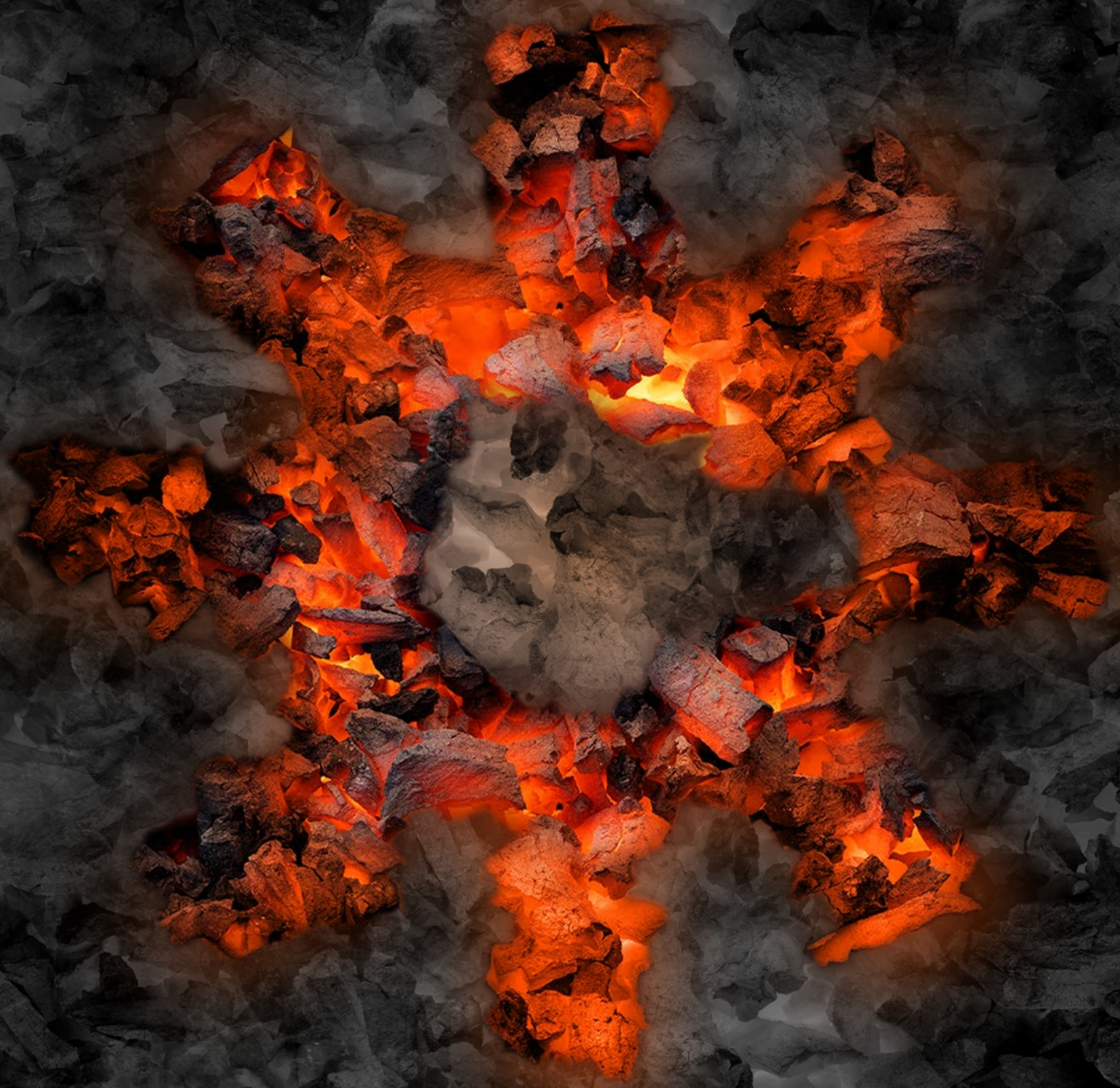
SunCoke Sustainability Report 2024

April 2025



SunCoke Energy®

FOREWORD

2024 was a year of strong safety, environmental, and financial performance at SunCoke. Our achievements and improvements would not have been possible without the sustained efforts of SunCoke's employees whose everyday embodiment of SunCoke values is critical to our success. We will continue to work collaboratively to advance initiatives across our **Sustainability Foundations:**

1. **Occupational Health and Safety;**
2. **Advanced Technology; and**
3. **Innovation and Evolution of Products & Services**.

These initiatives create long term value for our shareholders, customers, and employees.

In 2024, we achieved our best ever safety record that reflects our ongoing commitment to prioritizing a safe, productive work environment. We recorded our best ever Total Recordable Incident Rate (TRIR) of 0.50, outperforming our peers in the "All Other Petroleum and Coal Products Manufacturing" and "Iron and Steel Mills" sectors.[1]

We set high safety standards for employees and contractors. In 2024, contractors working at our sites were awarded two National Maintenance Agreements Policy Committee Zero Injury Safety Incidents Awards (ZISA) for work completed at our Indiana Harbor and Middletown plants in 2024. Through the clear communication of safety expectations and best practices, we empower employees at all levels of our business to act safely from the moment they arrive at work to the moment they leave.

SunCoke's operational and financial success can also be attributed to our advanced technology and emphasis on continuous improvement which make us the most environmentally friendly coke producer and demonstrate our commitment to environmental excellence. We continue to drive environmental performance through continuous improvement and investing in our assets.

SunCoke's commitment to the long-term maintenance and improvement of our assets helps to drive our reputation as a consistent, high-quality coke producer. This commitment not only ensures long-term reliability, but also supports growth opportunities for our logistics and coke businesses. Our commitment is demonstrated by our significant investment of $72.9 million in our assets in 2024.

In 2024, a major reliability-focused investment supported the completion of the Middletown Heat Recovery Steam Generator (HRSG) upgrade program that began in 2019. Our HRSG technology has been a hallmark of our advanced technology and, by upgrading the HRSGs at the Middletown plant, we were able to improve the long-term reliability of these critical assets, while also improving environmental performance.

In our logistics business, capital allocation has been structured to support business growth. SunCoke's three logistics terminals, located on the Mississippi, Ohio, and Kanawha rivers, provide high throughput, offloading, onloading, and storage. Demand for our Kanawha River Terminal (KRT) services increased in 2024, resulting in a capital project to support a new barge to rail contract. Mobilizing KRT to support increased coal exports will drive increased EBITDA through higher transloading volumes.

In addition to investing in opportunities, in 2024 our business also addressed black lung by applying for and receiving a certificate of exemption that permanently transfers responsibility for payment of black lung benefits from SunCoke to the Department of Labor's Division of Coal Mine Workers Compensation.

We strive to continuously improve upon our own operations, but also recognize opportunities to support our customers in working towards their sustainability and operational objectives. Our high-quality, high-efficiency coke allows customers to reduce coke consumption which reduces emissions. This year much of our product innovation was concentrated on foundry coke, where we were granted three new patents relating to production, properties, and use. The patents have further solidified our competitive advantage in the foundry coke space by protecting our best-in-class technology across the foundry coke lifecycle.

In the steel value chain, SunCoke's blast furnace coke is a necessary input in the production of high-strength steel which is a critical material for many industries including automotive, rail, construction, and energy. Similarly, our foundry coke products are a critical input to foundries that engage in metalcasting and produce products critical to consumers and the renewable energy sector, that range from X-ray machines to wind turbines.

SunCoke produces the coke critical for the steel and metalcasting industries and does so reliably. This trait is becoming increasingly important as other coke producers shut down plants and supply chains are compromised, all while the U.S. aims to increase its domestic production. We are proud of our safety, community, and environmental performance and our ability to support our partners in achieving their own supply performance goals.

We will position ourselves to continue to support an evolving market by leveraging our core competencies to diversify our customers and product offerings. This includes our continued expansion in the foundry coke market and our continuous business development efforts in logistics for organic and inorganic growth.

As we look to 2025, we will continue to work towards excellence in day-to-day operations while pursuing further opportunities. Thank you for your interest and ongoing support of this mission.

Katherine Gates
President and CEO

[1] In 2023, the year for which the most recent data is available, the TRIR was 2.6 for businesses in the "All Other Petroleum and Coal Products Manufacturing" sector and 2.1 for businesses in the "Iron and Steel Mills" sector. Source: U.S. Bureau of Labor Statistics, "Injuries, Illnesses, and Fatalities," 2024, TABLE 1. Incidence rates of nonfatal occupational injuries and illnesses by industry and case types, 2023.

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.

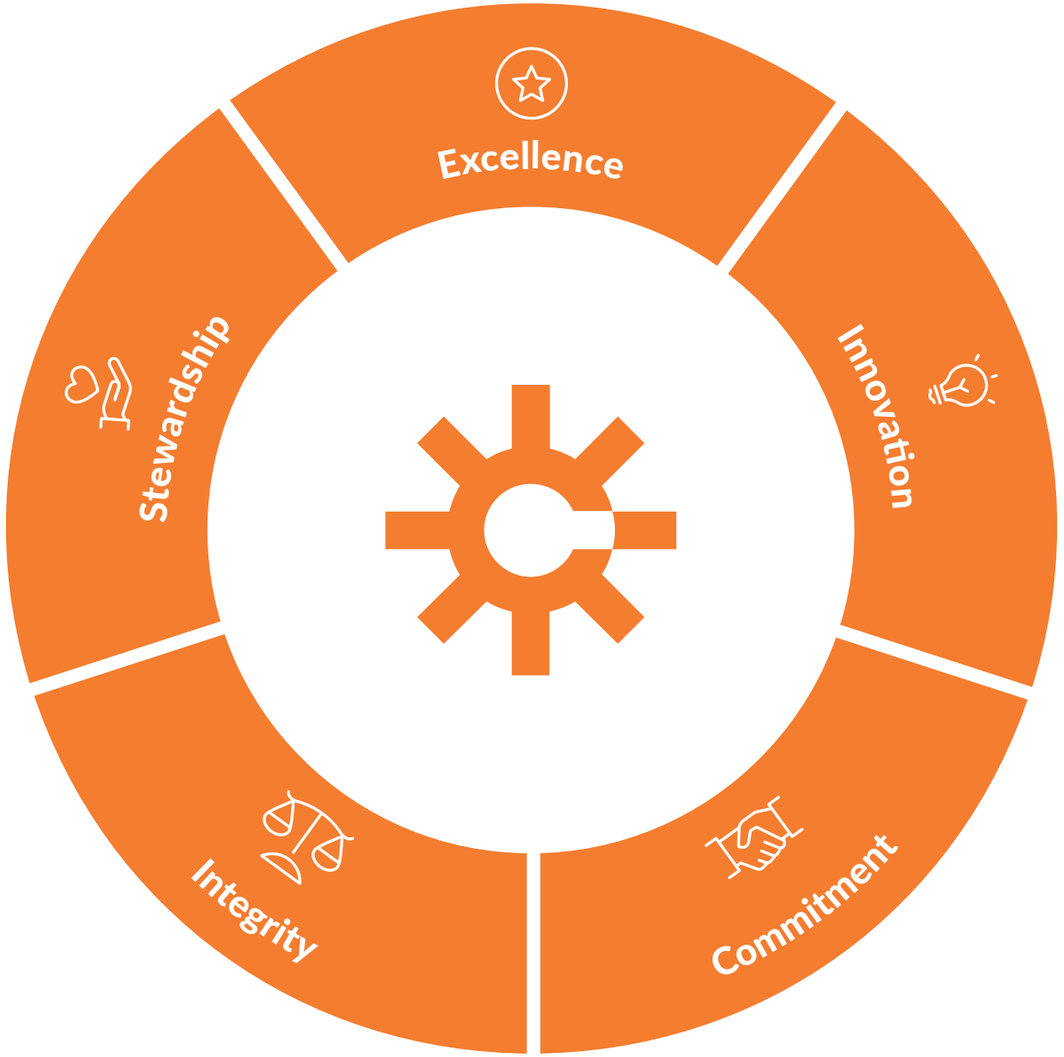
Excellence
Expect the best from yourself, remove obstacles, inspire and support others, and celebrate success.

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

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

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

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



ABOUT THIS REPORT

Disclosure Frameworks

Our sixth annual Sustainability Report covers our sustainability data and performance metrics for calendar year 2024 and has been informed by the Global Reporting Initiative (GRI) and the International Sustainability Standards Board (ISSB) International Financial Reporting Standards (IFRS) S1 (General Requirements for Disclosure of Sustainability-related Financial Information) and S2 (Climate-related Disclosures). The shift in reporting against the ISSB IFRS S1 and S2 standards will impact the indexing section of this Sustainability Report.

OUR KEY SUSTAINABILITY TOPICS

Our Key Sustainability Topics[2]

In this report, SunCoke defines key sustainability 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 sustainability 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.

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

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

2024 BY THE NUMBERS

#1 Independent Coke Producer in the US by Annual Output

0.50
Total Recordable Incident Rate

NEW RECORD!

46%
Open positions filled with internal candidates

1,168
No. of Employees
868 in the U.S.

~1%
Regrettable Turnover

43%
Percentage of Employees as Union Members

682,000 MWh
Electrical Power produced by SunCoke facilities

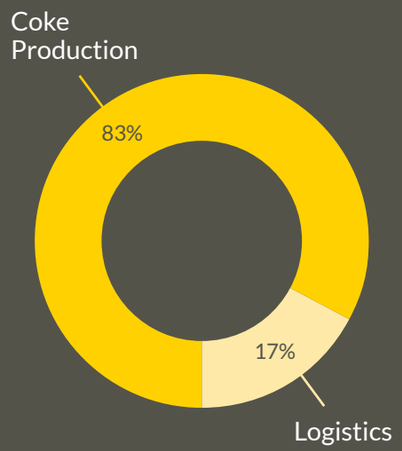
62,000 Homes
that could be powered by the electricity generated at SunCoke facilities

6.1M t
Total coal purchased

5.6M t
Total coke produced

4.0M t
Domestic coke produced

$272.8M
Adjusted EBITDA



$72.9M
Maintenance and Growth Capital

$168.8M
Operating cash flow

$103.5M
Net income

Continuous Improvement

Exceeded our target of achieving a TRIR of below 0.80, with our best ever TRIR of 0.50

Three new patents issued for innovation in foundry coke

Completed the upgrade of the last of five HRSGs at the Middletown plant, finalizing an upgrade program that began in 2019

Invested $72.9 million in maintenance and growth capital to ensure that our facilities are safe, efficient, reliable, and environmentally compliant, and to advance our growth projects

