NUCOR SUSTAINABILITY REPORT 13

Integrity

Can-Do Attitude

Pride

Responsibility

Optimism

Teamwork

Work Ethic

Communications

Respect

ABOUT THIS REPORT

With our 2013 Sustainability Report, we provide another look into Nucor's dedication to continual improvement at all levels of our organization. This report covers our Nucor mills and product facilities, including the David J. Joseph Company, Harris Steel Group, and Skyline Steel Operations. This report was developed to reflect the Global Reporting Initiative (GRI) G3.1 Sustainability Reporting guidelines, which provide a standard framework for organizations to report on social, environmental, governance, and economic performance. At the end of some of the sections, we have included the applicable GRI indicators. Where metrics recommended in GRI are relevant to Nucor Corporation and data was available, we have included this information, but we have not endeavored to report in accordance with GRI.

DEDICATION

To the more than 22,300 teammates of Nucor Corporation and our subsidiaries, thank you for embracing Nucor's mission to be cultural and environmental stewards in our communities where we live and work. Every story, every statistic, and every improvement cited in this report is a product of your hard work and commitment.

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LETTER FROM THE CHAIRMAN, CEO & PRESIDENT

NUCOR TEAMMATE SINCE 1991

COMMON VALUES, UNCOMMON RESULTS

Sustainability is not a concept that is new to Nucor, or a program that we have put in place; it is a common value, tracing its roots back to the beginning of our company. Over the course of more than 50 years, Nucor has grown from a small company to the largest recycler of scrap metal in the Western Hemisphere. We accomplished this by being the safest, highest quality, lowest cost, most productive, and most profitable steel and steel products company in the world. We care about our teammates, our customers, the environment, and the communities in which we live and work. It's not just our way of doing business; it's our nature.

Taking care of our customers is at the core of everything Nucor does. We define our customers as anyone our business directly impacts: our employees, our shareholders, and the people who purchase and use our products. Taking care of our customers is a daily objective for every Nucor teammate and the reason that Nucor is, and always will be, a sustainable business. Focused on that goal, we succeed by working together. It's that simple.

While the terminology in the marketplace has evolved over the years, the stories in this report demonstrate how Nucor's focus on sustainability has remained the same.

- We've taken Safety First to a new level by partnering with OSHA's Voluntary Protection Program at numerous mills, enabling us to better serve our teammates, industry, and communities with regard to safety training and awareness.

- Our teammates continue to be our most valuable asset, and we work hard to take care of them through our industry-leading pay, benefits, and culture. As a result, we have tremendous teammate satisfaction levels and a 93% teammate retention rate.

- Nucor continues to lead its industry in environmental performance and innovation. We are the proud recipients of numerous awards, including the Silver Crescent Award, awarded by the Silver Crescent Foundation to Nucor Steel – Berkeley for manufacturing excellence in South Carolina.

- Our commitment to community involvement remains a top priority. We've seen our teammates generously give of their finances and time when faced with daunting challenges like Hurricane Sandy and the fight against cancer. We've also seen them take the lead in helping their communities through local educational, recreational, and beautification projects.

- Our mission is to take care of our customers by providing top-notch service and products. Our new direct reduced iron (DRI) facility in Louisiana – powered by clean-burning natural gas – allows us to provide a broader range of sustainable products to our customers. We are expanding into exciting new markets, such as high-strength steel products that help our customers reduce the weight and increase the efficiency of their products.

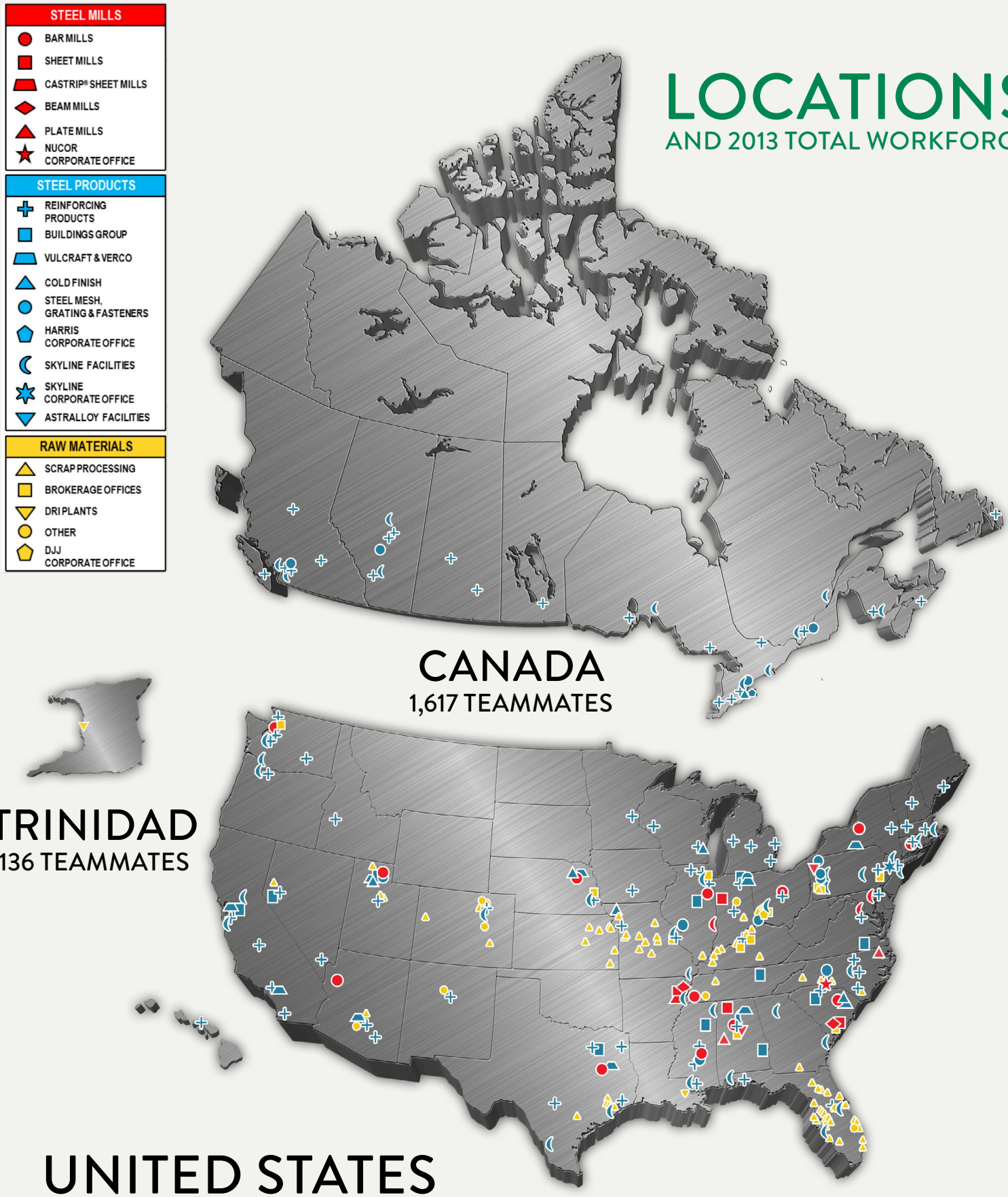
- Our board of directors and executive officer group continue to lead our organization according to the highest ethical standards, guided by our governance principles. We are proactively addressing difficult issues like conflict minerals and forced labor head-on. We are also focused on maximizing shareholder return, having proudly announced our 163rd consecutive cash dividend in the fourth quarter of 2013.

We hope that you enjoy reading this report as much as we enjoyed putting it together. We look forward to publishing more examples of Nucor's commitment to sustainable performance in the future.

John J. Ferriola

John J. Ferriola

LOCATIONS
AND 2013 TOTAL WORKFORCE



CANADA
1,617 TEAMMATES

TRINIDAD
136 TEAMMATES

UNITED STATES
20,538 TEAMMATES

MEXICO & OTHER INTERNATIONAL LOCATIONS
38 TEAMMATES

OUR MISSION

NUCOR IS MADE UP OF MORE THAN
22,300 TEAMMATES WHOSE GOAL IS TO
TAKE CARE OF OUR CUSTOMERS

WE ARE ACCOMPLISHING THIS BY BEING

THE SAFEST,
HIGHEST QUALITY,
LOWEST COST,
MOST PRODUCTIVE,

AND

MOST PROFITABLE

STEEL AND STEEL PRODUCTS
COMPANY IN THE WORLD.

WE ARE COMMITTED TO DOING THIS WHILE BEING
CULTURAL AND ENVIRONMENTAL STEWARDS
IN OUR COMMUNITIES WHERE WE LIVE AND WORK.

WE ARE SUCCEEDING BY
WORKING TOGETHER.

NUCOR®

OUR MILLS HAVE A PRODUCTION CAPACITY THAT EXCEEDS 27 MILLION TONS.
NUCOR IS THE LARGEST PRODUCER OF STEEL, JOIST, AND DECK IN THE UNITED STATES.
WE ARE THE WESTERN HEMISPHERE'S LARGEST RECYCLER.

MOTOROLA

HEALTH AND SAFETY PERFORMANCE

"We continue to focus on the most important thing we do every day: working safely."

JOHN FERRIOLA
1991-PRESENT

IT'S OUR

Stepping *Beyond* Zero

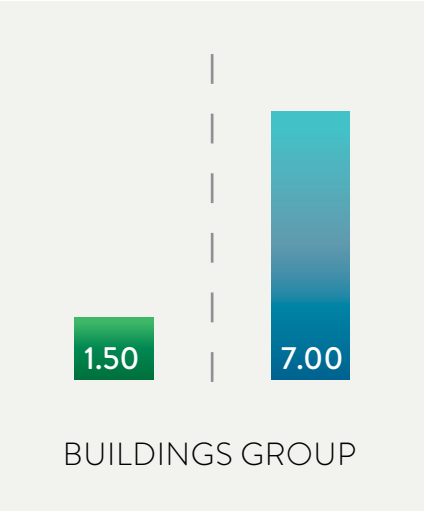
Our Partnership with OSHA

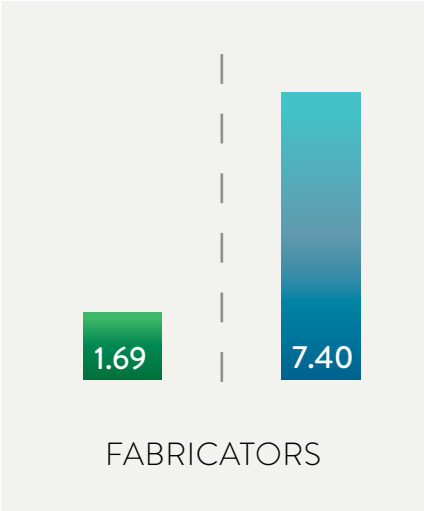
The motto "Safety First" embodies a deeply ingrained part of our culture: it is addressed at the start of virtually every shift we work, every meeting we conduct, and every report we publish. Every Nucor division has dedicated safety teams constantly working to improve our standards, and we make sure every one of our facilities gets audited regularly for safety performance.

SAFETY IS NO SIDESHOW: *IT IS OUR FIRST PRIORITY.*

We're convinced that focusing on safety performance helps keep our team strong, which leads to strong business performance. So in 2011, *Beyond Zero* became our new standard of safety excellence. When it comes to safety incidents, we're not interested in low occurrence; we're focused on no occurrence. We also don't limit ourselves to zero injuries or illnesses: *Beyond Zero* targets zero near misses, zero property damages, and zero potential for incidents.

2013 TOTAL OCCUPATIONAL INJURY & ILLNESS RATES | PER 100 WORKERS/200,000 HOURS PER YEAR





NUCOR 2013 | NATIONAL INDUSTRY AVERAGE

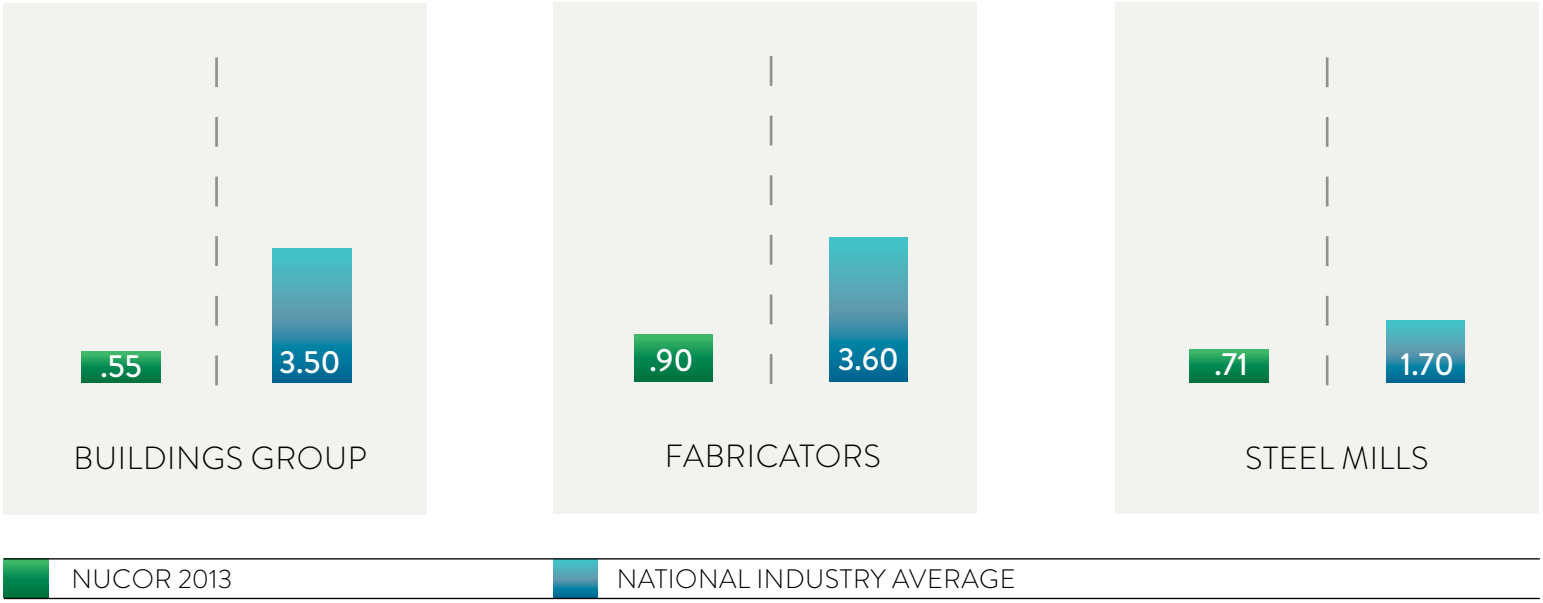
TAKING THE NEXT STEP

In our last report we introduced *Beyond Zero.* Since then, we've taken the next step in our commitment to safety by partnering with the Occupational Safety and Health Administration (OSHA) through the agency's Voluntary Protection Program (VPP). VPP is a program that recognizes companies that voluntarily go the extra mile to meet rigorous safety standards. As of December 31, 2013, 22 of Nucor's divisions were VPP recognized.

NUCOR'S INJURY RATE IS **CONSISTENTLY LOWER** THAN THE NATIONAL AVERAGE

One such division is Nucor Steel – Berkeley, in Huger, South Carolina. In addition to being a VPP site, this division now hosts voluntary training programs every two months. Led by OSHA trainers, these programs are free and open to the public. The Berkeley mill also holds an annual invitation-only safety summit for its contractors. This event, also led by OSHA trainers, averages 100 attendees and is punctuated each year by the Contractor Safety Award, presented by Nucor Steel – Berkeley in conjunction with OSHA. In addition, OSHA has on numerous occasions requested the Berkeley mill mentor other South Carolina companies on how to be successful during the VPP certification process.

2013 TOTAL DAYS AWAY, RESTRICTED & TRANSFER CASE RATES | PER 100 WORKERS/200,000 HOURS PER YEAR



Nucor teammates and divisions are also expanding their capabilities to contribute to the overall safety of our industry by partnering with OSHA through the Special Government Employee (SGE) program. The SGE program is an extension of VPP through which qualified public and private sector safety and health professionals can serve as OSHA representatives. SGEs are trained to perform on-site VPP evaluations and regularly contribute to the SGE knowledge base. Since 2011, 50 of our teammates representing 22 divisions have become SGEs.

Recently, two Nucor Steel Marion, Inc. teammates coordinated an SGE training event attended by participants from several companies including two teammates from Nucor Steel – Texas. Steve Washburn of the Marion division remarked, "[Doing this] shows our commitment to being involved in VPP and helping promote the program to other companies. It also gives us an opportunity to see how other companies are handling safety situations." Since this training, the Marion SGEs have performed six VPP audits and continue to provide scheduled trainings on behalf of OSHA's VPP.

Nucor is grateful for the opportunity to work alongside OSHA in expanding an industry-wide culture of safety.

Focused on Teammate Health

Providing Opportunities for Health, Fitness, and Prevention

Health and safety goes beyond just providing a safe work environment. That's why we offer opportunities for our teammates and their families to monitor and optimize their health and wellness.

100%

PERSONAL RESPONSIBILITY FOR SAFETY

MORE THAN

121,640

SAFETY DATA SHEETS DISTRIBUTED TO CUSTOMERS IN 2013

Health Fairs

For several decades, Nucor divisions across North America have hosted annual health fairs. Health fairs generally include services like blood screenings and diabetes tests, as well as visits from local health professionals. Nucor health fairs emphasize prevention, and have succeeded in providing numerous teammates with life-saving, preventative health insights.

On-site Medical & Fitness Centers

To better serve our teammates and their families, several of our facilities are equipped with medical staff and equipment. In addition, several Nucor facilities have installed on-site fitness centers, which are available to teammates 24 hours a day.

Health Education

Nucor facilities offer teammates, their families, and contractors a variety of educational opportunities on topics like safety, fitness, and nutrition.

STORM READY

Nucor Divisions Team Up with the National Weather Service

Americans living in the South and Midwest are no strangers to some of the harshest weather conditions the country has to offer. Hurricanes come up through the Gulf of Mexico, tornadoes race across the region, and some of the most violent thunderstorms in the country occur every summer in both Alabama and Arkansas.

In the wake of the deadly tornadoes that wreaked havoc in recent years, Nucor Steel Decatur, LLC in Alabama and Nucor Steel – Arkansas teamed up with the National Weather Service to be part of the StormReady® Supporter program. Started in 1999 in Tulsa, Oklahoma, the StormReady program helps strengthen local safety programs by developing the communication and safety skills needed to save lives and property, both before and during significant weather events.

The StormReady program uses a grassroots approach to coordinate communities, hospitals, universities, and large businesses to ensure emergency personnel and first responders have access to areas where weather events have caused the most severe damage. To be designated a StormReady Supporter, Nucor Steel Decatur, LLC and Nucor Steel – Arkansas had to be endorsed by their local emergency management agencies. These divisions are among fewer than 300 sites nationwide to be recognized as StormReady Supporters, including 12 other sites in Alabama and only two others in Arkansas.

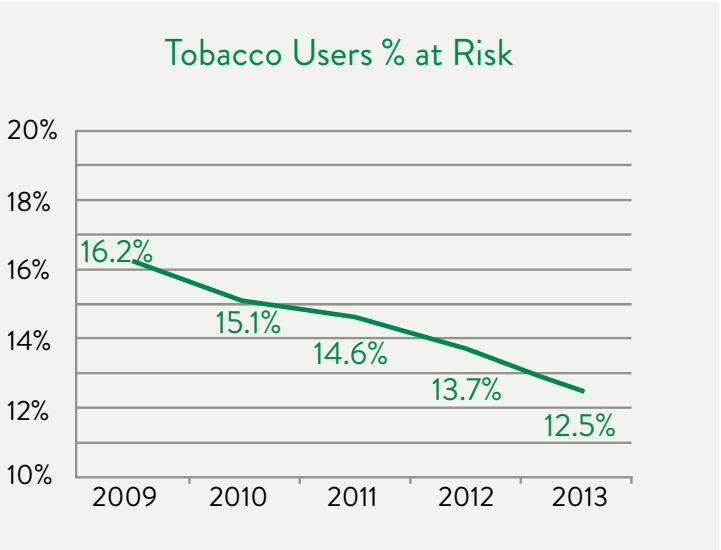
Nucor Steel – Arkansas was the first Nucor division to complete the StormReady Supporter process. The facility now has 10 severe weather shelters on site and coordinates closely with surrounding StormReady communities. Nucor Steel Decatur, LLC's teammates visited Nucor Steel – Arkansas as they were preparing their own application.

