Environmental Product Declaration Type III ITB No. 317/2022

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Self-drilling hollow bar system SHS nails and piles

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Basic information

This declaration is the Type III Environmental Product Declaration (EPD) based on EN 15804 and verified according to ISO 14025 by an external auditor. It contains the information on the impacts of the declared construction materials on the environment. Their aspects were verified by the independent body according to ISO 14025. Basically, a comparison or evaluation of EPD data is possible only if all the compared data were created according to EN 15804 (see point 5.3 of the standard).

Life cycle analysis (LCA): A1-A4, C1-C4 and D modules in accordance with EN 15804
(Cradle to Gate with options)

The year of preparing the EPD: 2022

Service Life: A service life up to 50 years depends on the soil conditions and the rate of corrosion

PCR: ITB-PCR A (PCR based on EN 15804)

Declared unit: 1 kg of Self-drilling hollow bar system

Product Standards: EN 14490 and EN 14199 (see a list of references)

Reasons for performing LCA: B2B

Representativeness: manufactured in Austria, year 2021

PRODUCTS DESCRIPTION

ANP - SYSTEMS GmbH is a recognized manufacturer in the field of tensioning and anchor technology with a manufacturing plant “WERK2” located in Puch, Austria. ANP-Systems products are produced in-house with state-of-the-art production technology and strict quality controls. They cover the spectrum of geotechnical applications with rock or ground nails, micropiles and a highly efficient self-drilling hollow bar systems.

PRODUCT APPLICATION

The SHS self-drilling hollow bar system developed by ANP-SYSTEMS is an efficient self-drilling support that ensures simple, quick and safe installation. SHS application spectrum covers all ANP products.

The principle of soil nailing consists in installing reinforcements in the form of bars (soil nails) into the natural soil in order to increase the tensile and shear strength of the ground. This creates a monolithic compound structure whose load-bearing property is similar to that of a gravity retaining wall loaded by external forces. Hollow-bar nails consist of three main components: the nail head, the steel tendon coupler and lost drill bit and the grout body. The steel tendon is a hollow steel bar with cold rolled thread and can therefore be cut or joined at any desired point.

Typical uses include securing terraces or slope cuts and excavations and the stabilizing of existing slopes and dams. The use as rock nails is a special application (see technical documents);

- Hollow-bar nails
- Solid-bar nails

Piles are deep foundation elements with a small diameter of up to 300 mm, by means of which loads from the superstructure are transferred to lower-lying, load-bearing soil layers through skin friction. Micropiles can transfer tensile, compression and alternating loads. Typical applications are the foundation or strengthening of existing foundations of structures (e.g. buildings, bridges, retaining walls, masts etc.) or uplift restraint for structures in groundwater. Hollow-bar piles consist of three main components: the pile head, the steel tendon or compression member – including coupler and lost drill bit - and the grout body (see technical documents);

- Hollow-bar piles
- Solid-bar piles

ANP-SHS’s advantages are:

- Approved system with internal and external monitoring
- Rapid construction progress by drilling, moving and injecting the hollow bars in one operation
- Self-drilling system can also be installed in non-stable floors with a lightweight device
- minimal disturbance of the subsoil and small space requirement when moving
- Good adaptation to transport and installation conditions by delivery in sections with couplers
- A large selection of drill bits allows use in a wide variety of soils
- Easy length adaptation on site in varying geological conditions, by using sections with couplers
- Excellent bond between SHS rod and cement mortar due to construction site-compatible thread ribs
- Good adaptation to the required loads through a wide range of diameters and cross-sections

Unit

The declared unit is 1 kg of self-drilling hollow bar system (piles and nails) representing the average value for the ANP products population.

System boundary

The life cycle analysis of the declared product covers “Product Stage” A1-A3 modules, transport to a construction site – A4 module,“End of Life stage” C1-C4 modules and gains and loads beyond system in D module (Cradle to Gate with options) in accordance with EN 15804 and ITB PCR A.

