

Environmental Product Declaration



Environmental Product Declaration for various ready mix concrete products produced by Holcim México Operaciones S.A. de C.V. at their Isla Blanca facility in Cancun

ADMINISTRATIVE INFORMATION

International Certified Environmental Product Declaration

Declared Product:	This Environmental Product Declaration (EPD) covers concrete products produced by Holcim México Operaciones S.A. de C.V.. Declared unit: 1 m ³ of concrete
Declaration Owner:	Holcim México Operaciones S.A. de C.V.
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	Ciudad de México, México
	www.holcim.com.mx
Program Operator:	Labeling Sustainability
	11670 W Sunset Blvd.
	Los Angeles, CA
	www.labelingsustainability.com/
Product Category Rule:	Core PCR: ISO 21930:2017 Sustainability in buildings and civil engineering works – Core rules for environmental product declarations of construction products and services SubPCR: NSF International (March 2020). Product Category Rule (PCR) for Environmental Product Declarations (EPD) PCR for Concrete, v2.1
	Sub PCR Program Operator: NSF International
	Sub-category PCR review was conducted by: Thomas P. Gloria, Ph. D. of Industrial Ecology Consultants: 35 Bracebridge Rd., Newton, MA 02459-1728, t.gloria@industrial-ecology.com. Dr. Michael Overcash of Environmental Clarity: 2908 Chipmunk Lane, Raleigh, NC 27607-3117, mrovercash@earthlink.net. Mr. Bill Stough of Sustainable Research Group: PO Box 1684, Grand Rapids, MI 49501-1684, bstough@sustainableresearchgroup.com. Mr. Jack Geilbig, EcoForm: 2624 Abelia Way, Suite 611, Knoxville, TN 37931, jgeilbig@ecoform.com.
Independent LCA Reviewer and EPD Verifier:	This EPD was independently verified in accordance with ISO 14025 and ISO 21930. The life cycle assessment was independently reviewed in accordance ISO 14044 and the referenced PCR.
	Independent verification of the declaration, according to ISO 14025:2006
	Internal <input type="checkbox"/> ; External <input checked="" type="checkbox"/>
	Third Party Verifier Geoffrey Guest, Certified 3rd Party Verifier under the International EPD Program (www.environdec.com), CSA Group (www.csaregistry.ca)
Date of Issue:	24 July 2023
Period of Validity:	5 years; valid until 23 July 2028
EPD Number:	235c63fc-d6ec-41f9-a1a9-0115ed85c408



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COMPANY DESCRIPTION

Holcim Mexico produces and markets cement, ready-mix concrete, and other products and services for construction. The company has a nationwide presence through 7 cement plants with a current installed capacity to produce 12.6 million tons per year, 23 cement distribution centers, two maritime terminals, 1 Corporate Office, plus 35 ready-mix concrete plants, seven platforms, and a Geocycle transfer center, 26 commercial partners with more than 90 ready-mix concrete plants, more than 500 mixing pots, one aggregates plant and a Technological Innovation Center for Construction (CITEC).

Sustainable Development is an integral part of Lafarge Holcim's strategy around the world. Holcim Mexico has a clear vision of the future it wants for our country, which contributes to its development. Holcim Mexico's main objective is to create value. Creating value ensures long-term business success in covering the triple bottom line (i.e., social, economic, environmental values). Finally, good operating performance and a solid return on invested capital go hand in hand with sustainable development.

Holcim continues to invest in research and development. They have the Innovation and Development Center, located in Lyon (France), with satellite locations in various regions developing a comprehensive portfolio of innovators and sustainable solutions. These include different categories: inclusive business models, water management solutions, urban mining solutions (recycled aggregates), waste treatment services, energy-efficient solutions (insulating building materials), resource-efficient solutions (high recycled content, bags soluble cement), and low CO₂ building materials.

Holcim operates with the belief that they can gain an advantage by developing knowledge and brand equity in the green building segment.

STUDY GOAL

The intended application of this life cycle assessment (LCA) is to comply with the procedures for creating a Type III environmental product declaration (EPD) and publish the EPD for public review on the website, <http://labelingsustainability.com/>. This level of study is in accordance with EPD Product Category Rule (PCR) for Ready Mix Concrete published by NSF International (2019) and is a sub-PCR of International Standards Organization (ISO) 21930:2017 Sustainability in buildings and civil works - Core rules for EPDs of construction products and services; International Standards Organization (ISO) 14025:2006 Environmental labels and declarations, Type III environmental declarations-Principles and procedures; ISO 14044:2006 Environmental management, Life cycle assessment- Requirements and guidelines; and ISO 14040:2006 Environmental management, Life cycle assessment-Principles and framework. The performance of this study and its subsequent publishing is in alignment with the business-to-business (B2B) communication requirements for the environmental assessment of building products. The study does not intend to support comparative assertions and is intended to be disclosed to the public.

This project report was commissioned to differentiate Holcim México Operaciones S.A. de C.V. from their competition for the following reasons: generate an advantage for the organization; offer customers information to help them make informed product decisions; improve the environmental performance of Holcim México Operaciones S.A. de C.V. by continuously measuring, controlling and reducing the environmental impacts of their products; help project facilitators working on Leadership



in Energy and Environmental Design (LEED) projects achieve their credit goal; and to strengthen Holcim México Operaciones S.A. de C.V.'s license to operate in the community. The intended audience for this LCA report is Holcim México Operaciones S.A. de C.V.'s employees, their suppliers, project specifiers of their products, architects, and engineers. The EPD report is also available for policy makers, government officials interested in sustainability, academic professors, and LCA professionals. This LCA report does not include product comparisons from other facilities.

DESCRIPTION OF PRODUCT AND SCOPE

This EPD reports on 24 concrete mixes manufactured at the Holcim Mexico Operaciones S.A. de C.V. Isla Blanca concrete facility in Q. Roo., México.

This LCA assumes the impacts from products manufactured in accordance with the standards outlined in this report. This LCA is a cradle-to-gate study, and therefore, stages extending beyond the plant gate are not included in this LCA. Excluded stages include transportation of the manufactured material to the construction site; on-site construction processes and components; building (infrastructure) use and maintenance; and "end-of-life" effects.

READY MIX CONCRETE DESIGN SUMMARY

The following tables provide a list of the ready mix concrete products considered in this EPD along with key performance parameters.