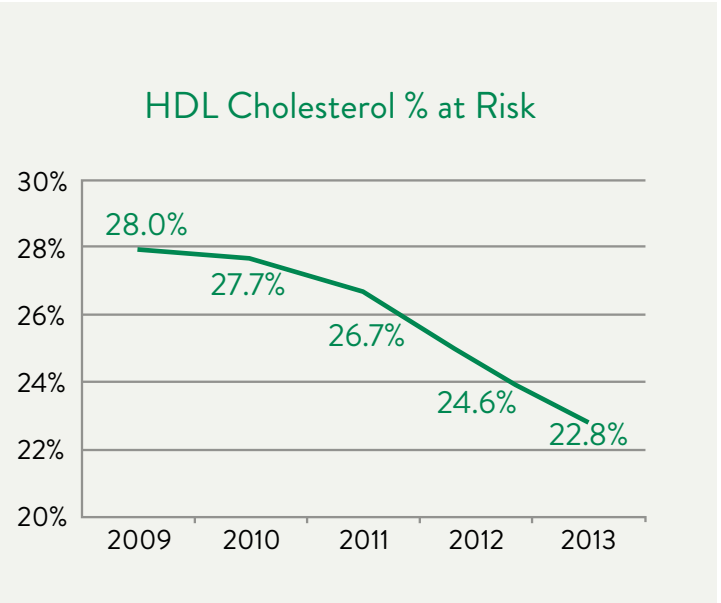
Nucor Steel Decatur, LLC began the StormReady application process following the April 2011 tornadoes that struck the division's property during three days of devastation that saw 350 tornadoes strike in 21 states, killing 348 people. Though the mill lost power for a week, and many teammates were rendered homeless by the damage, Nucor Steel Decatur, LLC kept its teammates on the payroll and encouraged them to get out and help their teammates and neighbors in any way possible. Teammates from Nucor Steel Tuscaloosa, Inc. also assisted in rebuilding the affected communities, clearing debris and donating manpower and equipment for relief.

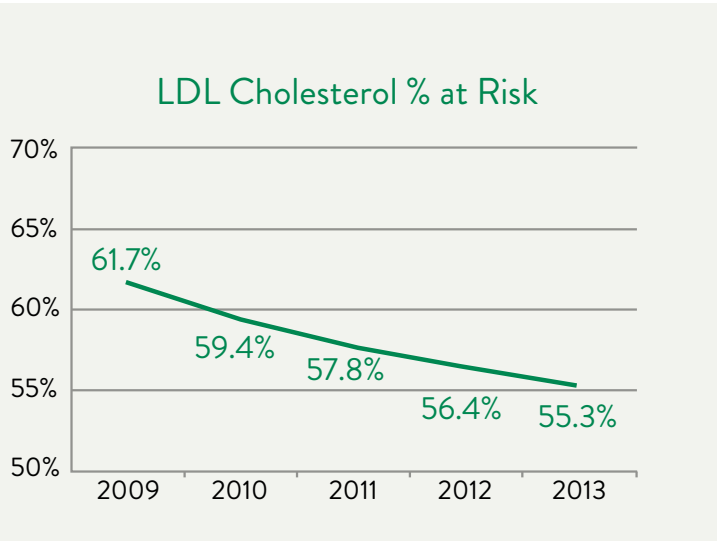
Nucor Steel Decatur, LLC has since added 14 severe weather shelters with a combined capacity for nearly 400 people. Like so many of the mill's other recognitions, such as the OSHA's Voluntary Protection Program Status, the StormReady Supporter recognition demonstrates the mill's commitment to the safety of its teammates and that of the surrounding community.

NuYou

In 2005, we began the NuYou health and wellness program to help all Nucor teammates make better healthcare decisions. As part of the program, we have tracked the percentage of teammates who are considered "at risk" in certain health categories. In the five years we have tracked results, we have seen a decline in the percentage of teammates at risk in every category.







FAMILY MATTERS

When teammates at Nucor Building Systems – Texas found out one of their own was battling cancer, they came together to help.

Nucor teammates organized a barbecue sandwich fundraiser to help support their fellow teammate, who works in quality service, in her fight against cancer. The division's cooking team cooked the meat on the plant's big smoker, and sold sandwiches to teammates and other businesses in the area. Through this one event, they raised $10,000 to help her with her medical expenses.

"It is an honor and privilege to be part of such an amazing team and to work for Nucor Building Systems – Texas," said Jennifer Prestridge, the leader of the fundraising effort.

Tom Batterbee, General Manager of Nucor Building Systems – Texas, explained, "I think this is an example of the Nucor culture at work – teamwork, family spirit, and taking care of our internal customers."

RISING STARS

In our industry, OSHA's Voluntary Protection Program (VPP) is the gold standard for safety excellence. The program recognizes companies that voluntarily go the extra mile to meet rigorous safety standards.

Since 2005, 22 Nucor divisions have earned VPP recognition. This achievement has been driven primarily by our teammates, with the full support of management. VPP evaluation involves a meticulous on-site evaluation of literally every aspect of day-to-day operations. From general housekeeping to confined space management to procedures for locking down machines, candidates must demonstrate that safety is built into every task of every job of every department. Within the program, VPP Star Status is the highest level of voluntary achievement.

VPP Certified Divisions

Nucor Steel – Hertford
Nucor Steel Seattle, Inc.
Nucor Steel – Nebraska
Nucor Steel Decatur, LLC
Nucor Steel Marion, Inc.
Nucor Steel – Arkansas
Nucor Building Systems – SC
Nucor Steel – Texas
Vulcraft – Nebraska
Nucor Steel – Berkeley
Nucor Steel Jackson, Inc.
Vulcraft – Texas
Nucor Steel Tuscaloosa, Inc.
Nucor Steel Kankakee, Inc.
Nucor Steel – Indiana
Kirby Building Systems
Vulcraft – Alabama
Nucor Building Systems – IN
Nucor Cold Finish – NE
Vulcraft – Indiana
Nucor Fastener – Indiana
Nucor Building Systems – TX

In 2013, Nucor Chairman, CEO, and President, John Ferriola, recognized 14 of Nucor's 22 VPP divisions for their outstanding safety performance, their dedication to VPP, and their partnership with OSHA.

CEO Recognized Divisions

Nucor Cold Finish – Nebraska
Vulcraft – Alabama
Nucor Steel – Texas
Nucor Steel Kankakee, Inc.
Nucor Steel Tuscaloosa, Inc.
Nucor Steel Decatur, LLC
Nucor Steel – Berkeley
Nucor Steel – Arkansas
Nucor Building Systems – Texas
Kirby Building Systems
Nucor Building Systems – South Carolina
Vulcraft – Nebraska
Vulcraft – Indiana
Vulcraft – Texas

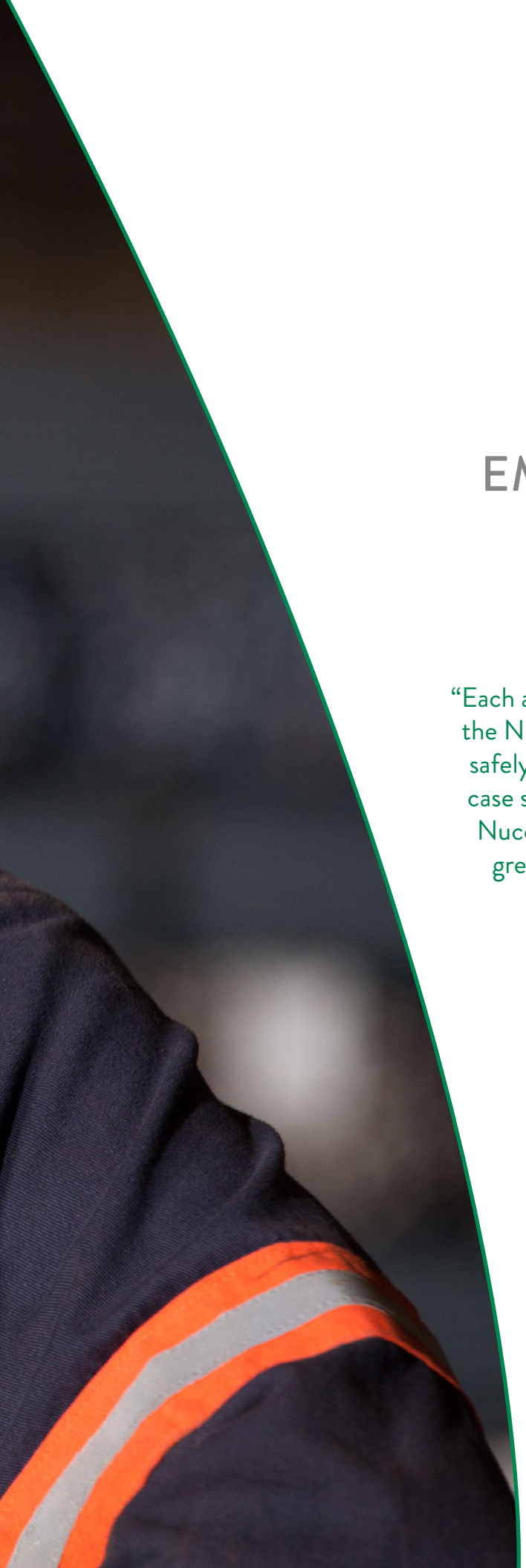
> So, Mr. Chairman, thank you. We have so much to do. This has been good. **I mean I'm telling you, Mr. Lee, every company in this country should be like yours,** and then we don't even need OSHA. But we do need OSHA because somebody has got to investigate.

Former U.S. Representative Lynn Woolsey (D, CA-6), praising Nucor during the testimony of Mike Lee, Vice President and General Manager of Nucor Steel Decatur, LLC, in front of the U.S. House Subcommittee on Workforce Protections hearing on Promoting Safe Workplaces Through Voluntary Protection Programs on June 28, 2012.

HEALTH AND SAFETY PERFORMANCE INDICATORS

GRI NUMBER	DESCRIPTION	REPORTED	PAGE
ASPECT: OCCUPATIONAL HEALTH AND SAFETY			
LA6	Percentage of total workforce represented in formal joint management-worker health and safety committees that help monitor and advise on occupational health and safety programs.	Completely Reported	10
LA7	Rates of injury, occupational diseases, lost days, and absenteeism, and number of work-related fatalities by region and by gender.	Partially Reported	10, 11
LA8	Education, training, counseling, prevention, and risk-control programs in place to assist workforce members, their families, or community members regarding serious diseases.	Completely Reported	13, 15

TO FIGHT BACK
MOTOROLA



EMPLOYEE RELATIONS

"Each and every day, the more than 22,300 men and women of the Nucor team are building a stronger new Nucor by working safely, working smart, and working together. As has been the case since our company was founded nearly five decades ago, Nucor's teammates – the right people – are our company's greatest assets and our greatest competitive advantage."

JOHN FERRIOLA
1991-PRESENT

IT'S OUR

A Constant For Success: The Nucor Way

A lot has changed in the steelmaking business over the last 50 years. Nucor has been a leader in bringing about many of those changes. And to lead the way, our teammates have continually adapted as the world has changed around us. But one thing has remained constant since our founding: our culture – the Nucor Way.

Every teammate at Nucor lives and works by the Nucor Way. These 10 core principles drive and direct our pursuit of continual improvement as a team.

Becoming part of the Nucor family means a commitment to each of these core values. The Nucor Way is the cornerstone of our success in the scrap yard, in the steel mill, in the fabrication plant, in the brokerage office, and in every aspect of the hard work our more than 22,300 teammates do every day.

Embracing these 10 values not only attracts the right people, it allows us to keep them. Because at Nucor, we give our teammates the tools they need to succeed, and then we get out of their way. This allows Nucor teammates to meet and overcome every challenge that they face. We have proven this time and time again. Our teammates succeed by working together.

We're doing it the Nucor Way. That's an advantage that no one else can imitate.

Nucor's Employee Relations Principles

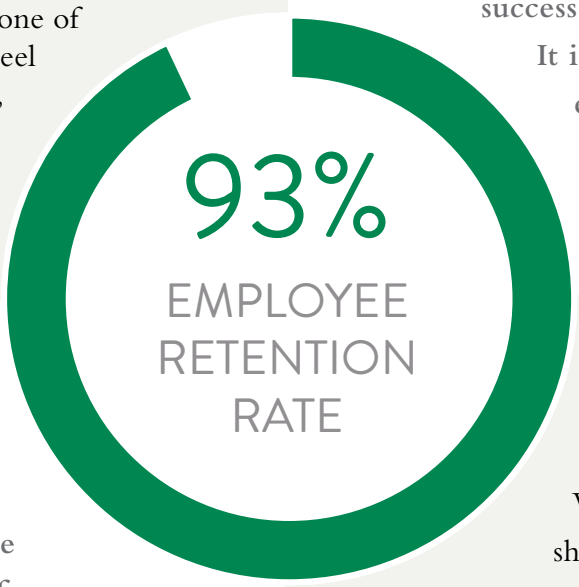
Nucor embraces four key principles as the foundation of our relationship with our teammates.

Pay for Performance

At Nucor, everyone's compensation is based on pay for performance. In our mills, that means income is tied directly to the amount of quality steel produced each day. And for management and administration, income is tied to how well the company does overall. In our experience, teammates perform better when they have the opportunity to earn according to their productivity. As a result, Nucor is one of the most productive steel companies in the world, and our teammates are some of the most well-compensated in the industry.

Right to Be Treated Fairly

Nucor teammates not only have the right to be treated fairly, but we also strive to create an environment where our teammates know they will be treated fairly. There are no reserved parking spots, no special vacation plans, and no first-class travel perks. Our success is driven by teamwork. It is why we call our employees "teammates."



Avenue of Appeal

Our teammates always have a right to be heard. They can ask for a review of a complaint if they feel a supervisor has not provided a fair hearing. And they can appeal the decision to the general manager or the corporate office.

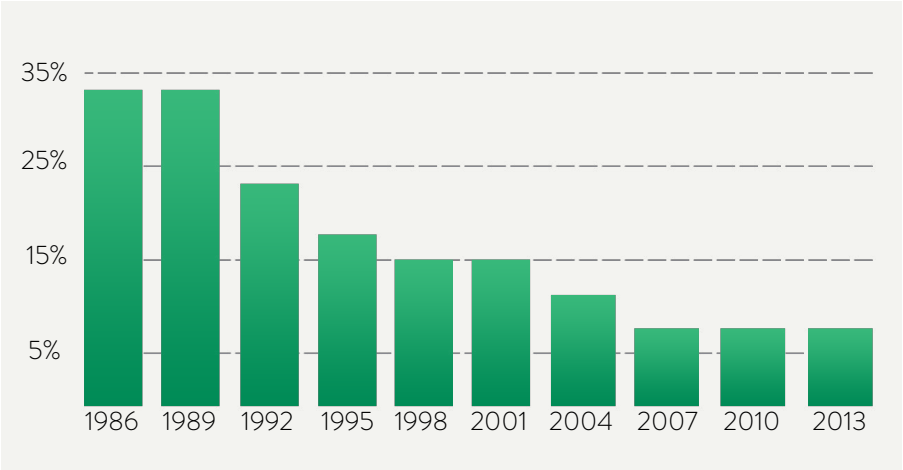
Do Your Job, Have It Tomorrow

We believe our teammates should feel confident that if they do their jobs properly, they will have a job tomorrow. We strive to provide job security for all of our teammates with our practice of not laying off teammates for lack of work.

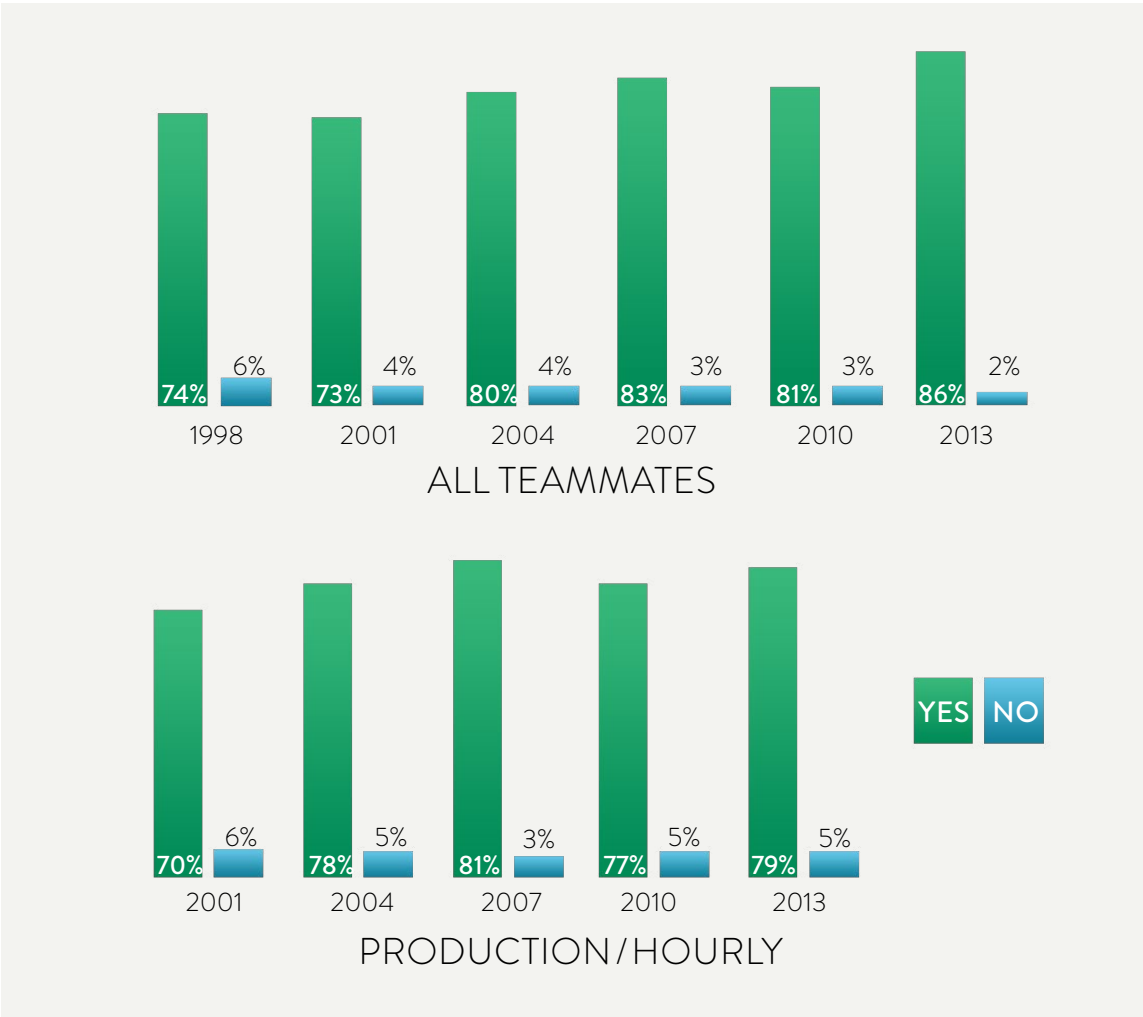
Satisfied Teammates

Once we have found the right people, we want to keep them. An important part of achieving that goal is knowing what they think and how they feel about working at Nucor. Every three years since 1986, Nucor has asked teammates to fill out a comprehensive survey that provides feedback on management in their department and division, the teammates' working environment, and their feeling about the direction of the company. It is an important tool that we use to continually improve our company.

The latest survey was administered in 2013 and received an 88% response rate.



▲ PERCENTAGE OF NEGATIVE RESPONSES, OVERALL RESULTS



◀ OVERALL, ARE YOU SATISFIED WITH NUCOR AS A PLACE TO WORK?

Investing in Future Leaders

The Nucor Foundation Approaches 40

Investing in our teammates so they can grow and reach their personal and professional goals is vital to our goal of building a strong team and an even stronger future for our company. What sets us apart is our definition of teammates, which includes our teammates' families.

