



SUSTAINABILITY REPORT 2022



RIESS KELOMAT GMBH

FOREWORD

We are generation-minded, probably because our family business is now in the ninth generation. Sustainable thinking has always been practised in our company. Therefore it is not a new trend for us, but a matter of course. For the fifth time we are happy to report on how we carry on the spirit of our ancestors and still remain open to new ideas.

Sincere regards,



Dipl. -Ing. Julian Riess

Susanne RieB

Ing. Friedrich Riess

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For ease of legibility we have dispensed with references to "he/she" and "him/her". The form used refers equally to men and women.

ABOUT US

SUSTAINABILITY AT RIESS KELOMAT

Our company has been in existence since 1550, primarily because sustainability is traditional at RIESS KELOMAT. This was a conviction deeply held by our forefathers. As far as we are concerned, sustainability means applying these principles in the modern era.

Healthy and responsible - cooking our way

Cooking in the 19th century involved harmful substances. When heated, pans released toxic substances. Our grandfather decided to manufacture "healthy cookware" made from porcelain enamel.

If you think this is no longer a problem today, think again. Pots and pans are still potential sources of toxins. We are committed to cookware that is free of any harmful substances and which promotes health.

Nowadays our responsibility extends even further: we are committed to energy-saving and safe cooking. We help our customers to use our quality products so that the products have a long life. We address individual customer's wishes – we put the customer first. We also don't give in to management methods that try to tell us differently.

Positive balance for nature and the climate

Our first source of energy was coal from the nearby mountain. Our grandfathers, Josef, Julian and Leopold Riess, realised that this fossil fuel is a finite resource and what would we do when it ran out? They also did not want to accept the film of soot that covered everything. This is why the first hydroelectric power station was constructed in 1926 and henceforth all the machinery operated using inexhaustible, clean electricity.

Julian Riess also realised that if he built a dam for his power station, the fish would no longer be able to reach their spawning grounds and then how would he be able to fish next year? He thus used spare material to construct one of Austria's first fish ladders.

Today we are the only cookware manufacturer whose production shows a positive CO₂ balance. Our plant operates using electricity from our own hydroelectric plants. We generate more electricity than we need and feed it into the networks as green energy.

Any impact on nature complies with agreed levels and we significantly undercut threshold values. We support the surrounding natural world and use the resources that nature has given us!

Family business

As a traditional business located on the Eisenstrasse, or Iron Road, in Lower Austria, our family has been part and parcel of this region for generations. Our employees have always been drawn from the surrounding villages. We are a big family business in two senses: our business has been passed down through the family for generations and is managed today by the ninth generation. We also regard us and our employees as one big family. We live and die by our reputation as a good employer. This is why our employees' health and satisfaction also matter to us.

Our customers are not the only people to whom we offer tailored solutions. The same applies to the people we work with on a day-to-day basis.

Managing with what there is

When our forefathers were faced with the decision whether or not to invest in a production for enamel products, they sold land that had long been owned by the family. They did not want to incur debts; they had to manage with what financial resources they had. Their guiding principle was – total independence!

We still adhere to this principle today. We think long term. We also apply this long-term point of view to our annual profits. We grow cautiously. Even if we had the short-term opportunity to expand capacity, we would refuse if we could not guarantee long-term utilization.

Not only is longevity important where our products are concerned, but also our tried-and-tested machinery. We avoid waste as materials and energy are precious.



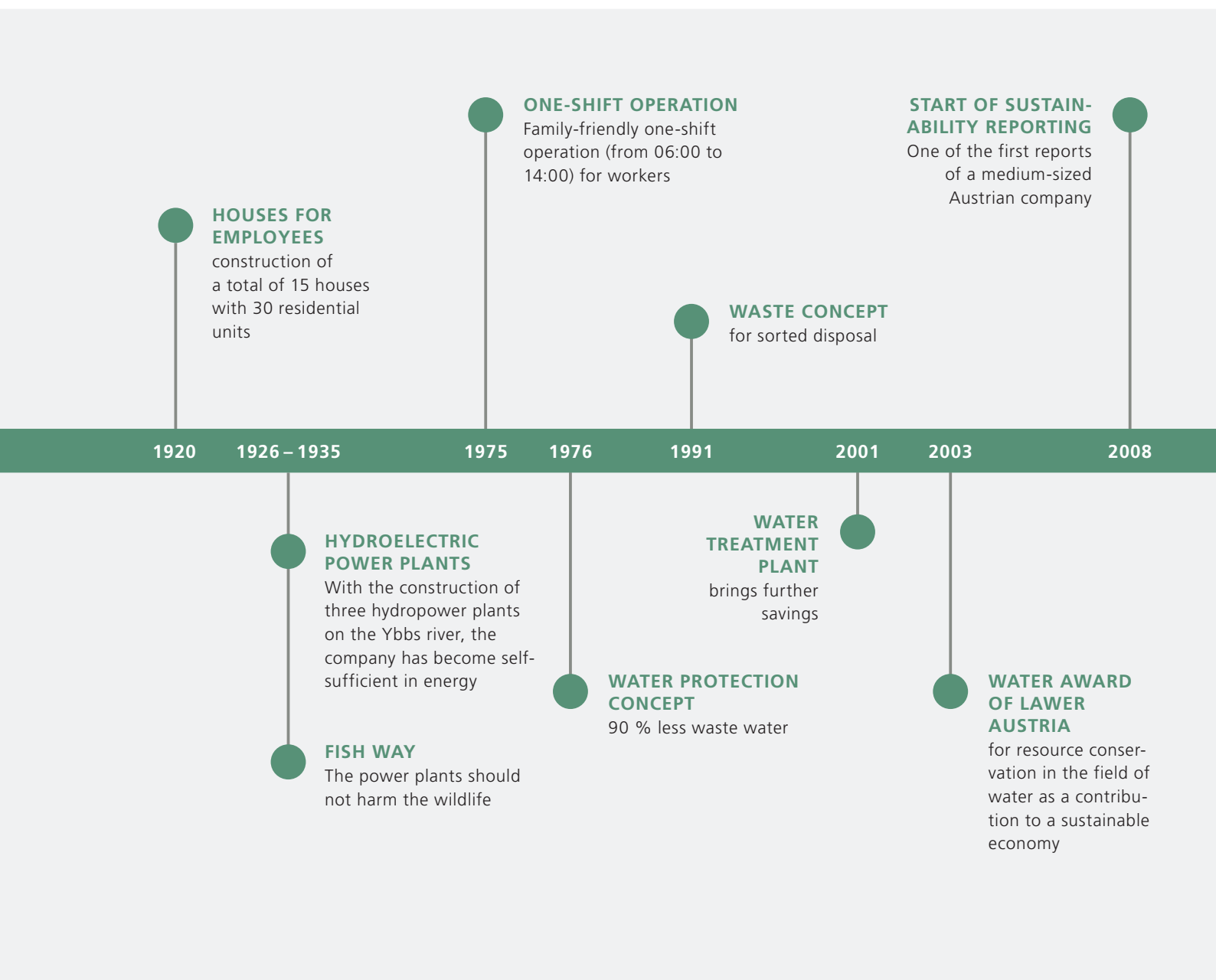
MILESTONES OF OUR SUSTAINABLE DEVELOPMENT

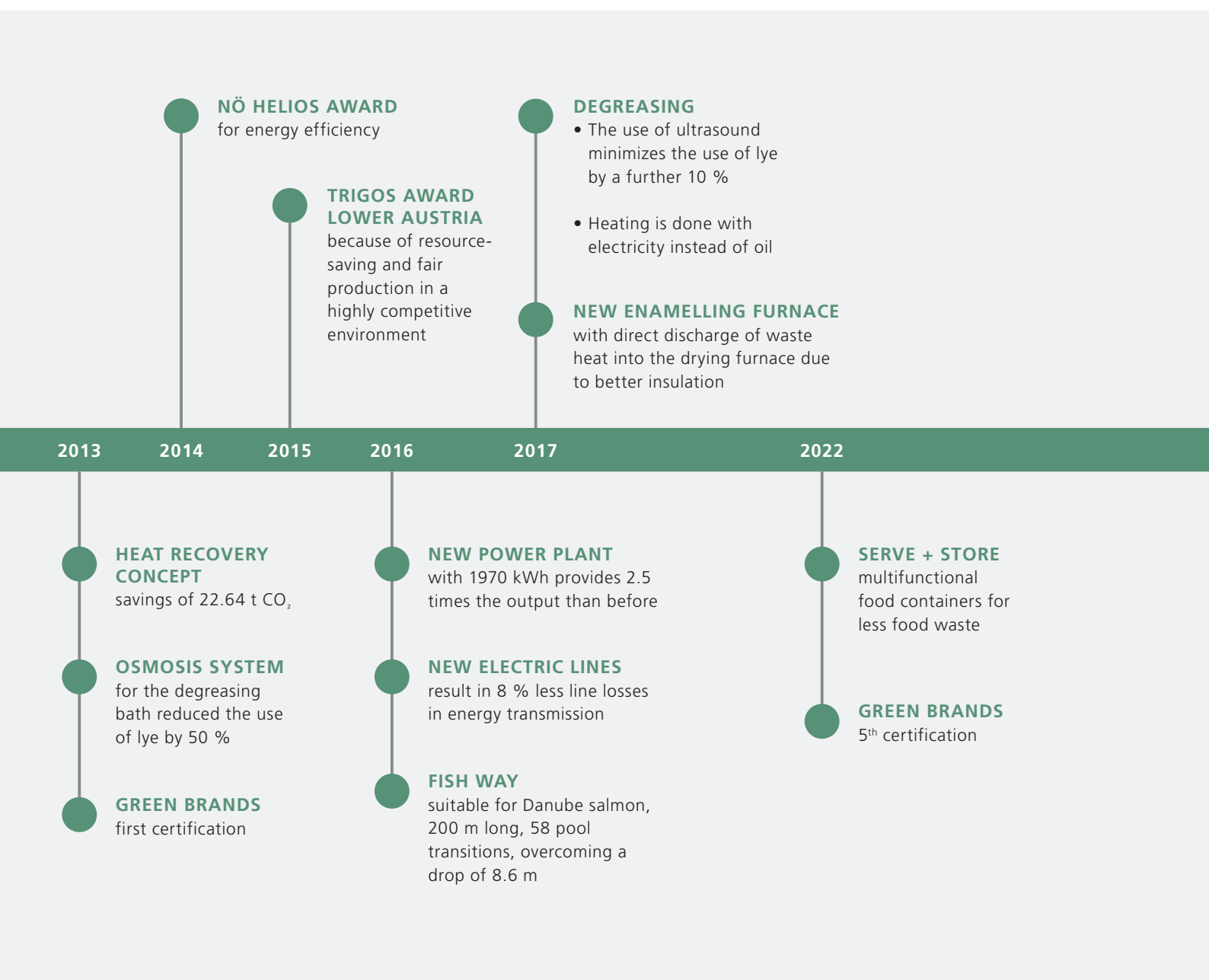
„Acting sustainably for people and the environment was modeled for us by our grandfathers. We want to pass this on as well.“

Friedrich Riess

In the 100 years that enamelling has been carried out in Ybbsitz, the philosophy was from the begin-

ning to produce self-sufficiently in terms of energy and resource-saving. Environment and people were and are an important concern for the entrepreneurial family. All process steps of the production are continuously examined and improved with regard to resources and energy consumption.