Allocation

The allocation rules used for this EPD are based on general ITB PCR A. Production of steel fibers is a multi line process (see Figure 1) in a manufacturing plant located at Puch, Austria. Allocation of impacts is done on product mass basis (99.9%). All impacts from raw materials production (steel tubes for bars, steel for nuts and couplers, emulsion, drill bits, nuts, PE spacers, PE-HD elements, foil, boxes, welding material, pallets) are allocated in the A1 module of the LCA. 99.9% of the impacts from a line production were allocated to products covered by this declaration in A3 module. Module A2 includes transport of raw materials such as steel (mainly trucks) from suppliers to manufacturing plant. Municipal wastes and all other waste of the factory were allocated to module A3. Energy supply (Salzburg AG), own phototovoltanics and electricity (KELAG) was inventoried and 99.9% was allocated to the product assessed (A3). Emissions in the factory are assessed based on declared values and by using Ecoinvent data for energy carriers. Austrain energy mix 2021 for electricity production was used.

System limits

99.9% materials and 99.9% of the energy consumption (electricity, diesel, gas) were inventoried in the factory and were included in the calculation. In the assessment, all significant parameters from gathered production data are considered, i.e. all material used per formulation (main input is steel), utilized thermal energy and electric power consumption, direct production waste, and available emission measurements. Precomponents like labels & tapes with a percentage share of less than 0.1% were not included in the calculations. It is assumed that the total sum of omitted processes does not exceed 1% of all impact categories. In accordance with EN 15804 machines and facilities (capital goods) required for and during production are excluded, as is transportation of employees.

A1 and A2 Modules: Raw materials supply and transport

Based on the provided declarations for main steel producers it was assumed that ANP uses EAF steel (99%) with calcultated recyclate content (80%). Using this assumption for the carbon footprint ITB adopted generic data for "EAF steel production”. Data on transport of all different input products to the manufacturing plants were inventoried in details and modelled (weighted average distance approach). For calculation purposes European fuel averages are applied in module A2.

A3: Production

The production process is presented in Figure 1. The producer uses green electricity certified by the supplier.