This report coincides with the 40th year of the Nucor Foundation. Created in 1974 by Nucor Founder Ken Iverson, the Foundation provides scholarships for the post-secondary education of Nucor teammates' children. Since its inception, the Foundation has paid out over $70,591,000.

In 2013, the Foundation provided $4,733,929 in scholarships and educational disbursements for more than 2,045 students. In addition, Nucor announced an increase in the annual scholarship from $3,000 to $3,200 for the 2014-2015 school year. This increase will provide a total of $12,800 over four years to each recipient. Nucor's teammate tuition reimbursement program was also set to increase (effective January 1, 2014) and provide teammates with $3,200 per year, and their spouses with $1,600 for up to two years, in approved educational reimbursements.

IN 2013,
THE FOUNDATION PROVIDED

$4,733,929

in scholarships and educational disbursements for more than

2,045 STUDENTS

Since its inception, the Foundation has paid out over

$70,591,000

Return on Investment

Nucor is investing in the next generation of engineers and leaders by providing college students with internships and co-op opportunities. In addition, some interns and co-ops are awarded Nucor Foundation scholarships. These recipients often go on to join Nucor and become leaders in their departments.

Sam Ervin

Nucor Building Systems – South Carolina

Sam graduated from Clemson University and joined Nucor in 2010. He is now an Estimating Supervisor.

Adam Zewe

Nucor Steel Decatur, LLC

Adam graduated from Carnegie Mellon University and joined Nucor in 2009. He is now a Melt Shop Supervisor.

WORKFORCE SOLUTIONS NAMES NUCOR STEEL – TEXAS 2013 EMPLOYER OF THE YEAR

Workforce Solutions Brazos Valley named Nucor Steel – Texas the 2013 Employer of the Year for the Brazos Valley. Workforce Solutions cited Nucor's outstanding recycling performance and its commitment to Nucor teammates. It also praised Nucor's community support on a number of projects, including the 2013 Workforce Solutions Brazos Valley HYPE (Helping Youth Prepare for Employment) Career Expo for area junior and senior high school students; paid internships for area high school students; and the County Race for Life campaign.

LABOR PRACTICES & DECENT WORK PERFORMANCE INDICATORS

GRI NUMBER	DESCRIPTION	REPORTED	PAGE
EMPLOYMENT			
LA1	Total workforce by employment type, employment contract, and region, broken down by gender.	Partially Reported	6
LA2	Total number and rate of new employee hires and employee turnover by age, group, gender and region.	Partially Reported	21
LA3	Benefits provided to full-time employees that are not provided to temporary or part-time employees, by major operations.	Partially Reported	21
ECONOMIC PERFORMANCE			
EC1	Direct economic value generated and distributed, including revenues, operating costs, employee compensation, donations and other community investments, retained earnings, and payments to capital providers and governments.	Partially Reported	46, 50, 66
MARKET PRESENCE			
EC7	Procedures for local hiring and proportion of senior management hired from the local community at significant locations of operation.	Partially Reported	24
INDIRECT ECONOMIC IMPACTS			
EC8	Development and impact of infrastructure investments and services provided primarily for public benefit through commercial, in-kind, or pro bono engagement.	Partially Reported	35, 44-45, 49, 50
EC9	Understanding and describing significant indirect economic impacts, including the extent of impacts.	Partially Reported	46, 50

NUCOR
TEXAS
NO ONE GETS HURT ON OUR SHIFT TODAY !

ENVIRONMENTAL PERFORMANCE

"Do what you say, say what you do. Walk the talk!
That's what integrity means at Nucor."

JOHN FERRIOLA
1991-PRESENT

IT'S OUR

Integrity

Committed to Environmental Responsibility

Year after year, Nucor's long-standing commitment to the environment is defined by our corporate environmental policies. Because Nucor encourages our teammates to take ownership of the entire process of making steel, we also expect them to take personal responsibility for our environmental stewardship. Each facility has adapted our core corporate environmental principles and created location- or division-specific policies to ensure environmental responsibility is embraced throughout Nucor.

According to Steve Rowlan, Nucor's Director of Environmental Affairs, "Environmental compliance is the responsibility of each and every teammate, from manager to the frontline teammate."

NUCOR CORPORATION ENVIRONMENTAL POLICY

As the largest recycling company in the Western Hemisphere, Nucor recognizes our role in protecting the environment. We value the environment of the communities in which we operate and recognize its importance to our teammates, their families, and our continued welfare. Protecting the environment is critical to our operations and the company's long-term success. To this end, we endorse these principles to demonstrate our commitment to the environment.

OUR PRINCIPLES

Performance

To continually improve the effectiveness of our Environmental Management System, Nucor will:

- Pursue pollution prevention and waste minimization opportunities;
- Investigate and develop technologies and operations that improve environmental performance;
- Regularly evaluate the Environmental Management System and make appropriate improvements.

Stewardship

Nucor recognizes its potential for environmental impact on the communities in which it operates. We will continually strive to minimize these impacts by evaluating our operations and researching new technologies and opportunities.

Responsibility

Environmental protection is the individual obligation of each Nucor teammate and a primary responsibility of management. Nucor also requires contractors, vendors, and suppliers to comply with applicable environmental laws.

Standards

Nucor and its divisions will comply with the laws and regulations governing their operations. Environmental compliance is a priority for Nucor management equal with all other business functions.

Outreach

Nucor will strive to foster open dialogue so that we may effectively communicate with our teammates, our neighbors, and other concerned parties.

LEARN MORE AT: WWW.NUCOR.COM/RESPONSIBILITY/ENVIRONMENT/EMS

BIG LITTLE CHANGES

Continual improvement is a driving force in Nucor's culture and can be seen in some of the large environmental projects we undertake. But what often goes unnoticed is the big impact made by small changes we make every day. Consider, for example, the ongoing environmentally efficient updates being made to our facilities, from new lights and appliances to new motors to run our equipment. As Vulcraft – Nebraska's Environmental Coordinator, Dwight Eisenbraun, explains: "It's the little things. But when you go back 10 years, the impact is huge."

IN 2013, APPROXIMATELY $65 MILLION WAS APPROVED FOR CAPITAL EXPENDITURES ASSOCIATED WITH ENVIRONMENTAL REGULATION COMPLIANCE AT OUR FACILITIES.

GOING SOLAR

In 2013, Vulcraft of New York, Inc. undertook an aggressive solar project in partnership with the NY-Sun Initiative. The New York State solar power program has a planned investment of $800 million in state solar projects through 2015. Vulcraft's 1.6 megawatt system includes 8,892 panels covering 155,500 square feet of roof over the production bay, and produces electricity to cover roughly one-sixth of the facility's annual consumption. This means less reliance on the grid, and cleaner, more sustainable energy for Vulcraft. In addition, any excess power produced by the project will be returned to the grid, which means a cleaner, more sustainable grid for the state of New York.

RAISING THE BAR

Nucor is committed to being an environmental steward in the communities where we operate. This is why we have 47 Environmental Management Systems (EMS) in place, and the reason every newly built or acquired facility immediately develops a timeline to get ISO 14001:2004 certified. Because we know the value of teamwork, certified and experienced Nucor facilities work hand-in-hand with new ones to help them develop an effective EMS.

Steve Rowlan explains, "Nucor is committed to the long-term performance of the EMS programs to reduce our impact on the communities in which we live and work."

Though many of our EMS programs have been in place for years, our teammates continue to improve upon them through audit processes, corrective actions, internal audits and management reviews. We've even added several internal programs that, while not required under the ISO 14001:2004 standard, produce results. Our focus on a value-added EMS has helped us develop an effective, company-wide program.

WHY AN ENVIRONMENTAL MANAGEMENT SYSTEM?

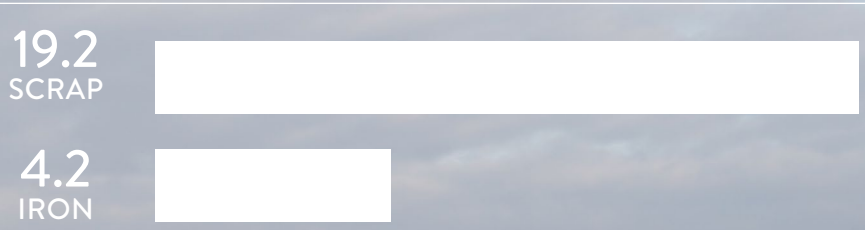
- Helps ensure consistent, sustainable regulatory compliance
- Drives continual improvement in environmental performance through effective internal audits and corrective actions
- Enables the achievement of meaningful environmental objectives to reduce emissions, conserve natural resources, and effectively manage waste streams
- Provides the framework to maximize teammate participation and involvement in the environmental interactions

ISO 14001:2004 CERTIFIED NUCOR FACILITIES

American Buildings Company – Atlantic
American Buildings Company – Midwest
American Buildings Company – South
American Buildings Company – West
CBC Steel Buildings
Gulf States Manufacturers
Kirby Building Systems
Nucor Building Systems – Indiana
Nucor Building Systems – South Carolina
Nucor Building Systems – Texas
Nucor Building Systems Utah, LLC
Nucor Castrip Arkansas, LLC
Nucor Cold Finish – Nebraska
Nucor Cold Finish – South Carolina
Nucor Cold Finish – Utah
Nucor Cold Finish – Wisconsin
Nucor Fastener – Indiana
Nucor–LMP, Inc.
Nucor Steel – Arkansas
Nucor Steel – Auburn, Inc.
Nucor Steel – Berkeley
Nucor Steel Birmingham, Inc.
Nucor Steel Connecticut, Inc.
Nucor Steel Decatur, LLC
Nucor Steel – Hertford
Nucor Steel – Indiana (including Castrip®)
Nucor Steel Jackson, Inc.
Nucor Steel Kankakee, Inc.
Nucor Steel Marion, Inc.
Nucor Steel Memphis, Inc.
Nucor Steel – Nebraska
Nucor Steel Seattle, Inc.
Nucor Steel – South Carolina
Nucor Steel – Texas
Nucor Steel Tuscaloosa, Inc.
Nucor Steel – Utah
Nucor-Yamato Steel
Nu-Iron Unlimited
Verco Decking, Inc.
Vulcraft – Alabama
Vulcraft – Indiana
Vulcraft – Nebraska
Vulcraft of New York, Inc.
Vulcraft – South Carolina
Vulcraft – Texas
Vulcraft – Utah

2013 ENVIRONMENTAL PERFORMANCE

RAW MATERIAL CONSUMPTION | MILLION TONS



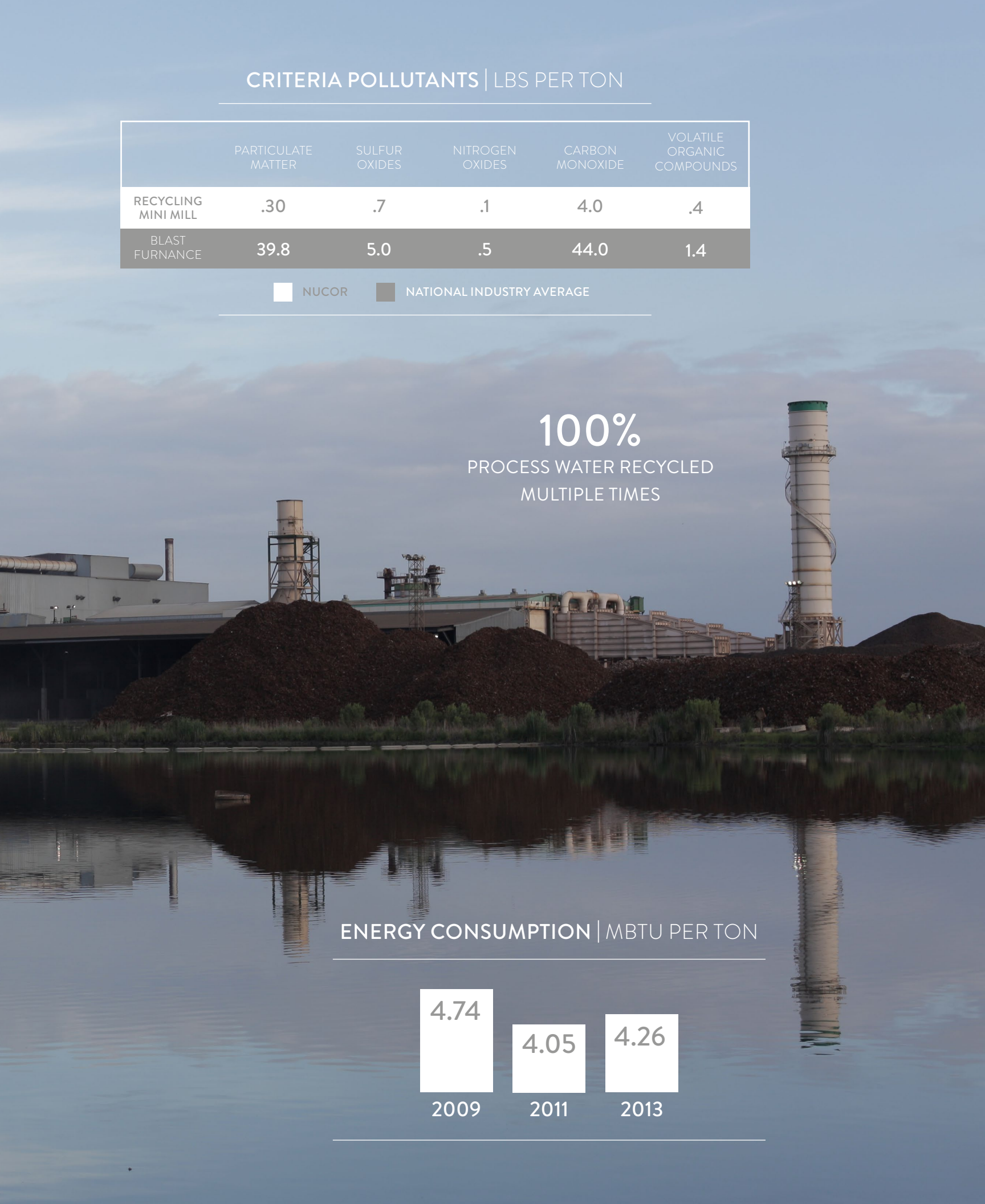
% OF EAF DUST RECYCLED

2007	2009	2011	2013
59%	87%	92%	99%

CRITERIA POLLUTANTS | LBS PER TON

	PARTICULATE MATTER	SULFUR OXIDES	NITROGEN OXIDES	CARBON MONOXIDE	VOLATILE ORGANIC COMPOUNDS
RECYCLING MINI MILL	.30	.7	.1	4.0	.4
BLAST FURNANCE	39.8	5.0	.5	44.0	1.4

NUCOR NATIONAL INDUSTRY AVERAGE



100%

PROCESS WATER RECYCLED MULTIPLE TIMES

ENERGY CONSUMPTION | MBTU PER TON

Tapping the Power of NATURAL GAS

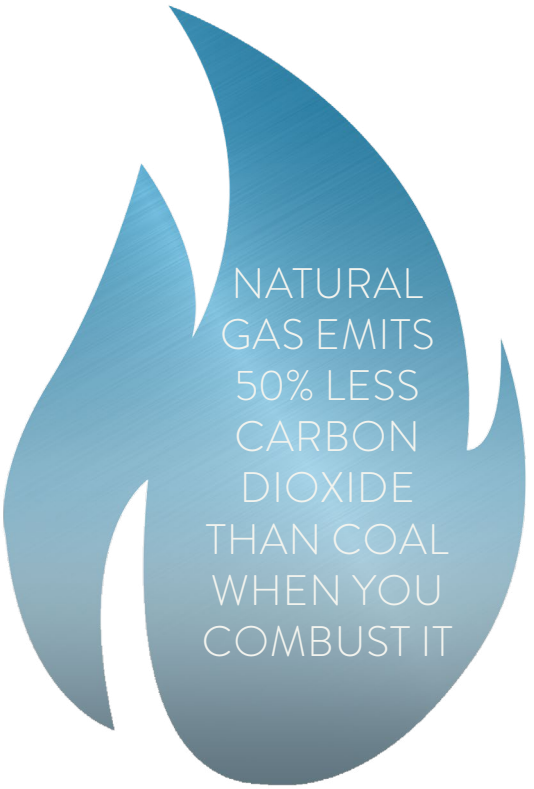
The United States has
2,718
trillion cubic feet of accessible natural gas, enough to meet America's diverse energy needs for
> 100 years

America's newfound abundance of natural gas is powering a renaissance in American manufacturing. Glass, steel, aluminum, and chemical manufacturers, among others, have announced hundreds of new projects totaling billions of dollars in new investments in recent years. American workers are already seeing dividends in the form of increased manufacturing employment, with more than 68,000 high-wage manufacturing jobs being created annually. But the benefits of natural gas aren't just economic. As the cleanest fossil fuel and a highly efficient energy source, natural gas reduces the environmental footprint of American manufacturers and makes them more sustainable.

Natural gas prices played a major role in our decision to locate our new direct reduced iron (DRI) plant in Louisiana. Natural gas is a huge input cost in making DRI, so natural gas prices make a significant difference. The plant we are operating today in Louisiana is the largest in the world and the first one to operate in the U.S. since 2009. Our new DRI plant is a $750 million investment that will produce critical raw materials needed for our steel operations and will employ 150 people full time. In the coming years, we are considering additional manufacturing investments at the same location on the Mississippi River.

Our efforts to take advantage of the natural gas revolution don't end there. Nucor has entered into an innovative agreement with the oil and gas company Encana to secure long-term access to low-cost natural gas. Under this agreement, we are sharing the cost of drilling new natural gas wells. The natural gas revolution is forging unique partnerships like this between manufacturers and the energy industry for the benefit of both the environment and our economy.

Nucor's Louisiana DRI facility will rely on this natural gas, and will nearly double our annual consumption. As a result, Nucor will be one of the largest consumers of natural gas in North America.



Nucor consumes 60 MILLION mmbtus/year total of natural gas – 1/2 of which will be used by our LOUISIANA DRI FACILITY

LITTLE THINGS **ADD UP**

It takes a lot of effort to separate trash down to the little plastic tops on aerosol cans. But that is what the teammates of Vulcraft of New York, Inc. have set out to do. They have made it a priority to segregate all of their waste streams. They have found this allows them to maximize recycling and the rebate that they get on their effort. It is a win-win for the environment and for the business.

Every day, teammates put their cans, plastic water bottles, aerosol cans, paper, and cardboard in separate boxes. The division's teammates are just as efficient on the production lines – recycling scrap metal, copper wire, aluminum, welding tips, and plastic sheets from rail cars. They receive payment on a little over half of the recycled items, the other half are recycled just because it is the right thing to do. These little efforts add up over time, like adding pennies to a piggy bank.

The program recycles

600 TONS

of trash per year, generating

$763,000

in revenues, to date

To date, this program has brought in revenues of $763,000, or about $117,000 a year, and enabled Vulcraft of New York to give a portion of the proceeds back to the community. This is around 600 tons of trash per year diverted from the landfill back into products. If the division was paying for these items to be disposed of as trash, it would have cost the facility approximately $78,256 to landfill the material. This is what a strong commitment to both the environment and business sustainability looks like up close.

Chip Hill, Vulcraft of New York, Inc.'s Environmental Technician, was the early founder of this program. "The goal was to educate the workforce on recycling opportunities at [the division] so that our teammates would take this practice and use it at home. We are also proud that this program allows us to serve our community by even donating our toner cartridges to Chemung Elementary School and monetary donations to local charities."

PLANT TUFF®

New Generation of Slag Products

Steel isn't the only product made at Nucor mills. The steelmaking process also produces a secondary product called slag. When cooled and processed, slag looks a lot like crushed limestone and shares many of the same physical and chemical properties.