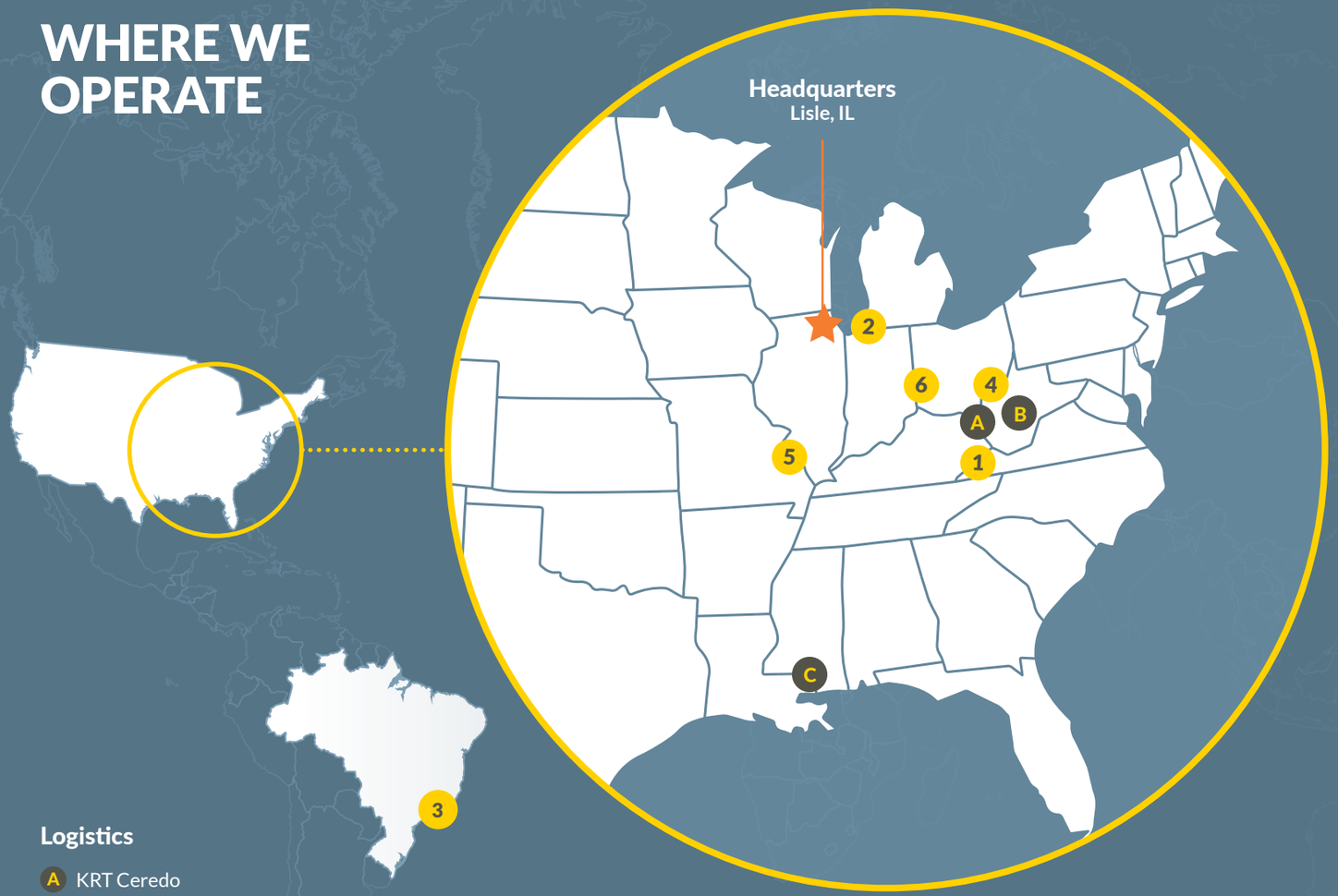
CONTENTS

Navigating this Report

The interactive circles on the right side of each page visually represent the current section within the document. Clicking on any of these circles will immediately transport you to the corresponding section. The **Home** button returns you to this **Table of Contents**.

01
Who We Are

WHERE WE OPERATE



Logistics

- A KRT Ceredo
- B KRT Quincy
- C Convent Marine Terminal

LEGEND

- Year of Startup
- Annual Cokemaking Nameplate Capacity (1,000 tons)

Cokemaking

Jewell Coke
Vansant, VA
1962
720

Indiana Harbor
East Chicago, IN
1998
1,220

Vitória
Vitória, Brazil
2007
1,700

Haverhill 1 and 2
Franklin Furnace, OH
2005/08
550 each

Granite City
Granite City, IL
2009
650

Middletown
Middletown, OH
2011
550

OUR BUSINESS

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 is either utilized by the customer or goes to the power grid.

SunCoke's origins can be traced back to 1960 with the construction of three test ovens at the Jewell cokemaking facility in Vansant, Virginia.[3] 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—five in the U.S. and one in Brazil.

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

In addition to our coke plants, we operate three 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. 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, further solidifying our place as an innovator in the industry. Our entry into the foundry coke market, with annual demand of approximately 500,000 to 550,000 tons in the U.S. and Canada, coincided with the closure of all remaining U.S.-based foundry coke producers except one, leaving a significant supply deficit that SunCoke has filled.

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

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.

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.

Blast Furnace Coke
Blast Furnace Coke is critical for the production of blast furnace steel.

In a blast furnace, coke is burned and removes oxygen in the smelting of iron ore. That ore is then fed into basic oxygen furnaces (BOF) where it is turned into steel. By virtue of having been refined, coke has a higher carbon content than coal, meaning that less coke can be burned to generate the same amount of energy.

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

Examples of metalcasting 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.

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 in 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 in 2022, 2023, and 2024. Foundry coke is a specialized type of coke that is used in 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.

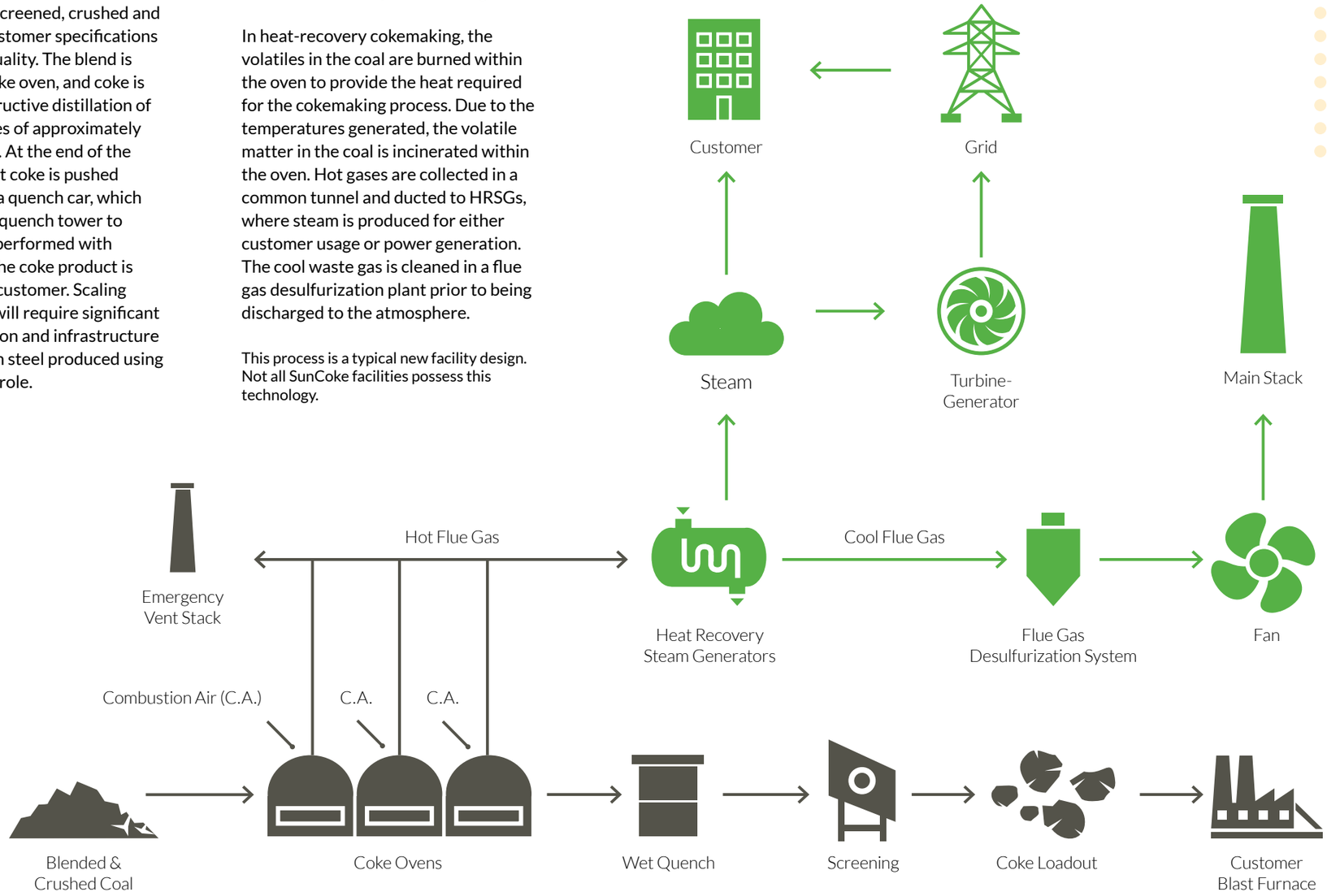
Cokemaking Process

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. Quenching is performed with water after which the coke product is transported to the customer. Scaling renewable energy will require significant spatial reorganization and infrastructure investment in which steel produced using coke will play a key role.

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.



02

SunCoke and American Industry

A HISTORICAL PERSPECTIVE ON COKE

SunCoke's blast furnace and foundry coke represent the most advanced innovations in a long tradition of continuous improvement in coke development. Coke is critical to steel and foundry processes, but has also served many other functions. Since coke was first introduced in the 17th century as an alternative to wood and peat in the production of pale ale, it has been widely used in industry as well as other applications. Today, SunCoke's blast furnace and foundry coke are primarily applied in steel production and metalcasting where they continue to play a critical role in the manufacturing of products that sustain the American economy.

Towards Higher Power Density

Insights into the evolution of human societies highlight a key trend: the quest for ever-higher power densities in energy use. From the era where humans depended on the diffuse energy of wood and animal labor, to the present day, this drive for more concentrated energy forms has been pivotal in shaping civilizations. Fossil fuels, particularly coke, epitomize this trend. Coke, derived from coal, is a concentrated transformation of ancient biomass, amassing millions of years of solar energy into a form that can be extracted and utilized with unmatched energy density. This concentration has been instrumental in powering the industrial revolutions, especially in steel production, urban expansions, and technological advancements that characterize modern life.

3 Key Functions of Modern Blast Furnace Coke

Thermal

Coke combustion is essential in blast furnaces for generating the high temperatures required to melt iron ore and other materials.

Chemical

When coke burns in blast furnaces, it produces carbon monoxide (CO), which reacts with iron ore (mainly iron oxides) to remove the oxygen, leaving behind molten iron.

Physical and Mechanical

Coke is hard and porous which allows it to provide essential structural support for the burden of iron ore and limestone in the blast furnace. Its strength and porosity facilitate efficient gas flow and chemical reactions within the furnace.

The Evolving Uses of Coke

For Brewing Pale Ale
In the 17th century, coke replaced wood and peat in the brewing process, leading to the development of pale ale. Wood and peat smoke had previously infused beer with a dark color, as seen in porters and stouts, and the use of cleaner burning coke allowed brewers to achieve a lighter colored ale for the first time.

For Iron Production
In the early 18th century, at least 32 tons of wood were needed to produce one ton of bar iron. Coke replaced charcoal, which was produced by burning wood, and reduced the stress placed on forests by logging activities.

For Heating Homes
Following the United Kingdom's 1956 Clean Air Act, coke became preferred over coal for home heating due to its lower smoke emissions.

For High-Quality Steel and Metalcasting
Today, SunCoke leverages the most environmentally friendly cokemaking technology to produce blast furnace coke which is used for high-quality blast furnace steel and foundry metalcasting.

POWER DENSITY

Energy sources can be evaluated by power density, which is the power generated per unit area. Renewable energy and biofuels, while reducing GHG emissions, require more space than fossil fuels due to lower power density. Conversely, coke offers high-density, consistent energy for industries like steel making. The spatial efficiency of fossil fuels contrasts with the low power density of renewables and biofuels, implying that transitioning to renewables would require vast land use and socioeconomic changes. Thus, fossil fuels remain essential, and scaling renewables will necessitate significant infrastructure and spatial adjustments, with steel from coke being crucial.

In 2024, SunCoke domestically produced 4.0 million tons of coke. 4.0 million tons of coke contains approximately 118 million gigajoules (GJ).

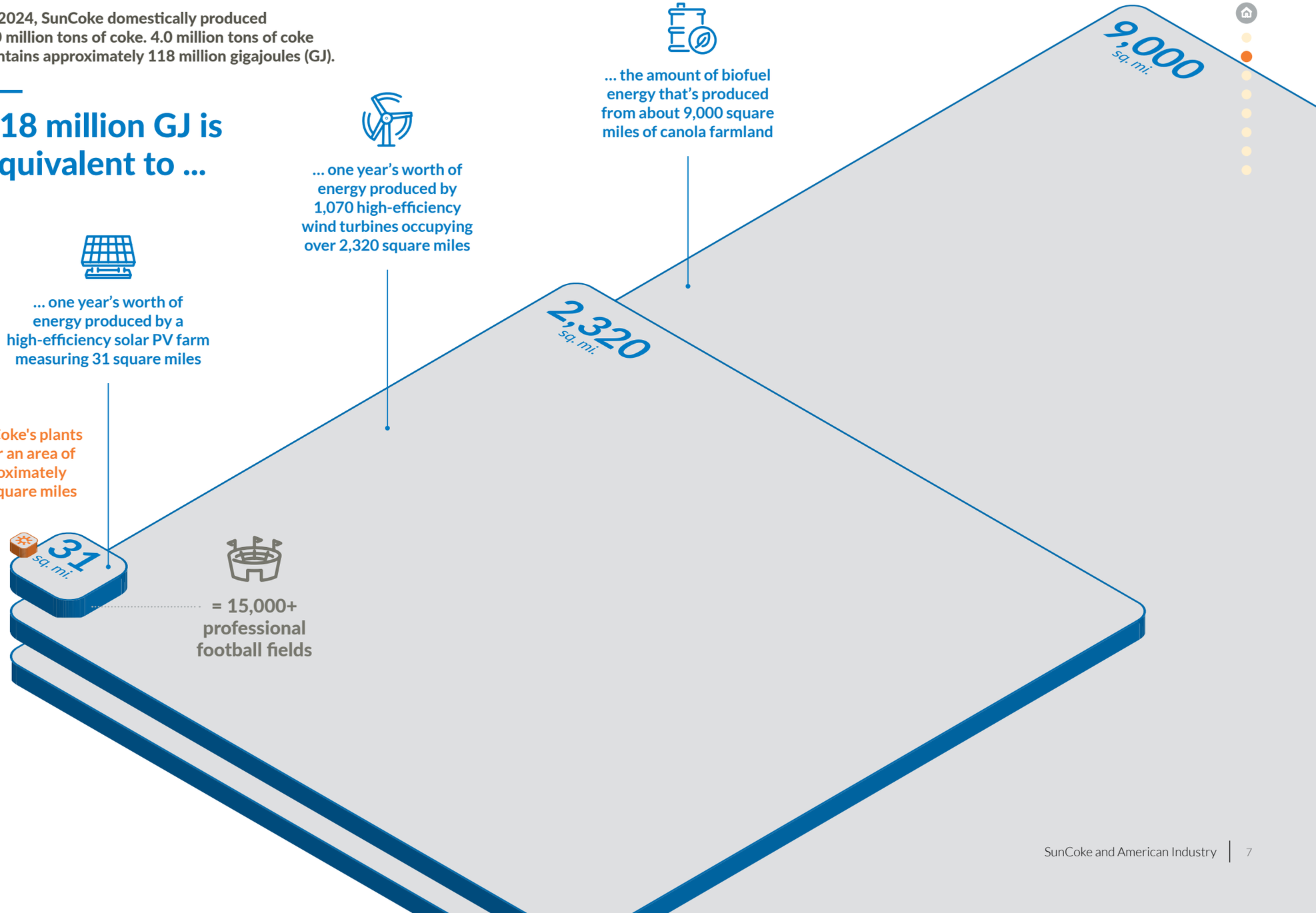
118 million GJ is equivalent to ...