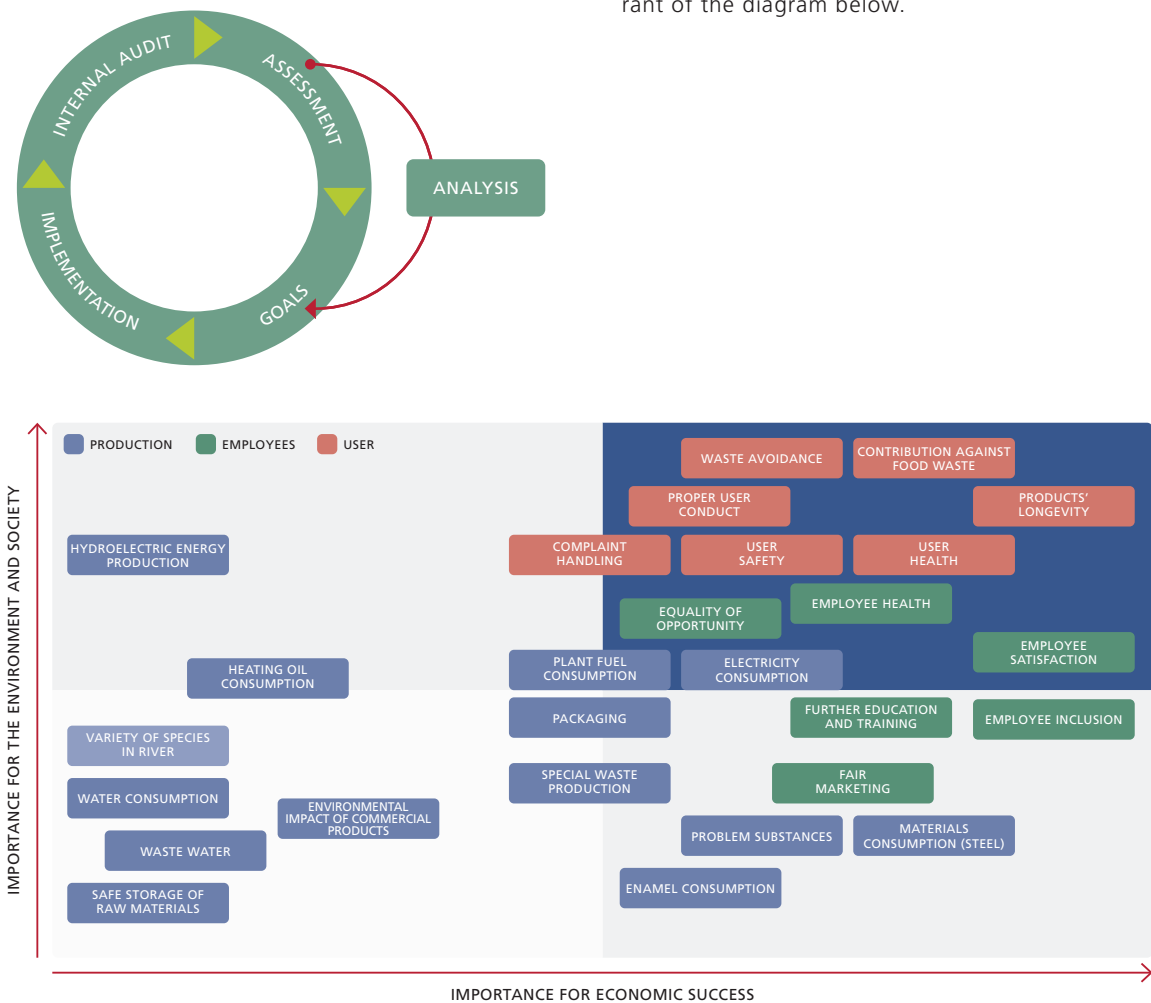
CORPORATE POLICY

WE OPERATE IN HARMONY WITH OUR SURROUNDINGS

“Our philosophy is ecological vision, a sustainable approach and social responsibility.” Julian Riess

The company uses the ONR 192500 sustainability management system to embed its centuries-old, sustainable corporate management in its processes. Sustainability management follows the circuit shown in the diagram.

In addition to general principles of social responsibility, the company has defined all the specific sustainability issues that are important to it. The starting point is annual collection of data and analysis of sustainability indicators. Particular attention is paid, as part of sustainability management, to the issues shown in the upper right quadrant of the diagram below.



WE REALISE THAT PEOPLE MAKE THE DIFFERENCE

"Clearly defined responsibilities and a good age mix foster team spirit and healthy competition."

Susanne Rieß

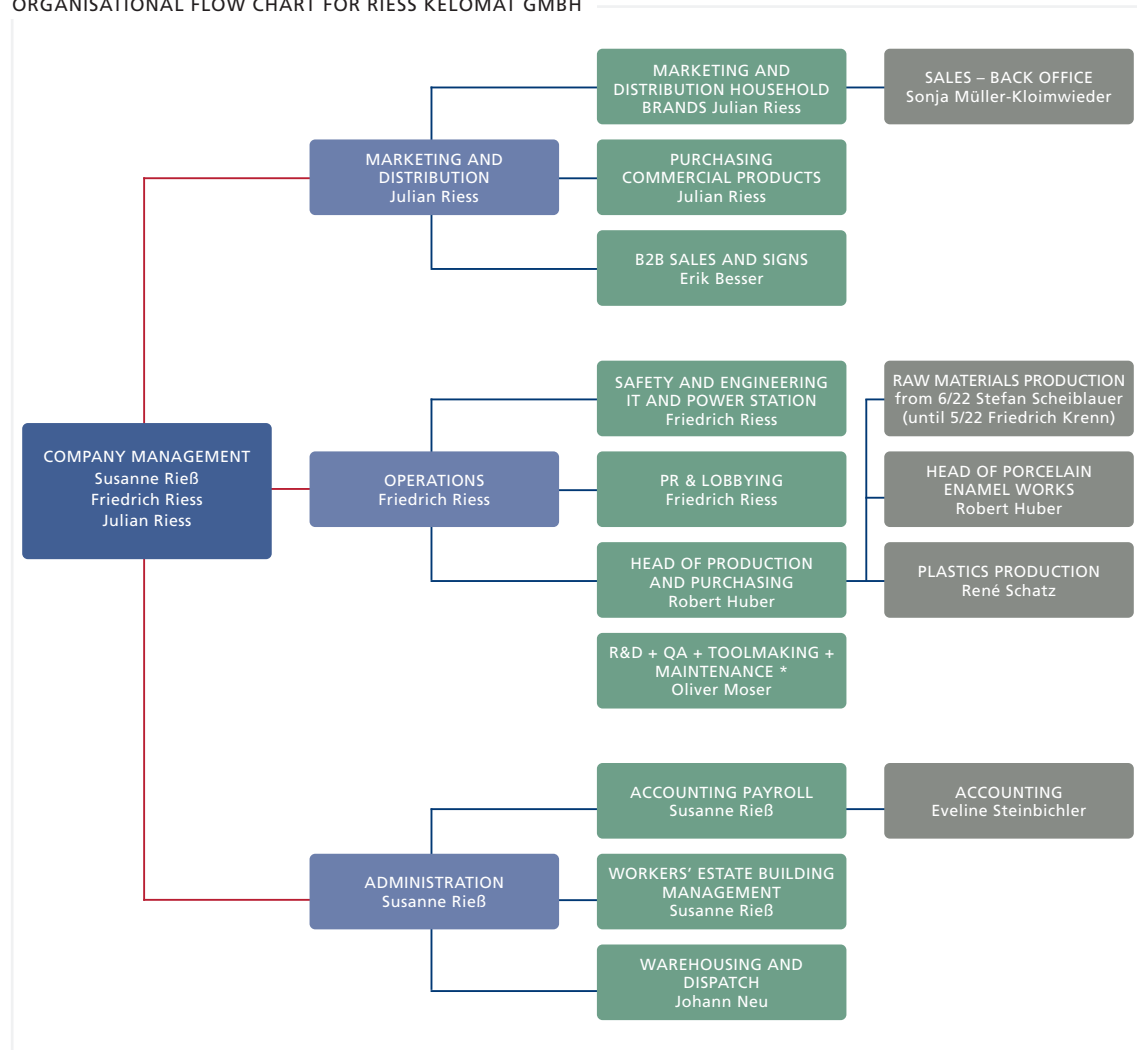
RIESS KELOMAT GmbH is 100 % family-owned and is managed by the ninth generation – Friedrich Riess, Julian Riess and Susanne Rieß. There is clear separation of roles, although important decisions are always taken jointly.

