



# Ali Pre Green Ali Cem Green

## Environmental Product Declaration

In accordance with ISO 14025 and EN 15804  
Programme: The International EPD System, [www.environdec.com](http://www.environdec.com)  
Programme operator: EPD® International AB  
EPD registration no.: S-P-00404  
Geographical scope: Global

Date of emission: 2013/02/22  
Version date: 2023/10/30  
Validity: 2024/06/07



Ali Pre Green

Global warming potential	732 kg CO <sub>2</sub> eq/ton
Use of recycled materials	540 kg/ton
Recycled materials content (ISO 14021 compliant)	48.1%
Recycled pre-consumer materials (ISO 14021 compliant)	48.1%
Recycled post-consumer materials (ISO 14021 compliant)	0%

Ali Cem Green

Global warming potential	614 kg CO <sub>2</sub> eq/ton
Use of recycled materials	424 kg/ton
Recycled materials content (ISO 14021 compliant)	37.8%
Recycled pre-consumer materials (ISO 14021 compliant)	37.8%
Recycled post-consumer materials (ISO 14021 compliant)	0%

Company	Heidelberg Materials Italia Cementi S.p.A.
Website	<a href="http://www.heidelbergmaterials.it">www.heidelbergmaterials.it</a>
EPD Registration No	S-P-00404
Validity	2024/06/07
LCA coverage	Cradle-to-gate

# Declaration of general information

This Environmental Product Declaration (EPD) covers the **ALI PRE GREEN** and **ALI CEM GREEN**, two products with low CO<sub>2</sub> emissions (<500 kgCO<sub>2</sub> for A3 stage) and high recycled material content (>30%). The recycled material content is determined following guidelines in ISO 14021 whereas the CO<sub>2</sub> emissions threshold is derived from the third party verified country or regional specific database of the Global Cement and Concrete Association (GCCA), former Cement Sustainability Initiative (CSI).

## Manufacturer information

Heidelberg Materials Italia Cementi Spa has been the leading company in Italy in the production of cement since 1864. Over one hundred years of history built on people, knowledge and innovation that have enabled the company to become a leading player in the construction material industry from the very beginning. Heidelberg Materials Italia Cementi Spa's widespread presence, rooted in the territory, and the ability of offering innovative, quality products, are at the base of integrated solutions and applications that meet the needs of the cement and concrete market. The industrial structure consists of eight plants for cement production, a plant for special products with a reduced environmental footprint compared to traditional cement and several grinding centres. The production sites have obtained the ISO 14001 environmental certificate and, in some geographical areas, also the CSC Certificate, which certifies the sustainable procurement process along the entire production chain according to the basic principles of Sustainability. The industrial network is complete and integrated, thanks to the remarkable presence in the concrete and aggregates industry with the company Heidelberg Materials Italia Calcestruzzi Spa.

Heidelberg Materials Italia Cementi Spa, alongside Heidelberg Materials Italia Calcestruzzi Spa, offers a wide range of products, applications, and solutions, from cement to ready-mixed concrete. The category of traditional cements consists of products suitable for specific construction types: road and

marine infrastructures, civil and industrial floorings, dams, extraction wells and the most common applications for the construction sectors. Alongside traditional cement, Heidelberg Materials Italia Cementi Spa also offers a range of solutions for the renovation of buildings, with binders, natural lime, mortar and leveling compounds, products that stand out for their quality, durability, and ease of application. Additionally, there is a range of eco.build products on offer meeting the growing market demand for solutions oriented to environmental sustainability and promoting the circular economy.

Heidelberg Materials Italia Cementi Spa is a founding member of the Italian Green Building Council, the association that promotes the dissemination of the principles of the circular economy in the building industry, and is also a partner of the Global Compact, the international organisation that promotes the principles of sustainable development. Now Heidelberg Materials Italia Cementi Spa is part of the Heidelberg Materials, worldwide leader in the industry, with 53,000 employees in over 3,000 production plants in 50 countries in 5 continents. Among the sustainability goals of the Group there is the reduction by 30% of the CO<sub>2</sub> emissions per cement ton within 2025.

Further information on Heidelberg Materials and Heidelberg Materials Italia Cementi Spa can be accessed at the official website <http://www.heidelbergmaterials.com/en> and <http://www.heidelbergmaterials.it>.