Mix designs: 0 to 15 MPa

Table 1: Declared products with Mix designs: 0 to 15MPa considered in this environmental product declaration

Mix#	Unique name/ID	Short description	Product type	28 day strength, MPa	H ₂ O to cement ratio
3	77035ND2014	3.5 MPa 28d strength Ready mix concrete	Ready mix concrete	3.5	0.6710963
4	77036ND2010	3.6 MPa 28d strength Ready mix concrete	Ready mix concrete	3.6	0.6430868
5	77038ND2010	3.8 MPa 28d strength Ready mix concrete	Ready mix concrete	3.8	0.6137072
6	77040ND2010	4 MPa 28d strength Ready mix concrete	Ready mix concrete	4.0	0.5891239
7	77042ND2010	4.2 MPa 28d strength Ready mix concrete	Ready mix concrete	4.2	0.5664740
8	77045ND2010	4.5 MPa 28d strength Ready mix concrete	Ready mix concrete	4.5	0.5441989
9	77048ND2010	4.8 MPa 28d strength Ready mix concrete	Ready mix concrete	4.8	0.5250660
10	77050ND2010	5 MPa 28d strength Ready mix concrete	Ready mix concrete	5.0	0.5037783
11	73050NB0518	5.4 MPa 28d strength mortars and fillers	mortars and fillers	5.4	0.7745455
12	70100NB2018	12.8 MPa 28d strength Ready mix concrete	Ready mix concrete	12.8	0.9173913



13	73100NB0518	12.8 MPa 28d strength mortars and fillers	mortars and fillers	12.8	1.1593407
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Mix designs: 15 to 20 MPa

Table 2: Declared products with Mix designs: 15 to 20MPa considered in this environmental product declaration

Mix#	Unique name/ID	Short description	Product type	28 day strength, MPa	H ₂ O to cement ratio
14	70150NB2014	17.7 MPa 28d strength Ready mix concrete	Ready mix concrete	17.7	0.8138528
15	73150NB0514	17.7 MPa 28d strength mortars and fillers	mortars and fillers	17.7	0.8390244

Mix designs: 21 to 25 MPa

Table 3: Declared products with Mix designs: 21 to 25MPa considered in this environmental product declaration

Mix#	Unique name/ID	Short description	Product type	28 day strength, MPa	H ₂ O to cement ratio
16	70200NB2014	22.6 MPa 28d strength Ready mix concrete	Ready mix concrete	22.6	0.7148289
17	73200NB0518	22.1 MPa 28d strength mortars and fillers	mortars and fillers	22.1	0.7745455

Mix designs: 26 to 30 MPa

Table 4: Declared products with Mix designs: 26 to 30MPa considered in this environmental product declaration

Mix#	Unique name/ID	Short description	Product type	28 day strength, MPa	H ₂ O to cement ratio
18	04250NB2014	27.5 MPa 28d strength Ready mix concrete	Ready mix concrete	27.5	0.5679012
19	73250NB0514	27 MPa 28d strength mortars and fillers	mortars and fillers	27.0	0.6463415

Mix designs: 31 to 35 MPa

Table 5: Declared products with Mix designs: 36 to 40MPa considered in this environmental product declaration

Mix#	Unique name/ID	Short description	Product type	28 day strength, MPa	H ₂ O to cement ratio
20	04300NB2018	32.4 MPa 28d strength Ready mix concrete	Ready mix concrete	32.4	0.5830816
21	73300NB0518	32.4 MPa 28d strength mortars and fillers	mortars and fillers	32.4	0.5702479



Mix designs: 36 to 40 MPa

Table 6: Declared products with Mix designs: 36 to 40MPa considered in this environmental product declaration

Mix#	Unique name/ID	Short description	Product type	28 day strength, MPa	H2O to cement ratio
22	04350NB2018	37.3 MPa 28d strength Ready mix concrete	Ready mix concrete	37.3	0.5284553
23	56350NB1065	37.3 MPa 28d strength special concrete	special concrete	37.3	0.3431373
24	73350NB0514	36.8 MPa 28d strength mortars and fillers	mortars and fillers	36.8	0.4942263

Mix designs: 41 to 45 MPa

Table 7: Declared products with Mix designs: 41 to 45MPa considered in this environmental product declaration

Mix#	Unique name/ID	Short description	Product type	28 day strength, MPa	H2O to cement ratio
2	3740ND1018	42.2 MPa 28d strength Ready mix concrete	Ready mix concrete	42.2	0.5454545

Mix designs: 51 to 55 MPa

Table 8: Declared products with Mix designs: 51 to 55MPa considered in this environmental product declaration

Mix#	Unique name/ID	Short description	Product type	28 day strength, MPa	H2O to cement ratio
1	3735NB2018	53.9 MPa 28d strength Ready mix concrete	Ready mix concrete	53.9	0.195

READY MIX CONCRETE DESIGN COMPOSITION

The following figures provide mass breakdown (kg per functional unit) of the material composition of each ready mix concrete design considered. Please note that the presented breakdown has been randomly altered by +/-10%, and is therefore only an approximation; this manipulation is to ensure confidentiality.

Table 9: Design composition

Product Components	Raw Material, weight%
Cement	Proprietary
Aggregates	30-60.00
Others	0.01-5.00
Total	100.00



SYSTEM BOUNDARIES

The following figure depicts the cradle-to-gate system boundary considered in this study:

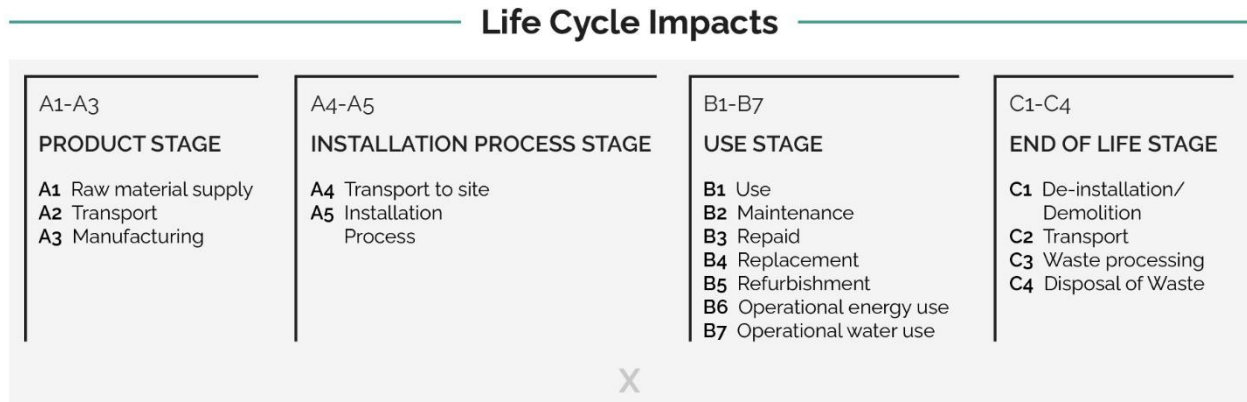


Figure 1: **General life cycle phases for consideration in a construction works system**

