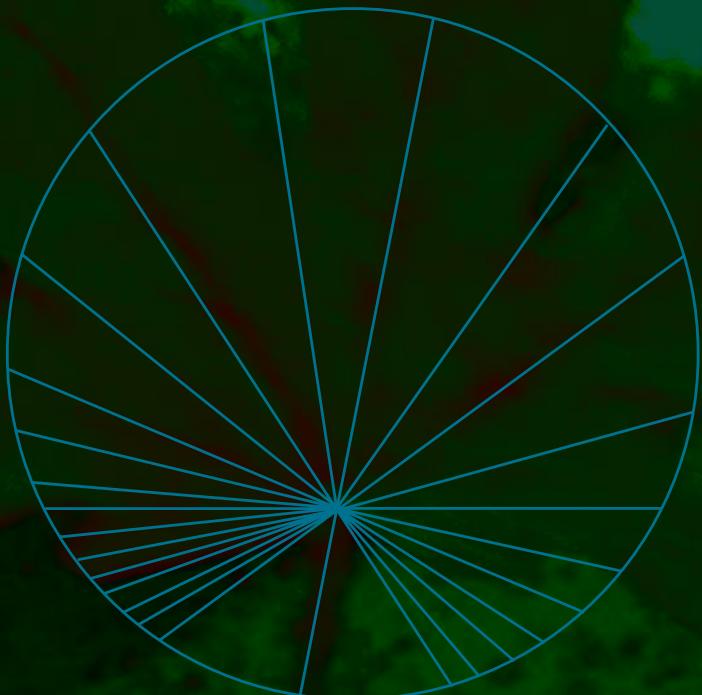




Working Responsibly

Corporate Responsibility Report



Valuing our World

For many years, the Koppers name has stood for quality and dependability. We are building on that quality and dependability with a commitment to corporate responsibility, including excellent safety, health and environmental performance.

Our mission is to be the most valued supplier of quality products and services to the industries we serve, providing unsurpassed personal attention to our customers and attaining total quality in everything we do. Our dedication to quality, coupled with our flexibility, enables Koppers to be the leader in the markets we serve around the world.

We believe in corporate responsibility—a way of doing business that safeguards the environment, conserves natural resources and makes sustainable contributions to society. This is the essence of sustainability for Koppers.

Corporate responsibility influences the way we work every day. Our initiatives to protect the environment, the health of our employees and our communities are strategic priorities. To move these priorities forward, we have developed a Safety, Health and Environmental Management System and have gained ISO 14001 certification at our global manufacturing facilities. Through our management system, we set performance targets, provide training and openly communicate with our neighbors about our work. Our management system makes it possible for us to build a culture of excellence at each of our operating facilities.

Corporate responsibility is good for business. Ethical business practices and outstanding customer service are essential for the ongoing financial health of our company. Through our commitment to corporate responsibility, we enhance products, improve health and safety practices, reuse byproducts, and reduce our impact on the environment.

This report is one way that Koppers demonstrates its commitment to corporate responsibility. Within this report, we discuss issues and report our progress in a clear and comprehensive manner. We hope you find this report useful and thank you for your interest in Koppers.



Walter W. Turner,
President,
Chief Executive Officer



Leslie S. Hyde
Vice President,
Safety and Environmental Affairs



Randall D. Collins
Vice President,
Regulatory Affairs

About Us

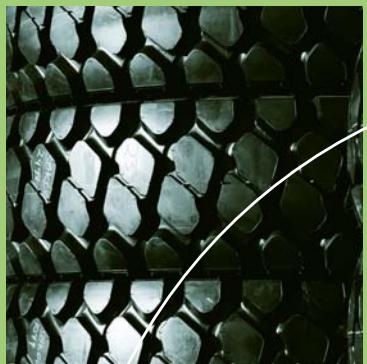
Koppers, with corporate headquarters and a technical center in Pittsburgh, Pennsylvania, is a global integrated producer of carbon compounds and treated wood products for use by the utility, construction, railroad, aluminum, chemical and steel industries. Including its joint ventures, Koppers operates 37 facilities in the United States, United Kingdom, Denmark, Australia, the Pacific Rim and South Africa. The company's stock is shared by a large number of employee investors and by majority equity owner Saratoga Partners of New York, N.Y. Koppers was established in December 1988 as a management buyout of carbon materials and wood treating assets from Koppers Company, Inc. For more information, visit www.koppers.com.



