

NUCOR®

SASB Index



About Us

Nucor Corporation manufactures steel and steel products by recycling ferrous scrap and converting other high-purity iron units in Electric Arc Furnaces (EAFs). Nucor uses scrap steel as the primary raw material in producing steel and steel products. In 2024, we recycled approximately 20.3 million net tons of scrap steel.

Nucor is organized into three business segments: steel mills, steel products and raw materials. The steel mills segment is Nucor's largest, representing 75% of the company's sales to external customers in 2024. Almost all of Nucor's operating facilities and customers are in North America.

This report presents information aligned with the guidelines of the International Sustainability Standards Board's (ISSB's) Sustainability Accounting Standards Board (SASB) – Iron and Steel Producers sector standard. It covers our Steel Mills segment, which accounts for about 90% of Nucor's overall greenhouse gas emissions, including Scopes 1, 2 and 3. The information and data provided in this report address the requirements of the SASB guidelines to the maximum extent possible, considering data availability. This document complements and expands upon our sustainability reporting, including our 2024 Corporate Social Responsibility Report, our most recent TCFD Report, and our public filings with the Securities and Exchange Commission. For additional information, please refer to [nucor.com/investors](https://www.nucor.com/investors) and [nucor.com/ESG](https://www.nucor.com/ESG).

Nucor Steel Mills

Nucor produces a variety of steel products in its steel mills, including sheet steel (hot-rolled, cold-rolled, and galvanized), plate steel, structural steel (wide-flange beams, beam blanks, H-piling and sheet piling) and bar steel (blooms, billets, concrete reinforcing bar, merchant bar and engineered special bar quality "SBQ"). Nucor manufactures steel primarily from scrap steel and scrap steel substitutes using EAFs, along with continuous casting and automated rolling mills.

Nucor's steel mills primarily sell products to steel service centers, fabricators and manufacturers throughout the United States, Canada and Mexico. In 2024, the Steel Mills Segment sold approximately 18.5 million tons to external customers, representing 80% of our shipments. The remaining 20% of the Steel Mills Segment's shipments went to Nucor's Steel Products Segment.

The data represented in the following tables reflects 2024 metrics from the steel mills owned and operated by Nucor.

Activity Metrics for Nucor Steel Mills				
Raw Steel Production	2024	2023	2022	SASB Code
Metric Tons Cast (million t)	21,000,000	21,100,000	20,500,000	EM-IS-000.A
Percentage - Basic Oxygen Furnace (%)	0%	0%	0%	
Percentage - Electric Arc Furnace (%)	100%	100%	100%	
Total Iron Ore Production ¹ (t)	0	0	0	EM-IS-000.B
Total Coking Coal Production ² (t)	0	0	0	EM-IS-000.C

1. Nucor does not produce or use iron ore at any of its steel mills. However, iron ore is consumed at Nucor's Direct Reduced Iron (DRI) operations, where DRI is produced and then sold internally to our steel mills for use.
 2. Nucor does not produce coking coal at any of its steel mills. However, coal or coke may be purchased and used as a raw material in our steel-making operations.

Steel Mill Greenhouse Gas Emissions				
	2024	2023	2022	SASB Code
Scope 1 Greenhouse Gas Emissions	4,300,000	4,300,000	4,600,000	EM-IS-110a.1
Percentage Covered Under Emissions-Limiting Regulations	2%	2%	Not Available	





Our Strategy to Manage Scope 1 Emissions (EM-IS-110a.2)

Nucor's Electric Arc Furnaces (EAFs) produce the most diverse range of steel shapes and grades in the U.S., with some of the lowest greenhouse gas (GHG) emission rates and highest energy efficiencies per ton of steel among carbon steel producers worldwide. EAFs are among the cleanest steel production processes, utilizing significant quantities of recycled content. There is growing interest in our EAF-produced steels among manufacturers, construction contractors, engineers, architects and government agencies who value the lower GHG intensity, high recycled content and end-of-life recyclability of our products. Some customers are even incorporating GHG intensity and recycled content requirements into their product specifications.