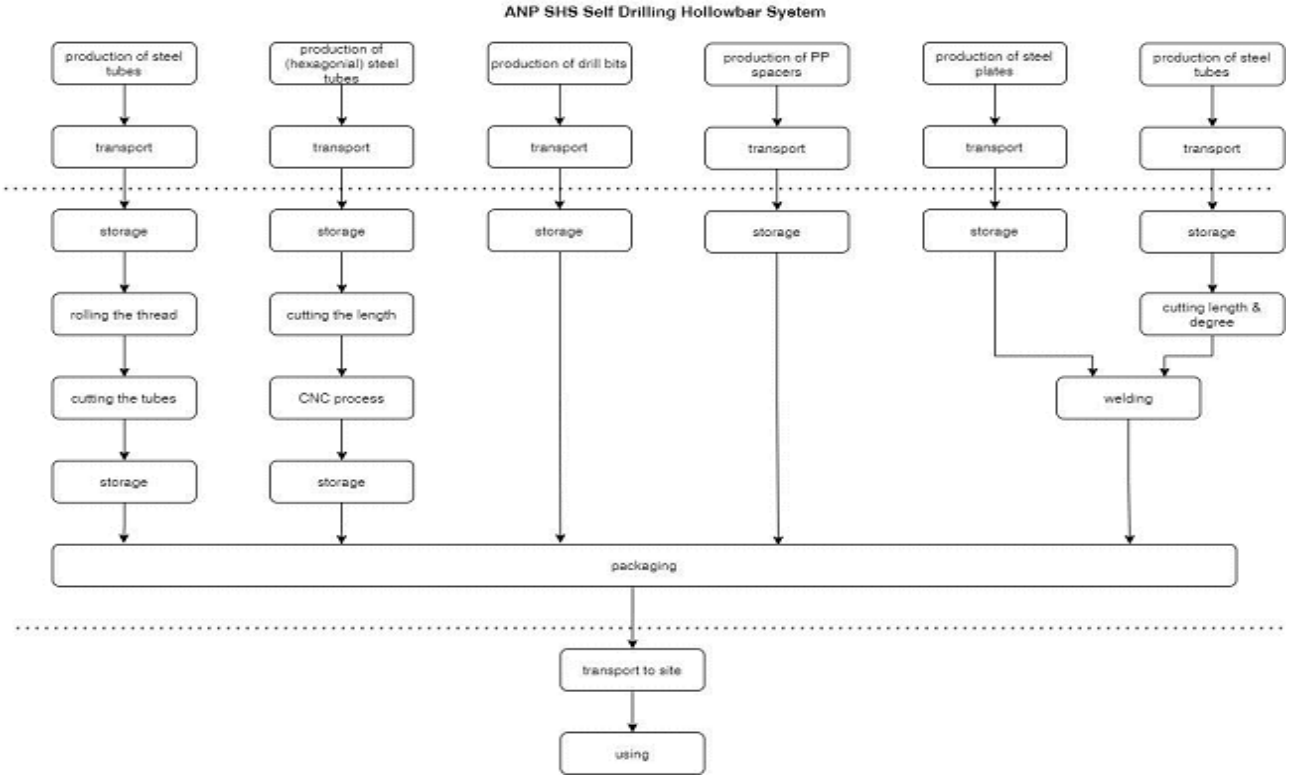

Figure 1. A schematic diagram of the industrial process (A3 module).

A4: Transport to construction site

The following transport scenario to the place of use was assumed based on the manufacturer's declaration: large vehicle, 75% capacity over an average distance of 500 km. For calculation purposes, European averages for fuel are applied in module A4.

End of life scenarios (C and D modules)

The end of life scenario has been generalized (table 1). There are two different end of life scenarios assumed. Type 1 called temporary use - according to the product application the system for temporary use is partly recyclable. The “free length” parts of the anchor are removeable and therefor completely recyclable. The free length could be cut from the bonded. Regained material, e.g. couplers or bars should be considered as scrap, but of course, recyclable. Type 2: permanent use: a product for permanent use is not meant to be dismantled from the ground, rock or other surface material. Once set, the micropiles or nails are lost. For (C1 module) 15% material recovery potential is assumed. All recovered steel can be used for new steel production (EAF process). It is assumed that at the end of life the transport distance for recovered product from the deconstruction place to waste processing (C2) is 50 km by small truck with 75% capacity utilization and fuel consumption of 15 l per 100 km. No product elements are landfiled (C4) for both scenarios. The reuse, recovery and recycling potential for a new product system is considered beyond the system boundaries (module D) based on World Steel recommendations and national practice (net scrap approach, see references).

Table 1. End of life scenarios for ANP products

Progress products	Material recovery	Reuse	Recycling	Landfilling
ANP systems	15%	0%	15%	0%

Data collection period

The data for manufacture of the declared products refers to the period between 01.01.2021– 31.12.2021 (1 year). The life cycle assessments were done for Austria as reference area.

Data quality - production

The values determined to calculate A3 originate from verified Progress LCI inventory data for Werk2 Factory. A1 values were prepared considering generic steel production process. Allocation for steel production impacts is done in accordance with *LCI data for Steel products Report* compiled by Braian Hughes and William Hare (World Steel Association).

Assumptions and estimates

The impacts of the representative products were aggregated using weighted average. Data regarding production per 1 kg of product was averaged for the analysed product group. All production processes (A3) were assigned to different types of products in an equal way (mass-based approach).

Calculation rules

LCA was done in accordance with the ITB PCR a document. Characterization factors are CML ver. 4.2 based (2016). ITB-LCA algorithms were used for impact calculations. A1 was calculated based on data from the databases and generic EPD for steel, A2 and A3 were calculated based on the LCI questionnaire provided by the manufacturer.

Databases

The background data for the processes come from the following databases: Ecoinvent v3.8 (steel, ancillary items, packaging, "green electricity", PV energy production, gas and diesel combustion), specific data (partly specific data for steel were specific data was provided). Specific (LCI) data quality analysis was a part of the audit (input numbers are verified). The time related quality of the data used is valid (5 years).

Comparability

Environmental product declarations of construction products may not be comparable if they do not comply with EN 15804. The manufacturer is responsible for its own data presented in the declarations.

Health related issues

Product can be considered as neutral for Indoor Air Quality. According to the latest revision of Article 59, the Regulation (EC) No 1907/2006 on the Registration, Evaluation, Authorization and restriction of Chemicals (REACH), "the REACH list", of substances of very high concern' (SVHC) the product is not manufactured with or contains any of these substances above a concentration of 0.1% by weight.