## Product description

**ALI CEM GREEN** is manufactured by Heidelberg Materials Italia Cementi Spa in its cement plant situated at Guardiaregia in the South of Italy. The main component of **ALI CEM GREEN** is **ALI PRE GREEN**, a Calcium Sulfoaluminate clinker (CSA). **ALI CEM GREEN** and **ALI PRE GREEN** are highly technological products able to guarantee ultra-high performance in terms of strength and safety. This EPD refers to both **ALI PRE GREEN** and **ALI CEM GREEN** used for rapid setting, high early strength development and shrinkage compensation.

**ALI CEM GREEN** is an effective solution for a wide variety of applications:

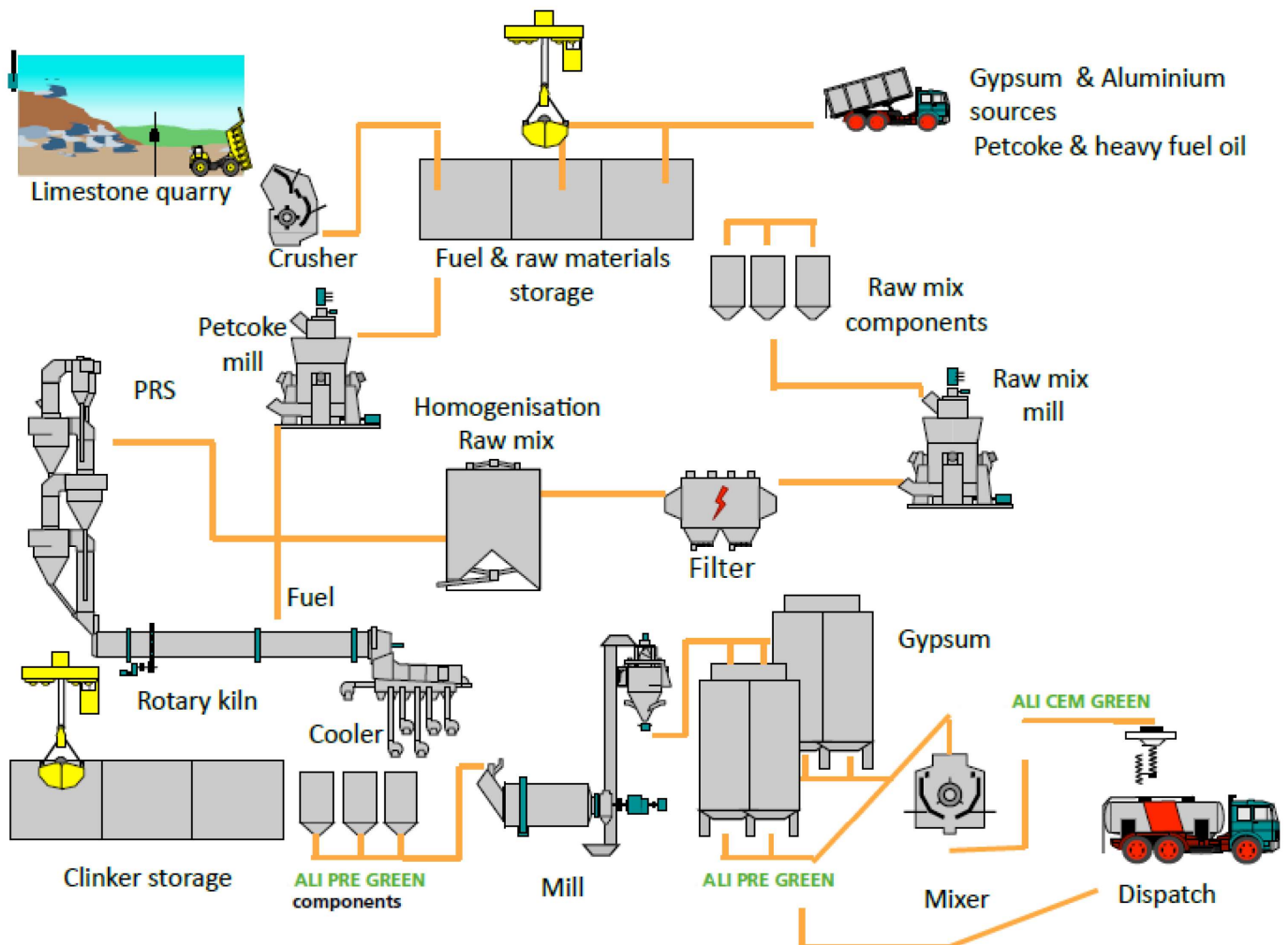
- Adhesives
- Rapid sealants and mortars
- Precasts
- Floor screeds
- Shotcrete
- Waste inertization

In addition **ALI CEM GREEN** is appropriate for products that are exposed to aggressive environments such as acid-resistant coatings.