Nucor is committed to reducing GHG emissions intensity and mitigating our impact on climate change by becoming more energy-efficient and less carbon-intensive across all aspects of our business. Our focus extends to reducing Scope 1 and Scope 2 emissions, as well as Scope 3 emissions, particularly those associated with the carbon-intensive raw materials used in our steelmaking operations.

Greenhouse Gas Targets

In January 2025, Nucor announced that the Global Steel Climate Council (GSCC) certified Nucor's science-based net-zero targets in alignment with the GSCC's "Steel Climate Standard" and the International Energy Agency's "Net Zero by 2050: A Roadmap for the Global Energy Sector." These targets, grounded in science-based criteria, are a crucial step toward environmental sustainability and align with the Paris Agreement's aim to limit global temperature rise to below 1.5°C above pre-industrial levels. Our net-zero target includes reaching a GHG intensity of 116 kg GHGs per metric ton of steel, covering Scopes 1, 2 and 3 emissions.

Additionally, Nucor has set an interim science-based GHG reduction target for 2030, aiming for 975 kg GHGs per metric ton of steel, also inclusive of Scopes 1, 2 and 3 emissions. To achieve these targets, Nucor has implemented comprehensive plans, demonstrating our dedication to reducing our carbon footprint and advancing toward a more sustainable future.

Net-Zero Strategies

With our new science-based targets, Nucor has developed a comprehensive strategy to achieve emissions reductions across Scopes 1, 2, and 3. For Scope 1, our strategies focus on enhancing circular steelmaking, optimizing the use of carbon materials and upgrading existing equipment. In Scope 2, we prioritize energy efficiency projects, collaborate with utility providers to green the grid and invest in clean energy through Power Purchase Agreements (PPAs). Our Scope 3 strategies include utilizing greener raw materials, implementing carbon capture technologies and investing in low carbon-intensity iron sources. For more information on Nucor's targets and net-zero strategies, please refer to our **2024 Nucor Sustainability Report**.

Net-Zero Strategies Summary Overview

Scope 1 Strategies

Pioneering Circular Steel	Nucor has been a pioneer in the steel industry for over 50 years, employing electric arc furnaces to manufacture a wide variety of essential steel products by recycling scrap metal. This approach has enabled Nucor to achieve a greenhouse gas emissions intensity less than half of the global average. We are committed to sustaining this momentum by leveraging innovative practices to advance the circular economy further and continuing to lower our greenhouse gas footprint.
Supersonic Injection	Nucor utilizes injection carbon in steelmaking operations to provide additional energy for melting materials in electric arc furnaces. We are currently investigating supersonic injection methods to enhance the efficiency of this process, aiming to reduce the quantity of carbon material required per ton of steel.
Reheat Furnace Upgrades	Nucor recognizes the substantial natural gas consumption and direct greenhouse gas emissions associated with reheat furnaces at our mills. We are actively investigating options to enhance furnace efficiency and continue to invest in micro-mill technologies, which eliminate the need for steel reheating by immediately rolling cast steel.

Scope 2 Strategies

Supporting Electricity Grid Decarbonization	Electricity serves as the primary energy source for melting scrap metal in Nucor's electric arc furnaces, making us a significant consumer of electrical power, and contributing to our Scope 2 emissions. Consequently, Nucor is actively collaborating with utilities to advocate for the adoption of zero-carbon electricity generation methods.
Renewable Power Purchase Agreements	Nucor leverages power purchase agreements (PPAs) to procure renewable electricity for our operations, aligning with our commitment to sustainability. The renewable energy credits obtained from these PPAs are utilized to decrease the environmental footprint of our Econiq line of products, contributing to reduced GHG intensity.
Investing in Clean Energy	Nucor's electric arc furnaces require a reliable supply of electricity. To help meet this demand sustainably, Nucor is partnering with companies advancing next generation zero GHG nuclear technologies such as NuScale and Helion.
On-Site Renewable Power Generation & Storage	At select facilities, we are actively pursuing increased use of on-site solar power generation and energy storage to lower our power costs and reduce the carbon footprint of our power consumption.
Energy Efficiency Projects	Nucor remains committed to enhancing energy efficiency across all its facilities as a key strategy to reduce greenhouse gas emissions. Through ongoing efforts, we aim to achieve greater operational efficiency and contribute to a more sustainable future.

