

ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804

Owner of the Declaration	Cementa AB, HeidelbergCement Group
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-HCG-20160236-CAD1-EN
Issue date	2016-12-16
Valid to	2022-12-15




Multicem

Cementa AB, HeidelbergCement Group

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General Information

<p>Cementa AB, HeidelbergCement Group</p> <p>Programme holder IBU - Institut Bauen und Umwelt e.V. Panoramastr. 1 10178 Berlin Germany</p> <hr/> <p>Declaration number EPD-HCG-20160236-CAD1-EN</p> <hr/> <p>This Declaration is based on the Product Category Rules: Cement, 07.2014 (PCR tested and approved by the SVR)</p> <hr/> <p>Issue date 2016-12-16</p> <hr/> <p>Valid to 2022-12-15</p> <hr/> <p></p> <hr/> <p>Prof. Dr.-Ing. Horst J. Bossenmayer (President of Institut Bauen und Umwelt e.V.)</p> <hr/> <p></p> <hr/> <p>Dr. Burkhard Lehmann (Managing Director IBU)</p>	<p>Multicem</p> <hr/> <p>Owner of the Declaration Cementa AB Årstaängsvägen 25, Box 47210 SE-100 74 Stockholm</p> <hr/> <p>Declared product / Declared unit 1 metric t of Multicem</p> <hr/> <p>Scope: This Environmental Product Declaration (EPD) covers the product life cycle stages A1-A3. It is valid for Multicem, manufactured by Cementa AB at the plant Slite, Sweden, in 2015. This analysis relies on transparent, plausible and documented basis data. All the model assumptions, which influence the results, are declared. The life cycle assessment is representative for the products introduced in the declaration for the given system boundaries. The owner of the declaration shall be liable for the underlying information and evidence; the IBU shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.</p> <hr/> <p>Verification</p> <table border="1"> <tr> <td colspan="2">The CEN Norm /EN 15804/ serves as the core PCR</td> </tr> <tr> <td colspan="2">Independent verification of the declaration according to /ISO 14025/</td> </tr> <tr> <td><input type="checkbox"/> internally</td> <td><input checked="" type="checkbox"/> externally</td> </tr> </table> <hr/> <p></p> <hr/> <p>Dr. Eva Schmincke (Independent verifier appointed by SVR)</p>	The CEN Norm /EN 15804/ serves as the core PCR		Independent verification of the declaration according to /ISO 14025/		<input type="checkbox"/> internally	<input checked="" type="checkbox"/> externally
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Product

Product description / Product definition

Cement is a hydraulic binder. It consists of finely-ground, non-metallic inorganic compounds. Cement is produced by grinding cement clinker and other main or minor constituents. When water is added to cement, a cement paste is formed, which sets and hardens by means of hydration reactions. After hardening, it retains its strength and stability even under water.

The declared product Multicem is a blend of cement CEM I in accordance with /EN 197-1/ and cement kiln dust, manufactured by Cementa at the plant Slite. It does not comply with /EN 197-1/. The calculation is based on plant-specific data of 2015.

Multicem was designed within the scope of the continued product development towards better products with higher environmental profile, based on Cementa's zero vision for carbon emissions.

For the use and application of the product the respective national provisions at the place of use apply.

Application

In general, the application of cement has a large variety. Multicem is a special product, which is used for soil stabilization and solidification.

Technical Data

Multicem has, in comparison with products such as Cementa's Kalkcement (a lime-cement product), better stabilization properties.

Multicem is delivered in bulk from the cement plant and comes ready to use. The characteristics of the product are similar as those of lime-cement stabilization products (e.g. Cementa's Kalkcement).

When producing Multicem, the use of raw material such as limestone is replaced with cement kiln dust which also adds to the environmental profile of the product.

Performance data of the product with respect to its characteristics in accordance with the relevant technical provision ((No CE-marking)).

Base materials / Ancillary materials

Clinker: 47.5 - 50 %
Cement clinker is made of a raw material mixture that is added to the cement kiln and sintered at a temperature of 1400 °C. The basic materials for the production of cement clinker consist of calcium oxide (CaO), silicon dioxide (SiO₂) and small amounts of aluminum oxide (Al₂O₃) and iron oxide (Fe₂O₃). Raw materials that provide these constituents are limestone, chalk and clay or limestone marl as its natural occurring mixture.

