

### Statement of Verification

BREG EN EPD No: 000130

ECO EPD Ref. No. 000424 This is to verify that the

**Environmental Product Declaration** 

provided by:

Ekinciler Iron and Steel Works Inc. (member of UK

is in accordance with the requirements of:

EN 15804:2012+A1:2013

and

**BRE Global Scheme Document SD207** 

This declaration is for:

Carbon Steel Reinforcing Bar (Secondary production route scrap)

Organize Sanayi Bolgesi PK240 SAriseki 31200 Iskenderum Htav Turkey







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BRE Global Ltd., Garston, Watford WD25 9XX.

T: +44 (0)333 321 8811 F: +44 (0)1923 664603 E: Enquiries@breglobal.com





# **Environmental Product Declaration**

**EPD Number:** 000130

### **General Information**

EPD Programme Operator	Applicable Product Category Rules
BRE Global Watford, Herts WD25 9XX United Kingdom	BRE Environmental Profiles 2013 Product Category Rules for Type III environmental product declaration of construction products to EN 15804:2012+A1:2013
Commissioner of LCA study	LCA consultant/Tool
UK CARES Pembroke House 21 Pembroke Road Sevenoaks Kent, TN13 1XR UK	UK CARES EPD Tool thinkstep UK Ltd Euston Tower - Level 33, 286 Euston Road London, NW1 3DP www.thinkstep.com
Declared/Functional Unit	Applicability/Coverage
1 tonne of carbon steel reinforcing bars manufactured by the secondary (scrap-based) production route as used within concrete structures for a commercial building.	Manufacturer-specific product
EPD Type	Background database
Cradle to Gate with options	GaBi
Demonstra	ation of Verification
CEN standard EN 1	5804 serves as the core PCR <sup>a</sup>
Independent verification of the declare □Internal	ation and data according to EN ISO 14025:2010 ⊠ External
(Where approp	riate <sup>b</sup> ) Third party verifier:

### a: Product category rules

b: Optional for business-to-business communication; mandatory for business-to-consumer communication (see EN ISO 14025:2010, 9.4)

### **Comparability**

Click here to enter text.

Environmental product declarations from different programmes may not be comparable if not compliant with EN 15804:2012+A1:2013. Comparability is further dependent on the specific product category rules, system boundaries and allocations, and background data sources. See Clause 5.3 of EN 15804:2012+A1:2013 for further guidance



#### Information modules covered

Product			Const	ruction	Use stage  Related to the building fabric Related to the building			End-of-life				Benefits and loads beyond the system boundary				
A1	A2	А3	A4	A5	B1	B2	В3	B4	B5	В6	В7	C1	C2	C3	C4	D
Raw materials supply	Transport	Manufacturing	Transport to site	Construction – Installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction demolition	Transport	Waste processing	Disposal	Reuse, Recovery and/or Recycling potential
V	V	V	$\square$	$\square$	$\square$	$\square$	V	V	$\square$	$\square$	$\overline{\square}$	$\overline{\Delta}$	V	$\square$	$\square$	$\square$

Note: Ticks indicate the Information Modules declared.

### **Manufacturing site(s)**

Ekinciler Demir ve Celik San. A.S. (member of UK CARES)

### **Construction Product:**

### **Product Description**

Reinforcing steel bar (according to product standards listed in Sources of Additional Information) that is obtained from scrap, melted in an Electric Arc Furnace (EAF) followed by hot rolling.

The declared unit is 1 tonne of carbon steel reinforcing bars as used within concrete structures for a commercial building.



#### **Technical Information**

Property	Value, Unit
Production route	EAF
Density	7850 kg/m <sup>3</sup>
Modulus of elasticity	200000 N/mm <sup>2</sup>
Weldability (Ceq)	max 0.50 %
Yield strength (as per BS 4449:2005)	min 500 N/mm²
Tensile strength (as per BS 4449:2005)	min 540 N/mm <sup>2</sup> (Tensile strength/Yield Strength ≥ 1.08)
Surface geometry (Relative rib area, f <sub>R</sub> as per BS 4449:2005)	min 0.040 for Bar Size >6mm & ≤12mm min 0.056 for Bar Size>12
Agt (% total elongation at maximum force as per BS 4449:2005)	min 5 %
Re-bend test (as per BS 4449:2005)	Pass
Fatigue test (as per BS 4449:2005)	Pass
Recycled content (as per ISO 14021:2016)	98.0 %