In the global world of business, no corporation stands alone. At Koppers, we understand the importance of facing global business issues in a responsible manner. We are committed to business practices that benefit our customers, employees, shareholders, the environment and our communities.

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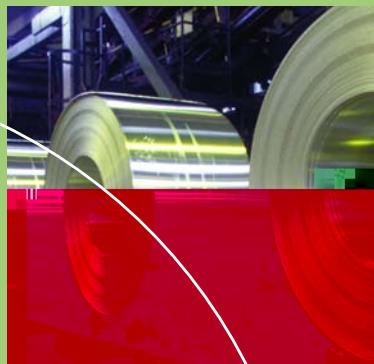
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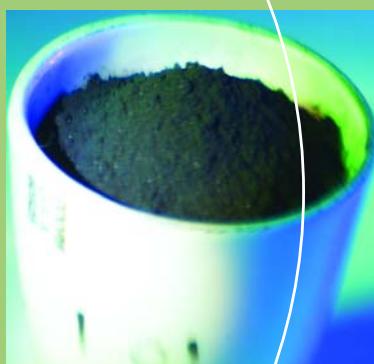
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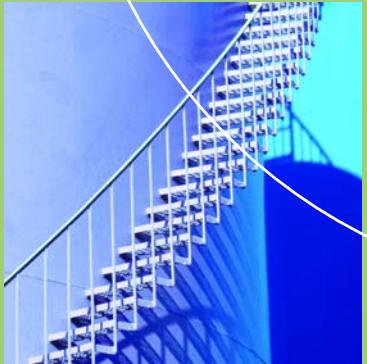
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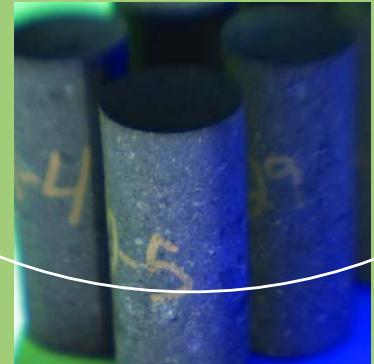
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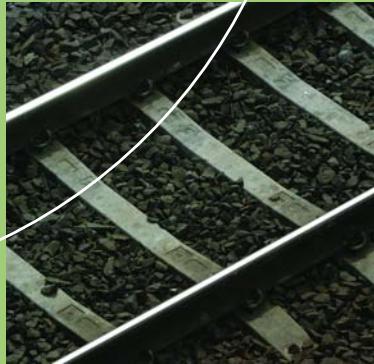
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Producing and Contributing

responsibly

Working Responsibly through Product Stewardship

Koppers and its customers sustain the infrastructure of our technologically driven world. We supply products to the railroad, steel, aluminum, construction and power industries that facilitate transportation of people and goods, and aid power and communication transmission. These services improve the quality of modern life.

Koppers is committed to exploring new opportunities in our businesses that will contribute to the global economy. For example, researchers at our technical headquarters in Harmarville, Pennsylvania in the United States are investigating production and applications of specialty high-softening-point carbon pitches and mesophase pitches. These specialty pitches have the potential to produce improved friction materials, which could lead to the development of more effective, less expensive and longer-lasting brake systems for aircraft and automobiles. We are developing specialty carbon structures for improved heat and electricity management, which may someday lead to improved energy conservation.

Compliance with consumer safety regulations is a foundation for product stewardship at Koppers. We not only provide Material Safety Data Sheets on all our products, we provide additional resources detailing safe handling and use information for specific products. MSDS information is available for all Koppers products by accessing our website, www.koppers.com, or by calling an MSDS on-demand hotline 866 852 5239.

1. [Automotive Tires](#)
2. [Creosote](#)
3. [Aluminum Coils](#)
4. [Utility Poles](#)
5. [Carbon Black](#)
6. [Steel Stairway](#)
7. [Core samples of Carbon Anodes](#)
8. [Railroad Ties](#)

Working Responsibly by Contributing to Society

Koppers recognizes that its manufacturing operations impact the lives of people in many ways, directly and indirectly. As a responsible company, we are committed to managing our operations in ways that provide the greatest benefits to our customers, employees, shareholders, the environment and our neighbors.

Economic

Koppers provides our customers with products and services that drive important industries around the world. Our carbon pitch, for example, is used to produce steel and aluminum, keeping these major industries and their employees productive.

