Sustainability Report 2023







SunCoke Energy®

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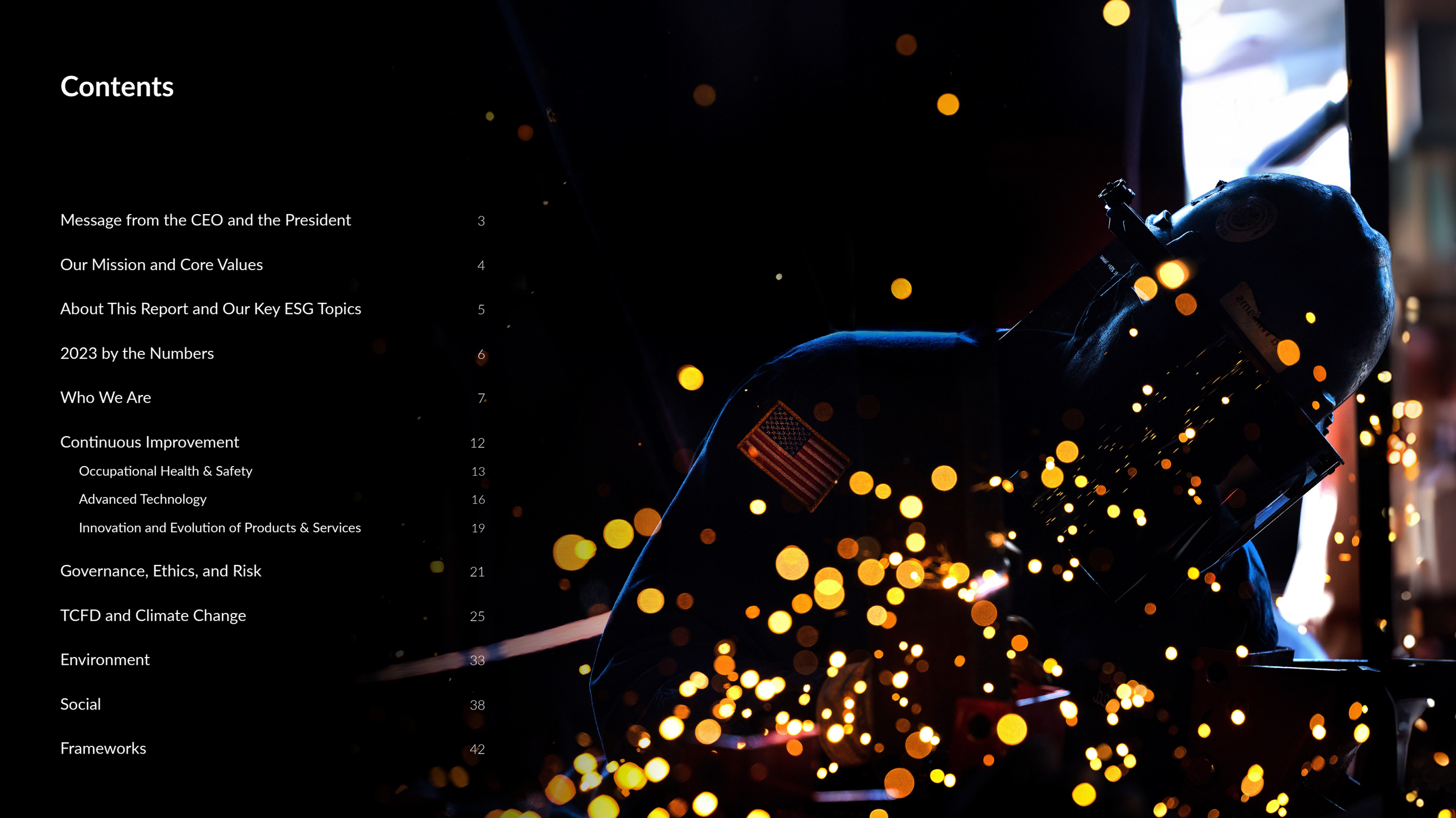
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Message from the CEO and the President

We are pleased to present SunCoke's 2023 Sustainability Report. Reflecting on this past year, it is clear that our successes were the result of the efforts of SunCoke's employees and we want to thank them for their sustained hard work and dedication.

At SunCoke, sustainability is understood as encompassing all business practices that contribute to the long-term resilience of our organization. In 2023, we took strides to advance initiatives across our **Sustainability Foundations**:

1. Occupational Health and Safety;
2. Advanced Technology for Leading Environmental and Operational Performance; and
3. Innovation and Evolution of Products & Services.

Our Sustainability Foundations form the basis for how we approach long-term value creation for our shareholders, customers, and employees.

Occupational health and safety remained our top priority in 2023. We have taken measures to continuously improve upon our existing safety initiatives and procedures. Our approach to improvement has been characterized by efforts to standardize a uniform safety system where possible, resulting in consistent safety performance and better knowledge sharing across our sites. In terms of key safety metrics, we maintained a Total Recordable Incident Rate (TRIR) of 0.99 for 2023, which remains lower than the industry average for the "All Other Petroleum and Coal Products Manufacturing" and "Iron and Steel Mills" sectors.

In addition to our diligent attention to our safety performance, our operational and financial performance remained strong in 2023. We continued to make capital investments that will position us to continue to deliver value to our shareholders in the years to come. In 2023, we invested $94.5 million in maintenance and growth capital to ensure that our facilities are safe, efficient, reliable, and environmentally compliant, and to advance our growth projects. This marked a significant increase in 2023 compared to our typical annual run-rate of $80 - $85 million, further emphasizing our commitment to investing in our facilities.

The strong operational performance that comes from these investments provides the basis to grow and diversify our customer and product base. Additionally, in 2023, we completed a capital project for foundry coke screening at our Jewell plant that allows for more efficient and effective sorting of foundry coke prior to shipment—saving time, increasing product yield, lowering emissions, and more efficiently allocating operational expenses. We continue to advance in the foundry market as we secure patents for our innovative approaches.

This culture of continuous improvement is embedded across our operations. This year's Sustainability Report showcases our culture of innovation and continuous improvement across our Sustainability Foundations. We are committed to implementing and advancing initiatives that allow us to maintain our role as a critical part of the steel value chain and a positive contributor to the communities in which we operate. This approach allows us to improve operational performance while evolving to meet the growing and changing needs of the steel industry.

Steel will be a critical material in the ongoing energy transition. As a producer of coke—a key ingredient in the production of blast furnace steel—SunCoke forms a critical part of the supply chains that depend on steel to build sustainable energy infrastructure and solutions like electricity networks, wind turbines, electric vehicles (EVs), solar panels, and geothermal plants.

Beyond the energy transition, steel will remain a critical building block of our societies. We expect the demand for buildings, automobiles, and infrastructure to continue to drive demand for high-strength, high-quality steel. SunCoke can produce the coke critical for the production of this steel and can do so reliably, a trait that is becoming increasingly critical when other coke producers shut down plants and supply chains are compromised. We are proud of our safety, community, and environmental performance and our ability to support our partners in achieving their own supply performance goals.

Looking forward, we see three specific opportunity areas to help the industry meet evolving demands that would also further solidify our place as a critical player in the steel value chain.

First, we will continue to work closely across the industry as a technical partner, committed to education and awareness for our industry and sharing technical expertise with customers in our value chain for mutual benefit.

Second, we will continue to maintain strong customer relationships and optimize our operations, which employ the most environmentally sound cokemaking technology available, positioning ourselves as the preferred supplier of high-strength, high-quality coke. In addition, we will continue to explore opportunities and technology that will allow us to support our customers as the steel industry evolves.

Lastly, we will continue to adapt to market changes by leveraging our core competencies to diversify our customers and product offerings. This includes our continued expansion in the foundry coke market, our continuous business development efforts in logistics, and ongoing work on the potential partnership with U.S. Steel to manufacture Granulated Pig Iron (GPI) at the Granite City Works facility.

As we further evaluate the energy and lower carbon economy transition, including the impacts on SunCoke and others in the steel industry, we are challenged to think more strategically about the long-term. We see opportunities in these challenges, such as growing our participation in the U.S. coke market as competitors' aging and less environmentally friendly facilities go offline, and will focus on further integrating sustainability into our business while assisting our customers in meeting their sustainability goals.





Michel G. Rippey
Chief Executive Officer

Katherine Gates
President

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Our Mission and Core Values

Our Mission

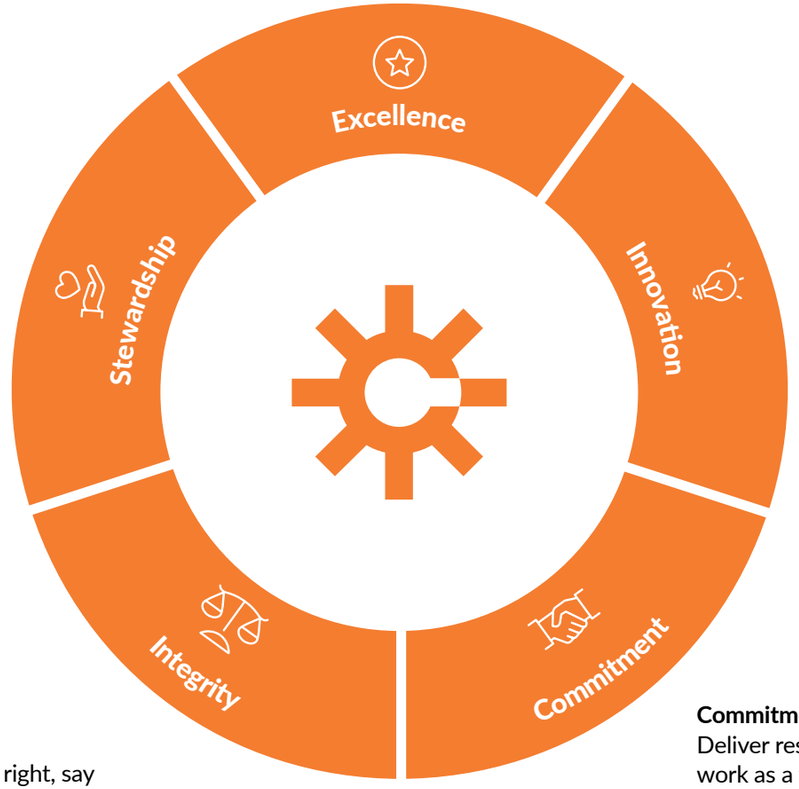
To meet the needs of our customers by providing high-quality products and logistics services, while operating our facilities safely, efficiently, and responsibly.

We develop and manage all products and services to meet our rigorous quality standards and the specific needs of our customers. We are working to profitably grow our Company and create value for investors through our current coke and logistics businesses as well as other opportunities.

Core Values

SunCoke's values of Excellence, Innovation, Commitment, Integrity, and Stewardship are at the heart of who we are and how we work every day. Those values guide our actions and decisions so that we can always strive to do the right thing for our stakeholders, our business, and each other.

Excellence
Expect the best from yourself, remove obstacles, inspire and support others, embrace diversity, and celebrate success.



Innovation
Master the science and process, create a better way, find a better solution, and push the envelope.

Stewardship
Provide safe, reliable, and environmentally sound operations for our people and their families, our customers, and the communities where we do business.

Integrity
Do what is right, say what you mean, do what you say, earn trust, and treat others with respect.

Commitment
Deliver results, be accountable, work as a team, continuously improve and grow, and always communicate effectively.

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Disclosure Frameworks

Our fifth annual Sustainability Report covers our sustainability data and performance metrics for calendar year 2023 and has been informed by the Global Reporting Initiative (GRI), the Sustainability Accounting Standards Board (SASB), and the recommendations of the Taskforce on Climate-related Financial Disclosures (TCFD).

As a raw material supplier to the steel industry, our risks, exposures, and key ESG topics align most closely with the steel industry and relevant ESG disclosure frameworks. As a result, several of the SASB topics and metrics addressed herein are from the SASB Iron & Steel Producers Standard. We will continue to assess our disclosures annually and include additional relevant information as it becomes applicable.

Our Key Environmental, Social, and Governance (ESG) Topics

In this report, SunCoke defines key ESG topics as those that may:

1. Have an impact on the Company's business strategy in the short and/or long term;
2. Have an impact on the environment or society now or in the future; and/or
3. Influence the assessments, decisions, and actions of our stakeholders.

This report generally focuses on eight key ESG topics that we deem to be most relevant to our cokemaking and logistics operations, and describes our management approach and strategy related to each of them.

For any questions regarding our sustainability reports and disclosures, please contact **sustainability@suncoke.com**.

Our Key ESG Topics[1]

- Occupational Health & Safety
- Air Emissions
- Community Engagement & Relations
- Energy
- Employee Development, Retention, and Diversity
- Environmental Compliance
- Climate Change Management
- Waste

[1] See the section on "Enterprise Risk" for more information on SunCoke's key ESG topics and our process for identifying them.



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2023 by the Numbers

#1

Independent coke producer in the U.S. by annual output

5.61M t
Total coke produced

4.05M t
Domestic coke produced

40M t
Processing capacity across logistics terminals

$249.0M
Operating cash flow

$268.8M
Adjusted EBITDA
Earnings Before Interest, Taxes, Depreciation, and Amortization

$63.5M
Net Income

$94.5M
Maintenance and Growth Capital

0.99
TRIR

46%
Open position filled with internal candidates

1,151
Employees
871 in the U.S.

1%
Regrettable turnover

692,000 MWh
Electrical power produced by SunCoke facilities

63,000
Homes that could be powered by the electricity generated at SunCoke facilities

Continuous Improvement in Action

Awarded the National Maintenance Agreements Policy Committee Zero Injury Safety Incidents Award (ZISA) for the Heat Recovery Steam Generator (HRSG) upgrades project at the Haverhill plant.

One new patent issued for innovation in foundry coke with another patent pending.

Completed a capital project for foundry coke screening at our Jewell plant that allows for more efficient and effective sorting of foundry coke prior to shipment.

Invested $94.5 million in maintenance and growth capital to ensure that our facilities are safe, efficient, reliable, and environmentally compliant, and to advance our growth projects. This marked a significant increase in 2023 compared to our typical annual run-rate of $80 - $85 million, further emphasizing our commitment to investing in our facilities.

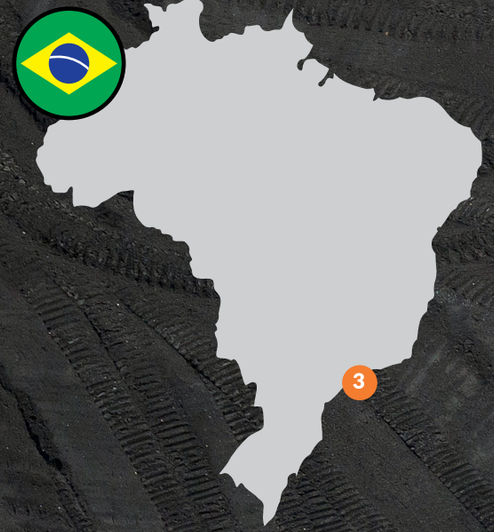
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Who We Are

Where We Operate







Headquarters

★ Lisle, IL

Cokemaking

1. Jewell Coke
2. Indiana Harbor
3. Vitória, Brazil
4. Haverhill 1 and 2
5. Granite City
6. Middletown

Logistics

7. Lake Terminal
8. KRT Ceredo
9. KRT Quincy
10. Convent Marine Terminal

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Industry Leaders in Safety, Operational Excellence, and Innovation.

SunCoke Energy, Inc. (SunCoke or the Company) is a proud member of the steel industry, manufacturing blast furnace coke, a key raw material for the production of blast furnace steel, for domestic and global steel customers, as well as foundry coke, another key raw material critical for foundry cupola furnace operation. Additionally, SunCoke produces steam and power from waste heat recovery, which either is utilized by the customer or goes to the power grid.

SunCoke's origins can be traced back to 1960 with the construction of 3 test ovens at the Jewell cokemaking facility in Vansant, Virginia.[2] We have expanded significantly since our founding—today, SunCoke is the largest independent producer of high-strength, high-quality coke in the Americas. SunCoke is headquartered in Lisle, Illinois. After over 65 years since our founding, we now operate six cokemaking facilities—5 in the U.S. and one in Brazil.

Additionally, we operate four logistics terminals in the U.S. that process raw materials and act as intermediaries between our customers and end users for both the U.S. and global export markets. In 2023, approximately 85% of our adjusted EBITDA was from production of coke (blast furnace and foundry combined), while roughly 15% was from our logistics services. Our growth has been, and still is, fueled by a drive to innovate and enhance our performance. An innovation that set SunCoke apart early on was our development of heat-recovery cokemaking technology, designed to combust the coal's volatile components liberated during the cokemaking process and use the resulting heat to create steam or electricity for sale. We are the only North American coke producer that utilizes heat recovery technology in the cokemaking process, allowing us to produce coke more efficiently and with a lower environmental impact than our peers.

More recently, we began to expand beyond blast furnace coke production into the development of foundry coke, keeping our place as an innovator in the industry. Our entry into the foundry coke market, with annual demand of approximately 600,000 tons in the U.S. and Canada, coincided with the closure of all the remaining U.S.-based foundry coke producers but one, leaving a significant supply deficit that SunCoke has filled.

[2] Today, the Jewell cokemaking facility is still in operation and produces all of SunCoke's foundry coke.

We continue to develop our foundry business by prioritizing research and development (R&D) and reinvesting our profits into the Company through capital improvement projects. The benefits of our approach are passed on to our customers in the form of product and production reliability and improvements in product quality.

Metal products manufacturing in the U.S. is evolving to meet the demands of changing environmental, economic, and political landscapes and our history of innovation makes us perfectly suited to act as a reliable partner through this process. Customers can rely on our high-strength, high-quality coke to support their business needs.

Note: SunCoke is not a coal miner and has not been involved in coal production for nearly a decade, having divested our mining operations in 2016.

Blast Furnace Coke
Blast Furnace (BF) Coke is a key raw material for the production of blast furnace steel.

In a blast furnace, coke is used as a fuel and reducing agent to remove oxygen in the smelting of iron ore. That ore is then fed into basic oxygen furnaces where it is turned into steel.

Foundry Coke
Foundry Coke is used in cupolas to melt metals so that they can be poured into casts.

Examples of metal casting products include engine blocks and fire hydrants. Smaller size foundry coke can be used for sugar and mineral wool manufacturing.

