ENVIROMENTAL PRODUCT DECLARATION
as per ISO 14025 and EN 15804

<table>
<thead>
<tr>
<th>Owner of the Declaration</th>
<th>European Federation of Concrete Admixtures Associations Ltd. (EFCA)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Programme holder</td>
<td>Institut Bauen und Umwelt e.V. (IBU)</td>
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<td>Declaration number</td>
<td>EPD-EFC-20150090-IAG2-EN</td>
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<tr>
<td>ECO EPD Ref. No.</td>
<td>ECO-00000384</td>
</tr>
<tr>
<td>Issue date</td>
<td>16/09/2015</td>
</tr>
<tr>
<td>Valid to</td>
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</table>

Concrete admixtures – Water Resisting Admixtures
European Federation of Concrete Admixtures Associations Ltd. (EFCA)

www.ibu-epd.com / https://epd-online.com
# General Information

European Federation of Concrete Admixtures Associations Ltd. (EFCA)

**Programme holder**
IBU - Institut Bauen und Umwelt e.V.
Panoramastr. 1
10178 Berlin
Germany

**Declaration number**
EPD-EFC-20150090-IAG2-EN

**This Declaration is based on the Product Category Rules:**
Concrete admixtures, 07.2014
(PCR tested and approved by the SVR)

**Issue date**
16/09/2015

**Valid to**
13/09/2020

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Concrete admixtures – water resisting admixtures

**Owner of the Declaration**
European Federation of Concrete Admixtures Associations Ltd. (EFCA)
Radius House, 51 Clarendon Road, Watford, Herts, WD17 1HP United Kingdom

**Declared product / Declared unit**
1 kg of water resisting admixtures, density: 1 - 1.6 kg/l

**Scope:**
This validated Declaration entitles EFCA to bear the symbol of the Institut Bauen und Umwelt e.V. It exclusively applies for the product groups referred to for plants operated in Belgium, France, Germany, Italy, Netherlands, Norway, Spain, Sweden, Switzerland, Turkey and the United Kingdom by companies that are members of EFCA National Associations in these countries and for a period of five years from the date of issue. It involves a Model EPD where the product displaying the highest environmental impact in a group was selected for calculating the Life Cycle Assessment. Please refer to the EFCA website www.efca.info for a list of National Associations. The application of this EPD is only possible for member companies of EFCA’s member associations and only for specific formulations with a total score below the declared maximum score for a product group according to the associated guidance document. The owner of the declaration shall be liable for the underlying information and evidence; the IBU shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

**Verification**
The CEN Norm /EN 15804/ serves as the core PCR
Independent verification of the declaration according to /ISO 14025/

[ ] internally  [x] externally

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Prof. Dr.-Ing. Horst J. Bossenmayer
(President of Institut Bauen und Umwelt e.V.)

Dr. Burkhard Lehmann
(Managing Director IBU)

Matthias Schulz
(Independent verifier appointed by SVR)

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# Product

## 2.1 Product description
Admixtures are liquid or powdery agents that are introduced in small amounts (< 5% by mass of the cement content) to concrete while it is being mixed and that enhance the properties of the fresh and/or hardened concrete.
Water-resisting admixtures are admixtures which reduce the capillary absorption of hardened concrete. The results of the Life Cycle Assessment provided in this declaration have been selected from the product with the highest environmental impact (worst-case scenario).

## 2.2 Application
Concrete admixtures are used as constituent materials for the production of concrete, mortar and grout (unreinforced concrete, reinforced and prestressed concrete, site-mixed and ready-mixed concrete, precast concrete). Their application should be in line with the manufacturer’s technical documents and Declaration of Performance.

