



# EPD

## Environmental Product Declaration for Cement CP V ARI

Programme: The International EPD® System

Programme operator: EPD International AB

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In accordance with ISO 14025 and EN 15804:2022+A2:2019





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CEN standard EN 15804 serves as the Core Product Category Rules (PCR)

Product category rules (PCR):

PCR 2019:14 Construction products (EN 15804:A2); Version 1.11; 2021-02-05

PCR 2019:14 c-PCR-001 Cement and Building Lime (EN 16908); Version 2022-05-18

UN CPC 375

PCR review was conducted by The Technical Committee of the International EPD® System

Independent third-party verification of the declaration and data, according to ISO 14025:2006:

EPD process certification       EPD verification

Third party verifier: Maurizio Fieschi, [fieschi@studiosfieschi.it](mailto:fieschi@studiosfieschi.it), [www.studiosfieschi.it](http://www.studiosfieschi.it)

Approved by: The International EPD® System

Procedure for follow-up of data during EPD validity involves third party verifier:

Yes       No

The EPD owner has the sole ownership, liability, and responsibility for the EPD. EPDs within the same product category but from different programmes may not be comparable. EPDs of construction products may not be comparable if they do not comply with EN 15804. For further information about comparability, see EN 15804 and ISO 14025

## Company Information

**Owner of the EPD:** Votorantim Cimentos S.A, Gomes de Carvalho Street - 11º floor - 12º floor - 04547-006 – São Paulo, SP, Brazil.

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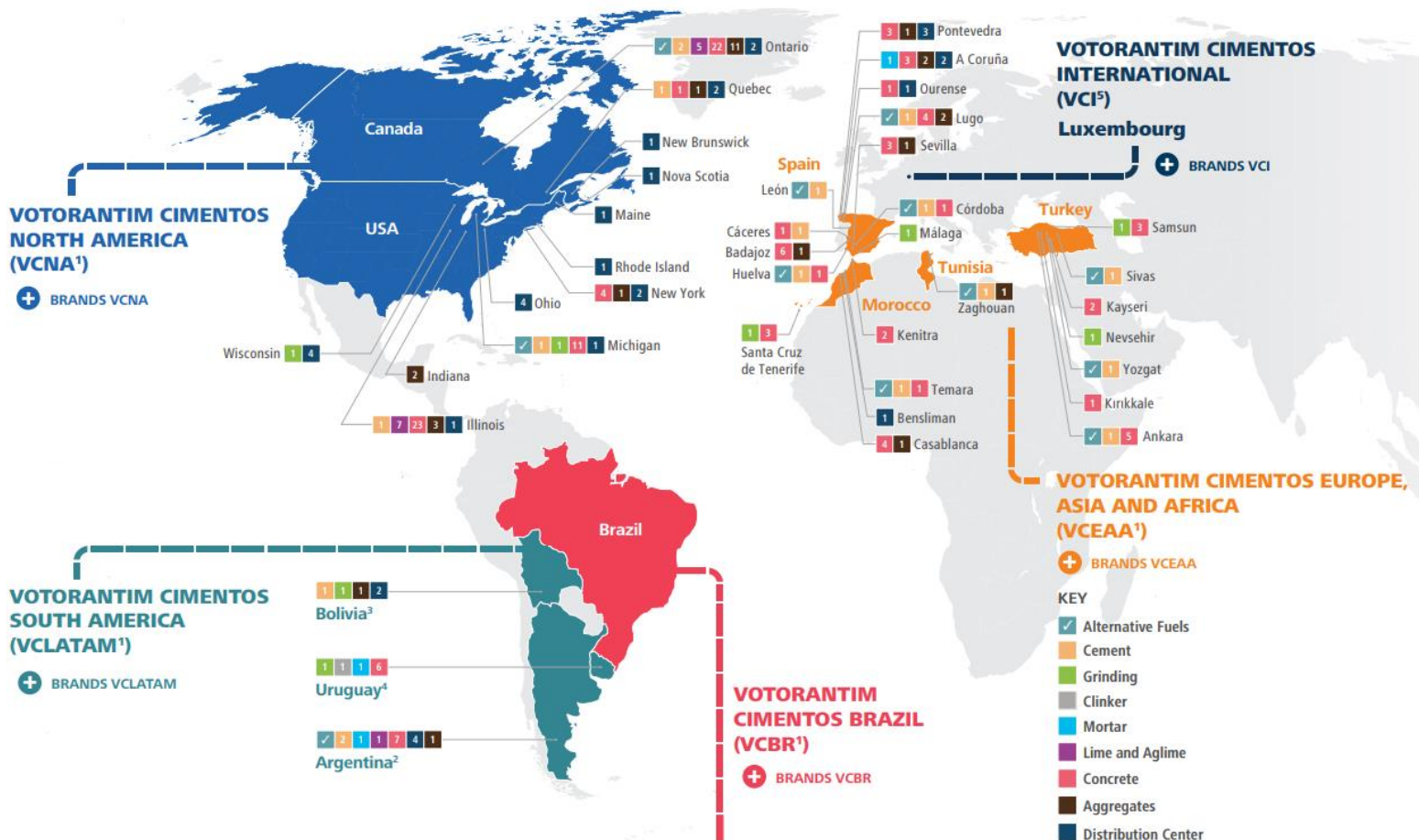
**Description of the organisation:** Building materials manufacturer

