

# Environmental Product Declaration



**Environmental Product Declaration for cement products  
produced by Holcim Argentina at their Puesto Viejo facility in  
Puesto Viejo, Argentina**

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## ADMINISTRATIVE INFORMATION

### International Certified Environmental Product Declaration

<b>Declared Product:</b>	This Environmental Product Declaration (EPD) covers cement products produced by Holcim Argentina Declared unit: 1 tonne of cement
<b>Declaration Owner:</b>	Holcim Argentina 680 Humberto Primo, Complejo Capitalinas, Edificio Suquia, Piso 4, Oficina 47 Córdoba, Argentina holcim.com.ar
<b>Program Operator:</b>	Labeling Sustainability Address, 11670 W Sunset Blvd. City, State, Los Angeles, CA <a href="http://labelinsustainability.com/">http://labelinsustainability.com/</a>
<b>Product Category Rule:</b>	Core PCR: ISO 21930:2017 Sustainability in buildings and civil engineering works – Core rules for environmental product declarations of construction products and services SubPCR: Product Category Rules (PCR) for ISO 14025 Type III Environmental Product Declarations (EPD) of Portland, Blended, Mansory, Mortar and Plastic (stucco) Cements, Valid through March 31, 2025. 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, <a href="mailto:t.gloria@industrial-ecology.com">t.gloria@industrial-ecology.com</a> . Mr. Bill Stough, Sustainable Research Group: PO Box 1684, Grand Rapids, MI 49501-1684, <a href="mailto:bstough@sustainableresearchgroup.com">bstough@sustainableresearchgroup.com</a> . Mr. Jack Geilbig, EcoForm: 2624 Abelia War, Suite 611, Knoxville, TN 37931, <a href="mailto:jgeilbig@ecoform.com">jgeilbig@ecoform.com</a>
<b>Independent LCA Reviewer and EPD Verifier:</b>	This EPD was independently verified in accordance with ISO 14025. 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 CSA group ( <a href="http://www.csaregistries.ca">www.csaregistries.ca</a> ), Labeling Sustainability ( <a href="http://www.labelingsustainability.com">www.labelingsustainability.com</a> ), P3Optima ( <a href="http://www.P3Optima.com">www.P3Optima.com</a> )
<b>Date of Issue:</b>	20 January 2023
<b>Period of Validity:</b>	5 years; valid until 20 January 2028
<b>EPD Number:</b>	doc13d31-83f9-4490-8b4b-6a36c139e8e0



## COMPANY DESCRIPTION

Holcim Argentina belongs to the Holcim Group and is a world leader in innovative and sustainable solutions for construction. With more than 90 years of experience in Argentina, it employs more than 1,000 collaborators and has extensive coverage of the national territory. It has four cement plants located in the provinces of Córdoba, Mendoza, Jujuy and Buenos Aires. Likewise, it has permanent and mobile plants of elaborated concrete; a plant of stone aggregates; and another for industrial waste co-processing, called Geocycle.

At Holcim, we work for the cities of the future. The world population is estimated to reach 10 billion by 2050, with 70% of people living in cities by then. With 1.6 billion people lacking adequate housing and sanitation, we need to build livable cities that work for everyone. At Holcim, we are part of the solution.

United in our vision to be the global leader in innovative and sustainable building solutions, we play an essential role in accelerating our world's transition to a more inclusive, net-zero emissions future. Driven by our purpose to create progress for people and the planet, we are at the forefront of sustainable building solutions.

## 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 Cement published by NSF (2020) and is a PCR in accordance with ISO 21930 for Preparing an Environmental Product Declaration for Portland, Blended Hydraulic, Masonry, Mortar, and Plastic (Stucco) Cements. EPDs for cements that follow other PCRs may not be comparable.; 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 Argentina 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 Argentina 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 Argentina's license to operate in the community. The intended audience for this LCA report is Holcim Argentina'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 is prepared for products classified as UN CPC Group 3744-Cement or CSI MasterFormat Division 03 30 00 Cast-in-Place Concrete

This EPD is primary reported Holcim data from the reference year 2021. It reports on the five cement mixes produced at the Puesto Viejo cement plant, made from primarily limestone. These five cement mixes make up 100% of yearly production at the Puesto Viejo cement plant. Cement from the Puesto Viejo cement plant is used in the EPDs for concrete mixes in Argentina concrete plants.