This is a Cradle-to-gate life cycle assessment and the following life cycle stages are included in the study:

- A1: Raw material supply (upstream processes) - Extraction, handling, and processing of the materials used in manufacturing the declared products in this LCA.
- A2: Transportation - Transportation of A1 materials from the supplier to the “gate” of the manufacturing facility (i.e. A3).
- A3: Manufacturing (core processes)- The energy and other utility inputs used to store, move, and manufacturer the declared products and to operate the facility.

As according to the PCR, the following figure illustrates the general activities and input requirements for producing ready mix concrete products and is not necessarily exhaustive.

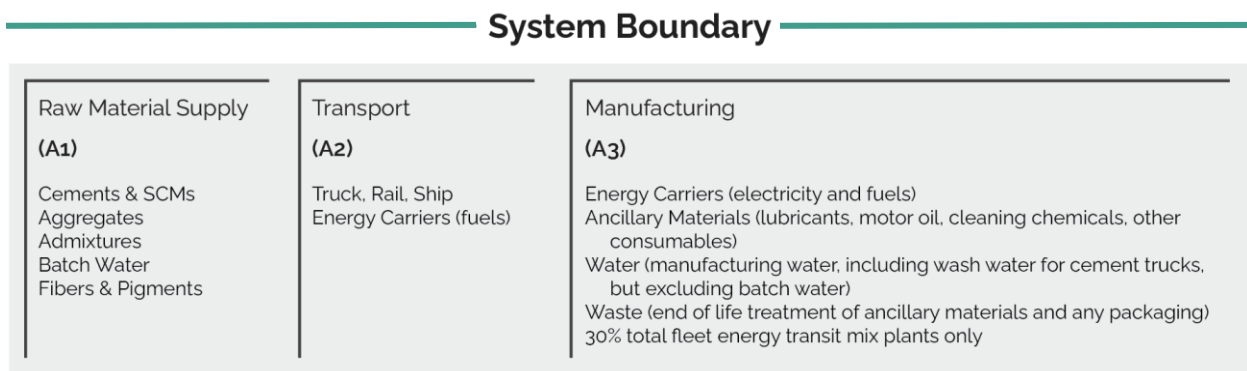


Figure 2: **General system inputs considered in the product system and categorized by modules in scope**

In addition, as according to the relevant PCR, the following requirements are excluded from this study:



- Production, manufacture and construction of A3 building/capital goods and infrastructure;
- Production and manufacture of steel production equipment, steel delivery vehicles, earth-moving equipment, and laboratory equipment;
- Personnel-related activities (travel, furniture, office supplies);
- Energy use related to company management and sales activities.

For this LCA the manufacturing plant, owned and operated by Holcim México Operaciones S.A. de C.V., is located at their Planta Isla Blanca facility in México. All operating data is formulated using the actual data from Holcim México Operaciones S.A. de C.V.'s plant at the above location, including water, energy consumption and waste generation. All inputs for this system boundary are calculated for the plant.

This life cycle inventory was organized in a spreadsheet and was then input into an RStudio environment where pre-calculated LCIA results for relevant products/activities stemming from the ecoinvent v3.8 database and a local EPD database in combination with primary data from Holcim México Operaciones S.A. de C.V. were utilized. Explanations of the contribution of each data source to this study are outlined in the section 'Data Sources and Quality'. Further LCI details for each declared product are provided in the sections 'Detailed LCI tables' and 'Transport tables' of the detailed LCA report. A parameter uncertainty analysis was also performed where key statistical results (e.g. min/mean/max etc.) are provided in the detailed LCA report.

CUT-OFF CRITERIA

ISO 14044:2006 and the focus PCR requires the LCA model to contain a minimum of 95% of the total inflows (mass and energy) to the upstream and core modules be included in this study. The cut-off criteria were applied to all other processes unless otherwise noted above as follows. A 1% cut-off is considered for all renewable and non-renewable primary energy consumption and the total mass of inputs within a unit process where the total of the neglected inputs does not exceed 5%.

DATA SOURCES AND DATA QUALITY ASSESSMENT

Raw material transport: A combination of actual mode/distance combinations were assumed for key bulk materials whereas ecoinvent default multi-modal market mix distances were assumed for other inputs where no original data could be provided.

Electricity: Electricity consumption values are for Holcim Mexico in calendar year 2022. These values were direct reported from Holcim records. The unit process "market for electricity, medium voltage/electricity, medium voltage/MX/kWh" was used to represent the Mexico grid electricity used by the concrete plant.

Process/space heating: No fuel is used for space heating at this plant.

Fuel required for machinery: Machinery-related fuel requirements were determined from direct Holcim information. The types of machinery used include generators, pumps to pump concrete to higher elevations, and transportation equipment used for moving materials.



Waste generation: Waste generation values are directly reported from Holcim operations for both bulk waste and hazardous waste. No High-level radioactive waste is generated on-site at this facility. Wash water values are direct reported water use from Holcim México for 2022.

Recovered energy: Not applicable.

Recycled/reused material/components: The amount of returned concrete is based on Holcim primary data for the reference year, 2022..

Module A1 material losses: Due to lack of data, default loss factors of 5% were assumed. The PCR states " A3 shall include an assumption of 5% material loss unless product specific data is available and transparently reported in the project LCA report underlying the EPD;"

Direct A3 emissions accounting: Direct emissions are modeled using fuel and technology appropriate ecoinvent activities. See LCI input tables for details.

Waste transport requirements: Transportation distances are using estimated values. The waste hauler cannot guarantee the exact distances traveled due to the variation of route and actual location of disposal. Most waste disposal sites are near the plant therefore the 25 km distance is a representative estimate. Returned concrete and wash water, measured in kilograms, is based on direct Holcim reporting for the reference year 2022.

Product transport requirements: The diesel fuel used by the mixing trucks is direct primary information reported from Holcim México records for the year 2022. The concrete PCR allots 30% of the overall mixing truck total for stage A3 (manufacturing) for mixing the materials.