Logistics
Our terminals act as intermediaries between our customers and end users by providing transloading and mixing services for materials that are transported in numerous ways, including rail, truck, barge, or ship.



Our high-quality coke allows our customers to use less coke while maintaining optimal blast furnace operations, helping them to lower the greenhouse gas (GHG) footprint of their steel manufacturing processes.

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Cokemaking Operations

Coke is manufactured by processing metallurgical coal in specialty coke ovens to remove the volatiles and produce a high-stability, specifically sized carbon product that is used as a critical input to the blast furnace production of steel, or for melting iron and other metals in foundry cupolas.

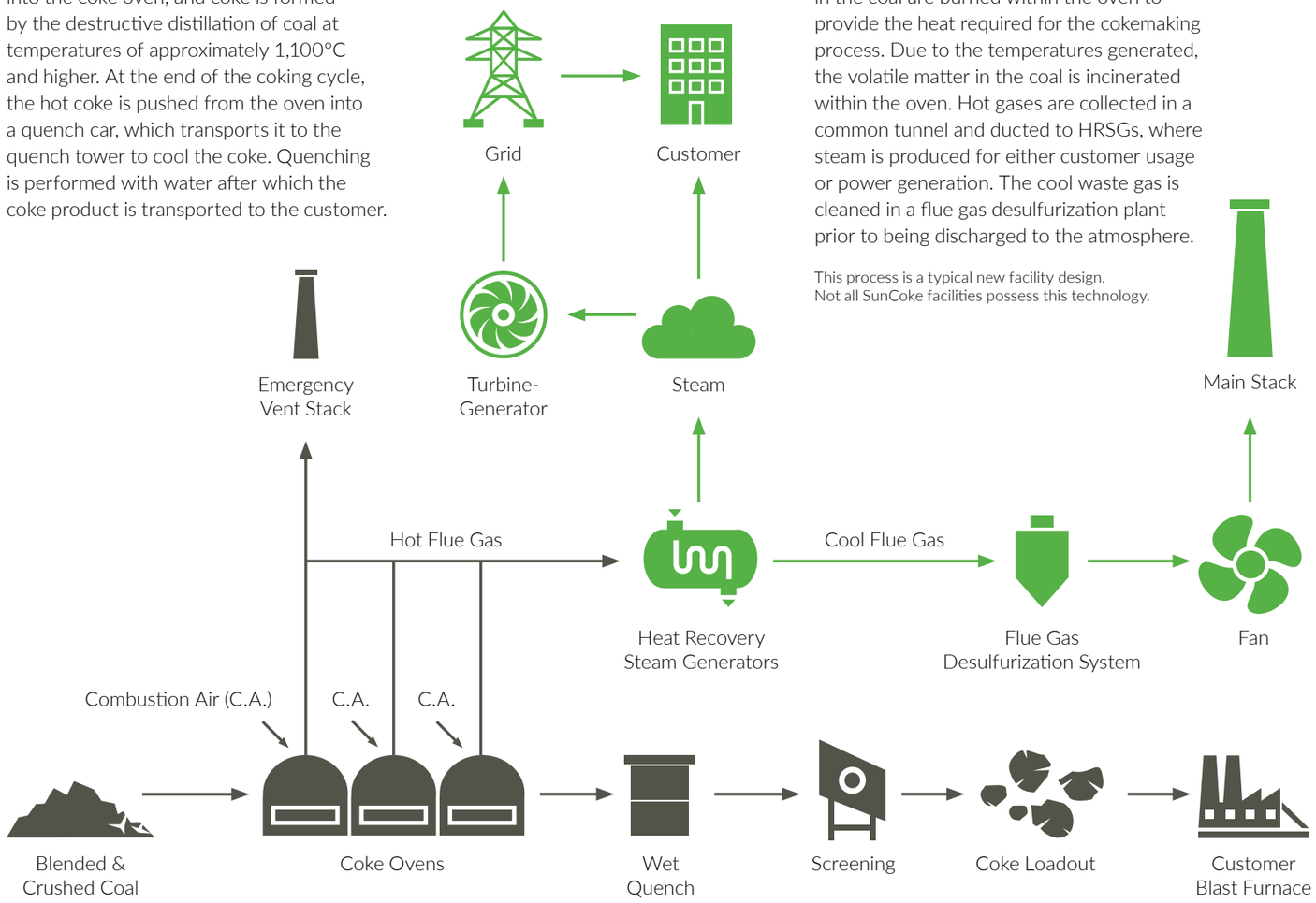
Globally, we have a total of approximately 5.9 million tons of annual blast furnace cokemaking capacity. Our five U.S. facilities, located in Illinois, Indiana, Ohio, and Virginia, have a combined total nameplate capacity of approximately 4.2 million tons of blast furnace coke annually. Our innovative technology produces high-strength, high-quality blast coke in the larger sizes preferred by blast furnace steel customers because it allows them to use less coke while maintaining optimal blast furnace operations, helping them to lower the GHG footprint of their steel manufacturing processes.

To diversify our business and customer base, we began developing and testing foundry coke in 2020, entered the market in 2021, and grew our market participation subsequently in 2022 and 2023. Foundry coke is a specialized type of coke that is used at foundries to melt iron and various metals in cupola furnaces. Further processing via casting or molding creates products used in various industries such as construction, transportation, and industrial products.

Our Middletown and Haverhill facilities produced 692,000 MWh of electricity in 2023, which is nearly the amount of power 63,000 families or homes need for an entire year.

Cokemaking Process

Selected coals are screened, crushed and blended to meet customer specifications for coal and coke quality. The blend is charged into the coke oven, and coke is formed by the destructive distillation of coal at temperatures of approximately 1,100°C and higher. At the end of the coking cycle, the hot coke is pushed from the oven into a quench car, which transports it to the quench tower to cool the coke. Quenching is performed with water after which the coke product is transported to the customer.



Heat-recovery cokemaking

In heat-recovery cokemaking, the volatiles in the coal are burned within the oven to provide the heat required for the cokemaking process. Due to the temperatures generated, the volatile matter in the coal is incinerated within the oven. Hot gases are collected in a common tunnel and ducted to HRSGs, where steam is produced for either customer usage or power generation. The cool waste gas is cleaned in a flue gas desulfurization plant prior to being discharged to the atmosphere.

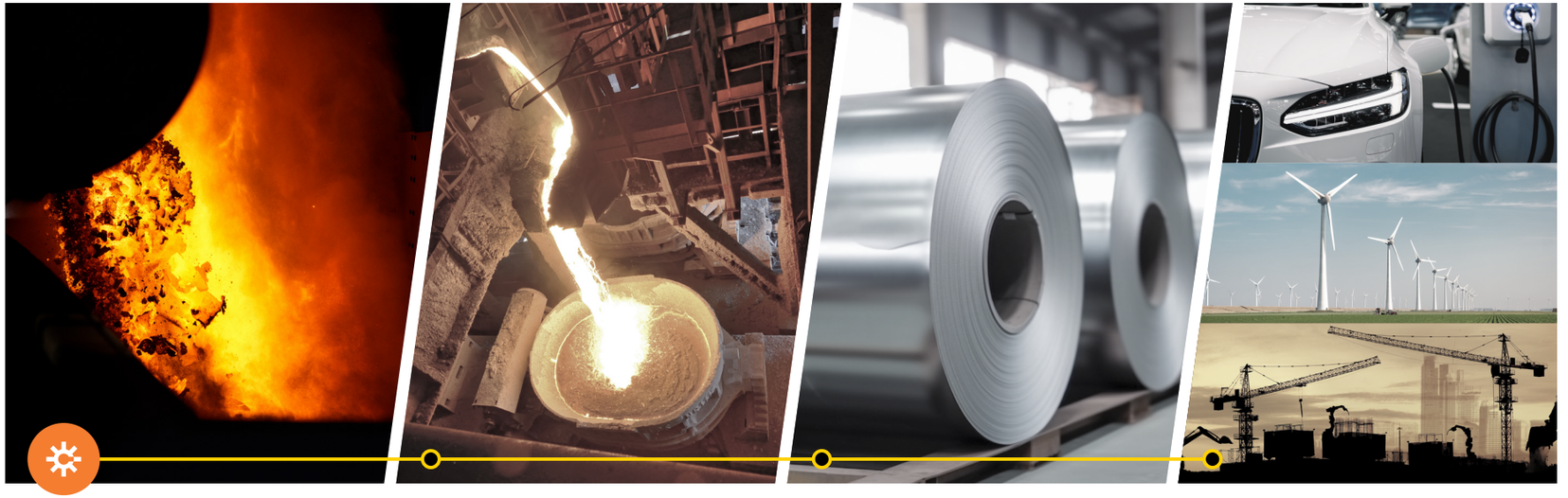
This process is a typical new facility design.
Not all SunCoke facilities possess this technology.

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Stages of the Steelmaking Process

SunCoke produces a critical input to the steel making process for the highest-strength flat-rolled steel manufactured in the U.S. In the steelmaking process, SunCoke operates in the cokemaking stage, which is the process of transforming metallurgical coal into coke—a high carbon-content fuel primarily used in steel production. The coke is sold to major steel producers where it is utilized as a fuel in their blast furnaces. These furnaces reduce iron ore to molten iron, which is then transferred to a basic oxygen furnace to be turned into steel.

The high-strength, high-purity steel that is produced from the coke supplied by SunCoke is sold domestically and internationally to be used in many industries such as automotive, energy, and construction.



Cokemaking

Coal is “charged” (i.e., loaded) into the coke oven, and coke is formed by the destructive distillation of coal at temperatures of approximately 1,100°C and higher. At SunCoke’s facilities, this process is completed under negative pressure, reducing the potential for emissions.

Foundry Production

We also produce and sell foundry coke out of our Jewell cokemaking facility. Foundry coke, a material necessary for numerous critical manufacturing components, is a high-quality type of coke that is used at foundries to melt iron and various metals in cupola furnaces, which is further processed via casting or molding into products used in several industries such as construction, transportation (i.e., engine blocks) and industrial products.

Steel Manufacturing

SunCoke’s customers use coke as fuel and a reducing agent in their blast furnaces where they reduce iron ore to create molten iron, which is then heated in a basic oxygen furnace to be turned into steel.

Development of Steel-Based Products

The liquid steel is then cast in various ways to create a variety of steel-based products, each of which services a specific group of end markets.

End Markets

Blast furnace steel-based products are primarily used in the production of automobiles, appliances, and infrastructure. Additionally, blast furnace steel-based products are becoming increasingly critical in the energy transition where they are used in the production of EVs, hydro power, wind power, and more.

When the steel industry is strong, local communities across the U.S. are able to thrive.

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SunCoke's Role in a Sustainable Steel Industry

Coke: A Key Input for Steel Production

In order for blast furnace steel production to occur, metallurgical coal must first be converted into coke. Coke acts as a vital reducing agent in the steelmaking process and can also be used to melt iron and other metals in foundry cupolas. As such, SunCoke plays a critical role in initial phases of the steelmaking process. SunCoke's role has become more critical as we fill gaps in the supply chain created by the closure of competitors' plants.

Additionally, our coke will remain critical to support the burden structure and gas distribution (the burden is the charge to the blast furnace) as steel companies explore the use of hydrogen injection and other green additives in the steel making process.

SunCoke's Cokemaking Process

What sets us apart is the quality of our coke, which is a direct result of how we approach coke production. First, selected coals are screened, crushed, and blended to meet customer specifications for coal and coke quality. The blend is then charged into the coke oven, and coke is formed by the destructive distillation of coal at temperatures of approximately 1,100°C and higher. At the end of the coking cycle, the hot coke is pushed from the oven into a quench car, which transports it to the quench tower to cool using water, after which the coke product is transported to the customer.

Importance of Steel to the American Economy

The steel industry has always been at the core of the U.S. economy, feeding into critical industries including the automotive sector, buildings, and infrastructure. Steel was at the center of the first industrial revolution, and it will continue to play a role as our global economy navigates the current energy transition and related investments into new infrastructure development.

According to a past study by the American Iron and Steel Institute (AISI), the American iron and steel industry accounts for more than $520 billion in economic output in the U.S. economy, and supports nearly 2 million jobs in the U.S. when considering the direct, indirect (supplier), and induced impacts.[3]

The broader community impact this industry has had across the country is also notable. When the steel industry is strong, local communities across the U.S. are able to thrive.

Supplying Domestic and International Markets

In addition to playing a critical role within the U.S. steel market, we continue to explore opportunities to increase our production, domestic distribution, and exports of coke into new and expanding markets. The consistent high-strength and high-quality of our coke is recognized across markets.

The Future of the Steel Industry

We recognize that the landscape for the steel industry is changing. There are three critical trends that we believe will influence the industry's direction in the coming years:

1. Automotive Industry – EVs

   The high-quality steel produced using coke is a critical input in the construction of EVs, a segment of the automotive industry that is growing in the U.S. and globally. EVs weigh significantly more than internal combustion engine vehicles due to the weight of their batteries. High-strength, lightweight steel helps to offset the weight of the batteries, ensuring that EVs are able to travel practical distances safely.

   As automakers increase their pursuit of scaling up their EV production to facilitate the energy transition, their need for reliable products will continue.

2. Resilient building and infrastructure needs due to climate change

   As developers see an increase in volatility in the physical environment due to changing climate conditions, there is a need to ensure buildings and other infrastructure are constructed with high-quality, reliable products. Blast furnace steel is a key material for the development of these structures, and high-quality steel is produced by high-quality coke. Because designs are likely to face increased requirements to be more resilient to the physical environment, we anticipate blast furnace steel will remain a critical product in the development of these structures.

3. Responsible supply chains

   Customers across industries are increasingly examining their supply chains for environmental and social performance, including the steel value chain. Customers and purchasers want to be assured that the partners they are working with are producing quality products, and are doing so in an ethical and safe manner. SunCoke is proud to be an employer that adheres to rigorous safety standards, protects workers' rights, and acts as a responsible participant in the steel value chain.



[3] AISI, "The Economic Impact of the American Iron and Steel Industry," https://www.steel.org/economicimpact/#:~:text=According%20to%20a%20recently%20released,(supplier)%20and%20induced%20impacts.

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Continuous Improvement

Our efforts in 2023 demonstrated our continued commitment to SunCoke's Sustainability Foundations, which are:

Occupational Health and Safety

Advanced Technology for Leading Environmental and Operational Performance

Innovation and Evolution of Products and Services

Our Sustainability Foundations are advanced through SunCoke's culture of continuous improvement. When these sustainability foundations are strategically aligned and continuously improved upon, they drive more efficient, cost-effective, and sustainable operations.

This section highlights key achievements from 2023 that demonstrate our culture of continuous improvement and how it is helping us advance our sustainability priorities across our organization.

Timeline of Continuous Improvement by SunCoke

1998
Indiana Harbor facility became the first plant in the world to use heat recovery with flue gas desulfurization (the environmental treatment of waste gases).

2006 – 2009
Our Haverhill 1 and Haverhill 2 facilities were constructed and brought online with process steam and power generation capabilities.

2011
Our Granite City facility was constructed and brought online to provide coke and process steam to U.S. Steel Granite City Works.

2012 – 2013
Our Middletown facility was constructed and brought online with power generation capability.

2016
Completed gas sharing upgrades at Haverhill and Granite City plants, reducing emissions during maintenance.

2019
Formation of SunCoke's first Sustainability group.

2020
Publication of SunCoke's first Sustainability Report and CDP Climate Change Response.

2021
Beginning of foundry coke production at SunCoke's Jewell Plant.

2023

- TRIR Significantly lower than Average Industry-Wide Rates.
- Awarded the National Maintenance Agreements Policy Committee ZISA for the HRSG upgrades project at the Haverhill plant.
- Maintained our goal of zero injuries in the workplace.

- SunCoke heat recovery technology generated enough electricity to power 63,000 homes in 2023.
- Over $94M invested in maintenance and growth capital.
- Completed the foundry coke screener project at the Jewell plant.

- We were issued a new patent for our innovations in foundry coke, with another patent pending. These patents relate to foundry coke's efficiency, ultimately allowing our customers to use less coke in their cupola, also lowering their CO_2 footprint.
- Continued to provide technical support for our customers.
- Continued to look for new markets to grow service and product offerings.

Looking Ahead

- Continue to work toward our safety goal of zero incidents.
- Advance our climate and sustainability priorities. *See "TCFD and Climate Change" for more information.*
- Continue allocating capital to projects that increase operational and environmental performance.
- Work to obtain third-party verification for Scopes 1 and 2 GHG emissions.

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SUSTAINABILITY FOUNDATION #1

Occupational Health & Safety

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Maintaining the Health and Safety of Our Employees and Contractors

Safety is our highest priority at SunCoke, and we therefore consider it to be one of our key ESG topics. We live by the ethos: Think Safe. Act Safe. Be Safe. We believe every job can and should be done safely every day. Through continued training and active safety leadership, we instill in our employees that a safe and healthy workplace is everyone's responsibility.

Our Safety Management Program is designed to detect potential health and safety issues, identify new or changing regulations, find opportunities for improved safety in our operations, and take appropriate actions as needed.

Our goal is to ensure that all employees and contractors understand how their individual actions contribute to the successful execution of our safety program and performance. We train and assess team members and contractors on SunCoke's Safety Vision and Safety Program annually. Additionally, in 2023, we implemented a more rigorous contractor onboarding process that was put in place for all capital projects. During the implementation of these projects, we have rigorous programs to ensure that contractors or those who do not frequently work on SunCoke sites are able to operate safely alongside our SunCoke employees.

To further emphasize their importance, both safety and environmental performance are included as metrics in our annual incentive program.

We live by the ethos:
Think Safe. Act Safe. Be Safe.

Safety Vision to Achieve Our Goal of Zero Incidents

We have a goal of zero injuries in the workplace. Our efforts were recognized by being awarded the National Maintenance Agreements Policy Committee Zero Injury Safety Incidents Award (ZISA) for a large equipment upgrade project at the Haverhill plant. This award recognizes that SunCoke and its contractors worked 57,408 hours to complete the project without incident. This recognition fuels us to continue to push for ever-better safety performance.

To reach our goal of zero incidents and injuries, we follow our **Safety Vision**, which includes five core components:



Visible Safety Leadership
Site and corporate leadership are committed to safety as the paramount value within the Company, and our site leadership practices Visible Safety Leadership on a daily basis.



Communication and Training
All team members and contractors must take responsibility for their own safety and the safety of those around them, and we train to ensure proper safety knowledge.



