

Statement of Verification

BREG EN EPD No.: 000392

Issue 01

This is to verify that the

Environmental Product Declaration

provided by:

CCL Scandinavia A/S



is in accordance with the requirements of:

EN 15804:2012+A1:2013

and

BRE Global Scheme Document SD207

This declaration is for:

1 kilogram of CE-marked Corrugated Duct according to EN 523 "Steel strip sheaths for prestressing tendons", Category 1 and Category 2

Company Address

Ny Vestergårdsvej 11
DK 3500 Værløse
Denmark



Signed for BRE Global Ltd

Emma Baker

Operator

23 November 2021

Date of this Issue

23 November 2021

Date of First Issue

22 November 2026

Expiry Date



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To check the validity of this statement of verification please, visit www.greenbooklive.com/check or contact us.

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Environmental Product Declaration

EPD Number: 000392

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
CCL International Unit 8, Millennium Drive, Leeds, LS11 5BP	Pat Hermon BRE LINA v2
Declared Unit	Applicability/Coverage
1kg Corrugated Duct	Product Average.
EPD Type	Background database
Cradle to Gate	ecoinvent v3.2
Demonstration of Verification	
CEN standard EN 15804 serves as the core PCR ^a	
Independent verification of the declaration and data according to EN ISO 14025:2010 <input type="checkbox"/> Internal <input checked="" type="checkbox"/> External	
(Where appropriate ^b)Third party verifier: Nigel Jones	
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	
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			Construction		Use stage							End-of-life				Benefits and loads beyond the system boundary
					Related to the building fabric					Related to the building						
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	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
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Note: Ticks indicate the Information Modules declared.

Manufacturing site

CCL Scandinavia A/S
Ny Vestergårdsvej 11
DK 3500 Værløse

Construction Product

Product Description

This LCA covers corrugated steel ducts. Corrugated steel ducts are used in bonded post-tensioning and precast concrete elements and can also be used to create recesses.

All standard ducts are manufactured in accordance with the harmonized standard EN523 and is CE-marked, as per EU building materials regulations. The Declaration of Performance (DOP) for standard ducts can be downloaded from the website.

Ducts are available in a range of sizes and types where:

- Type BR are ducts according to EN523 Category 1.
- Type BRM are ducts according to EN 523 Category 1 working as couplers.
- Type KR are ducts according to EN523 Category 2.
- Type KRM are ducts according to EN 523 Category 2 working as couplers.

Type:	Specifications:				
	Weight kg:	Ø mm:	L mm:	kg/m:	m/kg:
BR4030	2.46	30	6000	0.41	2.44
BR4035	3	35	6000	0.5	2
BR4040	3.24	40	6000	0.54	1.85
BR4045	3.66	45	6000	0.61	1.64
BR4050	4.08	50	6000	0.68	1.47
BR4055	4.5	55	6000	0.75	1.33
BR4060	4.92	60	6000	0.82	1.22
BR4065	5.28	65	6000	0.88	1.14
BR4070	5.7	70	6000	0.95	1.05
BR4075	6.12	75	6000	1.02	0.98
BR4080	7.2	80	6000	1.2	0.83
BR4085	7.5	85	6000	1.25	0.8
BR5050	5.4	50	6000	0.9	1.11
BR5055	5.88	55	6000	0.98	1.02
BR5060	6.42	60	6000	1.07	0.93
BR5065	6.96	65	6000	1.16	0.86
BR5070	7.44	70	6000	1.24	0.81
BR5075	7.98	75	6000	1.33	0.75
BR5080	8.52	80	6000	1.42	0.7
BR5085	9.06	85	6000	1.51	0.66
BR5090	9.54	90	6000	1.59	0.63
KR6116	14.7	116	6000	2.45	0.41
KR6121	15.78	121	6000	2.63	0.38
KR6126	15.9	126	6000	2.65	0.38
KR6130	16.2	130	6000	2.7	0.37
BRM4035	0.1	35	200	0.5	2
BRM4040	0.11	40	200	0.54	1.85
BRM4045	0.12	45	200	0.61	1.64
BRM4050	0.14	50	200	0.68	1.47
BRM4055	0.15	55	200	0.75	1.33
BRM4060	0.16	60	200	0.82	1.22
BRM4065	0.18	65	200	0.88	1.14
BRM4070	0.21	70	225	0.95	1.05
BRM4075	0.23	75	225	1.02	0.98
BRM4080	0.3	80	250	1.2	0.83
BRM4085	0.31	85	250	1.25	0.8
BRM5055	0.2	55	200	0.98	1.02
BRM5060	0.21	60	200	1.07	0.93
BRM5065	0.23	65	200	1.16	0.86
BRM5070	0.25	70	200	1.24	0.81
BRM5075	0.3	75	225	1.33	0.75