Votorantim Cimentos is an international building materials and sustainable solutions company, in operation since 1933. The company is part of the Votorantim Group and is present in 11 countries through the South America, North America, Europe, Middle East and Africa.

Votorantim Cimentos is one of the most vertically integrated companies in the industry, with a diverse portfolio that includes cement, concrete, aggregates, mortars, grouts, finishing products, plasticizers, aglime and waste management (co-processing).

Sustainability is part of Votorantim Cimentos strategy, and the company has a long history in this constant pursuit of more advanced technologies to reduce the environmental footprint, improve energy efficiency, ensure the health, safety and well being and promote social and environmental development of the communities around its operation.

## VOTORANTIM CIMENTOS HAS 32 CEMENT PLANTS AND 16 GRINDING PLANTS WORLDWIDE.



**Product name:**

CP V ARI, Obras Especiais – Santa Helena

**Product identification:**

CP V ARI

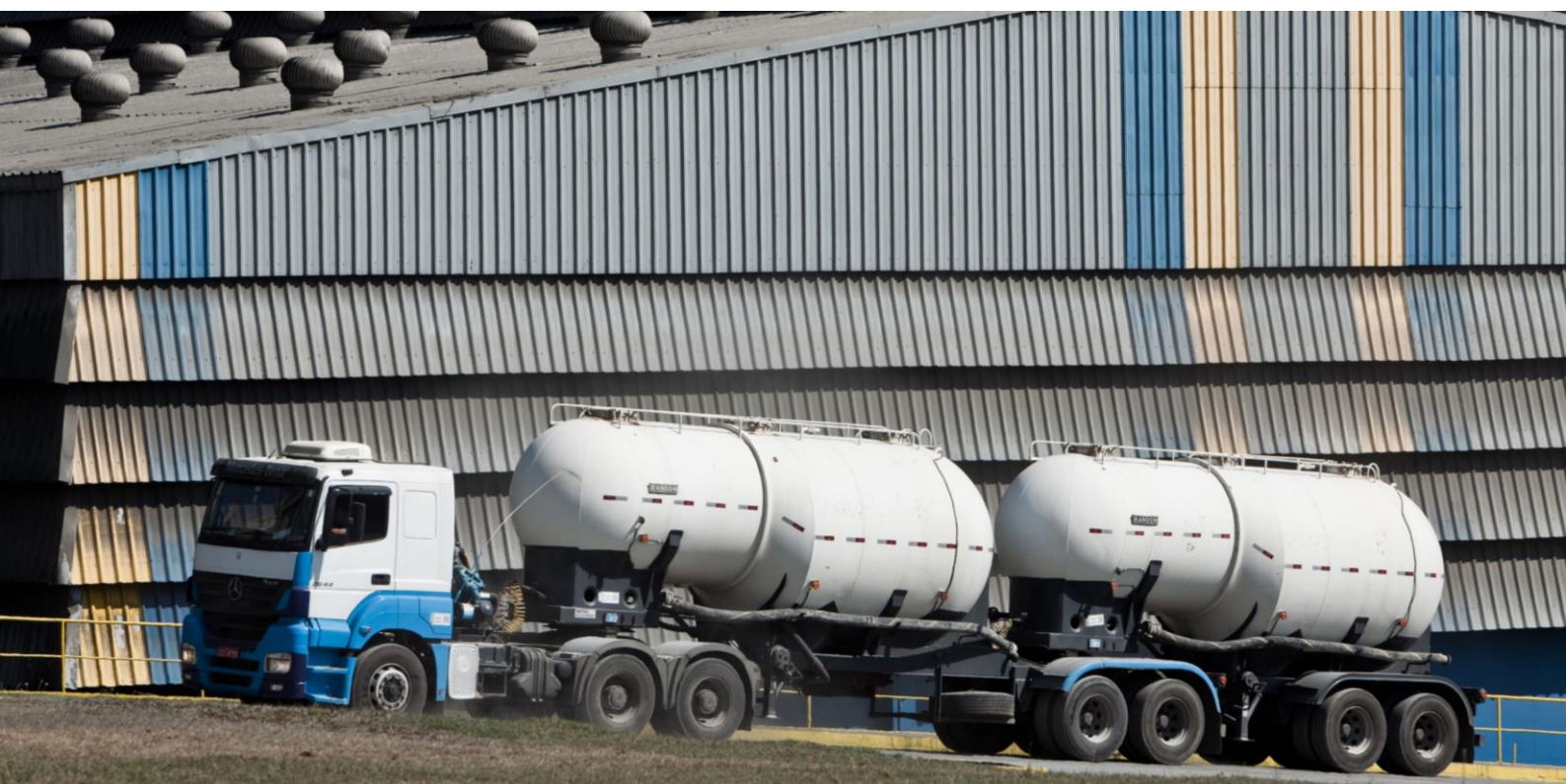
**Product description:** The CP V ARI is a high early strength cement, designed for industries and prefabricated groups and suitable for situations where there is need rapid de-forms. Used in concrete artifacts (concrete blocks, concrete prestressed, high-performance concrete, interlocking floors and prefabricated concrete in general). It is sold in bulk only.

It can be integrated in the following products.