Scope 3 Strategies

Low Copper Shred	Nucor has initiated a low copper shred project at its Berkeley, South Carolina facility. This initiative focuses on removing non-magnetic materials, like copper, to enhance the quality and utility of scrap metal. By increasing recycled content and reducing our reliance on high-embodied carbon iron inputs, Nucor can produce even higher quality steel materials with low environmental impacts.
Low Carbon Iron Innovations	Iron inputs, such as pig iron and Direct Reduced Iron (DRI), are energy-intensive to produce and contribute significantly to Scope 3 emissions in steelmaking. To mitigate the environmental impact of its iron inputs, Nucor is actively investing in and exploring methods to produce them with much lower carbon footprints.
Green Raw Materials	Nucor is dedicated to revolutionizing the steelmaking process by sourcing greener raw materials, including lower carbon ingredients, bio-based materials, and reclaimed waste, to align with its environmental goals. By integrating these sustainable alternatives, Nucor is reducing its product footprint and advancing a more sustainable steel industry.
NSLA Carbon Capture	In June 2023, Nucor finalized an agreement with ExxonMobil to implement a Carbon Capture & Sequestration process at our Louisiana DRI plant. This initiative will enable us to capture, transport and store up to 800,000 metric tons of CO ₂ annually, lowering the GHG emissions profile of Louisiana's DRI.

Energy Management

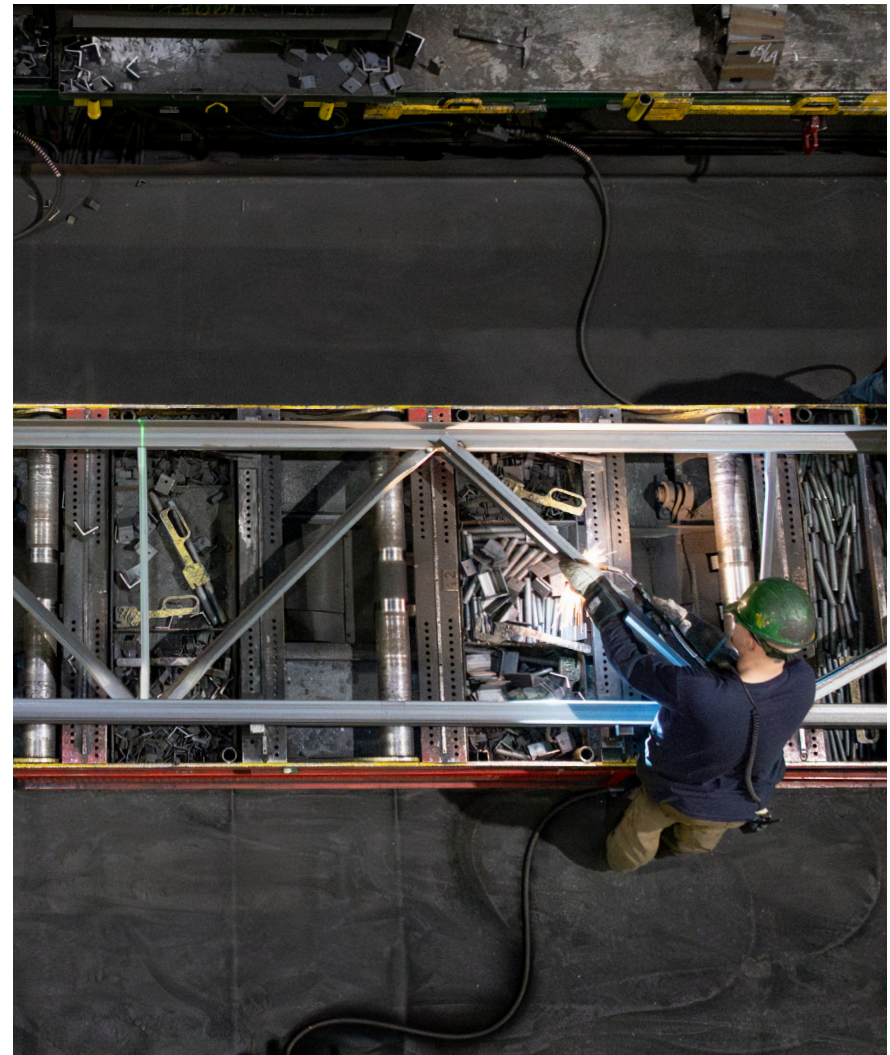
	2024	SASB Code
Total Energy Consumed ¹ (GJ)	110,155,000	EM-IS-130a.1
Percentage Grid Electricity	51%	
Percentage Renewable	7%	
Total Fuel Consumed (GJ)	53,459,000	EM-IS-130a.2
Percentage Coal (%)	22%	
Percentage Natural Gas (%)	71%	
Percentage Renewable (%)	0%	