Type:	Specifications:				
	Weight kg:	Ø mm:	L mm:	kg/m:	m/kg:
BR5095	10.08	95	6000	1.68	0.6
BR5100	10.14	100	6000	1.69	0.59
BR5105	11.1	105	6000	1.85	0.54
BR5110	11.64	110	6000	1.94	0.52
BR5115	12.18	115	6000	2.03	0.49
BR5120	12.6	120	6000	2.1	0.48
BR5125	12.9	125	6000	2.15	0.47
BR5130	13.2	130	6000	2.2	0.45
BR5140	14.4	140	6000	2.4	0.42
BR5150	15.3	150	6000	2.55	0.39
KR5080	8.52	80	6000	1.42	0.7
KR5085	9.06	85	6000	1.51	0.66
KR6090	12	90	6000	2	0.5
KR6095	12.12	95	6000	2.02	0.5
KR6096	12.12	96	6000	2.02	0.5
KR6100	12.18	100	6000	2.03	0.49
KR6101	12.24	101	6000	2.04	0.49
KR6105	13.32	105	6000	2.22	0.45
KR6106	13.38	106	6000	2.23	0.45
KR6111	13.98	111	6000	2.33	0.43
KR6115	14.64	115	6000	2.44	0.41
BRM5080	0.32	80	225	1.42	0.7
BRM5085	0.38	85	250	1.51	0.66
BRM5090	0.44	90	275	1.59	0.63
BRM5095	0.5	95	300	1.68	0.6
BRM5100	0.51	100	300	1.69	0.59
BRM5105	0.56	105	300	1.85	0.54
BRM5110	0.63	110	325	1.94	0.52
BRM5115	0.71	115	350	2.03	0.49
BRM5120	0.74	120	350	2.1	0.48
BRM5125	0.7	125	350	2	0.5
BRM5130	0.77	130	350	2.2	0.45
KRM5085	0.45	85	250	1.81	0.55
KRM5090	0.53	90	275	1.91	0.52
KRM6096	0.18	96	300	0.61	1.64
KRM6101	0.19	101	300	0.62	1.61
KRM6106	0.2	106	300	0.67	1.49
KRM6111	0.29	111	350	0.82	1.22
KRM6115	0.3	115	350	0.85	1.18
KRM6116	0.3	116	350	0.86	1.16
KRM6121	0.32	121	350	0.92	1.09

Other diameters can be manufactured on request.

This is an average EPD covering all corrugated ducts produced over the course of 1 year

Technical Information

Essential characteristics	Performance	Standard
Water tightness	Water loss max. 1.5% (vol.)	EN 523 & EN 524-6
Flexural behaviour	23N – 787N	EN 523 & EN 524-2
Lateral load resistance	600N – 1500N	EN 523 & EN 524-4
Tensile load resistance	400N – 2200N	EN 523 & EN 524-5