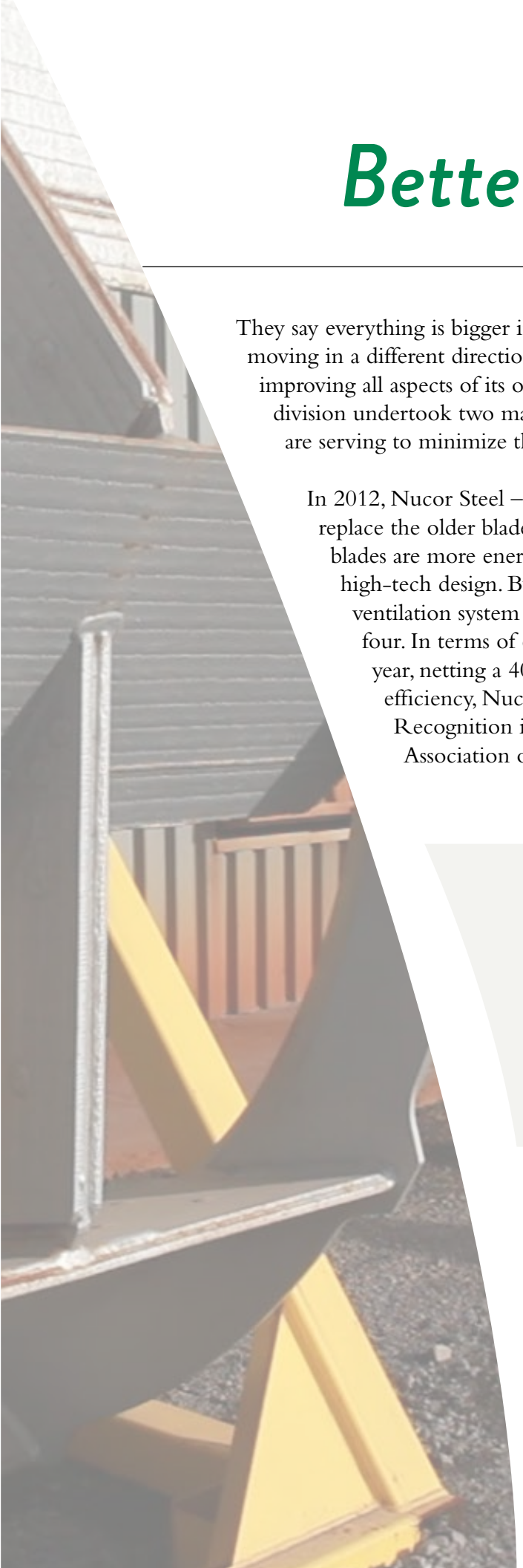
Nucor is always looking for new markets for slag and our Nucor Steel-Indiana division answered that call. Working with Edw. C. Levy Co., whose company roots are in agriculture, the two companies saw the elemental composition of slag as an opportunity to benefit the environment and the agricultural community. From that brainstorm, and a lot of research, came two new products: Plant Tuff® Silicon Fertilizer with Tuff Shield™ and Plant Tuff® AgLime. Here are just a few of the Plant Tuff Silicon Fertilizer with Tuff Shield benefits:

Plant Tuff Silicon Fertilizer with Tuff Shield

- Helps improve protection from insects & disease
- Helps reduce chemical use, making it child- and pet-friendly
- Helps develop larger, more expansive root systems
- Helps improve fertilizer efficiency & soil structure
- Helps with drought resistance, so less watering
- Helps conserve natural resources with its eco-friendly composition

While Nucor continues to work with the National Slag Association and others to demonstrate slag's benefits in new markets, Nucor's vendors and partners also continue their innovation with slag products. As a result, slag has been refined and innovated into new markets with increasing speed, benefiting many industries and markets at once.

To learn more about slag, visit the National Slag Association online at www.nationalslag.org.



Better, Not Bigger

They say everything is bigger in Texas. But Nucor Steel – Texas' environmental strategy is moving in a different direction. Like many of our mini mills, the Texas division is continually improving all aspects of its operations, including its environmental footprint. Most recently, the division undertook two major initiatives around its bag house and water cooling tower that are serving to minimize the mill's environmental impact, while also reducing operating costs.

In 2012, Nucor Steel – Texas undertook a bag house fan replacement project to replace the older blades with newer high-efficiency Airstream blades. These new fan blades are more energy efficient and require less maintenance due to their high-tech design. By replacing the fans, the mill improved the overall efficiency of its ventilation system by 29%, allowing for the operation of only three fans instead of four. In terms of energy, the new blades save 2,000 kW/h or 16,000,000 kW per year, netting a 40% reduction in energy costs. For its investment in environmental efficiency, Nucor Steel – Texas received both the Steel Manufacturers Association Recognition in Environmental Stewardship and Recycling Award and the Association of Iron and Steel Technology 2012 Energy Achievement Award.

OVERALL EFFICIENCY

of ventilation in the mill improved by

29%

Nucor Steel – Texas has also made a substantial investment in its water conservation efforts. Recently, the mill updated the drives on its non-contact water-cooling systems for both its melt shop and rolling mill. The division has also partnered with Linde Gas, a national provider of oxygen and nitrogen, to reuse their blowdown water discharge in their melt shop non-contact water-cooling tower to reduce groundwater reuse. The mill is actively reducing its public water usage by developing its second stormwater collection and reuse facility.

STANDOUT Achievements

"Every time I visit a mill, I visit the baghouse," says Chairman, CEO, and President John Ferriola. Here he is pictured visiting the baghouse with environmental teammates at Nucor Steel – Texas.

The President's Environmental Award

Nucor's environmental performance is a priority at the executive level, as it is core to both our mission and sustainability. From the boardroom to the melt shop, we are dedicated to environmental stewardship. The President's Environmental Award recognizes facilities with superior performance in a range of activities designed to preserve and conserve America's natural resources.

The award is given annually to Nucor divisions that achieve the highest levels of environmental performance. It is based on factors that range from exceptional compliance records to setting and achieving effective, realistic goals for environmental conservation. Protecting our environment is important to us, our teammates, and the communities in which we work and live.

Silver Crescent Manufacturing Excellence Award

In March of 2013, Nucor Steel – Berkeley was honored with the South Carolina Silver Crescent Manufacturing Excellence Award.

The Silver Crescent Award is the most prestigious award that a South Carolina manufacturer can receive. It is presented annually by the Silver Crescent Foundation, its partners, and the manufacturing community. The Award recognizes the most excellent manufacturing operations.

Honorees are chosen from a statewide slate of finalist companies nominated for superior performance in seven Crescents of Excellence:

- Environmental Stewardship
- Financial Performance
- Customer Satisfaction
- Employee Engagement
- Citizenship
- Innovation
- Longevity Plan for South Carolina

Awards are given to companies in three size categories – Small, Medium, and Large – for exhibiting strong economic impact, a commitment to workforce, and involvement in and contributions to their communities. Nucor Steel – Berkeley received the honor in the Large category.

Giff Daughtridge, Vice President and General Manager of Nucor Steel – Berkeley, announced the award to the team saying: "It feels very gratifying that manufacturing experts and civic leaders recognize the high level of integrity, loyalty, intelligence, and work ethic of our team. This is a great milestone as we continue on our path of continuous improvement."

AWARDS

A Selection of our Sustainability Awards 2012-2013

2012 Steel Manufacturers Association Achievement in Community Involvement Award
Nucor Steel Decatur, LLC; Nucor Steel Tuscaloosa, Inc.

South Suburban Chamber of Commerce 2012 Business of the Year
Nucor Cold Finish Wisconsin, Inc.

Mississippi Recycling Coalition's 2012 "Corporate Recycler of the Year" Environmental Hero Award
Nucor Steel Jackson, Inc.

New York State Department of Environmental Conservation Environmental Leadership Program
Nucor Steel – Auburn, Inc.

Mississippi Department of Environmental Quality EnHance Leadership Award
Clay Burton, Environmental Manager of *Nucor Steel Jackson, Inc.*

North Carolina Forestry Service Forestry Stewardship Award
Nucor Steel - Hertford

American Association of Community Colleges Outstanding Workforce Development Award
Nucor Detailing Center and Northeast Community College

2012 and 2013 CSX Chemical Safety Excellence Award
Nucor Corporation

Fort Payne Chamber of Commerce 2013 Large Business of the Year Award
Vulcraft – Alabama

2013 Steel Manufacturers Association Achievement in Community Involvement Award
Gulf States Manufacturers

2013 Steel Manufacturers Association Community Involvement Recognition Award
Nucor Steel – Berkeley; Nucor Steel Decatur, LLC; Nucor Steel Jackson, Inc.;
Nucor Steel – Nebraska; Nucor Steel Seattle, Inc.; Verco – Antioch

2013 Steel Manufacturers Association Environmental Stewardship and Recycling Recognition Award
Nucor Steel Seattle, Inc.; Nucor Steel – Texas; Nucor Steel Tuscaloosa, Inc.

2013 Steel Manufacturers Association Innovation Recognition Award
Nucor Steel Decatur, LLC

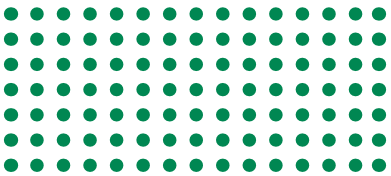
2013 Steel Manufacturers Association Achievement in Environmental Stewardship and Recycling Award
Vulcraft – Alabama

Over **118** NUCOR ENVIRONMENTAL PROFESSIONALS completed over **9,525** ENVIRONMENTAL COMPLIANCE TASKS in 2013.

8,000+ TASKS

Waste Sampling
Dust Inspection
Deep Well
Environmetrics
WDEQ Well Report
EMS O/T Report
AERF Submission
TRI Report
Lime Permit/Reg.
Scale Calibrate
Tire Report
PEA and Enviro
Drum Depot Insp.
SPCC Inspection
NSPS Records
Monthly Emission
001 Sample
Baghouse Gauges
Dust Col Inspect
Baghouse Inpect
HAZ STORAGE INSP
Fan Amps Weekly
Air Records
Monthly Scrap
Title V Certif
Radiation CAL.
Emrg Equip Insp
PTP pump oilers
Res. Stormwater
Spill Kit
Pressure Vessels
SWPPP
PEA Scorecard
Opacity Reader
Detention Pond
Collect Air Data
SARA 312 Report
New Hire Training
Backflow Test

105 NUCOR ENVIRONMENTAL PROFESSIONALS

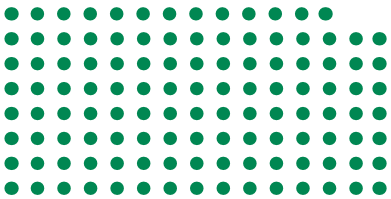


2011

9,525+ TASKS

Waste Sampling
Dust Inspection
Deep Well
Environmetrics
WDEQ Well Report
EMS O/T Report
AERF Submission
TRI Report
Lime Permit/Reg.
Scale Calibrate
Tire Report
PEA and Enviro
Drum Depot Insp.
SPCC Inspection
NSPS Records
Monthly Emission
001 Sample
Baghouse Gauges
Dust Col Inspect
Baghouse Inpect
HAZ STORAGE INSP
Fan Amps Weekly
Air Records
Monthly Scrap
Title V Certif
Radiation CAL.
Emrg Equip Insp
PTP pump oilers
Res. Stormwater
Spill Kit
Pressure Vessels
SWPPP
PEA Scorecard
Opacity Reader
Detention Pond
Collect Air Data
SARA 312 Report
New Hire Training
Backflow Test
Slag Inspections
WW Samples
Monthly DMR
Tank Inspections
Air Exceedance
ODS Review
SARA Tier II
EMS Mgt Review
Annual Stack Test
POTW Sampling
Annual VEO
Calib. Magnahelix
Title V Cert
Sanitary Survey
T-105 Drain Clean

118 NUCOR ENVIRONMENTAL PROFESSIONALS



2013

ENVIRONMENTAL PERFORMANCE INDICATORS

GRI NUMBER	DESCRIPTION	REPORTED	PAGE
MATERIALS			
EN1	Materials used by weight or volume.	Completely Reported	32
EN2	Percentage of materials used that are recycled input materials.	Completely Reported	32
ENERGY			
EN3	Direct energy consumption by primary energy source.	Partially Reported	33
EN5	Energy saved due to conservation and efficiency improvements.	Partially Reported	29, 37
EN6	Initiatives to provide energy-efficient or renewable energy based products and services, and reductions in energy requirements as a result of these initiatives.	Completely Reported	29, 34, 36, 37
EN7	Initiatives to reduce indirect energy consumption and reductions achieved.	Partially Reported	30, 31
WATER			
EN10	Percentage and total volume of water recycled and reused.	Partially Reported	33
EMISSIONS, EFFLUENTS AND WASTE			
EN20	NOx, SOx, and other significant air emissions by type and weight.	Partially Reported	33
EN22	Total weight of waste by type and disposal method.	Partially Reported	32, 35
PRODUCTS AND SERVICES			
EN26	Initiatives to mitigate environmental impacts of products and services, and extent of impact mitigation.	Partially Reported	34, 35, 60
OVERALL			
EN30	Total environmental protection expenditures and investments by type.	Partially Reported	29, 35

COMMUNITY RELATIONS

"Our teammates are hard-working, generous people who care deeply about the communities in which they live. In fact, most of our community efforts are teammate-led. They truly want to give back, and Nucor is thrilled to support them."

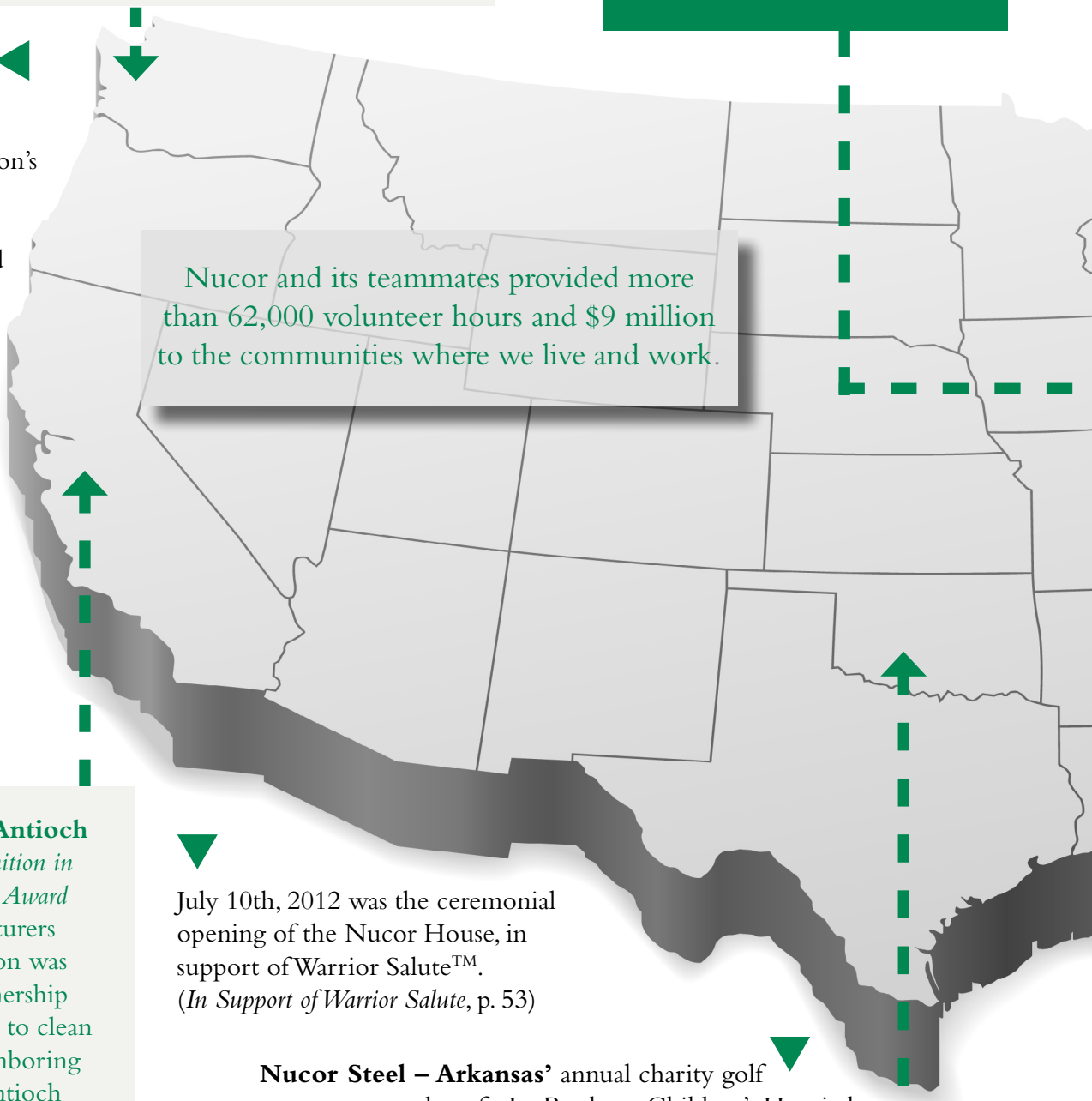
JOHN FERRIOLA
1991-PRESENT

IT'S OUR

Nucor Steel Seattle, Inc. and the West Seattle & Fauntleroy YMCA have formed a strong and long-lasting partnership. With Nucor's donation of $250,000 over a five-year period, the YMCA will be able to complete an $11 million renovation project. Walter Reese, Nucor Seattle, Inc.'s Controller, has been a member of the YMCA board of directors for the past nine years.

Nucor Steel Kankakee, Inc. donated and installed the Land Lubber's Pirate Ship Playground at the Kankakee Valley Park District's River Road Park.

In 2012, **Nucor** raised $574,000 for the American Cancer Society's Relay for Life through the organization's National Corporate Team Program. Nucor's 26 teams and 428 participants ranked third in the nation for estimated funds raised. (*The Heart and Soul of a Community*, p. 50)



Nucor and its teammates provided more than 62,000 volunteer hours and $9 million to the communities where we live and work.

Vulcraft – Utah and **Nucor Building Systems Utah, LLC** contributed to the construction of a new welcome sign for Brigham City, Utah. (*Community Welcome*, p. 51)

In April 2013, **Verco – Antioch** was awarded the *Recognition in Community Involvement Award* by the Steel Manufacturers Association. The division was recognized for its partnership with U.S. Fish & Wildlife to clean up and protect the neighboring California coastline Antioch Dunes National Wildlife Refuge.