LIFE CYCLE ASSESSMENT (LCA) – Results

Declared unit

The declaration refers to the unit DU– 1 kg of ANP SHS product (Table 2). The following life cycle modules are included in the declaration (Table 2).

Table 2. System boundaries (life stage modules included) in a product environmental assessment

Environmental assessment information (MA – Module assessed, MNA – Module not assessed, INA – Indicator Not Assessed)																
Product stage			Construction process		Use stage							End of life				Benefits and loads beyond the system boundary
Raw material supply	Transport	Manufacturing	Transport to construction site	Construction-installation process	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction demolition	Transport	Waste processing	Disposal	Reuse-recovery-recycling potential
A1	**A2**	**A3**	**A4**	**A5**	**B1**	**B2**	**B3**	**B4**	**B5**	**B6**	**B7**	**C1**	**C2**	**C3**	**C4**	**D**
MA	**MA**	**MA**	**MA**	**MNA**	**MNA**	**MNA**	**MNA**	**MNA**	**MNA**	**MNA**	**MNA**	**MA**	**MA**	**MA**	**MA**	**MA**

Table 3. Environmental product characteristic – 1 kg of ANP SHS product

Environmental impacts: (DU) 1 kg										
Indicator	**Unit**	**A1**	**A2**	**A3**	**A4**	**C1**	**C2**	**C3**	**C4**	**D**
Global warming potential	kg CO_2	5.21E-01	1.18E-01	3.05E-03	5.25E-02	3.98E-04	5.04E-04	2.64E-03	0.00E+00	-2.00E-02
Depletion potential of the stratospheric ozone layer	kg CFC 11	8.19E-08	2.47E-08	1.07E-09	9.00E-09	4.55E-12	1.74E-10	3.03E-11	0.00E+00	-1.37E-09
Acidification potential of soil and water	kg SO_2	3.67E-03	7.29E-04	1.14E-05	4.16E-04	3.65E-07	3.48E-06	2.42E-06	0.00E+00	-7.92E-05
Formation potential of tropospheric ozone	kg Ethene	2.39E-04	2.11E-05	6.51E-05	2.67E-05	1.88E-06	2.33E-07	1.25E-05	0.00E+00	-3.60E-06
Eutrophication potential	kg $(PO_4)^{3-}$	1.36E-03	8.10E-05	1.82E-05	7.38E-05	1.52E-08	6.15E-07	1.01E-07	0.00E+00	-4.32E-05
Abiotic depletion potential (ADP-elements) for non-fossil resources	kg Sb	3.55E-04	4.80E-07	1.88E-05	2.03E-07	3.06E-06	3.17E-09	2.03E-05	0.00E+00	-1.22E-05
Abiotic depletion potential (ADP-fossil fuels) for fossil resources	MJ	8.80E+00	2.19E+00	4.57E-02	7.17E-01	4.73E-03	6.18E-03	3.15E-02	0.00E+00	-2.13E-01
Environmental aspects: (DU) 1 kg										
Indicator	**Unit**	**A1**	**A2**	**A3**	**A4**	**C1**	**C2**	**C3**	**C4**	**D**
Use of renewable primary energy excluding renewable primary energy resources used as raw materials	MJ	INA	INA	INA	INA	INA	INA	INA	INA	INA
Use of renewable primary energy resources used as raw materials	MJ	INA	INA	INA	INA	INA	INA	INA	INA	INA
Total use of renewable primary energy resources (primary energy and primary energy resources used as raw materials)	MJ	1.11E+00	3.24E-02	8.38E-01	1.00E-02	7.10E-04	6.18E-05	4.71E-03	0.00E+00	-5.34E-02
Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials	MJ	INA	INA	INA	INA	INA	INA	INA	INA	INA
Use of non-renewable primary energy resources used as raw materials	MJ	INA	INA	INA	INA	INA	INA	INA	INA	INA
Total use of non-renewable primary energy resources (primary energy and primary energy resources used as raw materials)	MJ	1.18E+01	2.24E+00	4.80E-02	7.50E-01	5.21E-03	6.50E-03	3.45E-02	0.00E+00	-3.78E-01
Use of secondary material	kg	7.99E-01	0.00E+00	3.42E-03	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	-1.79E-03
Use of renewable secondary fuels	MJ	4.05E-03	4.05E-03	2.40E-06	3.77E-02	1.02E-08	3.24E-04	0.00E+00	0.00E+00	-6.99E-05
Use of non-renewable secondary fuels	MJ	4.39E-03	4.39E-03	0.00E+00	0.00E+00	2.02E-06	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Net use of fresh water	m^3	7.12E-02	4.05E-04	5.71E-06	1.29E-06	1.49E-04	6.62E-08	9.93E-06	0.00E+00	-1.52E-05
Other environmental information describing waste categories: (DU) 1 kg										
Indicator	**Unit**	**A1**	**A2**	**A3**	**A4**	**C1**	**C2**	**C3**	**C4**	**D**
Hazardous waste disposed	kg	1.46E-05	5.43E-06	2.61E-04	4.64E-06	6.30E-09	2.39E-07	4.19E-08	0.00E+00	-1.52E-05
Non-hazardous waste disposed	kg	5.60E-01	9.72E-02	2.26E-04	5.51E-03	8.50E-01	1.28E-01	7.91E-03	0.00E+00	-5.97E-03
Radioactive waste disposed	kg	6.20E-05	1.30E-05	2.36E-08	1.01E-07	6.34E-09	1.59E-08	4.19E-08	0.00E+00	-4.43E-06
Components for re-use	kg	2.22E-09	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	1.50E-03	0.00E+00	-1.25E-04
Materials for recycling	kg	1.60E-06	0.00E+00	9.90E-04	0.00E+00	1.60E-04	2.25E-02	1.55E-01	0.00E+00	-1.16E-06
Materials for energy recovery	kg	0.00E+00	0.00E+00	1.26E-03	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	-1.73E-07
Exported energy	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