... one year's worth of energy produced by a high-efficiency solar PV farm measuring 31 square miles

... one year's worth of energy produced by 1,070 high-efficiency wind turbines occupying over 2,320 square miles

... the amount of biofuel energy that's produced from about 9,000 square miles of canola farmland

SunCoke's plants cover an area of approximately 1.4 square miles



= 15,000+ professional football fields

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 BOF 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.

	The Steelmaking Process	SunCoke's Input
1 **Raw Material Sourcing**	The steel production process begins with the procurement of raw materials, primarily iron ore, coal, and limestone. These materials are either mined domestically or imported. Coal is refined into coke before being processed in blast furnaces.	**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 emissions of hazardous air pollutants.
2 **Raw Material Processing**	**Blast Furnace** Coke is fed into blast furnaces which produce molten iron that is then fed into BOFs to make steel. **Electric Arc Furnace (EAF)** EAFs use electricity to melt scrap metal in a furnace with other materials such as iron to make recycled steel.	**Steel Manufacturing** SunCoke's customers use coke in their blast furnaces to reduce iron ore and create molten iron, which is then heated in a BOF to be turned into steel.
3 **Casting and Rolling**	Liquid steel is cast into slabs, billets or other shapes and rolling mills shape the steel into flat or long products.	**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.
4 **Finishing**	After steel is produced, it undergoes finishing processes such as rolling, coating, and cutting. This stage tailors the steel for specific applications and customer requirements.	**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.
5 **Distributing**	Finished steel products are distributed through a network of wholesalers, retailers, and manufacturers. The logistics involve transportation (e.g., rail, truck, or barge) to reach end-users.	*See next page for examples of end markets.*

SUPPORTING A STRONG AMERICAN STEEL INDUSTRY

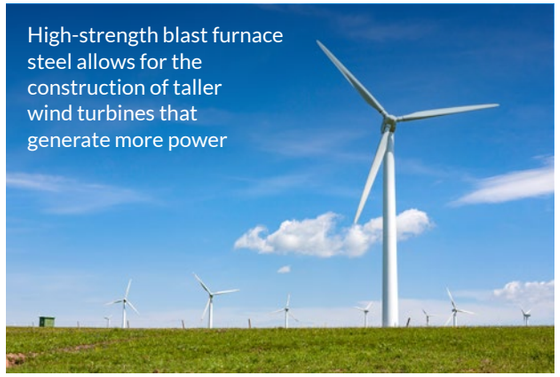
The steel industry has always been at the core of the U.S. economy, feeding into critical industries including the automotive sector, buildings, and infrastructure. In 2023, the U.S. produced an impressive 89.7 million net tons of crude steel, securing its position as the third-largest steel producer in the world, following China and India. Notably, the U.S. meets 70-90% of its steel consumption through domestic production.

SunCoke supports the steel industry through the manufacture of blast furnace coke which is fed into blast furnaces to make high-quality, high-strength steel. Blast furnace steel is an important part of U.S. domestic steel production because many industries, including automotive manufacturing, construction, and heavy machinery rely on the specific properties of high-quality blast furnace steel that can't be achieved through other means of production.

SunCoke blast furnace coke is used in blast furnaces where it creates molten iron. This molten iron is then fed into BOFs where it is combined with scrap steel and flux, then injected with oxygen to remove carbon and create steel.

Blast furnace steel accounts for approximately 30% of steel production in the U.S. with the other 70% produced in EAFs which use electricity from the grid to melt iron and scrap steel. EAFs can be limited by the availability of scrap steel as well as an inability to achieve the same purity as blast furnaces due to contaminants on scrap steel.

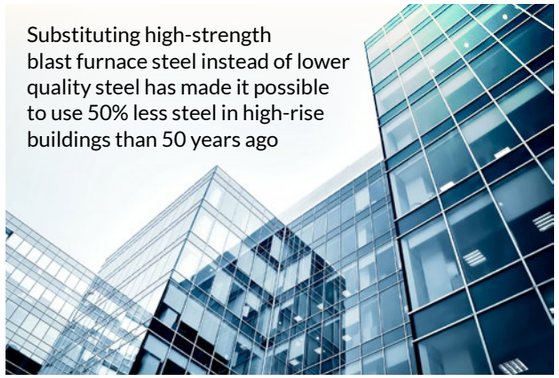
Nearly every new vehicle uses blast furnace steel



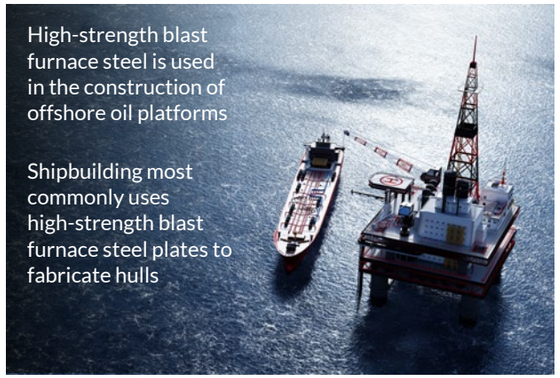
High-strength blast furnace steel allows for the construction of taller wind turbines that generate more power

High-strength blast furnace steel can reduce farming machinery weight by 30-50% without compromising durability

Advanced strength blast furnace steel is a necessary component of both trains and rail infrastructure



Substituting high-strength blast furnace steel instead of lower quality steel has made it possible to use 50% less steel in high-rise buildings than 50 years ago



High-strength blast furnace steel is used in the construction of offshore oil platforms

Shipbuilding most commonly uses high-strength blast furnace steel plates to fabricate hulls

To create a purer steel output, EAFs add pig iron in addition to scrap steel. SunCoke is looking to become a partner in EAF steelmaking and partner with the Granite City Works facility to manufacture Granulated Pig Iron (GPI). We are excited at the prospect of becoming a trusted partner to both blast furnace and EAF steel production in the United States.

The Impacts of the American Iron and Steel Industry

$520B
in economic output

$130B
in wages and benefits

~2M
direct, indirect, and induced jobs

$56B
in federal, state, and local taxes[4]

[4] American Iron and Steel Institute, "THE PROFILE OF THE AMERICAN IRON AND STEEL INSTITUTE," accessed February, 2025, https://www.steel.org/wp-content/uploads/2024/01/AISI-Profile-Book_updated-3.2023.pdf.

SUNCOKE FOUNDRY COKE FOR METALCASTING

In addition to playing a critical role in the steel value chain, SunCoke is proud to support another backbone of American industry: metalcasting.

Metalcasting facilities, which are often referred to as foundries, have been operated in the United States since the country's founding, and played a critical role in the expansion of American railways, the bolstering of America's national defense, and the expansion of the U.S. automotive sector. Today, foundry products are so widely used that one is rarely more than 10 feet from a metal casting in the United States.[5]

The Metalcasting Process

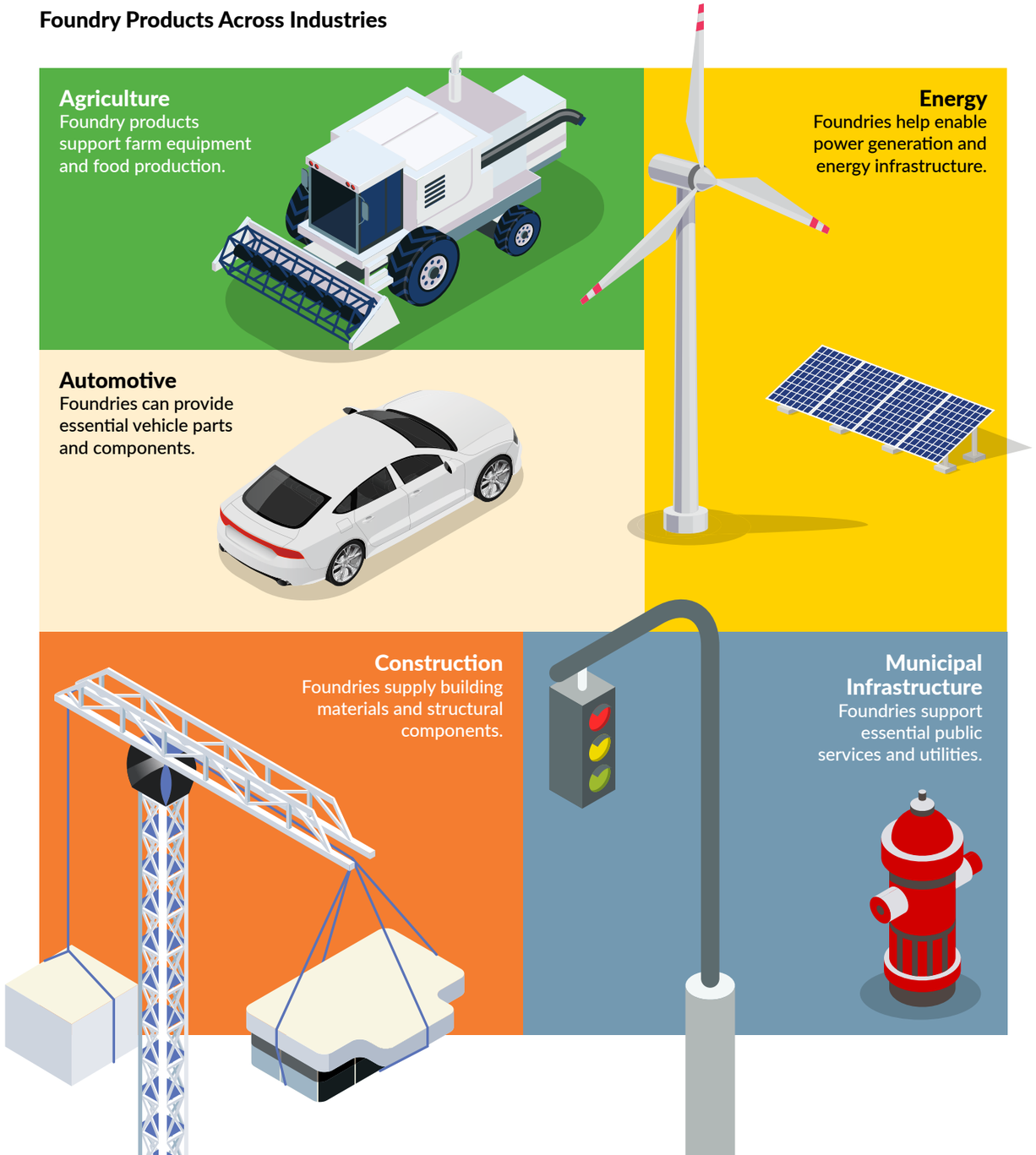
SunCoke's foundry coke is used in metalcasting. Metalcasting is the process in which high-temperature molten or liquid metal is poured into a mold made of sand, metal, or ceramic, to form geometrically complex parts. All major metals can be cast. The most common are iron, aluminum, magnesium, zinc, steel, and copper-based alloys.

SunCoke's Role

SunCoke supports the metalcasting industry by producing high-quality, high-efficiency foundry coke and acting as a technical partner for foundries across the country.

[5] American Foundry Society, "ABOUT METALCASTING," accessed November, 2024, https://www.afsinc.org/about-metalcasting.

Foundry Products Across Industries



Wide-Ranging Economic Impact

As one of only two foundry coke producers in the United States and the highest quality foundry coke producer in the country, we view ourselves as an essential partner to the metalcasting industry in continuing to generate significant economic impact domestically.

90%
of all manufactured goods contain some metal castings

490,000
jobs tied to the metalcasting industry

$32.16B
in wages and benefits

$110.52B
of dollars of economic output

$10.59B
in federal, state, and local taxes[6]

[6] American Foundry Society, "U.S. METALCASTING INDUSTRY IMPACT ON U.S. JOBS & THE ECONOMY," accessed November, 2024, https://www.afsinc.org/us-metalcasting-industry-impact-us-jobs-economy

03

Continuous Improvement

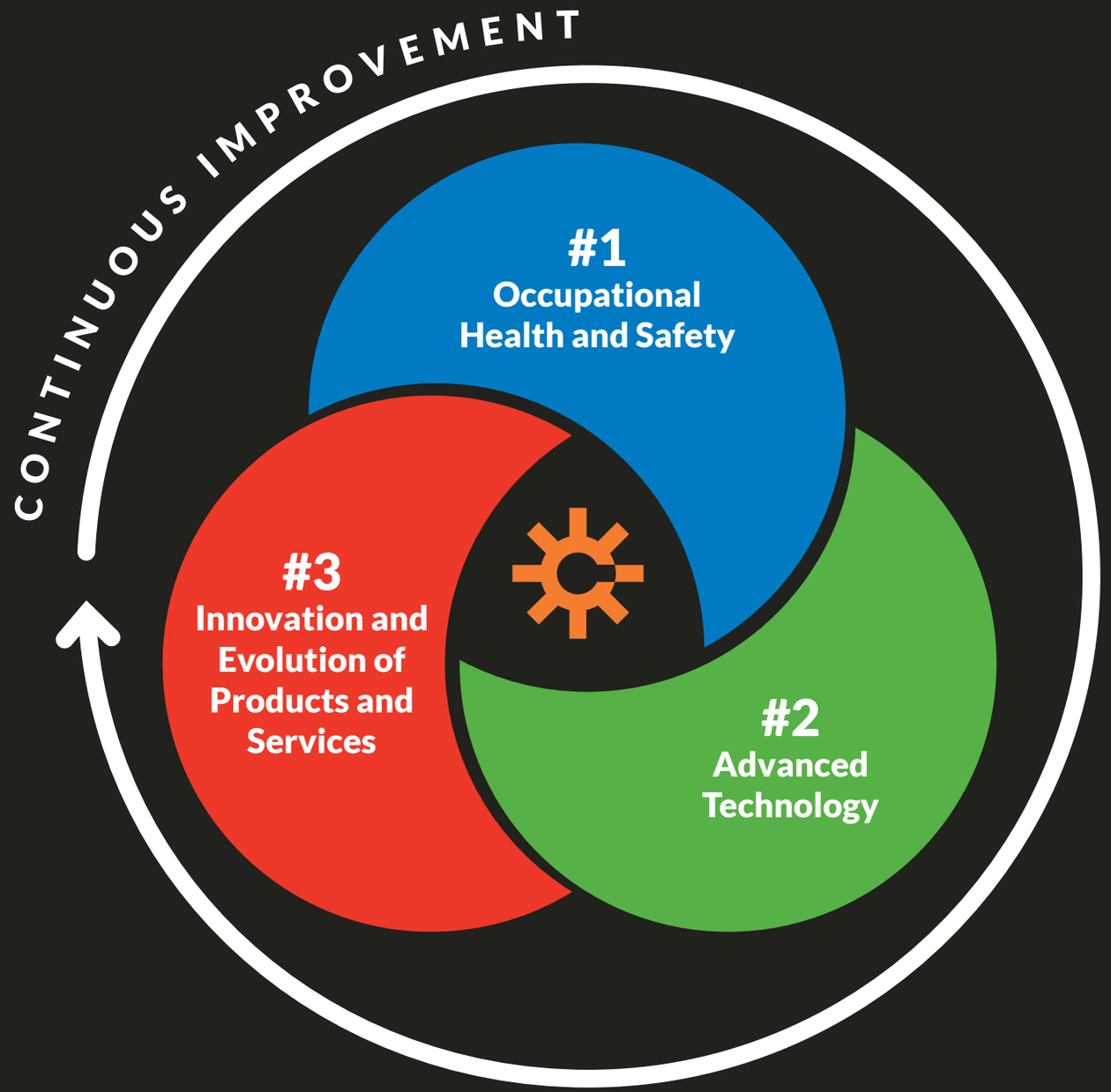
This section highlights key achievements from 2024 that demonstrate our culture of continuous improvement and how it helps us advance our sustainability priorities across our organization.