## 2.3 Technical Data
Water resisting admixtures must comply with the general requirements of /EN 934-1:2008/ and the additional requirements of /EN 934-2:2009+A1:2012/, Table 9.
2.4 Application rules
For products placed on the market in the European Economic Area (EEA) the Construction Product Regulation (Regulation (EU) No 305/2011) applies /CPR/. Outside of the EEA, the corresponding national regulation applies. Admixture products placed on the market under the CPR require a Declaration of Performance and CE marking taking consideration of /EN 934-2:2009+A1:2012/. For the application and use of the products the respective national provisions apply.

2.5 Delivery status
Water-resisting admixtures are usually supplied in liquid, paste or powder form in containers made of steel or plastic. Typical container sizes are canisters containing approx. 25 kg, drums with approx. 200 kg or Intermediate Bulk Containers (IBC) with 1000 kg. The containers are shipped on wooden pallets. For larger applications, loose deliveries in tank trucks with a capacity in excess of 1 tonne are also used.

2.6 Base materials / Ancillary materials
Primarily salts of higher fatty acids serve as raw materials for water-resisting admixtures, supplied as aqueous dispersions. Dispensers of higher fatty acids as well as emulsions containing silanes or siloxanes as active agents are also used. Dispensers of calcium stearate in water are the most common water-resisting admixtures. Deforming agents, emulsifying agents and preservatives are added as minor components and auxiliaries for water-resisting admixtures. The active agent concentration of the calcium stearate most frequently used lies between 20 and 50 percentage by mass. The typical dosage of water-resisting admixtures lies between 0.5 and 1.0 percentage by mass in relation to the cement weight. The products covered by this EPD typically contain the following proportions by mass of constituent materials and auxiliaries referred to:

- Silanes/Siloxanes*: max. 50%
- Calcium stearate*: max. 40%
- Salts of higher fatty acids*: max. 20%
- Additives: max. 0.2%
- Water: approx. 50-85%

*Solid content
These volumes are average values and the composition of products complying with the EPD can deviate from these concentration levels in individual cases.

Note: For companies to declare their products within the scope of this EPD it is not sufficient to simply comply with the product composition shown above. The application of this EPD is only possible for member companies of EFCA’s member associations and only for specific formulations with a total score below the declared maximum score for a product group according to the associated guidance document. Small volumes (< 0.5% by mass) of biocides with functional chemical groups for example isothiazolinones or dioxahexane are used as preservatives in concrete admixtures during storage. More detailed information is available in the respective manufacturer’s documentation (e.g. product data sheets, safety data sheets).

Unless indicated on the safety data sheet, concrete admixtures do not contain any substances in concentrations of more than 0.1% which are included in the list of Substances of Very High Concern (SVHC) for inclusion in Annex XIV of the REACH regulation. No flame retardants are used in concrete admixtures.

2.7 Manufacture
Concrete admixtures are usually manufactured by mixing ingredients together in batch mode and filling containers for dispatch. The process follows quality standards outlined in /EN 934-6:2001+A1:2005/.

2.8 Environment and health during manufacturing
As a general rule, no environmental or health
protection measures other than those specified by law are necessary.

2.9 Product processing/Installation
During concrete manufacture, concrete admixtures are usually added along with the mixing water or included in premixed concrete.

Health and safety measures (eye protection, hand protection, possibly respiratory equipment and body protection) are to be taken and consistently adhered to in accordance with the information on the safety data sheet and conditions on site.

2.10 Packaging
Reusable containers are, where practicable taken back by the manufacturer and redirected into the production circuit. Empty plastic or steel containers which can no longer be used are recyclable.

Wooden reusable pallets are, where practicable taken back by the manufacturer or building material trader who returns them to the building product manufacturer redirecting them into the production process.

2.11 Condition of use
During the use phase, concrete admixtures are firmly bound into the cement matrix in hardened concrete. Concrete admixtures make an essential contribution towards optimising the physical and chemical properties of concrete enhancing its performance, durability, economic value and sustainability.

2.12 Environment and health during use
During the use phase, concrete admixtures are firmly bound into the cement matrix in hardened concrete. No relevant risks are known for water, air and soil if the products are used as designated.