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.

## CEMENT DESIGN SUMMARY

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

Table 1: Declared products with All declared products considered in this environmental product declaration

Mix#	Unique name/ID	Short description	Product Type	Resistance @28 Days (MPa)
1	Albañilería	Masonry Cement	Ordinary Portland	5.5
2	CPF40	Filler Portland Cement allow to obtain high initial resistances and greater cohesion in mixtures, improving their performance in concretes to pavements.	Ordinary Portland	40
3	CPP40	Versatile cement specially formulated for concrete mixers.	Portland Pozzolana	30
4	CPC30	Composite Portland Cement Class 30	Ordinary Portland	40
5	Exported Clinker	Clinker for Export	Clinker	-

## CEMENT DESIGN COMPOSITION

The following figures provide mass breakdown (kg per functional unit) of the material composition of each cement 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 2 Cement composition

Product Components	Raw Material, weight%
Clinker	Proprietary
Mineral Additions (limestone and Pozzolana)	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 (ND= Not Defined)

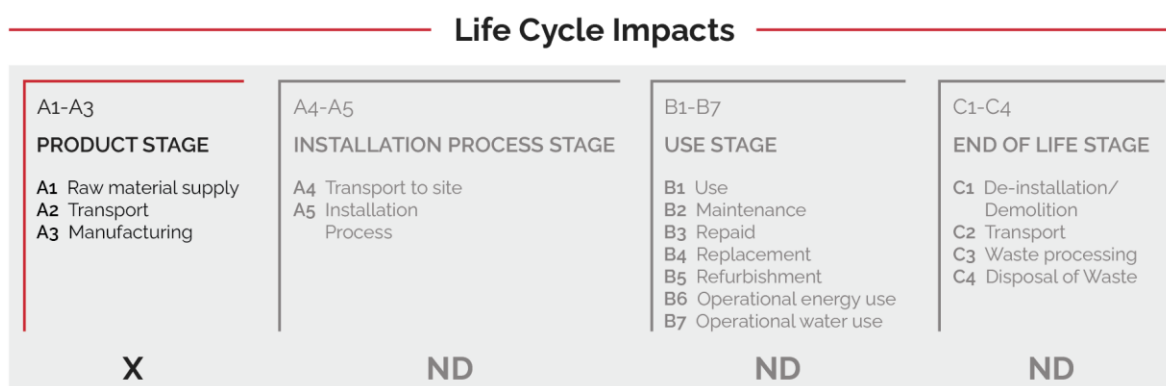


Figure 1: General life cycle phases for consideration in a construction works system

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 cement products and is not necessarily exhaustive.



