

Environmental Product Declaration



In accordance with ISO 14025 and EN 15804 for:

Insulated precast concrete, sandwich wall

from

Bohus Betong

BOHUS BETONG

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General information

Programme:	The International EPD® System
Address:	EPD International AB Box 210 60 SE-100 31 Stockholm Sweden
Website:	www.environdec.com
E-mail:	info@environdec.com

CEN standard EN 15804 serves as the Core Product Category Rules (PCR)
Product category rules (PCR): PCR 2012:01, Construction products and construction services, (EN 15804:A1) v.2.33.
PCR review was conducted by: The Technical Committee of the International EPD® System. The review panel may be contacted via info@environdec.com .
Independent third-party verification of the declaration and data, according to ISO 14025:2006: <input type="checkbox"/> EPD process certification <input checked="" type="checkbox"/> EPD verification
External independent verifier: Håkan Stripple at IVL Swedish Environmental Research Institute E-mail: hakan.strippl@ivl.se <i>In case of recognised individual verifiers:</i> Approved by: The International EPD® System
Procedure for follow-up of data during EPD validity involves third party verifier: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No

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Company information

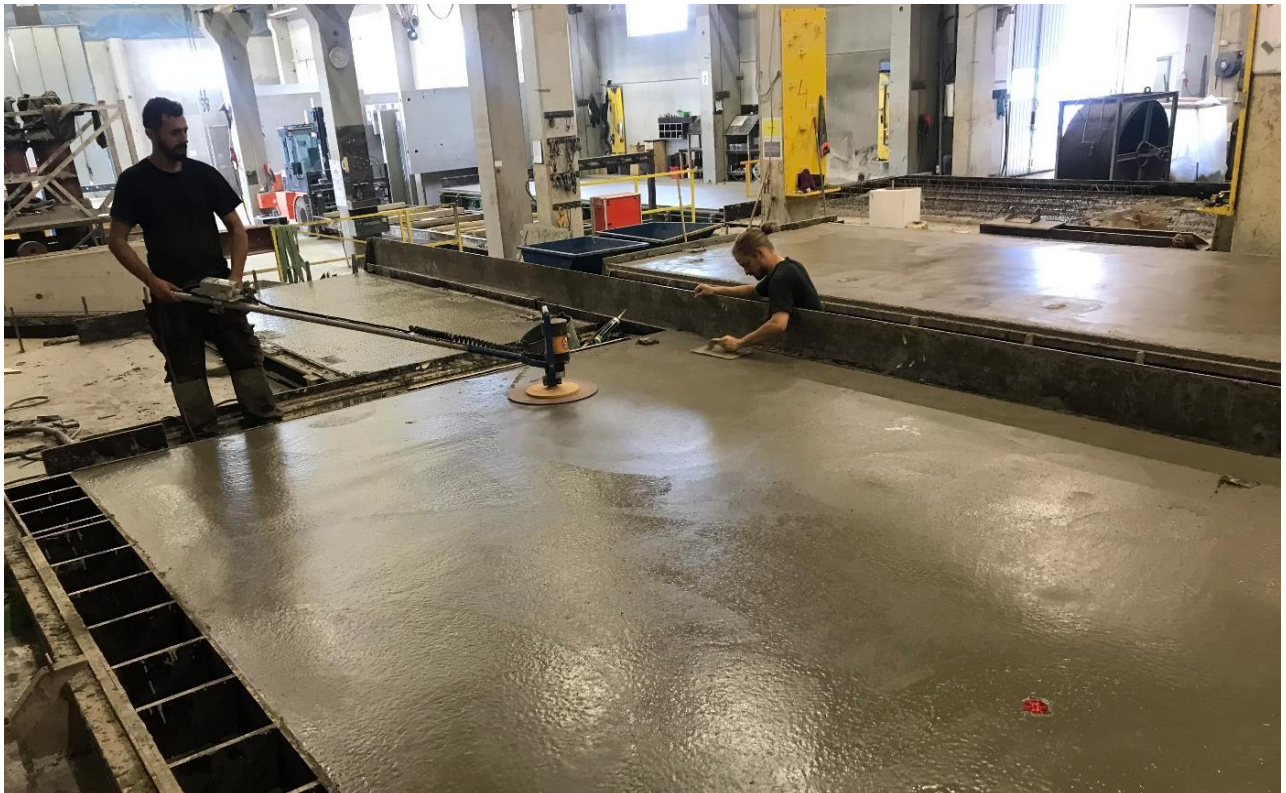
Owner of the EPD: Bohus Betong AB
Svarteborg 27
455 97 Dingle
The EPD owner has the sole ownership

Contact: Bertil Eliasson
0524 281 70
bertil@bohusbetong.se

Description of the organisation: Bohus Betong AB is an independent privately-owned company established in 1925. With the business idea to “design, manufacture, deliver and assemble complete concrete structures for housing, agricultural buildings, and offices”, the company offers a wide range of precast concrete products. The products are currently used in various buildings on the Swedish market. Bohus Betong has about 60 employees who are motivated to make high quality products to their customers every day.