2.13 Reference service life
Not relevant as this declaration relates to a preliminary product.

2.14 Extraordinary effects
Fire
Not relevant as this declaration relates to a preliminary product.

Water
Not relevant as this declaration relates to a preliminary product.

Mechanical destruction
Not relevant as this declaration relates to a preliminary product.

2.15 Re-use phase
Not relevant as this declaration relates to a preliminary product.

2.16 Disposal
Empty, dried containers are directed to the recycling process where practicable. Residue must be directed to proper waste disposal taking consideration of local guidelines.

2.17 Further information
More information is available in the manufacturers’ product or safety data sheets on the manufacturers’ Web sites or on request.

An electronic version of this declaration is available at www.efca.info and www.bau-umwelt.com

3. LCA: Calculation rules

3.1 Declared Unit
This EPD refers to the declared unit of 1 kg concrete admixture with a density of 1-1.6 kg/l in accordance with the /PCR Part B/ for concrete admixtures. The results of the Life Cycle Assessment provided in this declaration have been selected from the product with the highest environmental impact (worst-case scenario). Depending on the application, a corresponding conversion factor such as the density to convert volumetric use to mass must be taken into consideration.

3.2 System boundary
Modules A1, A2 and A3 are taken into consideration in the LCA:
- A1 Production of preliminary products
- A2 Transport to the plant
- A3 Production incl. provision of energy, production of packaging as well as auxiliaries and consumables and waste treatment

The Declaration is therefore “cradle-to-gate”.

3.3 Estimates and assumptions
For this EPD formulation and production data defined by EFCA were considered. Production waste was assumed to be disposed of to landfill without credits as a worst case.

An average of plastic containers and wooden pallets was considered in the LCA.

3.4 Cut-off criteria
All raw materials submitted for the formulations and production data were taken into consideration. The manufacture of machinery, plant and other infrastructure required for production of the products under review was not taken into consideration in the LCA. Transport of packaging materials is also excluded.

3.5 Background data
Data from the /GaBi 6/ data base was used as background data.

3.6 Data quality
Representative products were applied for this EPD and the product in the group displaying the highest environmental impact was selected for calculating the LCA results. The data sets are no more than 4 years old.

Production data and packaging are based on details provided by the manufacturer. The formulation used for evaluation refers to a specific product. The data quality of the background data is considered to be sufficient.
3.7 **Period under review**
Representative formulations were compiled by EFCA in 2011.

3.8 **Allocation**
No allocations were applied for production.

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

4. **LCA: Scenarios and additional technical information**

In accordance with the /PCR Part B/, no scenarios are indicated as only Modules A1-A3 are declared.
### 5. LCA: Results

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

<table>
<thead>
<tr>
<th>PRODUCT STAGE</th>
<th>CONSTRUCTION STAGE</th>
<th>USE STAGE</th>
<th>END OF LIFE STAGE</th>
<th>BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARIES</th>
</tr>
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<tbody>
<tr>
<td>Raw material supply</td>
<td>Transport</td>
<td>Manufacturing</td>
<td>Transport from the gate to the site</td>
<td>Assembly</td>
</tr>
<tr>
<td>A1</td>
<td>A2</td>
<td>A3</td>
<td>A4</td>
<td>A5</td>
</tr>
<tr>
<td>X</td>
<td>X</td>
<td>X</td>
<td>MND</td>
<td>MND</td>
</tr>
</tbody>
</table>