Safe Work Practices
All team members and contractors take the time necessary to properly identify and mitigate all hazards and safely do each job.



Incident Investigation
We have a structured process for investigating incidents and perform root cause analysis of significant incidents.



Continuous Improvement
We are always focused on preventing safety incidents and Thinking Safe, Acting Safe, and Being Safe. Continuous improvement is reflected across all practices, including safety.

SunCoke Visible Leadership Program

We build a culture of safe work beginning in the field with site leaders practicing Visible Safety Leadership on a daily basis. Site leaders conduct daily Safety Observations in which teams pause and review all identified hazards and proper safety procedures associated with a task prior to continuing. Site leaders include the General Manager, Operations Manager, Maintenance Manager, Safety and Environmental Personnel, Engineering Personnel, Area Owners, Team Leaders, Supervisors, and any other field supervisory personnel. Management has an expectation of safe work practices, provides oversight, and delivers feedback on safety processes.

Our safety program requires that SunCoke provide training and information to the appropriate contractor representative(s) for the SunCoke Visible Safety Leadership program. Contractors are then responsible for training each of their on-site personnel and any subcontractor personnel on this process and their specific responsibilities within it prior to beginning work.

Striving for Continuous Improvement to Safety

At an enterprise level, SunCoke monitors safety performance across facilities and creates corporate safety goals for SunCoke to implement, in addition to our site-specific goals. Safety statistics are reviewed on a routine basis to track our progress against our goals.

Progress toward these goals is supported by capital expenditure projects that aim to continuously make our plants and logistics facilities safer.

Incident Investigation

For all safety-related incidents, SunCoke ensures that incidents are properly investigated and, where warranted, conducts a root cause failure analysis, with corrective actions completed if needed. Safety Managers are responsible for communicating takeaways and lessons learned from each safety incident to both facility and enterprise employees.

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Safety Performance

Our year-over-year safety performance is consistently better than average industry-wide rates. According to the Bureau of Labor Statistics, the Total Recordable Incident Rate (TRIR) within our sector of All Other Petroleum and Coal Products Manufacturing was 3.1 for 2022. The Iron and Steel Mills sector was 2.2 in 2022. Our target TRIR at SunCoke for 2023 was 0.80 company-wide, and we achieved 0.99 TRIR at the end of the year. TRIR is a key safety metric because it captures a company's safety performance by calculating the number of recordable incidents per 100 full-time workers during a 1-year period. The lower the TRIR, the better a company's safety performance. SunCoke's TRIR is calculated based on employee and contractor incident rates, reflecting our goal of continuously improving the safety of all who work on SunCoke's sites.

Another key safety metric is Lost Time Incident Rate (LTIR). It is used to record the average number of incidents leading to an employee being unable to work for a minimum of 1 day during a 1-year period. Our total LTIR for 2023 was 0.68.

Our year-over-year safety performance is significantly lower than average industry-wide rates and our TRIR measured 0.99 for 2023.

Incident Summary by Type[4]

Year	2021	2022	2023
Total Fatalities	0	0	0
Total TRIR[5]	0.76	0.69	0.99
Total LTIR	0.24	0.28	0.68
Total Near Miss Frequency Rate	15.42	17.00	12.96

Employee and Contractor Breakdown for Recordable Injuries

Year	2021	2022	2023
Employee TRIR	0.77	0.82	1.31
Employee LTIR	0.46	0.45	0.94
Contractor TRIR	0.75	0.53	0.71
Contractor LTIR	0.08	0.09	0.45





[4] This data is representative of both U.S. and Brazil operations and includes contractor statistics.

[5] TRIR = includes MSHA reportable incidents.

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SUSTAINABILITY FOUNDATION #2

Advanced Technology

for Leading Environmental and Operational Performance

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Overview

We rose to and have remained in our role as an industry leader because we continue to improve upon our technology, increasing operational efficiency and environmental performance. For example, in 2023, we completed a capital project for foundry coke screening at our Jewell plant that allows for more efficient and effective sorting of foundry coke prior to shipment—saving time, increasing product yield, lowering emissions, and more efficiently allocating operational expenses.

We continue to refine what is already the leading cokemaking technology in the industry. Our innovative heat-recovery cokemaking technology sets the bar for environmental performance. The technology allows us to capture excess heat from our ovens to produce steam and generate electrical power, making our coke production the most energy-efficient in the industry. We lead the industry as the only U.S. coke producer to utilize such a process in our operations.

We continue to evaluate and invest in innovations that improve our processes, increase energy efficiency, realize climate-related opportunities, and mitigate climate-related risks. In past years, these enhancements have included cokemaking processes that increase the metallurgical coal to coke yield, which may enable us to reduce the amount of carbon emitted per unit of coke produced.

Striving for Continuous Improvement in Advanced Technology

Foundry Coke Screening Project at Jewell

Foundry coke production capacity at our Jewell plant has been increasing significantly. To accommodate this shift, we invested in a foundry coke screener that allows us to sort coke more efficiently before it is loaded for shipping. The screener reduces the need for handling and transportation prior to shipping, leading to increased yield of foundry coke, and reducing emissions from coke handling.

Increasing Yield at Jewell

At the Jewell plant, we implemented a significant improvement project to improve our efficiency when charging our ovens. By implementing and designing a new piece of equipment to better direct coal into the ovens during charging, we reduced coal loss from ground spillage, helping to improve operational efficiency.

Haverhill Fuel Tanks Initiative

In assessing further opportunities to improve our operational efficiency as well as our environmental impact, this past year we installed larger fuel storage tanks at our Haverhill plant. Larger fuel tanks have allowed us to reduce annual total fuel deliveries to the plant by over 70%. Hence, larger fuel tanks have reduced delivery costs and reduced emissions from deliveries to the plant.

Superior Technology that Sets the Industry Standard

We are a technological leader in cokemaking. Our advanced HRSG cokemaking technology has numerous advantages over by-product cokemaking, including:

- Producing higher quality coke
- Using waste heat to generate derivative energy for resale
- Producing minimal hazardous waste
- Generating no hazardous by-products and virtually no hazardous air pollutants

Our technological advances have created distinct advantages that improve iron and steelmaking economics and environmental performance when compared to our competitors, some of whom have struggled to comply with environmental standards.

Our technology set an example and served as the basis for the U.S. national establishment of Maximum Achievable Control Technology (MACT) standards, developed under the Clean Air Act of the U.S. Environmental Protection Agency (EPA). These standards use the hazardous air pollutants of the best-performing ("Maximum Achievable") industry sources to set the standard that an industry must meet in order to comply.

Additionally, all heat-recovery cokemaking facilities that we have built in the U.S. since 1998 have either met or exceeded the Best Available Control Technology or Lowest Achievable Emission Rate standards as set forth for cokemaking facilities. All of these points demonstrate that our facilities consistently excel at minimizing air emissions of concern for the environment and human health.

Negative Pressure and Co-Generation

Our cokemaking ovens operate on a regenerative principle that transforms coal into solid state carbon (coke), and releases entrained volatile matter into gases. While under negative pressure, these gases are thermally destroyed during the coking cycle, which reduces the environmental impact.

Operating the ovens under negative pressure causes air to be pulled into the oven through air ports on each oven door and sole flue, maximizing temperatures by allowing air to flow into the oven. This approach enables the combustion of volatile and polyaromatic carbon compounds and prevents the leaking of flue gases into the atmosphere. The excess heat produced in this process is converted to steam and/or electricity through HRSGs and steam turbines.

Through our heat-recovery process, we generate power with no additional GHG emissions. We provide this energy to our customers, allowing us to play a role in reducing their reliance on other types of fuel and reducing their own value-chain GHG emissions. Indiana Harbor, built in 1998, became the first heat recovery plant in the world that integrated heat recovery with flue gas desulfurization.

A typical heat-recovery facility that we design and operate to produce 1.1 million tons of coke per year can generate more than 90 megawatts of electric power per hour.

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Our Cokemaking Facilities and their Innovative Use of Waste Heat

Owned and Operated

Facility	Location	Year of Startup	Annual Cokemaking Nameplate Capacity (1,000 tons)	Use of Waste Heat
Jewell	Vansant, VA	1962	720	Partially used for coal drying
Indiana Harbor	East Chicago, IN	1998	1,220	Heat for power generation
Haverhill 1	Franklin Furnace, OH	2005	550	Process steam
Haverhill 2	Franklin Furnace, OH	2008	550	Power generation
Granite City	Granite City, IL	2009	650	Steam for power generation
Middletown	Middletown, OH	2011	550	Power generation

Operated

Facility	Location	Year of Startup	Annual Cokemaking Nameplate Capacity (1,000 tons)	Use of Waste Heat
Vitória	Vitória, Brazil	2007	1,700	Steam for power generation

[6] CSR = coke strength after reaction

[7] PAH = polycyclic aromatic hydrocarbon

[8] RCRA = Resource Conservation and Recovery Act; regulates waste generation and disposal, including hazardous waste

[9] CWA = Clean Water Act; regulates discharge of waste and stormwater to environment

[10] NPDES = National Pollution Discharge Elimination System; regulates permitting of discharge of waste and stormwater to environment

SunCoke's Heat-Recovery Process vs By-Product Process

SunCoke's Heat-Recovery Process

Air Quality

Coke is manufactured under negative pressure, pulling in ambient air and releasing virtually no hazardous air pollutants

Coal volatiles are combusted within the oven, resulting in virtually no emissions of hazardous air pollutants from equipment and oven doors

By-Products

No hazardous by-products are created in our process

Excess heat from coking is used to generate steam for our customers, a high-efficiency source of energy for their processes; OR

Excess heat from coking can also be used to generate electricity, providing a source of energy to our customers

Quality

Allows production of higher quality coke with a higher CSR[6] than a by-product plant using a similar coal blend, which in turn reduces the coke load required in the blast furnace

Hazardous Waste and Water

Produces minimal hazardous waste and does not require a chemical plant with wastewater discharge

By-Product Process

Air Quality

Coke created under positive pressure, allowing for leaking of coal combustion by-products such as PAHs[7] and benzol/benzene compounds from equipment and oven doors

By-Products

Coal volatiles evolved during coking process flow through ducts and are refined downstream in a chemical plant to produce coke oven gas and other by-products such as tar, light oil, and sulfur

Quality

Lesser quality, lower CSR coke from the same coal blend

Hazardous Waste and Water

Process produces both hazardous waste streams (RCRA[8]) and non-hazardous wastewater discharge streams (CWA[9]-NPDES[10])

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SUSTAINABILITY FOUNDATION #3

Innovation and Evolution of Products and Services

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Striving for Continuous Improvement in Innovation and Evolution

We are a technology driven company whose excellent product quality and reliability are evidenced by our long-term take or pay contracts. In addition, we continually monitor the market to look for opportunities to evolve our products. This was evidenced by our entry into the foundry market in 2021. We also strive for continuous improvement and innovation internally in our processes to optimize operational efficiencies and performance. In 2023, we invested $94.5 million in maintenance and growth capital to ensure that our facilities are safe, efficient, reliable, and environmentally compliant, and to advance our growth projects. This marked a significant increase in 2023 compared to our typical annual run-rate of $80 - $85 million, further emphasizing our commitment to investing in our facilities. The strong operational performance that comes from these investments provides the basis to grow and diversify our customer and product base. This focus on innovation and evolution allows us to adapt our business against changing market dynamics.

Foundry Coke
Foundry coke is a specialized type of coke that foundries use to melt iron and various metals in cupola furnaces. The resulting metal products are then further processed via casting or molding into products used in various industries such as construction, transportation, and industrial products. In the process of producing foundry coke, smaller coke sizes are also created, including egg coke, coke breeze, and coke dust. These smaller coke sizes can be used in sugar production from sugar beets, rockwool production, lead battery recycling, and power production, thus serving a wider range of customers.

Innovation

In 2023, we continued to invest in R&D to further refine our products and processes, such as our entry into the foundry market. An exciting output from this year's R&D efforts has been the development of a new foundry coke that began production in 2024. This new formula was developed by charging our coke ovens with a number of different coal blends to arrive at an optimal product.

These coal blends could not and cannot be run in by-product ovens as they would swell too much and break. In other words, our heat recovery coke making design unlocked the ability to produce coke from coal blends that other coke production technologies can't make. This is one of many examples of the way in which we, as a technology-driven company, leverage our assets to continuously innovate.

Patents: A marker of innovation

By their very nature, patents represent a formalized recognition of innovation. Throughout the years, we have been issued over 50 patents, and we continue to deploy our novel technology directly in our assets. Some of our most notable patents are related to our heat-recovery coking design and operation, including patents for pollution control systems, oven pushing and charging mechanisms, oven flue gas control mechanisms, reliability improvements and environmental control improvements. In 2023, we were issued a new patent for our innovations in foundry coke, with another patent pending. These patents relate to foundry coke's efficiency, ultimately allowing our customers to use less coke in their cupolas, also lowering their CO_2 footprint.

Key patents granted to SunCoke in 2023

- High-quality foundry coke*
- Higher activity foundry coke*
- Hydrated activated carbon for removing mercury from a flue-gas desulfurization system
- Corrosion resistant spray dry absorber
- Low particulate matter quench tower design

*The patented shape and chemical properties of our foundry coke provide improved performance in foundry cupola operations thereby enabling increased metal production and decreased coke usage.

Evolution

Our science and technology-driven approach to innovation is vital to our efforts to grow and evolve our business. As we evolve by entering into new markets, it is our culture of innovation that allows us to excel.

An excellent example of ongoing, successful evolution is our production of foundry coke. We entered the market in 2021 and grew the business by 30% in 2022.

Expanding into foundry coke has been beneficial to SunCoke because it contributes to our positive financial performance, diversifies our product line, and, from an environmental standpoint, it is relatively less carbon intensive than our blast furnace coke in the production process.

Our success in the foundry market is attributable to our ability to innovate in the space and to meet unfulfilled demand. Our entry into the market coincided with the closure of many U.S.-based foundry coke producers, leaving an annual demand of 600,000 tons in the U.S. and Canada. By producing foundry coke, we are playing a key role in keeping this critical industry in the U.S., including the local jobs and associated value chains.

Expanding Opportunities

SunCoke has identified select areas that present evolution opportunities. In 2022, SunCoke announced that it had entered a non-binding letter of intent with U.S. Steel to construct, own, and operate a state-of-the-art GPI plant at Granite City. Work continues on this potential opportunity that would allow SunCoke to supply critical materials to electric arc furnace (EAF) steel producers.

Technical Partnership

We see ourselves as a technical partner to the industries in which we operate. To enact meaningful change as technical partners, we work to ensure that, as we innovate internally, we disseminate that knowledge to industry groups, customers, and potential customers. Approaching those relationships as partnerships facilitates the co-evolution of ideas and contributes to the resilience of the value chain. For our customers, this includes assisting them on our products and how they can optimize their operations.

In 2023, a key avenue for developing technical partnerships was our employees' participation in committees organized by the AISI as well as the American Coke and Coal Chemicals Institute (ACCCI).

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Governance, Ethics, and Risk

Governance

Strong governance is an important aspect of SunCoke's culture. Our commitment to sustainable governance is led from the top, with clear accountabilities for oversight and implementation of our sustainability commitments.

SunCoke's Board of Directors currently consists of eight directors with proven records of professional success and leadership, all of whom demonstrate the highest personal and professional ethics. Each director is elected to a 3-year term of office and the Board considers a variety of factors, including the diversity of backgrounds and experience that would be brought to the Board when assessing candidates. Our Board has an Audit Committee, a Compensation Committee, and a Governance Committee.

Corporate governance at SunCoke is designed to promote the long-term interests of our stockholders, strengthen Board and management accountability, foster responsible decision-making, and engender public trust.

The Governance Committee and the Board are regularly briefed by representatives of the management-level ESG Steering Committee on ESG issues and disclosures. *See "TCFD and Climate Change" for more information.*

SunCoke Board's Responsibilities

- Oversight body for the management of SunCoke
- Reviews and approves the Company's strategic plan, operating plan, and major corporate actions
- Monitors the Company's performance, including senior executives
- Reviews and approves executive compensation
- Reviews and approves CEO and management succession plans

Ethics

At SunCoke, we view all employees as representatives of SunCoke, responsible for protecting our reputation for quality, professionalism and corporate responsibility, ethical behavior, and sound conduct. Ethical conduct is a cornerstone of the way that we do business.

We strive to act with integrity and look to our Code of Business Conduct and Ethics for the principles and values that guide our daily actions. All employees must complete annual training on our Code of Business Conduct and Ethics, which we review and update as needed. The most recent revision occurred this year.

We educate all employees to avoid potential conflicts of interest, in accordance with our Conflicts of Interest Policy. Our Prohibited Payments and Political Contributions Policy addresses payments made to U.S. officials, including campaign contributions. Our Gifts, Entertainment, and Sponsored Travel Policy provides guidance regarding business courtesies, including reporting obligations and value limitations. Our Human Rights Policy outlines our commitment to a fair living wage for all employees and affirms our commitment to sustainable business practices that ensure the wellbeing of our employees, customers, and communities in which we operate.

SunCoke Policies


Code of Business Conduct and Ethics


Health & Safety Policy


Political Contributions Statement


Environmental Policy


Human Rights Policy


Supplier and Vendor Code of Conduct

Guidance and Reporting Without Fear of Retaliation

All employees, officers, and directors are required to report any suspected Code of Business Conduct and Ethics Policy violations to the Compliance Team. We provide a variety of methods for anonymous feedback including a direct mail inbox, our confidential 24/7 reporting hotline, or our Workplace Ethics and Compliance Program website, among other methods.

Our hotline is administered by a third party and can be accessed by calling the toll-free 24/7 number: (877) 918-1997, or by visiting the website at https://suncoke.alertline.com. SunCoke's Compliance Team takes each submission seriously and investigates each inquiry. In addition to our anonymous hotline, hourly employees represented by a collective bargaining unit can also file a report using the applicable union grievance process.

At SunCoke, we view all employees as representatives of SunCoke, responsible for protecting our reputation for quality, professionalism and corporate responsibility, ethical behavior, and sound conduct.

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Sustainability-Linked Remuneration

Since SunCoke became an independent company in 2011, safety and environmental performance have been part of our compensation metrics. For 2023, safety and environmental performance each accounted for 10% of consolidated company performance goals within the annual incentive plan for all non-union employees, including executives.