In cities and towns in eleven countries on five continents, Koppers operating facilities have provided quality jobs to residents, in some cases, for generations. Koppers and its employees contribute to local government revenues and create demand for local housing, goods and services.

Social Responsibility

We engage in open communication with our neighbors through Community Advisory Panels at many of our facilities. Through these organizations, Koppers and community representatives learn from each other. We work cooperatively with local law enforcement, emergency response and regulatory agencies to protect our neighbors, employees and the environment. By interacting with our neighbors, we create open lines of communication that promote better understanding and trust.

Koppers and its employees are active participants in our communities, contributing to various charities. Many employees volunteer in local service organizations. We strive to be leaders in the business community, demonstrating our corporate citizenship through service on boards and monetary donations.

Koppers and its employees connect excellence in safety and environmental performance to our communities. Safety, health and environmental excellence is recognized by the Directors' Award for Safety Excellence, the Environmental Stewardship Award and the Environmental Compliance Award. When plant employees win one of these awards, they receive a financial stipend that is donated to local charities of their choice.

Protecting Safety, Health and the Environment

responsibly

Working Responsibly for Safety and Health

At Koppers, safety and health are core values. We regularly review and improve processes, procedures and work areas to protect employees. Through behavior-based safety training and practices, we encourage employees to accept responsibility for their own safety and to look out for each other.

Monitoring Safety and Health

Koppers tracks and reports on its progress in keeping employees safe and healthy. Fewer safety incidents can positively influence morale, productivity and costs. In turn, healthy workers enjoy uninterrupted employment, which better enables each of our employees to meet commitments and obligations.

Koppers conducts monitoring studies to protect employees' health and ensure regulatory compliance. Depending upon the job assignment, employees are evaluated for various health indicators.

Recognition for Safety Performance

Koppers promotes personal responsibility by sponsoring internal awards for safety excellence. Locations that complete 12 months and 100,000 hours without any safety related incidents receive the Directors' Award for Safety Excellence. This award recognizes the plant, individual employees, and their families with a variety of rewards. The community benefits from a donation to local nonprofits selected by employees.

In 2004, these plants received the Directors' Award for Safety Excellence:

- Roanoke, fourth award, 109,000 hours without incident
- Koppers Arch, Malaysia, second consecutive award, 300,000 hours without incident
- Koppers Arch, South Africa, 102,000 hours without incident
- Koppers Arch, New Zealand, 106,000 hours without incident

Historically, the U.S. National Safety Council (NSC) recognizes Koppers for exemplary safety performance, honoring certain facilities with Perfect Record Awards for working at least 12 consecutive months without a Days Away from Work (DA) case. It also awards the NSC Green Cross for Safety Excellence Achievement Award for Days Away from Work (DA) rates that are less than 50 percent of the Bureau of Labor Statistics (BLS) rate for industries in the applicable North American Industry Classification code.

In 2004, 12 Koppers facilities met the criteria for the Perfect Record Awards and are expected to qualify: Eastern Region Procurement, Florence, S.C., Follansbee, W. Va., Gainesville, Fla., Guthrie, Ky., Montgomery, Ala., Muncy, Pa., Portland, Ore., Roanoke, Va., Superior, Wis., Western Region Procurement and Woodward, Ala.

Thirteen plants met the criteria for the NSC Green Cross for Safety Excellence Achievement Award and are expected to qualify: Eastern Region Procurement, Florence, S.C., Follansbee, W. Va., Gainesville, Fla., Galesburg, Ill., Guthrie, Ky., Montgomery, Ala., Muncy, Pa., Portland, Ore., Roanoke, Va., Superior, Wis., Western Region Procurement and Woodward, Ala.

In 2004, Koppers was recognized by several railroads for maintaining an excellent record of safely transporting materials that are classified as hazardous. They were: Norfolk Southern Corporation (third award for Koppers), Kansas City Southern Railway and Canadian National Railway Company. In addition, the Scunthorpe Area Health and Safety Group presented the Koppers plant in Scunthorpe, UK with an Award for Prevention of Accidents for continuing their high safety performance.

Working Responsibly for the Environment

Koppers focuses on improving its environmental performance in order to minimize the impact of our operations on natural systems, including ecosystems, land, air and water. We seek ways to further reduce the generation of waste, and find more efficient and effective ways to reuse the byproducts of our operations.

Environmental Commitment

Koppers strives to use energy, raw materials and other resources wisely. Our goal is to reduce or eliminate environmental releases and the generation of waste materials through ongoing improvement processes. We regularly report on our progress toward this goal.