Gypsum/Anhydrite/Residual gypsum: 0 - 2.5 %
Gypsum and anhydrite are added as setting regulators to cement. Many cement plants use residual gypsum from flue gas desulfurization as well.

Cement kiln dust: 50 %
Cement kiln dust (CKD) is a fine, powdery material, portions of which contain unreacted raw feed, clinker dust, and fuel ash.

No substances according to the /Candidate List of Substances of Very High Concern for Authorisation/ are used in cement.

Reference service life

This study covers the production stage information (from A1 to A3) of the product. As no use stage is declared, the reference service life for cement is irrelevant.

LCA: Calculation rules

Declared Unit

The declared unit is 1 metric t of Multicem.

Declared unit

Name	Value	Unit
Declared unit	1	t
Conversion factor to 1 kg	0.001	-

System boundary

Type of EPD: cradle-to-gate

For the modeling of cement both specific production data from HeidelbergCement and background data (especially for upstream processes) have been used. For life cycle modeling of the considered product, the verified /WBCSD-CSI/ online tool for EPDs of concrete and cement is used. The tool was developed by Quantis and is owned by the Cement Sustainability Initiative (CSI) of the World Business Council for Sustainable Development. The life cycle assessment in the tool has been implemented in compliance with /EN 15804/, the General Programme Instructions (GPI 2.5) for the International EPD® System, the product category rules /UN CPC 375 Concrete/ and /UN CPC 3744 Cement/.

A significant factor regarding primary data collection is the emission measurement directly at plant. In line with the official regulations, regular data collections are

established at HeidelbergCement group. The emission data of the clinker burning process are included in this LCA study. Preferably directly measured kiln emission values in the specific plant are considered. Noise, landscape impact, vibration etc. are not within the scope of this study. In case that specific kiln emission data are not available, default values are automatically used by the /WBCSD-CSI/ tool.

The selected system boundaries comprise the production of cement including raw material extraction up to the finished product at the factory gate.

The product stage contains:
Module A1: Extraction and processing of raw materials.

Module A2: Transport of raw materials to the factory gate and internal transport.

Module A3: Cement production.

The construction stage, the use stage and the disposal stage are not included in the life cycle assessment of cement.

Comparability

Basically, a comparison or an evaluation of EPD data is only possible if all the data sets to be compared were created according to /EN 15804/ and the building context, respectively the product-specific characteristics of performance, are taken into account. The used background database has to be mentioned.

LCA: Scenarios and additional technical information

The development of scenarios has to be made on the finished product (e.g. concrete) and not on the upstream product cement.

LCA: Results

DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; MND = MODULE NOT DECLARED)

PRODUCT STAGE			CONSTRUCTION PROCESS STAGE		USE STAGE							END OF LIFE STAGE				BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARIES
Raw material supply	Transport	Manufacturing	Transport from the gate to the site	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	MND	MND	MND	MND	MNR	MNR	MNR	MND	MND	MND	MND	MND	MND	MND

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT: 1 metric t Multicem

Parameter	Unit	A1-A3
Global warming potential	[kg CO ₂ -Eq.]	3.96E+2
Depletion potential of the stratospheric ozone layer	[kg CFC11-Eq.]	3.28E-6
Acidification potential of land and water	[kg SO ₂ -Eq.]	3.84E-1
Eutrophication potential	[kg (PO ₄) ³ -Eq.]	1.63E-1
Formation potential of tropospheric ozone photochemical oxidants	[kg ethene-Eq.]	6.12E-2
Abiotic depletion potential for non-fossil resources	[kg Sb-Eq.]	2.07E-5
Abiotic depletion potential for fossil resources	[MJ]	1.47E+3

RESULTS OF THE LCA - RESOURCE USE: 1 metric t Multicem

Parameter	Unit	A1-A3
Renewable primary energy as energy carrier	[MJ]	1.39E+2
Renewable primary energy resources as material utilization	[MJ]	0.00E+0
Total use of renewable primary energy resources	[MJ]	1.39E+2
Non-renewable primary energy as energy carrier	[MJ]	1.43E+3
Non-renewable primary energy as material utilization	[MJ]	0.00E+0
Total use of non-renewable primary energy resources	[MJ]	1.43E+3
Use of secondary material	[kg]	5.19E+2
Use of renewable secondary fuels	[MJ]	3.46E+2
Use of non-renewable secondary fuels	[MJ]	4.98E+2
Use of net fresh water	[m ³]	5.09E-1