July 10th, 2012 was the ceremonial opening of the Nucor House, in support of Warrior Salute™. (*In Support of Warrior Salute*, p. 53)

Nucor Steel – Arkansas' annual charity golf tournament to benefit Le Bonheur Children's Hospital raised $175,000 in 2013. (*A Round for Happiness*, p. 50)

In 2013, **Nucor Building Systems Utah, LLC** minted Challenge Coins inaugurating a new cultural initiative. The coins were presented at the division's Veterans Day Event. (*Carry it Forward*, p. 61)

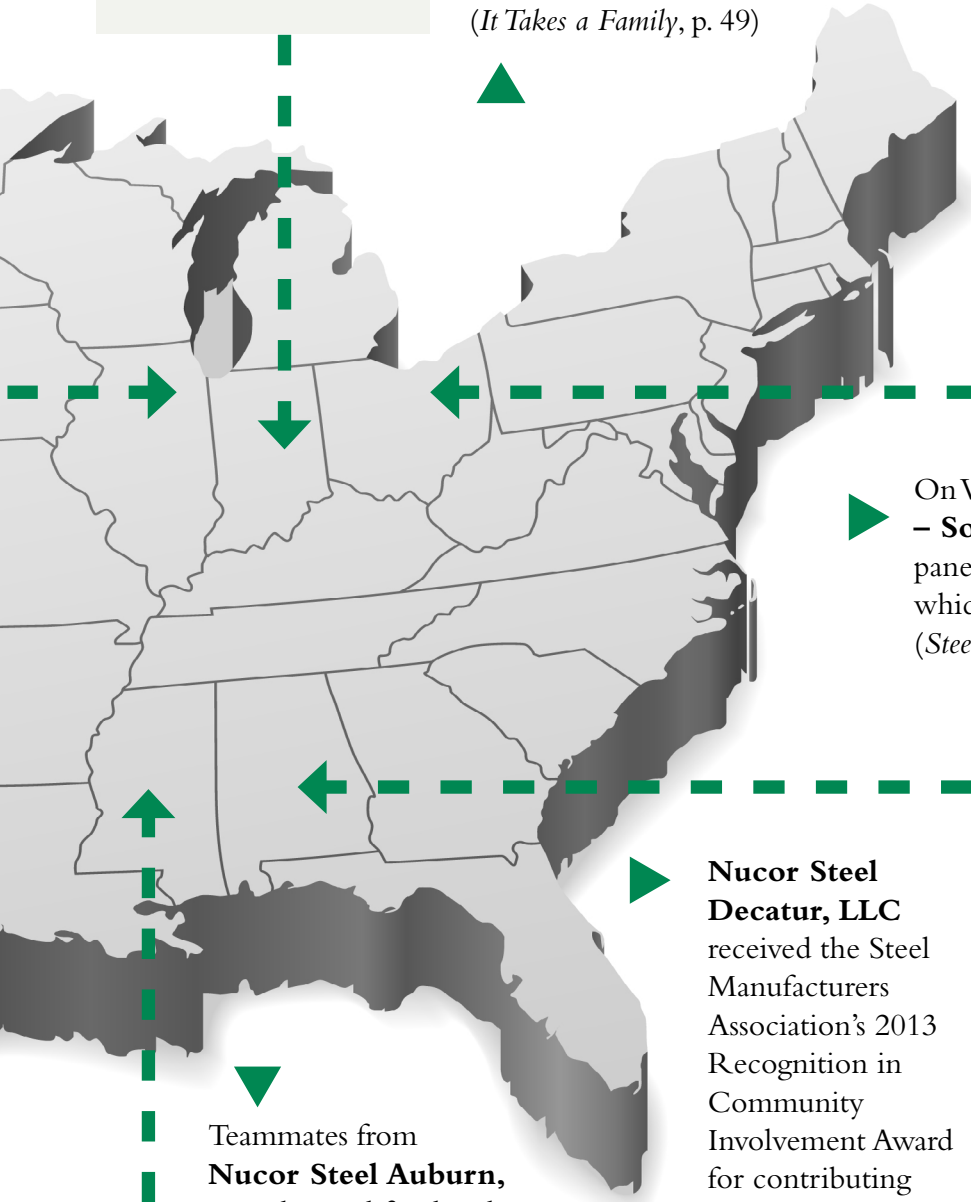
The towns of Moore and El Reno, Oklahoma were hit by tornadoes on May 20 and May 31, 2013. Following these catastrophic events, **Nucor Steel Decatur, LLC** partnered with Bank Independent to create the Oklahoma Tornado Relief Fund. The division pledged to match donations up to $10,000.

MAPPING PROGRESS

In September 2013, **Nucor Steel – Indiana** contributed $25,000 to the Montgomery County Chapter of the American Red Cross.

Spring 2013, Nucor Teammates from **Nucor Steel – Indiana, Castrip LLC**, and **Vulcraft – Indiana** designed, donated materials and helped build a bridge for Shelterwood Boarding School. (*It Takes a Family*, p. 49)

In late 2012, several teammates at the **corporate office** spent Red Shirt Friday signing more than 200 American Red Cross holiday cards in honor of our service men and women as a part of Nucor's Holiday for Heroes program. The cards were distributed to service members in the states and abroad. (*Red Shirt Fridays*, p. 53)



Nucor Steel Marion Inc. raised $131,639 (surpassing their goal of $104,000) at its fourth annual charity golf outing and reception to benefit Make-A-Wish Ohio, Kentucky, and Indiana.

On Veteran's Day 2012, **Nucor Building Systems – South Carolina** celebrated by dedicating a steel panel flag adorned with 50 hand-cut stars, 34 of which were dedicated to veterans from the division. (*Steel, Stars, and Stripes*, p. 52)

In 2012, every Nucor division in Alabama participated in the Simon the Loving Lion Challenge, raising more than $1.35 million to support the Children's of Alabama Hospital in Birmingham.

Nucor Steel Decatur, LLC received the Steel Manufacturers Association's 2013 Recognition in Community Involvement Award for contributing steel to Gulf States Manufacturers steel minutemen. (*In Honor of Veterans*, p. 52)

In June 2013, four of Nucor's Alabama divisions – **Nucor Steel Decatur, LLC, Vulcraft – Alabama, Nucor Steel Tuscaloosa, Inc.**, and **DJJ Birmingham** – rallied together to fight Multiple Sclerosis with Bike MS: North Alabama. Nucor's team of 22 raised over $16,000.

Teammates from **Nucor Steel Auburn, Inc.** donated food and supplies to victims of Hurricane Sandy. (*Hurricane Sandy*, p. 47)

In 2013, **Nucor Steel Jackson, Inc.** and **General Recycling** sponsored Mississippi Blood Services' newest donor coach, a mobile blood donation unit.

Nucor Steel Jackson, Inc. donated $33,000 to the Mississippi Organ Recovery Agency.

PUTTING OUR MONEY WHERE OUR HEART IS

At the heart of every Nucor facility are the dedicated people who make up our team. But more importantly, these teammates make up the heart of the local communities that our divisions are proud to call home.

A core part of our corporate mission is to be cultural and environmental stewards in the communities where we live and work. And to us, it's not just about giving back, it's about diving in and being part of our communities. From schools, parks, and charitable organizations to disaster relief efforts, investing in our communities is an important part of what we do.

We believe the strength of a business is a reflection of the community that supports it. As it turns out, we operate in some of the best communities around.

During 2013, Nucor and its teammates were grateful for the opportunity to provide more than 62,000 volunteer hours and $9 million to the communities that support us.

62,453
HOURS OF VOLUNTEER WORK
= 33
FULL-TIME EMPLOYEES

$146,482 ENDOWMENTS FOR PROFESSORS/COLLEGE SCHOLARSHIPS	**$2,092,189** DIRECT CONTRIBUTIONS TO COLLEGES/UNIVERSITIES	**$4,470,034** DIRECT CONTRIBUTIONS TO CHARITIES
$1,789,055 RAISED THROUGH CHARITY EVENTS	**$880,800** RAISED THROUGH TEAMMATE CONTRIBUTIONS	**$9,378,560** TOTAL CONTRIBUTIONS

HURRICANE SANDY

How the Nucor Way Turned the Tide for a Devastated Community

Nucor is known for having an employee-centered, community-minded culture. The core values that define this culture – things like teamwork, personal responsibility, and treating people the right way – are known around Nucor as the Nucor Way. These principles guide how we work together and, perhaps more importantly, how we operate outside of work in our homes and communities.

In an article written in the Fall 2013 edition of the Nucor News, Nucor's quarterly teammate newsletter, Chairman, CEO, and President John Ferriola, described the Nucor Way as a "competitive advantage" for Nucor, a foundational strength that has sustained the company for more than 40 years, regardless of economic climates, strategic focus, or industry changes. In doing so, Ferriola reminded his readers that the real key to Nucor's success is them: the people of Nucor.

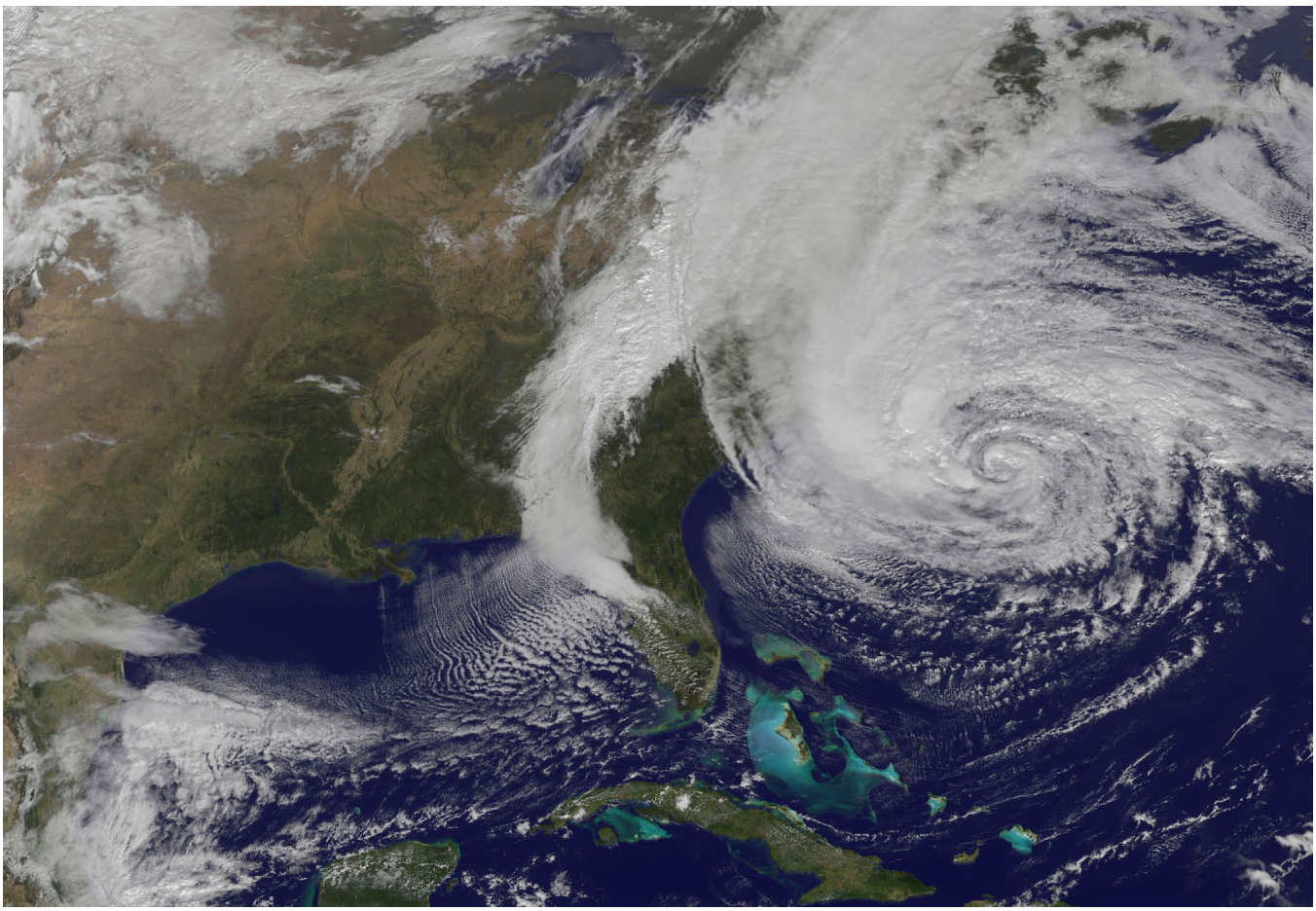
Soon after the edition was published, a heartwarming response came from an unexpected place. While reading Ferriola's article, Christine Errico was overwhelmed as she recalled how the Nucor Way had affected her and her family in the aftermath of Hurricane Sandy. Living on the Jersey Shore, Christine's family experienced the impact of Sandy firsthand, losing most of their food and sustaining damage to their home and utilities. Soon after, Christine's husband, a Nucor Steel Auburn, Inc. teammate, called to tell her that some fellow teammates were gathering supplies and planned to drive them from Auburn to help the Erricos.

> "We had enough supplies for neighbors, friends, and family to stay with us – to stay warm, eat, shower, and feel safe...doing it the Nucor Way is an advantage no one else can imitate."

In her letter to Nucor, Christine recalls, "Six hours later they arrived with the car filled to the brim with a generator, gas containers, tons of groceries, batteries, flashlights, and lots of TLC." She went on to explain, "What Nucor didn't know was that the next two weeks they [helped] multiple families in our town that were not prepared for the storm. We had enough supplies for neighbors, friends, and family to stay with us – to stay warm, eat, shower, and feel safe….

All I can say is we are truly blessed to be a part of the Nucor family. I agree with Mr. Ferriola… doing it the Nucor Way is an advantage no one else can imitate."

The Erricos' story is a clear example of how the Nucor Way is not just a way to work, but a way of life for Nucor teammates. It is a commitment that extends beyond the walls of Nucor's facilities, not to mention city lines.



In October 2012, Hurricane Sandy pounded the eastern seaboard of the United States. The hurricane ranked as the most destructive hurricane of 2012 and the second most costly hurricane in the nation's history.

It Takes a Family

Ask any Nucor teammate why they love Nucor, and they'll tell you about being part of a family. But for us, the family includes our customers, communities, and industry partners because we know that great things happen when we work together.

Shelterwood is a therapeutic boarding school located near Kansas City, Missouri. Founded in 1980, the school provides life-changing therapy and a safe, structured environment for at-risk teens.

During the spring of 2013, Nucor teammates from Castrip LLC and Nucor Steel – Indiana were visiting the school when they learned of the school's dream to build new outdoor recreation facilities, including a low ropes challenge course and trails for hiking and biking. There was just one problem: the new plans required a 32-foot bridge, which challenged the school's limited resources. But in typical fashion, the Nucor teammates saw an opportunity and got to work bringing the Nucor community together.

Back in Indiana, Nucor enlisted the generous help of David Emerson, a professional engineer at Nucor Steel – Indiana. Soon after, Mark Johanningsmeier, also a professional engineer, and Rick Stiver from sister division Vulcraft – Indiana, offered to design and build the bridge. When Vulcraft – Indiana's fastener supplier, Fastenal, volunteered to donate any needed fasteners, Shelterwood's vision was nearly a reality.

The only remaining challenge was getting the structure from northeastern Indiana to western Missouri. Braeden Terrell, the owner of Mooresville, Indiana transportation company Quick-Shot, heard about the project and generously offered to transport the bridge parts at no cost in honor of his late father, Dan Terrell. The bridge parts arrived at Shelterwood on July 9th, and on July 14th, a team of Nucor families, Shelterwood staff, and Home Depot volunteers gathered to complete construction of the bridge.

Some people say "it takes a village." At Nucor, it just takes a family.

The *Heart and Soul* of a COMMUNITY

For several years, a growing number of Nucor facilities have participated in the American Cancer Society's Relay for Life events. Relay for Life raises money to fight cancer through team-based fundraising walk events and boasts more than 4 million participants in over 20 countries. In addition to raising money, these events celebrate cancer survivors and what they have overcome, remember those who have been lost to the disease, and honor those who have fought or are fighting cancer.

Recently, Relay for Life developed the National Corporate Team Program in order to engage the participation of larger companies. The program has successfully built thousands of teams from within some of America's largest companies, including Nucor Corporation.

NUCOR RAISED
$574,000
with 428 participants and 26 teams

In 2012, Nucor's participation in the National Corporate Team Program ranked third in the nation, pledging $574,000. By way of comparison, the top two corporate teams in 2012 pledged a combined $3 million through 20,629 participants and 2,123 teams, averaging $145 per participant. Nucor's $574,000 was pledged through only 428 participants and 26 teams from several Nucor divisions, averaging $1,341 per participant. Karen Woldahl, co-captain of Nucor Steel Decatur, LLC's Relay for Life team, explained, "I had been very involved in Relay for several years, but when Nucor became part of the National Corporate Team Program, it opened my eyes to the impact we were making on a much larger scale."

A Round for Happiness

Le Bonheur Children's Hospital in Memphis, Tennessee is recognized as one of the best children's hospitals in America. Since opening in 1952, the hospital – whose name means Happiness – has been dedicated to providing complete medical care to children and advocating for the well-being of every child it serves.

Since 1999, Nucor Steel – Arkansas has held an annual charity golf tournament to benefit Le Bonheur. Attended by customers, suppliers, and employees from across the country, the event has raised more than $1 million since its inception, including $175,000 in 2013.

The Arkansas division has a special connection to Le Bonheur, as many teammates' children have received critical care from the hospital. Nucor Vice President and General Manager Sam Commella explained: "We have seen first-hand how vital Le Bonheur is to our community.... We are honored to be part of their important mission."

COMMUNITY WELCOME

Investing in the Communities We're Proud to Call Home

New welcome sign in Brigham City, Utah.

On September 5th, 2012, the ribbon was cut in commemoration of the new welcome sign in Brigham City, Utah. The project – a collaboration between city administrators and local Rotary Club leaders – was made possible by the support of several local businesses, including Nucor facilities in the Brigham City area.

The project was spearheaded by structural engineer and past-president of the Brigham City Rotary Club, Jim Moore. Jim teamed up with Vulcraft – Utah's Larry Boyer, who coordinated the production of the sign's metal arch, which was donated by the division. Additionally, Nucor Building Systems Utah, LLC created and donated the "Welcome" plate that is mounted at the center of the sign's arch.

In Honor of Veterans

We believe that sustainable businesses can't exist without sustainable lives and communities. One way we embody this belief is through our long-standing tradition of supporting the members of the United States Armed Forces. When our teammates are called to action, we gladly hold their jobs, supplement their military pay to match their Nucor salaries, and extend their benefits while away. We also recruit veterans when hiring, valuing the strong character developed when serving one's country. Nucor salutes America's service men and women, and considers it an honor to serve them when they come home.

Nucor Steel Decatur, LLC received the Steel Manufacturers Association's 2013 Recognition in Community Involvement Award for contributing steel to Gulf States Manufacturers steel minutemen, which are made to show support for American military personnel. A minutemen cutout stands at the entrance gate of Nucor Steel Memphis, Inc. in honor of America's service men and women.

STEEL, STARS, AND STRIPES

On Veteran's Day 2012, Nucor Building Systems – South Carolina celebrated by dedicating a steel panel flag adorned with 50 hand-cut stars, 34 of which were dedicated to veterans from the division. General Manager John Hollatz remarked: **"We are proud to have products made in America by those who have served America."**

In Support of Warrior Salute

Nucor teammates and community members gather on July 10, 2012, for the ceremonial opening of the Nucor House. Residents moved in Friday, July 6th, 2012.

Nucor has been a long-time supporter of Warrior Salute™, a service that provides employment opportunities, clinical and rehabilitative therapies, and other support services to veterans with post-traumatic stress disorder or traumatic brain injury.

Nucor's support helped create the organization's first transitional home for veterans, the 14-bed Nucor House near Rochester, New York. The house provides a temporary residence for veterans and their families for the duration of the program, along with peer support, 24-hour care, and clinical services. The house opened on July 6, 2012, after months of renovations and preparations for residents.

RED SHIRT FRIDAYS

For several years, Nucor has actively participated in Red Shirt Friday, a growing movement of support for America's service men and women. Red Shirt Friday participants wear red on Fridays to honor the sacrifice our military makes for our nation and to show solidarity with troops at home and abroad.

CUSTOMER RELATIONS

"These are exciting times for Nucor, as our company grows stronger and stronger. A stronger Nucor is one that is continually improving its capability to take care of all of our customers, the people who buy and use our products, our teammates, and our shareholders."

JOHN FERRIOLA
1991-PRESENT

IT'S OUR

STEELY RENEWABLES

Sustainable Steel Makes Sustainable Energy, and Vice Versa

"There are so many different moving parts to a renewable project. Whether it is a one megawatt or 1,000 megawatt project, Nucor has an opportunity to participate," says Joe Cerchiaro, Marketing Manager for the Power, Energy, and Infrastructure team of the Nucor steelmaking group. Nucor is predominantly focusing on solar and wind projects, where we are supplying a wide and expanding variety of steels. What could be more fitting than using recycled steel to produce renewable energy?

While solar panels are known mostly for their silicon cells, they also require steel. The silicon cells, which join together to form a circuit, are typically held together in a steel frame, as well as securely mounted by steel to a roof or other surface. A variety of Nucor steels fit the bill for solar. For example, Nucor Steel Marion, Inc. has used their signpost fabrication technology to create steel posts ideal for solar panels, and Nucor Building Systems is roll-forming steel sheet for use as framing material. Additionally, Nucor Steel – Berkeley provides W6 beams to customers who produce mounting systems for photovoltaic solar fields. These beams are the base of mounting systems and support solar panels. We will continue to find ways to meet the needs of the solar companies who are working hard to meet America's growing energy demands.

As with solar, Nucor is positioned to provide high-quality, environmentally-friendly steel to the wind market. There are approximately 200 tons of steel in every wind tower: 150 tons of plate, 10 tons of rebar, a few hundred pounds of steel fasteners, plus the specifically engineered, high-strength, low-weight steels used in the high-tech turbines. The Nucor family of steelmakers and fabricators are uniquely positioned to provide the wide variety of steels and technical expertise needed for these complicated projects.