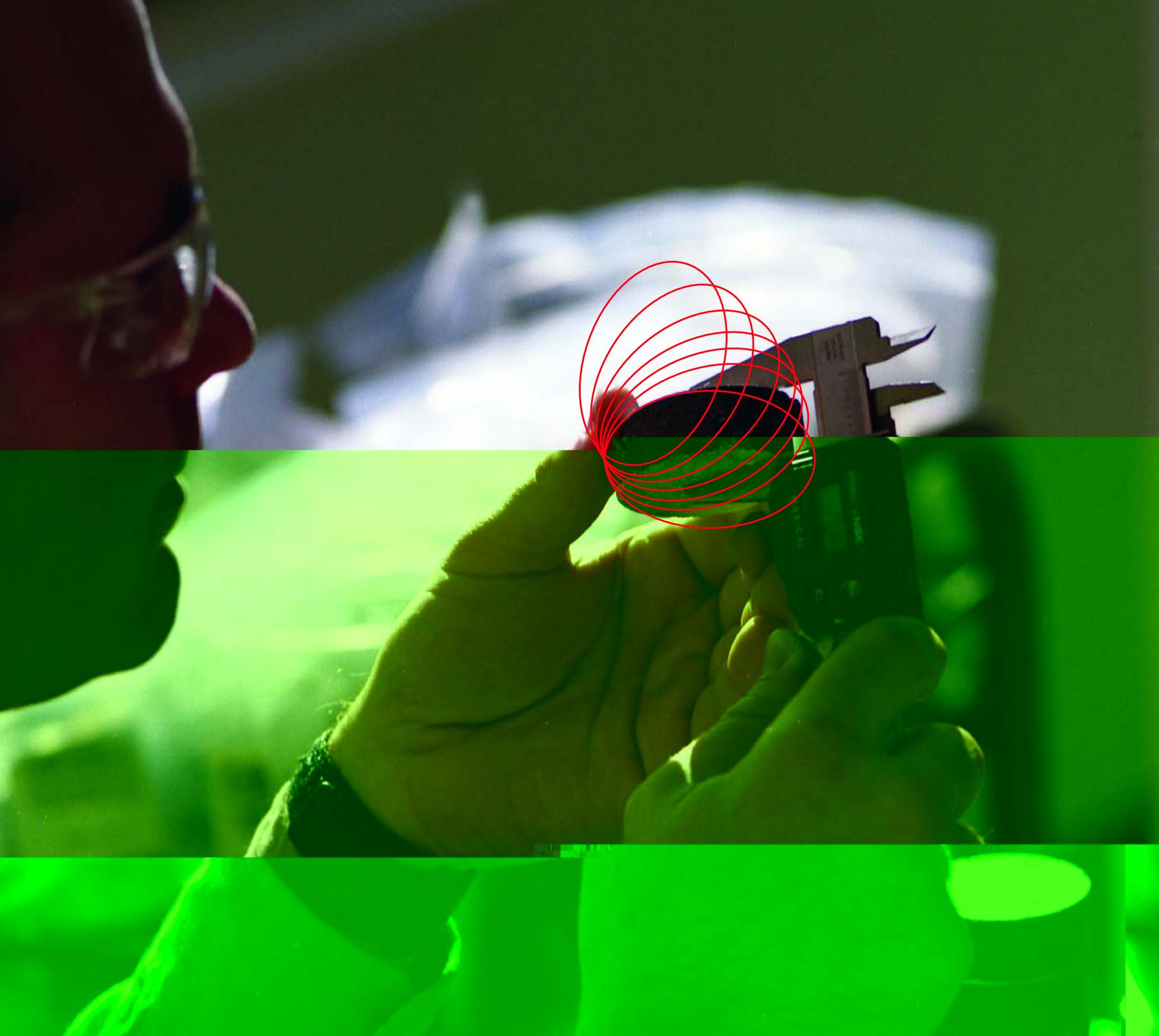
Our goal is to comply with or exceed expectations of all environmental regulations. To do so, we update our operations to meet changing federal, state, local and international regulations, as well as our internal standards. We conduct appropriate training to achieve this goal.

Rewarding Innovation

Through the Environmental Stewardship Award, Koppers encourages plant employees to find new ways to conserve or reduce energy use, prevent pollution and reduce waste. In 2004, Koppers recognized two employee groups for their creative thinking in environmental management.