The following tables depict a list of assumed life cycle inventory utilized in the LCA modeling to generate the impact results across the life cycle modules in scope. An assessment of the quality of each LCI activities utilized from various sources is also provided.

Table 10: LCI inputs assumed for module A1 (i.e. raw material supply) *Data Quality Assessment Key Fair=1, Good=2, Very Good =3.*

Input	LCI.activity	Data.source	Geo	Year	Technology	Time	Geography	Reliability	Completeness
Water	tap water production, conventional with biological treatment/tap water/RoW/kg	ecoinvent v3.8	Estado de Mexico	v3.8 in 2021	2	3	1	3	3
Limestone Gravel	limestone quarry operation/limestone, unprocessed/RoW/kg ; Note: modifications made (see ecoinvent activity changes table)	ecoinvent v3.8	Yucatan, Quintana Roo	v3.8 in 2021	2	3	1	3	3



Additives	market for chemical, organic/chemical, organic/GLO/kg	ecoinvent v3.8	Estado de Mexico	v3.8 in 2021	2	3	1	3	3
Silica fume	market for silica fume, densified silica fume, densified Cutoff, S	ecoinvent v3.8	Tabasco	v3.8 in 2021	3	3	3	3	3
Cement (CPC 40) - PROVEEDOR : HOLCIM MACUSPAN A	CPC 40	Progam Operator: Labeling Sustainability-EPD ID: 09cddb67-dd75-4879-9c7d-74d4664d8e10	Tabasco	30 November 2021	3	NA	3	3	3

DATA QUALITY ASSESSMENT

Data quality/variability requirements, as specified in the PCR, are applied. This section describes the achieved data quality relative to the ISO 14044:2006 requirements. Data quality is judged based on its precision (measured, calculated, or estimated), completeness (e.g., unreported emissions), consistency (degree of uniformity of the methodology applied within a study serving as a data source) and representativeness (geographical, temporal, and technological).

Precision: Through measurement and calculation, the manufacturers collected and provided primary data on their annual production. For accuracy, the LCA practitioner and 3rd Party Verifier validated the plant gate-to-gate data.

Completeness: All relevant specific processes, including inputs (raw materials, energy, and ancillary materials) and outputs (emissions and production volume) were considered and modeled to represent the specified and declared products. The majority of relevant background materials and processes were taken from ecoinvent v3.8 LCI datasets where relatively recent region-specific electricity inputs were utilized. The most relevant EPDs requiring key A1 inputs were also utilized where readily available.

Consistency: To ensure consistency, the same modeling structure across the respective product systems was utilized for all inputs, which consisted of raw material inputs and ancillary material, energy flows, water resource inputs, product, and co-products outputs, returned and recovered Ready Mix Concrete materials, emissions to air, water and soil, and waste recycling and treatment. The same background LCI datasets from the ecoinvent v3.8 database were used across all product systems. Crosschecks concerning the plausibility of mass and energy flows were continuously conducted. The LCA team conducted mass and energy balances at the plant and selected process level to maintain a high level of consistency.

Reproducibility: Internal reproducibility is possible since the data and the models are stored and available in a machine readable project file for all foreground and background processes, and in Labeling Sustainability's proprietary Ready Mix Concrete LCA calculator* for all production facility



and product-specific calculations. A considerable level of transparency is provided throughout the detailed LCA report as the specifications and material quantity make-up for the declared products are presented and key primary and secondary LCI data sources are summarized. The provision of more detailed publicly accessible data to allow full external reproducibility was not possible due to reasons of confidentiality.

*Labeling Sustainability has developed a proprietary tool that allows the calculation of PCR-compliant LCA results for Ready Mix Concrete product designs. The tool auto-calculates results by scaling base-unit technosphere inputs (i.e. 1 kg sand, 1 kWh electricity, etc.) to replicate the reference flow conversions that take place in any typical LCA software like openLCA or SimaPro. The tool was tested against several LCAs performed in openLCA and the tool generated identical results to those realized in openLCA across every impact category and inventory metric (where comparisons could be readily made).

Representativeness: The representativeness of the data is summarized as follows.

- Time related coverage of the manufacturing processes' primary collected data from 2022-01-01 to 2022-12-31.
- Upstream (background) LCI data was either the PCR specified default (if applicable) or more appropriate LCI datasets as found in the country-adjusted ecoinvent v3.8 database.
- Geographical coverage for inputs required by the A3 facility(ies) is representative of its region of focus; other upstream and background processes are based on US, North American, or global average data and adjusted to regional electricity mixes when relevant.
- Technological coverage is typical or average and specific to the participating facilities for all primary data.

ENVIRONMENTAL INDICATORS AND INVENTORY METRICS

Per the PCR, this EPD supports the life cycle impact assessment indicators and inventory metrics as listed in the tables below. As specified in the PCR, the most recent US EPA Tool for the Reduction and Assessment of Chemical and Other Environmental Impacts (TRACI), impact categories were utilized as they provide a North American context for the mandatory category indicators to be included in the EPD. Additionally, the PCR requires a set of inventory metrics to be reported with the LCIA indicators (see tables below).

It should be noted that emerging LCA impact categories and inventory items are still under development and can have high levels of uncertainty that preclude international acceptance pending further development. Use caution when interpreting data in any of the following categories.

LIMITATIONS

This EPD is a declaration of potential environmental impact and does not support or provide definitive comparisons of the environmental performance of specific products. Only EPDs prepared from cradle-to-grave life cycle results and based on the same function and reference service life and quantified by the same functional unit can be used to assist purchasers and users in making informed comparisons between products.



LCIA results are relative expressions and do not predict impacts on category endpoints, the exceeding of thresholds, safety margins or risks. Further, LCA offers a wide array of environmental impact indicators, and this EPD reports a collection of those, as specified by the PCR.

In addition to the impact results, this EPD provides several metrics related to resource consumption and waste generation. While these data may be informational in other ways, they do not provide a measure of impact on the environment

TOTAL IMPACT SUMMARY

The following table reports the total LCA results for each product produced at the given ready mix concrete facility on a per 1m³ of concrete basis.