### **Main Product Contents**

Material/Chemical Input	%
Fe	97
C, Mn, Si, V, Ni, Cu, Cr, Mo and others	3

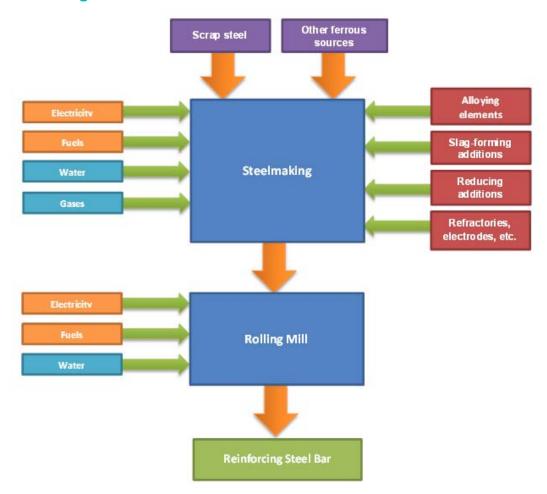
## **Manufacturing Process**

Scrap metal is melted in an electric arc furnace to obtain liquid steel. This is then refined to remove impurities and alloying additions can be added to give the required properties.

Hot metal (molten steel) from the EAF is then cast into steel billets before being sent to the rolling mill where they are rolled and shaped to the required dimensions for the finished bars and coils of reinforcing steel.



### **Process flow diagram**



### **Construction Installation**

Processing and proper use of reinforcing steel products depends on the application and should be made in accordance with generally accepted practices, standards and manufacturing recommendations.

During transport and storage of reinforcing steel products the usual requirements for securing loads is to be observed.

#### **Use Information**

The composition of the reinforcing steel products does not change during use.

Reinforcing steel products do not cause adverse health effects under normal conditions of use.

No risks to the environment and living organisms are known to result from the mechanical destruction of the reinforcing steel bar product itself.

### **End of Life**

Reinforcing steel products are not reused at end of life but can be recycled to the same (or higher/lower) quality of steel depending upon the metallurgy and processing of the recycling route.

It is a high value resource, so efforts are made to recycle steel scrap rather than disposing of it at EoL. A recycling rate of 92% is typical for reinforcing steel bar products.



### **Life Cycle Assessment Calculation Rules**

### **Declared unit description**

The declared unit in Life Cycle Assessment Calculation Rules section 1 tonne of carbon steel reinforcing bars manufactured by the secondary (scrap-based) production route as used within concrete structures for a commercial building (i.e. 1 tonne in use, accounting for losses during fabrication and installation, not 1 tonne as produced).

### System boundary

The system boundary of the EPD follows the modular design defined by EN 15804. This is a cradle to gate – with all options EPD and thus covers all modules from A1 to C4 and includes module D as well.

Impacts and aspects related to losses/wastage (i.e. production, transport and waste processing and end-of-life stage of lost waste products and materials) are considered in the modules in which the losses/wastage occur.

Once steel scrap has been collected for recycling it is considered to have reached the end of waste state.

### Data sources, quality and allocation

Data Sources: Manufacturing data of the period 01/01/2018-31/12/2018 has been provided by Ekinciler Demir ve Celik San. A.S. (member of UK CARES).

Data Quality: Data quality can be described as good. Background data are consistently sourced from thinkstep databases. The primary data collection was thorough, considering all relevant flows and these data have been verified by UK CARES.

Allocation: EAF slag and mill scale are produced as co-products from the steel manufacturing process. Impacts are allocated between the steel, the slag and the mill scale based on economic value.

Production losses of steel during the production process are recycled in a closed loop offsetting the requirement for external scrap. Specific information on allocation within the background data is given in the GaBi datasets documentation (/GaBi 8 2019/).

#### **Cut-off criteria**

On the input side all flows entering the system and comprising more than 1% in total mass or contributing more than 1% to primary energy consumption are considered. All inputs used as well as all process-specific waste and process emissions were assessed. For this reason, material streams which were below 1% (by mass) were captured as well. In this manner the cut-off criteria according to the BRE guidelines are fulfilled.