- Reinforced Mortar
- Reinforced concrete with structural function

- Reinforced concrete for quick de-forms, cured with thermal curing
- Reinforced concrete for quick de-forms, cured by chemical product
- Prestressed concrete with prestressing bars after concrete hardening
- Prestressed concrete with prestressing bars before the release of concrete
- Unreinforced concrete
- Floor of unreinforced or reinforced concrete
- Industrial concrete floors
- Precast concrete and cement artifacts cured by water sprinklers
- Precast and cement artifacts for rapid de-forms , cured with thermal curing
- Precast and artifacts for rapid de-forms , cured with water sprinklers

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Technical characteristics		ABNT NBR 16697	CP V ARI
Mechanical properties	Compressive Strength – 1 days (Mpa)	≥ 14.0	25,4
	Compressive Strength – 3 days (Mpa)	≥ 24.0	38.2
	Compressive Strength – 7 days (Mpa)	≥ 34.0	43.5
	Compressive Strength – 28 days (Mpa)	N/A	52.8
Chemical Properties	Magnesium Content	≤ 6.5	5.58
	Sulfate Content (%)	≤ 4.5	2.77
	Loss of ignition (%)	≤ 6.5	2.49
	Insoluble residue (%)	≤ 3.5	0.54
Physical Properties	Initial setting (min)	≥ 60	159
	Final setting (min)	≤ 600	230
	Specific Surface #200 (%)	≤ 6.0	0.00