RESULTS OF THE LCA – OUTPUT FLOWS AND WASTE CATEGORIES:

1 metric t Multicem

Parameter	Unit	A1-A3
Hazardous waste disposed	[kg]	0.00E+0
Non-hazardous waste disposed	[kg]	0.00E+0
Radioactive waste disposed	[kg]	0.00E+0
Components for re-use	[kg]	0.00E+0
Materials for recycling	[kg]	0.00E+0
Materials for energy recovery	[kg]	0.00E+0
Exported electrical energy	[MJ]	0.00E+0
Exported thermal energy	[MJ]	0.00E+0

Remark to Global warming potential:

This includes 61.1 kg CO₂-eq. from the incineration of wastes in clinker production. According to the polluter-pays-principle /EN 15804/ that would be assigned to the production system, which has caused the waste. In this EPD the CO₂ contribution is not subtracted. This is to ensure comparability across countries of calculated global warming potentials for cements even if the used secondary fuels in other countries do not have waste status.

Remark to Waste categories:

The waste indicators account for wastes from clinker and cement manufacturing only.

References

Institut Bauen und Umwelt

Institut Bauen und Umwelt e.V., Berlin(pub.):
Generation of Environmental Product Declarations
(EPDs);
www.ibu-epd.de

ISO 14025

DIN EN ISO 14025:2011-10: Environmental labels and
declarations — Type III environmental declarations —
Principles and procedures

EN 15804

EN 15804:2012-04+A1 2013: Sustainability of
construction works — Environmental Product
Declarations — Core rules for the product category of
construction products

EN 197-1:2011

Cement - part 1: Composition specification and
conformity criteria for common cements

EN 206:2013

Concrete: Specification, performance, production and
conformity

General principles

for the EPD range of Institut Bauen und Umwelt e.V.
(IBU), 2013-04

www.ibu-epd.com

WBCSD-CSI

Cement Sustainability Initiative (CSI) of World
Business Council for Sustainable Development
<http://www.wbcscement.org/>

PCR 2012:01

Product Category Rules according to ISO 14025:
Construction products and construction services,
version 2.01, 2012:01
<http://environdec.com/en/PCR/Detail/?Pcr=8098>

UN CPC 3744 Cement

Product Category Rules for Cement, 2010,
<http://environdec.com/en/PCR/Detail/pcr2010-09>

UN CPC 375 Concrete

Product Category Rules for Unreinforced Concrete,
WBCSD Cement Sustainability Initiative, 2013
<http://environdec.com/en/PCR/Detail/pcr2013-02>

Candidate List of Substances of Very High Concern for Authorisation

European Chemical Agency, 2014
www.echa.europa.eu/web/guest/candidate-list-table

**Publisher**

Institut Bauen und Umwelt e.V.
Panoramastr. 1
10178 Berlin
Germany

Tel +49 (0)30 3087748- 0
Fax +49 (0)30 3087748- 29
Mail info@ibu-epd.com
Web www.ibu-epd.com

**Programme holder**

Institut Bauen und Umwelt e.V.
Panoramastr. 1
10178 Berlin
Germany

Tel +49 (0)30 - 3087748- 0
Fax +49 (0)30 - 3087748 - 29
Mail info@ibu-epd.com
Web www.ibu-epd.com

**Author of the Life Cycle**

Assessment
HeidelbergCement Technology
Center
Oberklamweg 6
69181 Leimen
Germany

Tel +49 6221 481 13719
Fax +49 6221 481 13757
Mail martina.dietermann@htc-gmbh.com
Web www.heidelbergcement.com

**Owner of the Declaration**

Cementa AB, HeidelbergCement
Group
Årstaängsvägen 25
11743 Stockholm
Sweden

Tel +46 8 625 68 00
Fax +46 8 753 36 20
Mail bodil.hokfors@cementa.se
Web www.cementa.se