Product-related or management system-related certifications: Products from Bohus Betong AB are certified by Nordcert according to EN 305 and other standards. The certification secures that all products fulfil their technical requirements and that they are manufactured according to current building norms.

Name and location of production sites: Bohus Betong AB has two production sites, one located in Dingle and one in Jönköping, Sweden.



Product information

Product name: Insulated precast concrete, sandwich wall



Product description: Sandwich walls are most commonly used as facades but sometimes also as isolated walls between areas with different temperatures. The wall has two layers of concrete with insulation in between. The elements are customised for individual projects and are produced after requirements specified by the customer. This includes specifications for recesses and other details such as electrical wire. Depending on the customer's needs, the type of insulation and the thickness of the product can also vary. In the first part of the process, the product is optimized in terms of the lifecycle for the building.

All raw materials are transported to the factory. Cement is the ingredient in concrete that affects the environment the most and therefore, Bohus Betong tries to minimize the cement content in the concrete without reducing the quality of the products. When cement is produced at the cement factory, a calcination process is taking place. During this process, carbon dioxide is released from the limestone. Concrete recaptures a part of this carbon dioxide in its use phase and in its end-of-life stage. The recapturing of carbon dioxide in the use phase is included in this EPD. Reinforcing steel also has a significant environmental impact and optimizing the content of reinforcement is therefore prioritized. The reinforcement is usually cut and bended in Bohus Betong's factories.

Concrete is produced by putting aggregate, cement, water, and admixtures in a concrete mixer. After mixing, the liquid concrete is poured into a mould and the surface is prepared. Moulds for the elements

and recesses are normally made of wood. Sometimes, when there is a large number of similar moulds, they are produced in steel. After a night in the moulds, the concrete has hardened and the mould is removed. After this, the element is inspected. Finally, the sandwich wall is stored until delivery.

The sandwich walls are registered and assessed in Byggvarubedömningen, and in SundaHus.

More information can be found at the website www.bohusbetong.se.

Geografical scope (Sweden): Insulated precast concrete sandwich walls are manufactured at the production site in Dingle, Sweden.

UN CPC code: 375

LCA information

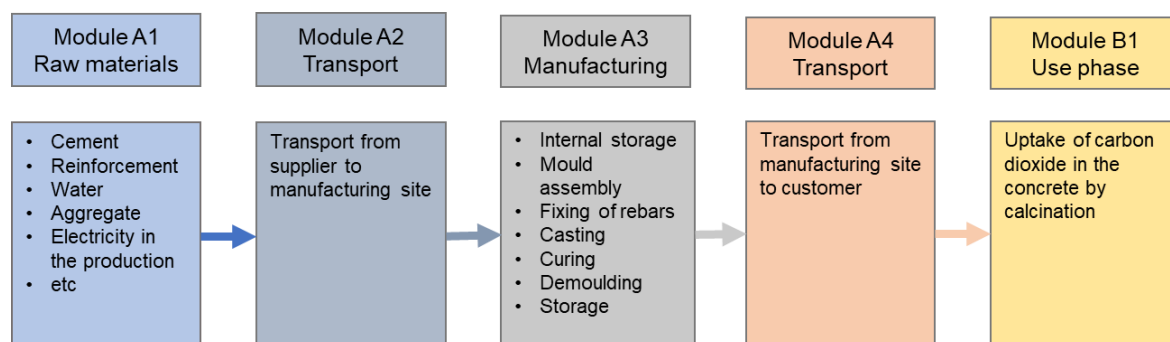
Declared unit: 1 metric tonne of insulated precast concrete, sandwich wall.

Reference service life: The expected service life of the product is 50 years.¹

Time representativeness: Data is representative for production year 2020. For materials, energy and transports, generic industry data from Ecoinvent and Agri-footprint has been used. Specific EPD data has been used for cement and insulation.

Database(s) and LCA software used: Ecoinvent 3.6, Agri-footprint and SimaPro 9.1.1.1.

Description of system boundaries: This is a cradle to gate EPD with options, A4 and B1 is added.



A1: Extraction and processing of raw materials, electricity use, energy generation from pellets and generation of waste in the production.

A2: Transports from suppliers to Bohus Betong production site.