Friedrich Riess is responsible for Technology and Production, Julian Riess is in charge of Sales and Marketing and Susanne Rieß handles Finance and Human Resources. The management is supported by a team of specialists, some of whom have been with the company for a very long time and who trained here.

At the same time apprenticeships, which the firm heavily promotes, ensure a good age mix. (<25 years: 12.2 %, 25–34 years: 17.3 %, 35–44 years: 21.2 %, 45–54 years: 29.5 %, 55+ years: 19.9 %).

For 11 years now, the average length of service of our staff has remained at a stable 10.7 years, whilst at the same time the age structure is very well balanced.

ORGANISATIONAL FLOW CHART FOR RIESS KELOMAT GMBH



* research & development + quality control + toolmaking + maintenance

WE HAVE THREE MAINSTAYS AND BELIEVE IN QUALITY

“Over the years three business divisions have developed out of the various characteristics of porcelain enamel and our know-how in metal processing and enamelling.”

Julian Riess

The company's core expertise lies in production of thermoformed, pressed and pressure-formed metal items, injection-moulded plastic items and, above all, surface finishing with porcelain enamel. As a composite material porcelain enamel – glass on iron – has many wonderful properties.

It can be used anywhere that extreme heat stability, UV resistance, abrasion resistance, and smooth, anti-bacterial surfaces are required. The company's extensive experience of enamelling has resulted in a range of products and services offered by the following three separate areas of business.



HOMEWARES

We are Austria's only cookware manufacturer and enameller. In addition to the RIESS brand produced in Ybbsitz, the Austrian KELOMAT brand has also been part of our kitchenware and cookery range since 2005.

Our comprehensive product range is complemented by some distributed brands.

www.riess.at
www.kelomat.at



PORCELAIN ENAMEL SIGNS

We manufacture porcelain enamel house numbers, advertising boards and road and information signs. Our signs can be found on streets in Vienna, Graz, Klagenfurt and Trieste, and at Frankfurt Airport.

The signs were enamelled at our factory and then screen-printed with images and lettering.

www.riesskelomat.at
www.emailschilder.co.at



INDUSTRIAL COMPONENTS

In the B2B sector we create innovative solutions for industrial customers in small and medium series in the field of metal forming and enamelling.

Modern deep-drawing machines produce steel, stainless steel and aluminium into shape.

We produce custom made products with a glossy enamel surface such as cooker parts, lampshades, sanitary ware, water reservoirs, wall cladding and much more.

www.riesskelomat.at

THE RIESS BRAND

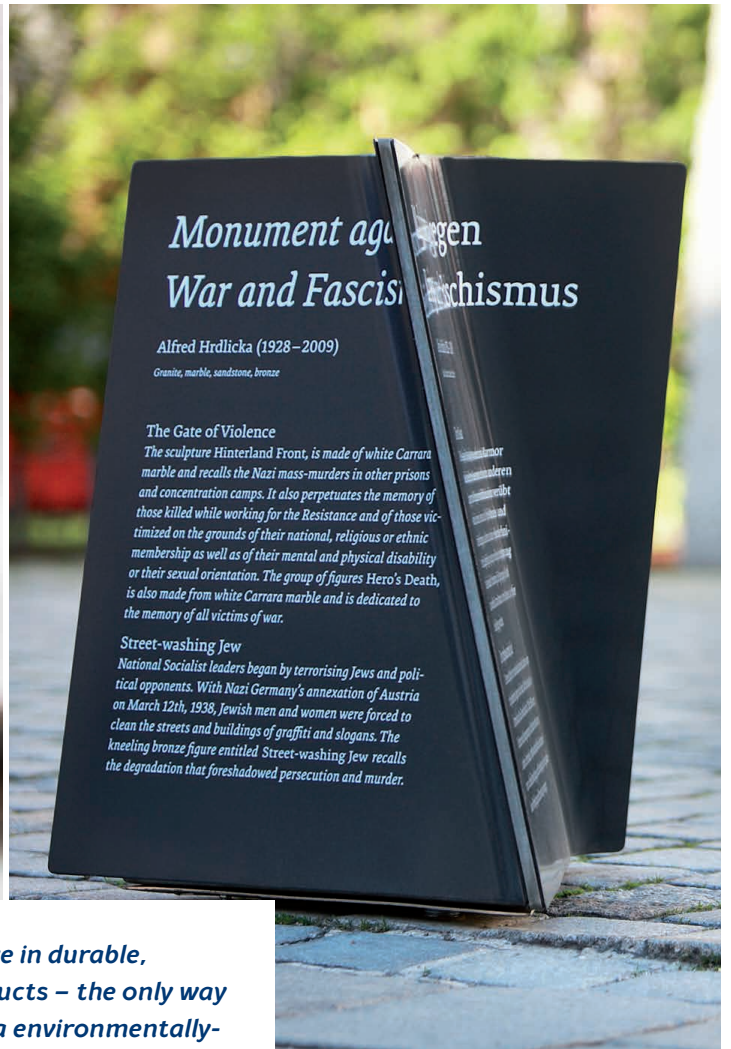
has been synonymous with premium quality, handmade porcelain enamel cookware from Austria, and for enamel signs and custom-made articles since 1922. Well trained employees and high quality raw materials ensure a premium finish and extreme durability.

All products meet the highest performance standards, and are certified by the European Enamel Authority and Green Brands.

THE KELOMAT BRAND

is the leading Austrian brand for high-quality stainless steel cookware and kitchen equipment. KELOMAT is known for its classic pressure cooker with safety valve, which enables speedy, energy-saving, healthy steam cooking.

KELOMAT is known for a wide range of stainless steel pots and pans, with or without the KELOMAT quality, non-stick, scratch resistant-surface and a complete range of kitchen utensils.



***“We believe in durable,
high quality products – the only way
for us to supply an environmentally-
friendly product that will give
pleasure for a long time.”***

Friedrich Riess



SUSTAINABLE GROWTH

WE ARE INDEPENDENT AND BELIEVE IN TAKING THINGS ONE STEP AT A TIME

"Porcelain enamel is enjoying a renaissance, from which we are benefiting. We're pleased, but we won't let it make us arrogant."

Julian Riess

As far as RIESS KELOMAT is concerned, long-term success means organic growth and market focus.

Innovation is an important factor for growth, together with historic products. New ideas are jointly developed using regular feedback of customers, field staff and designers and subsequently launched on the market.

In the 2021 financial year the company sold approximately 822,933 sales units of enamel cooking ware.

A total of 60 % of annual turnover can be attributed to porcelain enamel products, 35 % to KELOMAT cookware and 5 % to commercial goods and kitchen accessories. Germany is the most important export market. We export to a total of 37 countries.

In addition to Europe, the USA and, in recent years China, Korea and Australia, are important markets for enamel cookware.

We raised the awareness of our brand as well as our POS presence in Austria and with our neighbours in Germany, Italy, Slovenia and Switzerland. And we steadily increased our export rate to 33 %.

Sustainable expansion of our exports of RIESS brand cookware with the help of new sales partnerships.

WE LISTEN TO OUR CUSTOMERS AND ADAPT TO THEIR NEEDS

"We have swum against the tide. Instead of optimizing our range, we have listened to our customers and banked on a diverse range. Our customers love it."

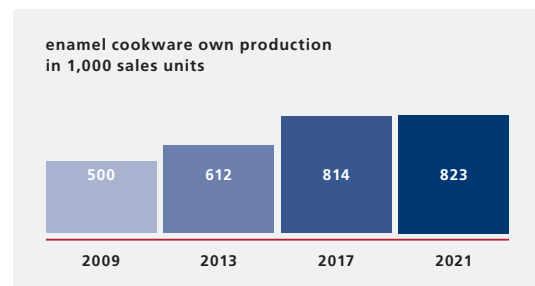
Friedrich Riess

In addition to quality work, a high level of flexibility and speed of supply are declared corporate aims.

Approximately 600 moulds guarantee that we can respond very flexibly to customer requirements. We manufacture special, one-off requests in addition to small-scale production runs. All 1,000 products are available to customers ex stock.

Goods are put together per order and delivered "just in time". Depending on the quantity ordered, goods are dispatched either by parcel service or freight forwarders.

In our logistics process we aim to minimise staffing levels and wasted journeys thus saving working time and using energy and fuel in a "resource-friendly" way.



TEN GOOD REASONS TO USE RIESS
PORCELAIN ENAMEL IN THE KITCHEN:

1. CO₂neutral – and made in Austria
2. suitable for induction and all types of cooker
3. scratch-resistant
4. easy to clean and antibacterial
5. perfect for healthier and energy-saving cooking
6. odour neutral
7. heat-resistant till 450°
8. durable if treated properly
9. available in a wide variety of colours and designs
10. recyclable into scrap metal



"Porcelain enamel is nothing more than glass on iron, permanently fused together in the kiln."

Friedrich Riess



ENVIRONMENT FRIENDLY PRODUCTION

WE NEED IRON, GLASS, WATER AND VERY
LITTLE ELSE

*"If new developments aren't in keeping
with our sustainable working methods,
we start to think out of the box."*

Friedrich Riess

Technically speaking, porcelain enamel is the term for a composite material made from glass and iron. Glass is melted and anorganically fused with the metal substrate in the kiln.

Production in our manufacture doesn't generate any CO₂, because we use our own hydroelectric power plants. The entire value creation chain is geared to saving resources and is continually optimised; this is ensured by a proprietary environmental programme.

Iron: from rough sheet steel to saucepan



The rough, high-quality steel sheets are transported by rail from Voest Alpine AG in Linz to Gresten near Ybbsitz. The raw material is temporarily stored here and cut to the required widths as necessary, before being rolled into coils. This optimises use of the sheet metal and minimises waste during cutting.

The coils are delivered to Ybbsitz via a regional forwarding agent, where they are cut into the basic shapes, the circles for pans and lids, or stamped and moulded direct into the desired shape using the deep drawing press. The pan rim is then moulded and the handles are mounted.