OUR SUSTAINABILITY FOUNDATIONS & CONTINUOUS IMPROVEMENT

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.

In 2024, we continued to reinforce our emphasis on sustainability and continuous improvement. This builds upon our existing progress in integrating environmental considerations into work practices, reducing environmental risks, and training employees and contractors in environmental best practices. Similarly, our long-term commitment to continuous improvement has supported our objectives to drive optimal performance across coke operations, heat recovery operations, logistics terminals, maintenance for asset reliability, and capital management.

At SunCoke, our drive to foster collaboration between our various business functions allows us to develop synergies and achieve sustainability and continuous improvement objectives simultaneously. The path to excellence in each category lies in a collective focus on the way we work: everyone, everyday, to continuously improve results. Personal ownership of operational excellence and strong quality assurance measures are two principles that guide continuous improvement and sustainability at SunCoke. These principles are embodied across all SunCoke teams such as in engineering where SunCoke staff support each plant to make our coke ovens more efficient or in logistics where each staff member monitors weather trends daily, allowing us to mitigate climate risk and remain nimble. In 2024, we advanced a number of our year-over-year continuous improvement initiatives.



TIMELINE OF CONTINUOUS IMPROVEMENT

1960
The first three test ovens were built at the Jewell cokemaking facility, located in Buchanan County, Virginia.

1972
16 large Jewell Thompson ovens were built.

1990
SunCoke technology designated as the Maximum Achievable Control Technology (MACT) under the U.S. Clean Air Act of 1990.

1998
Indiana Harbor facility, located in Indiana, 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, located in Ohio, were constructed and brought online with process steam and power generation capabilities.

2007
Expanded further into international markets by opening our first heat-recovery cokemaking facility in Vitória, Brazil.

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

SunCoke spun off from its former parent organization, Sunoco Inc.

2012 - 2013
Our Middletown facility, located in Ohio, was constructed and brought online with power generation capability.

2013
Diversified our service offerings by expanding into the logistics business with the acquisition of the Lake and Kanawha River Terminals, located in Indiana and West Virgina, respectively.

2015
Acquired Convent Marine Terminal to expand logistics services.

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.

2024
Our efforts in 2024 demonstrated our continued commitment to SunCoke's Sustainability Foundations.

LOOKING AHEAD

Continue to work toward our safety goal of zero incidents.

Advance our sustainability priorities.

Maintain the focus on continuous improvement.

#1 Occupational Health and Safety

- Achieved a record TRIR of 0.50, achieving a significantly lower rate than our industry average.
- Awarded two National Maintenance Agreements Policy Committee ZISA for projects completed at the Indiana Harbor and Middletown plants.
- Maintained our goal of zero injuries in the workplace.

#2 Advanced Technology

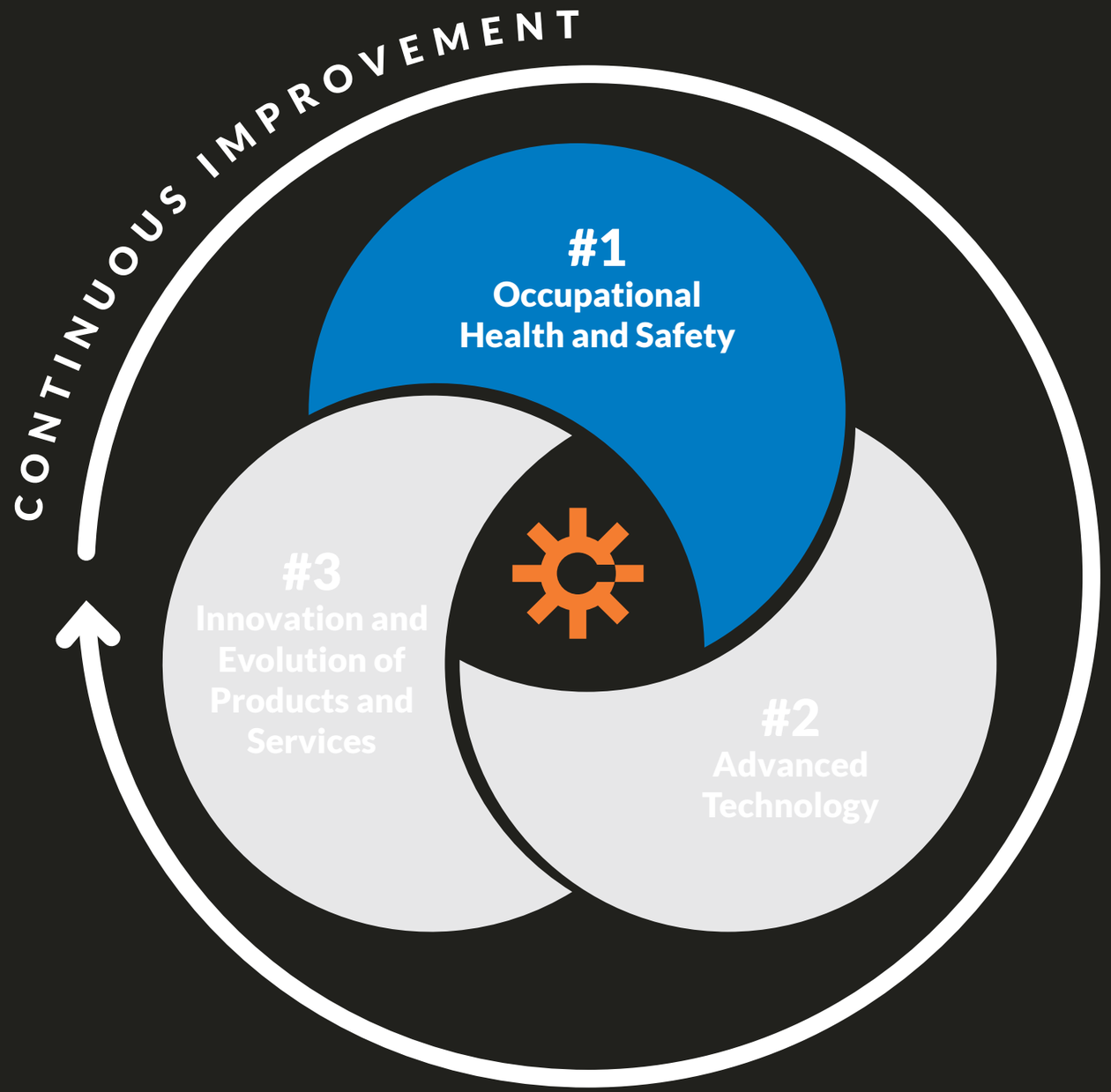
- Finished a project to upgrade the five HRSGs at the Middletown plant.
- Committed to a multimillion dollar expansion of KRT Ceredo that will triple annual capacity based on a long term take-or-pay contract.
- SunCoke heat recovery technology generated enough electricity to power 62,000 homes.

#3 Innovation and Evolution of Products and Services

- We were issued three new patents for our innovations in foundry coke, spanning a large part of the technical landscape and securing our competitive advantage.
- Developed new technologies to provide technical support to our foundry customers.
- Continued to evaluate opportunities to grow service and product offerings.

Sustainability Foundation #1

Occupational Health and Safety



MAINTAINING THE HEALTH AND SAFETY OF OUR EMPLOYEES AND CONTRACTORS

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

Our top priority has always been the safety and health of our employees, contractors, and visitors.

Safety is so important to SunCoke that we include safety in our core values and also incorporate safety as a metric in our short-term incentive program. We have an ambition of zero incidents and injuries in the workplace. To reach our goal, we follow our Safety Vision, which is comprised of five core components.

Five Core Components of Safety Vision

Visible Safety Leadership

Site and corporate leadership have made a commitment 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 take responsibility for their own safety and the safety of those around them, and we train for proper safety knowledge.

Safe Work Practices

All team members and contractors take the time necessary to properly identify and mitigate 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.

SAFETY VISION TO ACHIEVE OUR GOAL OF ZERO INCIDENTS

We have a goal of zero injuries in the workplace. In 2024, our progress was recognized when contractors working at our sites were awarded two National Maintenance Agreements Policy Committee ZISAs for work completed at our Indiana Harbor and Middletown plants. These awards recognize that SunCoke and its contractors worked 997,691 hours and 105,291 hours to complete the projects without incident at Haverhill and Middletown, respectively.

Additionally, this year, the Middletown and Haverhill plants also completed major maintenance and repair projects without reportable incidents. 474 contractors were brought on site to support these efforts, and the success of the projects can be attributed to our robust safety training in addition to the SunCoke capital team's presence on site to identify and address hazards as well as communicate best practices.

Beyond external recognition, we recognize excellence in safety internally by organizing luncheons and similar events for those plants that achieve high safety performance.

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. We monitor corporate safety goals through bi-weekly meetings with the safety managers at each of our plants and monthly meetings with the general managers and safety managers from each of our plants. Consistent knowledge sharing between our safety leaders has been a critical component of our ongoing positive safety performance. SunCoke also improves the effectiveness of our safety program by ensuring that management is present in field operations to provide direct oversight and lead by example.

Progress toward these goals is supported by capital expenditure projects that aim to continuously make our plants and logistics facilities safer. One such capital expenditure project was the implementation of Maximo Mobile which has enabled SunCoke team members to use tablets to document inspections and issue work orders from the field. The immediate digitization of inspection and work order records supports SunCoke's broader efforts to leverage effective data management to continuously improve safety performance.

SAFETY PERFORMANCE

Our target for TRIR at SunCoke for 2024 was 0.80 company-wide, which includes both employees and contractors. In 2024, we achieved our best ever TRIR of 0.50, significantly outperforming against our target and demonstrating leadership amongst peers. 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.

Our excellent safety record is best understood in comparison to industry-wide safety performance. According to the Bureau of Labor Statistics, the TRIR of Other Petroleum and Coal Products (Coke) Manufacturing was 2.6 in 2023 and the TRIR for the Iron and Steel Mills sector was 2.1 in 2023, based on the most recent data available. Our year-over-year safety performance is consistently significantly lower than average industry-wide rates, demonstrating our strong commitment to safety.

INCIDENT INVESTIGATION

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

Incident Summary by Type[7]

Year	2022	2023	2024
Total Fatalities	0	0	0
Total TRIR[8]	0.69	0.99	0.50
Total Lost Time Incident Rate (LTIR)	0.28	0.68	0.18
Total Near Miss Frequency Rate	17.00	12.96	9.05

Employee and Contractor Breakdown for Recordable Injuries

Year	2022	2023	2024
Employee TRIR	0.82	1.31	0.66
Employee LTIR	0.45	0.94	0.22
Contractor TRIR	0.53	0.71	0.36
Contractor LTIR	0.09	0.45	0.14

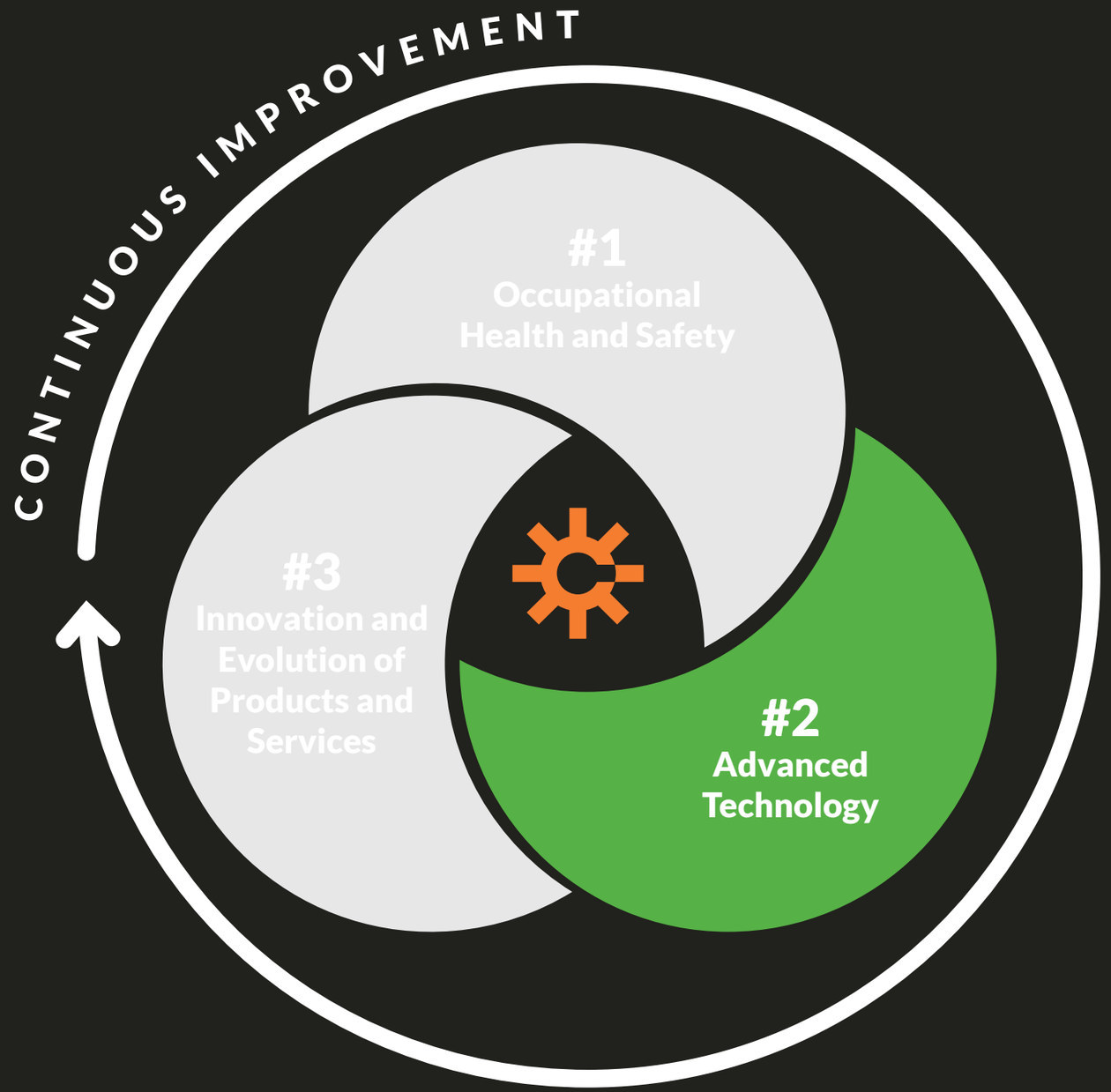
Our year-over-year safety performance is significantly lower than average industry-wide rates and we exceeded our TRIR target of 0.80, measuring 0.50 for 2024.

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

[8] TRIR includes MSHA reportable incidents.

Sustainability Foundation #2

Advanced Technology



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.

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.

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 (MW) of electric power per hour.

Middletown HRSG Upgrades

This year, SunCoke completed the upgrades of the last of five HRSGs at the Middletown plant. Over the course of the period, which began in 2019, each of the five HRSGs were fully upgraded to improve reliability.

Our HRSG technology is the reason for our status as an environmental leader in coke production and we take pride in continuing to ensure that they run optimally.

INNOVATIVE USE OF WASTE HEAT IN OUR COKEMAKING FACILITIES

Facility	Use of Waste Heat
Jewell	Partially used for coal drying
Indiana Harbor	Heat for power generation
Haverhill 1	Process steam
Haverhill 2	Power generation
Granite City	Steam for power generation
Middletown	Power generation
Vitória	Steam for power generation

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.