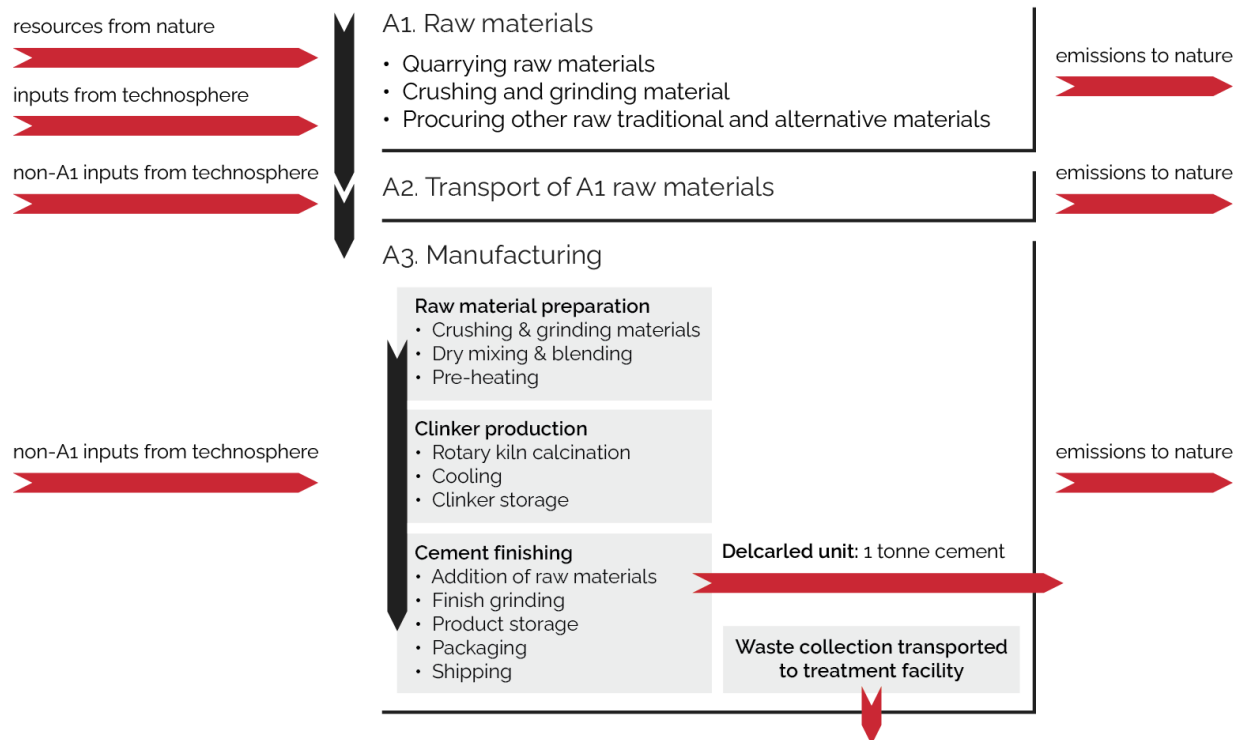


Figure 2: **General system inputs considered in the product system and categorized by modules in scope**

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, earthmoving 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 Argentina, is located at their Planta Puesto Viejo facility in Argentina. All operating data is formulated using the actual data from Holcim Argentina 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 Argentina 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 Argentina in calendar year 2021. These values were direct reported from Holcim Argentina records. The unit process "market for electricity, medium voltage/electricity, medium voltage/AR/kWh" was used to represent the Argentina grid electricity used by the Puesto Viejo cement plant.

**Process/space heating:** No fuel was used for space heating at this facility in 2021.

**Fuel required for machinery:** Machinery-related fuel requirements were determined from direct Holcim information for gasoline. Limestone is moved using an electric conveyor which is included in the total electricity. Gasoline is for utility vehicles for moving other 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.

**Recovered energy:** Not Applicable.

**Recycled/reused material/components:** Not applicable.

**Module A1 material losses:** Due to lack of data, default loss factors were assumed.

**Direct A3 emissions accounting:** All emission data are based on primary fuel reporting from Holcim Argentina. The direct emissions calculations for the kiln are from the ecoinvent unit process "clinker production | clinker | Cutoff, U - RoW" and are calculated with direct Holcim Argentina primary information for CO<sub>2</sub> decarbonization of the limestone at the kiln. The decarbonization number is verified by a third-party and also has been evaluated using peer-reviewed industry data.

**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 hazardous waste disposal sites are near the plant therefore the 25 km distance is a representative estimate.

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 3: LCI inputs assumed for module A1 (i.e. raw material supply)

Input	LCI.activity	Data.source	Geo	Year	Technology	Time	Geography	Reliability	Completeness
<b>Additives</b>	market for chemical, inorganic/chemical, inorganic/GLO/kg	ecoinvent v3.8	Argentina	v3.8 in 2021	2	3	1	3	3
<b>Natural gas (to make Clinker Batch Type I)</b>	market for natural gas, high pressure/natural gas, high pressure/RoW/m3	ecoinvent v3.8	Neuquen	v3.8 in 2021	2	3	1	3	3
<b>Iron ore (to make Clinker Batch Type I)</b>	iron ore mine operation, 63% Fe/iron ore, crude ore, 63% Fe/IN/kg	ecoinvent v3.8	Jujuy	v3.8 in 2021	2	3	1	3	3
<b>Limestone (to make Clinker Batch Type I)</b>	limestone production, crushed, for mill/limestone, crushed, for mill/RoW/kg; Note: modifications made (see ecoinvent activity changes table)	ecoinvent v3.8	Jujuy	v3.8 in 2021	2	3	1	3	3
<b>Clay</b>	clay pit operation/clay/RoW/kg	ecoinvent v3.8	Jujuy	v3.8 in 2021	2	3	1	3	3
<b>Gypsum</b>	gypsum quarry operation/gypsum, mineral/RoW/kg	ecoinvent v3.8	Salta	v3.8 in 2021	2	3	1	3	3
<b>Pozzolana</b>	calcareous marl production/calcareous marl/RoW/kg	ecoinvent v3.8	Salta	v3.8 in 2021	2	3	1	3	3
<b>Solid waste fuel (to make Clinker Batch Type I)</b>	Waste input produced off-site	See A3 inputs	Jujuy	See A3 inputs	2	A3	2	A3	A3

