions	500,104	555,362	616,411

Scope 2 GHG Emissions	2013	2012	2011
Electricity	112,814	124,092	138,206
Purchased Steam	78,241	101,868	112,838
Total Scope 2 GHG Emissions	191,055	225,960	251,044

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ENERGY CONSUMPTION (IN GJ)

Direct Energy Consumption	2014	2013	2012
Renewables			
Wood Chips	415,438	422,380	476,191
Used Ties	N/A	672,671	914,770
Non-renewables			
Gasoline	10,293	15,575	14,795
Diesel	114,511	110,809*	108,710*
Fuel Oil #6	366,350	377,347	433,821
Solvent	249,459	370,693	475,782
Coal	N/A	N/A	N/A
Coke Oven Gas	674,474	576,169	583,571
Natural Gas	2,765,726	2,738,004	2,499,427
Kerosene	938	2,013	758
Propane	3,796	1,505	1,136
Total Direct Energy Consumption	4,600,985	5,287,166*	5,508,961*
Energy Sold	95,123	229,648	219,117

*Figures restated to correct calculation error in conversion of diesel fuel to gigajoules.

Indirect Energy Consumption	2014	2013	2012
Electricity	689,550	677,012	677,554
Steam	860,540	831,377	819,495
Total Indirect Energy Consumption	1,550,090	1,508,389	1,497,049

Spills	2014			2013	2012
	Total	RUPS	CMC		
Total number of spills	13	10	3	18	12
Total volume of spills (in gallons)	1,885	535	1,350	12,165	178,943

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WATER (IN M³)

Water Withdrawal	CMC			RUPS		
	2014	2013	2012	2014	2013	2012
Municipal water supply	1,528,724	N/A	N/A	104,863	170,715	146,268
Well water	0	N/A	N/A	82,451	226,800	241,510
River water	441,481	N/A	N/A	19,670	18,776	24,946
Rainwater	0	N/A	N/A	N/A	N/A	N/A
Groundwater	0	N/A	N/A	N/A	N/A	N/A

Water Discharge	CMC			RUPS		
	2014	2013	2012	2014	2013	2012
Discharge to Publicly Owned Treatment Works						
Biological aeration	619,373	N/A	N/A	272,024	221,978	219,422
Activated sludge	0	N/A	N/A	22,305	22,560	22,404
Non-biological treatment	0	N/A	N/A	5,023	5,270	4,528
Non-treated	737,826	N/A	N/A	1,471	82,396	76,170
Discharge to Overground Water Sources						
NPDES permitted	342,090	N/A	N/A	177,311	622,765*	23,013**
Form R (estimated)	1,449,794	N/A	N/A	451,825	(included above)	309,588

*Inclusive of Form R estimated discharges and Green Spring evaporated discharge of 8,944 m³.

**Inclusive of Green Spring evaporation discharge of 5,471 m³.

CMC data includes USCMC, KCMC, SCW/PB (UK), and KCCC.

Each facility maintains specific water-quality parameters and limits, which are available upon request.

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GLOBAL WASTE DISPOSAL (IN METRIC TONS)

Hazardous Waste	CMC			RUPS		
	2014	2013	2012	2014	2013	2012
Incineration	967.8	393.5	1,151.2	1,526.7	839.8	1,395.0
Energy Recovery	940.9	388.94	2,902.56	273.23	4.86	21.03
Organics Recovery	9,236.6	1,274.23	0	0.03	0.02	0
Metal Recovery	1.11	6.88	0.22	2.96	0.5	0.3
Landfill	2,104.1	244.37	60.37	79.14	36.83	139.46

Non-Hazardous Waste	CMC			RUPS		
	2014	2013	2012	2014	2013	2012
Landfill	1,796.9	N/A	2,468	2,431.4	N/A	10,357
Reused/recovered wood waste	N/A	N/A	7,402 m ³	31,570.1	N/A	434
Reused	N/A	N/A	3.4	N/A	N/A	N/A
Recycled	379.6	N/A	291	443.4	N/A	1,245 (recycled steel)
Recovered	122.5	N/A	206.5	N/A	N/A	N/A
Municipal waste	163	N/A	104	255	N/A	N/A
Offsite	N/A	N/A	567.5	39.1	N/A	N/A
KCCC (all plant waste sent to partner Tangshan Iron & Steel)	4.7	N/A	24	N/A	N/A	N/A

CMC data includes USCMC, KCMC, SCW/PB (UK), and KCCC. RUPS data for 2014 includes USRUPS and KWP (Australia).

Waste disposal data for facilities is based on information provided by our waste disposal contractors.

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COMPLIANCE

	2014	2013	2012
Environmental			
Fines (\$)	23,200	27,309	75,359
Notices of violation	4	9	4
Safety			
Fines (\$)	1,600	0	9,000
Notices of violation	1	1	1
Transportation			
Fines (\$)	5,600	8,200	15,000
Notices of violation	3	2	1
Product safety			
Fines (\$)	0	1,469	0
Notices of violation	0	1	0

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CORPORATE INFORMATION

Koppers Inc.
436 Seventh Ave.
Pittsburgh, PA 15219-1800
USA
www.koppers.com

We invite your feedback on our sustainability efforts. Please direct comments and questions to:

Christina Clinton Evans
Communications Manager
EvansCC@koppers.com
(412) 227-2947