Mix designs: 0 to 15 MPa

Table 11: Total life cycle (across modules in scope) impact results for Mix designs: 0 to 15MPa, assuming the geometric mean point values on a per 1 m³ of concrete basis

a) Midpoint Impact Categories:

Indicator/LCI Metric	AP	EP	GWP	ODP	PCOP	ADPe	ADPf
Unit	moles of H ⁺ -Eq	kg N	kg CO ₂ -Eq	kg CFC-11-Eq	kg NO _x -Eq	kg Sb-Eq	MJ, net calorific value
Minimum	35.5	0.204	291	2.89e-05	0.495	0.00074	2150
Maximum	60.4	0.245	508	4.87e-05	0.837	0.00128	3590
Mean	50.7	0.229	423	4.11e-05	0.705	0.00107	3030
Median	51.8	0.231	432	4.2e-05	0.72	0.00109	3090
77035ND2014	49.5	0.227	412	4.02e-05	0.688	0.00104	2960
77036ND2010	50.7	0.229	422	4.11e-05	0.704	0.00107	3020
77038ND2010	51.8	0.231	432	4.2e-05	0.72	0.00109	3090
77040ND2010	53	0.233	442	4.29e-05	0.736	0.00112	3160
77042ND2010	54.7	0.236	457	4.42e-05	0.759	0.00116	3250
77045ND2010	56.5	0.239	473	4.57e-05	0.784	0.0012	3360
77048ND2010	58.4	0.242	490	4.71e-05	0.81	0.00124	3470
77050ND2010	60.4	0.245	508	4.87e-05	0.837	0.00128	3590
73050NB0518	46.4	0.222	386	3.76e-05	0.645	0.000981	2790
70100NB2018	41.3	0.214	341	3.36e-05	0.575	0.000864	2480
73100NB0518	35.5	0.204	291	2.89e-05	0.495	0.00074	2150

b) Inventory Metrics:

Indicator/LCI Metric	TPE	RE	NRE	NR	RR	WD	LFW	LFHW	CBW	CWW	CHW	CNH
Unit	MJ-Eq	MJ-Eq	MJ-Eq	kg	m ³	m ³	kg waste	kg waste	m ³	m ³	kg	kg
Minimum	2370	66.2	2290	57.3	0.00303	0.478	168	0.00425	0.205	1.35e-05	0.0224	87.4



Maximum	400 0	126	384 0	95. 7	0.0060 8	0.67 2	202	0.0063 4	0.224	1.35e- 05	0.022 4	87.4
Mean	336 0	103	325 0	80. 8	0.0048 1	0.59 4	189	0.0055 5	0.212	1.35e- 05	0.022 4	87.4
Median	342 0	104	333 0	82. 6	0.0048 6	0.59 7	191	0.0056 5	0.21	1.35e- 05	0.022 4	87.4
77035ND20 14	328 0	99. 3	318 0	79. 2	0.0045 6	0.58 4	188	0.0054 6	0.212	1.35e- 05	0.022 4	87.4
77036ND20 10	334 0	103	325 0	80. 6	0.0047 4	0.59 1	189	0.0055 5	0.21	1.35e- 05	0.022 4	87.4
77038ND20 10	342 0	104	333 0	82. 6	0.0048 6	0.59 7	191	0.0056 5	0.207	1.35e- 05	0.022 4	87.4
77040ND20 10	350 0	108	339 0	84. 5	0.0051 5	0.60 5	192	0.0057 4	0.205	1.35e- 05	0.022 4	87.4
77042ND20 10	362 0	112	350 0	86. 4	0.0053 8	0.62	194	0.0058 8	0.206	1.35e- 05	0.022 4	87.4
77045ND20 10	373 0	116	362 0	89. 4	0.0055 8	0.63 6	197	0.0060 3	0.207	1.35e- 05	0.022 4	87.4
77048ND20 10	389 0	121	374 0	92. 8	0.0057 2	0.65 4	199	0.0061 8	0.209	1.35e- 05	0.022 4	87.4
77050ND20 10	400 0	126	384 0	95. 7	0.0060 8	0.67 2	202	0.0063 4	0.21	1.35e- 05	0.022 4	87.4
73050NB05 18	308 0	92. 7	299 0	74.4	0.0042 6	0.57 1	183	0.0051 7	0.224	1.35e- 05	0.022 4	87.4
70100NB20 18	275 0	80. 4	266 0	66.1	0.0035 5	0.52 5	177	0.0047 7	0.222	1.35e- 05	0.022 4	87.4
73100NB05 18	237 0	66. 2	229 0	57.3	0.0030 3	0.47 8	168	0.0042 5	0.222	1.35e- 05	0.022 4	87.4

Mix designs: 15 to 20 MPa

Table 12: Total life cycle (across modules in scope) impact results for Mix designs: 15 to 20MPa, assuming the geometric mean point values on a per 1 m3 of concrete basis

a) Midpoint Impact Categories:

Indicator/LCI Metric	AP	EP	GWP	ODP	PCOP	ADPe	ADPf
Unit	moles of H ⁺ -Eq	kg N	kg CO ₂ -Eq	kg CFC-11-Eq	kg NO _x -Eq	kg Sb-Eq	MJ, net calorific value
Minimum	37.9	0.208	314	3.09e-05	0.529	0.000794	2290
Maximum	41.7	0.215	343	3.4e-05	0.581	0.000872	2500
Mean	39.8	0.212	328	3.24e-05	0.555	0.000833	2400
Median	39.8	0.212	328	3.24e-05	0.555	0.000833	2400
70150NB2014	41.7	0.215	343	3.4e-05	0.581	0.000872	2500
73150NB0514	37.9	0.208	314	3.09e-05	0.529	0.000794	2290



b) Inventory Metrics:

Indicator/LCI Metric	TPE	RE	NR E	NR R	RR	WD P	LFW	LFHW	CBW C	CWW C	CHW	CNH W
Unit	MJ-Eq	MJ-Eq	MJ-Eq	kg	m3	m3	kg waste	kg waste	m3	m3	kg	kg
Minimum	2510	72.2	2460	61.2	0.00329	0.457	171	0.00444	0.181	1.35e-05	0.0224	87.4
Maximum	2760	80.1	2700	66.9	0.00365	0.502	178	0.00484	0.197	1.35e-05	0.0224	87.4
Mean	2640	76.2	2580	64.1	0.00347	0.48	174	0.00464	0.189	1.35e-05	0.0224	87.4
Median	2640	76.2	2580	64.1	0.00347	0.48	174	0.00464	0.189	1.35e-05	0.0224	87.4
70150NB2014	2760	80.1	2700	66.9	0.00365	0.502	178	0.00484	0.197	1.35e-05	0.0224	87.4
73150NB0514	2510	72.2	2460	61.2	0.00329	0.457	171	0.00444	0.181	1.35e-05	0.0224	87.4