The Utility Poles and Piling plant in Grenada, Mississippi, implemented a process to reduce residual material from wood treatment. The old process required hazardous waste disposal of significant quantities of wastewater. Now these materials are passed through a new filter press. The solid waste that remains weighs much less and decreases wastewater disposal by 85 percent.

The Continental Carbon plant in Kurnell, NSW, Australia, developed a new storm water retention system that allows contaminants to be removed. Clean water is pumped off the surface of a collection system for use in the production of carbon black. By recycling storm water, the Kurnell plant saves 75 million liters of water a year and reduces storm water discharge.



KOPPERS SAFETY PERFORMANCE
Global Incident Rates and Performance

	2001	2002	2003	2004
DART Rate*	2.69	2.55	2.61	2.48
TR Rate	5.06	5.05	5.23	3.79
MTR Rate	5.60	6.51	6.04	4.03
DART Cases	59	47	55	51
TR Cases	111	107	110	78
MT Cases	126	120	127	83
2004 MTR Objective				5.10

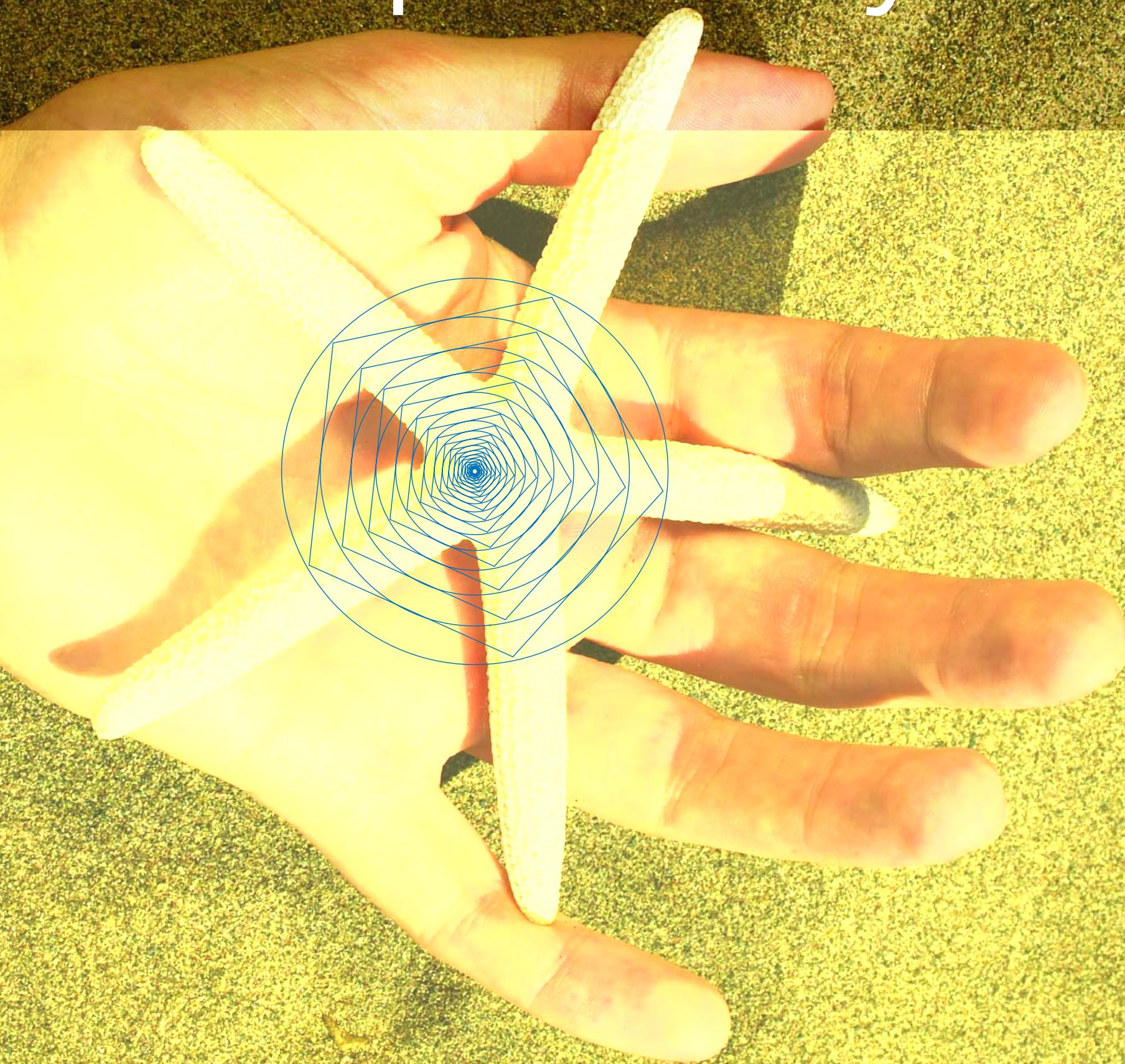
- 24 operating locations completed the year without a Days Away case. In addition, 17 of these 24 locations did not have any restricted/transferred cases.