Haverhill HRSG

SUNCOKE'S HEAT-RECOVERY PROCESS VS BY-PRODUCT PROCESS

	SunCoke's Heat- Recovery Process	By-Product 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	Coke is created under positive pressure, allowing for leaking of coal combustion by-products such as PAHs[9] and benzol/ benzene compounds 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	Coal volatiles that are evolved during the 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	Allows production of higher quality coke with a higher CSR[10] than a by-product plant using a similar coal blend, which in turn reduces the coke load required in the blast furnace	Lesser quality, lower CSR coke from the same coal blend
Hazardous Waste and Water	Produces minimal hazardous waste and does not require a chemical plant with wastewater discharge	Process produces both hazardous waste streams (RCRA[11]) and non-hazardous wastewater discharge streams (CWA[12]-NPDES[13])

[9] PAH = polycyclic aromatic hydrocarbon

[10] CSR = coke strength after reaction

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

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

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

Haverhill HRSG

WORKING FOR CONTINUOUS IMPROVEMENT IN ADVANCED TECHNOLOGY

Water Treatment Upgrades

At our Haverhill plant, we implemented an ultra filtration unit to increase the efficiency of lime use when scrubbing sulfur dioxide from the flue gas. This project reduced both lime consumption and the amount of dry scrubber residue waste material generated. By identifying this continuous improvement opportunity, we were able to reduce the waste generated from this process by 15% in 2024.

By reducing lime usage, SunCoke achieves significant cost savings, mitigates future price risks, and generates sustainable co-benefits in waste management.

CASE STUDY

Reducing Lime Use at Plants

SunCoke's approach to continuous improvement explores opportunities to embed sustainability from project identification to project closing. One example of this is our ongoing lime use reduction program. We have a long history of working to optimize lime use across our facilities.

Reducing lime usage reduces raw material usage and the amount of waste generated in the process. Our program's success can be attributed to a strong basis in performance data, plant-level innovations, and inter-plant knowledge sharing.

Initiatives can reduce dry scrubber residue by optimizing lime usage through operational efficiency.

1 IDENTIFY important activities that drive results

Lime is a critical input at SunCoke plants and is required for SO_2 control; use of lime for controlling SO_2 results in waste dry scrubber residue that must be disposed of

2 MEASURE those critical activities

SunCoke has developed several metrics to measure lime use

3 REVIEW Performance Metrics

Performance metrics are reviewed and opportunities to optimize lime use are identified

Lime is a necessary raw material for our operations but results in the generation of a non-hazardous waste product

4 DETERMINE the steps required to close performance gaps

Plants are supported in developing purpose-built solutions to optimize their lime use. Initiatives include raising slaking temperatures and dilution water piping upgrades

5 COLLABORATE to celebrate successes, share best practices and work as a team to address challenges

Lessons learned are shared across the fleet and we continue to build on successes

6 CREATE action plans to continuously improve

SunCoke builds upon lessons learned to identify further paths to lime use optimization

Identifying sustainability co-benefits strengthens the business case for further implementation

Legend

Process

Application

Sustainability Vector

SUNCOKE VITÓRIA

Leading Environmental and Operational Performance

SunCoke has been operating a heat recovery coke plant in Vitória, Brazil since 2008. An emphasis on leveraging advanced technology to generate efficiencies and mitigate environmental impact have been a part of the plant's identity from the beginning. In fact, it was the first heat recovery cokemaking plant in Brazil. With 320 ovens and eight HRSGs, the Vitória plant is also one of the largest coke plants in the country, producing 1.6 million tons of coke annually and generating approximately 160 MW of electricity per hour.

As described below, in recent years, the facility has identified and implemented several site-specific projects to minimize fugitive emissions and enhance environmental performance. These projects, which are based on best practices at our U.S. plants, support the plant's efforts in continuous improvement. For example, we have focused on reducing fugitive dust emissions by implementing site-optimized equipment, including:

Telescopic Trunk Allows for greater control and containment of coal as it is deposited into the yard, reducing spillage and the spread of coal particulate matter.

Conveyor Belts We have covered conveyor belts and lined all conveyor belts with trays to mitigate coal spillage and further contain any coal that may be spilled.

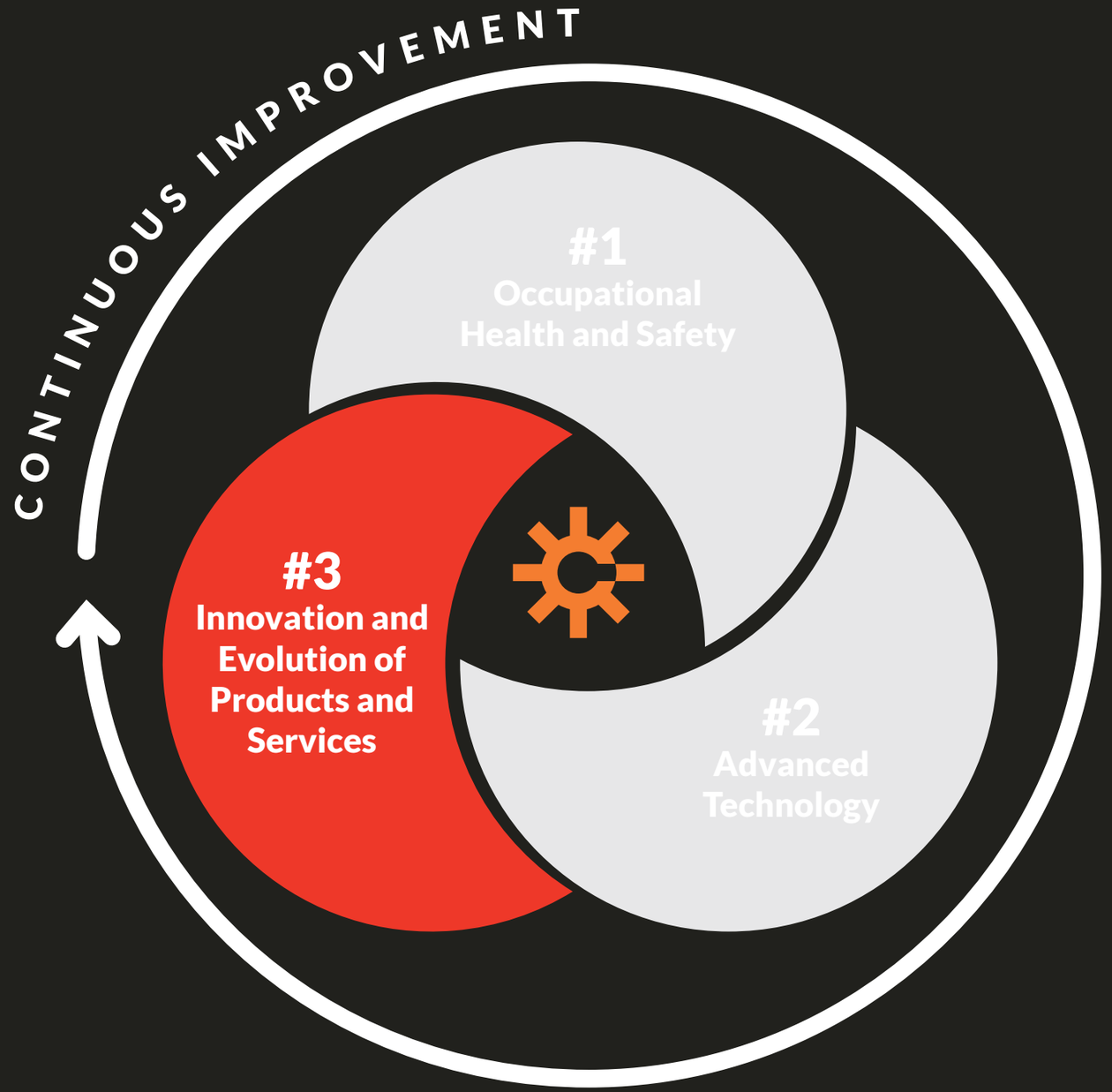
Rain Birds Manages the moisture content of the coal to reduce particulate matter.

These efforts in continuous improvement allow SunCoke to remain a trusted supplier to the steel industry in Brazil, the largest steel producing-country in South America, and the ninth largest steel-producing country in the world.[14] This in, turn, supports our emphasis on building resilient supply chains and maximizing access to a range of customer groups.

[14] World Steel Association, "World Steel in Figures 2024," 2024, https://worldsteel.org/data/world-steel-in-figures/world-steel-in-figures-2024/

Sustainability Foundation #3

Innovation and Evolution of Products and Services



OVERVIEW

We are a technology-driven company whose excellent product quality and reliability are evidenced by our long-term take or pay contracts, as well as our foundry coke sales and blast furnace coke spot market sales. To continue to meet changing market demands, we actively explore opportunities to evolve our products. Our dedication to product evolution is most clear in our successful entry into foundry coke production. We also strive for continuous improvement and innovation internally in our processes to optimize operational efficiencies and performance. In 2024, we invested $72.9 million in maintenance and growth capital to ensure that our facilities are safe, efficient, reliable, and environmentally compliant, and to advance our growth projects. 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.

PATENTS: A MARKER OF INNOVATION

By their very nature, patents represent a formalized recognition of innovation. Throughout the years, we have been issued over 80 U.S. patents and over 220 patents in foreign jurisdictions. We continue to deploy our novel technology directly into our assets, with 38 patents pending in the U.S. and an additional 75 pending in foreign jurisdictions. 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 2024, we were issued three new patents for our innovations in foundry coke. These patents have further documented our foundry coke advantage by covering a large technological landscape: the coal blends science to make our coke, the process to make foundry coke in our ovens, the beneficial and unique characteristics of our foundry coke, and the use of this coke in iron foundries, our primary market.

Key patents granted to SunCoke in 2024

- Composition of matter patent, covering SunCoke's discoveries regarding the unique properties of foundry coke that deliver high quality and performance for our customers.
- Coal blend patent, covering coal blends that we find process best in our unique oven technology and result in high-quality foundry coke products for our customers.
- Coke use patent, covering the unique shape and material properties of our foundry coke and protecting the use of our coke in our primary market, iron foundries.

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 customers, and potential customers. This knowledge transfer supports the ongoing strength of the foundry industry as a new generation enters the workforce.

Approaching technical 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 with our products and how they can optimize their operations. In 2024, we developed a custom gas analyzer that customers have used in foundries to provide real-time data on the efficiency of operations, driving stronger performance.

In addition to direct partnership with customers, we also participate in committees organized by the American Iron and Steel Institute (AISI), the American Coke and Coal Chemicals Institute (ACCCI), and the Association for Iron and Steel Technology (AIST).

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. In 2024, we built upon our existing foundry coke business, exploring more opportunities to export our foundry coke and provide associated technical support to international customers.

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. 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. The development of this opportunity remains a strategic priority for SunCoke.

Kanawha River Coal Terminal – Ceredo

In 2024, SunCoke began a $12 million expansion of KRT Ceredo that, when complete, will triple the terminal's capacity to process coal. Key elements of the expansion will include a new barge unloader as well as increased conveying capacity. The KRT Ceredo expansion will increase efficiency and support American business' access to international markets, making it an important contributor to domestic supply chain resiliency.

04

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 seven 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 background 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 full Board is responsible for overseeing SunCoke's environmental issues, including climate-related risks and opportunities. The Board is regularly briefed by representatives of the management-level Sustainability and Continuous Improvement Steering Committee on Sustainability issues and disclosures. *See "Climate Management" 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 & COMPLIANCE

We have adopted a Code of Business Conduct and Ethics that applies to all of our officers, directors and employees, including senior financial officers and executives. Our Code of Business Conduct and Ethics, along with our Core Values, establish the principles that guide our daily actions to uphold the highest standards of ethical and legal behavior. Whether working with customers, vendors, business partners or neighbors, we always strive to act with integrity. All employees must complete annual training on our Code of Business Conduct and Ethics, which we review and update as needed. We educate all employees to avoid potential conflicts of interest. 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. We also have a Human Rights Policy, which affirms our commitment to a fair living wage for all employees.

Guidance & Reporting Without Fear of Retaliation

All employees, officers, and directors must report suspected policy violations of our Code of Business Conduct and Ethics to the Compliance Team, which is led by our Chief Compliance Officer and includes representatives from our Human Resources and Legal departments. They can do so through a variety of channels, including, but not limited to, directly reporting to a supervisor, providing email or verbal reports directly to the Compliance Team and using our confidential, third-party 24/7 reporting hotline or website. Calls and online submissions are anonymous, unless the notifying party discloses his or her identity. We take the anonymity of these communications seriously and SunCoke's Compliance Team follows up on each submission. In addition to the anonymous hotline, hourly employees represented by a collective bargaining unit can also file a report using the applicable union grievance process. Nothing in our Code of Business Conduct and Ethics is intended to prevent anonymous individuals from communicating directly with relevant government authorities about potential violations of law.

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

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.

PERFORMANCE-LINKED COMPENSATION

Since SunCoke became an independent company in 2011, safety and environmental performance have been part of our compensation metrics. For 2024, safety and environmental performance each accounted for 10% of consolidated company performance goals within the annual incentive plan for 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 the Occupational Health and Safety Administration (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 sustainability 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 sustainability efforts.

Stakeholder	Engagement Approach
Investors	Discussing sustainability topics in investor calls and sustainability reports. Supporting conversations with management on sustainability 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 sustainability 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.

KEY SUSTAINABILITY 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

Sustainability Topic	Associated Risks & Opportunities
Occupational Health & Safety Safety processes and procedures that ensure continued safety throughout all business processes.	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.	• Developing and maintaining strong working relationships in the communities in which we operate. • Supporting with job creation in economically challenged communities.
Employee Development & Retention Creating an environment that attracts new employees and supports long-term retention.	• Employee engagement and retention. • Competitiveness in attracting new employees • Driving recruitment of a range of employees through internship programs. • Driving recruitment by offering market-based compensation, benefits, and upward mobility within the organization. • Employee and contractor adherence to our Code of Business Conduct and Ethics.

ENVIRONMENTAL

Sustainability Topic	Associated Risks & Opportunities
Environmental Compliance Energy created and consumed as part of our operations.	• Air emissions from our operations. • Compliance with extensive permit requirements. • Compliance with new or future, potentially more stringent regulations.
Climate 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.	• Support the energy transition by supplying high-strength, high-quality coke to make the steel that is critical for a low carbon economy. • Support increased U.S. commodity exports with our logistics terminals. • 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.	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.	• 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.
Waste Creation and disposal of hazardous and non-hazardous waste produced in SunCoke's operations.	• Generation of hazardous and non-hazardous wastes. • Disposal of hazardous and non-hazardous wastes.

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.

Impactful Partnership Story

SunCoke mitigates supply chain risk not only through effective coal sourcing but also by partnering with organizations that embed reliability throughout the coal handling process. One significant and impactful partnership in this effort has been with RECO Products and Services (RECO), a small, female owned business headquartered in West Virginia. RECO, leveraging its extensive industry knowledge, provides freeze conditioning services to SunCoke across seven states throughout the coal supply chain. This streamlines communication, reduces costs, and delivers a reliable, customized solution that addresses SunCoke's operational challenges. We are excited to continue strengthening this partnership, which mitigates risk in SunCoke operations while supporting the growth of small enterprises in the region.

Managing International Supply Chain Risk

In response to expected changes in US government trade policy, specifically regarding tariffs, SunCoke has taken proactive steps to mitigate and minimize potential impacts. These efforts involve not just the Procurement team, but the entire supply chain, including Operations, Engineering, Inventory Management, Finance, Legal, and SunCoke's supply partners.