Only minimal offcuts are produced thanks to optimised sheet use, and these offcuts are returned to the raw materials cycle. As production uses the cold-forming technique (no heat), this saves energy and reduces the environmental impact.

New Investment 2021



In 2021, the Dunkes 250 t thermoforming press was installed. The modern parameter management enables easier and faster setup. Deep drawing is more sensitive and forms thin sheets more precisely, despite 50 tons more press force. Connections for future automation are included. The best safety technology protects employees

The resulting blanks are degreased in an alkaline bath, so that the glass coating can perfectly fuse with the metal in the kiln. This is the final step before enamelling.

Glass: a durable, natural surface

By individually tailoring the composition of the enamel slip it is possible to produce almost any shade of colour. The glassy coating, called porcelain enamel, consists of glass, potash and metal oxides. The various raw materials are mixed and melted at temperatures of 1,000 °C to 1,200 °C in the kiln. The liquid enamel mass is then set and broken into flakes (granules) or frits. At the enamel factory the granules or frits are finely milled and combined with the pigments. Water is the only suspension medium used.

Porcelain enamel: two become one

Now it is time for the enamelling process. The iron moulds are coated inside and out with the enamel slip, dried and fired in the kiln. When the temperature reaches around 850 °C, the iron moulds and the layer of glass fuse. They are then immersed in the chosen colour of enamel dross, dried and fired again in the kiln.

WE USE OUR RESOURCES CAREFULLY

"Since 2013, Riess Kelomat has been undergoing our strict certification process for the company and products with excellent results. Since then, there have been four recertifications, which – starting from a very level – continued to show improvements in all in all categories. The high priority ecological criteria in the company and the products of the products was thus proven several times."

Norbert R. Lux, Managing Director / CEO
GREEN BRANDS Organization

Waste management

In line with the precautionary principle and sustainability, waste management is focused to avoiding harmful or adverse effects on humans, animals and plants, their source of live and their natural environment.

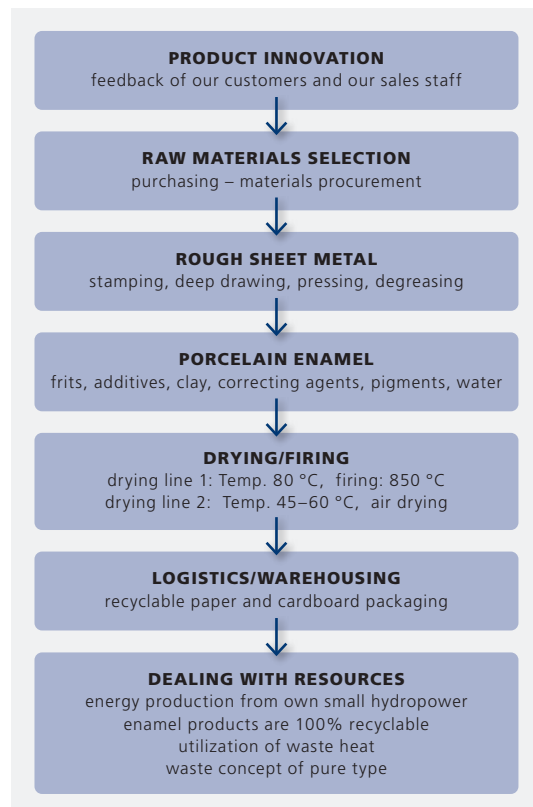
The waste management concept is not a one-off state recording with punctual measures, but the first link in a chain of improvements. All waste, including any iron and sheet steel offcuts, is collected separately and recycled by a licensed company.

Iron and sheet metal cuttings are collected separately and recycled by an authorised company.

Along with iron, **enamel slip** is one of the waste products of production. The enamel slip not used in production (approx. 30 %) is collected, processed and largely returned to production. Soiled enamel that cannot be reprocessed is filtered and dried and then taken over by a disposal company.

The enamel application machines with article-specific programme control optimise the application of enamel and ensure minimum residual quantities of slip. Spraying robots also help to optimise the residual amount of enamel slip and reduce CO₂ emissions at the same time.

FROM PRODUCT IDEA TO FINISHED PRODUCT – WITH THE FOCUS ON SAVING RESOURCES



Water is also used carefully. The water that runs off is treated and fed back into the production process. In order to save resources, the water used is reused several times.

Oils, acids and alkalis – necessary for degreasing the blanks – are handled with care and efforts are constantly made to minimise their production and energy consumption.

The use of ultrasound has reduced the amount of lye used by about 10 %.

By changing the degreasing baths to purely electric heating (previously a carrier oil system), the basins are heated with clean electrical energy and CO₂ is saved.

Two drying chambers dry the degreased goods with little energy.

Oils, acids and alkalis are stored in drums or plastic containers which are placed on collecting trays. These are made of sheet steel and are acid and oil resistant.

Heat recovery

The firing process is the most energy-intensive step in the production process. Over the years, a sophisticated system has been developed for the optimal use of energy with the aim of reusing as much of the waste heat as possible.

Enamel is melted in a so-called reverse enamelling furnace. This means that fired products are removed at the same time as those to be fired are brought in (heat exchanger principle). This prevents unnecessary heat from escaping. During the firing process at approx. 850 °C in the kiln, the heat generated is used threefold:

- to fire the porcelain enamel products in the kiln at 850 °C
- to dry the goods in the drying kiln at between 45 and 80 °C (after the enamel dross has been applied)
- to heat the production hall

To exploit this plant's maximum output, it is operated on a shift rota as part of an optimised working time model.

SHIFT 1: The products to be fired are dried in the firing kiln (temperature approx. 80 °C) and then fired. The excess heat from the firing kiln is used to heat the drying kiln.

SHIFT 2: Any exhaust gases from the drying kiln during Shift 1 are now used for the second, slower drying line. During this drying process the goods are suspended just below the production hall roof on conveyor belts and dried with the exhaust gases from the drying kiln. Depending on the time of year the temperature beneath the roof is 45-60 °C.

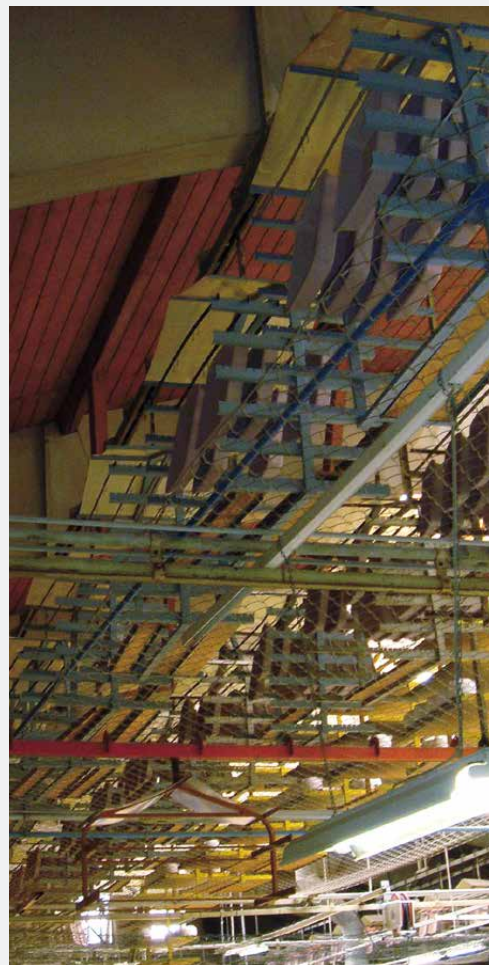
Thanks to improved heat recovery, we have saved 27.64 tons of CO₂ per year since 2013.

In 2017, the enamelling furnace was completely renovated. In addition to a 20 % increase in capacity, this also resulted in an increase in energy efficiency. The higher waste heat means more residual heat in the drying oven and a better indoor climate in the production hall.

GENERAL RENOVATION OF THE ENAMELLING FURNACE



FOLLOWING APPLICATION OF THE ENAMEL, THE PRODUCTS ARE DRIED IN THE VERY WARM AIR UNDER THE ROOF.





"We aim to avoid any waste."
Friedrich Riess



WE BORROW WATER AND USE IT CAREFULLY

„Water helps us produce electricity and our goods without harming the environment. Safeguarding this resource for future generations is a matter of course for us.“ Friedrich Riess

Water – for CO₂-neutral production

At RIESS KELOMAT GmbH, water is mostly used to generate electricity. This ensures carbon-neutral production of enamel cookware, industrial components and signs.

Between 1926 and 1935, the grandfathers of the current owners of the company built three hydro-electric power plants at the site in Ybbsitz, which were placed along the big and the small branch of the river Ybbs. They replaced the old coal-fired furnaces, which burdened the environment with their soot and exhaust emissions, with emission-free electric enamelling furnaces. This immediately made them independent of non-sustainable fossil fuels. As a further benefit, the energy generated in the hydro-electric power plants is renewable and almost CO₂-free.



In order to secure power supply from the company's own power plants for the future, an additional power plant, Gaissulz, was built in 2016 with a maximum capacity of 1,193 KWh. It was built on the dam of an already existing power plant at the „Grosse Ybbs“ – which again was an environmentally-friendly solution.

The overhead lines from the power plant to the production building were replaced by new 20 kVA underground cables which reduce power losses in transmission by 8 %.

Renovating the small power plant at the „kleine Ybbs“ inside the company building in order to boost its efficiency by 10 %.