A3: Manufacturing of the product at Bohus Betong production site.

A4: Transports from Bohus Betong production site to the customer.

B1: Carbonation of the insulated precast concrete sandwich wall during its use phase.

The use phase of the products, B1, is included in the study to cover the uptake of carbon dioxide in concrete by carbonation. It is the net emissions from the cradle-to-gate activities that has a real impact on climate change. From a national perspective, the concrete stock takes up CO₂ at almost the same rate as the emission occurs from the calcination. By including the uptake of carbon dioxide in the use phase, this “cradle-to-gate with options study” provides a more coherent picture of the real climate impact from the product.

Estimates and assumptions: Heat, electricity and other energy use as well as waste in production are calculated as a weighted average per produced tonne of all products using yearly production data and rate for 2020. No assumptions made.

There are variations in the mix of materials (cement, aggregate and reinforcement etc) in the concrete product. Material percentages in the content information are averages.

The variation in material composition for different mixes and the related environmental impact is within +/- 10 % compared to the given average in this EPD.

¹ <https://www.svenskbetong.se/bygga-med-betong/bygga-med-prefab/miljo-och-hallbarhet/livslangd-for-byggnader>

The distance to customers used in A4 is an average for Bohus Betongs customers, it is estimated to be 102 km by truck.

Cut off criteria: All major materials, production energy use and waste are included. Materials less than 1 % weight in the concrete product are not taken into account.

Data quality: The data quality can be described as fair for waste estimations and transports and good for other data. The primary data collection has been done thoroughly and all relevant flows are considered.

Modules declared, geographical scope, share of specific data (in GWP-GHG indicator) and data variation:

	Product stage			Construction process stage		Use stage							End of life stage				Resource recovery stage
	Raw material supply	Transport	Manufacturing	Transport	Construction installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
Module	A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Modules declared	x	x	x	x	ND*	x	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
Geography	EU	EU	SE	SE	-	SE	-	-	-	-	-	-	-	-	-	-	-
Specific data used	About 25 % specific					-	-	-	-	-	-	-	-	-	-	-	-
Variation – products	within +/- 10 % compared to the given average in this EPD					-	-	-	-	-	-	-	-	-	-	-	-
Variation – sites	Not relevant					-	-	-	-	-	-	-	-	-	-	-	-

*Not declared.

Content information

Product components	Weight, kg	Post-consumer material, weight-%	Renewable material, weight-%
Reinforcement	35	9	0
Cement	146	0	0
Aggregate	732	0	0
Water	81	0	0
Insulation	6	0	0
TOTAL	1 000	0	0
Packaging materials	Weight, kg	Weight-% (versus the product)	
TOTAL*	0	0	

*No packaging materials.

Dangerous substances from the candidate list of SVHC for Authorisation	EC No.	CAS No.	Weight-% per functional or declared unit
TOTAL*	-	-	0

*No dangerous substances from the candidate list of SVHC for Authorisation.

Environmental Information

Potential environmental impact – mandatory indicators according to EN 15804

Results per tonne insulated precast concrete, sandwich wall							
Indicator	Unit	A1	A2	A3	Tot.A1-A3	A4	B1
Global warming potential (GWP)	kg CO ₂ eq.	2.10E+02	1.15E+01	3.79E-01	2.22E+02	1.03E-02	-2.10E+00*
Depletion potential of the stratospheric ozone layer, (ODP)	kg CFC-11 eq.	8.54E-06	5.01E-07	3.20E-08	9.08E-06	2.10E-11	0.00E+00
Acidification potential (AP)	kg SO ₂ eq.	4.58E-01	6.90E-02	5.35E-03	5.32E-01	4.33E-05	0.00E+00
Eutrophication potential (EP)	kg PO ₄ ³⁻ eq.	2.48E-01	1.48E-02	1.96E-03	2.65E-01	9.90E-06	0.00E+00
Formation potential of tropospheric ozone (POCP)	kg C ₂ H ₄ eq.	6.85E-02	2.85E-03	4.69E-04	7.18E-02	2.12E-06	0.00E+00
Abiotic depletion potential – Elements	kg Sb eq.	9.46E-04	1.42E-04	3.11E-06	1.09E-03	4.14E-10	0.00E+00
Abiotic depletion potential – Fossil resources	MJ, net calorific value	1.31E+03	1.58E+02	4.18E+00	1.47E+03	1.46E-01	0.00E+00

* Only the carbonation of the product is considered in the use phase as it is strongly related to the calcination in A1 (net CO₂ emission) and the CO₂ uptake is calculated for 50 years.