SunCoke considers possible supply chain disruptions and market volatility. The company has identified materials currently sourced from multiple countries and evaluated current inventory levels and usage of those materials to be prepared with adequate supply. This analysis focused on identifying the most critical items and those at highest risk of tariff impact based on their sourcing locations.

The information gathered enabled SunCoke to implement several key strategies:

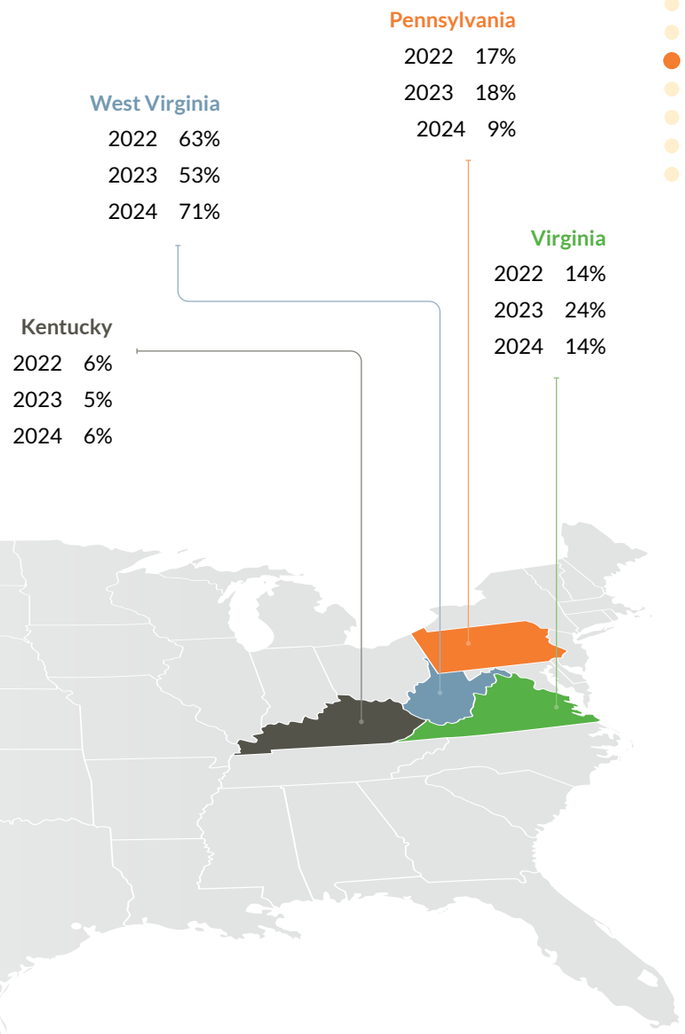
- Collaborating with existing suppliers to explore alternative manufacturing sites within the US or other low/zero tariff risk countries
- Evaluating potential new suppliers that could serve as viable sourcing options
- Building strategic inventory buffers for the most critical items that lack alternative suppliers outside high-risk tariff countries, to avoid supply chain disruptions
- Engaging with the Legal department to stay informed on trade policy developments and advocate for favorable tariff exclusions on items that cannot be sourced domestically

By taking these proactive, cross-functional measures, SunCoke aims to effectively mitigate the potential impacts of evolving US trade policies and tariffs across its supply chain.

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 2024, we purchased approximately 6.1 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[15]



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

SunCoke Logistics Supporting Resilient Supply Chains

Commodity producers moving their products today must contend with a range of risks from geopolitical to environmental, and SunCoke's uniquely diversified logistics business segment is well positioned to support new and existing customers with bringing their products to market.

Our fleet of terminals are located on the Mississippi, Ohio, and Kanawha rivers and are designed for high-throughput unloading, offloading, and storage of a variety of commodities – including coal, iron ore, petroleum coke, blast furnace coke, and aggregates– from and to river barges, ocean vessels, trucks, and rail cars. Direct service by Canadian National railroad at CMT and both NS and CSX railroads at the Kanawha River Terminals further enable customers to move their commodities where and when they need.

Changing Export Market

SunCoke's logistics terminals are supporting customers impacted by the reduction of U.S. domestic coal consumption with exporting their products to international markets. In 2023, coal exports rose by over 15% from 2022, resulting in full capacity at many U.S. terminals.[16] Our expanding capacity at KRT leaves us well positioned to support new and existing customers with mitigating their supply chain risks by providing alternative routes to ports that service international trade routes.

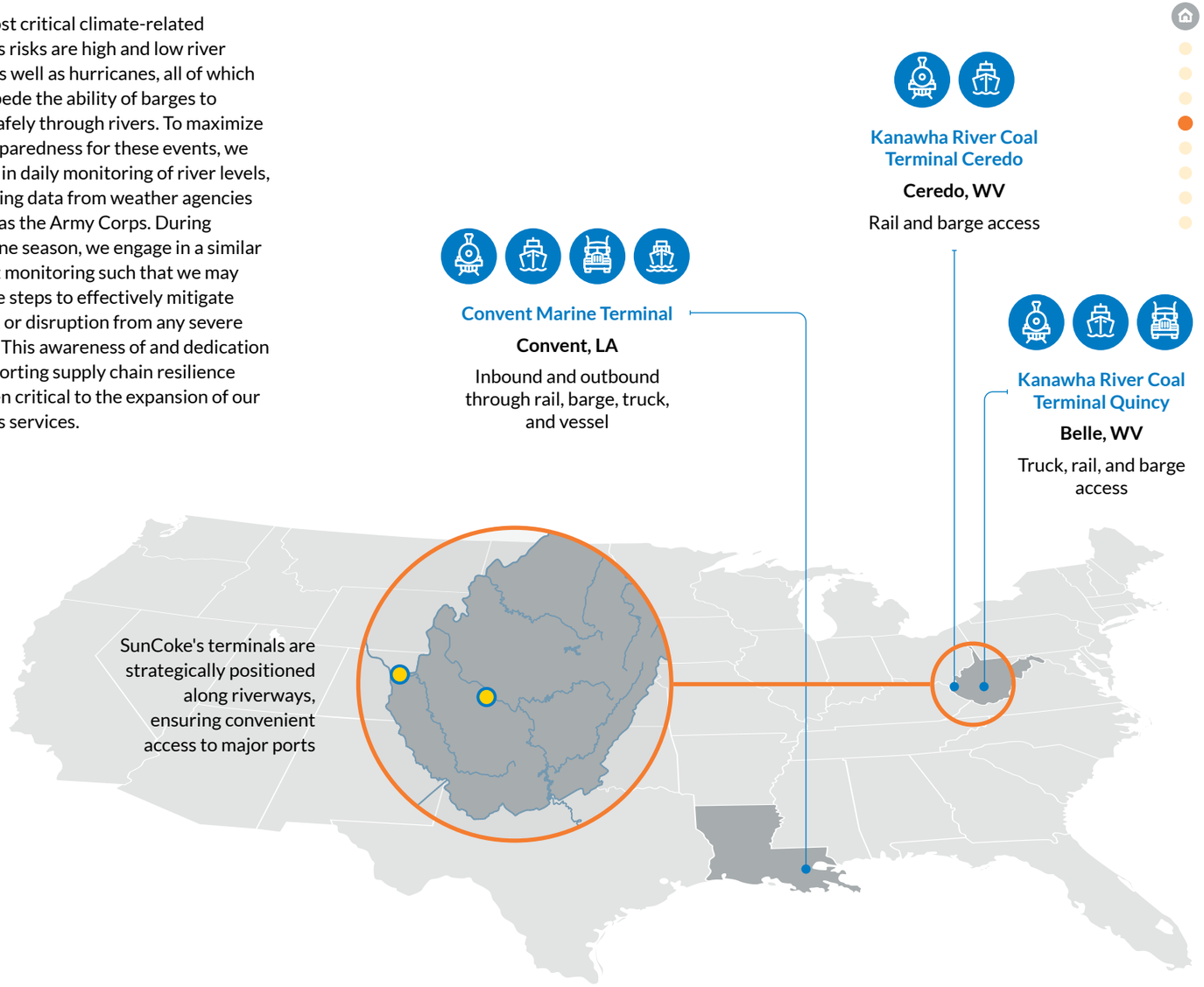
Baltimore Bridge Collapse

SunCoke logistics have supported customers with mitigating longer term supply chain risks, but our nimble operations are also able to adapt to immediate, unforeseeable supply chain disruptions. The Baltimore bridge collapse of 2024 left many commodities stranded and unable to be shipped to international markets. Due to SunCoke KRT's strategic positioning on the Ohio river, coal owners with stranded assets were able to transport their products to KRT by barge where they were then transloaded to rail and shipped to other international ports. We seek to leverage our strategic positioning to strengthen our value chain over the short and long term.

Climate Risks Affecting Logistics

In addition to geopolitical risks, the risk of physical climate events is changing the way that commodities are being shipped. Increasingly, mines are shipping through more than one logistics terminal, in part to mitigate the risk that climate events such as wildfires, high or low rivers, hurricanes, and more might leave assets stranded. We support customers in managing increasing climate risk through diligent monitoring of climate and weather events.

Our most critical climate-related logistics risks are high and low river levels as well as hurricanes, all of which can impede the ability of barges to move safely through rivers. To maximize our preparedness for these events, we engage in daily monitoring of river levels, leveraging data from weather agencies as well as the Army Corps. During hurricane season, we engage in a similar diligent monitoring such that we may take the steps to effectively mitigate the risk or disruption from any severe events. This awareness of and dedication to supporting supply chain resilience has been critical to the expansion of our logistics services.



[16] U.S. Energy Information Administration, "Annual Coal Report 2023," 2024, https://www.eia.gov/coal/annual/pdf/acr.pdf

05
Climate Management

OVERVIEW

Incorporating climate-related considerations into our strategy and sustainability disclosures is not new—we have been doing so for several years. In SunCoke's 2023 Sustainability Report, this section was entitled 'TCFD and Climate Change,' but the title has been adjusted in recognition that the TCFD standards have been integrated into the ISSB IFRS S2 standard. The structure of this section largely remains the same.

Our decision to begin reporting against the ISSB standards 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.

IFRS S2 FRAMEWORK

Our reporting follows the recommendations of TCFD as represented in the ISSB IFRS S1 and S2 standards. It starts with Governance, followed by Strategy, then Risk Management, and finally, Metrics.

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 sustainability risks, including climate-related issues.

Metrics

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

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 Sustainability and Continuous Improvement Steering Committee, which is comprised of executive and management personnel, interfaces across all three levels and with SunCoke Operations to coordinate and implement our climate strategy.

As we maintain our focus on continuous improvement, we transitioned our ESG Steering Committee to the Sustainability and Continuous Improvement Steering Committee in 2024. The Committee functions as a working group responsible for monitoring climate-related risks and coordinating the development and implementation of SunCoke's sustainability and continuous improvement (including climate change) strategy and disclosures.

Representatives of the Sustainability and Continuous Improvement Steering Committee meet with the Board at least twice annually for briefings on climate-related risks, as well as overall SunCoke sustainability strategy and reporting.

Governance Chart

BOARD

Board of Directors and the Governance Committee

The full Board is responsible for overseeing SunCoke's climate strategy. The Board 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 Board met to discuss climate strategy and environmental matters twice in 2024.

EXECUTIVE

The President and CEO[17]

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

MANAGEMENT

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

The Director of Environmental and Sustainability is responsible for informing both the strategic direction and the day-to-day implementation of SunCoke's sustainability strategy. Responsibilities also include supporting the Vice President, Assistant General Counsel & Chief Compliance Officer (VP, AGC & CCO) with environmental compliance matters.

SUSTAINABILITY AND CONTINUOUS IMPROVEMENT STEERING COMMITTEE

Permanent Members
- VP, AGC and CCO
- VP, CTO
- Director, Environmental and Sustainability
- Director, Continuous Improvement and Engineering
- Director, Engineering
- Director, Technology

Adjunct Members
- VP and Controller
- VP, AGC and Corporate Secretary

Board-Level Discussions

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

Preliminary Value Chain Mapping

Completed a preliminary value chain mapping exercise that evaluated the environmental dependencies, risks, and opportunities of companies upstream and downstream from our cokemaking operations.

Sustainability disclosures

Reviewed and published our sustainability disclosures, including our Annual Sustainability Report and CDP Climate Change response. This included a discussion on the alignment of the 2024 Sustainability Report with ISSB's IFRS S1 and S2 standards.

Ongoing environmental initiatives

Continuous efforts to improve environmental performance and generate efficiencies within our processes.

New Director Roles

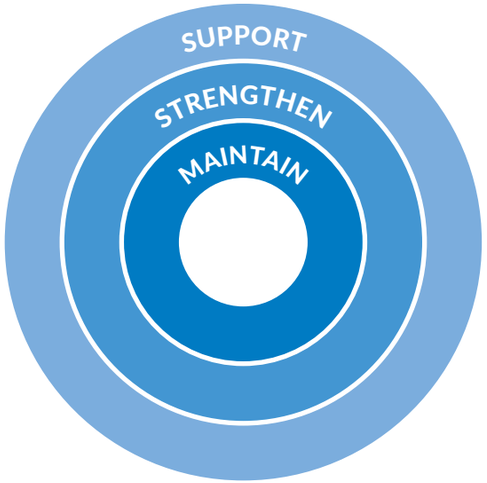
SunCoke further formalized its commitment to sustainability and continuous improvement by creating director-level positions to manage environmental and sustainability matters, and continuous improvement. Here, the title of Director does not refer to members of the Board but to upper-management level SunCoke employees.

Exposure to Climate Regulation

Continuing to monitor developments in climate regulation and engage with the relevant stakeholders on any applicable regulations.

[17] Katherine Gates, SunCoke's President and CEO

STRATEGY



The Three Dimensions of SunCoke's Climate Strategy

Support
Support the energy transition by supplying high-strength, high-quality coke to make the steel that is critical for a low carbon economy.

Strengthen
Strengthen the resilience of our business by diversifying our product offerings in response to industry needs.

Maintain
Maintain our strong customer relationships and optimize our operations to position ourselves as the preferred supplier of high-strength, high-quality coke while exploring opportunities and technology that will allow SunCoke to support customers as the steel industry evolves.

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 six 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 carbon dioxide (CO_2) emissions intensity is the lowest of the nine largest steel producing countries and the EU (European Union)-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.