### **LCA Results**

(MND = module not declared; MNR = module not relevant; INA = indicator not assessed; AGG = aggregated)

Parameters describing environmental impacts										
			GWP	ODP	AP	EP	POCP	ADPE	ADPF	
			kg CO <sub>2</sub> equiv.	kg CFC 11 equiv.	kg SO₂ equiv.	kg (PO <sub>4</sub> ) <sup>3-</sup> equiv.	kg C₂H₄ equiv.	kg Sb equiv.	MJ, net calorific value.	
	Raw material supply	A1	AGG	AGG	AGG	AGG	AGG	AGG	AGG	
Product stage	Transport	A2	AGG	AGG	AGG	AGG	AGG	AGG	AGG	
1 Toddet Stage	Manufacturing	A3	AGG	AGG	AGG	AGG	AGG	AGG	AGG	
	Total (of product stage)	A1-3	824	1.01E-06	4.61	0.479	0.268	7.93E-05	9.69E+03	
Construction	Transport	A4	16.4	2.71E-15	3.59E-02	8.93E-03	-1.15E-02	1.26E-06	222	
process stage	Construction	A5	94	1.01E-07	0.48	5.27E-02	2.25E-02	9.30E-06	1.13E+03	
	Use	B1	0	0	0	0	0	0	0	
	Maintenance	B2	0	0	0	0	0	0	0	
	Repair	В3	0	0	0	0	0	0	0	
Use stage	Replacement	B4	0	0	0	0	0	0	0	
	Refurbishment	B5	0	0	0	0	0	0	0	
	Operational energy use	B6	0	0	0	0	0	0	0	
	Operational water use	B7	0	0	0	0	0	0	0	
	Deconstruction, demolition	C1	2.05	2.89E-16	2.97E-03	4.22E-04	3.27E-04	5.71E-08	28.3	
End of life	Transport	C2	39.6	6.44E-15	0.127	3.19E-02	-3.33E-02	2.94E-06	536	
Life of file	Waste processing	C3	0	0	0	0	0	0	0	
	Disposal	C4	1.19	6.92E-15	7.14E-03	8.09E-04	5.57E-04	4.38E-07	16.7	
Potential benefits and loads beyond the system boundaries	Reuse, recovery, recycling potential	D	565	-3.54E-12	1.33	0.117	0.172	-3.49E-05	4.49E+03	

GWP = Global Warming Potential; ODP = Ozone Depletion Potential; AP = Acidification Potential for Soil and Water; EP = Eutrophication Potential;

POCP = Formation potential of tropospheric Ozone; ADPE = Abiotic Depletion Potential – Elements; ADPF = Abiotic Depletion Potential – Fossil Fuels;



Parameters	describing r	esoui	rce use, pri	imary ener	gy			
			PERE	PERM	PERT	PENRE	PENRM	PENRT
			MJ	MJ	MJ	MJ	MJ	MJ
	Raw material supply	A1	AGG	AGG	AGG	AGG	AGG	AGG
Product stage	Transport	A2	AGG	AGG	AGG	AGG	AGG	AGG
Product stage	Manufacturing	А3	AGG	AGG	AGG	AGG	AGG	AGG
	Total (of product stage)	A1-3	1.22E+03	0	1.22E+03	9.78E+03	0	9.78E+03
Construction	Transport	A4	12.9	0	12.9	223	0	223
process stage	Construction	A5	160	0	160	1.14E+03	0	1.14E+03
	Use	B1	0	0	0	0	0	0
	Maintenance	B2	0	0	0	0	0	0
	Repair	В3	0	0	0	0	0	0
Use stage	Replacement	B4	0	0	0	0	0	0
	Refurbishment	B5	0	0	0	0	0	0
	Operational energy use	B6	0	0	0	0	0	0
	Operational water use	В7	0	0	0	0	0	0
	Deconstruction, demolition	C1	8.73E-02	0	8.73E-02	28.4	0	28.4
Find of life	Transport	C2	29.6	0	29.6	537	0	537
End of life	Waste processing	СЗ	0	0	0	0	0	0
	Disposal	C4	2.18	0	2.18	17.2	0	17.2
Potential benefits and loads beyond the system boundaries	Reuse, recovery, recycling potential	D	-4.69E+02	0	-4.69E+02	4.26E+03	0	4.26E+03

PERE = Use of renewable primary energy excluding renewable primary energy used as raw materials;
PERM = Use of renewable primary energy resources used as raw

materials;