## Upstream processes: raw material acquisition and refinement

The cement manufacturing process begins with the mining of limestone, the main raw material for cement. The material is extracted from mines and transported to the pre-blending yard

## Core process: Cement Production



**1 Pre-homogenization** - The extracted material from the mines is stored in the pre-blending yard. In this phase, samples are collected for analysis in the quality lab. The limestone chemical composition is drawn (content of calcium, silicon, iron and aluminum).

**2 Flour milling** - In the flour mill, the limestone is ground with clay and specific additives (such as ferrous and aluminic ores or substitutes co-processed materials). The clay is a product that is rich in silica, iron and aluminum, which are essential for the quality of cement. The final product is composed of very fine grains, hence the name flour. A filter installed in the mill prevents dust emissions to the atmosphere. The flour is stored in special silos to be sent to the rotary kiln.

**3 Clinker production**- Before being inserted in the rotary kiln, the flour passes through the cyclone tower to be heated by the hot gases originated by the kiln lying below. When the flour arrives at the rotary kiln, it is already around 900°C, this helps in reducing energy consumption. Inside the kiln, temperature reaches 1450°C producing the clinker.

**4 Cooling** - To complete the clinker production process, the material is cooled in a cooler and the temperature reduced to less than 200°C. A filter is installed in the machine's output, releasing the cooling air without pollutants into the atmosphere. A new sample collection is performed for chemical testing in the Quality Control Laboratory. The clinker is transported to the hoppers, where others raw materials that make up the cement are stored, such as: gypsum, limestone and pozzolan or slag. Depending on the percentage of each product, obtains a cement specification

**5 Cement milling** - The mixture goes to the cement mill where all the components are milled until they reach the ideal particle size, resulting in high-quality cement.

**6 Cement shipment** - After its grinding, the cement is stored in silos to be bagged and marketed.

**Functional unit / declared unit:** The declared unit is one (1) metric tonne (t) of cement.

**Reference service life:** not specified.

**Time representativeness:** The data used in this study cover from January 2021 to December 2021.

**Database(s) and LCA software used:** GCCA Industry EPD Tool for Cement and Concrete and Ecoinvent database (v.3.5).

**System boundaries:** This EPD evaluates the environmental impacts of one metric tonne of cement from Cradle to gate (A1-A3).