**RESULTS OF THE LCA - ENVIRONMENTAL IMPACT: 1 kg water resisting admixture**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Unit</th>
<th>A1-A3</th>
</tr>
</thead>
<tbody>
<tr>
<td>Global warming potential</td>
<td>kg CO&lt;sub&gt;2&lt;/sub&gt;-Eq.</td>
<td>2.67E+0</td>
</tr>
<tr>
<td>Depletion potential of the stratospheric ozone layer</td>
<td>kg CFC11-Eq.</td>
<td>4.26E-10</td>
</tr>
<tr>
<td>Acidification potential of land and water</td>
<td>kg SO&lt;sub&gt;2&lt;/sub&gt;-Eq.</td>
<td>8.29E-3</td>
</tr>
<tr>
<td>Eutrophication potential</td>
<td>kg (PO&lt;sub&gt;4&lt;/sub&gt;3-) -Eq.</td>
<td>9.56E-4</td>
</tr>
<tr>
<td>Abiotic depletion potential for non-fossil resources</td>
<td>kg Sb-Eq.</td>
<td>7.20E-5</td>
</tr>
<tr>
<td>Abiotic depletion potential for fossil resources</td>
<td>[MJ]</td>
<td>5.70E+1</td>
</tr>
</tbody>
</table>

**RESULTS OF THE LCA - RESOURCE USE: 1 kg water resisting admixture**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Unit</th>
<th>A1-A3</th>
</tr>
</thead>
<tbody>
<tr>
<td>Renewable primary energy as energy carrier</td>
<td>[MJ]</td>
<td>7.23E+0</td>
</tr>
<tr>
<td>Renewable primary energy resources as material utilization</td>
<td>[MJ]</td>
<td>0.00E+0</td>
</tr>
<tr>
<td>Total use of renewable primary energy resources</td>
<td>[MJ]</td>
<td>7.23E+0</td>
</tr>
<tr>
<td>Non-renewable primary energy as energy carrier</td>
<td>[MJ]</td>
<td>6.08E+1</td>
</tr>
<tr>
<td>Non-renewable primary energy as material utilization</td>
<td>[MJ]</td>
<td>0.00E+0</td>
</tr>
<tr>
<td>Total use of non-renewable primary energy resources</td>
<td>[MJ]</td>
<td>6.08E+1</td>
</tr>
<tr>
<td>Use of secondary material</td>
<td>[kg]</td>
<td>0.00E+0</td>
</tr>
<tr>
<td>Use of renewable secondary fuels</td>
<td>[MJ]</td>
<td>6.17E-4</td>
</tr>
<tr>
<td>Use of non-renewable secondary fuels</td>
<td>[MJ]</td>
<td>5.89E-3</td>
</tr>
<tr>
<td>Use of net fresh water</td>
<td>[m³]</td>
<td>1.68E-2</td>
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</table>

**RESULTS OF THE LCA – OUTPUT FLOWS AND WASTE CATEGORIES: 1 kg water resisting admixture**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Unit</th>
<th>A1-A3</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hazardous waste disposed</td>
<td>[kg]</td>
<td>8.14E-6</td>
</tr>
<tr>
<td>Non-hazardous waste disposed</td>
<td>[kg]</td>
<td>2.53E-1</td>
</tr>
<tr>
<td>Radioactive waste disposed</td>
<td>[kg]</td>
<td>1.50E-3</td>
</tr>
<tr>
<td>Components for re-use</td>
<td>[kg]</td>
<td>0.00E+0</td>
</tr>
<tr>
<td>Materials for recycling</td>
<td>[kg]</td>
<td>0.00E+0</td>
</tr>
<tr>
<td>Materials for energy recovery</td>
<td>[kg]</td>
<td>0.00E+0</td>
</tr>
<tr>
<td>Exported electrical energy</td>
<td>[MJ]</td>
<td>0.00E+0</td>
</tr>
<tr>
<td>Exported thermal energy</td>
<td>[MJ]</td>
<td>0.00E+0</td>
</tr>
</tbody>
</table>