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-produced primary steel 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 blast furnace-produced steel will require a reliable supply of coke, as coke is critical for 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

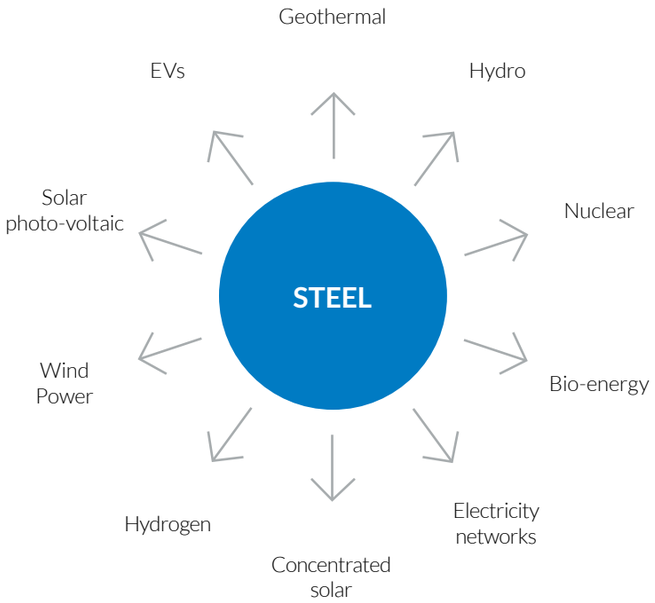
As our steel customers work to reduce their GHG emissions by using alternative lower-carbon blast furnace fuel sources and reducing the overall amount of coke used, the importance of not compromising on the strength and quality of the needed coke becomes even more critical to them. SunCoke's high-strength, 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 number of sectors that are supporting the transition to a low carbon economy, as shown by the diagram below.[18]

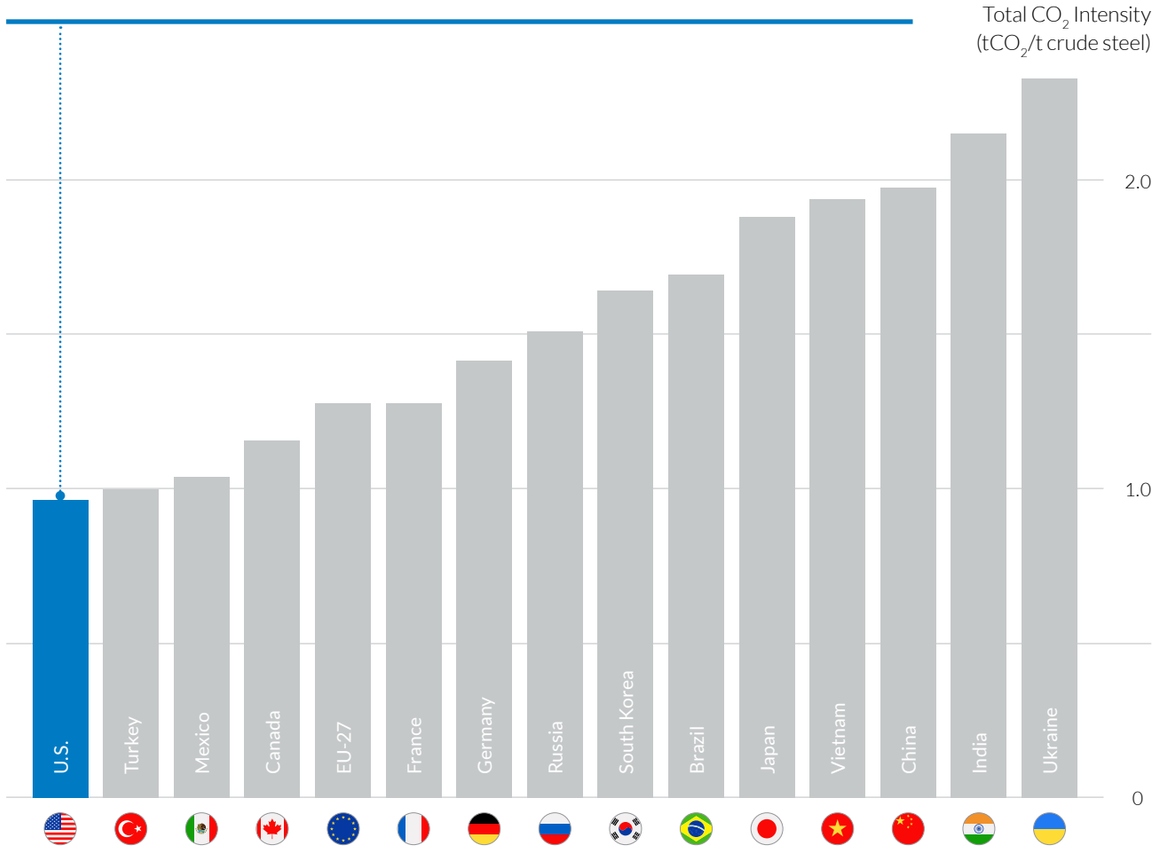


[18] Adapted from McKinsey & Company, "The raw-materials challenge: How the metals and mining sector will be at the core of enabling the energy transition," 2022

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

Largest Steel Producing Countries and the EU-27 (2019)[19]

- 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



RISK MANAGEMENT

Our process for identifying and managing climate-related issues on a global and site-specific basis is continuously being advanced. 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

GHG Regulations

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
Increasingly, regulatory policy relating to GHG emissions is being applied to corporate reporting internationally. An important example is many countries' adoption and legislation of the ISSB's standards.

In the U.S., the Securities and Exchange Commission's (SEC) rule on The Enhancement and Standardization of Climate-Related Disclosures for Investors had numerous requirements, but the rule has now been stayed. SunCoke will continue to monitor the rule for any developments.

Although SunCoke is not currently mandated to report against any climate disclosure standards, we continue to monitor them as a potential long-term risk. Regulations that mandate significant emissions reductions could pose a risk if SunCoke cannot address them. To manage these related risks, SunCoke is beginning to voluntarily report against the ISSB standards.

REPUTATION

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 operational disruption, financial loss, reputational damage, 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

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.

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 or sell more foundry 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), even as steel companies explore the use of hydrogen and other green additives in the steel making process.

Carbonaceous substitutes for coke

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

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 produced by SunCoke.

SunCoke's Response

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 2024, 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.

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.

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 emissions where possible.
- Continue to invest in innovations that improve our processes, yield, and product portfolio and provide high-strength, high-quality coke and logistics services to our customers.
- Continue to monitor climate-related risks as part of our regular risk assessment processes.

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 metric tons)	2022	2023	2024
Scope 1 GHG Emissions[20] (CO_2e)[21]	4.53	4.38	4.53
Scope 2 GHG Emissions (CO_2e)	0.14	0.15	0.14
Scope 1 GHG Intensity (tons CO_2e/ton coke produced)	0.89	0.86	0.89

Our Scope 1 emissions are tied to the amount of metallurgical coal that 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 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.

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

[20] 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.

[21] Carbon Dioxide Equivalent

06 Environment

ENVIRONMENTAL STEWARDSHIP & COMPLIANCE

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

SunCoke operates under environmentally sound operations; complies with all laws, regulations, and permits; reduces emissions and environmental impact; and promotes 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 2024, 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.

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.

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.

GHG emissions from our operations and their impact on climate change
- Completed our 4th CDP Climate Change report.
- Produced more electricity via our production process than the electricity consumed by it.
- Continued championing new initiatives through the 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 "Climate Management" for our reported GHG emissions from 2022 to 2024.

Other Significant Air Emissions Data 1,000 tons

Air Emissions	2022	2023	2024
VOCs volatile organic compounds (U.S. only)	0.05	0.05	0.05
NOx nitrogen oxides (U.S. only)	3.4	3.3	3.4
SO_2 sulfur dioxide	12.8	12.5	12.3
PM particulate matter	2.0	2.3	2.1
CO carbon monoxide (U.S. only)	0.5	0.5	0.5
Pb lead	0.003	0.003	0.003

Fuel Consumption 1,000 cubic meters (m^3)

Fleet fuel consumption of gasoline	1.1	1.1	1.2
Fleet fuel consumption of diesel	7.8	8.9	10.1

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 Sustainability and Continuous Improvement 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.

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

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 1,000 TJ (Terajoules)	**2022**	**2023**	**2024**
Coal-based energy used in coking of coal	91.5	90.9	87.7
All other forms of energy used (excluding coal)	3.3	3.4	3.9
Total	94.8	94.3	91.6

Purchased Energy Use (TJ)	**2022**	**2023**	**2024**
Natural Gas	1,835	1,856	2,277
Propane	31	20	61
Fuel Oils	336	377	427
Electricity	1,117	1,135	1,164
Total	3,319	3,388	3,929

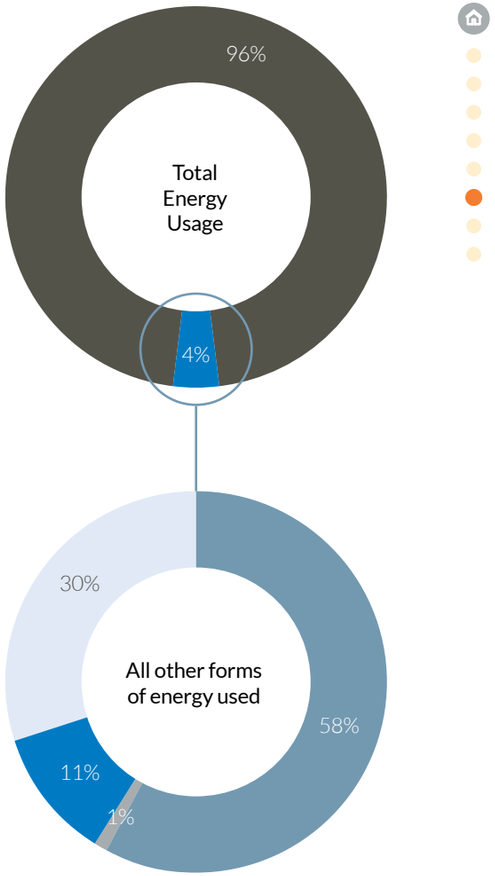
All purchased electrical power is sourced from the electricity grid. In 2024, electrical power purchased from the grid represented 30% of purchased energy. In 2022 and 2023, it represented 34% and 33%, respectively.

Site	**Type**	**Unit**	**2022**	**2023**	**2024**
Haverhill 2	●	1,000 TJ[22]	1.1	1.3	1.2
Middletown	●	1,000 TJ	1.3	1.2	1.3
Haverhill 1	▲	million tons	1.4	1.4	1.3
Granite City	▲	million tons	1.7	1.6	1.6
Vitória	▲	million tons	3.8	3.5	3.4

● Power generated

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

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



Coal-based energy used in coking of coal

Natural Gas

All other forms of energy used (excluding coal)

Propane

Fuel Oils

Electricity

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 2,380 acres, with our total disturbed land measuring less than 2,380 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.

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. We have turned stormwater management into an opportunity, for example, certain coke plants collect stormwater for use in irrigation systems that manage dust at our plants.

Water Usage (million m^3)	2022	2023	2024
Total Fresh Water Withdrawn[23]	6.3	6.6	7.1
U.S.	4.9	5.2	5.2
Brazil	1.5	1.3	1.9
Total Fresh Water Withdrawn and Consumed in Locations with High Baseline Water Stress (Brazil)	1.5	1.3	1.9
Total Water Consumption	6.3	6.6	7.1
U.S.	4.9	5.2	5.2
Brazil	1.5	1.3	1.9
Total Wastewater Discharge[22]	0.2	0.2	0.2
Percentage of Fresh Water Withdrawn from Locations with High Baseline Water Stress (Brazil)	23%	20%	27%

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

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.

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. In 2024, we upgraded our water treatment systems at the Haverhill plant and co-benefits were a reduction in lime consumption and, as a result, a reduction in the creation of dry scrubber residue which is delivered to landfills. Additionally, this past year, both our Middletown and Granite City plants also engaged in lime use reduction initiatives, leveraging increased slaking temperatures and dilution water piping redesign.

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	2022	2023	2024
Percentage Waste Recycled	89%	91%	74%
Total Non-Hazardous Waste Produced, including recycling[24] (1,000 tons)	155	161	128
Total Hazardous Waste Produced at U.S. Facilities[25] (1,000 tons)	1.8	2.0	1.5
Total Hazardous Waste Produced at Brazil Coke Production Facility (1,000 tons)	0.3	0.1	0.1
Total Hazardous Waste Produced (1,000 tons)	2.1	2.2	1.6
Percent of Total Waste that is Hazardous	1%	1%	1%

Spills[26]	2022	2023	2024
Total Number of Reportable Spills	0	0	0
Total Spill Volume	0	0	0
Percentage of Spills Recovered	N/A	N/A	N/A

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

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

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

07
Social

OVERVIEW

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 respected and enabled. 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 focus on providing a fair living wage; providing base pay well above the U.S. minimum wage; complying with all applicable laws and standards related to labor practice and human rights including child labor laws; 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 2024, 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 sustainability topic review and discussions and took the actions described below.

2024 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.

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 40% of domestic employees.
- Maintained partnerships with unions in each of our union facilities.

Right to equal pay for equal work
- 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 2024 TRIR of 0.50.
- 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.

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.

HUMAN CAPITAL STRATEGY

Our human capital strategy is centered on talent retention, succession planning, workforce stability, training and total compensation. At SunCoke, we strive to create a welcoming work environment where our employees are valued, trusted, and motivated to contribute meaningfully both as individuals and as a part of the team. We believe our employees offer a fresh perspective on SunCoke operations and value each employee's contribution across the business. Company leadership and the Compensation Committee of our Board of Directors are closely engaged in overseeing the Company's human capital management programs. The leadership of our Human Resources department, in partnership with local Human Resources and General Managers sponsor the development and oversight of all human capital programs in the organization including: (i) workforce composition, talent acquisition and retention, (ii) culture, (iii) workforce stability, (iv) employee development and training, (v) benefits, (vi) talent management, and (vii) total compensation. Additionally, Human Resources collaborates with our Legal department, including the Chief Compliance Officer, as necessary for matters related to human capital, ethics and compliance.

Culture and Core Values

Our culture at SunCoke is driven by our 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. They guide our actions and decisions so 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, and celebrate success.
- Innovation: master the science and process, create a better way, find a better solution and push the envelope.
- Commitment: deliver results, be accountable, work as a team, continuously improve and grow and always communicate effectively.
- Integrity: do what is right, say what you mean, do what you say, earn trust and treat others with respect.
- Stewardship: provide safe, reliable and environmentally sound operations for our people and their families, our customers and the communities where we do business.

Workforce Composition

As of December 31, 2024, we have 868 employees in the U.S. Approximately 40% of our domestic employees, at our coke-making operations, are represented by the United Steelworkers union under various local collective bargaining agreements. Additionally, approximately 3% of our domestic employees are represented by the International Union of Operating Engineers at our Lake Terminal facility.

As of December 31, 2024, we have 300 employees at the coke-making facility in Vitória, Brazil, all of whom are represented by Sindimetal-ES union under a labor agreement.

Talent Retention, Development & Training

In addition to our focus on workforce stability, we strive to continually attract, develop, engage, and retain a high-performing team that executes our strategy of long-term profitable growth. We are committed to employee development and helping individuals reach their full potential, by making ongoing investments in our team.

We have a continual focus on strengthening technical, professional and leadership capabilities at every level using contemporary learning strategies to foster high performance. Development occurs in the form of specialized leadership training through third-party vendors, cross training, stretch assignments, and on the job training. In 2024, frontline supervisors and first-time managers received training to strengthen their leadership skills, including training on conflict resolution, high-quality decision making, communication, coaching, and improving safety and workplace performance. Strategic talent reviews occur at a minimum, twice a year, across the company.

SunCoke also provides a robust training program that is meant to meet applicable regulatory requirements. In addition to the annual interactive video-based SunCoke Code of Business Conduct and Ethics training we provide to all employees; 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, Conducting Effective Investigations, Retirement Planning, and Substance Abuse Awareness.

SunCoke's Personal Information & Privacy Policy outlines specific procedures for employees to handle sensitive information in a secure and responsible manner. The Personal Information & Privacy Policy is updated periodically to reflect evolving data security best practices. SunCoke utilizes a variety of information security training methods, including training segments on data security best practices and periodic security awareness communications that remind employees to stay vigilant with respect to data security.

SunCoke Student Opportunities

Employee retention is critical to workforce stability, but talent attraction plays an equally important role. In 2024, SunCoke implemented various internship outreach initiatives to identify the next generation of leaders in sustainable, efficient, coke development.

We conducted outreach through several different avenues ranging from a partnership with Handshake, an online platform for career guidance and talent development with over 17 million users, to strategic partnerships with the universities in the communities where we operate. This includes established relationships with the University of Illinois as well as Southwest Virginia Community College.