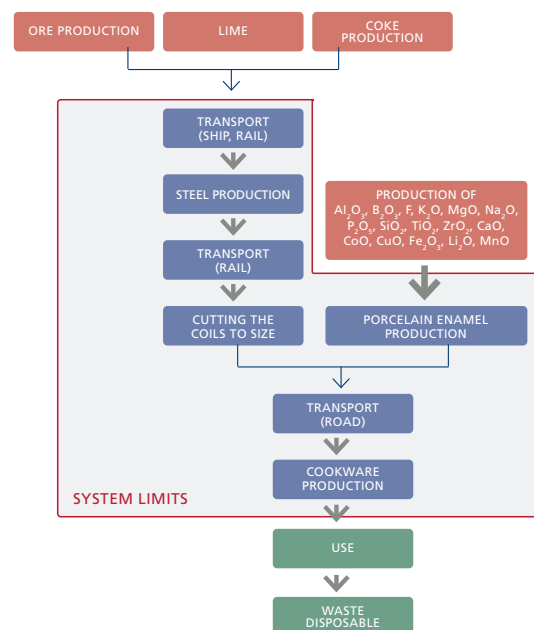
CARBON FOOTPRINT INVESTIGATION 2014 / WIENER NEUSTADT UNIVERSITY OF APPLIED SCIENCES, CAMPUS WIESELBURG NACH ISO 14044

Both the emissions and the environmental impact caused by transporting the base materials, producing the enamel and steel and creating the finished product were analysed. The steps in the pre-production chain outside the defined system boundary were not considered, as there was no sufficiently reliable data available.

The following three points were found to be most significant for carbon-neutral production:

1. The surplus green power generated in the hydro-electric power plants fed into the public grid
2. The small amount of waste water (23 % of the input)
3. The high portion of metal recycled (35 % of the input)

EXAMINED PROCESS STEPS (SYSTEM LIMITS)



FACTS HYDROPOWER PLANT:

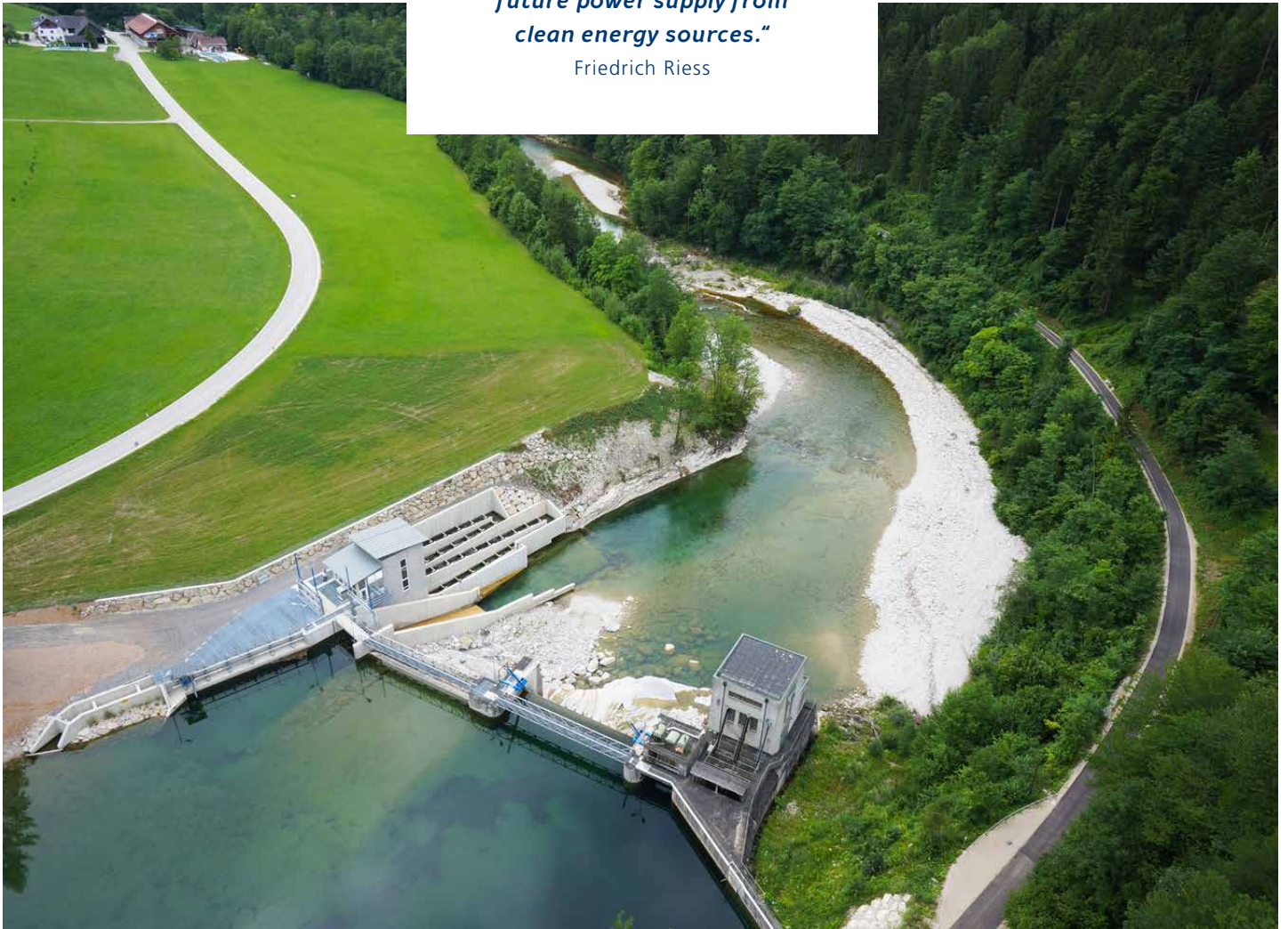
| | |
|--------------------------|-----------------------|
| Kaplan turbine | 94% efficiency |
| total output | 1970 kWh |
| energy output | 9,2 mio. kWh per year |
| CO ₂ -savings | 11,327 t per year |

2/3 of the energy produced is fed into
the fed into the public grid
= green electricity for 2,000 households



*„With our new power plant,
we have made provisions for
future power supply from
clean energy sources.“*

Friedrich Riess



Water – habitat for fish and small animals

In order to ensure that fish could reach their spawning areas, the grandfathers of the current owners already **installed a fish ladder on their own initiative** when they built the power plants at the „Große Ybbs“ **in the 1920s and 30s**. Since 2005 there has been an improved fish ladder at the “Kleine Ybbs”, with 15 natural-looking pools measuring two to four metres in diameter and up to one metre in depth.

As part of the construction of the new power plant, a new fishway was installed in 2016, which in practice means an energy loss of approximately 200,000 kW/year (400 litres/second). Due to the limited space available the construction proved to be complicated and challenging, so that an investment of almost one million euros was needed.

A 200 m long vertical-slot fishway with a 3 m x 2 m x 1.2 m tank was installed which is suitable for Danube salmon. A total of 58 slots allow the fish to overcome a height difference of 8.6 m over a distance of 167 m. The required design flow rate for the fishway is 400 l/s.

Water – for cooling and rinsing

Water for the plant comes from our springs and aquifers. The water is primarily used as a coolant and for rinsing and is used several times. Cooling uses most of the water. **The company adopted a sustainable water conservation concept very early on, which has resulted in water savings of 90 % since 1976.**

RIESS KELOMAT's waste water statistics for production are far below the official maximum limits. **By integrating a water treatment plant in 2001, we further reduced volumes of waste water.** The waste water is filtered and recycled as rinsing water. In 2003 the company was awarded the province of Lower Austria's water conservation prize for its activities in this field.

The importance of fishways



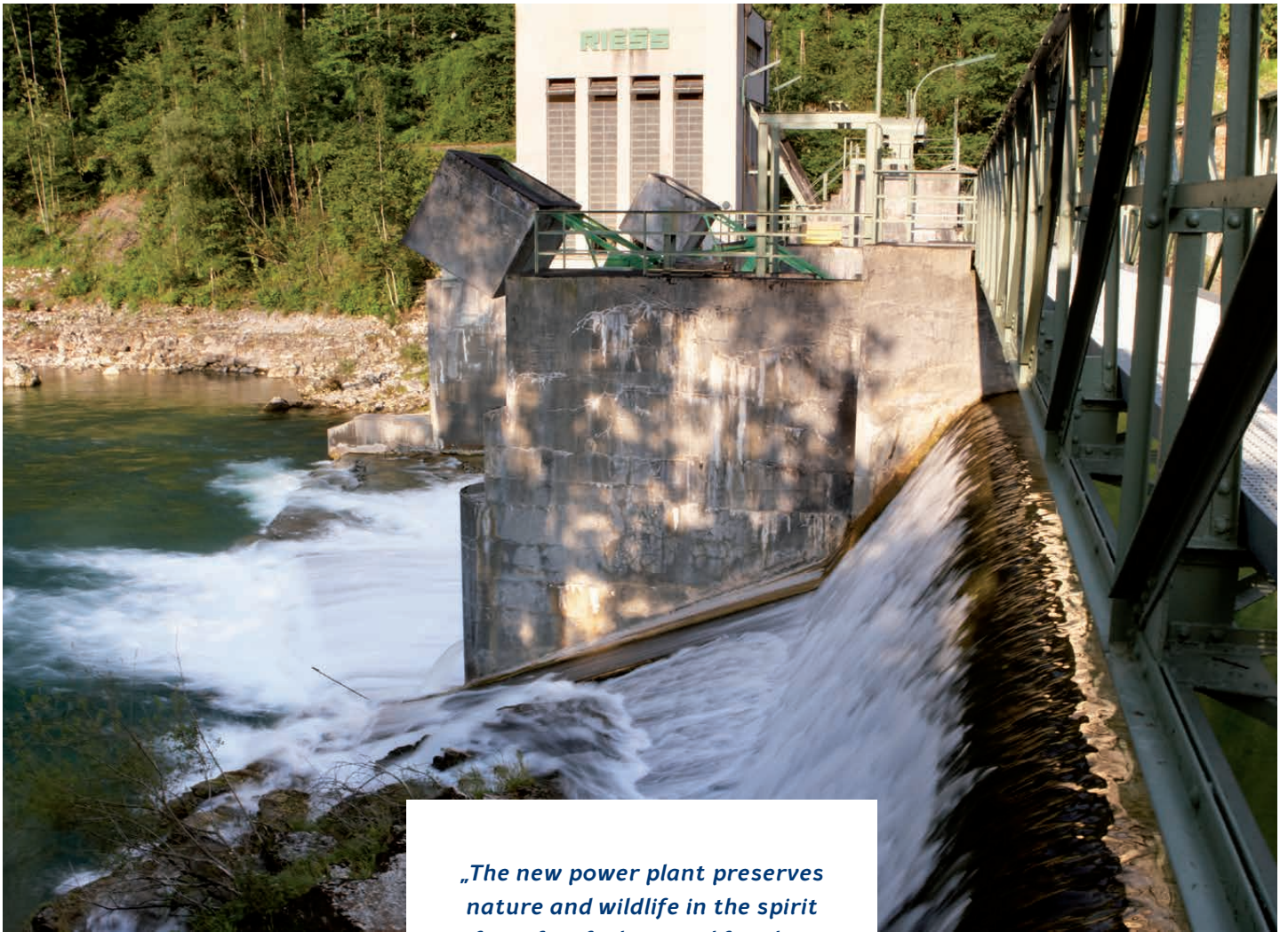
The fish ladder at the „Kleine Ybbs“

Fish often migrate over many kilometres in natural bodies of water in order to reach suitable spawning grounds or habitats. If they are confronted with impassable barriers, individual fish species or whole communities of fish might disappear as a consequence.