PERT = Total use of renewable primary energy resources;

PENRE = Use of non-renewable primary energy excluding nonrenewable primary energy resources used as raw materials; PENRM = Use of non-renewable primary energy resources used as raw materials;

PENRT = Total use of non-renewable primary energy resource



Parameters of	describing res	ource	use, secondary n	naterials and fuels	s, use of water	
			SM	RSF	NRSF	FW
			kg	MJ net calorific value	MJ net calorific value	m³
	Raw material supply	A1	AGG	AGG	AGG	AGG
Decide at at a se	Transport	A2	AGG	AGG	AGG	AGG
Product stage	Manufacturing	А3	AGG	AGG	AGG	AGG
	Total (of product stage)	A1-3	1.21E+03	8.81E-03	5.69E-02	3.03
Construction	Transport	A4	0	0	0	2.19E-02
nrocess stane	Construction	A5	121	8.81E-04	5.69E-03	0.347
	Use	B1	0	0	0	0
	Maintenance	B2	0	0	0	0
	Repair	В3	0	0	0	0
Use stage	Replacement	B4	0	0	0	0
	Refurbishment	B5	0	0	0	0
	Operational energy use	В6	0	0	0	0
	Operational water use	В7	0	0	0	0
	Deconstruction, demolition	C1	0	0	0	2.02E-04
Ford of life	Transport	C2	0	0	0	0.05
End of life	Waste processing	C3	0	0	0	0
	Disposal	C4	0	0	0	4.34E-03
Potential benefits and loads beyond the system boundaries	Reuse, recovery, recycling potential	D	0	0	0	0.443

SM = Use of secondary material; RSF = Use of renewable secondary fuels;

NRSF = Use of non-renewable secondary fuels; FW = Net use of fresh water



Other environmental information describing waste categories									
			HWD	NHWD	RWD				
			kg	kg	kg				
	Raw material supply	A1	AGG	AGG	AGG				
Droduct stage	Transport	A2	AGG	AGG	AGG				
Product stage	Manufacturing	A3	AGG	AGG	AGG				
	Total (of product stage)	A1-3	4.36E-02	248	3.32E-02				
Construction	Transport	A4	1.25E-05	1.81E-02	3.03E-04				
process stage	Construction	A5	4.36E-03	34.6	4.12E-03				
	Use	B1	0	0	0				
	Maintenance	B2	0	0	0				
	Repair	В3	0	0	0				
Use stage	Replacement	B4	0	0	0				
	Refurbishment	B5	0	0	0				
	Operational energy use	В6	0	0	0				
	Operational water use	В7	0	0	0				
	Deconstructio n, demolition	C1	3.40E-09	3.45E-03	3.34E-05				
End of the	Transport	C2	2.84E-05	4.15E-02	7.23E-04				
End of life	Waste processing	СЗ	0	0	0				
	Disposal	C4	2.94E-07	80.1	2.31E-04				
Potential benefits and loads beyond the system boundaries	Reuse, recovery, recycling potential	D	2.83E-06	8.89	-9.10E-02				

HWD = Hazardous waste disposed; NHWD = Non-hazardous waste disposed; RWD = Radioactive waste disposed



Other enviro	nmental inforr	nation	describing outpu	ut flows – at end o	of life	
			CRU	MFR	MER	EE
			kg	kg	kg	MJ per energy carrier
	Raw material supply	A1	AGG	AGG	AGG	AGG
Product stage	Transport	A2	AGG	AGG	AGG	AGG
Product stage	Manufacturing	A3	AGG	AGG	AGG	AGG
	Total (of product stage)	A1-3	0	0	0	0
Construction	Transport	A4	0	0	0	0
process stage	Construction	A5	0	120	0	0
	Use	B1	0	0	0	0
	Maintenance	B2	0	0	0	0
	Repair	В3	0	0	0	0
Use stage	Replacement	B4	0	0	0	0
	Refurbishment	B5	0	0	0	0
	Operational energy use	В6	0	0	0	0
	Operational water use	В7	0	0	0	0
	Deconstruction, demolition	C1	0	0	0	0
F-4-4 115-	Transport	C2	0	0	0	0
End of life	Waste processing	СЗ	0	920	0	0
	Disposal	C4	0	0	0	0
Potential benefits and loads beyond the system boundaries	Reuse, recovery, recycling potential	D	0	0	0	0