Safety performance at SunCoke consists of an all-company target across our Coke, Consolidated, and Logistics business units, which is measured using the regulatory TRIR by OSHA and the Mine Safety and Health Administration (MSHA). To achieve performance of more than 100%, there must be no high severity incidents. High severity is defined as an injury resulting in permanent and total disability or resulting in a fatality.

Environmental performance is determined by a comprehensive assessment of (i) venting levels relative to each plant's operating permit or other agreements or allowances; (ii) the number of preventable "deviations," which are defined as non-conformance with an EPA air permit term; and (iii) consideration of other relevant factors. In conducting its assessment of these factors, the Compensation Committee uses a formulaic approach for (i) and (ii), but also applies its judgment when considering (iii) as a modifier.

Enterprise Risk

Enterprise Risk Management Process

To thoroughly assess risk throughout our operations, we utilize an enterprise risk management (ERM) process to identify and manage operational risks and risk owners. Our structured analysis of safety, environmental, and employee considerations allows process review by multiple levels of management.

Our Audit Committee and Board review key identified risks, and our Board and upper management strategize to reduce risk for the Company.

The ERM process is formally conducted annually; however, risks and risk mitigation are discussed with the Audit Committee and the Board regularly throughout the year.

Stakeholder Engagement

Identifying and managing our ESG risks and priorities requires a deep knowledge and understanding of the priorities and perspectives of a broad range of stakeholders. As we review our key topics, we consider the needs and expectations of both internal and external stakeholders. These stakeholder requirements and expectations shape the areas where we focus our ESG efforts.

Stakeholder	Engagement Approach
Investors	Discussing ESG topics in investor calls and sustainability reports. Supporting conversations with management on ESG strategy and objectives.
Customers	Coordinating on sourcing and blending of raw materials (e.g., metallurgical coal). Maintaining strong working relationships and participating in regular customer meetings. Regular quality meetings with customer representatives.
Government & Regulatory Agencies	Following well-established processes for compliance and reporting. Proactively communicating with agencies on ESG matters. Maintaining strong working relations with local, state, and federal regulators.
Suppliers	Engaging in long-term planning. Using our supplier management system. Requiring adherence to our Supplier and Vendor Code of Conduct.
Communities	Engaging with communities on various aspects of our operations. Conducting community outreach and investment.
Unions	Negotiating collective bargaining agreements. Respecting the right to form a union.
Potential Employees	Publishing sustainability disclosures and other external communications. Partnering with industry associations, local colleges, and hiring networks.



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Key ESG Topics

SunCoke reviews its key environmental and social topics and industry risks on an ongoing basis. Through this process, our leadership team and employees identify the topics of highest priority for SunCoke to actively manage, both domestically in the U.S. and abroad.

SOCIAL

Occupational Health & Safety

Safety processes and procedures that ensure continued safety throughout all business processes.

Associated Risk & Opportunity
Ensuring the continuous health and safety of our employees and contractors in the work environment.

Community Engagement & Relations

Meaningful engagement with the communities in which we operate and giving back in a variety of ways.

Associated Risk & Opportunities
- Developing and maintaining strong working relationships in the communities in which we operate.
- Supporting with job creation in economically challenged communities.

Employee Development, Retention, and Diversity

Creating an environment for all employees to thrive, allowing for long-term retention and promoting wellbeing and success.

Associated Risks & Opportunities
- Employee engagement and retention.
- Attracting employees of all backgrounds seeking growth and development opportunities.
- Employee and contractor adherence to our Code of Business Conduct and Ethics.

ENVIRONMENTAL

Climate Change Management

The ability to adjust and adapt our operations in the face of increased regulation, investor and community interest, inclement weather, and other effects of climate change.

Associated Risks & Opportunities
- Support the energy transition by supplying high-strength, high-quality coke to make the steel that is critical for a low carbon economy.
- Risks related to evolving regulatory requirements and investor and public sentiment related to climate change.
- Our reliance on metallurgical coal and fossil fuels in our production process.
- Extreme weather events and changing climate conditions.

Air Emissions

GHG and other air emissions created by our manufacturing processes.

Associated Risk & Opportunity
Technical limitations to directly reduce GHG emissions from our production process, paired with opportunities associated with our high-quality, high-CSR coke and more environmentally sound heat-recovery technology.

Energy

Energy created and consumed as part of our operations.

Associated Risks & Opportunities
- Increased cost of energy and opportunities for implementing energy reduction technologies.
- Opportunities to sell the power generated from our waste heat to the public through the grid.
- Opportunities to sell process steam to our customers.

Environmental Compliance

Maintaining compliance with environmental permits and requirements, as required of operations by state and federal law.

Associated Risks & Opportunities
- Air emissions from our operations.
- Compliance with extensive permit requirements.
- Compliance with emerging, potentially more stringent regulations.

Waste

Creation and disposal of hazardous and non-hazardous waste produced in SunCoke's operations.

Associated Risks & Opportunities
- Generation of hazardous and non-hazardous wastes.
- Disposal of hazardous and non-hazardous wastes.

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Supply Chain Risk

Supplier Code of Conduct

We require all vendor and supplier colleagues to adhere to SunCoke's established Code of Business Conduct and Ethics. Additionally, we have a separate Supplier and Vendor Code of Conduct that outlines all further requirements for suppliers, and we operate a management system designed to evaluate the safety performance of suppliers.

Furthermore, our suppliers and vendors must comply with SunCoke's Environmental and Health and Safety Policies, SunCoke's Human Rights Policy, and all applicable environmental, health, and safety regulations—including those relating to hazardous materials, raw materials, wastewater, solid waste, and air emissions—at all times.

Supply Chain Risk Identification and Management

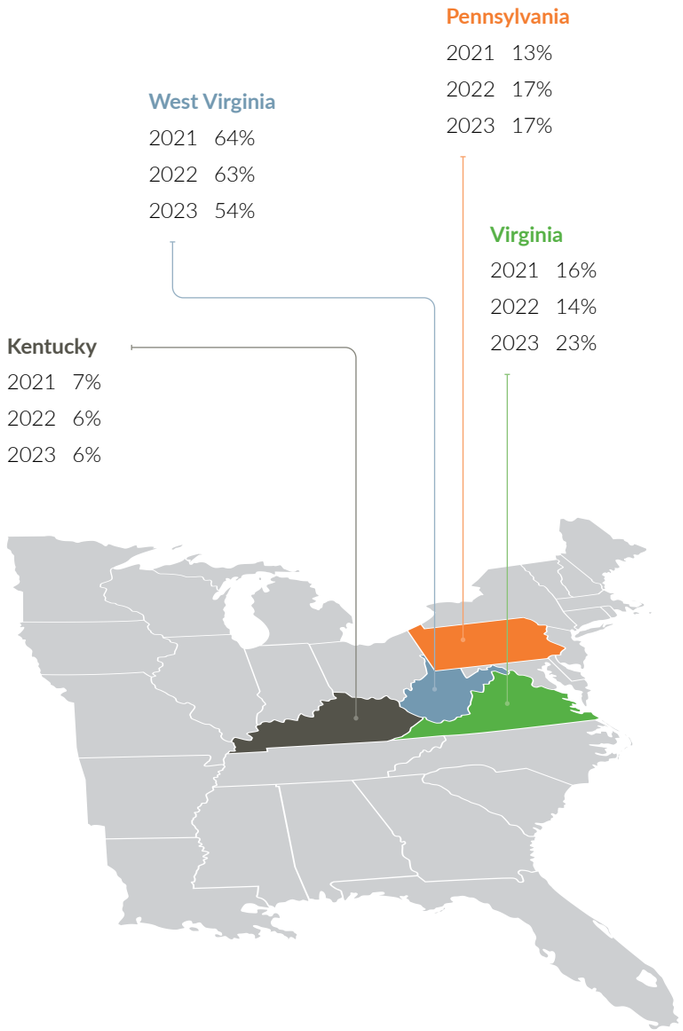
By working with our customers on sourcing the amount and blend of metallurgical coal critical to produce the coke they need, we mitigate the risks associated with market changes.

We utilize our ERM process to identify and manage business risks and risk owners across our portfolio, including our supply chain, and to develop mitigating controls and processes for those identified risks. Identifying and addressing supply chain and value chain risks by working with suppliers, ensuring diversified sources for our materials, and engaging in long-term planning is built into our business strategy.

Raw Materials

Metallurgical coal is the principal raw material for our cokemaking operations. We purchase all metallurgical coal used to produce coke at our domestic cokemaking facilities from third parties. We believe there is an adequate supply of metallurgical coal available in the U.S. and worldwide, and we have been able to supply metallurgical coal to our domestic cokemaking facilities without any significant disruption in coke production. Each ton of coke produced at our facilities requires approximately 1.4 tons of metallurgical coal. In 2023, we purchased 5.9 million tons of metallurgical coal. This aspect of our supply chain typically operates in rural distressed communities, and our operations provide economic opportunities through indirect job creation.

Metallurgical Coal Tonnage Sourcing[11]



[11] This data is inclusive only of U.S. operations.



Our suppliers and vendors must comply with SunCoke's Code of Conduct, Environmental Policies, Health and Safety Policies, Human Rights Policy, Supplier and Vendor Code of Conduct, and all applicable environmental, health, and safety regulations, at all times.

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TCFD and Climate Change

Incorporating climate-related considerations into our strategy and sustainability disclosures is not new—we have been doing so for several years. We regularly update our disclosures to further align with the recommendations of the TCFD and evolving stakeholder expectations. This reflects our continued efforts to demonstrate how climate strategy informs, and becomes a part of, our overall corporate strategy. Our climate-related disclosure includes additional information on:

- Our governance structure for overseeing, monitoring, and implementing our climate strategy, risk management, and metrics;
- The three dimensions of our climate strategy, including the strategic rationale behind each of them; and
- The key drivers that inform our decision-making on issues related to the energy transition.



Our reporting follows the same structure as the TCFD framework. It starts with Governance, followed by Strategy, then Risk Management, and finally, Metrics. A summary of our approach to each of these four areas is outlined on the right.

Governance

Our climate governance includes accountability and ownership at multiple levels, from our Board of Directors and Board committees to the employees that impact our operations every day.

Strategy

Our climate strategy is designed to allow SunCoke to capitalize on opportunities that arise from the energy transition and evolution of the steel industry. Additionally, we will strengthen our business by diversifying our product offerings and customers in response to industry needs.

Risk Management

Guided by our long-standing ERM program, SunCoke takes a methodical approach to identifying, assessing and managing ESG risks, including climate-related issues.

Metrics

Our climate-related metrics help us to measure our progress, benchmark our performance and identify opportunities for improvement.



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Governance

Maintaining oversight of climate-related issues at the Board, executive, and management levels is key to ensuring consistency throughout the setting and implementation of climate-related strategy. SunCoke accordingly assigns climate-related responsibilities to positions at each of these three levels. In addition, our ESG Steering Committee, which comprises executive and management personnel, interfaces across all three levels and with SunCoke Operations to coordinate and implement our climate strategy.

Board-Level Discussions

In the past year, the ESG Steering Committee led several initiatives focusing on climate risks and opportunities. Highlighted below are certain topics that the ESG Steering Committee reviewed and will continue to discuss on a regular basis with SunCoke's Governance Committee, Audit Committee, and Board.

- Securities and Exchange Commission (SEC) climate rule
  Monitoring and reviewing the SEC climate rule.
- Physical risks at our facilities
  Reviewed our assessment finding low risk of physical impacts at our facilities.
- Sustainability disclosures
  Reviewed and published our sustainability disclosures, including our 2023 Sustainability Report and CDP Climate Change 2023 response.
- GHG Scopes 1 and 2 limited assurance audit
  Looking to complete a third-party verification of Scope 1 and 2 data, following the completion of the project to prepare for verification.
- Ongoing environmental initiatives
  Continuous efforts to improve environmental performance, including reducing fuel usage and reducing hazardous waste generation.

Governance Chart

BOARD

Board of Directors and the Governance Committee

The full Board (including Board Chair, all Directors, CEO and President) is responsible for overseeing SunCoke's climate strategy. The Governance Committee is the Board level committee that is specifically tasked with coordinating oversight of SunCoke's environmental matters, including climate change. The committee assesses identified risks to the Company, including climate-related risks, monitors climate-related regulations, orients overall company strategy, and reviews and approves sustainability and climate-related disclosures. The committee meets to discuss climate strategy at least once annually or more frequently as needed. Climate-related issues were discussed twice with the Board in 2023; once with the Governance Committee and once with the full Board.

EXECUTIVE

The CEO and the President[12]

The CEO and the President are each responsible for setting overall business strategy, including any climate-related strategy, and therefore, have the highest executive-level responsibility for climate-related issues.

MANAGEMENT

Vice President, Assistant General Counsel & Chief Compliance Officer, and Director of EHS

The Vice President, Assistant General Counsel & Chief Compliance Officer (VP, AGC & CCO) and the Director of EHS are responsible for day-to-day implementation of our sustainability strategy and oversight of all environmental compliance matters.

ESG Steering Committee

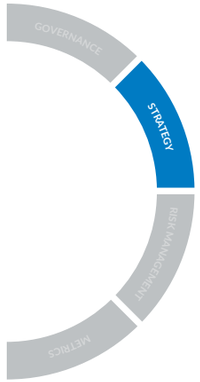
In 2022, SunCoke formed our ESG Steering Committee from our former Climate Change Team and Sustainability Team. The Committee functions as a working group responsible for monitoring climate-related risks and coordinating the development and implementation of SunCoke's ESG (including climate change) strategy and disclosures. Representatives of the ESG Steering Committee meet with the Governance Committee at least twice annually for briefings on climate-related risks, as well as overall SunCoke sustainability strategy and ESG reporting.

Permanent Members
- VP, AGC and CCO
- VP, Technology
- Director, EHS
- Director, Asset Optimization
- Director, Technology

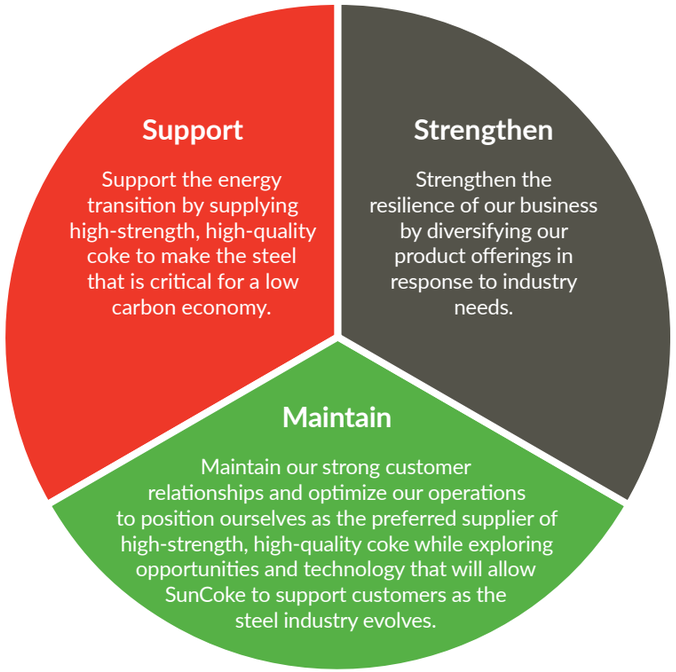
Adjunct Members
- VP and Controller
- VP, Secretary
- VP, Human Resources

[12] SunCoke's CEO and the President are both members of the Board and the Executive Committee

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The Three Dimensions of SunCoke's Climate Strategy



SunCoke's newer, well-maintained operations are ideally situated to take additional market share as aging by-product plants close.

Strategic Rationale

Transition Risks

We reviewed our exposure to climate-related risks by examining the following questions:

- At what pace might the U.S. steel industry decarbonize, and what might such a transition look like?
- How might demand for steel change in the coming decades?
- How might demand for blast furnace coke change in the coming decades?

SunCoke is taking proactive steps to respond to the long-term shift to a more sustainable steel value chain by analyzing our own technical options for carbon reduction. Additionally, we are exploring opportunities to diversify our product mix, for example, through a potential partnership with U.S. Steel to manufacture pig iron for EAF steel-making processes.

To the extent that future demand for blast furnace coke decreases, SunCoke expects to be able to counterbalance this effect on the Company by growing our own participation in the market. As the only company to build greenfield cokemaking facilities in the U.S. in the last approximately 30 years, our well-maintained operations are ideally situated to take additional market participation from aging by-product coke batteries. Additionally, we are working to diversify our business through foundry coke. Our ability to maintain our operations and expand into foundry will only become increasingly critical for the industry when considering that in the past ten years alone, over 6 million tons of cokemaking (blast furnace and foundry) plant capacity belonging to our competitors in the U.S. have closed or cold idled, including 2.8 million tons between 2021 and 2023.

Our strategy is to grow our market participation and increase our revenue by supporting our customers with their decarbonization plans. By using our high-strength, high-quality coke, our customers can use less coke while maintaining optimal blast furnace operations, which helps them to lower the GHG footprint of their steel manufacturing processes.

Overall, SunCoke plans to navigate the energy transition by continuing to provide customers with the highest quality coke. SunCoke is also exploring business opportunities and technology that will allow us to support customers as the steel industry evolves.

Steel is critical for the energy transition

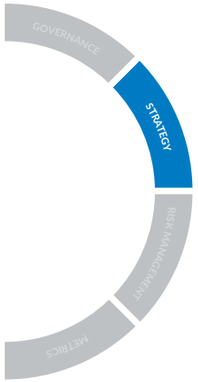
Building the infrastructure for a low-carbon economy will be materials-intensive, and we are convinced that steel will be the most critical material of all.

Steel is a critical material to all low-carbon technologies like wind and solar power generation, battery- and fuel-cell-based EVs, and hydrogen production. It will also play an enabling role across sustainable energy technologies requiring additional infrastructure, like electricity networks.

At SunCoke, we recognize that with the growing importance of steel for a low-carbon economy, the greater the opportunity for us to remain the supplier of choice for high-quality, high-strength U.S.-made coke for our steel customers.

Furthermore, by focusing on the American steel industry—whose CO_2 emissions intensity is the lowest of the nine largest steel producing countries and the EU-27—we have the opportunity to further integrate our products and services with an innovative and forward-looking value chain. The American steel industry is making significant investments to further decrease its carbon emissions and advance its leadership position on sustainability, and we at SunCoke are proud to be part of that.

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Domestically produced blast furnace steel will be vital to the U.S. steel industry for decades to come

Demand for steel in the U.S. is expected to grow significantly over the coming decades, supported by factors such as a booming automobile industry, an accelerating urban population, and the low-carbon energy transition.