Use of resource

Results per tonne insulated precast concrete, sandwich wall								
Indicator		Unit	A1	A2	A3	Tot.A1-A3	A4	B1
Primary energy resources – Renewable	Use as energy carrier	MJ, net calorific value	3.73E+02	3.80E+00	5.90E+01	4.36E+02	1.96E-04	0.00E+00
	Used as raw materials	MJ, net calorific value	7.71E-01	0.00E+00	0.00E+00	7.71E-01	0.00E+00	0.00E+00
	TOTAL	MJ, net calorific value	3.74E+02	3.80E+00	5.90E+01	4.37E+02	1.96E-04	0.00E+00
Primary energy resources – Non-renewable	Use as energy carrier	MJ, net calorific value	1.56E+03	1.69E+02	4.92E+00	1.73E+03	1.56E-01	0.00E+00
	Used as raw materials	MJ, net calorific value	6.55E+01	0.00E+00	0.00E+00	6.55E+01	0.00E+00	0.00E+00
	TOTAL	MJ, net calorific value	1.62E+03	1.69E+02	4.92E+00	1.80E+03	1.56E-01	0.00E+00
Secondary material		kg	4.08E+01	0.00E+00	0.00E+00	4.08E+01	0.00E+00	0.00E+00
Renewable secondary fuels		MJ, net calorific value	3.91E+01	0.00E+00	0.00E+00	3.91E+01	0.00E+00	0.00E+00
Non-renewable secondary fuels		MJ, net calorific value	8.60E+01	0.00E+00	0.00E+00	8.60E+01	0.00E+00	0.00E+00
Net use of fresh water		m ³	7.98E+01	2.51E-01	4.67E-02	8.01E+01	3.99E-05	0.00E+00

Waste production and output flows

Waste production

Results per tonne insulated precast concrete, sandwich wall							
Indicator	Unit	A1	A2	A3	Tot.A1-A3	A4	B1
Hazardous waste disposed	kg	5.86E-03	1.32E-04	8.50E-06	6.00E-03	0.00E+00	0.00E+00
Non-hazardous waste disposed	kg	2.29E+01	4.48E-01	1.35E-01	2.35E+01	1.29E-08	0.00E+00
Radioactive waste disposed	kg	3.47E-03	2.70E-04	2.06E-05	3.76E-03	0.00E+00	0.00E+00

Output flows

Results per tonne insulated precast concrete, sandwich wall							
Indicator	Unit	A1	A2	A3	Tot.A1-A3	A4	B1
Components for re-use	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Material for recycling	kg	5.36E-03	0.00E+00	3.14E+00	3.15E+00	0.00E+00	0.00E+00
Materials for energy recovery	kg	1.10E-02	0.00E+00	6.04E+00	6.06E+00	0.00E+00	0.00E+00
Exported energy, electricity	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Exported energy, thermal	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

Interpretation of LCA results

Environmental impact for 1 tonne of precast product is mainly caused by module A1, see Figure 1. Module A2 contributes marginally to the parameters, and the contribution from A3 and A4 is almost insignificant. B1, has a marginal positive impact on the global warming potential, which is shown as a negative bar in the figure.

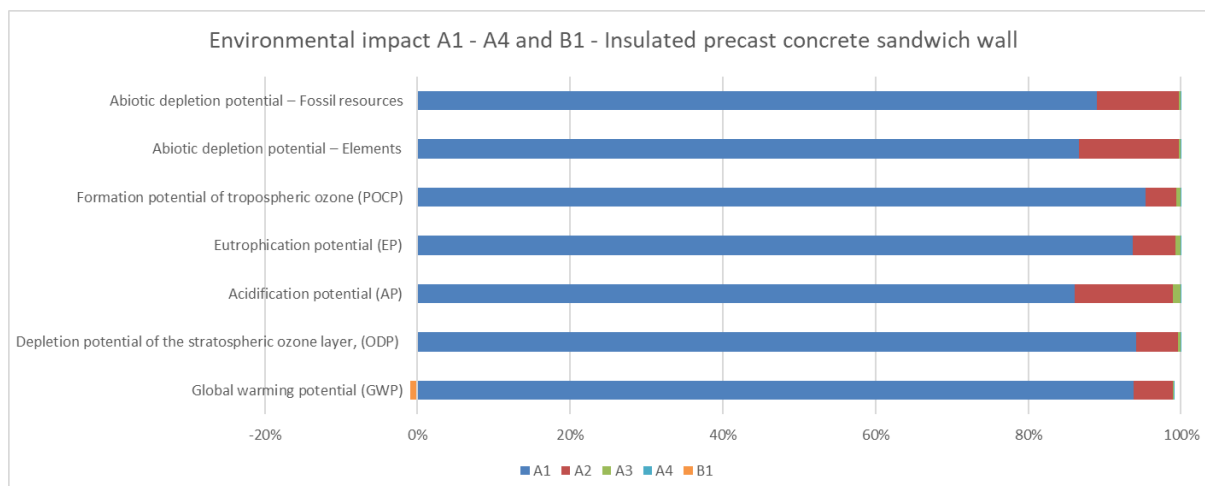


Figure 1. Figure of the contributions from the environmental impacts in A1-A4 for insulated precast concrete sandwich walls.