1. Energy and fuel consumption measured in Gigajoules (GJ). The total energy consumed by Nucor includes purchased electricity, natural gas, and carbon raw material inputs. Electricity is the primary energy source for the scrap melting process.

Air Quality

Air Emissions ¹	2024	SASB Code
Carbon Monoxide (t)	21,000	EM-IS-120a.1
Nitrogen Oxides, excluding N ₂ O, (t)	4,100	
Sulfur Oxides, as SO ₂ (t)	2,500	
Particulate Matter, as PM ₁₀ (t)	1,800	
Manganese (t)	13	
Lead (t)	3	
Volatile Organic Compounds (t)	1,100	
Polycyclic Aromatic Hydrocarbons (t)	Limited Data Available	

1. The air emissions estimates in this disclosure attempt to quantify emissions from all regulated activities and sources of emissions at the steel mills. Sources of emissions include production and process emissions, emissions from transportation of materials, including roadway emissions, and ancillary equipment emissions. The estimated emissions do not include emissions from office buildings and sources of emissions not subject to regulation under the Clean Air Act.



The air emissions data listed in this report is a compilation of information from each individual Nucor steel mill. This data is not intended to be used for regulatory purposes. If available, emissions data obtained from continuous emissions monitors (CEMs) is included in this disclosure. Absent CEMs data, the emissions were determined based upon performance test data, engineering calculations, material analyses and mass balance equations. As required by the Clean Air Act Title V operating permits, the air emissions data reflects information provided to the regulatory agencies pursuant to 40 CFR 70.6 and 40 CFR 71.6.

Water Management		
	2024	SASB Code
Total Fresh Water Withdrawn Thousand Cubic Meters (m ³)	27,000	EM-IS-140a.1
Percentage Recycled (%)	88%	
Percentage of Operations with High or Extremely High Water Stress (%)	17%	

In our commitment to minimizing our environmental impact, we prioritize the efficient use of water resources across our operations. By implementing advanced treatment systems, we have achieved the ability to recycle as much as 90% of our water up to 8-10 times before it requires disposal. Additionally, we have strategically constructed stormwater retention ponds throughout our facilities to capture and reuse stormwater runoff. Recognizing the vital role water plays in our cooling processes, we remain aware of the potential adverse impacts excessive water withdrawal can have on local ecosystems and communities. For additional metrics on water management, please refer to Nucor's **2024 Nucor Sustainability Report**.