Mix designs: 21 to 25 MPa

Table 13: Total life cycle (across modules in scope) impact results for Mix designs: 21 to 25MPa, assuming the geometric mean point values on a per 1 m3 of concrete basis

a) Midpoint Impact Categories:

Indicator/LCI Metric	AP	EP	GWP	ODP	PCOP	ADPe	ADPf
Unit	moles of H+-Eq	kg N	kg CO2-Eq	kg CFC-11-Eq	kg NOx-Eq	kg Sb-Eq	MJ, net calorific value
Minimum	45.5	0.221	376	3.7e-05	0.633	0.000955	2720
Maximum	46.4	0.222	386	3.76e-05	0.645	0.000981	2790
Mean	46	0.222	381	3.73e-05	0.639	0.000968	2760
Median	46	0.222	381	3.73e-05	0.639	0.000968	2760
70200NB2014	45.5	0.221	376	3.7e-05	0.633	0.000955	2720
73200NB0518	46.4	0.222	386	3.76e-05	0.645	0.000981	2790

b) Inventory Metrics:

Indicator/LCI Metric	TPE	RE	NR E	NR R	RR	WD P	LFW	LFHW	CBW C	CWW C	CHW	CNH W
Unit	MJ-Eq	MJ-Eq	MJ-Eq	kg	m3	m3	kg waste	kg waste	m3	m3	kg	kg
Minimum	3020	89.8	2920	72.8	0.00403	0.533	183	0.00515	0.197	1.35e-05	0.0224	87.4
Maximum	3100	91.7	2970	74.4	0.00416	0.571	183	0.00517	0.224	1.35e-05	0.0224	87.4



Mean	3060	90.8	2940	73.6	0.00409	0.552	183	0.00516	0.211	1.35e-05	0.0224	87.4
Median	3060	90.8	2940	73.6	0.00409	0.552	183	0.00516	0.211	1.35e-05	0.0224	87.4
70200NB2014	3020	89.8	2920	72.8	0.00403	0.533	183	0.00515	0.197	1.35e-05	0.0224	87.4
73200NB0518	3100	91.7	2970	74.4	0.00416	0.571	183	0.00517	0.224	1.35e-05	0.0224	87.4

Mix designs: 26 to 30 MPa

Table 14: Total life cycle (across modules in scope) impact results for Mix designs: 26 to 30MPa, assuming the geometric mean point values on a per 1 m3 of concrete basis

a) Midpoint Impact Categories:

Indicator/LCI Metric	AP	EP	GWP	ODP	PCOP	ADPe	ADPf
Unit	moles of H+-Eq	kg N	kg CO2-Eq	kg CFC-11-Eq	kg NOx-Eq	kg Sb-Eq	MJ, net calorific value
Minimum	52.3	0.232	436	4.22e-05	0.725	0.0011	3120
Maximum	52.3	0.232	436	4.22e-05	0.725	0.0011	3120
Mean	52.3	0.232	436	4.22e-05	0.725	0.0011	3120
Median	52.3	0.232	436	4.22e-05	0.725	0.0011	3120
04250NB2014	52.3	0.232	436	4.22e-05	0.725	0.0011	3120
73250NB0514	52.3	0.232	436	4.22e-05	0.725	0.0011	3120

b) Inventory Metrics:

Indicator/LCI Metric	TPE	RE	NRE	NR	RR	WDP	LFW	LFHW	CBWC	CWWC	CHW	CNH
Unit	MJ-Eq	MJ-Eq	MJ-Eq	kg	m3	m3	kg waste	kg waste	m3	m3	kg	kg
Minimum	3460	107	3350	83.3	0.00501	0.587	190	0.00563	0.193	1.35e-05	0.0224	87.4
Maximum	3470	107	3360	83.5	0.00502	0.62	192	0.00571	0.223	1.35e-05	0.0224	87.4
Mean	3460	107	3360	83.4	0.00502	0.603	191	0.00567	0.208	1.35e-05	0.0224	87.4
Median	3460	107	3360	83.4	0.00502	0.603	191	0.00567	0.208	1.35e-05	0.0224	87.4
04250NB2014	3470	107	3350	83.3	0.00501	0.587	192	0.00571	0.193	1.35e-05	0.0224	87.4
73250NB0514	3460	107	3360	83.5	0.00502	0.62	190	0.00563	0.223	1.35e-05	0.0224	87.4



Mix designs: 31 to 35 MPa

Table 15: Total life cycle (across modules in scope) impact results for Mix designs: 31 to 35MPa, assuming the geometric mean point values on a per 1 m³ of concrete basis

a) Midpoint Impact Categories:

Indicator/LCI Metric	AP	EP	GWP	ODP	PCOP	ADPe	ADPf
Unit	moles of H ⁺ -Eq	kg N	kg CO ₂ -Eq	kg CFC-11-Eq	kg NO _x -Eq	kg Sb-Eq	MJ, net calorific value
Minimum	53.2	0.234	443	4.31e-05	0.738	0.00112	3170
Maximum	56.2	0.238	472	4.53e-05	0.779	0.0012	3350
Mean	54.7	0.236	458	4.42e-05	0.758	0.00116	3260
Median	54.7	0.236	458	4.42e-05	0.758	0.00116	3260
04300NB2018	53.2	0.234	443	4.31e-05	0.738	0.00112	3170
73300NB0518	56.2	0.238	472	4.53e-05	0.779	0.0012	3350

b) Inventory Metrics:

Indicator/LCI Metric	TPE	RE	NRE	NR R	RR	WD P	LFW	LFHW	CBW C	CWW C	CHW	CNH W
Unit	MJ-Eq	MJ-Eq	MJ-Eq	kg	m ³	m ³	kg waste	kg waste	m ³	m ³	kg	kg
Minimum	3520	111	3410	84.8	0.00505	0.604	193	0.00578	0.203	1.35e-05	0.0224	87.4
Maximum	3730	117	3590	89.4	0.00556	0.647	195	0.00595	0.217	1.35e-05	0.0224	87.4
Mean	3620	114	3500	87.1	0.0053	0.626	194	0.00586	0.21	1.35e-05	0.0224	87.4
Median	3620	114	3500	87.1	0.0053	0.626	194	0.00586	0.21	1.35e-05	0.0224	87.4
04300NB2018	3520	111	3410	84.8	0.00505	0.604	193	0.00578	0.203	1.35e-05	0.0224	87.4
73300NB0518	3730	117	3590	89.4	0.00556	0.647	195	0.00595	0.217	1.35e-05	0.0224	87.4