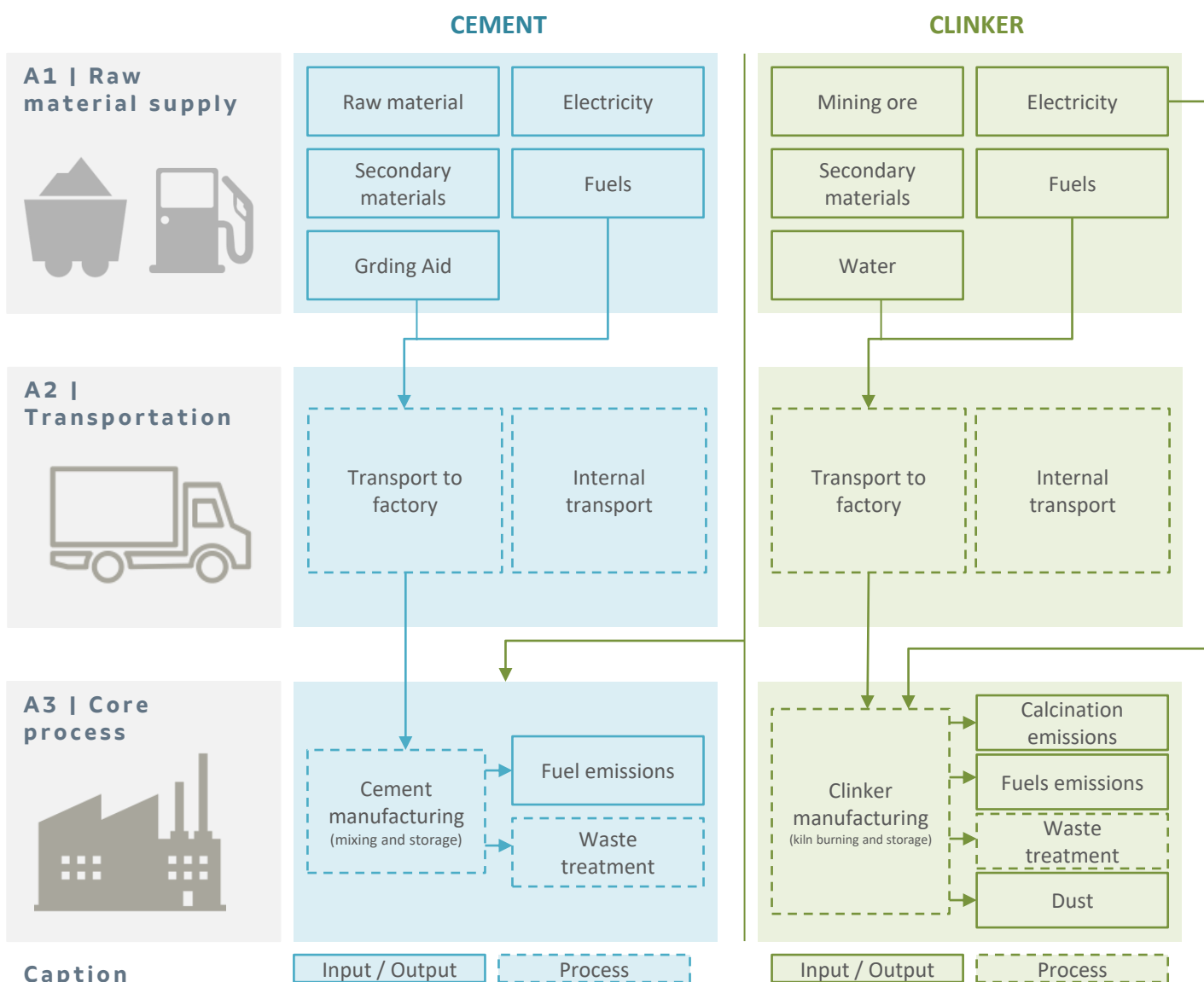
The defined system is split in three categories:

**A1 | Raw Material Supply:** Includes the production of raw materials and fuels, recycling processes of secondary materials and energy required in the production process.

**A2 | Transportation:** Transportation up to factory gate and internal transport

**A3 | Core process:** Cement and packaging manufacturing and waste treatment and transport

The figure below shows the system boundaries in a cradle to grave approach.



	Product stage			Construction process stage					Use stage				End of life stage			Resource recovery stage	
	Raw material supply	Transport	Manufacturing	Transport	Construction installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
Module	A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Modules declared	X	X	X	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND
Geography	BRA	BRA	BRA	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Variation – products	Not relevant			-	-	-	-	-	-	-	-	-	-	-	-	-	-
Variation – sites	Not relevant			-	-	-	-	-	-	-	-	-	-	-	-	-	-

\*X = Module Declared; MND = Module Not Declared; BRA = Brazil

**Data quality:** ISO 14044 was applied in terms of data collection and quality requirements. The data concerning the modules A1 (raw material supply), A2 (transportation) and A3 (product manufacturing) were provided by Votorantim Cimentos S.A. and involved all input and output materials of the cement plant, the consumed utilities (energy) and the distances and means of transport for each input stream. Regarding electricity mix, it was used the national electricity mix supply of 2020 as published in the Brazilian Energy Balance 2021 (BEN2021) from Empresa de Pesquisa Energética (EPE) (<https://www.epe.gov.br/pt/abcdenergia/matriz-energetica-e-eletrica>).