RESULTS INTERPRETATION

The environmental impacts of ANP SHS products (cradle to gate with options) is largely dependent on the production of steel on which the manufacturer has a limited influence. The carbon impact of steel production in the product stage A1 is 77% in total. Production is based on green energy (almost zero carbon impact) and there are no any other significant emissions or environmental impacts in the production processes alone (A3). LCA results show that the cradle-to-gate carbon (Global Warming Potential) impact of 1 kg of ANP SHS production is 0.52 kg CO_2 eq. Such a result is due to the conscious choice of EAF steels with a significant environmental performance. In comparison, a 1 kg of steel produced worldwide in 2021 emitted on average 1.80 kg of carbon dioxide. The LCA results show that the cradle-to gate fossil fuel depletion (ADP fuels) is equal to 8.85 MJ/kg of product which should be considered below average for steel based products.
The transport of raw materials from distances is rather optimized (0.12 kg CO_2/kg) but due to the considerable distances of supplies has some potential to be improved. The recovered products (scenario 1) have environmental benefit potential (module D) and can be recycled in steep production process.

VERIFICATION

The process of verification of this EPD was in accordance with ISO 14025 and ISO 21930. After verification, this EPD is valid for a 5-year-period. EPD does not have to be recalculated after 5 years if the underlying data have not changed significantly.

The basis for LCA analysis was EN 15804 and ITB PCR A
Independent verification corresponding to ISO 14025 (sub clause 8.1.3.) [X] external [ ] internal
External verification of EPD: Ph.D. Eng. Halina Prejzner LCA. LCI audit and input data verification: Ph.D. D. SC.Eng. Michał Piasecki, m.piasecki@itb.pl Verification of LCA: Ph.D. Eng. Justyna Tomaszewska,. j.tomaszewska@itb.pl

The purpose of this declaration is to provide a B2B basis for the assessment of buildings and other building work. Comparison of EPD data only makes sense if all data sets to be compared have been developed in accordance with EN 15804 and product-specific performance characteristics and their impact on building works are taken into account.

dr hab. inż. Michał Piasecki

KIEROWNIK
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dr inż. Agnieszka Winkler-Skalna