### 6. LCA: Interpretation

When considering upstream production and transport of pre-products as well as manufacturing of the concrete admixture (modules A1-A3), the main driver of impacts in all categories is production of pre-products (module A1). The European electricity grid mix plays a fairly important role in defining ozone depletion potential (ODP) impact and radioactive waste, and also has minor influence on acidification potential (AP). The plastic packaging of the concrete admixture has some influence on the cradle-to-gate results in the category of photochemical ozone creation potential (POCP), non-renewable primary energy demand (PENRT), and abiotic depletion potential for fossil resources (ADPF) and also makes a small contribution to ODP, AP, global warming potential (GWP) impacts. Wooden pallets make a small contribution to renewable primary energy demand (PERT). Treatment of production waste has negligible contribution to impacts in all categories with the exception of eutrophication potential (EP), where landfilling of production waste contributes a minor amount.
7. Requisite evidence

As this involves a declaration of preliminary products, special tests and evidence within the framework of drawing up this Model Environmental Product Declaration have not been carried out or provided.

8. References

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

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

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

**CPR**  

**EN ISO 9001:2008**  

**GaBi 6 software & documentation**  

**EN 196-2:2013**  
Test methods for cement – Part 2: Chemical analysis of cement

**EN 206:2013**  
Concrete – Part 1: Specification, performance, production and conformity

**EN 480-1:2014**  
Admixtures for concrete, mortar and grout – Test methods – Part 1: Reference concrete and reference mortar for testing

**EN 480-2:2006**  
Admixtures for concrete, mortar and grout – Test methods – Part 2: Determination of setting time

**EN 480-4:2005**  
Admixtures for concrete, mortar and grout – Test methods – Part 4: Determination of bleeding of concrete

**EN 480-5:2005**  
Admixtures for concrete, mortar and grout – Test methods – Part 5: Determination of capillary absorption

**EN 480-6:2005**  
Admixtures for concrete, mortar and grout – Test methods – Part 6: Infra red analysis

**EN 480-8:2012**  
Admixtures for concrete, mortar and grout – Test methods – Part 8: Determination of the conventional dry material content

**EN 480-10:2009**  
Admixtures for concrete, mortar and grout – Test methods – Part 10: Determination of water-soluble chloride content

**EN 480-11:2005**  
Admixtures for concrete, mortar and grout – Test methods - Part 11: Determination of air void characteristics in hardened concrete

**EN 480-12:2005**  
Admixtures for concrete, mortar and grout – Test methods – Part 12: Determination of the alkali content of admixtures

**EN 480-14:2006**  
Admixtures for concrete, mortar and grout – Test methods – Part 14: Determination of the effect on corrosion susceptibility of reinforcing steel by potentiostatic electro-chemical test

**EN 934-1:2008**  
Admixtures for concrete, mortar and grout – Part 1: Common aspects

**EN 934-2:2009+A1:2012**  
Admixtures for concrete, mortar and grout – Part 2: Concrete admixtures – Definitions, requirements, conformity, marking and labelling

**EN 934-5:2007**  
Admixtures for concrete, mortar and grout – Part 5: Admixtures for sprayed concrete – Definitions, requirements, conformity, marking and labelling

**EN 934-6:2001+A1:2005**  
Admixtures for concrete, mortar and grout – Part 6: Sampling, conformity control and evaluation of conformity

**EN 12350-2:2009**  
Testing fresh concrete – Part 2: Slump test

**EN 12390-3:2009**  
Testing hardened concrete – Part 3: Compressive strength of test specimens
EN 12350-5:2009  
Testing fresh concrete – Part 5: Flow table test

EN 12350-7:2009  
Testing fresh concrete – Part 7: Air content – Pressure methods

EN 14487-1:2005  
Sprayed concrete – Part 1: Definitions, specifications and conformity

EWC/AVV waste code  
Directive governing introduction of the European Waste Catalogue  
http://www.ngs-mbh.de/zs/eak.html

ISO 758:1976  
Liquid chemical products for industrial purposes; Determination of density at 20 °C

ISO 4316:1977  
Surface active agents; Determination of the pH value of aqueous solutions; Potentiometric method

PCR Part A  

PCR Part B  
Product Category Rules for Construction Products, Part B: Requirements on the EPD for concrete admixtures, 2014-07

REACH  
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