Blast furnace (BF)-produced primary steel (also known as basic oxygen furnace steelmaking, or BOF) will continue to play a critical role in the U.S. steel industry for decades to come, even as EAFs become an increasingly common form of steelmaking. The continued demand for BF-produced steel will require a reliable supply of coke, as coke is a critical fuel and reducing agent to remove oxygen in the smelting of iron ore in a blast furnace.

At SunCoke, we are proud to play a key role in maintaining the domestic supply lines that will help meet the U.S.' growing demand for crude steel through our production of high-quality coke.

SunCoke is well positioned to grow its participation in the U.S. coke market as competitors' aging and less environmentally friendly facilities go offline

SunCoke expects to benefit by growing our participation in the market as less environmentally friendly cokemaking facilities are shut down. As the only company to build greenfield cokemaking facilities in the U.S. in the last approximately 30 years, our advanced technology operations are ideally situated to take additional market participation from aging by-product coke batteries. With the newest fleet of coke plants operating with a smaller environmental footprint, strong compliance record, and commitment to invest in our assets, we secure our long-term position as a critical raw material supplier in the steel production chain.

SunCoke's high-strength, high-quality coke allows customers to lower their emissions by using less coke in making steel

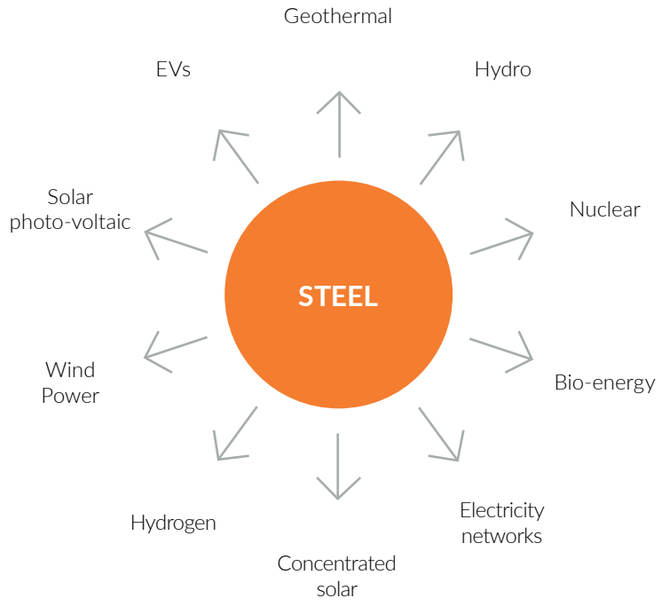
As our steel customers work to reduce their GHG emissions by using alternative lower-carbon blast furnace fuel sources and reducing the overall amount of coke used, the importance of not compromising on the strength and quality of the needed coke becomes even more critical to them. SunCoke's high-strength, high-quality coke allows our customers to use less coke while maintaining optimal blast furnace operations, which helps them lower the GHG footprint of their steel manufacturing processes.

We can build on our core competencies in technology innovation and coal blending to diversify our product offerings and customers

Our deep expertise in coke production gives us a unique set of technical skills, market entry points, and industry insights with which to continue diversifying and innovating our business. We are well positioned to take advantage of new opportunities that will increase the resilience of our corporate strategy journey.

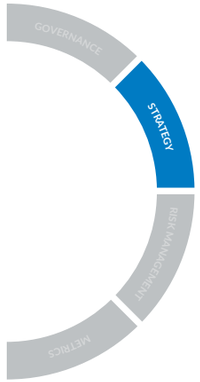
Steel—an energy transition enabler

Steel is a critical material for a transition to a low-carbon economy, as shown by the diagram below.[13]

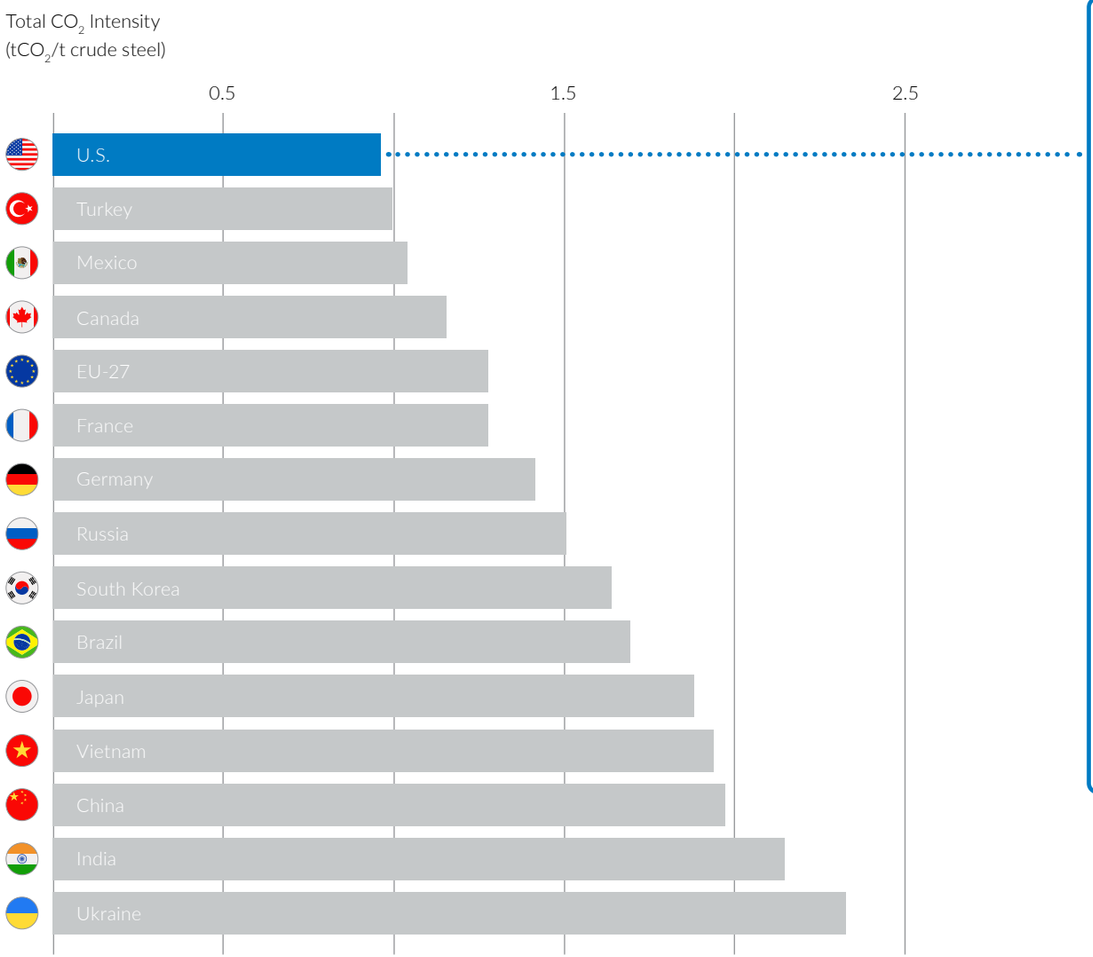


[13] Adapted from McKinsey & Company, "The raw-materials challenge: How the metals and mining sector will be at the core of enabling the energy transition," 2022

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Largest Steel Producing Countries and the EU-27 (2019)[14]



Lowest CO_2 emissions intensity of the nine largest steel producing countries and the EU-27

Operates blast furnaces that are among the most carbon-efficient in the world

Essential to the U.S. decarbonization strategy, economic security, and critical infrastructure

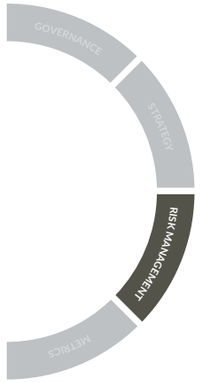
Continues to make key investments to further decrease its carbon emissions and advance its leadership position on sustainability

"Steel is integral to the energy transition, serving as a critical material for technologies such as wind turbines, electric vehicles, and advanced manufacturing processes."

— Mission Possible Partnership

[14] Adapted from Hasanbeigi, "Steel Climate Impact: An International Benchmarking of Energy and CO_2 Intensities," Global Efficiency Intelligence, 2022

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Risk Management

Our process for identifying and managing climate-related issues on a global and site-specific basis is continuously being improved. This includes maintaining and reviewing our climate risk register.

The register allows us to capture and monitor relevant climate risks, including emerging ones, regardless of whether the risks meet the thresholds or criteria of our overarching ERM processes. Inclusion in our climate risk register or disclosure in this report does not indicate or imply that any potential risk has been deemed material.

Consideration Timeframe

- ●○○ Short Term
- ○●○ Medium Term
- ○○● Long Term
- ●●● Short to Long Term

Climate-Related Considerations

Policy and Regulatory

Decarbonization of the steel industry

○●○

The White House's pledge to decarbonize industrial heat needed to make steel

In 2021, the U.S. pledged to rejoin the Paris Agreement, and began discussion of a goal of achieving a 100% clean energy economy and net-zero GHG emissions in the U.S. no later than 2050. The stated climate and energy plans also aim to decarbonize industrial heat needed to make steel, concrete, and chemicals, and "reimagin[e]" carbon-neutral construction materials. The mechanisms for achieving these goals have not been detailed but could result in regulatory GHG emissions reductions requirements for SunCoke to meet in the future.

GHG Regulations

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The GHG Tailoring Rule

The GHG Tailoring Rule is an example of a current regulation that can impact SunCoke through permitting thresholds for GHG emissions from significant stationary sources. Compliance with the permitting thresholds for GHG emissions (when applicable) is key to avoiding legal liability and other consequences.

Potential impacts of a new or more stringent GHG emissions standard

A new or more stringent GHG emission standard designed to address climate change and physical effects attributed to climate change by requiring reduction of GHG emissions may adversely affect our business. There has been increasing attention to climate change and the impact of GHGs, particularly from fossil fuels, which are integral to our cokemaking and logistics businesses. Because our coking process is dependent on coal as a raw material and the coking process generates carbon dioxide, we are limited in our ability to reduce our GHG emissions.

Reputational

Public and investor opinion

●●●

Participating in the coal and fossil fuels industries

Since SunCoke operates in the coal value chain (we use metallurgical coal in the coking process and transport thermal coal, among other products, at our logistics terminals), we have the potential to suffer negative reputational impacts related to investor and public opinion on fossil fuels.

Climate risk mitigation

Depending on the nature and severity of any climate- or weather-related events, SunCoke could be exposed to financial loss, reputational damage, or potential government or other regulatory enforcement actions, or private litigation.

Acute and Chronic Physical Risks

Extreme weather (e.g., flooding, hurricanes, polar vortex), and prolonged changes in energy consumption due to warmer winters

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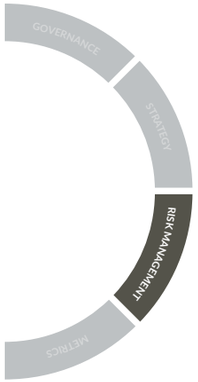
Impacts on operations, supply chains, & workforce

Climate change may cause changes in weather patterns and increase the frequency or severity of weather events and flooding. Severe weather events and flooding could impact our operations. For example, our terminals are located near bodies of water and may be impacted by flooding or hurricanes, disrupting our or our customers' ability to move products. Additionally, extreme cold could prevent coal delivery and unloading at our coke plants, impeding operation, or create a more hazardous outdoor working environment for our employees.

Downstream and upstream impacts

Severe weather may adversely impact our suppliers and our customers and their ability to purchase and transport our products.

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Disruptive Technology, Energy Transition, and Markets

Alternatives to processes that require coke

Less carbon-intensive alternatives

Technology changes in the steel value chain, particularly those that aim to reduce coke consumption, could have the potential to impact our business. A reduction in demand for domestic coke needed to manufacture steel would have the potential to decrease SunCoke's revenues (a) if SunCoke was not the preferred supplier and (b) if SunCoke was unable to export its coke in the face of diminishing domestic demand. Scrap steel recycling, the use of EAFs, and hydrogen injection have not emerged as a substantive risk to SunCoke; however, we continue to monitor technology developments in this space as part of our risk assessment processes. For example, through this process, we determined that coke will remain critical to support the burden structure and gas distribution (the burden is the charge to the blast furnace) as steel companies explore the use of hydrogen and other green additives in the steel making process.

Carbonaceous substitutes for coke

Carbonaceous substitutes

In the past, there have been technologies that have sought to produce carbonaceous substitutes for coke in the blast furnace. While none have proven commercially viable thus far, we monitor the development of any potential technologies carefully.

Customer climate targets

Customer climate targets

Several of our largest customers have stated goals or efforts for reducing their GHG footprint, including net zero targets. How these customers pursue their climate targets may have an impact on their reliance on coke products produced by SunCoke.

SunCoke's Response

Our response to transition risks and opportunities

- R&D
  Our R&D program seeks to improve existing and develop promising new cokemaking technologies or processes, including new product development and process improvement designs.

- Diversification with foundry coke and potential other projects
  We are diversifying our markets and products, including through foundry coke production and a potential partnership with U.S. Steel to manufacture GPI for EAF steelmaking processes.

- Energy savings
  We continue to evaluate energy saving opportunities, such as reducing natural gas use.

Examples of our response to physical risks

- Hurricane risk mitigation
  We have upgraded the equipment anchoring systems at Convent Marine Terminal (CMT) to mitigate the risks of equipment movement in hurricane conditions. This upgrade helps to stabilize vessels during rapid water movement conditions.

- Preparing our facilities for extreme cold weather
  We have developed procedures to prepare our facilities for extreme cold weather, such as temperatures below -35°C and ensure continued normal operations, including freeze treating coal and coke cars, supplying natural gas for heat, using glycol in critical instrumentation, and other activities to allow continued equipment operations during extreme cold periods.

Physical climate risk

In 2023, we also reviewed our physical climate risks. We evaluated the potential risks that physical impacts of climate change such as hurricanes and temperature extremes may pose to our assets, based on historical experience and local geographical information.

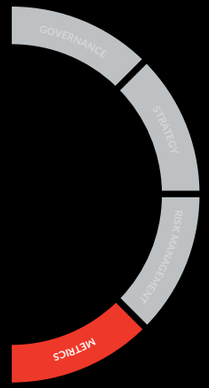
We believe that our overall asset risk to physical impacts is relatively low. This is largely because we do not operate fragile assets (such as crops), and our facilities are well situated to mitigate most major impacts. Furthermore, the risk of hurricanes at our Vitória and CMT facilities is mitigated through hurricane/inclement weather preparation plans at these facilities.

Furthermore, we focus on personnel safety in extreme temperatures through heat mitigation processes and temperature monitoring.

Looking Ahead

- Execute our climate strategy; *see The Three Dimensions of SunCoke's Climate Strategy*.
- Continue to ensure compliance with various legal obligations, such as measuring and reporting our GHG emissions and determining the need for any changes.
- Continually refine our climate risk analysis and incorporate the findings into our capital and strategic planning decisions.
- Communicate the environmental benefits of our cokemaking processes to our customers and regulators.
- Continuously improve our processes to reduce energy use and carbon emissions where possible.
- Continue to invest in innovations that improve our processes, yield, and product portfolio and provide high-strength, high-quality coke to our customers.
- Continue to monitor climate-related risks as part of our regular risk assessment processes.

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Metrics

GHG Emissions

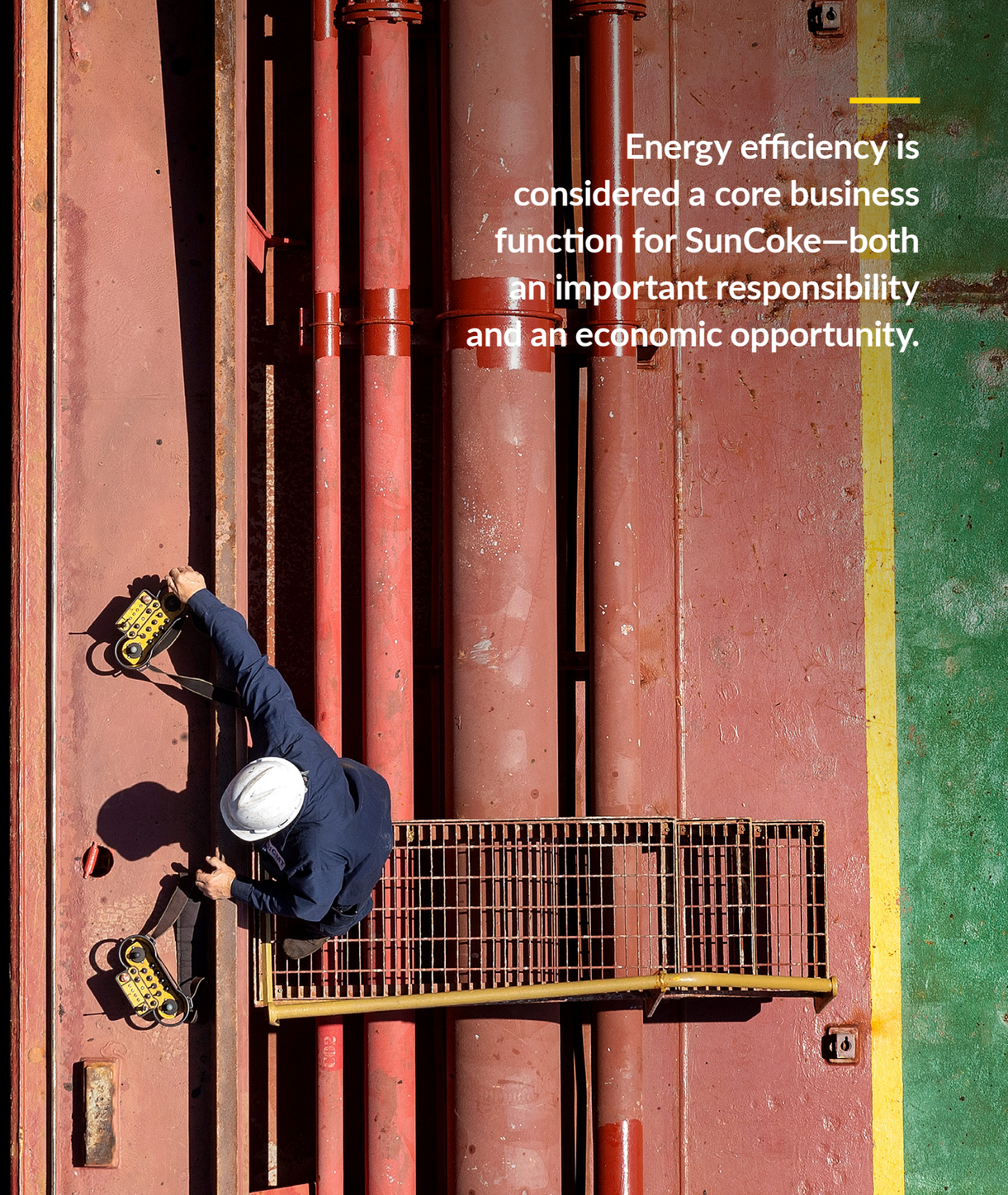
Our GHG emissions are directly tied to the amount of metallurgical coal charged and amount of product produced— and thus our financial results.