The river Ybbs is in fact located in the grayling zone. The main species in this zone are grayling, brown trout and bullhead. Other typical companion species are burbot, chub, barbel, minnow, Danube salmon and nase. According to the EU water framework directive, the species which should determine the dimensions of the fishway is the Danube salmon, with a length of 80 cm.

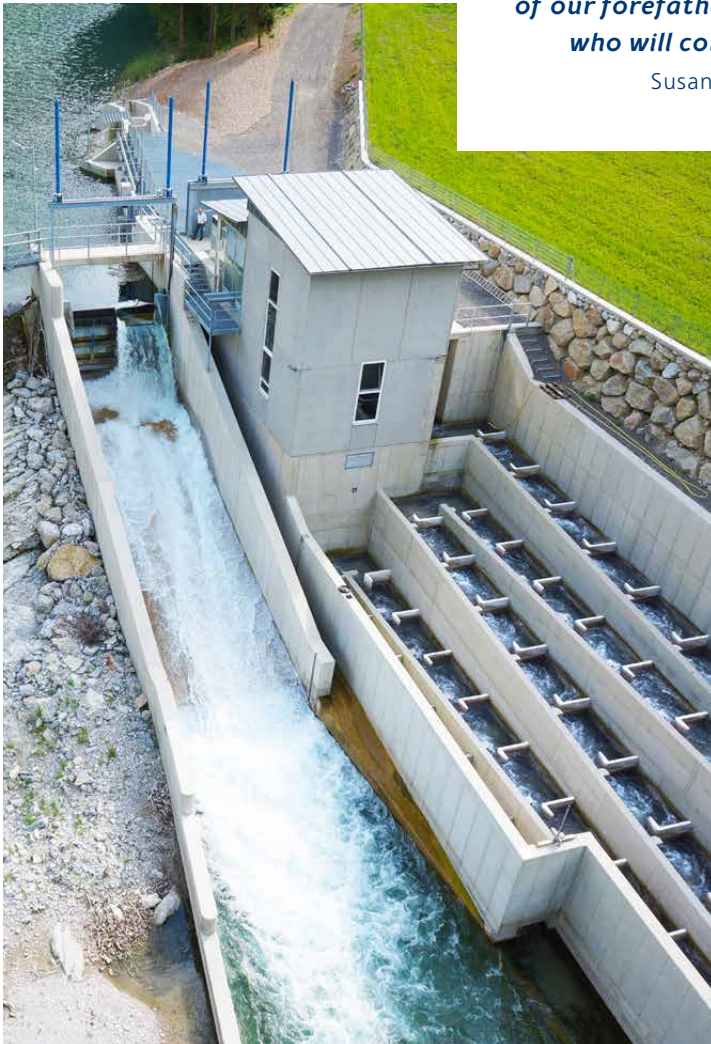


The new fishway at the at the „Große Ybbs“



*„The new power plant preserves
nature and wildlife in the spirit
of our forefathers and for those
who will come after us.“*

Susanne RieB



PRODUCT SUSTAINABILITY PROFILE

WE ARE CONVINCED THAT PORCELAIN
ENAMEL IS A SUSTAINABLE MATERIAL

“We are not only proud of our product quality, but above all that we manufacture in harmony with nature.” Friedrich Riess

Multiple favourable properties

Porcelain enamel combines the favourable properties of metal with those of glass. It is not only used for household items, but also in the engineering and construction fields. Enamelled surfaces exhibit the abrasion-resistance that is typical of glass and are extremely durable, abrasion-, corrosion-, weathering and heat-resistant.

Further to these properties, porcelain enamel is antibacterial, flavour preserving and suitable for people with Nickel allergy. The surfaces stay smooth and retain their bright colours even after many years of use. Riess's high-quality porcelain enamel products comply with applicable European standards with regard to their resistance to acids and alkalis.

Thanks to its excellent heat transfer and retention properties, using enamel cookware requires less cooking energy. Because of their iron core, enamel pots and pans also work on modern induction hobs.

Enamel has always been used not only for cooking, frying and baking, but also for aroma-preserving and hygienic storage.

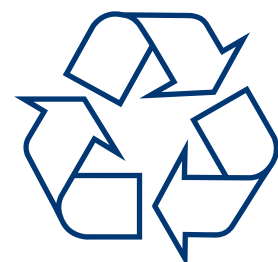
As little – recyclable – packaging as possible

We also minimise use of resources where packaging is concerned. We exclusively use fully recyclable paper and cardboard. A high proportion of products are purposefully supplied without surrounding cardboard. The majority are simply wrapped in tissue paper to protect against dust. The only exceptions are large products such as sets of saucepans and large baking and roasting tins.

In 2011 the company was awarded the “Embalissimo” packaging prize for Aromapot packaging. The Austrian Packaging Association considered the product presentation for KELOMAT kitchen utensils, using a hanging tab, to be an exemplary packaging solution and conferred on it the “Vorbildliche Verpackung 2012” award.

Easily recyclable end product

Porcelain enamel products are easy and cheap to recycle. Used products are returned to the materials cycle via the metal recycling system. The metal in the products can be almost infinitely recycled. Porcelain enamel does not contain chlorine and is inflammable, which is why the production process and recycling do not release toxic emissions. During the melting process porcelain enamel helps to form the necessary slag in the furnace.





*„Enamel is a beautiful,
aesthetic material,
the favourite pieces can still be
passed on to the grandchildren.“*

Sarah Wiener



WE ARE HAPPY TO PASS ON OUR KNOWLEDGE OF PORCELAIN ENAMEL

"We frequently realise that with the knowledge about the material, consumer can take even more advantage of their kitchenware."

Friedrich Riess

Many people still know very little about porcelain enamel as a material. Education about the material, proper cleaning and care, energy-saving, safe and healthy cooking as well as hygienic, aroma-neutral storage is provided via training, publications, web and media work. With every item purchased, consumers receive detailed information about porcelain enamel and instructions on how to use it safely. It is very easy for customers to contact the company with questions and complaints. The company also provides information via the Internet, in the press and publications, and through PR.

Web

Information about the RIESS and KELOMAT brands is provided in a user-friendly manner on the web-sites riess.at, kelomat.at.

Videos

Learning videos about enamel as a material and about energy-saving use of enamel pans ("The 5 golden pan rules").

Information material

Our publication "The pan manual" (only available in German as "Pfannenfibel") is available at the POS in order to provide customer information about energy-saving use of enamel pans and healthy cooking.

The "World of learning" (available in German as "Lernwelt") was developed as a training and reference book for better customer service at the POS.

Customer dialogue

Uncomplicated customer contact through more presence on the social media platforms facebook, instagram and youtube or via e-mail.

Guided tours

RIESS offers guided tours of the traditional enamel manufacture. The production facilities are accessible and we are a partner of the German Red Cross in their "assisted travel" scheme.

WE BELIEVE IN THE POWER OF GOOD DESIGN

"Good design lasts; many of our product designs are successful in the market since decades."

Julian Riess

Artists and designers value porcelain enamel as a material, the high-quality production and the company's receptiveness to experimental work.

Long design tradition



Carl Auböck, the father of industrial design in Austria, designed striped spherical pots made of enamel in the 1960s and 1970s.

British star designer Tom Dixon and Californian pop artist Mel Ramos had work done at the enamel manufactory.

The VIENNA DESIGNWEEK has chosen RIESS as a partner company several times. The Viennese designer duo "Polka" as well as the UK designer Oscar Wanless came to Ybbsitz and were inspired by the material.

Current product design

"Democratic design for the pot – beautiful, functional cookware for every household." Since 2008, the Viennese design studio dottings, Sofia Podreka and Katrin Radanitsch, has designed three product lines under the RIESS truehomeware brand. In 2013, a series of two-tone bakeware was created in collaboration with celebrity chef Sarah Wiener, followed by the retro series Giants and Dwarfs in 2015. In 2022, the Serve + Store storage containers followed, which received the Red Dot Design Award 2022.

Rethinking storage

With its products, the company also wants to make sustainable behavior easier in everyday life. Serve + Store storage containers are a contribution against food waste and disposable packaging. In the design, emphasis was also placed on multifunctionality. The result is kitchen basics for order in the kitchen and refrigerator, stylish serving and much more. The lids serve vice versa as trays and plates, the base as a storage box or small baking dish.



*„From the fridge into the oven or
straight onto the table.
Without complicated decanting
or packaging, we save handles,
space and our energy.”*
Katrin Radanitsch, dottings



reddot winner 2022



EMPLOYEES

WHAT WE DO IS DETERMINED BY OUR FOCUS ON PEOPLE

“Throughout our business’s history we have never paid mere lip service to social commitment and a work-life balance.”