Main Product Contents

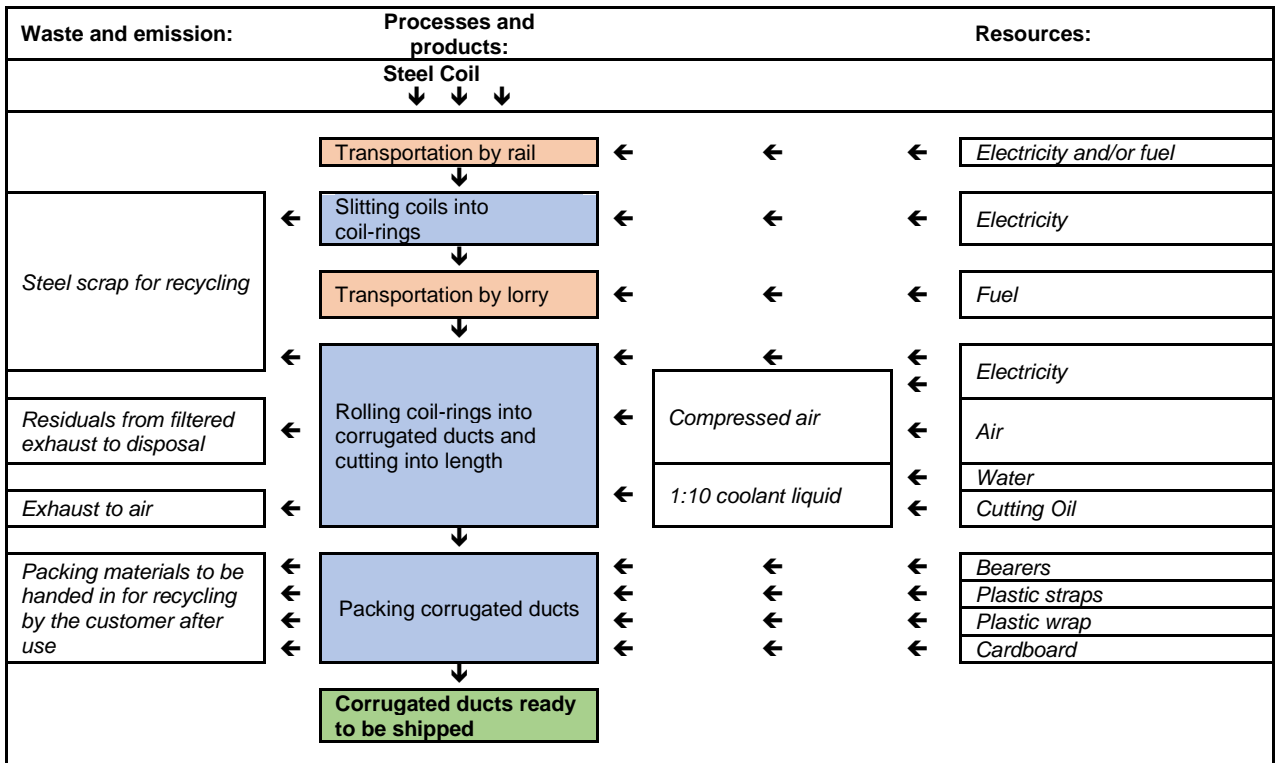
Material/Chemical Input	%
Steel	100%

Material composition of all products assessed within this average EPD

Manufacturing Process

The input material is cold rolled Steel Coils. Coils are transported to a third party for slitting into coil rings which are then transported to the manufacturer where they are rolled into ducts, cut to length and packed.

Process flow diagram



Life Cycle Assessment Calculation Rules

Declared unit description

1 kg of corrugated duct as used in precast and post tensioning concrete

System boundary

This is a cradle to gate EPD, reporting all production life cycle stages of modules from A1 to A3 inclusive in accordance with EN 15804:2012+A1:2013.

Data sources, quality and allocation

Data collected by the manufacturer for the production of corrugated ducts for the period 1st January 2020 to 31st December 2020 has been used for this EPD.

The manufacturing site is a combination of a manufacturing unit and a maintenance and repair shop. Electricity consumption was determined by measuring the consumption on the manufacturing unit for different representative dimensions (types) of the products. The measurements have been carried out by an authorized company. The specific power consumptions for the remaining dimensions (types) of the products is calculated using interpolation.

The consumption of water is calculated based on the factual consumption.

Figures for the raw materials, ancillary materials and packaging were from actual usages. Allocation of energy, water, and waste has been done according to the provisions of the BRE PCR PN514 and EN 15804. Secondary data has been drawn from the steel manufacturer's EPD for cold rolled steel coils and the BRE LINA database v2.0.83. The background LCI datasets are based on ecoinvent v3.2 (2015) which was used for all other material energy and waste data requirements.