Waste Management		
	2024	SASB Code
Amount of Waste Generated (t)	1,200,000	EM-IS-150a.1
Percentage Hazardous (%)	34%	
Percentage Recycled (%)	59%	

While Nucor's reliance on EAF technology means that it recycles more than 20 million tons of ferrous scrap that might otherwise be landfilled, its process does produce some amount of waste. However, the two primary sources (on a volume basis) of waste generated by Nucor EAF operations are themselves considered valuable commodities and are recycled for further uses and applications. These are steel slag and particulate emissions collected by air pollution control equipment (baghouse dust), which contains zinc. Approximately 99% of all such materials are recycled by Nucor.





Workplace Health and Safety				
	2024	2023	2022	SASB Code
Total Recordable Incident Rate at Nucor Steel Mills (recordables per 200,000 hours)	0.72	0.62	0.59	EM-IS-320a.1
Total Fatality Rate	0	0.0003	0	
Near Miss Frequency Rate (NMFR) for (a) Direct Employees and (b) Contract Employees	Not Available	Not Available	Not Available	

Nucor continues to embrace the goal of becoming the “World’s Safest Steel Company” as a core part of our mission. To make continued progress toward world-class safety performance, we have initiated new regional safety competitions among our operations, focused intently on hand safety and leveraged outside expertise to further develop our front-line leaders’ safety focus. We are pleased with our progress, achieving a company-wide injury and illness rate of 0.77 (number of OSHA recordable incidents per 200,000 hours worked) for 2024.

Our mills are registered to Occupational Safety & Health Management Systems, including OHSAS 18001 and ANSI Z10, with divisions investigating conversion to the new ISO 45001. All divisions have access to Safety & Health Professionals, both internally and externally, to ensure best practices are followed and legal requirements, including OSHA, NFPA, FRA, DOT, and ANSI, are met. Additionally, Nucor facilities participate in OSHA’s Voluntary Protection Program (VPP), which recognizes companies that voluntarily implement effective safety and health management systems and maintain injury and illness rates below national industry averages. Currently, 24 Nucor facilities are recognized as OSHA VPP Sites. Additional information relating to Nucor’s safety management practices can be found in the **2024 Nucor Sustainability Report**.



Supply Chain Management (EM-IS-430a.1)

A steady supply of high-quality scrap and scrap substitutes is essential for Nucor to produce high-quality steel. Our raw materials segment safely produces, sources, trades and transports the necessary steelmaking raw materials. Nucor's steel mills consume ferrous scrap and virgin iron units (e.g., DRI, Pig Iron, HBI) sourced both domestically and internationally by this segment. These materials constitute our largest production cost.

In 2024, the David J. Joseph (DJJ) company processed over 5.6 million tons of ferrous scrap and supplied a total of 20 million tons, with the balance sourced by DJJ's scrap brokerage operations. This scrap supply is predominantly domestic, supported by a well-established U.S. supply chain ranging from sole proprietors to large firms like DJJ. Robust processes are in place to monitor scrap for dangerous materials and report stolen scrap, often assisting law enforcement. Most virgin iron units are sourced internationally, primarily from suppliers in Brazil. Following the 2021-2024 geopolitical events, we ceased sourcing from Russia. Energy, another major input, is sourced from electric utilities, regional grids and gas pipelines.

We use various methods to assess the safety, human rights, and environmental performance of our suppliers, including in-person visits and third-party reports. Nucor maintains and implements several relevant policies, such as our Human Rights Policy, Supplier Code of Conduct and policies against human trafficking and forced labor, all accessible at www.nucor.com/ESG.

Nucor's broad, diversified supply chain is a significant strength, reducing steelmaking costs, shortening the supply chain and providing greater flexibility over our metallic inputs. The successful implementation of our raw material strategy, including key investments in DRI production and DJJ's scrap brokerage and processing services, gives us greater control over our metallic inputs.