## 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. Most relevant background materials and processes were taken from ecoinvent v3.6 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 Cement materials, emissions to air, water and soil, and waste recycling and treatment. The same background LCI datasets from the ecoinvent v3.6 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 Eco-Purpose's proprietary Cement 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.

Label Sustainability has developed a proprietary tool that allows the calculation of PCR-compliant LCA results for Cement 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 2020-01-01 to 2020-12-31.
- Upstream (background) LCI data was either the PCR specified default (if applicable) or more appropriate LCI datasets as found in the country-adjusted ecoinvent v3.6 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.

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 cement facility on a per 1 tonne of cement basis.

Table 4: Total life cycle (across modules in scope) impact results for All declared products, assuming the geometric mean point values on a per 1 tonne of cement basis

### a) Midpoint Impact Categories:

Indicator/LCI Metric	AP	EP	GWP	ODP	PCOP	ADPe	ADPf
Unit	moles of H <sup>+</sup> -Eq	kg N	kg CO <sub>2</sub> -Eq	kg CFC-11-Eq	kg NO <sub>x</sub> -Eq	kg Sb-Eq	MJ, net calorific value
Minimum	34.7	0.0345	277	1.1e-05	0.576	0.000204	1790
Maximum	107	0.106	828	3.41e-05	1.67	0.00578	4600
Mean	82.8	0.0809	617	2.49e-05	1.26	0.00304	3740
Median	96.8	0.0898	639	2.45e-05	1.32	0.00252	4320
Albañilería	34.7	0.0345	277	1.1e-05	0.576	0.00133	1790



CPF40	107	0.106	706	3.41e-05	1.46	0.00539	4600
CPP40	75.4	0.073	634	2.2e-05	1.28	0.00252	3590
CPC30	100	0.101	639	3.31e-05	1.32	0.00578	4320
Exported Clinker	96.8	0.0898	828	2.45e-05	1.67	0.000204	4400

## b) Inventory Metrics:

Indicator/LCI Metric	TPE	RE	NRE	NRR	RR	WDP	LFW	LFHW	bioC
Unit	MJ-Eq	MJ-Eq	MJ-Eq	kg	m3	m3	kg waste	kg waste	kg
Minimum	2070	114	1940	57.4	0.000144	0.346	10.1	0.00186	-0.122
Maximum	5220	211	4980	162	0.00337	1.02	55.9	0.0079	-0.0602
Mean	4230	154	4060	130	0.00145	0.649	33.3	0.00515	-0.0862
Median	4900	119	4650	150	0.000242	0.46	26.4	0.00437	-0.0676
Albañilería	2070	114	1940	57.4	0.000144	0.346	10.1	0.00186	-0.0602
CPF40	5220	211	4980	162	0.00337	1.02	53.7	0.0079	-0.119
CPP40	4020	119	3920	124	0.000242	0.411	26.4	0.00389	-0.0676
CPC30	4900	209	4650	150	0.00332	1.01	55.9	0.00771	-0.122
Exported Clinker	4960	118	4800	156	0.000185	0.46	20.6	0.00437	-0.062

## REFERENCES

### ASTM Standards:

- 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

#### CSA Standards:

- CAN/CSA A3000 Cementitious Materials Compendium
- CAN/CSA G40.20/G40.21 General requirements for rolled or welded structural quality steel / Structural quality steel

#### 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>
- 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>