Mix designs: 36 to 40 MPa

Table 16: Total life cycle (across modules in scope) impact results for Mix designs: 41 to 45MPa, assuming the geometric mean point values on a per 1 m³ of concrete basis

a) Midpoint Impact Categories:

Indicator/LCI Metric	AP	EP	GWP	ODP	PCOP	ADPe	ADPf
Unit	moles of H ⁺ -Eq	kg N	kg CO ₂ -Eq	kg CFC-11-Eq	kg NO _x -Eq	kg Sb-Eq	MJ, net calorific value
Minimum	57.5	0.241	481	4.65e-05	0.798	0.00122	3420



Maximum	73.7	0.267	622	5.92e-05	1.02	0.00158	4370
Mean	65.1	0.253	548	5.24e-05	0.902	0.00139	3870
Median	64.2	0.251	542	5.16e-05	0.888	0.00137	3820
04350NB2018	57.5	0.241	481	4.65e-05	0.798	0.00122	3420
56350NB1065	73.7	0.267	622	5.92e-05	1.02	0.00158	4370
73350NB0514	64.2	0.251	542	5.16e-05	0.888	0.00137	3820

b) Inventory Metrics:

Indicator/LCI Metric	TPE	RE	NRE	NR R	RR	WD P	LFW	LFHW	CBW C	CWW C	CHW	CNH W
Unit	MJ-Eq	MJ-Eq	MJ-Eq	kg	m3	m3	kg waste	kg waste	m3	m3	kg	kg
Minimum	3790	120	3690	91.6	0.00569	0.642	198	0.00613	0.184	1.35e-05	0.0224	87.4
Maximum	4870	158	4700	116	0.00777	0.755	219	0.00745	0.225	1.35e-05	0.0224	87.4
Mean	4300	138	4170	103	0.00663	0.706	207	0.00672	0.205	1.35e-05	0.0224	87.4
Median	4240	136	4110	102	0.00642	0.722	205	0.00659	0.205	1.35e-05	0.0224	87.4
04350NB2018	3790	120	3690	91.6	0.00569	0.642	198	0.00613	0.205	1.35e-05	0.0224	87.4
56350NB1065	4870	158	4700	116	0.00777	0.755	219	0.00745	0.184	1.35e-05	0.0224	87.4
73350NB0514	4240	136	4110	102	0.00642	0.722	205	0.00659	0.225	1.35e-05	0.0224	87.4

Mix designs: 41 to 45 MPa

Table 17: Total life cycle (across modules in scope) impact results for Mix designs: 41 to 45MPa, assuming the geometric mean point values on a per 1 m3 of concrete basis

a) Midpoint Impact Categories:

Indicator/LCI Metric	AP	EP	GWP	ODP	PCOP	ADPe	ADPf
Unit	moles of H+-Eq	kg N	kg CO2-Eq	kg CFC-11-Eq	kg NOx-Eq	kg Sb-Eq	MJ, net calorific value
Minimum	77.7	0.274	660	6.24e-05	1.08	0.00166	4590
Maximum	77.7	0.274	660	6.24e-05	1.08	0.00166	4590
Mean	77.7	0.274	660	6.24e-05	1.08	0.00166	4590
Median	77.7	0.274	660	6.24e-05	1.08	0.00166	4590
3740ND1018	77.7	0.274	660	6.24e-05	1.08	0.00166	4590



b) Inventory Metrics:

Indicator/LCI Metric	TPE	RE	NRE	NR R	RR	WD P	LFW	LFHW	CBW C	CWW C	CHW	CNH W
Unit	MJ-Eq	MJ-Eq	MJ-Eq	kg	m3	m3	kg waste	kg waste	m3	m3	kg	kg
Minimum	5120	170	4940	123	0.00804	0.926	224	0.00775	0.315	1.35e-05	0.0224	87.4
Maximum	5120	170	4940	123	0.00804	0.926	224	0.00775	0.315	1.35e-05	0.0224	87.4
Mean	5120	170	4940	123	0.00804	0.926	224	0.00775	0.315	1.35e-05	0.0224	87.4
Median	5120	170	4940	123	0.00804	0.926	224	0.00775	0.315	1.35e-05	0.0224	87.4
3740ND1018	5120	170	4940	123	0.00804	0.926	224	0.00775	0.315	1.35e-05	0.0224	87.4

Mix designs: 51 to 55 MPa

Table 18: Total life cycle (across modules in scope) impact results for Mix designs: 51 to 55MPa, assuming the geometric mean point values on a per 1 m3 of concrete basis

a) Midpoint Impact Categories:

Indicator/LCI Metric	AP	EP	GWP	ODP	PCOP	ADPe	ADPff
Unit	moles of H+-Eq	kg N	kg CO2-Eq	kg CFC-11-Eq	kg NOx-Eq	kg Sb-Eq	MJ, net calorific value
Minimum	85.2	0.287	720	6.89e-05	1.17	0.00185	5110
Maximum	85.2	0.287	720	6.89e-05	1.17	0.00185	5110
Mean	85.2	0.287	720	6.89e-05	1.17	0.00185	5110
Median	85.2	0.287	720	6.89e-05	1.17	0.00185	5110
3735NB2018	85.2	0.287	720	6.89e-05	1.17	0.00185	5110

b) Inventory Metrics:

Indicator/LCI Metric	TPE	RE	NRE	NR R	RR	WD P	LFW	LFHW	CBW C	CWW C	CHW	CNH W
Unit	MJ-Eq	MJ-Eq	MJ-Eq	kg	m3	m3	kg waste	kg waste	m3	m3	kg	kg
Minimum	5670	183	5490	137	0.00892	0.788	239	0.00858	0.123	1.35e-05	0.0224	87.4
Maximum	5670	183	5490	137	0.00892	0.788	239	0.00858	0.123	1.35e-05	0.0224	87.4
Mean	5670	183	5490	137	0.00892	0.788	239	0.00858	0.123	1.35e-05	0.0224	87.4
Median	5670	183	5490	137	0.00892	0.788	239	0.00858	0.123	1.35e-05	0.0224	87.4



3735NB201	567	183	549	137	0.0089	0.78	239	0.0085	0.123	1.35e-	0.022	87.4
8	0		0		2	8		8		05	4	

ADDITIONAL ENVIRONMENTAL INFO

No regulated substances of very high concern are utilized on site.