The GCCA Environmental Product Declaration tool (v3.1). GCCA’s Industry EPD Tool for Cement and Concrete is a web based calculation tool for EPDs of clinker, cement, concrete, mortars and precast elements, available in both International and North American versions. The present report refers to the International version only.

The latter complies with PCR 2019:14 Construction products (EN 15804:A2) and complementary PCRs c-PCR-001 Cement and building limes (EN 16908) as well as with the General Programme Instructions (GPI 3.01) of the International EPD® System.



The GCCA EPD tool (v3.1) is developed by Quantis <https://quantis-intl.com/> and verified by Studio Fieschi <http://www.studiofieschi.it/en>. The International EPD® System, which provides the framework to develop and publish EPDs based on ISO 14025 and EN 15804, gives the final approval of the tool's compliance with the rules. The underpinning database for the GCCA EPD tool is the version of the Ecoinvent database (v.3.5) and cement manufacturing data obtained through the GNR process (<https://gccassociation.org/sustainability-innovation/gnrgcca-in-numbers/>).

There is no missing data for this cement product, since all the required raw data were provided from the ERP system (SAP) that company uses.

**Geographical scope:** São Paulo Metropolitan Region (Brazil)

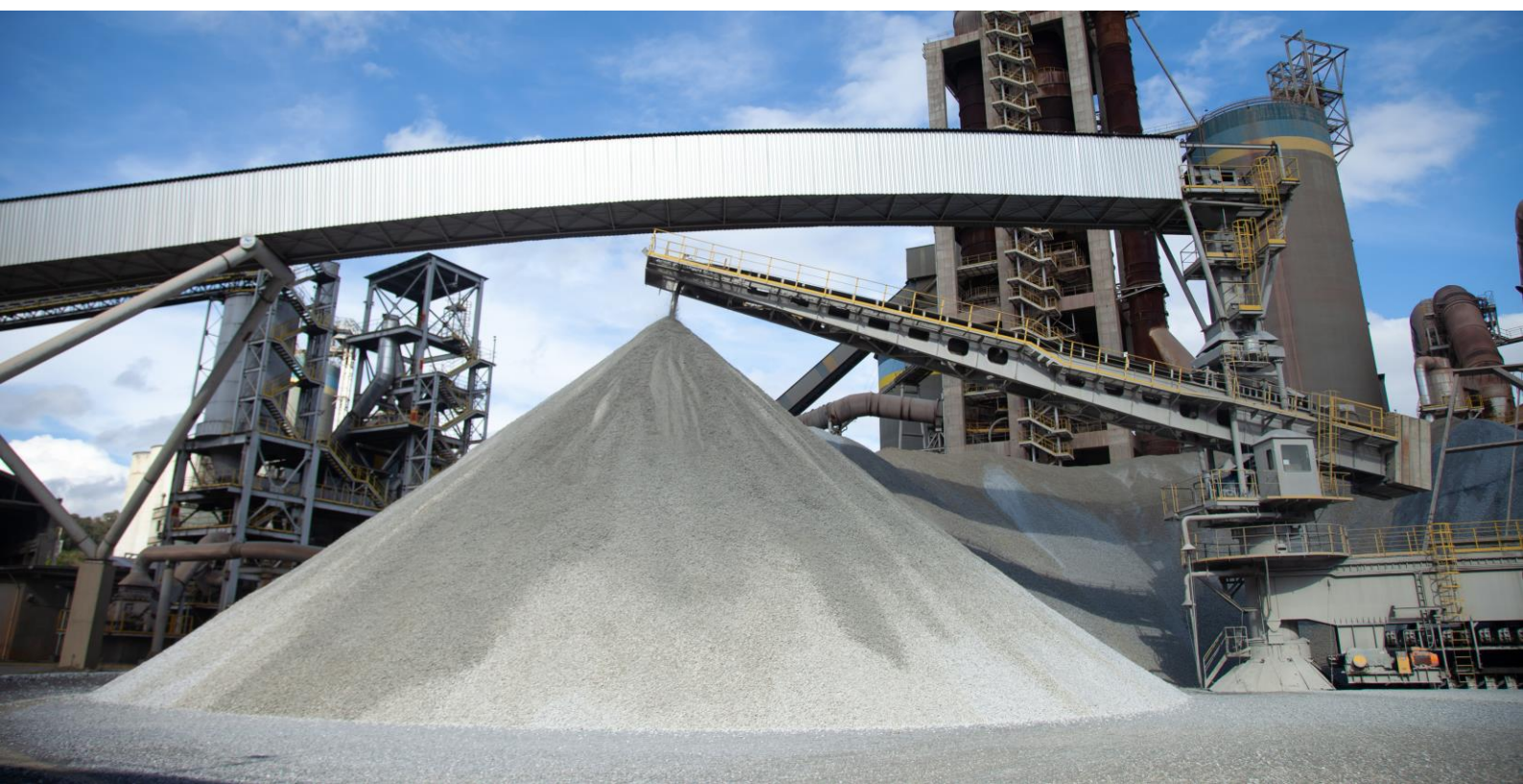
**Assumptions:** This EPD was developed by using GCCA international modelling of energy use and environmental impact to obtain a suitable estimation for products manufactured.