Susanne Rieß

Company housing

The houses date from the 1930s, when the company experienced a sharp decline in production due to the economic crisis. In order to avoid making employees redundant, RIESS had its employees construct 15 houses, divided into a total of 30 flats, on a nearby plot of land. Employees lived free of charge in the flats and were able to grow vegetables in the gardens.

Eleven of the original 15 houses still exist. Nowadays these flats are let to employees on reasonable terms. The apartments can be occupied until the employees have built or purchased their own homes.

Family-friendly working hours

At the request of employees, RIESS KELOMAT GmbH switched from standard working hours to shifts. The majority of employees work in the early shift (6.00 am to 14.00 pm), which allows for an excellent work-family-life balance.

Accessibility of the workplace

Over three quarters of our staff live in the neighbouring communities of Ybbsitz, Waidhofen/Ybbs and Opponitz and some of them also manage a farm as a second source of income, so they appreciate our flexible working hours.

Since the public transport connection to the site is not ideal, most travel to work in their own cars. We offer parking spaces in order to make it easier for our staff to get to work quickly. An electric filling station is also located on the company premises.

Safety and healthcare

“RIESS KELOMAT is one of the safest places I have ever worked.”

Ing. Mag. Ulrich Schörghofer, Safety Centre

Safety is paramount at RIESS KELOMAT GmbH. The workforce receives regular training on the latest safety regulations relating to handling acids and alkalis or operating machinery. The safety of all plant and equipment is regularly checked by a works safety committee. Old machines are adapted to new safety standards.

RIESS KELOMAT quickly and reliably rectifies any defects that occur. The safety centre’s safety officers help the company to remove causes of potential accidents. The company has low accident statistics. The company has several, well-trained first aiders ready to provide a rapid response in the event of injuries.

We invest continuously in employee safety, to reduce noise and dust pollution and provide optimum lighting at workstations. There is a works doctor whom employees can consult at Mödling occupational health centre, a modern centre for occupational health and safety at work.



*"A good mix of generations
and gender within our team
is important for us."*

Susanne Rieß



WE PUT HEART AND SOUL INTO EVERY ITEM WE MANUFACTURE

"There are lots of stages to all our products. In order to be perfect every piece not only requires enormous expertise, but also love of craftsmanship." Julian Riess

Apprenticeships – learning on the job

For generations we have attached great importance to thoroughly training employees in metalworking, special enamelling and plastics processing techniques, as well as machine tool and fixtures construction. We are proud that every year we successfully train several apprentices, often in dual apprenticeships.

They can learn trades such as plant electrician and mechanical engineer. Many apprentices (dual electrical and mechanical engineering apprenticeship) go on to study for a Master of Science degree.

For the training of apprentices in 3-D drawing, a separate a separate masters's office is made available provided.

Continuing professional development

"We need generalists, not specialists. Qualified apprentices and employees must have a wide range of specialist knowledge." Friedrich Riess

Every employee can choose from 80 different training and CPD courses every year. This promotes employees' long-term loyalty and personal development and ensures success in the market as a result of premium product quality. There are courses on the latest IT topics and various modules in the fields of hydraulics, electrical and plastics engineering, languages and organisation management, so employees can enhance their qualifications.

We also offer personal and health education seminars in addition to the technical CPD courses. Some employees also take the enamelling course at Iserlohn University of Applied Sciences in Germany every year.

Many training measures are offered annually through the regional qualification network.

The development of staff for management tasks is promoted through training courses and attendance at specialist conferences.

Promoting team spirit

"In addition to the skills of a craftsman, we also place great emphasis on responsibility and team spirit." Susanne Rieß

The company participated in the generation mentoring scheme by WIP = Wirtschaftsantrieb am Punkt, an independent association of SMEs in Lower Austria which represents SME interests, a CPD programme for management, specialists and employees. The model, which is based on a system of in-house mentors, is supposed to dispel prejudice and generate positive synergy from interaction between the generations.

Prospective new employees have an opportunity to familiarise themselves with the business during a taster week. If they are taken on they are offered a comprehensive training programme. Each company department regularly organises cross-departmental guided tours, with a brief period of training.

"This way everyone is familiar with and understands the procedures and connections between work processes. It makes communication on a daily basis easier and promotes improved mutual understanding", is how Robert Huber, head of goods management, explains the programme.



*„We try to grow our knowledge
constantly, mostly by learning
from each other.“*

Susanne RieB



COMPANY

WE LOOK FOR PARTNERS WHO THINK AS WE DO

“RIESS KELOMAT is an important partner for our association. The company impresses with a high level of environmental awareness over its entire production chain, from energy generation to actual production. It also complies with the strict EU directives on food safety and subjects itself to quality control in cookware enamelling by the European Enamel Authority (EEA) in order to offer a healthy and durable product to the consumer.”

Heinz Binder, Austrian enamel association

To produce the desired, high quality products, the company sets standards for purchasing of raw materials and its commercial goods. All RIESS KELOMAT's suppliers are urged to sign the BSCI Code of Conduct 2014 (BSCI = Business Social Compliance Initiative). www.bsci-intl.org

Quality takes top priority when choosing suppliers, followed by supply capability and price. We also place emphasis on strengthening the Austrian economy, short transport distances and production under fair conditions.

The rough sheet metal is purchased exclusively from Voest Alpine AG in Linz. The raw materials for porcelain enamel come from Germany, Belgium, the Netherlands and Italy.

WE WANT TO MAKE A CHANGE

“As a company we should actively shape our environment.” Friedrich Riess

Friedrich Riess is actively involved in various working parties, in the trade association (medium-sized business initiative), in the Austrian Enamel Association (Österreichischer Email Verband - ÖEV), the Wirtschaftsanstrieb am Punkt (WIP) initiative and the European Enamel Authority,

where in addition to addressing the topic of sustainability he also represents the interests of proprietor-run medium-sized companies.

Well-trained employees are the lifeblood of a healthy economy and the backbone of the company. We are therefore dedicated to investing time and money in training young people and committing ourselves to regional development projects.

Furthermore, social and charitable projects are supported on an ongoing basis, primarily in the areas of cooking and regional foods.

WE HAVE BEEN IN THE AREA SINCE 1550 AND ARE DEEPLY ROOTED HERE

“RIESS KELOMAT is represented worldwide with its products and we are proud that the production takes place in Ybbsitz.”

Gerhard Lueger, mayor of Ybbsitz

The company is a long-established family business in the market town of Ybbsitz. With 145 employees, it is one of the most important employers in the region. Local tourism is supported by free guided tours of the company. The company premises and factory halls are made available free of charge for many social, cultural and sporting events in the community. Concerts of the “Klangraum Waidhofen/Ybbs” and exercises of the voluntary fire department are supported. This makes a significant contribution to social life in the market town of Ybbsitz.

The electric filling station located on the plant premises is also accessible to the general public and is a contribution to the promotion of electric mobility in the region.



*"We have been manufacturing in
Ybbsitz since 1550, so the region
is very dear to us."*

Friedrich Riess



COMPANY HISTORY

1350 Existence of the house and estate
"sup eben apud tanzstatt" first documented

1550 Establishment of a hammer mill. Production of simple iron pans and cauldrons. Iron smelted into bars for making tools.

1616 The awarding of an own coat of arms by emperor Matthias.

1690 The Riess family took ownership of the business.

1801 Johann Riess from the iron-working town of Steyr married into the „Tanzstatt firm with the hammers“.

1890 Conversion from a smithy to a metal drawing and forming business. Water wheels give way to modern turbines and new sheet metal-processing machines replace the pan hammers.

1914 Business handed down to the seventh generation, brothers Julian, Leopold and Josef

1919/1920 Construction of the workers' housing

1922 Start of enamelling. Construction of a glass kiln for making porcelain enamel.

1926–1935 Construction of three hydroelectric plants along the Kleiner and Großer Ybbs rivers. Coal-fired kilns replaced with electric enamelling kilns to make the company energy-independent and improve quality through electro-enamelling.

1939–1945 Second World War. Manufacture of field crockery and/or shutdown.

1951 Handover to the eighth generation – Friedrich, Julian and Leopold

1954 Erection of a U-shaped furnace. Expansion of machinery to include production of raw materials. Start of production of cookware suitable for electric cookers.

1965–1975 Company buildings newly built or refurbished. Production of stainless steel goods.

1983 Austrian coat of arms

1988 Production of high-quality enamel signs commences

1995 Start of sales in Germany with own sales force

2000 Handover to the ninth generation – cousins Julian, Friedrich and Susanne

2001 Takeover of Austrian brand KELOMAT – RIESS KELOMAT is the only cookware manufacturer and supplier from Austria.

2005 Expansion of exports to Europe and overseas to what is currently 35 countries around the world.

2008 First sustainability report

2009/2010 Introduction of "truehomeware" premium range (designed by Dottings) with "Aromapots" and "kitchenmanagement".

2012 Extensions to the truhomeware line followed in 2012 with the Riess Edition Sarah Wiener and in 2015 with Giants and Dwarfs. Friedrich Riess is awarded Entrepreneur of the Year 2012 by the Austrian Trade Association.

2013-2023 Green Brand certificate for the company and the RIESS brand, which has been certified for the fifth time – valid until 2023.

2015 Trigos Lower Austria award and nomination for the national TRIGOS award.

2016 Construction of a further power plant at the Große Ybbs.

2017 Certification according to ISO 9001:2015 for the development and implementation of an effective quality management system for the production of industrial components, and distinction with the Austria quality label.