REFERENCES

ASTM Standards:

- ASTM A36/A36M Standard Specification for Carbon Structural Steel
- ASTM A108 Standard Specification for Steel Bar, Carbon and Alloy, Cold-Finished
- ASTM A123/A123M Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products
- ASTM A153/A153M Standard Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware
- ASTM A184 Standard Specification for Welded Deformed Steel Bar Mats for Concrete Reinforcement
- ASTM A307 Standard Specification for Carbon Steel Bolts, Studs, and Threaded Rod 60,000 PSI Tensile Strength
- ASTM A416/A416M Standard Specification for Steel Strand, Uncoated Seven-Wire for Prestressed Concrete
- ASTM A555/A555M Standard Specification for General Requirements for Stainless Steel Wire and Wire Rods
- ASTM A615/A615M Standard Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement
- ASTM A666 Standard Specification for Annealed or Cold-Worked Austenitic Stainless Steel Sheet, Strip, Plate, and Flat Bar
- ASTM A706/A706M Standard Specification for Deformed and Plain Low-Alloy Steel Bars for Concrete Reinforcement
- ASTM A767/A767M Standard Specification for Zinc-Coated (Galvanized) Steel Bars for Concrete Reinforcement
- ASTM A775/A775M Standard Specification for Epoxy-Coated Steel Reinforcing Bars
- ASTM A820/A820M Standard Specification for Steel Fibers for Fiber-Reinforced Concrete
- ASTM A884/A884M Standard Specification for Epoxy-Coated Steel Wire and Welded Wire Reinforcement
- ASTM A934/A934M Standard Specification for Epoxy-Coated Prefabricated Steel Reinforcing Bars
- ASTM A1064/A1064M Standard Specification for Carbon-Steel Wire and Welded Wire Reinforcement, Plain and Deformed, for Concrete
- ASTM C33/C33M Standard Specification for Concrete Aggregates
- ASTM C94 Standard Specification for Ready-Mixed Concrete
- ASTM C150/C150M Standard Specification for Portland Cement



- ASTM C260/C260M Standard Specification for Air-Entraining Admixtures for Concrete
- ASTM C595 Standard Specification for Blended Hydraulic Cements
- ASTM C618 Standard Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
- ASTM C979/C979M Standard Specification for Pigments for Integrally Colored Concrete
- ASTM C989/C989M Standard Specification for Slag Cement for Use in Concrete and Mortars
- ASTM C1017/C1017M Standard Specification for Chemical Admixtures for Use in Producing Flowing Concrete
- ASTM C1116/C1116M Standard Specification for Fiber-Reinforced Concrete
- ASTM C1157/C1157M Standard Performance Specification for Hydraulic Cement
- ASTM C1240 Standard Specification for Silica Fume Used in Cementitious Mixtures
- ASTM C1602/C1602M Standard Specification for Mixing Water Used in the Production of Hydraulic Cement Concrete
- ASTM G109 Standard Test Method for Determining Effects of Chemical Admixtures on Corrosion of Embedded Steel Reinforcement in Concrete Exposed to Chloride Environments
- ASTM C330/C330M Standard Specification for Lightweight Aggregates for Structural Concrete
- ASTM C494/C494M Standard Specification for Chemical Admixtures for Concrete

CSA Standards:

- CAN/CGSB-1.40 Anticorrosive Structural Steel Alkyd Primer
- CAN/CSA G30.18 Carbon steel bars for concrete reinforcement
- CAN/CSA A3000 Cementitious Materials Compendium
- CAN/CSA G40.20/G40.21 General requirements for rolled or welded structural quality steel / Structural quality steel
- CAN/CSA A23.1/A23.2 Concrete Materials and Methods of Concrete Construction/Test methods and Standard Practices for Concrete
- CAN/CSA A23.4 Precast concrete - Materials and construction
- CSA S806 Design and construction of building structures with fiber-reinforced polymers

ISO Standards:

- ISO 6707-1: 2014 Buildings and Civil Engineering Works - Vocabulary - Part 1: General Terms
- ISO 14021:1999 Environmental Labels and Declarations - Self-declared Environmental Claims (Type II Environmental Labeling)
- ISO 14025:2006 Environmental Labels and Declarations - Type III Environmental Declarations - Principles and Procedures
- ISO 14040:2006 Environmental Management - Life Cycle Assessment - Principles and Framework
- ISO 14044:2006 Environmental Management - Life Cycle Assessment - Requirements and Guidelines



- ISO 14067:2018 Greenhouse Gases - Carbon Footprint of Products - Requirements and Guidelines for Quantification
- ISO 14050:2009 Environmental Management - Vocabulary
- ISO 21930:2017 Sustainability in Building Construction - Environmental Declaration of Building Products

EN Standards:

- EN 16757 Sustainability of construction works - Environmental product declarations - Product Category Rules for concrete and concrete elements
- EN 15804 Sustainability of construction works - Environmental product declarations - Core rules for the product category of construction products

Other References:

- US EPA Waste Reduction Model (WARM), Fly Ash
Chapter: <http://epa.gov/climatechange/wycd/waste/downloads/fly-ash-chapter10-28-10.pdf>
- American Concrete Institute (ACI) 211: Standard Practice for Selecting Proportions for Normal, Heavyweight, and Mass Concrete.
- ACI 318-14 Building Code Requirements for Structural Concrete and Commentary. American Concrete Institute. Farmington Hills, MI, USA available at <https://www.concrete.org/store/>
- Mather, B & Ozyildirim, C. (2002). SP-1(02) : Concrete Primer. American Concrete Institute: SP0102. American Concrete Institute. Farmington Hills, MI, USA available at <https://www.concrete.org/store/>
- NSF International (February 2019). Product Category Rules (PCR) for ISO 14025 Type III Environmental Product Declarations (EPDs) of Concrete v1.2.
- Product Category Rules for Preparing an Environmental Product Declaration for Precast Concrete (UN CPC 37550), ASTM International, March 2015. https://www.astm.org/CERTIFICATION/DOCS/266.PCR_for_Precast_Concrete.pdf
- USGBC LEED v4 for Building Design and Construction, 11 Jan 2019 available at <https://www.usgbc.org/resources/pcr-committee-process-resources-part-b>
- USGBC PCR Committee Process & Resources: Part B, USGBC, 7 July 2017 available at <https://www.usgbc.org/resources/pcr-committee-process-resources-part-b>.