Nucor's involvement in building America's energy future doesn't stop with generation projects. The energy distribution system involves large amounts of steel, and Nucor fulfills the needs of its customers with a variety of energy distribution products. Most recently, Nucor has been working to offer recycled steel poles in place of traditional wood transmission poles. This "wood to steel" initiative has many benefits to local governments and customers: steel transmission poles have a longer life, are more durable, and are more environmentally friendly. Instead of consuming trees, Nucor's poles are made from 98% recycled steel.

We look forward to continuing to support the growth of America's renewable energy sector. After all, **it's our nature.**

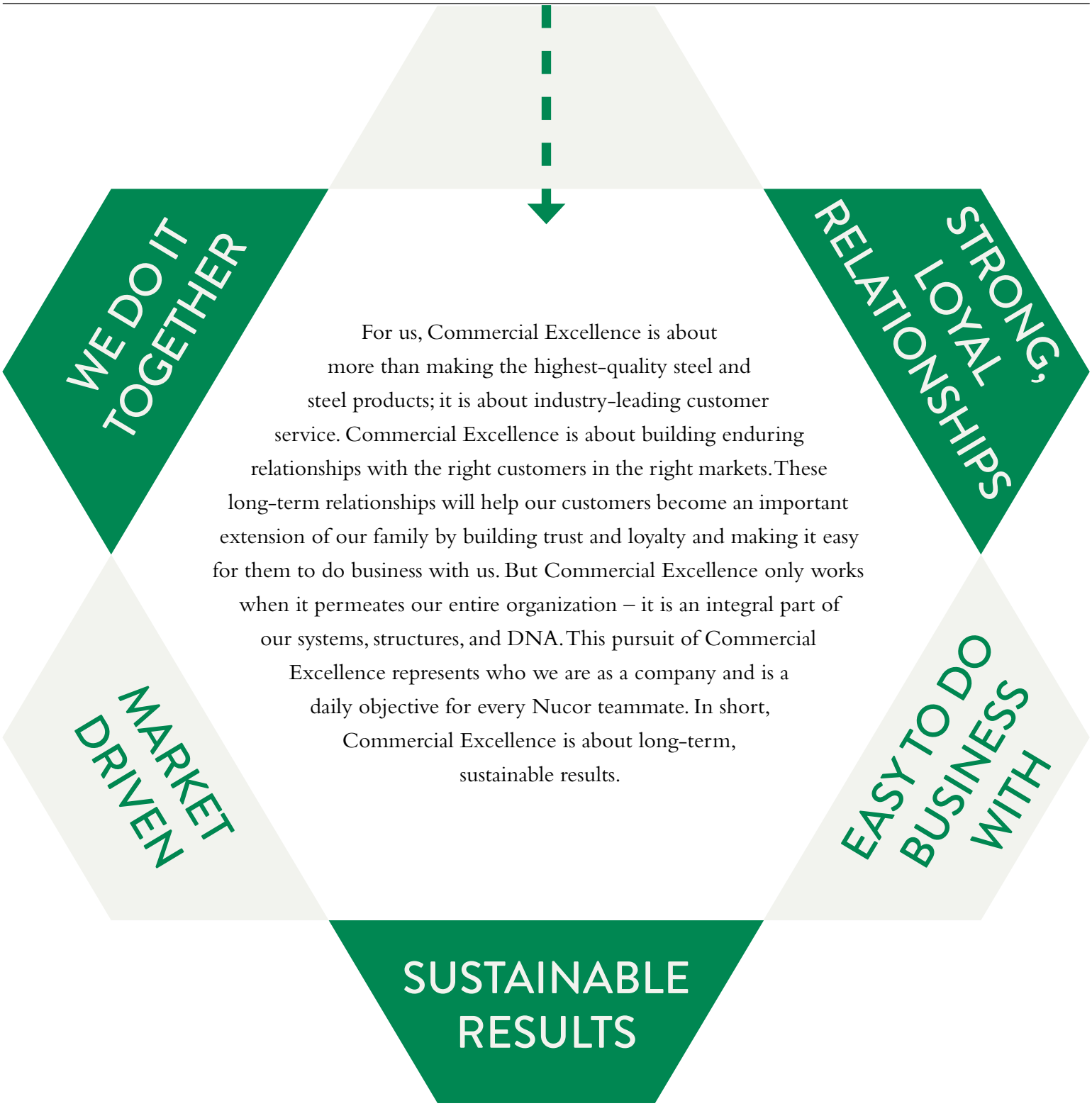
WOOD TO STEEL INITIATIVE

Instead of consuming trees, Nucor's poles are made from approximately

98%

recycled steel

CONTINUING TO **FOCUS** ON COMMERCIAL EXCELLENCE



For us, Commercial Excellence is about more than making the highest-quality steel and steel products; it is about industry-leading customer service. Commercial Excellence is about building enduring relationships with the right customers in the right markets. These long-term relationships will help our customers become an important extension of our family by building trust and loyalty and making it easy for them to do business with us. But Commercial Excellence only works when it permeates our entire organization – it is an integral part of our systems, structures, and DNA. This pursuit of Commercial Excellence represents who we are as a company and is a daily objective for every Nucor teammate. In short, Commercial Excellence is about long-term, sustainable results.

Open For Business

Nucor Steel Louisiana LLC is the Largest, Most Efficient DRI Plant in the World

"The domestically produced high quality DRI produced at Nucor Steel Louisiana reduces our dependence on imported iron. We are creating domestic jobs that support our long-term goal of securing our raw material stream. The high quality iron gives Nucor's steel mills the opportunity to introduce recycled steel into new markets."

– Steve Rowlan, Director of Environmental Affairs at Nucor

On Christmas Eve 2013, Louisiana's newest industrial business – Nucor Steel Louisiana LLC started production at its new direct reduced iron (DRI) plant in St. James Parish. The company broke ground on the project three years ago and has since transformed a field of sugar cane into the home of the largest DRI plant in the world, and the first one to operate in the U.S. since 2009.

DRI is a raw material used in our mini mill steelmaking process. While scrap metal will continue to be our main steelmaking feedstock, producing our own DRI gives Nucor greater flexibility to respond to changes in scrap prices. Nucor now has the ability to choose the most cost effective iron unit depending on market conditions for scrap and DRI. This flexibility is a key ingredient to our long-term efficiency and sustainability.

Nucor's Louisiana plant uses natural gas to heat iron ore and convert it into high-grade metallic iron. We then ship the DRI to our mills, where it is used in the steelmaking process to produce high-quality steel products like sheet, plate, and special bar quality steels that are used to build cars, trucks, bridges, and appliances. The plant's location on the Mississippi River is ideal for bringing in iron ore and shipping DRI out to Nucor's steel mills.

Nucor has formed a partnership with Encana Oil and Gas, providing access to a reliable, low-cost supply of natural gas. This partnership will ensure we can continue to produce DRI in a clean, efficient and sustainable way long into the future. Natural gas that is produced with Encana will be sold to offset the cost of gas used at the DRI plant and our steel mills.

Operations in the early phase of production at the Louisiana division have gone extremely well, with the plant producing excellent quality DRI. The first shipment of DRI left the plant less than a week after starting production. These results are a testament to the hard work, skill, and dedication of Nucor's 140 Louisiana teammates.

Nucor has had a long-standing commitment to American manufacturing and its workers, and we are proud to be able to create these high-quality manufacturing jobs in Louisiana and our country. Nucor is on track to reach 150 teammates at the facility by 2015.

With its excellent business climate, quality workforce, and access to the Mississippi River and Gulf of Mexico, Louisiana is a great place for Nucor to call home.

WHY WE DON'T TAKE **WEIGHT** LIGHTLY

How Nucor is Making Steel Lighter and Stronger

"Less is more," as the saying goes. This is especially true if you are in the heavy equipment industry, where there are substantial benefits to reducing the weight of the equipment. As heavy equipment like combines and tractors get larger, manufacturers are facing increasing demand to reduce the weight of the machinery without compromising its strength or durability. Combines, for instance, have gotten so large that their weight makes them prone to getting stuck in mud. And while their size increases operational efficiency, reducing their weight is a must in order to maintain maneuverability. With the automotive industry, Corporate Average Fuel Economy (CAFE) standards are driving demand for lower-weight cars and trucks; with every pound shaved, fuel consumption is reduced and cost savings are realized over the long term.

But manufacturers aren't just looking to lighten the load of their heavy equipment. They must maintain strength and durability. That's why, for years, Nucor has worked with manufacturers – especially in the automotive sector – to develop lighter, stronger, and more durable steel products. This has lead to innovative products like our NuHeat and NuStrength steels and our Cold Rolled Motor Lamination (CRML) steel.

The applications are vast and quickly growing. Cargo ships, for instance, can be as long as four football fields and weigh 220,000 tons, with the average trans-Atlantic trip consuming as much as 200,000 gallons of heavy fuel oil. Lighter, high-strength Nucor steel products can help reduce fuel consumption and costs while increasing sustainability for end-users. The same is true in the electrical steel category, where motor designers for products like hybrid cars are working hard to maximize the efficiency of their motors. In the end, we aren't just working to be a more sustainable Nucor, we are working to provide solutions that help our customers increase their own sustainability.

CARRY IT *FORWARD*

Challenge Coins and the Currency of Quality

The concept of challenge is an essential part of Nucor's cultural DNA. It embodies our drive for continual improvement, motivates us to innovate and be a leader in our industry, and underpins our mission to take care of our customers. We are constantly challenging ourselves to be the best and to keep getting better.

But on Veterans Day 2013, the word *challenge* took on a new and significant meaning for the teammates at Nucor Building Systems Utah, LLC. Earlier that year, Nucor Building Systems President Jeff Carmean had issued a quality challenge to promote a culture of quality at the division. The idea was that quality means more than simply doing what we're asked. Rather, quality is a mindset, a commitment to going above and beyond, and the result of a team dedicated to taking care of its customers and each other.

It did not take long for the teammates to build on Jeff's challenge in a unique way. Because many of the division's teammates are veterans, the word *challenge* quickly brought to mind the military tradition of challenge coins. Challenge coins date back to at least ancient Rome, when soldiers who performed exceptionally well received specially minted coins as a bonus, which they often kept as mementos instead of spending. Today, the tradition continues in the United States military, where coins are carried and displayed as badges of honor and tokens of solidarity.

Soon, many of the Utah teammates began carrying and displaying the challenge coins they had acquired during their own military service. The coins quickly generated interest among many of the division's teammates. As they caught on, the team decided to design and mint their own challenge coin as a way of inaugurating the new cultural initiative. The coin was to be presented at the division's upcoming Veterans Day event.

The Veterans Day event was well attended by both local veterans and Nucor teammates.

The event was well attended by teammates and veterans from a 40-mile radius, some of whom had served in World War II. Teammate and former United States Army soldier Dana Christensen, who presented the coin on Veterans Day, wanted to honor those whose legacy was providing freedom for current and future generations. Christensen recalled: "These men and women represent a legacy of quality: leading good lives, working hard, and preserving the American quality of life. Today, we are the 'future generations' they served for, so how are we going to carry that legacy forward?" Dana and his fellow teammates have clearly answered that call.

Keith
Aaron

GOVERNANCE

"We are not waiting for things to turn around. We are finding ways to grow our company and be successful despite the lackluster economy by continually looking for ways to improve our performance and lower our costs. We are investing in projects that will move us up the value chain and providing superior customer service."

JOHN FERRIOLA
1991-PRESENT

IT'S OUR

NUCOR GOVERNANCE

Holding Ourselves to the Highest Ethical Standards

Nucor's culture is one that respects the individual. The open door policy of all of our locations fosters a culture where all participate and contribute to the progress of the company. Our teammates, neighbors, and shareholders should always be treated fairly, honestly, and respectfully. At the same time, we – that's everyone in our company – should conduct ourselves according to the highest ethical standards. As a result, all of our teammates are accessible and accountable.

Learn more at: www.nucor.com/governance

One of Nucor's guiding principles is to encourage our teammates to treat other people the way you would want to be treated. We make sure everyone has the right tools, resources and training to get the job done, and then we get out of their way. And when we make a mistake, we learn from it and move forward. We want people to take ownership of challenges, not fear them.

We're all in it together as a team.

Governance Principles

Nucor's governance principles provide a framework for the composition, operation, and responsibilities of the board of directors.

Standards of Business Conduct and Ethics

Nucor's reputation and success rely on the ethical conduct of our employees, officers, and directors. Our standards include, but are not limited to, abiding by all guidelines to avoid giving or receiving gifts for the improper influence of our business, avoiding and disclosing conflicts of interest, ensuring that political contributions are in compliance with state and federal regulations, ensuring the proper use of company assets, and reporting in a transparent manner.

Supplier Code of Conduct

Nucor requires its suppliers to comply with high standards of social responsibility. This code of conduct prohibits the use of forced and child labor and requires suppliers to treat employees with dignity and respect, free from unlawful discrimination. Nucor's suppliers must provide fair and lawful wages and benefits to their employees. In addition, Nucor expects each of its suppliers to minimize their environmental footprint and conduct business in accordance with high ethical standards. Suppliers must maintain documented compliance with this code to continue doing business with Nucor.

Committee Responsibilities and Charters

Nucor's board of directors has three standing committees – Audit, Compensation and Executive Development, and Governance and Nominating. These committees operate in accordance with written charters, which have been adopted by the board of directors. Stockholders may communicate with the board of directors, or any of its independent directors, by sending correspondence to Nucor's corporate office in the care of the corporate secretary.

Code of Ethics for Senior Financial Professionals

This code is a supplement to the Standards of Business Conduct and Ethics and is designed to deter wrongdoing and promote honest and ethical conduct by Nucor's senior financial officers and CEO. The code applies specifically to the preparation and oversight of financial information used in reporting to the Securities and Exchange Commission and other public and private stakeholders.

KEY FINANCIAL DATA

Financial Highlights (in Thousands, Except Per Share Data)

FOR THE YEAR	2013	2012	2011
NET SALES	$19,052,046	$19,429,273	$20,023,564
GROSS MARGIN	$1,410,625	$1,513,538	$1,881,420
NET EARNINGS ATTRIBUTABLE TO NUCOR STOCKHOLDERS	$488,025	$504,619	$778,188
NET EARNINGS PER SHARE, DILUTED	$1.52	$1.58	$2.45
DIVIDENDS DECLARED PER SHARE	$1.4725	$1.4625	$1.4525
CASH PROVIDED BY OPERATING ACTIVITIES	$1,077,949	$1,200,385	$1,031,053
NET INCOME TAXES PAID	$64,800	$313,500	$322,400
AT YEAR-END			
WORKING CAPITAL	$4,449,830	$3,631,796	$4,312,022
PROPERTY, PLANT, AND EQUIPMENT, NET	$4,917,024	$4,283,056	$3,755,604
LONG-TERM DEBT	$4,380,200	$3,630,200	$4,280,200
STOCKHOLDERS' EQUITY	$7,645,769	$7,641,571	$7,474,885

Nucor announced its **163rd** consecutive cash dividend in the fourth quarter of 2013.

POSITION OF STRENGTH

Nucor's Five-Pronged Strategy for Profitable Growth

OPTIMIZATION OF EXISTING OPERATIONS	1
INVESTMENT IN RAW MATERIALS	2
GREENFIELD GROWTH IN NEW TECHNOLOGIES AND MARKETPLACE NICHES	3
INTERNATIONAL GROWTH THROUGH JOINT VENTURES	4
PURSUIT OF STRATEGIC ACQUISITIONS	5

Learn more about our operations and financial reporting at:

www.nucor.com/investor

CONFLICT MINERALS

The Dodd-Frank Wall Street Reform & Consumer Protection Act

In August 2012, the U.S. Securities and Exchange Commission (SEC) issued final rules implementing the Conflict Minerals Provision of H.R. 4173 (Dodd-Frank Wall Street Reform & Consumer Protection Act, Section 1502).

Under the new rules, the SEC requires all publicly traded companies to disclose and report their use of metals derived from "conflict minerals" originating from the Democratic Republic of Congo and nine adjoining countries when their use is not from recycled or scrap sources and is necessary to the function or production of manufactured products.

The SEC's exemption of recycled and scrap material from the conflict minerals rule is consistent with international guidance on responsible supply chains of minerals from conflict areas developed by the Organization for Economic Cooperation and Development (OECD). The use of recycled and scrap material helps sustainability efforts by decreasing the demand for mining of virgin minerals in the covered countries and throughout the rest of the world.

STEPS TAKEN

Developed a scoping process utilizing expertise of teammates at each of its manufacturing operations.

Evaluated vendors for 2013 using scoping document to determine which of them may have sold Nucor a product covered by the SEC final rule.

Surveyed vendors using the Electronics Industry Citizenship Coalition and Global e-Sustainability Initiative conflict minerals reporting template.

In the few cases where a vendor's product may have contained conflict minerals, Nucor received representations from the vendors that no conflict minerals originated in covered countries.

Scrap metal and scrap substitutes are the most significant element in Nucor's total cost of steel production and the largest raw material inputs into its finished steel products. Scrap metal used by Nucor is sourced from post-industrial or post-consumer scrap, melted in electric arc furnaces and poured into continuous casting systems to produce new steel.

Nucor conducted a good faith inquiry regarding its material inputs and the manufacturing of its steel products. As a result, Nucor believes that a very small portion of its products manufactured in 2013 contain conflict minerals that may have been necessary to the functionality or production of its products. However, based on its reasonable country of origin inquiry process, Nucor has no reason to believe that the conflict minerals may have originated in covered countries or that they did not come from recycled or scrap sources.

Nucor plans to implement additional steps to reduce the risk that any necessary conflict minerals will be sourced from the covered countries, including amending its supplier code of conduct to address Nucor's expectation that its vendors will not source conflict minerals used in its products from mines in those areas.

DOING OUR PART
TO END FORCED LABOR

Nucor's most valuable asset is our people. We go to great lengths to show them the care, dignity, and respect they deserve. That is why Nucor is also making every effort to ensure forced labor is eliminated from our supply chain.

One of our key areas of focus is Northern Brazil, which is the source of one of Nucor's significant feedstock ingredients – pig iron. Pig iron is an intermediate iron product that is created by smelting raw iron ore at high temperature with a carbon-reducing agent. In Northern Brazil, this agent is often charcoal.

The charcoal production process in Brazil is very labor intensive and takes place in relatively remote and inaccessible areas. In some cases, charcoal production has created difficult working conditions – at times falling to the level of forced labor.

Nucor has taken a proactive approach to help ensure that the charcoal used to make our pig iron does not come from forced labor, including:

- Nucor requires each pig iron manufacturer that ships product to Nucor to certify that its pig iron was manufactured without the use of involuntary labor.
- Nucor retains a Brazilian law firm to monitor the Brazilian Labor Ministry's Black List of firms that have been found to use forced labor. We then remove these firms from our list of acceptable suppliers.
- Nucor requires that all of our suppliers of charcoal-based pig iron in Northern Brazil either belong to the Citizen's Charcoal Institute (ICC) and subject their pig iron suppliers to random, unannounced audits, or become signatories to the National Pact to Eradicate Slave Labor in Brazil (the National Pact) and comply with its commitments.
- Nucor has become a patron of the ICC. As a patron, Nucor contributes to the ICC's funding and receives reports of audits conducted on charcoal producers.