Direct GHG Emissions (million mtons)

	2021	2022	2023
Scope 1 GHG Emissions (CO_2e)[15]	4.19	4.53	4.38
Scope 2 GHG Emissions (CO_2e)	0.13	0.14	0.15
Scope 1 GHG Intensity (tons CO_2e/ton coke produced)	0.79	0.89	0.86

Our Scope 1 emissions are tied to the amount of metallurgical coal we use on an annual basis. Because coal is critical to make high-quality coke, the potential for alternative energy sources is very low. As a result, we are limited in our ability to reduce our GHG emissions; instead, our high-quality coke helps our steel customers to reduce their GHG emissions as previously explained. Energy efficiency is considered a core business function for SunCoke—both an important responsibility and an economic opportunity. We actively identify and implement new approaches that make our process more efficient, including investments that improve the amount of coke made per unit of coal fed into our ovens.

[15] These GHG emissions totals include contributions from all regions in which we operate. For most of these regions, all applicable GHGs are included. The contributions from Brazil include CO_2 only.



Energy efficiency is considered a core business function for SunCoke—both an important responsibility and an economic opportunity.

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Environment

We are committed to stewardship and environmental compliance as core values of our corporate culture. Environmental compliance is one of our key ESG topics, along with environmental impacts including air emissions, energy, and waste.

SunCoke strives to provide environmentally sound operations; comply with all laws, regulations, and permits; reduce emissions and environmental impact; and promote waste minimization and conservation through improved process efficiencies. We are proud of our advanced heat-recovery operations and generate power with no additional GHG emissions.

In 2023, we undertook a number of activities that demonstrate our commitment to environmental stewardship and progress toward mitigating our most important environmental risks.

Air quality and control of air pollutant emissions

- Successfully managed environmental compliance.
- Maintained our strict environmental management program.
- Continued adherence to best air pollution control practices.

Production and disposal of hazardous and non-hazardous wastes

- Ensured that all waste was disposed of properly.
- Achieved zero reportable waste-related spills at all locations.
- Continued recycling industrial materials at plants.

Land disturbances and the continued operation of our coal slurry impoundment

- Safely managed our coal slurry impoundment.
- Completed steps toward ongoing reclamation efforts at our legacy mining sites including structure removal and revegetation.

Water usage and discharge, water scarcity

- Recycled 75% of coke quenching water.
- Continued to adhere to best management practices for water pollution control.

GHG emissions from our operations and their impact on climate change

- Completed our fourth CDP Climate Change report.
- Produced more electricity via our production process than the electricity consumed by it.
- Continued championing new initiatives through the ESG Steering Committee, such as exploring avenues for the reduction of fuel usage in our operations.

Air Emissions

SunCoke strives to be a good steward of the environment and is committed to protecting air quality by managing emissions and impact on the natural environment. We manage emissions from our operations by focusing on maximizing operational efficiency and ensuring compliance with both federal and state legal requirements. We recognize that air quality is important to our business and stakeholders, especially our local communities, and we track and report the following criteria pollutants: sulfur dioxide, nitrogen oxides, carbon monoxide, volatile organic compounds, particulate matter, lead, and carbon dioxide.

Our coke oven technology set an example and served as the basis for establishing Maximum Achievable Control Technology, as it is designed to limit emissions of hazardous air pollutants. All heat-recovery cokemaking facilities that we have built in the U.S. since 1998 have either met or exceeded the applicable Best Available Control Technology or Lowest Achievable Emission Rate standards set forth for cokemaking facilities.

See "Metrics" in "TCFD and Climate Change" for our reported GHG emissions from 2021 to 2023.

Other Significant Air Emissions Data (1,000 tons)

Air Emissions	2021	2022	2023
VOCs volatile organic compounds (U.S. only)	0.1	0.1	0.1
NOx nitrogen oxides (U.S. only)	3.4	3.4	3.3
SO_2 sulfur dioxide	13.0	12.8	12.5
PM particulate matter	2.0	2.0	2.3
CO carbon monoxide (U.S. only)	0.4	0.5	0.5
Pb lead	0.003	0.003	0.003

Fuel Consumption (1,000 m^3)

Fleet fuel consumption of gasoline	1.1	1.1	1.1
Fleet fuel consumption of diesel	8.3	7.8	8.9

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Energy Usage

SunCoke considers energy efficiency a core business function—both an important responsibility and an economic opportunity. Conserving energy and improving energy usage in our operations decreases expenses and reduces GHG emissions, resulting in a reduced environmental impact. Energy efficiency remains a key area to reduce environmental impact in operations and reduce exposure to regulatory or other climate-related risks. In 2023, SunCoke's ESG Steering Committee began an initiative to reduce fuel usage and increase efficiency at plants and terminals. Natural gas use is currently being reviewed to identify primary usage areas and identify opportunities for reduction. Other fuels may follow.

How SunCoke Uses Energy

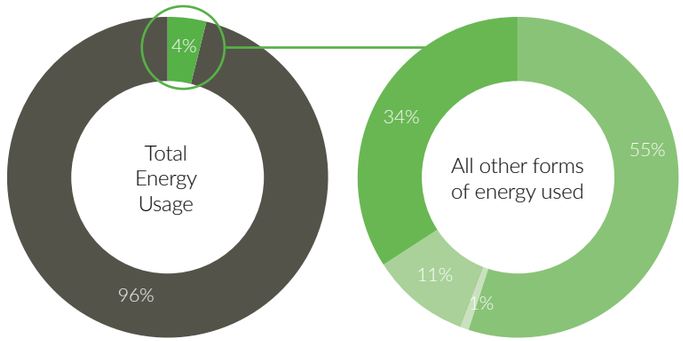
Metallurgical coal-based energy used in coking of coal

Metallurgical coal undergoes destructive distillation within our coke ovens. During this process, the volatile matter within the coal is burned, generating heat. The process is self-sustaining, meaning that the heat created in the ovens keeps the coking process going without the need for additional fuel or heat sources. In addition, the excess heat generated in the process is captured and used to generate steam for process use or power production.

All other forms of energy used by SunCoke in coking of metallurgical coal and in other applications

- Natural Gas: Used for heating, supplemental firing of the ovens, and oven idling for repairs.
- Propane: Used for heating.
- Fuel Oils: Used for heating, supplemental firing of the ovens, and oven idling for repairs.
- Electricity: All electricity we produce is sold to our customers or back to the grid. Incoming electricity from local utilities is used to run the facility and equipment. Examples of this equipment include crushers, conveyors, machines, fans, instrumentation, lighting, and HVAC.

Total Energy Use in TJ (Terajoules)	**2021**	**2022**	**2023**
Coal-based energy used in coking of coal	94,220.0	91,468.6	90,916.6
All other forms of energy used (excluding coal)	3,350.0	3,318.6	3,388.0
Total	97,571.0	94,787.2	94,304.6



Coal-based energy used in coking of coal
All other forms of energy used (excluding coal)
Natural Gas
Fuel Oils
Propane
Electricity

Purchased Energy Use (TJ)	**2021**	**2022**	**2023**
Natural Gas	1,805	1,835	1,856
Propane	54	31	20
Fuel Oils	353	336	377
Electricity	1,138	1,117	1,135
Total	3,350	3,319	3,388

All purchased electrical power is sourced from the electricity grid. In 2023, electrical power purchased from the grid represented 34% of purchased energy. In both 2022 and 2021, it also represented 34%.

Site	**Type**	**Unit**	**2021**	**2022**	**2023**
Haverhill 2	●	TJ[16]	1,194.5	1,084.8	1,276.2
Middletown	●	TJ	1,300.8	1,285.8	1,215.9
Haverhill 1	▲	1,000 tons	1,339.3	1,444.0	1,401.0
Granite City	▲	1,000 tons	1,639.2	1,734.4	1,573.5
Vitória	▲	1,000 tons	3,988.4	3,803.9	3,477.7

● Power generated

▲ Steam sold to customers (steam goes to customer turbines for use in clean power production)

Energy efficiency remains a key area to reduce environmental impact in operations and reduce exposure to regulatory or other climate-related risks.

[16] TJ is equal to one trillion (1 x 1,012) joules, or about 0.278 GWh.

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Environmental Compliance

SunCoke strives to conduct its business operations in a manner that provides effective stewardship of the environment and verifies compliance through environmental management programs. Our Safety, Health, and Environmental Program incorporates internal and external audits, proactive enterprise learning, performance measurement, and reduction of environmental risks.

We believe that environmental incidents are generally preventable, and that prevention starts with our employees. SunCoke fosters a work environment in which employees are encouraged to report and raise environmental issues without fear of retaliation. We provide our employees with the resources and training necessary to help drive SunCoke in meeting our environmental objectives.

We work to drive continuous environmental improvement and high performance by:

- Integrating environmental considerations into work practices and utilizing the resources needed for compliance with applicable environmental laws, regulations, permits, and agreements;
- Reducing environmental risks through regular assessments, emergency preparedness programs, and effective utilization of innovative environmental technologies and practices; and
- Training employees and contractors on applicable environmental regulations and operating requirements and monitoring their performance and compliance.

We view our environmental compliance with an enterprise-wide lens. Our Director of EHS oversees all environmental compliance concerns and reports out on environmental, climate, and sustainability matters to our Board.

Chemical Management

SunCoke screens and approves all chemicals used in our facilities and processes to comply with safety, as well as environmental guidelines and regulations. Our process involves thorough review of chemical Safety Data Sheets by subject matter experts who assess applicable regulations; disposal, handling, and storage considerations; and associated risks of each new chemical. We complete this process prior to purchasing any new chemical that is brought on site. As a business-to-business company, we do not have control over end-user consumer products, and therefore do not control or manage the inclusion of any harmful chemicals in customer products.

Biodiversity and Disturbed Land

We aim to adhere to all applicable environmental regulations to reduce the risk of our operations to the surrounding communities and environment. Any time SunCoke seeks a new permit for a project, we collaborate with relevant state and federal agencies to complete biological and archaeological steps required for compliance. After analysis, we work to mitigate or minimize any potential impacts of our operations.

SunCoke's total footprint for all owned and leased locations is approximately 3,170 acres, with our total disturbed land measuring less than 3,170 acres. We have not identified any adverse effects related to endangered or threatened species on our properties from our routine operations, and therefore do not have a biodiversity policy at this time.

We review impacts to biodiversity when evaluating new projects or land disturbances. If we were to pursue a project requiring certain types of disturbance permitting, we would evaluate the potential impact on critical habitats, areas of archaeological significance, and areas with wetlands or other significant ecological or biodiversity value. This evaluation would be done by conducting detailed archaeological and ecological surveys. If we identify areas of potential impact, we would work with local permitting authorities to identify archaeological or biodiversity value and develop mitigation plans.

Legacy Impoundment and Reclamation

As a remaining liability from our legacy mining operations that were divested in 2016, we manage a single legacy coal slurry impoundment located near our Jewell facility in Virginia. Historically, the coal slurry impoundment stored coal slurry from coal-cleaning operations and is classified by the MSHA as a "high hazard potential" impoundment. Impoundments are classified not by their condition or probability of failure, but by the potential for loss of life or other impacts in the event of a catastrophic failure. High hazard potential dams (i.e., impoundments) have more rigorous design and operation criteria to minimize the potential loss of life or property damage.

This one remaining SunCoke impoundment meets MSHA's rigorous criteria for design and operation. Qualified personnel routinely monitor and inspect the impoundment for both safety and environmental compliance. We inspect the dam on at least a weekly basis and monitor for movement, vegetation growth, discharges, seepage, or other unusual conditions.

All discharged water is treated to meet stringent standards, and all discharges are permitted under local and federal programs. In the future, this site will undergo reclamation and will be restored, as closely as possible, to its original pre-mining condition.

In addition, as part of our commitment to properly maintain or reclaim disturbed lands, SunCoke has conducted the required reclamation activities at certain closed legacy mining sites since the divestiture of our coal mining business. This reclamation includes regrading and revegetation plans approved by local government agencies in previously disturbed areas. For example, we completed the removal of old coal handling equipment at the Whitewood legacy site in Virginia in 2021. We routinely monitor all reclamation work to ensure adherence to plan requirements and successful revegetation efforts.

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Water Management

Recognizing that water is an important natural resource, we monitor our water usage and work to leverage synergies throughout our locations to identify additional water efficiency and reuse opportunities. The data that we collect on our water usage enables us to make informed business decisions around water management throughout our portfolio.

Day-to-day responsibility for water resource management predominantly resides at the facility level. Many of our facilities are designed to collect and retain stormwater, which is then used as makeup water in our quenching process. We strive for full compliance with our obligations under our state and local government water permits.

In 2020, we conducted a review of our operations to identify locations operating in areas of high baseline water stress. We engaged a third party to conduct GIS mapping of our facilities and utilized the World Resources Institute's Aqueduct Water Risk Atlas to identify which facilities are located in areas with a high baseline water stress. All of our U.S. facilities are located near plentiful sources of water; therefore, water withdrawal and scarcity are not significant risks at those operations. However, we identified that our production facility in Vitória, Brazil, is located in a region with a high baseline water stress, and water scarcity and withdrawal are risks for that facility.

Our Brazil facility operates water reuse programs, including those described in the Coke Quenching and Water Conservation section below, to reduce our use of water and mitigate potential impacts on water scarcity. We also routinely evaluate additional water risk mitigation strategies to reduce our water usage and therefore our impact on the water stress in the area. We manage our water footprint responsibly for our operations, our communities, and the environment.

Coke Quenching and Water Conservation

Significant water use can be attributed to the process of quenching the coke. As part of our production process, after the coal forms into coke it requires cooling prior to screening, sizing, and delivery to customers. Each completed batch of coke is pushed from the oven and travels to a quench tower, where a specified amount of water is poured directly onto the hot coke to cool it. Because the water comes into direct contact with the hot coke, steam is formed during the process, and roughly 25% of the water used during the quench cycle evaporates. The remaining 75% of the quench water is recycled through the quenching system to be used again. Makeup water is added, and the process repeats for the next batch of coke. Reuse of this quench water allows us to significantly reduce our water consumption and environmental impact. In addition to reusing our quench water, we recycle water used for non-contact cooling of coke oven equipment, certain process water used in pollution control equipment, and water used in HRSG and turbine processes.

Wastewater and Stormwater Management

Wastewater is often associated with by-product cokemaking, and our heat-recovery cokemaking method produces minimal wastewater. This wastewater minimization is mainly due to the fact that SunCoke facilities do not perform the chemical recovery side of the cokemaking process. The wastewater that we do produce comes from our steam generation operations and is mainly blowdown water from steam generators and cooling towers. All of our water discharges must meet strict quality standards prior to discharge. We monitor the water we discharge to ensure that we meet the standards reflected in our EPA and state regulatory agency permits, and report regularly to relevant regulatory agencies as well as internal leadership. Several of our facilities are also permitted to discharge stormwater, and all stormwater discharges are required to meet applicable standards prior to discharge.

Water Usage (1,000 m^3)	2021	2022	2023
Total Fresh Water Withdrawn[17]	6,373	6,341	6,576
U.S.	4,878	4,879	5,233
Brazil	1,495	1,462	1,344
Total Fresh Water Withdrawn and Consumed in Locations with High Baseline Water Stress (Brazil)	1,495	1,462	1,344
Total Water Consumption	6,373	6,341	6,576
U.S.	4,878	4,879	5,233
Brazil	1,495	1,462	1,344
Total Wastewater Discharge[17]	150	208	238
Percentage of Fresh Water Withdrawn from Locations with High Baseline Water Stress (Brazil)	23%	23%	20%

The remaining 75% of quench water is recycled through the quenching system to be used again. Makeup water is added, and the process repeats for the next batch of coke.

[17] Does not include stormwater captured on site and used for makeup water.

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Solid and Hazardous Waste Management

We are committed to preventing spills and unintended releases and have procedures in place for the prevention and mitigation of impacts from any spills. We understand the impact a solid waste disposal or spill of hazardous materials could have on the local environment and take a targeted approach to reduce waste disposed to landfills and spills at facilities. If an incident does occur, we have processes in place to remedy any release, investigate root causes, and improve program management and other controls to reduce the risk of future events.

Dry scrubber residue from flue gas desulfurization is our primary solid waste product from our heat-recovery cokemaking technology and can be taken to a solid waste landfill, as it is non-hazardous.

Overall, our heat-recovery cokemaking process does not generate substantial quantities of hazardous waste. The primary hazardous waste we generate is material from periodic cleaning of HRSGs, which is classified as a characteristic hazardous waste under the RCRA. Three of our facilities are episodic large-quantity generators under RCRA as a result of our periodic HRSG maintenance activities.