Pre-defined data from GCCA tool for clinker was not used. For this EDP was used clinker data from Votorantim Cimentos' cement plant called Santa Helena.

All modelling assumptions adopted from the GCCA EPD tool.

Raw material (inbound) transport distances are generated from ERP data and are accurate across operations.

**Comparability:** EPD performance for construction products that they do not comply with EN 15804 may not be comparable. EPDs from separate programs but within the same product category may not be comparable as well.



Portland cement (CAS 65997-15-1) is consisting essentially of portland clinker finely ground and plaster. The clinker can also be mixed with others raw materials allowing the production of many types of cement Portland, such as Common Portland Cement; Compound Portland Cement; Blast Furnace Portland Cement; Pozzolanic Portland Cement and others. It may have the following composition as the mixture that is prepared:

	CAS NUMBER	CONCENTRATION RANGE
Tricalcium silicate	12168-85-3	20 - 70
Dicalcium silicate	10034-77-2	10 - 60
Calcium aluminate-iron	12068-35-8	5 - 15
Calcium sulphate	various	2 - 10
Tricalcium aluminate	12042-78-3	1 - 15
Calcium carbonate	1317-65-3	0 - 5
Magnesium oxide	1309-48-4	0 - 4
Calcium oxide	1305-78-8	0 – 0.2

For CP V ARI, the products components are:

Product components	Range (%)
Clinker	89 ~ 92
Limestone	3 ~ 5
Gypsum	4 ~ 7
Grinding aids	0.07 ~ 0.08

**Substance, Reach – Very High Concern:** The products does not contain any SVHS – Substances of Very High Concern, listed by European Chemicals Agency.



The following tables contain the environmental indicators for the Santa Helena plant, located in the city of Votorantim in the state of São Paulo, Brazil.