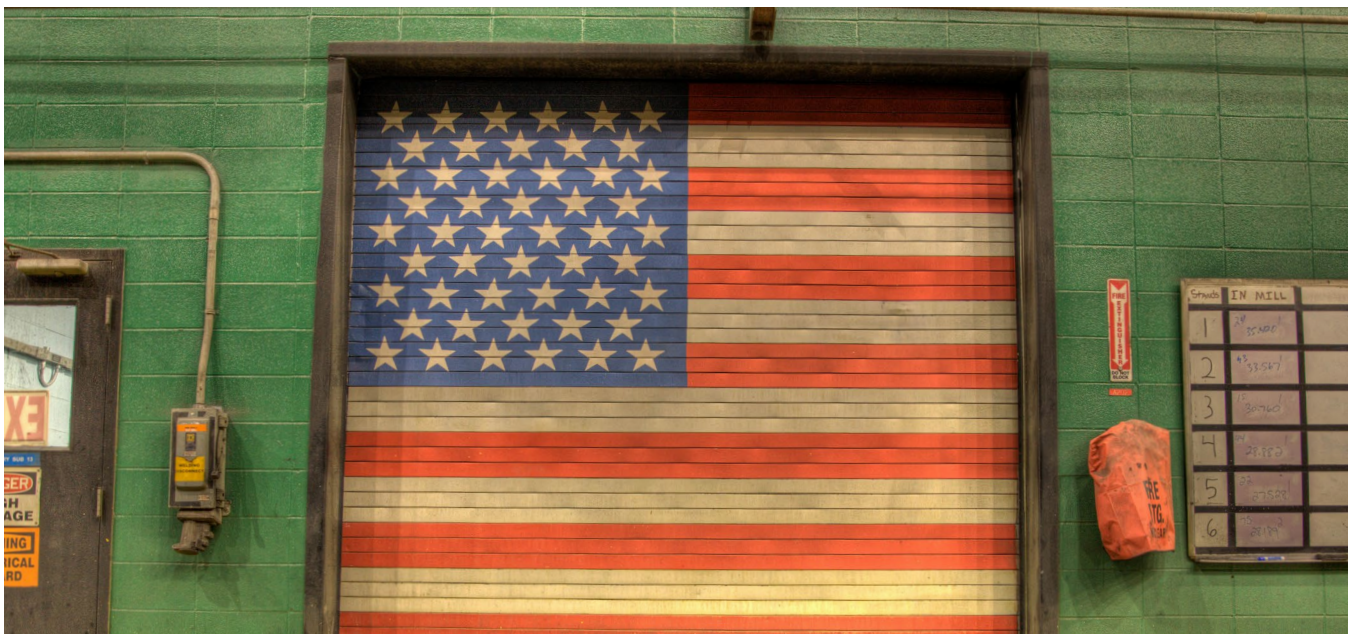
Nucor is not alone in facing this issue. We endorse the efforts of the Brazilian companies and nongovernmental organizations working to eliminate forced labor in Brazilian industries.

TRADE AND INDUSTRY

Nucor partners with a number of trade associations and industry organizations to pursue our common interests for the betterment of American manufacturing.

American Iron and Steel Institute www.steel.org	World Steel Association www.worldsteel.org
Association for Iron and Steel Technology www.aist.org	Steel Manufacturers Association www.steelnet.org
Steel Recycling Institute www.recycle-steel.org	American Institute of Steel Construction www.aisc.org
Metal Building Manufacturers Association www.mbma.com	Steel Framing Alliance www.steelframing.org
Steel Joist Institute www.steeljoist.org	Concrete Reinforcing Steel Institute www.crsi.org
Steel Deck Institute www.sdi.org	United States Green Building Council www.usgbc.org

In addition to the entities above, Nucor facilities participate in their state manufacturers' associations and numerous city and state manufacturers' sustainability councils.



LEARN MORE ABOUT NUCOR'S PUBLIC POLICY POSITIONS AT: WWW.NUCOR.COM/VOICE

GOVERNANCE PERFORMANCE INDICATORS

GRI NUMBER	DESCRIPTION	REPORTED	PAGE
1. STRATEGY AND ANALYSIS			
1.1	Statement from the most senior decision-maker of the organization.	Completely Reported	4-5
2. ORGANIZATIONAL PROFILE			
2.1	Name of the organization.	Completely Reported	Cover
2.2	Primary brands, products, and/or services.	Completely Reported	6
2.3	Operational structure of the organization, including main divisions, operating companies, subsidiaries, and joint ventures.	Completely Reported	6
2.4	Location of organization's headquarters.	Completely Reported	91
2.5	Number of countries where the organization operates, and names of countries with either major operations or that are specifically relevant to the sustainability issues covered in the report.	Completely Reported	6
2.6	Nature of ownership and legal form.	Completely Reported	64, 65
2.7	Markets served (including geographic breakdown, sectors served, and types of customers/beneficiaries).	Partially Reported	56, 59
2.8	Scale of the reporting organization.	Completely Reported	6, 7, 66
2.10	Awards received in the reporting period.	Completely Reported	10, 14, 16, 24, 37, 38, 39, 46
3. REPORT PARAMETERS			
3.1	Reporting period (e.g., fiscal/calendar year) for information provided.	Completely Reported	Cover
3.2	Date of most previous report (if any).	Completely Reported	10
3.3	Reporting cycle (annual, biennial, etc.).	Partially Reported	2

GOVERNANCE PERFORMANCE INDICATORS

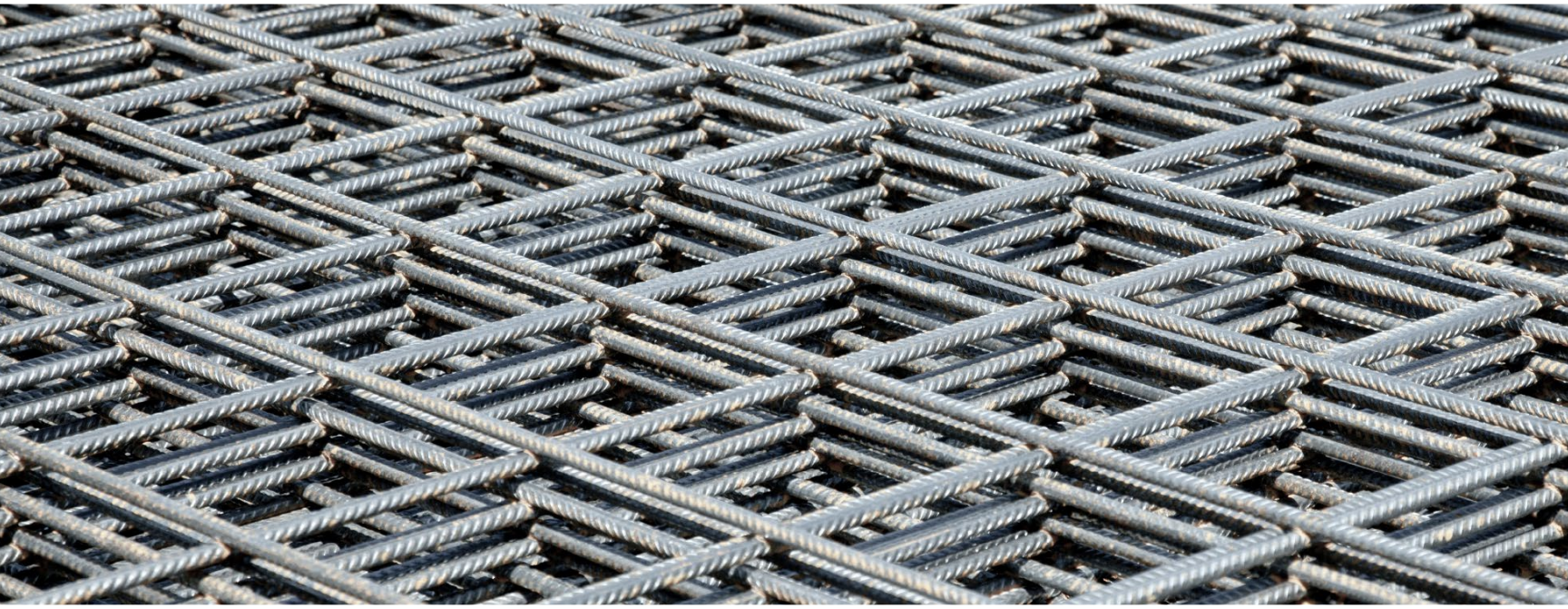
GRI NUMBER	DESCRIPTION	REPORTED	PAGE
3. REPORT PARAMETERS			
3.4	Contact point for questions regarding the report or its contents.	Completely Reported	91
3.5	Process for defining report content.	Completely Reported	2
3.6	Boundary of the report (e.g., countries, divisions, subsidiaries, leased facilities, joint ventures, suppliers.) See GRI Boundary Protocol for further guidance.	Completely Reported	2, 6
3.7	State any specific limitations on the scope or boundary of the report (see completeness principle for explanation of scope).	Completely Reported	2
3.9	Data measurement techniques and the bases of calculations, including assumptions and techniques underlying estimations applied to the compilation of the Indicators and other information in the report. Explain any decisions not to apply, or to substantially diverge from, the GRI Indicator Protocols.	Partially Reported	2
3.12	Table identifying the location of the Standard Disclosures in the report.	Completely Reported	17, 25, 41, 71-73
4. GOVERNANCE, COMMITMENTS, AND ENGAGEMENT			
4.1	Governance structure of the organization, including committees under the highest governance body responsible for specific tasks, such as setting strategy or organizational oversight.	Partially Reported	64, 65
4.2	Indicate whether the Chair of the highest governance body is also an executive officer.	Completely Reported	91
4.3	For organizations that have a unitary board structure, state the number and gender of members of the highest governance body that are independent and/or non-executive members.	Partially Reported	93
4.4	Mechanisms for shareholders and employees to provide recommendations for direction to the highest governance body.	Completely Reported	21, 65
4.5	Linkage between compensation for members of the highest governance body, senior managers, and executives (including departure arrangements), and the organization's performance (including social and environmental performance).	Completely Reported	21, 65
4.6	Processes in place for evaluating the highest governance body to ensure conflicts of interest are avoided.	Completely Reported	21, 65

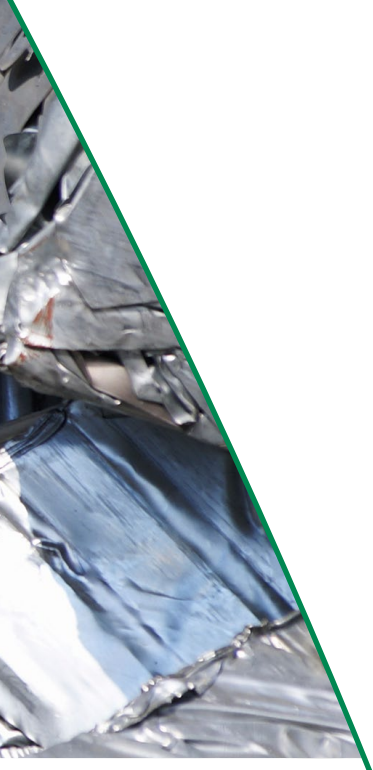
GOVERNANCE PERFORMANCE INDICATORS

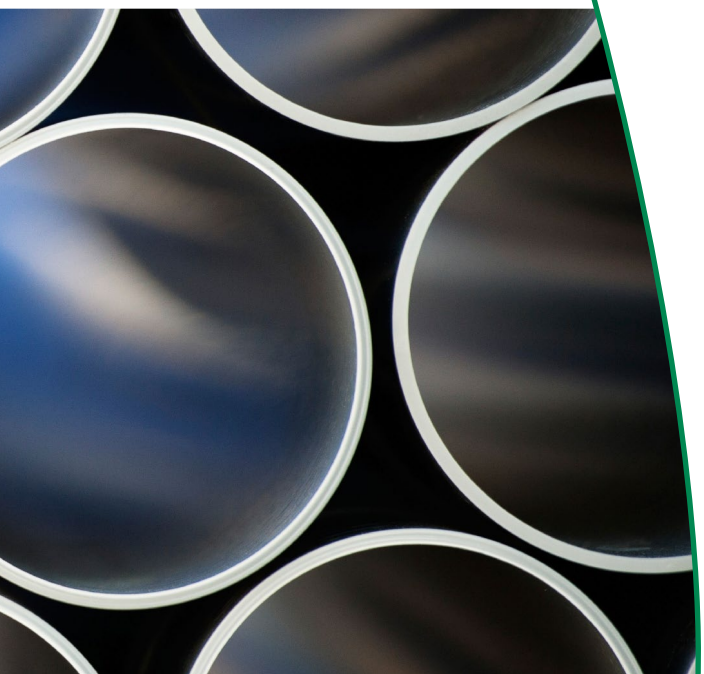
GRI NUMBER	DESCRIPTION	REPORTED	PAGE
4. GOVERNANCE, COMMITMENTS, AND ENGAGEMENT			
4.8	Internally developed statements of mission or values, codes of conduct, and principles relevant to economic, environmental, and social performance and the status of their implementation.	Completely Reported	4-5, 7, 21, 28, 46, 65, 67
4.9	Procedures of the highest governance body for overseeing the organization's identification and management of economic, environmental, and social performance, including relevant risks and opportunities, and adherence or compliance with internationally agreed standards, codes of conduct, and principles.	Completely Reported	68, 69
4.10	Processes for evaluating the highest governance body's own performance, particularly with respect to economic, environmental, and social performance.	Partially Reported	64
4.12	Externally developed economic, environmental, and social charters, principles, or other initiatives to which the organization subscribes or endorses.	Completely Reported	68, 69, 70
4.13	Memberships in associations (such as industry associations) and/or national/international advocacy organizations in which the organization ★ Has positions in governance bodies; ★ Participates in projects or committees; ★ Provides substantive funding beyond routine membership dues; or ★Views membership as strategic.	Partially Reported	70
4.14	List of stakeholder groups engaged by the organization.	Completely Reported	9, 19, 27, 43, 56, 63

HUMAN RIGHTS PERFORMANCE INDICATORS

INVESTMENT AND PROCUREMENT PRACTICES			
HR1	Percentage and total number of significant investment agreements and contracts that include clauses incorporating human rights concerns, or that have undergone human rights screening.	Partially Reported	68, 69
HR2	Percentage of significant suppliers, contractors and other business partners that have undergone human rights screening, and actions taken.	Partially Reported	68, 69
HR3	Total hours of employee training on policies and procedures concerning aspects of human rights that are relevant to operations, including the percentage of employees trained.	Partially Reported	68, 69
PUBLIC POLICY			
SO5	Public policy positions and participation in public policy development and lobbying.	Partially Reported	70







DAVID J. JOSEPH COMPANY 76

HARRIS STEEL GROUP 86

SKYLINE STEEL 90

IT'S OUR

Scrapping Expectations

David J. Joseph Company 2013 Sustainability Overview

When the David J. Joseph Company (DJJ) joined the Nucor family in 2008, it was an easy fit. DJJ and Nucor already relied on a longstanding partnership, the former having been a broker of ferrous scrap to Nucor since 1969. And both companies have strong corporate cultures with a focus on continual improvement. It is no surprise, then, that Nucor, the Western Hemisphere's largest recycler, would team up with us, America's oldest, most experienced recycling company.

Since joining Nucor, DJJ has continued to focus on sustainability at its more than 70 scrap recycling facilities and 12 brokerage offices. To DJJ, it's about recycling one of the world's most reusable materials while conserving our precious natural resources in the process. Perhaps the best testament to our sustainable business model is the simple fact that DJJ has been around for nearly 130 years. That's what happens when you take care of people and the environment, and why we say we are "scrapping expectations."

ENVIRONMENTAL EXCELLENCE ACROSS THE BOARD

Our recycling facilities are among the most environmentally sound in the industry. In addition to routine inspections for environmental performance, each facility receives a detailed annual inspection that rigorously evaluates all aspects of environmental performance, including teammate training and community outreach. Over 85% of our facilities achieved a score that resulted in environmental excellence during 2013.

>85%

of the facilities achieved a score that resulted in ENVIRONMENTAL EXCELLENCE IN 2013

GOING GREEN

At all recycling locations, DJJ has built a reputation for integrity, reliability, and honesty with its suppliers, consumers, teammates, civic organizations, and governmental agencies. As a good corporate citizen, DJJ takes seriously its responsibilities to preserve and protect the environment, provide a safe workplace, and give back to the communities in which DJJ does business. In each of the past six years, DJJ's Cincinnati headquarters was awarded the U.S. Environmental Protection Agency's Energy Star designation – the national symbol for protecting the environment through superior energy performance. This demonstrates DJJ's commitment to environmental stewardship.

DJJ strives to be a role model in the scrap industry. As such, DJJ provides community awareness and student education, utilizes state of the art technologies, provides a safe environment for teammates and customers, and strives to be as "green" as possible.

DJJ has a long history of participating in community events. Our family of companies sponsor a variety of exhibits and events, including many Earth Day activities in April. Through interactive exhibits, displays, and demonstrations at our various locations, we educate the public about the importance and benefits of recycling and the value that responsible recycling brings to their communities.

ENVIRONMENTAL METRICS

DJJ's recycling locations and U-Pull-&-Pay stores have long been leaders in efforts to remove mercury switches from the environment. Through 2013, we have recovered more than 170,000 switches, and in total DJJ has recovered more than 377 pounds of mercury from the environment. As the EPA contemplates fish consumption guidelines to control mercury exposure, DJJ has been doing something about it for many years by utilizing source control programs to ensure that all "convenience" light switches – which may contain mercury – are removed prior to receipt of automobiles before shredding. Before brokering shredded scrap, we ensure the shredder suppliers are actively participating in mercury switch removal.

DJJ has recovered

>170,000

SWITCHES

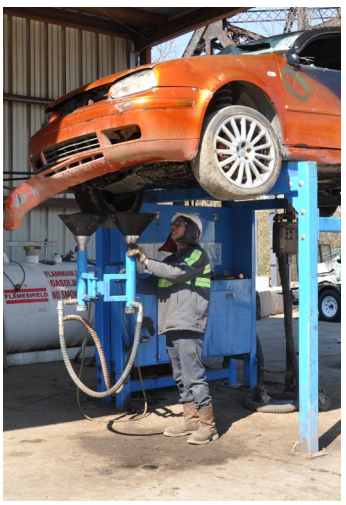
377

LBS OF MERCURY

from the environment to date

RECYCLING AUTOMOBILES – MORE THAN JUST METAL

Automobiles make up nearly 50% of the scrap fed to a typical metal shredder, but there is a lot that goes into preparing this material before it is processed through the shredder. Automobiles are full of pollutants. It takes training, inspections, and infrastructure to properly manage a sustainable way of recycling cars.



Gasoline, oil, and transmission fluids found in autos could be a significant pollutant if released into the environment. Our recycling process includes capturing these fluids and selling them as a commodity. When properly managed, these fluids can be turned into new synthetic oils, or in some cases, used as a fuel source for energy recovery. Gasoline is captured and sold for direct use or fuels blending. By recycling these and other fluids, we are turning waste streams into revenue streams. In addition to recycling ferrous and nonferrous scrap metal from automobiles, we also recycle windshield washer fluid, brake/power steering/oil/transmission fluids, antifreeze, CFC refrigerants, wheel weights, batteries, and gasoline.

Commitment to Safety

Providing a Safe and Healthful Workplace, Free of Injury and Illness

Ongoing and effective safety training is essential to the success of DJJ's safety program. In 2013, DJJ held numerous training programs for all levels of the organization. Highlights include three-day "Safety Schools" that equip new managers and supervisors with the information they need to run their plants safely, and safety conferences that are held to provide ongoing refresher sessions on the latest trends and focus items. All teammates also actively participate in safety meetings and specialized training sessions.

Safety is a core value throughout DJJ's operations. DJJ teammates have a responsibility to keep safety at the forefront of every action, whether in one of our recycling facilities, in the office, at a customer's location or in the car. Some of our teammates have a company-leased vehicle to conduct business and are expected to drive in a safe and responsible manner. In 2013, DJJ initiated a *Safe Driver Recognition Program*, which rewards safe and reliable company drivers.

In 2013, DJJ initiated a Safe Driver Recognition Program, which rewards safe and reliable company drivers.

DJJ President's Safety Award

Forty-five DJJ recycling facilities received the DJJ 2013 President's Safety Award. The primary criterion for becoming an award winner is excellence on the annual safety scorecard. This involves a comprehensive, full-day safety review of the plant's safety program, and each plant receives a score based on performance in dozens of areas, ranging from employee training and behavior to controlling physical hazards. The high scores earned by these plants demonstrate their considerable focus on workplace safety.

The Kentucky Governor's Safety and Health Award

River Metals Recycling's (RMR) Newport and Somerset, Kentucky facilities each won the prestigious Kentucky Governor's Safety and Health Award for businesses with 1-250 employees in 2013. The Governor's Safety and Health Award provides special recognition for RMR Newport's and Somerset's outstanding safety and health performances, and encourages development of programs designed to reduce and eliminate occupational injuries and illnesses.