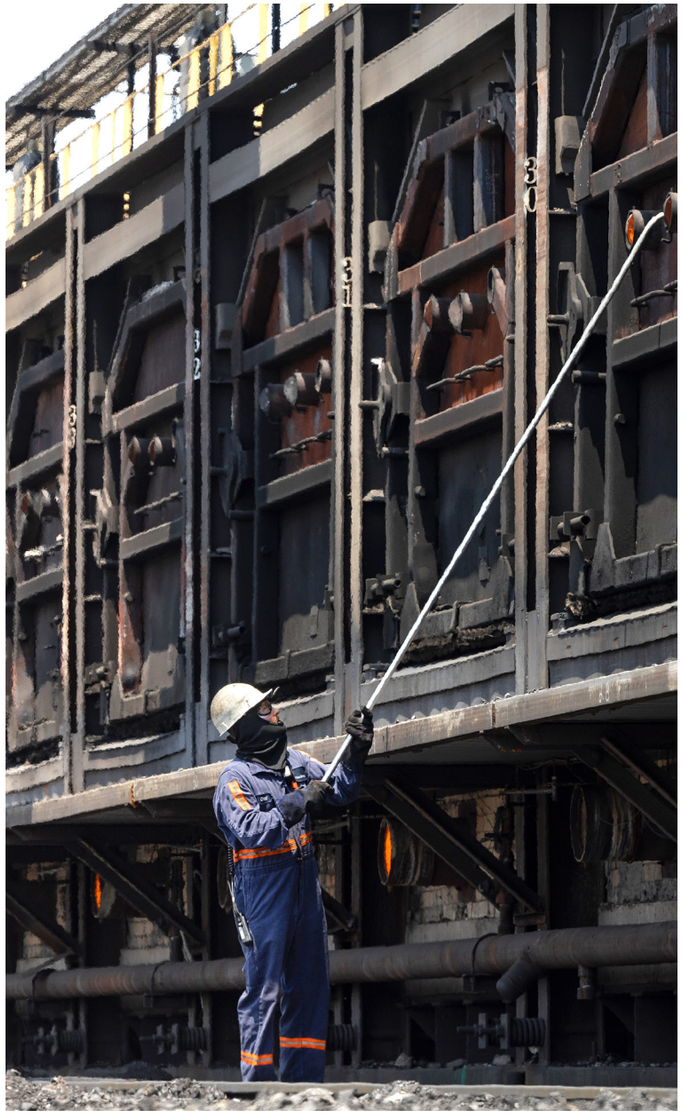
These facilities operate in compliance with RCRA requirements for episodic large-quantity generators, as follows:

- All personnel handling or managing hazardous wastes are properly trained.
- Specific areas are designated within each site for accumulation of wastes with the appropriate signage, storage, and secondary containment requirements.
- Accumulation areas are routinely inspected for evidence of actual or potential releases.
- Active hazardous waste contingency plans are maintained.
- All wastes are properly characterized prior to disposal.
- Hazardous wastes are shipped, tracked, and reported using hazardous waste manifests.

Prior to disposing of our hazardous wastes, we evaluate and tour any facility that we use to treat or dispose of hazardous waste to ensure they are fully and properly permitted and in compliance. This proactive approach limits our use of disposal facilities and associated risk of liability. All service providers that we choose are licensed and provide disposal information in line with reporting requirements. All contractor employees handling hazardous waste must be trained in EPA and Department of Transportation requirements for handling and transportation of hazardous waste materials.

Waste	**2021**	**2022**	**2023**
Percentage Waste Recycled	60%	89%	92%
Total Non-Hazardous Waste Produced, including recycling[18] (1,000 tons)	140.3	154.6	163.5
Total Hazardous Waste Produced at U.S. Facilities[19] (1,000 tons)	2.0	1.8	2.2
Total Hazardous Waste Produced at Brazil Coke Production Facility (1,000 tons)	0.3	0.3	0.1
Total Hazardous Waste Produced (1,000 tons)	2.2	2.1	2.3
Percent of Total Waste that is Hazardous	2%	1%	1%

Spills[20]	**2021**	**2022**	**2023**
Total Number of Reportable Spills	0	0	0
Total Spill Volume	0	0	0
Percentage of Spills Recovered	N/A	N/A	N/A



[18] Total Non-Hazardous Waste includes waste recycled.

[19] U.S. Facilities include both coke production facilities and terminals.

[20] Reportable Spills does not include accidental releases of stormwater or process cooling water.

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Social

Maintaining positive relationships with the communities in which we operate is paramount to SunCoke's continued success, as is maintaining a workforce where our team members feel included and empowered. Our emphasis on these two factors is arguably even more important and impactful when our employees come from the communities in which we work. By giving consideration to social policy and community relations, we can build upon and further strengthen long-lasting relationships. Through our continued operations, we hope to contribute to the further development of critical regions in the U.S., bolstering local economies and strengthening the local workforce for years to come.

Human Rights Issues

SunCoke's Human Rights Policy outlines our commitment to promoting the wellbeing of our employees and the communities in which we operate. We are committed to a diverse, inclusive environment, and comply with all applicable laws and standards related to labor practices and human rights at our facilities. We focus on providing a fair living wage, providing base pay well above the U.S. minimum wage, complying with all child labor laws, cultivating diversity in the workplace, and promoting employee health and safety. If we engage in any new business activities or geographic locations, we will review any potential human rights risks associated with those activities and update our list of human rights risks.

In 2023, we undertook a number of activities that demonstrate our commitment to our social values and our focus on our most relevant human rights risks. We continually monitor and manage a range of human capital and human rights risks. In alignment with the United Nations (UN) Guiding Principles Reporting Framework, we identified relevant human rights issues during the process of our annual ESG topic review and discussions and took the actions described below.

2023 Activities

Right not to be subject to discrimination

- Operated 24/7 reporting hotline and investigated all reports received.
- Maintained our policies, monitored for compliance, and enforced our no-retaliation policy.
- All employees successfully completed annual training on our anti-harassment, anti-discrimination, and no-retaliation policies.
- Provided diversity and inclusion (D&I) training to our workforce and to our HR managers.

Right to just and favorable work conditions

- Maintained our very low regrettable (voluntary) turnover of approximately 1%.
- Offered many employee benefits, including tuition reimbursement.
- Fulfilled our commitment to an excellent safety culture with our 24/7 EHS program.

Right to form or join a union

- Unions represent 44% of domestic employees.
- Maintained partnerships with unions in each of our union facilities.

Right to equal pay for equal work

- Continued to maintain commitment to diversity in our hiring process by pursuing diverse candidate slates and expanding visibility for our job postings.
- Maintained strict standards for employee protection requirements, including compliance with child labor laws and a commitment to a fair living wage.

Right to self determination

- Continued participation in Middletown Community Advisory Panel (CAP).
- Funded local community programming.
- Implemented robust succession planning and continued retention programs for employees.

Right to life and health

- Continued excellent safety record, reducing recordable rate from previous year.
- Achieved industry-leading 2023 TRIR of 0.99.
- Upheld commitment and continuous improvement effort to keeping employees safe with our robust safety and health program.
- Focused on driving safety from an expectation and leadership perspective.
- Continued focus on the safety programs implemented in Brazil in 2020.

Right to an adequate standard of living

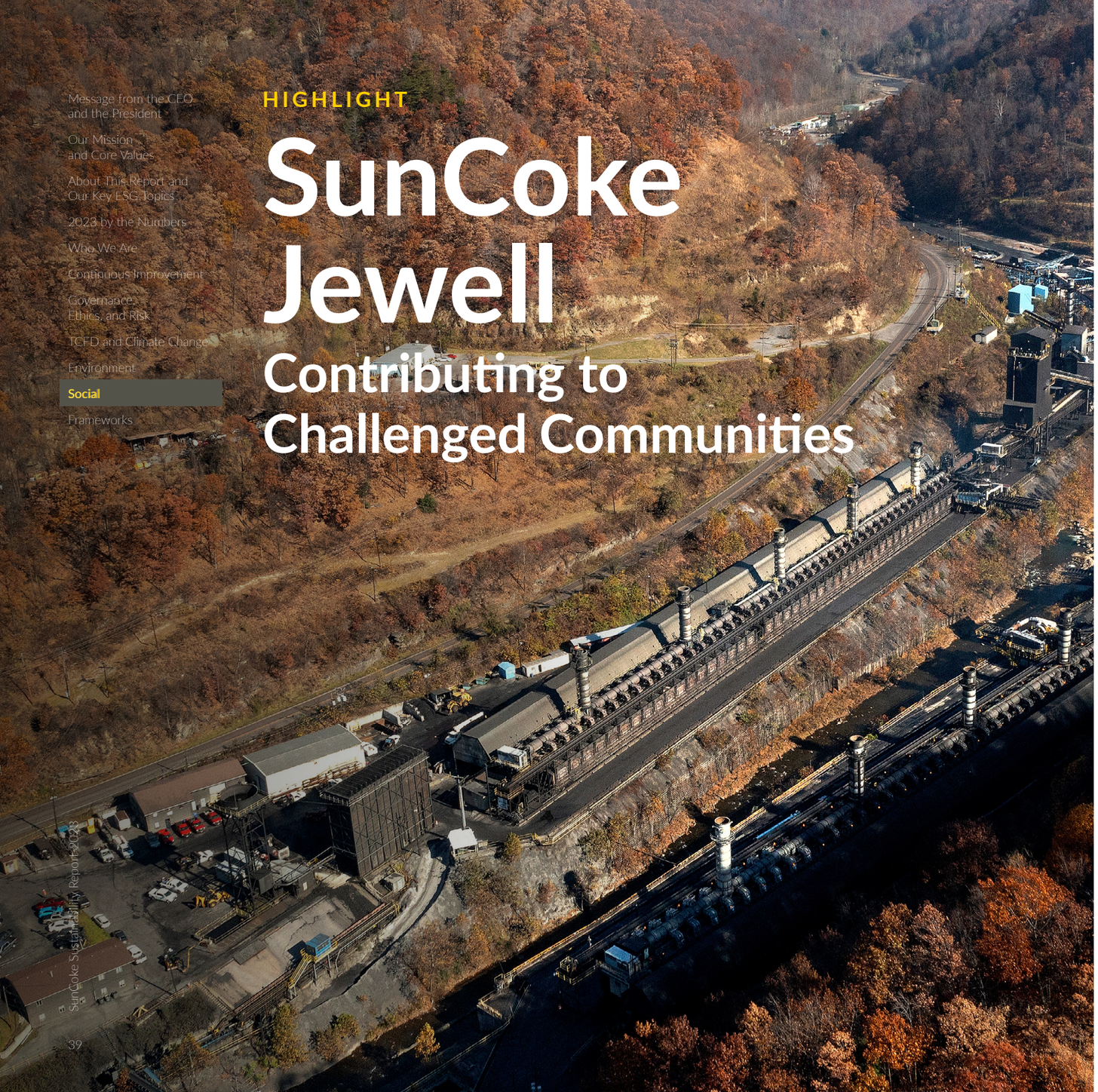
- Maintained our commitment to providing a living wage, providing base pay well above U.S. minimum wage and providing health care benefits and wellness programs to our employees.
- Continued market-based compensation assessments for new hires.

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HIGHLIGHT

SunCoke Jewell

Contributing to Challenged Communities



SunCoke's role in communities has been reinforced by community relations initiatives but is cemented by the role that SunCoke's plants and terminals play in contributing to the economic resiliency of communities over the long term. Nowhere has this been more important than in Buchanan County, Virginia, where SunCoke's Jewell Plant has operated since 1960. The Appalachian Regional Commission (ARC), an economic development partnership entity of the federal government and 13 state governments, has classified Buchanan County as Distressed.[21] This classification indicates that, based on three-year average unemployment rate, per capita market income, and poverty rate, Buchanan County, once a hub for the coal mining industry in the U.S., is one of the most economically distressed counties in the country. Data collected by the United States Census Bureau gives greater insight, indicating that, between 2018-2022, only 36.7% of Buchanan County's populations over the age of 16 was employed in the civilian workforce. In 2021, the United States Census Bureau recorded that the total employment in Buchanan County measured 3,973 residents.[22]

Beginning operations in 1960, the Jewell plant has provided stable, well-paid employment to Buchanan County for half a century. In 2023, the Jewell plant employed a daily average of 116 SunCoke employees and 70 contractors. This accounts for approximately 4.7% of Buchanan County's total employment, based on most recent publicly available data. The Jewell plant's reputation as a stable employer is illustrated by its average employee retention rate of 12 years. Employees remain at the Jewell Plant because of its competitive compensation packages and opportunities for upskilling. In 2023 alone, Jewell trained 36 employees to receive the American Red Cross – First Aid/CPR/AED Certification and 22 to receive the DMME/MSHA Electrical Repairman Certification Retraining. Finally, in addition to generating economic impact through employment, Jewell's operations account for approximately 7% of Buchanan County taxes, annually.

The Jewell Plant's community impact can be measured in numbers but can also be illustrated in experiences. In July 2022, the communities of Whitewood, Pilgrim's Knob, and Jewell Valley, Virginia, experienced flash flooding that caused significant damage, destroying dozens of homes, damaging many more, and laying waste to local infrastructure including bridges and the Pilgrim's Knob Community Center. SunCoke's Jewell Plant is located in Jewell Valley and has been a presence in the community for over 50 years. On the first day of the flood, Jewell plant employees mobilized to distribute food and water to community members, friends, and family in need. In the days, weeks, and months following, employees partnered with associations to clean debris created by the flood, supported bridge repairs, and participated in the revitalization of the Pilgrim's Knob Community Center. We are grateful to the communities surrounding the Jewell Plant for their immense contributions to the plant's success and will continue to make efforts to act as good neighbors.

[21] Appalachian Regional Commission, "Classifying Economic Distress in Appalachian Counties," https://www.arc.gov/classifying-economic-distress-in-appalachian-counties/.

[22] United States Census Bureau, "Quick Facts: Buchanan County, Virginia," https://www.census.gov/quickfacts/fact/table/buchanancountyvirginia/PST120221.

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Community Relations

Historically, SunCoke has focused on engaging with local communities in a variety of ways, including participating in community events, donating to local organizations and scholarships, and serving through charities. All SunCoke facilities have an annual charitable giving budget used to support local organizations of their choosing. In 2023, each site continued their annual tradition of charitable giving.

Workforce

Company leadership and our Board of Directors are actively involved in overseeing SunCoke's human capital management programs. Beyond Board and executive oversight, our Vice President of Human Resources, in partnership with local Human Resources and General Managers, sponsors the development and oversight of all human capital programs in the organization, including:

- Culture
- Workforce composition, recruitment, and our commitment to diversity, equity, and inclusion
- Workforce stability
- Employee development and training
- Benefits
- Talent management and total compensation
- Safety
- Ethics and compliance

Employee Development and Training

SunCoke provides a robust employee and contractor training program that meets or exceeds all applicable regulatory requirements for our industry. We also provide specialized trainings on an as-needed basis for current topics throughout the year. Over the past several years, special training topics have included Active Shooter Preparedness, Harassment, Worker's Compensation, Diversity and Inclusion, Conducting Effective Investigations, Retirement Planning, and Substance Abuse Awareness.

This past year, we partnered with Veritas Security Solutions to renew our Active Shooter Preparedness training. In-person training was provided to the corporate office as well as one plant, with a video recording being circulated to all of the plants and logistics facilities. Building on this specialized training, we partnered with One Way Safety to renew our confined space training.

We also offer employee assistance programs, including legal services, security training on identity theft, and tuition reimbursement.

We believe in developing our employees within their daily roles to be ready for their next assignment at SunCoke. Development occurs in the form of leadership training, stretch assignments, and on-the-job training. On an annual basis, we engage in active succession planning to ensure that we focus development and training activities on our high-performing and high-potential talent to ensure succession for our most critical roles.

SunCoke places emphasis on providing training to employees that allows them to develop new technical abilities. At the Indiana Harbor plant, employees are being given the opportunity to train as mechanics and electricians, with training cycles operating on an as-needed basis. The Jewell plant has even more expanded technical development opportunities, offering employees the chance to train as electricians, welders, crane operators, and welding inspectors. Further, salaried employees at the Jewell plant have the opportunity to take training in cost-failure analysis as well as metallurgical analysis. These activities have proven successful; we filled 46% of open positions with internal candidates in 2023.

Frontline Leader Management Training

This year, SunCoke's HR team has partnered with an external consultant to develop new frontline leader training programs. The training, beginning in 2024, is a movement from providing optional courses to embedding leadership training into SunCoke's culture. All frontline supervisors from each plant or logistics facility will attend, and the course will also be made optional to those showing management potential or interest. Some of the topics of the training will include conflict resolution and building the capacity to train others. Training will also incorporate workplace situations, including safety, allowing leaders to apply and practice the skills in a classroom setting first.

HR managers have continued to facilitate training on high-quality decision-making, communication, coaching, and improving workplace performance.

Leadership Retention and Workforce Stability

We recognize that workforce retention is a global issue affecting all sectors and geographies. SunCoke's commitment to employee retention has not wavered. The stability of our workforce is anchored by our experienced corporate leadership team along with our General Managers that lead day-to-day operations. Our leaders each have an average of over 20 years of leadership experience and an average of over 10 years with SunCoke. Furthermore, our average employee retention is between 10 and 11 years.

We strive to ensure that our development, benefits, performance management, and incentive programs are continually meeting the needs of our employees. Our success is demonstrated through our low regrettable turnover rate of approximately 1% in 2023.

Performance Management and Pay for Performance

Our full-year performance management process begins with setting annual goals for the Company, which guide the development of functional, local, and individual employee goals. Employees and their managers are accountable for the goals and must review their performance against the goals on an ongoing basis. We provide employee base wages that are competitive and consistent with employee position, skill level, experience, and geographic location.

Additionally, we believe that individual performance and the results of the Company are directly linked to the payment of annual short-term incentives, which is why a significant portion of employee compensation is performance based. Our short-term incentives are based on financial metrics as well as performance-based environmental and safety metrics. The level of pay at risk increases progressively with positions of greater responsibility, with long-term cash and equity incentives with multi-year vesting periods granted at the Director, Vice President, and Senior Vice President levels. Further, below the Director level, top performers may be granted long-term cash and equity incentives with multi-year vesting to help maximize retention. This practice helps the Company to retain those identified as having the top skills and abilities that are critical to our business.

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Benefits

We have a comprehensive offering of health, welfare, and retirement benefits. In addition, we offer supplemental benefits programs that aim to enhance the daily life and wellbeing of our employees, including:

- A benefits services price-transparency program
- Retirement planning education and coaching
- Paid time off programs including paid time for community service
- Tuition reimbursement
- Health management programs for chronic conditions
- A 24/7 employee assistance program
- Short- and long-term disability coverage
- Legal plan
- Identity Theft and Device Protection program
- Telemedicine programs, including behavioral health

These programs allow our employees to focus on their physical, emotional, and financial wellbeing.

Maintaining a Harassment-Free and Discrimination-Free Workplace

SunCoke is dedicated to providing a work environment free of harassment and discrimination, where all employees are assessed on their abilities and quality of work. We recognize that attracting and retaining a talented, diverse workforce requires that everyone have an equal opportunity to participate, contribute, and advance. We promptly and thoroughly investigate all allegations of harassment or discrimination, and do not permit any retaliation in the workplace.