<b>Core Environmental Impact Indicators</b>	<b>Unit</b>	<b>A1-A3</b>
GWP-tot	kg CO <sub>2</sub> eq.	8.52E+2
GWP-fos	kg CO <sub>2</sub> eq.	8.51E+2
GWP-bio	kg CO <sub>2</sub> eq.	1.81E-1
GWP-luc	kg CO <sub>2</sub> eq.	3.4E-1
ODP	kg CFC 11 eq.	1.67E-5
AP	mol H+ eq.	3.59E+0
EP-fw	kg PO <sub>4</sub> eq.	4.77E-2
EP-fw	kg P eq.	1.55E-2
EP-mar	kg N eq.	1.27E-3
EP-ter	mol N eq.	1.29E+1
POCP	kg NMVOC eq.	3.04E+0
ADPE*	kg Sb eq.	1.59E-4
ADPF*	MJ, net calorific value	1.37E+3
WDP*	m <sup>3</sup> world eq. deprived	4.37E+1

GWP-tot (Global Warming Potential total) • GWP-fos (Global Warming Potential fossil fuels) • GWP-bio (Global Warming Potential biogenic) • GWP-luc (Global Warming Potential land use and land use change) • ODP (Depletion potential of the stratospheric ozone layer) • AP (Acidification potential, Accumulated Exceedance) • EP-fw (Eutrophication potential, fraction of nutrients reaching freshwater end compartment) • EP-fw\* (Eutrophication potential, fraction of nutrients reaching freshwater end compartment\*) • EP-mar (Eutrophication potential, fraction of nutrients reaching marine end compartment) • EP-ter (Eutrophication potential, Accumulated Exceedance) • POCP (Formation potential of tropospheric ozone) • ADPE (Abiotic depletion potential for non- fossil resources) • ADPF (Abiotic depletion for fossil resources potential) • WDP (Water (user) deprivation potential, deprivationweighted water consumption)

\*Disclaimer: The results of this environmental impact indicator shall be used with care as the uncertainties of these results are high or as there is limited experience with the indicator.

<b>Potential environmental impact – additional mandatory</b>	<b>Unit</b>	<b>A1-A3</b>
GWP-GHG	kg CO <sub>2</sub> eq.	8.52E+2

The GWP-GHG indicator is not calculated by GCCA EPD Tool. The GWP-GHG indicator can be assimilated to the GWP-tot indicator

Parameters describing resource use	Unit	A1-A3
PERE	MJ, net calorific value	8.37E+2
PERM	MJ, net calorific value	0E+0
PERT	MJ, net calorific value	8.37E+2
PENRE	MJ, net calorific value	1.55E+3
PENRM	MJ, net calorific value	0E+0
PENRT	MJ, net calorific value	1.55E+3
SM	kg	0.00E+0
RSF	MJ, net calorific value	0E+0
NRSF	MJ, net calorific value	0E+0
NFW	m <sup>3</sup>	1.09E+0

PERE (Use of renewable primary energy excluding renewable primary energy resources 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 resources) • SM (Use of secondary materials) • RSF (Use of renewable secondary fuels) • NRSF (Use of non-renewable secondary fuels) • NFW (Net use of fresh water)

Other environmental information describing waste categories	Unit	A1-A3
HWD	kg	2.68E-2
NHWD	kg	0E+0
RWD	kg	ND

HWD (Hazardous waste disposed) • NHWD (Non-hazardous waste disposed) • RWD (Radioactive waste disposed)

Environmental information describing output flows	Unit	A1-A3
CRU	kg	0E+0
MFR	kg	7.89E+0
MER	kg	6.61E-2
EE	MJ per energy carrier	0E+0

CRU (Components for re-use) • MFR (Materials for recycling) • MER (Materials for energy recovery) • EE (Exported energy)



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International EPD® System, General Program Instructions for the International EPD System, version 3.01

International EPD® System, PCR 2019:14 Construction products, version 1.11 (EN 15804:A2)

International EPD® System, c-PCR-001 Cement and Building Lime (EN 16908)

International EPD® System, General Programme Instructions EN 15804:2012+A2:2019 Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products

GCCA's Industry EPD Tool for Cement and Concrete (V3.1), International version

Votorantim Cimentos Integrated Report 2021. Published in March 2021. São Paulo.

ABNT NBR 16697- Cimento Portland

Brazilian Energy Balance 2021 – base year 2020 – Ministry of Mines and Energy, Brazil