CRU = Components for reuse; MFR = Materials for recycling MER = Materials for energy recovery; EE = Exported Energy



### Scenarios and additional technical information

Scenario	Parameter	Units	Results
	Transport to the fabricators and on to the construction site; i and products. Road transport distance for rolled steel to fab for steel construction forms to site are assumed to be 100 k	ricators and road tra	ansport distand
	Truck trailer - Fuel	L/km	1.56
A4 – Transport to the ouilding site	Distance	km	350
	Capacity utilisation (including empty returns)	%	85
	Bulk density of transported products	kg/m³	7850
A5 – Installation in he building	Fabrication into reinforcing steel products and installation in all materials, products and energy, as well as waste process disposal of final residues during the construction stage. Instinto the building is assumed to result in 10% wastage (deter losses reported by the WRAP Net Waste Tool [WRAP 2017 requires 15.34 kWh/tonne finished product, and that there is process.	sing up to the end-callation of the fabric mined based on typ ]). It is assumed tha	of-waste state of cated product pical installation at fabrication
	Ancillary materials for installation - Waste material from fabrication, losses per tonne of construction steel forms	%	2
	Energy Use - Energy per tonne required to fabricate construction steel forms	kWh	15.34
	Waste materials from installation wastage	%	10
B1 - Use	No impacts occur during use.		
32 – Maintenance	No maintenance required		
B3 – Repair	No repair process required		
B4 – Replacement	No replacement considerations required		
B5 – Refurbishment	No refurbishment process required		
Reference service life	Reinforcing steel products are used in the main building struwill equal the lifetime of the building. The Concrete Society of BS EN 1990, which specifies "building structures and other lifetime of 50 years (The Concrete Society, n.d.; BSI, 2005). EPD is assumed to be 50 years.	follows the definition common structures	ns provided in " as having a
	Reference service life	Years	50
B6 – Use of energy; B7 – Use of water	No water or energy required during use stage related to the	operation of the bu	ilding
C1 to C4 End of life,	The end-of-life stage starts when the construction product is deconstructed from the building or construction works and dunction. This stage comprises: de-construction, demolition; waste processing for reuse, recovery and/or recycling; dispose	loes not provide an transport to waste	y further
	Waste for recycling - Recovered steel from crushed concrete	%	92



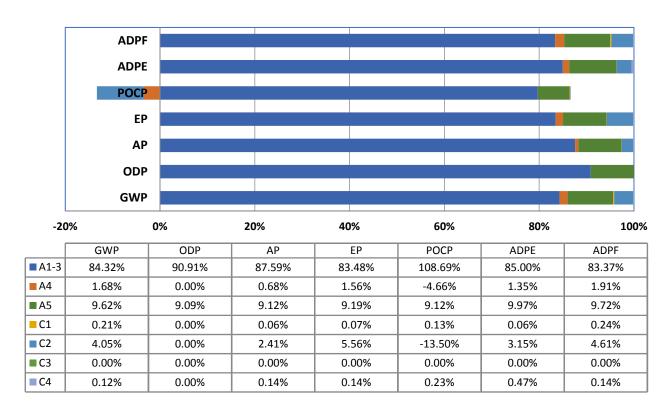
ooonanoo ana	additional technical information		
Scenario	Parameter	Units	Results
	Waste for energy recovery - Energy recovery is not considered for this study as most end of life steel scrap is recycled, while the remainder is landfilled	-	-
	Waste for final disposal - Unrecoverable steel lost in crushed concrete and sent to landfill	%	8
	Portion of energy assigned to rebar from energy required to demolish building, per tonne	MJ	24
	Transport to waste processing by Truck - Fuel consumption	L/km	1.56
	Transport to waste processing by Truck – Distance	km	463
	Transport to waste processing by Truck – Capacity utilisation	%	85
	Transport to waste processing by Truck – Density of Product	kg/m³	7850
	Transport to waste processing by Container ship - Fuel consumption	L/km	0.00401
	Transport to waste processing by Container ship - Distance	km	158
	Transport to waste processing by Container ship – Capacity utilisation	%	50
	Transport to waste processing by Container ship – Density of Product	kg/m³	7850
⁄lodule D	It is assumed that 92% of the steel used in the structure is re remainder is landfilled.  "Benefits and loads beyond the system boundary" (module I benefits and loads resulting from net steel scrap that is used that is collected for recycling at end of life.  The resulting scrap credit/burden is calculated based on the (/worldsteel 2011).	D) accounts for the I as raw material in	e environmental n the EAF and