The internship development pathway at Jewell is designed to develop an early, strong understanding of SunCoke's core values, then provide opportunities to apply those best practices with increasing amounts of responsibility. Interns begin in operations and maintenance to build their understanding of SunCoke. They are then paired with a project engineer to work on larger projects, developing engineering best practices. As the internship progresses, candidates take on more responsibilities in maintenance and engineering within the facility.

SunCoke was proud to welcome interns to the Jewell facility in the summer of 2024.

Succession Planning

We pride ourselves on being a lean workforce that focuses on developing and promoting talent internally. Our open roles are almost always filled internally. We engage in succession planning to help identify development and training opportunities for high performing talent, preparing potential successors for our most critical roles through assessment of the incumbents and equipping these employees with individualized development plans and job assignments to help them grow. We have implemented customized leadership development plans for the immediate successors of key positions.

Compensation and Benefits

Providing competitive benefits and compensation underpins our commitment to our engaged and productive employees. Our pay-for-performance philosophy aligns employee's individual contributions, behaviors and business results with individual rewards. Our short-term incentives include both 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 for retention. This helps the Company to retain those identified as having the top skills and abilities that are critical to our business.

We offer comprehensive benefits to our employees and their families, including health care coverage, retirement benefits, life and disability insurance, competitive vacation and leave policies. We also offer supplemental benefits programs designed to enhance the daily life and well-being of our employees, including: supplemental life insurance for all eligible family members, supplemental short-term disability, a legal services plan, an identity theft and device protection program, financial retirement planning education and coaching, paid-time off (including time for community service), tuition reimbursement, health management for chronic conditions, a 24/7 employee assistance program, telemedicine, critical illness, accident and hospital indemnity insurance.

Talent Management

We use an annual review process to evaluate employees' performance and assist in their development. 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.

Workforce Stability & Leadership Experience

Our regrettable turnover rate was approximately 1% in 2024. This low rate shows how successful our commitment to employee retention is. The stability of our workforce is also anchored by our experienced corporate leadership team along with our General Managers that lead the day-to-day operations at our facilities. Our leaders each have an average of nearly 20 years of leadership experience and an average tenure (or length of service) of over 14 years with SunCoke.

In 2024, SunCoke implemented various internship outreach initiatives to identify the next generation of leaders in sustainable, efficient, coke development.

MAKING SUNCOKE
A GREAT PLACE TO WORK:

EMPLOYEE & COMMUNITY ENGAGEMENT

SunCoke's most valuable partners are the communities where we operate. We view our relationship with communities as a collaboration in economic development and we make it our aim to provide stable employment as well as broader community support. Each year, both our plants, logistics terminals, and corporate offices organize events to bring our employees and communities together, celebrate our wins, and foster new skills. These events enhance the local areas as well as the SunCoke work environment all while support long-term retention. Some highlights from 2024 include:

Family Day

The Vitória plant's 2024 Family Day event celebrated unity, support, and team bonds. Activities included a guided bus tour of the facility, children's recreation, and a magic show. Employees received gifts, and Mother's Day was celebrated with special tributes in videos.

Scholarships

SunCoke's Jewell plant awarded $22,000 in scholarships to the children and grandchildren of SunCoke employees living in Buchanan County, VA.

Anniversary Celebration

Our corporate office in Lisle, Illinois, recognized employees who have shown ongoing dedication to SunCoke by hosting an even at the Morton Arboretum. Employees and their family members gathered in the scenic setting to recognize and celebrate 5, 10, and 15-year anniversaries of employment at SunCoke. The event also supported the Arboretum whose mission is to help trees thrive in the Chicago region and around the world.

Pink October

The Vitória plant's Pink October event emphasized healthy lifestyles, preventative methods and warning signs of breast cancer. Consultations with a doctor were available as well as opportunities to connect with HR.

Budget Management Classes

Classes on Budget Management and Control were taught to employees at the Vitória plant who are enrolled in the Graduate Program in Management and Industrial Processes. Employees had the opportunity to interact and apply their knowledge, aligning their qualifications with SunCoke's strategies.

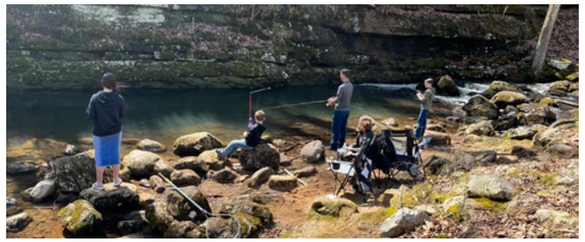
Supporting Local Teams

SunCoke sponsored the Indiana-based Triple Crown Boomstix youth softball program. Funds were used for uniform, equipment, and tournament fees.

Family Fishing

SunCoke supported the Whitewood Volunteer Fire Department in organizing and funding a family fishing day for the residents of Buchanan County, VA.

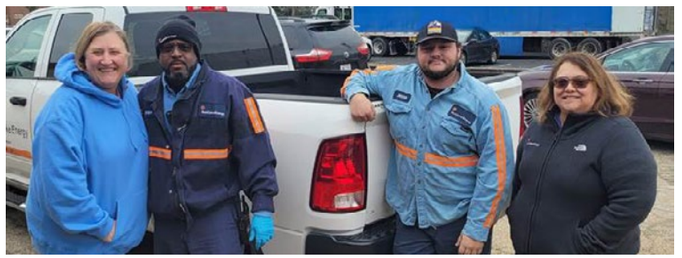





Holiday Giving Tree

In support of the Family Service of Middletown, Ohio, SunCoke's Middletown plant raised funds and gifts that were distributed to local children, adults, and seniors during the holidays.



08

Frameworks

This report covers our sustainability data and performance metrics for calendar year 2024 and has been informed by GRI, SASB (Iron & Steel Producers and Coal Operations industry standards), and the IFRS S1 and S2 standards.

GRI

GRI Standards	Suncoke Disclosures
GRI 2: General Disclosures 2021	
2-1 Organizational details	Who We Are 2024 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 2024. SunCoke’s Sustainability Report is published annually. About this Report Our Key Sustainability Topics
2-4 Restatements of information	
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 SunCoke and American Industry Continuous Improvement 2024 Annual Report on Form 10-K
2-7 Employees	Social > Human Capital Strategy
2-9 Governance structure composition	Governance, Ethics, and Risk > Governance Climate Management > Governance 2025 Proxy SunCoke Energy - About Us - Leadership - Board of Directors SunCoke’s Chair of the Board is not an executive officer in the organization.
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	
2-10 Nomination and selection of the highest governance body	2024 Annual Report on Form 10-K 2025 Proxy SunCoke Energy - About Us - Leadership - Board of Directors Governance, Ethics, and Risk > Performance-Linked Compensation Social > Human Capital Strategy
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	
2-15 Conflicts of interest	Governance, Ethics, and Risk > Ethics & Compliance Code of Business Conduct and Ethics
2-16 Communication of critical concerns	
2-26 Mechanisms for seeking advice and raising concerns	
2-22 Statement on sustainable development strategy	Foreword
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 > Human Capital Strategy 2024 Annual Report on Form 10-K
GRI 201: Economic Performance 2016	
201-1 Direct economic value generated and distributed	2024 by the Numbers 2024 Annual Report on Form 10-K
201-2 Financial implications and other risks and opportunities due to climate change	Climate Management > Strategy / Risk Management 2024 Annual Report on Form 10-K
201-3 Defined benefit plan obligations and other retirement plans	2024 Annual Report on Form 10-K

GRI

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	
302-2 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	Climate Management > 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	Climate Management > Metrics
305-5 Reduction of GHG emissions	
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 > Human Capital Strategy
401-2 Benefits provided to full-time employees that are not provided to temporary or part-time employees	2024 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 and safety	
403-5 Worker training on occupational health and 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	

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

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 ver. 2023-12	Suncoke Disclosures
Greenhouse Gas Emissions	
Gross global Scope 1 emissions, percentage covered under emissions limiting regulations	Climate Management > 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	Climate Management > 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 N2O), (3) SOx , (4) particulate matter (PM10), (5) manganese (MnO), (6) lead (Pb), (7) volatile organic compounds (VOCs), and (8) polycyclic aromatic hydrocarbons (PAHs)	Environment > Air Emissions
Activity metrics	
Total coking coal production	2024 by the Numbers

Energy Management	
(1) Total energy consumed, (2) percentage grid electricity and (3) percentage renewable	Environment > Energy Usage Within the reporting period, SunCoke did not directly source energy from renewable sources.
(1) Total fuel consumed, (2) percentage coal, (3) percentage natural gas and (4) percentage renewable	
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 2024, 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) Total recordable incident rate (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	Climate Management > Risk Management Governance, Ethics, and Risk > Enterprise Risk

SASB Coal Operations Industry Standard ver. 2023-12	Suncoke Disclosures
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
Labor Relations	
Percentage of active workforce employed under collective agreements	Social > Human Capital Strategy 2024 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

SASB • IFRS S1

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 (EPRP)	Environment > Legacy Impoundment and Reclamation We have one coal slurry impoundment, classified as high-hazard potential by MSHA. In 2024, 1 percent of produced waste was hazardous and 74 percent of waste was recycled.
Summary of tailings management systems and governance structure used to monitor and maintain the stability of tailings storage facilities	
Approach to development of Emergency Preparedness and Response Plans (EPRPs) for tailings storage facilities	

Required Disclosures	Suncoke Disclosures
Governance	
The governance body(s) or individual(s) responsible for oversight of sustainability-related risks and opportunities.	Governance, Ethics, and Risk Continuous Improvement > Occupational Health and Safety > SunCoke Visible Leadership Program
Management's role in the governance processes, controls and procedures used to monitor, manage and oversee sustainability-related risks and opportunities.	
Risk Management	
The processes to identify, assess, prioritize and monitor sustainability-related risks and opportunities, including whether and how those processes are integrated into and inform the entity's overall risk management process	Governance, Ethics, and Risk > Enterprise Risk
Metrics and targets	
The performance in relation to its sustainability-related risks and opportunities.	2024 by the Numbers Continuous Improvement > Occupational Health & Safety
The progress towards any targets the entity has set, and any targets it is required to meet by law or regulation.	Continuous Improvement > Occupational Health & Safety
Strategy	
The sustainability-related risks and opportunities that could reasonably be expected to affect the entity's prospects.	Governance, Ethics, and Risk > Key Sustainability Topics / Enterprise Risk / Supply Chain Risk Environment Social
The current and anticipated effects of sustainability-related risks and opportunities on the entity's business model and value chain.	
The effects of those sustainability-related risks and opportunities on the entity's financial position, financial performance and cash flows for the reporting period.	
The anticipated effects of those sustainability-related risks and opportunities on the entity's financial position, financial performance and cash flows over the short, medium and long term.	
The entity's capacity to adjust to the uncertainties arising from sustainability-related risks.	

IFRS S2

Required Disclosures	Suncoke Disclosures
Governance	
The governance body(s) or individual(s) responsible for oversight of climate-related risks and opportunities.	Climate Management > Governance
Management's role in the governance processes, controls and procedures used to monitor, manage and oversee climate-related risks and opportunities.	
Risk Management	
The processes and related policies the entity uses to identify, assess, prioritize and monitor climate-related risks.	Climate Management > Strategy / Risk Management Governance, Ethics, and Risk > Enterprise Risk / Key Sustainability Topics
The processes the entity uses to identify, assess, prioritize and monitor climate-related opportunities, including information about whether and how the entity uses climate-related scenario analysis to inform its identification of climate-related opportunities.	
The extent to which, and how, the processes for identifying, assessing, prioritizing and monitoring climate-related risks and opportunities are integrated into and inform the entity's overall risk management process.	
Strategy	
The climate-related risks and opportunities that could reasonably be expected to affect the entity's prospects.	Climate Management > Strategy / Risk Management
The current and anticipated effects of climate-related risks and opportunities on the entity's business model and value chain.	
The effects of climate-related risks and opportunities on the entity's strategy and decision-making.	
The effects of climate-related risks and opportunities on the entity's financial position, financial performance and cash flows for the reporting period.	
The anticipated effects of climate-related risks and opportunities on the entity's financial position, financial performance and cash flows over the short, medium and long term.	
The resilience of the entity's strategy and business model to climate-related changes, developments and uncertainties.	
Metrics and Targets	
The amount of absolute GHG emissions (Scope 1-3) and the approach used to measure GHG emissions.	Climate Management > Metrics
Internal carbon prices.	SunCoke does not use internal carbon prices.
Climate-related remuneration.	Governance, Ethics, and Risk > Performance-Linked Compensation
The quantitative and qualitative climate-related targets the entity has set to monitor progress towards achieving its strategic goals, and any targets it is required to meet by law or regulation, including any greenhouse gas emissions targets.	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.
Information about the entity's approach to setting and reviewing each target, and how it monitors progress against each target	
Information about the entity's performance against each climate-related target and an analysis of trends or changes in the entity's performance	

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 2024 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

Abbreviation	Definition
ACCCI	American Coke, Coal, and Chemical Institute
AGC	Assistant General Counsel
AISI	American Iron and Steel Institute
AIST	Association for Iron and Steel Technology
B	Billion
BOF	Blast Oxygen Furnace
℃	Degrees Celsius
C.A.	Combustion Air
CAP	Community Advisory Panel
CCO	Chief Compliance Officer
CEO	Chief Executive Officer
CMT	Convent Marine Terminal
CO	Carbon Monoxide
CO_2	Carbon Dioxide
CO_2e	Carbon Dioxide Equivalent
CSR	Coke Strength After Reaction
CTO	Chief Technology Officer
CWA	Clean Water Act
EAF	Electric Arc Furnace
EBITDA	Earnings Before Interest, Taxes, Depreciation, and Amortization
EHS	Environment, Health, and Safety
EPA	U.S. 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
GJ	Gigajoules
GPI	Granulated Pig Iron
GRI	Global Reporting Initiative
GWh	Gigawatt-Hour
HRSG	Heat Recovery Steam Generator
HVAC	Heating, Ventilation, and Air Conditioning
IFRS S1	International Financial Reporting Standards General Requirements for Disclosure of Sustainability-related Financial Information
IFRS S2	International Financial Reporting Standards Climate-related Disclosures
IL	Illinois
IN	Indiana
ISSB	International Sustainability Standards Board
KRT	Kanawha River Terminal
LA	Louisiana
LTIR	Lost Time Incident Rate
M	Million
MACT	Maximum Achievable Control Technology
MSHA	Mine Safety and Health Administration
MW	Megawatt
MWh	Megawatt-Hour
m^3	Cubic Meter
NOx	Nitrogen Oxide
NPDES	National Pollution Discharge Elimination System
OH	Ohio
OSHA	Occupational Health and Safety Administration
PAH	Polycyclic Aromatic Hydrocarbon
Pb	Lead
PM	Particulate Matter
PV	Photovoltaic
RCRA	Resource Conservation and Recovery Act
RECO	RECO Products and Services
R&D	Research and Development
SEC	Securities and Exchange Commission
SO_2	Sulfur Dioxide
SunCoke	SunCoke Energy Inc.
Sq.	Square
T	ton
TCFD	Taskforce on Climate-related Financial Disclosures
The Company	SunCoke Energy Inc.
TJ	Terajoules
TRIR	Total Recordable Incident Rate
UN	United Nations
U.S.	United States
VA	Virginia
VOC	Volatile Organic Compound
VP	Vice President
WV	West Virginia
ZISA	Zero Injury Safety Incidents Award

SunCoke Energy®

SunCoke Sustainability Report 2024