Module A1 consumes the majority of resources and produces the majority of the waste compared to Module A2-A4.

Within module A1, the extraction and processing of cement and iron reinforcement used in the product is the main contributor to the environmental impact, see Figure 2. Impact in A1 is further increases by produced waste mainly in the form of reinforcement and wood. Impact from other waste in the process is insignificant. The water used in the products is drawn from the groundwater. In the area where the manufacturing takes place, the water supply is deemed as good and water scarcity is not an issue.

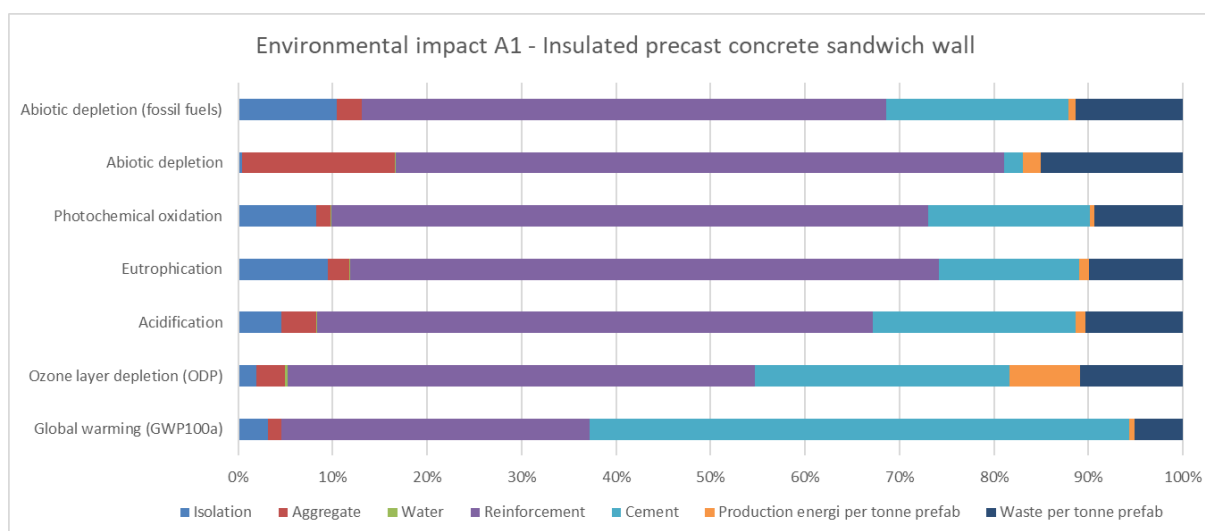


Figure 2. Figure of the contributions from the environmental impacts in A1 for insulated precast concrete sandwich walls.

Additional information

The calculations of B1 have been done according to the standard SS-EN 16757:2017 – Sustainability of construction works – Environmental product declarations – Product Category Rules for concrete and concrete elements.

References

General Programme Instructions of the International EPD® System. Version 3.01.

SS-EN 15804:2012 Sustainability of construction works – Environmental product declarations – Product Category Rules for concrete and concrete elements

PCR 2012:01. Construction products and construction services. V2.3
PCR 2012:01-Sub-PCR-G

SS-EN 16757:2017 Sustainability of construction works – Environmental product declarations – product Category Rules for concrete and concrete elements



Ecoinvent 3.6 database, <http://www.ecoinvent.org/>
Agri-footprint database, <https://www.agri-footprint.com/>

LCA software SimaPro Analyst 9.1.1.1

Material Safety Data sheets for:

- Superplasticizer masterglenium Ace 435
- Air-entraining admixtures Masterair 100
- Dynamon SX-A170

Contact information:

EPD owner:	BOHUS BETONG Bohus Betong AB, Svarteborg 27, 455 97 Dingle www.bohusbetong.se Bertil Eliasson, bertil@bohusbetong.se +46 524 281 70
LCA author:	 WSP Sverige AB, www.wsp.com Lisa Rasmusson, lisa.rasmusson@wsp.com +46 107 210 818
Programme operator:	 EPD International AB info@environdec.com