### Summary, comments and additional information

### Interpretation

Scrap-based carbon steel rebar of Ekinciler Demir ve Celik San. A.S. (member of UK CARES) is made via the EAF route. The bulk of the environmental impacts and primary energy demand is attributed to the manufacturing phase, covered by information modules A1-A3 of EN 15804. For GWP for instance, A1-A3 impacts account for 84.32% overall life cycle impacts for this category.



### References

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London Metal Exchange, Steel Rebar Prices, January 2019. https://www.lme.com/en-gb/metals/ferrous/

REGULATION (EU) No 305/2011 OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 9 March 2011 laying down harmonised conditions for the marketing of construction products and repealing Council Directive 89/106/EEC.

CARES SCS Sustainable Constructional Steel Scheme. Appendix 1 – Operational assessment schedule for the sustainable production of steel billets, steel bars/coils and wire rod for further processing into carbon steel bar, coil or rod for the reinforcement of concrete.

CARES SRC Steel for the Reinforcement of Concrete Scheme. Appendix 1 – Quality and operations assessment schedule for carbon steel bars for the reinforcement of concrete including inspection and testing requirements -  $\frac{\text{http://www.ukcares.com/approved-companies}}{\text{at the time of LCA study}} - 040803$ 

CARES SRC Steel for the Reinforcement of Concrete Scheme. Appendix CP&AS 21 - Quality and operations assessment schedule for Singapore Standard (SS 560:2016) weldable reinforcing steel bars, coils and decoiled products for the reinforcement of concrete including inspection and testing requirements - <a href="http://www.ukcares.com/approved-companies">http://www.ukcares.com/approved-companies</a> - Certificate number of conformance to SS 560:2016 at the time of LCA study – 190407

CARES SRC Steel for the Reinforcement of Concrete Scheme. Appendix CP&AS 24 - Quality and operations assessment schedule for Hong Kong Standard (CS2:2012) Steel Reinforcing Bars for the Reinforcement of Concrete - <a href="http://www.ukcares.com/approved-companies">http://www.ukcares.com/approved-companies</a> - Certificate number of conformance to SS 560:2016 at the time of LCA study – 190408

BS 4449:2005+A3:2016 Steel for the reinforcement of concrete. Weldable reinforcing steel. Bar, coil and decoiled product. Specification.

SS 560:2010 - Steel for the reinforcement of concrete – Weldable reinforcing steel – Bar, coil and decoiled product.



CS2:2012 - Steel Reinforcing Bars for the Reinforcement of Concrete.

ASTM A615/A615M – 16 Standard Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement.

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ISO 6935-2:2015 - Steel for the reinforcement of concrete - Part 2: Ribbed bars.

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DIN 488-2:2009 - Reinforcing steels - Reinforcing steel bars.

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CAN/CSA G30.18-09:2009 Carbon steel bars for concrete reinforcement.

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NEN 6008:2008 nl - Steel for the reinforcement of concrete.

NS 3576-3:2012 - Steel for the reinforcement of concrete - Dimensions and properties - Part 3: Ribbed steel B500NC.

TS 708:2016 - Steel for the reinforcement of concrete - Reinforcing steel.

BDS 9252:2007 - Steel for the reinforcement of concrete - Weldable reinforcing steel B500.

AS/NZS 4671:2001 - Steel reinforcing materials.

MS 146:2006 - Hot rolled steel bars for the reinforcement of concrete - Specification.

NBR 7480:2007 - Steel for The Reinforcement of Concrete Structures - Specification.

SI 4466-3:2013 - Steel for the reinforcement of concrete: Ribbed Bars.

GOST R 52544:2006 - Weldable deformed reinforcing rolled products of A500C and B500C classes for reinforcement of concrete constructions. Specifications.

IQS 2091-1999 Standard Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement.

STAS 438-1 1999 - Steel products for concrete reinforcement. Hot rolled structural steel. Grades and quality technical requirements.



SS-ENV-10080 - Steel for the reinforcement of concrete - Weldable ribbed reinforcing steel B500 - Technical delivery conditions for bars, coils and welded fabric.