Cut-off criteria

All inputs or outputs have been included and all raw materials, packaging and transport, energy, water use and wastes, are included, except for direct emissions to air, water and soil, which are not measured. Upstream extraction and/or processing of inputs are included within the use of the background datasets within LINA.

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 ₂ equiv.	kg CFC 11 equiv.	kg SO ₂ equiv.	kg (PO ₄) ³⁻ equiv.	kg C ₂ H ₄ equiv.	kg Sb equiv.	MJ, net calorific value.
Product stage	Raw material supply	A1	2.42E+00	6.87E-14	3.99E-03	4.30E-04	4.73E-04	6.19E-07	2.58E+01
	Transport	A2	7.00E-02	1.03E-08	3.46E-04	1.32E-04	4.90E-05	1.66E-07	1.02E+00
	Manufacturing	A3	-1.07E-02	1.65E-09	6.53E-05	2.54E-05	1.56E-05	8.89E-08	2.98E-01
	Total (of product stage)	A1-3	2.48E+00	1.20E-08	4.40E-03	5.87E-04	5.38E-04	8.74E-07	2.71E+01

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 resource use, primary energy			PERE	PERM	PERT	PENRE	PENRM	PENRT
			MJ	MJ	MJ	MJ	MJ	MJ
Product stage	Raw material supply	A1	1.63E+00	0.00E+00	1.63E+00	2.69E+01	0.00E+00	2.69E+01
	Transport	A2	6.51E-02	8.40E-08	6.51E-02	1.16E+00	0.00E+00	1.16E+00
	Manufacturing	A3	6.44E-01	3.37E-07	6.44E-01	3.21E-01	0.00E+00	3.21E-01
	Total (of product stage)	A1-3	2.34E+00	4.21E-07	2.34E+00	2.84E+01	0.00E+00	2.84E+01

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 non-renewable 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

LCA Results (continued)

Parameters describing resource use, secondary materials and fuels, use of water						
			SM	RSF	NRSF	FW
			kg	MJ net calorific value	MJ net calorific value	m ³
Product stage	Raw material supply	A1	2.69E-02	0.00E+00	0.00E+00	2.10E-02
	Transport	A2	0.00E+00	0.00E+00	0.00E+00	4.94E-04
	Manufacturing	A3	0.00E+00	0.00E+00	0.00E+00	3.31E-04
	Total (of product stage)	A1-3	2.69E-02	0.00E+00	0.00E+00	2.18E-02

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	
Product stage	Raw material supply	A1	9.31E-03	6.12E-02	4.78E-04	
	Transport	A2	1.25E-03	2.47E-02	7.20E-06	
	Manufacturing	A3	3.94E-04	2.57E-03	9.53E-07	
	Total (of product stage)	A1-3	1.10E-02	8.85E-02	4.86E-04	

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

LCA Results (continued)

Other environmental information describing output flows – at end of life						
			CRU	MFR	MER	EE
			kg	kg	kg	MJ per energy carrier
Product stage	Raw material supply	A1	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	Transport	A2	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	Manufacturing	A3	0.00E+00	3.62E-02	0.00E+00	0.00E+00
	Total (of product stage)	A1-3	0.00E+00	3.62E-02	0.00E+00	0.00E+00

CRU = Components for reuse;
MFR = Materials for recycling

MER = Materials for energy recovery;
EE = Exported Energy

References

BSI. Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products. BS EN 15804:2012+A1:2013. London, BSI, 2013.

BSI. Environmental labels and declarations – Type III Environmental declarations – Principles and procedures. BS EN ISO 14025:2010 (exactly identical to ISO 14025:2006). London, BSI, 2010.

BSI. Environmental management – Life cycle assessment – Principles and framework. BS EN ISO 14040:2006. London, BSI, 2006.

BSI. Environmental management – Life cycle assessment – requirements and guidelines. BS EN ISO 14044:2006. London, BSI, 2006.