The Utah Safety Council "Award of Merit"

In September, 2013, Western Metals Recycling's Utah locations (Plymouth, Metals Recovery, West Salt Lake and Provo) received the Utah Safety Council "Award of Merit" for achievements in workplace safety performance during 2012.

Nucor President's Environmental Award:
6 out of 7 of the regional operating recycling groups earned the 2013 Nucor President's Environmental Award.

The Safety Council of the Ozarks, a regional branch of the National Safety Council serving Southern Missouri and Northwest Arkansas recognized Advantage Metals Recycling's (AMR) unwavering focus on safety in the workplace with two prestigious awards in 2013:

- Les Reynolds Commitment to Excellence Award
  This is the highest regional award presented by the Safety Council of the Ozarks and was presented to AMR-Topeka.

- Ozarks Regional Safety Award
  These awards are presented to companies striving to provide a culture of safety in the workplace, with safety practices and accident rates which are better than the industry average. Eight AMR facilities earned this prestigious 2013 Ozarks Safety Excellence Award.

OSHA's SHARP Designation

Western Metals Recycling's (WMR) Salt Lake City, Utah recycling facility proudly received the prestigious SHARP (Safety & Health Achievement Recognition Program) designation from the Utah Department of Labor in the fall of 2012. WMR's Provo, Utah and Englewood, Colorado facilities each received the designation in July 2013. RMR Newport, Kentucky recycling facility received the SHARP designation from the Kentucky Secretary of Labor in December 2013. RMR Newport and WMR Englewood were the first recycling facilities in Kentucky and Colorado, respectively, to earn SHARP status.

Community Partnership

Real World Education on Environmental Issues

For the past few years, Advanced Placement Environmental Science students at Madeira High School in Cincinnati, Ohio have partnered with DJJ. The students meet with DJJ environmental professionals and tour two regional facilities, U-Pull-&-Pay (UPAP) and River Metals Recycling (RMR). Students are given hands-on opportunities to work in the field, collecting environmental data in three major areas defined under EPA Laws and Regulations:

- Clean Water Act
- Emergency Planning and Community Right-to-Know
- Oil Pollution Act

The overall involvement ranges from the routine application of dimensional analysis in the corporate classroom to a full experience tour of automobile crushers and shredders. This experience allows the students to take their study of recycling, waste stream management and environmental stewardship outside the classroom setting and to connect with professionals in industry. The students work in groups and complete the program by presenting their solution to several environmental calculation problems as "acting environmental consultants" for DJJ. The solutions are presented to DJJ executives in a business setting.

AWARDS

The David J. Joseph Company Named Aluminum Scrap Supplier of the Year

At the second annual American Metal Market Awards for Aluminum Excellence ceremony on June 12, 2012, DJJ was named *Aluminum Scrap Supplier of the Year*. The award is a tribute to DJJ's strong focus on safety, and its continuous commitment to its customers, products, and value-added services. The 2012 Aluminum Excellence Awards program recognized companies for efforts to improve competitiveness and demonstrate excellence in their operations.

The David J. Joseph Company Wins 2013 Platts Scrap and Recycling Industry Leadership Award

DJJ was named the 2013 Scrap and Recycling Industry Leader at the Platts Global Metals Awards. DJJ was recognized as a company that excels in its industry by consistently delivering strong returns to shareholders or owners while improving environmental efficiencies, implementing technological advances, and displaying a commitment to sustainable, forward-thinking solutions.

People Poll

DJJ Asks, Listens, and Acts

In July 2013, DJJ conducted its seventh *People Poll*, a confidential teammate survey, across all business units. The purpose of the poll is to solicit the candid opinions, suggestions, and feedback from DJJ's most valuable resource: its teammates. Once again, DJJ rated very well on its overall teammate engagement score. Employee engagement is a measure of DJJ teammates' commitment, pride, and satisfaction with the company and is a critical driver of profitability.

The 2013 survey received a 90% response rate, up from 88% in 2011, and is our highest participation rate ever. As a direct result of feedback from the 2013 and earlier *People Poll* surveys, DJJ has implemented a number of changes and initiatives including customer service, leadership, and communication training programs. DJJ also increased community outreach efforts and awareness, expanded the ways in which teammates' performance is recognized and rewarded, and enhanced certain benefit programs.

Community Relations

Kansas City Fire Department Emergency Response Training

The Advantage Metals Recycling (AMR) Kansas City recycling yard continues to work closely with the Kansas City Fire Department for emergency response training. AMR teammates use the equipment at the facilities to set up crash situations as requested by the instructors. The automobiles and space are provided at no cost for emergency response training on a regular basis, so that firefighters can develop the techniques and expertise needed to save lives. The donation of space and salvage vehicles allows the firefighters to become extremely proficient in most aspects of dismantling vehicles. The added training helps firefighters by reducing the stress level encountered on emergency scenes so the focus can be on the welfare of the people in the accident and not on basic equipment operation or techniques, ultimately saving lives. The program was so successful that 1,300 Kansas City Fire Department employees participated in refresher training at AMR.

DJJ supports a wide range of organizations through local investments, donations, and volunteer efforts. This commitment to the communities in which DJJ operates is not just a program or a donation; it's the way DJJ does business every day.

Metal Recycling Services Supports Local Monroe, North Carolina Fundraiser

Metal Recycling Services (MRS) proudly supported Monroe Police Department Detective Johnathan Williams as he participated in the 14th Annual Cycle to the Sea bike ride. Cycle to the Sea supports the programs provided by the Adaptive Sports and Adventure Program (ASAP). These programs celebrate the abilities of the physically challenged rather than their disabilities, creating an environment that fosters confidence and self-esteem.

River Metals Recycling Greensburg Hosts Batesville YMCA Summer Campers

RMR continues to be available to the community for tours and educational opportunities. In July 2013, a group of Batesville YMCA summer campers visited RMR Greensburg, Indiana recycling facility. The YMCA students were celebrating "green week." What better way to celebrate than to learn about how scrap recycling helps preserve and protect the environment?

Texas Port Recycling Recycled Bicycle Program

Texas Port Recycling's (TPR) Houston Port facility continues to give back to children in the greater Houston area through a unique, bicycle-recycling program. For several years, TPR has removed bikes that are brought to the recycling facility. TPR works cooperatively with the Huntsville State Prison, where inmates refurbish the bicycles, and then TPR donates the bicycles to needy children.

Western Metals Recycling Supports Habitat for Humanity

For Western Metals Recycling (WMR), Earth Day is recognized during the entire month of April at the Provo Recycling facility in Utah with a special contribution made to Habitat for Humanity. The WMR Provo facility donates three dollars per ton of ferrous scrap and two cents per pound for nonferrous scrap brought in across the scales during April to Habitat for Humanity. This donation funds house construction, helping to eliminate poverty housing and homelessness in the Provo area.

His Hands Christian Ministries Food Drive

For five consecutive years, WMR Englewood, Colorado donated food and cleaning products to His Hands Christian Ministries, a group providing for the underserved and homeless of Denver and Englewood. In 2013 alone, WMR donated over 800 pounds of food and over 400 pounds of cleaning and paper products to those in need.

School Metal Program Nucor/WMR Initiative

The WMR Salt Lake City recycling facility partners with Nucor to support the Granite School District. WMR participates in a year-round recycling program to help support the Granite School District welding programs. The "School Metal Program" positively impacts the community by collecting scrap steel from the Granite School District, then weighing and transporting the scrap to Nucor Steel – Utah, where it is exchanged for new steel used by students in the school's welding programs. Nucor then completes the recycling process by melting down the scrap metal collected and making new steel products.

Trademark Metals Gainesville Partners with Local Fire and Rescue Department

Trademark Metals Gainesville, Florida teamed up with the Gainesville Fire and Rescue Department, by donating automobiles for the Second Annual Citizen's Fire Academy. The academy allowed dozens of Gainesville residents to participate in hands-on scenarios that simulate real emergency situations the Fire and Rescue personnel experience while on the job.

U-Pull-&-Pay Denver Supports Operation Free Bird

Operation Free Bird is a non-profit event sponsored by the Adams County Sheriff's Office in Colorado and area businesses and organizations to benefit those who might need a helping hand during the holidays. All donated funds are paid to a local grocer who provides gift cards valued at $15. Citizens in need receive gift cards at the event in order to get turkeys or other food for Thanksgiving. Over 10,000 citizens attend this event annually and over 6,000 gift certificates were distributed in 2012. U-Pull-&-Pay Denver donated $4,000 in 2012.

Western Metals Recycling's Expanded Facility Helps Community Members Recycle

In 2012, Western Metals Recycling Salt Lake City, Utah expanded its nonferrous metal recycling facility. The new, state-of-the-art, 24,000-square-foot, covered, nonferrous metal recycling facility offers the general public drive-through recycling that is fast and friendly, making it easy to "go green" and recycle.

U-Pull-&-Pay Cincinnati Hosts Community Days

U-Pull-&-Pay Cincinnati, Ohio hosted Community Days on April 23 and 24, 2012. Many local politicians visited the store and met with members of the community. The store hosted a free cookout for customers and community members. All admission fees over both days were donated to the Carthage Civic League food pantry. In addition, the Carthage Fire Department offered auto safety tips and demonstrated emergency auto extractions.

Honoring America's Veterans

River Metals Recycling's Owensboro, Kentucky facility contributed to flights to Honor Flight Network, which honors America's veterans – especially WWII vets – for all their sacrifices. The organization coordinates flights taking veterans to Washington, D.C. to visit and reflect at their memorials. While visiting, these honored veterans are thanked, recognized, and admired for their years of service and sacrifice.

The RMR contribution helped provide transportation, food, and lodging assistance for veterans so they can enjoy a safe, memorable, and rewarding experience. This is an example of how the work RMR does in local communities has the power to radiate far and wide.

Ronald McDonald House

The DJJ philosophy has always been based on a sense of community, both in terms of our role as a leader in scrap metal recycling – helping to preserve and protect the environment – and philanthropy.

For over a decade, teammates from DJJ's corporate headquarters volunteer at the Ronald McDonald House (RMHC), serving dinner to the families staying at the house. Each year, 7 million children and families are served by RMHC, giving more families a comfortable place to stay during a difficult time while their children are obtaining medical services.

For well over a century, the DJJ culture and philosophy has revolved around being good neighbors in the communities in which we do business and giving back. This tradition remains part of DJJ today.

HARRIS STEEL

2013 Harris Steel Sustainability Overview

Harris Steel Group is a wholly owned subsidiary and part of Nucor Corporation. We process, fabricate, and distribute steel throughout the U.S. and Canada, through our many subsidiaries, including Harris Rebar, Harris Supply Solutions, Laurel Steel, and Fisher & Ludlow. Our products include: concrete reinforcing steel, epoxy-coated reinforcing steel, concrete post tension systems, wire products, cold finished bar, aluminum grating, heavy industrial steel grating, and expanded metal.

At Harris Steel, our number one value is *We Work Safe*. Our goal is zero injuries – a commitment we have backed up with remarkable safety progress since joining the Nucor family in 2007. In just seven years, we've seen a 78% decline in our Illness and Injury Rate, an 87% decline in our Lost Time Injury Rate, and an 86% decline in our combined Lost Workday and Rest Case Rate. This safety record is the result of our teammates' engagement and focus.

Raising the Bar

Harris Rebar

We are driven by our vision of being the safest, most profitable, and most customer-focused rebar contractor in North America. Our vision is guided by our core values:

- We work safe
- We are customer-focused
- We treat people with respect
- We act courageously to do the right thing
- We are honest and act with integrity

SERVICE

Harris Rebar is committed to providing our customers with full-service solutions for the fabrication and installation of our reinforcing steel products. In addition to providing top-quality products, our innovative team consistently rises to the unique demands and challenges of rebar installation. Our focus on safety, service and doing the right thing has proven invaluable in ensuring our customers' projects are successful.

SHARING

Harris Rebar has established itself as an industry leader in safety. We are active in our national association's safety committee and regularly lead safety seminars. Our Executive Vice President of Safety serves as Chair of the Concrete Reinforcing Steel Institute's National Safety Committee and actively promotes the sharing of safety best practices and training techniques, as well as the collaborative solving of safety issues impacting our industry as a whole.

Harris Steel's recordable safety incidents have declined significantly since 2007.

78% DECLINE — Illness and Injury Rate

87% DECLINE — Lost Time Injury Rate

86% DECLINE — Lost Workday & Rest Case Rate Combined

NOISE POLLUTION

An Environmental and Safety Consideration at Fisher & Ludlow

Noise pollution is a growing concern within our communities and has been a long standing concern within the occupational environment in both Canada and the United States. Like many Nucor divisions, Fisher & Ludlow's operations have seen the local residential population density increase significantly over the last decade. Where open fields once stood, we now have neighbors. As this occurs, manufacturers are being held to increasingly higher standards of noise mitigation to acquire and maintain operational permits. In response to these changes, Fisher & Ludlow has targeted operational noise pollution in two distinct areas: a teammate-focused effort targeting incidental noise generation; and an engineering-based effort targeting production equipment with quantified high noise operation.

Regarding the teammate-focused effort, our Joint Health and Safety Committees have successfully empowered our teammates to identify and mitigate incidental noise pollution sources in our operations using primarily recycled materials. For example, we now line our steel receiving bunkers with rubber to mitigate the noise pollution formerly caused by steel contacting steel. This innovation has reduced both occupational noise exposures for our teammates and environmental noise pollution for our neighbors.

Our engineering-based effort has made tremendous progress as well. For example, our manufacturing leaders have targeted our steel cutting saws for noise generation reduction. This effort – which impacts all 11 of our operations in both Canada and the United States – has included an analysis of cutting media and design, as well as the redesign of noise enclosures. By the end of the first quarter of 2014, we are ahead of schedule and are 50% complete.

Above and Beyond

In Support of Our Nations' Veterans

Harris Steel Group is committed to doing our part to contribute to the continual improvement of the communities where we operate. But we also recognize those in our communities who have gone above and beyond the call of duty on our behalf. We are proud to partner with organizations such as Wounded Warriors Canada, Wounded Warrior Project, Building for America's Bravest, and the Canadian Service Companion Program.

Focused on Environmental Responsibility: Laurel Steel

AWARDS

RECYCLING COUNCIL OF ONTARIO GOLD BUSINESS AWARD RECIPIENT

THE BURLINGTON, ONTARIO CHAMBER OF COMMERCE ENVIRONMENTAL ACHIEVEMENT AWARD RECIPIENT

ANNUAL LANDFILL DIVERSION RATE:

98%

TOTAL WASTE DIVERTED IN 2013:

>3,800

METRIC TONS

Laurel Steel implemented a waste reduction program in 1992. Since then, our

PRODUCTION INCREASED

50% ↑

LANDFILL WASTE DECREASED

↓ **50%**

ENERGY EFFICIENT LIGHTING has reduced lighting energy demand by

50%

Conversion of lift trucks from propane to natural gas has REDUCED GHG EMISSIONS BY

30%

SKYLINE STEEL

2013 Skyline Steel Sustainability Overview

Skyline Steel LLC is a premier steel foundation distributor serving the United States, Canada, Mexico, and the Caribbean and a wholly owned subsidiary of Nucor Corporation since 2012. We distribute high-quality products to service the most challenging applications including marine construction, bridge and highway construction, heavy civil construction, storm protection, underground commercial parking, and environment containment projects in the infrastructure and construction industries.

Our vast network spans from Washington State and California to Massachusetts, from Alberta, Canada to Queretaro, Mexico. Skyline is able to manufacture and deliver the sheet piling, spiralweld pipe, rolled and welded pipe, threaded bar, and accessories in the quickest, most efficient manner available. Our engineering team works with owners, engineers, and contractors long before projects are advertised. Because of this, needless waste in time, energy, and material is all minimized, leading to efficiencies and sustainable practices throughout our manufacturing process.

Our flagship products include hot rolled and cold formed sheet piles, H-piles, and pipe piling, while our processing and fabricating capabilities include spiralweld pipe piling, rolled and welded pipe piling, cold formed sheet piling, and threaded bar. Of the products we manufacture and supply, 80% are made from recycled steel and are 100% recyclable.

CUSTOMER FOCUS: OUR CORE PHILOSOPHY

A strong customer focus has always been an integral value at Skyline Steel. In our view, customer service goes beyond the salesperson-contractor relationship and steel delivery. Our well-connected network of stockyards allows our sales team to supply customers with the materials needed to continue working at any point of a project, so contractors can feel assured that steel will be available as needed and on schedule.

SAFETY FROM THE START

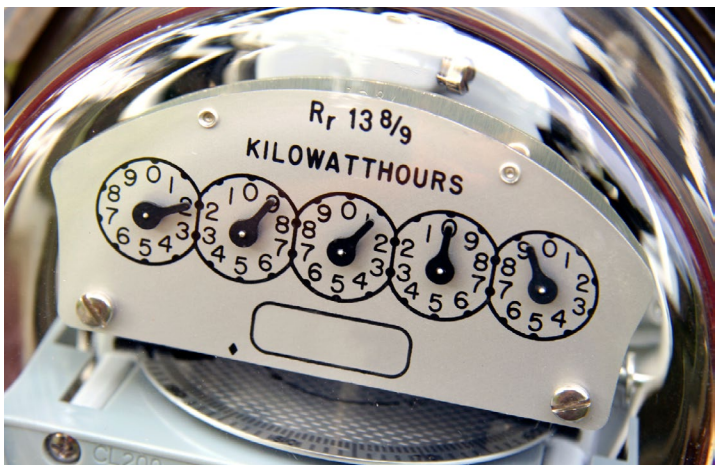
As a part of the Nucor family, Skyline is committed to Safety First in all that we do. We are Occupational Health & Safety Advisory Services (OHSAS) 18001 certified and will be seeking ISO 45001 certification when it is published. In addition, we are proud to have demonstrated this during our first year as a Nucor company; after being acquired in 2012, we were recognized in 2013 for superior safety performance. We guess you could say it's our nature, too.

HABITAT FOR HUMANITY $75K DONATION

Following the devastation of Hurricane Katrina, Skyline held its annual sales meeting in New Orleans, Louisiana and donated $25,000 to Habitat for Humanity. While there, the attendees also spent one day at a Habitat site, helping with their efforts there. The following year, Skyline donated an additional $50,000 to Habitat.

ENERGY (RELAMPING THE PLANTS)

Most Skyline plants have switched their light fixtures over from metal halide and high-pressure sodium lamps to more energy efficient options. The benefits are significantly reduced energy and replacement costs, as well as improved light quality. The remaining plants are in various stages to re-lamp their facilities.



Why Safety Matters

A collection of family photos, assembled by the teammates of Nucor Steel Marion, Inc.

NUCOR RECYCLES AN AVERAGE OF

1,200 POUNDS OF STEEL

EVERY SECOND OF EVERY HOUR OF EVERY DAY,

MAKING US THE WESTERN HEMISPHERE'S

LARGEST RECYCLING COMPANY.

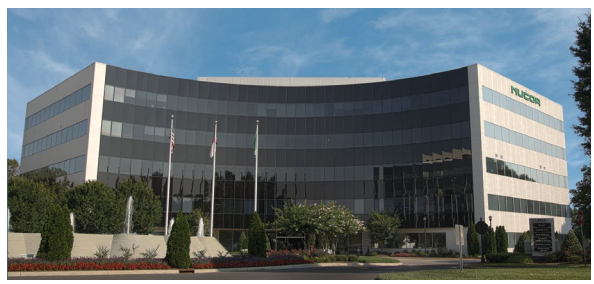
JOHN J. FERRIOLA
Chairman, Chief Executive Officer, and President

JAMES D. FRIAS
Chief Financial Officer, Treasurer, and Executive Vice President

RAYMOND J. MILCHOVICH
Lead Director

FOR A CURRENT LIST OF NUCOR'S BOARD OF DIRECTORS AND EXECUTIVE MANAGEMENT GROUP, PLEASE VISIT:
WWW.NUCOR.COM/GOVERNANCE

Corporate Headquarters
1915 Rexford Road
Charlotte, NC 28211



FOR MORE INFORMATION ABOUT NUCOR SUSTAINABILITY EFFORTS, PLEASE CONTACT US AT: SUSTAINABILITY@NUCOR.COM

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A SUSTAINABLE REPORT

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