2022

- special stamp 100 years of Riess enamel
- launch Serve + Store food-containers



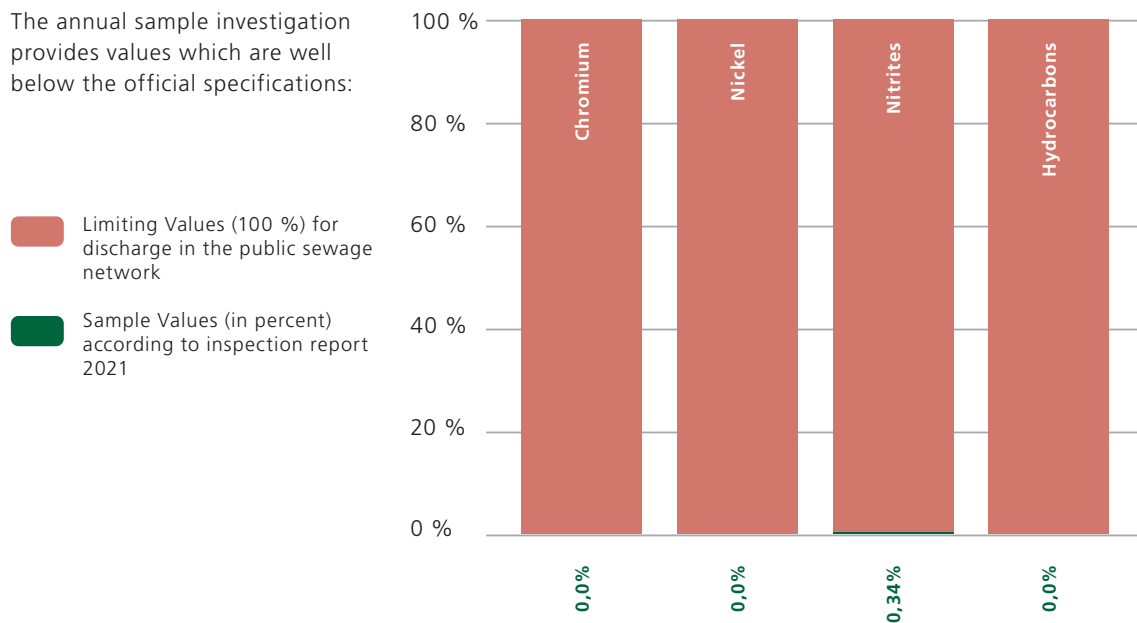
ECOLOGICAL KEY-FIGURES

| | 2009 | 2013 | 2017 | 2021 |
|---|--------------------|----------------------|----------------------|----------------------|
| REFERENCE FIGURES | | | | |
| Numbers of employees | 86 | 121 | 132 | 145 |
| Gross heated surface area (m ²) | 6,675 | 6,675 | 6,675 | 6,675 |
| Quantity produced (1,000 of sales parts) | 500 | 612 | 814 | 823 |
| ENERGY CONSUMPTION | | | | |
| Fuel oil (l) | 24,300 | 20,220 | 30,810 | 20,137 |
| Electricity (kWh) | 3,529,690 | 2,984,910 | 2,438,670 | 2,969,860 |
| Diesel (for emergency generator) (l) | 1,350 | 1,395 | 750 | 85 |
| Diesel (vehicle firms) (l) | 8,180 | 6,675 | 6,221 | 3,000 |
| Km travelled Representatives | 258,300 | 236,556 | 258,903 | 220,343 |
| MATERIAL CONSUMPTION (T) | | | | |
| Steel | 464 | 692 | 875 | 829 |
| Enamel | 87 | 91 | 156 | 165 |
| Packaging material | 131 | 111 | 132 | 100 |
| Plastic | 35 | 34 | 26 | 16 |
| SHARE OF WASTE | | | | |
| Waste paper (m ³) | 86 | 86 | 86 | 86 |
| Industrial resources (t) | 32 | 14 | 18 | 18 |
| Acids and based before degreasing (t) | 63 | 56 | 101 | 96 |
| Enamel dross (t) | 49 | 50 | 55 | 63 |
| WATER CONSUMPTION** | | | | |
| | | 2,810 m ³ | 5,300 m ³ | 4,853 m ³ |
| WASTE WATER (PRODUCTION)* | | | | |
| | 870 m ³ | 1,688 m ³ | 1,857 m ³ | 2,122 m ³ |
| ELECTRICITY F. OWN PRODUCTION (KWH) | | | | |
| Water power | 6,723,975 kW | 6,679,374 kW | 10,105,989 kW | 8,698,232 kW |
| Emergency generator | 2.,800 kW | 1,700 kW | 1,056 kW | 0 kW |
| RECYCLING MATERIAL (T) | | | | |
| Cardboard recycling | 24 | 111 | 132 | 100 |
| Metal recycling | 160 | 223 | 262 | 336 |

* Change from one to two shift productio

** Measured value at the mountain spring pipeline, monthly meter reading

The annual sample investigation provides values which are well below the official specifications:



| KEY EMPLOYEE FIGURES | 2009 | 2013 | 2017 | 2021 |
|--|------------|------------|------------|------------|
| Total number | 86 | 121 | 132 | 156 |
| Permanent staff | 71 | 83 | 111 | 124 |
| Leasing workers | 15 | 13 | 21 | 32 |
| WORKING RELATIONSHIP | | | | |
| Workers | 60 | 96 | 108 | 88 |
| Employees | 23 | 23 | 21 | 29 |
| Apprentices | 3 | 2 | 3 | 2 |
| SEX | | | | |
| Female | 47 | 74 | 79 | 81 |
| Male | 29 | 47 | 53 | 75 |
| AGE | | | | |
| Under 25 years | 12 | 20 | 14 | 19 |
| 25 – 34 years | 16 | 20 | 21 | 27 |
| 35 – 44 years | 26 | 23 | 21 | 33 |
| 45 – 54 years | 23 | 41 | 37 | 46 |
| Over 55 years | 9 | 22 | 19 | 31 |
| EDUCATION | | | | |
| School leaving examination | 6 | 8 | 3 | 3 |
| Specialist leaving certificate | 12 | 14 | 15 | 12 |
| Master's | 4 | 4 | 6 | 4 |
| Apprenticeship graduation | 34 | 38 | 41 | 38 |
| Other | 30 | 57 | 55 | 99 |
| PERIOD WITHIN THE FIRM | | | | |
| Less than 5 years | 24 | 63 | 43 | 79 |
| 5 – 10 years | 21 | 27 | 32 | 33 |
| 11 – 20 years | 15 | 9 | 11 | 20 |
| 21 – 30 years | 17 | 15 | 10 | 7 |
| Over 31 years | 9 | 12 | 16 | 17 |
| Average length of time within the firm | 15.6 years | 10.5 years | 11.1 years | 10.7 years |
| SAFETY | | | | |
| Average time lost due to illness per employee | 7 days | 14 days | 14 days | 9 days |
| Industrial accidents | 4 | 6 | 4 | 6 |
| Av. time lost due to reportable accidents (>3 days) | 0.5 | 10 | 16 | 4 |
| FLUCTUATION OF EMPLOYEES | | | | |
| Arrivals | 16 | 6 | 10 | 23 |
| Departures | 3 | 3 | 11 | 16 |
| Retirements | 2 | 2 | 2 | 4 |
| Fluctuation | 6.9 % | 4.1 % | 8.3 % | 12.8 % *** |
| VOLUNTARY SERVICES | | | | |
| Further training costs per employee (euros) | 140.– | 525.– | 369.– | 431.– |
| Canteen* | no | no | no | no |
| Company apartments / houses | yes | yes | yes | yes |
| Commuter support | | yes | yes | yes |
| Car sharing, company buses | no | no | no | no |
| Childcare within the firm* | no | no | no | no |
| Number of seminars on personal development, nutrition and health** | 25 | 26 | 30 | 30 |
| E-filling station on the company grounds | no | no | no | yes |

* because of the working hours model, it was not necessary to provide a canteen and a company childcare facility. See also Page 28 „Family- friendly working hours“

*** Fluctuation of in-house staff 1.1 %

** Health and nutrition seminars provided. the cost of these seminars is divided as follows: 1/3 works council, 1/3 firm, 1/3 employees.



GREEN BRANDS QUALITY LABEL

GREEN BRANDS is an independent international brand marketing organisation which provides certification in cooperation with independent institutions and companies in the fields of climate and environmental protection as well as sustainability, also working together with market research and opinion polling institutes. In 2013, RIESS KELOMAT received the Green Brands quality label for the first time from the GREEN BRANDS organisation, both for the company as a whole and for its enamel products. Since then, the label has been renewed four times.

www.green-brands.org



CO₂-NEUTRAL PRODUCTION

RIESS products are produced with hydro-electric power generated on site. The surplus is fed into the public power grid, offsetting the CO₂ emitted in the individual production steps. This means that the environment and the atmosphere are not polluted with CO₂ by the production of an enamel product from RIESS. Data and fact-based evidence regarding our carbon-neutral production is provided by a study by the Wiener Neustadt University of Applied Sciences, campus Wieselburg, performed with the help of the Gemis 4.6 database (GEMIS = Global Emissions Model for Integrated Systems). The first eco label for CO₂-neutral production of cookware was developed based on the study results.



certified quality

EEA CERTIFICATE

The European Enamel Authority (EEA) is committed to developing, updating and auditing quality requirements which are agreed by all member associations. For the consumer, this guarantees high quality on the part of those companies which comply with the EEA quality guidelines and are certified by the EEA.

www.european-enamel-authority.org/de



TRIGOS LOWER AUSTRIA 2015

In 2015 RIESS KELOMAT GmbH was nominated for the national TRIGOS award and received the TRIGOS Lower Austria in the category of whole-system CSR management.

www.trigos.at



HELIOS AWARD

Helios – the energy efficiency award of the state of Lower Austria – went to RIESS KELOMAT GmbH in 2014.

www.energieeffizienzpreis.at



ISO 9001:2015 QUALITY MANAGEMENT

On 22.10. 2017, RIESS KELOMAT GmbH was certified by Quality Austria Trainings, Zertifizierungs und Begutachtungs GmbH according to ISO 9001:2015 for the implementation and development of an effective quality management system in the production of industrial components.

www.qualityaustria.com



AUSTRIA QUALITY LABEL

The Austria quality label is awarded to Leading Companies in Austria. Quality Certification of the products is carried out by Quality Austria Trainings, Zertifizierungs und Begutachtungs GmbH.

www.qualityaustria.com

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