- 16 operating locations completed 2004 without a single work-related injury.

*DART, Total Recordable and Medical Treatment Rates refer to the number of Days Away From Work, Restricted/Transferred Workday cases per 100 workers.

Conserving

responsibly



Environmental Performance

Koppers gives Environmental Compliance Awards to plants that have zero environmental incidents and to plants that reduce the number of incidents by a specific percentage. These plants won Environmental Compliance Awards for their performance in 2004: Alorton, Ill., Clairton, Pa., Denver, Colo., Gainesville, Fla., Monessen, Pa., North Little Rock, Ark., Portland, Ore., and Superior, Wis.

These U.S. plants had no exceedences of Clean Water Act permit limits in 2004: Alorton, Ill., Denver, Colo., Gainesville, Fla., Green Spring, W. Va., Guthrie, Ky., Monessen, Pa., North Little Rock, Ark., Portland, Ore., Roanoke, Va., and Superior, Wis.

A number of outside agencies also recognized Koppers environmental performance:

The Industrial Association on Funen in Denmark honored Koppers plant in Nyborg, Denmark for its outstanding work in environmental reporting in 2003 and 2004.

The Koppers plant in Grenada, Mississippi, received the General Electric Water Technologies' Return on Environment™ Partnership Award in 2004. This was for reducing the volume of hazardous waste for off-site disposal by more than 80 percent (as noted above).

The U.S. Environmental Protection Agency honored Koppers for its commitment to meet U.S. environmental indicators for human health and groundwater at all 11 of its Resource Conservation and Recovery Act Corrective Action Facilities. Koppers was one of only 10 companies to be honored in 2004.

Koppers Green Spring, West Virginia facility received a compliance award from the West Virginia Department of Environmental Protection.

New South Wales Australia Environmental Protection Authority also recognized Koppers for its environmental performance in Australia in 2004.

KOPPERS ENVIRONMENTAL PERFORMANCE Environmental Compliance at US Locations

	2001	2002	2003	2004
Exceedences	55	58	46	76
Number of spills	15	19	15	20
Quantity of spills (gallons)	6,406	1,623	44,553	1,570

Koppers has been working on a multi-year initiative that is steadily reducing the amount of hazardous waste generated through operations. Initial results indicate that further reductions were achieved in 2004. The final 2004 results will be verified and included in subsequent reports.

Conservation and Recycling

Many Koppers products have inherent conservation benefits. Wood preservation, a core business at Koppers, is founded on conservation of the world's timber resources. Wood preservation enhances the safety of wood used in construction by preventing decay-related failures for decades. By preserving wood products, we enhance their performance, increase service life, and also decrease the demand on the world's forests.

Other Koppers products create value from the recycling of coal tar. Coal tar is a byproduct from the production of coke, which is an essential ingredient in steel making. Coal tar is the raw material in many Koppers carbon-based products used by the primary metals, wood preservation, transportation, and construction industries. By effectively using this byproduct material, Koppers derives added value from coal reserves.

At the end of their useful life, many Koppers products provide additional benefits through recycling. Each year the Koppers cogeneration plant in Muncy, Pennsylvania, converts about 110,000 tons of retired creosote-treated wood products into enough electricity to power more than 700 households. This also reduces the material that goes into landfills. Since 1988, Koppers has converted more than 1,392,000 tons of creosote-treated wood into energy and eliminated the need for 56 million cubic feet of landfill space. This is a volume that is slightly larger than the Sears Tower in Chicago.

Energy recycling from Koppers operations also aids conservation. The Nyborg, Denmark, plant transfers excess heat energy to a local utility, supplying power to meet 7 to 8 percent of the community's energy needs, enough to heat 1,000 houses a year. This also reduces chemical discharges and electricity use at the plant.