We require that equal employment opportunities be afforded to all qualified individuals, without regard to race, color, ancestry, religion, sex, sexual orientation, national origin, age, pregnancy, physical or mental disability, citizenship status, veteran status, gender identity or expression, genetic information, or any other characteristic or status that is protected by federal, state, or local law. This policy applies to all employment decisions, including recruiting, hiring, promoting, tenure of employment, and all terms and conditions of employment.

Diversity and Inclusion

We partner with reputable recruitment firms to fill key positions. Through these partnerships, we have a commitment to fill our job slates with workers from all backgrounds.

In 2023, SunCoke's commitment to diversity recruiting includes a new partnership with Circa, giving our job postings better exposure to underrepresented communities by promoting them through over 600 locally focused sites. Hiring managers then focus on ensuring a diverse pool of candidates are considered for job postings.

Diversity and Inclusion Training

Our D&I training was continued from 2022 into 2023. For frontline leaders and all SunCoke management, the training was conducted by an outside firm. The aim of the training was to further develop the ability to foster diversity and inclusion and create an environment where everyone feels valued and has the opportunity to succeed. While we believe that these efforts are important to the Company's long-term performance and value, we recognize the importance of pursuing such efforts in legally compliant ways. We are committed to not making employment (including hiring, promotion, and compensation) or other contracting decisions on the basis of any legally protected characteristic.

Workforce Demographics

As of December 31, 2023, we had approximately 871 employees in our U.S. operations. The United Steelworkers represented approximately 40% of our domestic employees, principally at our cokemaking operations under various contracts. Additionally, 3% of our domestic employees were represented by the International Union of Operating Engineers. Labor agreements at Kanawaha River Terminal, Lake Terminal, and Indiana Harbor will expire on April 30, 2025, June 30, 2025, and September 1, 2026, respectively. As of December 31, 2023, we had approximately 280 employees at the cokemaking facility in Vitória, Brazil, all of whom were represented by a union under a labor agreement. During 2023, the labor agreement at our Vitória, Brazil, facility was renewed for an additional year, and it expires on October 31, 2024.





We successfully filled 46% of open positions with internal candidates in 2023.

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GRI, SASB, & TCFD

This report covers our sustainability data and performance metrics for calendar year 2023 and has been informed by GRI, SASB (Iron & Steel Producers and Coal Operations industry standards), and the recommendations of the TCFD.

GRI

GRI Standards	SunCoke Disclosure
GRI 2: General Disclosures 2021	
2-1 Organizational details	Who We Are 2023 Annual Report on Form 10-K SunCoke is a publicly traded company on the New York stock exchange under the symbol "SXC."
2-2 Entities included in the organization's sustainability reporting	Who We Are
2-3 Reporting period, frequency and contact point	Reporting period is calendar year 2023. SunCoke's Sustainability Report is published annually. About this Report and Our Key ESG Topics
2-4 Restatements of information	Based on the provision of updated data, a reporting inaccuracy for the total fresh water withdrawn from the Granite City facility was corrected for the years of 2021 and 2022.
	This affects the following indicators reported by SunCoke: Total Fresh Water Withdrawn, Total Fresh Water Withdrawn (U.S.), Total Water Consumption, Total Water Consumption (U.S.), and Percentage of Fresh Water Withdrawn from Locations with High Baseline Water Stress (Brazil). This correction represents a 1% increase amount of total fresh water withdrawn for 2021, and a 24% decrease in total fresh water withdrawn for 2022.
2-5 External Assurance	The data in this Sustainability Report has not been externally verified.
2-6 Activities, value chain and other business relationships	Who We Are Continuous Improvement 2023 Annual Report on Form 10-K
2-7 Employees	Social > Workforce
2-9 Governance structure composition 2-11 Chair of the highest governance body 2-12 Role of the highest governance body in overseeing the management of impacts 2-13 Delegation of responsibility for managing impacts 2-14 Role of the highest governance in sustainability reporting	Governance, Ethics, and Risk > Governance TCFD and Climate Change > Governance 2023 Proxy SunCoke Energy - About Us - Leadership - Board of Directors SunCoke's Chair of the Board is not an executive officer in the organization.
2-10 Nomination and selection of the highest governance body 2-17 Collective knowledge of the highest governance body 2-18 Evaluation of the performance of the highest governance body 2-20 Process to determine remuneration 2-21 Annual total compensation ratio	2023 Annual Report on Form 10-K 2023 Proxy SunCoke Energy - About Us - Leadership - Board of Directors Governance, Ethics, and Risk > Sustainability-Linked Renumeration Social > Workforce
2-15 Conflicts of interest 2-16 Communication of critical concerns 2-26 Mechanisms for seeking advice and raising concerns	Governance, Ethics, and Risk > Ethics Code of Business Conduct and Ethics
2-22 Statement on sustainable development strategy	Message from the CEO and the President
2-25 Processes to remediate negative impacts	Environment > Legacy Impoundment and Reclamation
2-27 Compliance with laws and regulations	Governance, Ethics, and Risk Code of Business Conduct and Ethics
2-29 Approach to stakeholder engagement	Governance, Ethics, and Risk > Enterprise Risk Continuous Improvement > Technical Partnership
2-30 Collective bargaining agreements	Social > Workforce 2023 Annual Report on Form 10-K

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GRI Standards	SunCoke Disclosure
GRI 201: Economic Performance 2016	
201-1 Direct economic value generated and distributed	2023 by the Numbers 2023 Annual Report on Form 10-K
201-2 Financial implications and other risks and opportunities due to climate change	TCFD and Climate Change > Strategy / Risk Management 2023 Annual Report on Form 10-K
201-3 Defined benefit plan obligations and other retirement plans	2023 Annual Report on Form 10-K
GRI 301: Materials 2016	
301-1 Material used by weight or volume	Governance, Ethics, and Risk > Enterprise Risk Regarding other raw materials, SunCoke undertook a review of operations with respect to conflict minerals. Because we do not source conflict minerals and they are not necessary to the functionality or production of our products, conflict minerals are not a significant issue to our business and are not applicable to our operations. As such, we do not currently have a conflict minerals policy.
GRI 302: Energy 2016	
302-1 Energy consumption within the organization	Environment > Energy Usage
302-4 Reduction of energy consumption	
GRI 303: Water and Effluents 2018	
303-2 Management of water discharge-related impacts	Environment > Water Management
303-3 Water withdrawal	
303-4 Water discharge	
303-5 Water consumption	
GRI 304: Biodiversity 2016	
304-2 Significant impacts of activities, products and services on biodiversity	Environment > Biodiversity and Disturbed Land
GRI 305: Emissions 2016	
305-1 Direct (Scope 1) GHG emissions	TCFD and Climate Change > Metrics
305-2 Energy indirect (Scope 2) GHG emissions	
305-3 Other indirect (Scope 3) GHG emissions	Scope 3 not reported.
305-4 GHG emissions intensity	TCFD and Climate Change > Metrics
305-5 Reduction of GHG emissions	TCFD and Climate Change > Metrics
305-7 Nitrogen oxides (NOx), sulfur oxides (SOx), and other significant air emissions	Environment > Air Emissions
GRI 306: Waste 2020	
306-1 Waste generation and significant waste-related impacts	Environment > Solid and Hazardous Waste Management / Legacy Impoundment and Reclamation
306-2 Management of significant waste-related impacts	
306-3 Waste generated	Environment > Solid and Hazardous Waste Management
306-4 Waste diverted from disposal	
306-5 Waste directed to disposal	
GRI 401: Employment 2016	
401-1 New employee hires and employee turnover	Social > Workforce
401-2 Benefits provided to full-time employees that are not provided to temporary or part- time employees	2023 Annual Report on Form 10-K
GRI 403: Occupational Health and Safety 2018	
403-1 Occupational health and safety management system	Continuous Improvement > Occupational Health & Safety
403-2 Hazard identification, risk assessment, and incident investigation	
403-4 Worker participation, consultation, and communication on occupational health & safety	
403-5 Worker training on occupational health & safety	
403-7 Prevention and mitigation of occupational health and safety impacts directly linked by business relationships	
403-8 Workers covered by an occupational health and safety management system	
403-9 Work-related injuries	
403-10 Work-related ill health	

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GRI 404: Training and Education 2016	
404-2 Programs for upgrading employee skills and transition assistance programs	Social > Workforce

GRI 405: Diversity and Equal Opportunity 2016	
405-1 Diversity of governance bodies and employees	2023 Proxy SunCoke Energy - About Us - Leadership - Board of Directors

GRI 413: Local Communities 2016	
413-1 Operations with local community engagement, impact assessment, and development programs	Social

SASB

SASB Iron & Steel Producers Industry Standard Version 2023-12	SunCoke Disclosure
Greenhouse Gas Emissions	
Gross global Scope 1 emissions, percentage covered under emissions limiting regulations	TCFD and Climate Change > Metrics None of our U.S. or Brazil Scope 1 emissions are covered under emissions-limiting regulations.
Discussion of long- and short-term strategy or plan to manage Scope 1 emissions, emissions reduction targets, and an analysis of performance against those targets	TCFD and Climate Change > Risk Management / Metrics Who We Are > Cokemaking Operations Continuous Improvement > Advanced Technology / Innovation and Evolution
Air Quality	
Air emissions of the following pollutants: (1) CO, (2) NOx (excluding N_2O), (3) SOx , (4) PM10, (5) manganese (MnO), (6) lead (Pb), (7) VOCs, and (8) PAHs	Environment > Air Emissions
Energy Management	
(1) Total energy consumed, (2) percentage grid electricity and (3) percentage renewable (1) Total fuel consumed, (2) percentage coal, (3) percentage natural gas and (4) percentage renewable	Environment > Energy Usage Within the reporting period, SunCoke did not directly source energy from renewable sources.
Water Management	
(1) Total water withdrawn, (2) total water consumed; percentage of each in regions with High or Extremely High Baseline Water Stress	Environment > Water Management Our coke production facility in Vitória, Brazil, is located in a region with high baseline water stress. In 2023, this location accounted for approximately 21 percent of our water withdrawal.
Waste Management	
(1) Amount of waste generated, (2) percentage hazardous, (3) percentage recycled	Environment > Solid and Hazardous Waste Management
Workforce Health & Safety	
(1) TRIR, (2) fatality rate, and (3) near miss frequency rate (NMFR) for (a) direct employees and (b) contract employees	Continuous Improvement > Occupational Health & Safety
Supply Chain Management	
Discussion of the process for managing iron ore or coking coal sourcing risks arising from environmental and social issues	TCFD and Climate Change > Risk Management Governance, Ethics, and Risk > Enterprise Risk
Activity metrics	
Total coking coal production	2023 by the Numbers

SASB Coal Operations Industry Standard Version 2023-12	SunCoke Disclosure
Waste Management	
Description of waste management policies and procedures for active and inactive operations	Environment > Solid and Hazardous Waste Management / Legacy Impoundment and Reclamation
Biodiversity Impacts	
Description of environmental management policies and practices for active sites	Environment > Biodiversity and Disturbed Land

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SASB Coal Operations Industry Standard Version 2023-12	SunCoke Disclosure
Labor Relations	
Percentage of active workforce employed under collective agreements	Social > Workforce As of December 31, 2023, we had 871 employees in the U.S. Approximately 40 percent of our domestic employees, principally at our cokemaking operations, were represented by the United Steelworkers union under various contracts. Additionally, approximately 3 percent of our domestic employees were represented by the International Union of Operating Engineers. As of December 31, 2023, we had 280 employees at the cokemaking facility in Vitória, Brazil, all of whom were represented by a union under a labor agreement. 2023 Annual Report on Form 10-K
(1) Number and (2) duration of strikes and lockouts	SunCoke had no strikes or lockouts within the reporting period.
Workforce Health & Safety	
Discussion of management of accident and safety risks and long-term health and safety risks	Continuous Improvement > Occupational Health & Safety
Tailings Storage Facilities Management	
Tailings storage facility inventory table: (1) facility name, (2) location, (3) ownership status, (4) operational status, (5) construction method, (6) maximum permitted storage capacity, (7) current amount of tailings stored, (8) consequence classification, (9) date of most recent independent technical review, (10) material findings, (11) mitigation measures, (12) site-specific Emergency Preparedness and Response Plans (EPRPs) Summary of tailings management systems and governance structure used to monitor and maintain the stability of tailings storage facilities Approach to development of EPRPs for tailings storage facilities	Environment > Legacy Impoundment and Reclamation We have one coal slurry impoundment, classified as high-hazard potential by MSHA. In 2023, 1 percent of produced waste was hazardous and 21 percent of waste was recycled.

TCFD

TCFD Recommendations	SunCoke Disclosure
Governance	
a) Describe the board's oversight of climate-related risks and opportunities b) Describe management's role in assessing and managing climate-related risks and opportunities	TCFD and Climate Change > Governance Governance, Ethics, and Risk
Strategy	
a) Describe the climate-related risks and opportunities the organization has identified over the short, medium and long-term b) Describe the impact of climate-related risks and opportunities on the organization's businesses, strategy and financial planning	TCFD and Climate Change > Strategy / Risk Management
c) Describe the resilience of the organization's strategy, taking into consideration different climate-related scenarios, include a 2°C or lower scenario	Climate scenarios not reported.
Risk Management	
a) Describe the organization's processes for identifying and assessing climate-related risks b) Describe the organization's processes for managing climate-related risks c) Describe how processes for identifying, assessing, and managing climate-related risks are integrated into the organization's overall risk management	TCFD and Climate Change > Risk Management Governance, Ethics, and Risk
Metrics and Targets	
a) Disclose the metrics used by the organization to assess climate-related risks and opportunities in line with its strategy and risk management process	TCFD and Climate Change > Risk Management / Metrics Environment
b) Disclose Scope 1, Scope 2, and, if appropriate, Scope 3 GHG emissions, and the related risks	TCFD and Climate Change > Metrics Scope 3 not reported.
c) Describe the targets used by the organization to manage climate-related risks and opportunities and performance against target	Targets not reported.

Forward-Looking Statements

This Sustainability Report (the "Report") describes certain sustainability initiatives that are not necessarily material for financial reporting purposes. Sustainability-related information is subject to standards and frameworks that are continuing to evolve, including those for collection, measurement, and monitoring of underlying data. Our disclosures, as well as relevant internal controls, may change due to revisions in standards or framework requirements, availability or quality of information, changes in our business or applicable government policies, or other factors, many of which may be beyond our control. We aim to align certain of our disclosures and initiatives with various third-party frameworks. However, we cannot guarantee strict adherence to these frameworks' recommendations. Any errors, refinements, or other changes in the information or methodologies we use may result in changes to our disclosed performance. Given the inherent uncertainty and assumptions associated with several of our disclosures, including those regarding possible future conditions, it may be difficult to assess the degree, magnitude, or importance of any such deviations in advance.

Some of the statements in this Report constitute forward-looking statements within the meaning of the Private Securities Litigation Reform Act of 1995. Forward-looking statements include all statements that are not historical facts and may be identified by the use of such words as "believe," "expect," "plan," "project," "intend," "anticipate," "estimate," "predict," "potential," "continue," "may," "will," "should," or the negative of these terms or similar expressions. Certain of the information in this Report is subject to assumptions, estimates, or third-party information that we have not independently verified, and which may change over time. The forward-looking statements in this Report describe sustainability goals and plans, expectations, and beliefs relating to, among other things, future events and performance. These forward-looking statements are not guarantees of future events or performance, but are made based upon management's current expectations, estimates and beliefs, any or all of which ultimately may prove to be inaccurate, and involve known and unknown risks, uncertainties, and other important factors, many of which are beyond SunCoke's control, that may cause actual results to be materially different from those expressed in the forward-looking statements.

In its filings with the Securities and Exchange Commission (the "SEC"), SunCoke has included cautionary language identifying important factors, but not necessarily all the important factors, that could cause actual results to differ materially from those expressed in any forward-looking statement made by SunCoke. For information concerning these factors, and further information about our Company, we urge you to read our filings with including our quarterly reports on Form 10-Q, current reports on Form 8-K, and our 2023 Annual Report on Form 10-K, which contains our audited financial statements. Copies of these filings are available free of charge in the "Investors" section of SunCoke's corporate website.

All forward-looking statements included in this Report are expressly qualified in their entirety by such cautionary statements. The forward-looking statements contained herein speak only as of the date of this Report and, except as otherwise required by applicable law, SunCoke expressly disclaims any obligation to update or revise such forward-looking statements, and/or associated cautionary language, whether as a result of new information, future events, or otherwise after the date of this Report. Website and document references in this Report are provided for convenience only, and absent express language to the contrary, such materials are not incorporated into this Report by reference.

Glossary

ACCCI	American Coke and Coal Chemicals Institute
AGC	Assistant General Counsel
AISI	American Iron and Steel Institute
BF	Blast Furnace
BOF	Basic Oxygen Furnace
C.A.	Combustion Air
CCO	Chief Compliance Officer
CO_2	Carbon Dioxide
CO_2e	Carbon Dioxide Equivalent
CMT	Convent Marine Terminal
CSR	Coke Strength after Reaction
CWA	Clean Water Act
D&I	Diversity & Inclusion
EAF	Electric Arc Furnace
EBITDA	Earnings Before Interest, Taxes, Depreciation, and Amortization
EHS	Environment, Health, and Safety
EPA	Environmental Protection Agency
EPRP	Emergency Preparedness and Response Plans
ERM	Enterprise Risk Management
ESG	Environmental, Social, and Governance
EU	European Union
EV	Electric Vehicle
GHG	Greenhouse Gas
GIS	Geographic Information System
GPI	Granulated Pig Iron
GRI	Global Reporting Initiative
HRSG	Heat Recovery Steam Generator
LTIR	Lost Time Incident Rate
MACT	Maximum Achievable Control Technology
MSHA	Mine Safety and Health Administration
MWh	Megawatt-Hour
NOx	Nitrogen Oxides
NPDES	National Pollution Discharge Elimination System
OSHA	Occupational Safety and Health Administration
PAH	Polycyclic Aromatic Hydrocarbon
PM	Particulate Matter
RCRA	Resource Conservation and Recovery Act
R&D	Research and Development
SASB	Sustainability Accounting Standards Board
SEC	Securities and Exchange Commission
SO_2	Sulfur Dioxide
TCFD	Taskforce on Climate-related Financial Disclosures
TJ	Terajoule
TRIR	Total Recordable Incident Rate
U.S.	United States
VOC	Volatile Organic Compound
ZISA	Zero Injury Safety Incidents Award

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