Normative references

- ITB PCR A, General Product Category Rules for Construction Products
- LCI DATA FOR STEEL PRODUCTS at https://www.worldsteel.org/en/dam/jcr:04f8a180-1406-4f5c-93ca-70f1ba7de5d4/LCI%2520study_2018%2520data%2520release.pdf
- EN 14199:2015 Execution of special geotechnical works. Micropiles
- ISO 14025:2006. Environmental labels and declarations – Type III environmental declarations – Principles and procedures
- ISO 21930 Sustainability in buildings and civil engineering works – Core rules for environmental product declarations of construction products and services
- ISO 14044Environmental management – Life cycle assessment – Requirements and guidelines
- EN 15804 Sustainability of construction works - Environmental product declarations - Core rules for the product category of construction products
- EN 1992-1-1„Eurokod 2 - Projektowanie konstrukcji z betonu - Część 1-1: Reguły ogólne i reguły dla budynków”
- EN 14490: 2010 Execution of work in Special civil engineering - Soil nailing
- EN 1990: 2013 Eurocode - Basics of Structural engineering EN 1997-1: 2014 Eurocode 7 - Design, calculation and dimensioning in of the Geotechnics - Part 1: General rulesEN 10025-2: 2005 Hot-rolled products made of unalloyed structural steels -Technical delivery conditions for unalloyed structural steels
- EN 10080 Steel for the reinforcement of concrete - suitable for welding Reinforcing steel – general
- EN 10083-2,3 Quenched and tempered steels, Part 2: Technical delivery conditions for unalloyed steels Part 3: Technical delivery conditions for alloyed steelsEN 10210-1,2: 2006 Harm-finished hollow profiles for steel construction made of unalloyedStructural steels and fine grain structural steels - Part 1: Technical delivery conditions, Part 2: Limiting dimensions, dimensions and static values
- EN 10293: 2015 Cast steel for general, applications
- EN 12501-1,2: 2003 Corrosion protection of metallic materials – corrosion probability in Floors, Part 1: General Part 2: Low and unalloyed ferrous materials
- EN ISO 1461 Hot-dip galvanized on steel z inc coatings (Piece galvanizing) - requirements and tests EN ISO 15630-1: 2011 Steels for reinforcement and prestressing of concrete - Test procedure -Part 1: Reinforcing bars, wire rod and wire
- ANP - SYSTEMS GMBH BMVIT-327.120 / 0026-IV / IVVS2 / 2015 Page: 4
- ISO 1720 Rock drilling - extension rod for d eep hole Impact drilling equipment with 1, ½ cord thread to 2 Inches (38to 51 mm)
- ISO 10208 Equipment for rock drilling - left-handedCord thread EN 206: 2014 Concrete - Part 1: Definition, properties, production and conformityETAG 013: 2002 European Technical Approval Directive from Post-tensioning systems for prestressing structuresRVS 08.22.01: 2013 Grout anchors, grouted piles and nails
- EN 1990 Eurocode - Basics of Structural engineering
- EN 1997-1: 2014 Eurocode 7 - Design, calculation and dimensioning in of the Geotechnics - Part 1: General rules
- EN 10297-1. Seamless circular steel tubes for mechanical and general engineering purposes
- EN 10210-1 Hot finished structural hollow sections of non-alloy and fine grain steels

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CERTIFICATE № 317/2022
of TYPE III ENVIRONMENTAL DECLARATION

Product:

ANP self-drilling hollow bar system (nails and piles)

Manufacturer:

ANP - Systems GmbH
Christophorusstr. 12, A-5061 Elsbethen, Austria

confirms the correctness of the data included in the development of
Type III Environmental Declaration and accordance with the requirements of the standard

EN 15804

Sustainability of construction works.
Environmental product declarations.
Core rules for the product category of construction products.

This certificate, issued for the first time on 1st April 2022 is valid for 5 years
or until amendment of mentioned Environmental Declaration

Head of the Thermal Physic, Acoustics and Environment Department
Agnieszka Winkler-Skalna, PhD

INSTYTUT TECHNIKI BUDOWLANEJ

Deputy Director for Research and Innovation
Krzysztof Kuczyński, PhD

Warsaw, April 2022