In 2004, Koppers spent some \$2.4 million on environmental capital improvements in addition to the routine environmental operating expenses of approximately \$9 million.

Managing Systems and Employees

responsibly

Working Responsibly through Systemic Management

Koppers incorporates its operational goals, capital improvement planning, product development and training within our Safety, Health and Environmental Management System. Koppers operations are audited, both internally and by external agencies, to ensure that our production plants meet the high standards established by our management system.

As part of establishing our management system, we have achieved ISO 14001 certification for our global manufacturing facilities. The ISO 14001 certification is the global standard for responsible and effective environmental management systems. Certification of our management system:

- Assures our customers and our communities that Koppers is thoroughly engaged in and committed to safety and environmental stewardship.
- Ensures that our employees are properly trained and that management is dedicated to the process, by auditing performance and seeking continuous improvement.
- Validates that Koppers is committed to taking systematic steps to manage safety, health and environmental practices.

Working Responsibly with our Employees

Ethical and honest behavior is a condition of employment at Koppers. Employees receive training in the Koppers Ethics and Compliance Program and Procedures. This program emphasizes compliance in safety, health and environmental laws, and other laws including trade practice. Koppers requires that employees act ethically within our communities and with our customers.

At Koppers, we seek to be an employer of choice. We pride ourselves on the long tenure of our employees, many of whom have worked with us for decades. In our hiring and employment practices, we are committed to compliance with all laws regarding equal opportunity, discrimination, harassment and other employee-employer relationship matters.

Koppers employees receive competitive pay, benefits, and the training they need to do their jobs safely and successfully. Koppers also helps its employees reach their potential through professional development programs, in an atmosphere of trust and appreciation.

By working responsibly, Koppers will support our customers, protect our employees and the environment, and build trust in the communities where we operate as we continue to grow our company. This is the Koppers way of doing business: safeguarding the environment, conserving natural resources and making sustainable contributions to society.

CORPORATE HEADQUARTERS

Koppers Inc.
436 Seventh Avenue
Pittsburgh, PA 15219-1800
U.S.A.
412 227 2001

**AUSTRALASIAN OPERATIONS
HEADQUARTERS**

Koppers Australia Pty Ltd.
Level 10, 15 Blue Street
P. O. Box 2122
North Sydney, NSW 2059
Australia
61 2 9954 5411

**EUROPEAN OPERATIONS
HEADQUARTERS**

Koppers UK Limited
Normanby Gateway
Lysaghts Way
Scunthorpe
North Lincolnshire DN15 9YG
United Kingdom
44 (0)1724 281555

GLOBAL LOCATIONS**CARBON MATERIALS AND CHEMICALS**

UNITED STATES
Clairton, Pennsylvania
Follansbee, West Virginia
Monessen, Pennsylvania
Portland, Oregon
Stickney, Illinois
Woodward, Alabama

UNITED KINGDOM
Port Clarence
Scunthorpe

DENMARK
Nyborg

AUSTRALIA
Newcastle, New South Wales

CHINA

Tangshan

CONTINENTAL CARBON AUSTRALIA

Kurnell, New South Wales, Australia

KOPPERS TRADING

Beijing, China
Nyborg, Denmark

TECHNICAL CENTER

Harmarville, Pennsylvania

UTILITY POLES AND PILING

UNITED STATES
Denver, Colorado
Florence, South Carolina
Gainesville, Florida
Grenada, Mississippi

AUSTRALASIAN WOOD PRODUCTS

AUSTRALIA
Bunbury, Western Australia
Grafton, New South Wales
Hume, Australian Capital Territory
Longford, Tasmania
Takura, Queensland
Thornton, New South Wales

PHILIPPINES

Makati City

KOPPERS ARCH WOOD PROTECTION

Auckland, New Zealand
Beijing, China
Kuala Lumpur, Malaysia
Lautoka, Fiji
Osaka, Japan
Port Shepstone, South Africa
Sydney, Australia

RAILROAD PRODUCTS AND SERVICES

UNITED STATES
Denver, Colorado
Florence, South Carolina
Galesburg, Illinois
Green Spring, West Virginia
Grenada, Mississippi
Guthrie, Kentucky
Montgomery, Alabama
Muncy, Pennsylvania
North Little Rock, Arkansas
Portsmouth, Ohio
Roanoke, Virginia
Somerville, Texas
Superior, Wisconsin

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