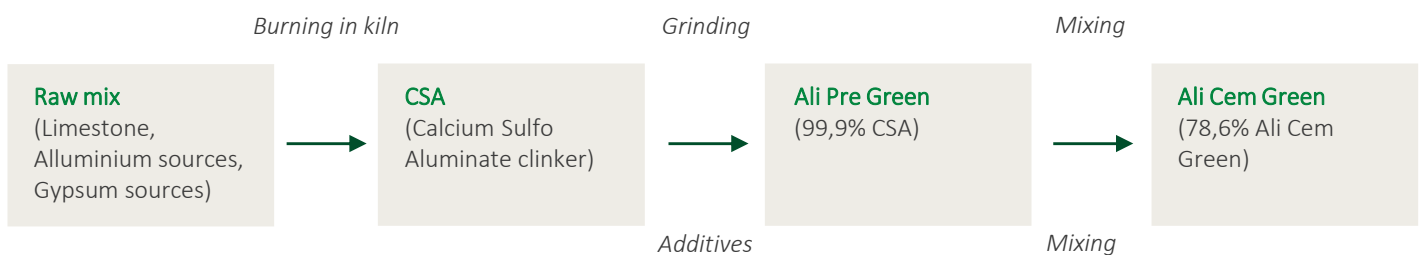
Chemically, **ALI CEM GREEN** is mainly composed of tetracalcium aluminate sulphate and its composition is optimized to confer it the ability to achieve not only high early strength, but also a progressive strength development up to very high values (i.e. 60 MPa at 28 days).

The production process of **ALI CEM GREEN** is similar to the general cement production process. Raw materials are combusted in a kiln producing clinker. In the case of **ALI CEM GREEN**, CSA is produced at reduced kiln temperatures (<1300°C vs 1450°C of portland clinker) due to lower required temperatures for the clinkerization reaction. CSA is ground together with selected additives to produce **ALI PRE GREEN**. The final production step involves the mixing of **ALI PRE GREEN** with gypsum to produce **ALI CEM GREEN**.

# Production process

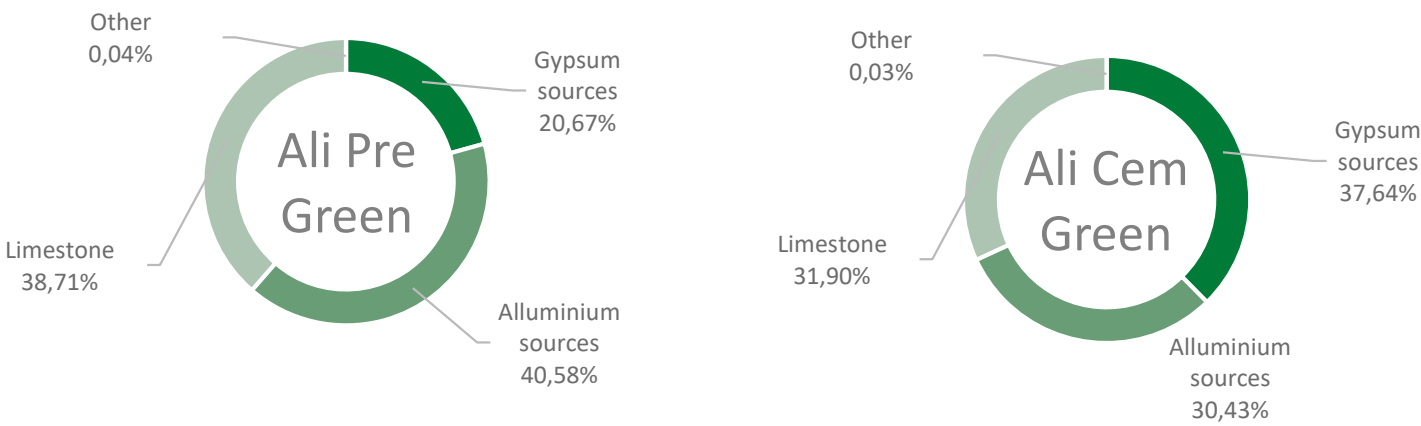


## Main pre-products



The overall composition of the products under study and the energy input involved are provided below. This shows relative percentages of materials and energy sources used in producing **ALI PRE GREEN** and **ALI CEM GREEN**, without considering loss in mass during combustion.

# Product composition



# Energy input (process)

	Diesel (l)	Electrical Energy (kWh)
Ali Pre Green	0.24	70.9
Ali Cem Green	0.19	74.7

**ALI PRE GREEN** and **ALI CEM GREEN** contain a high percentage of recycled materials used as aluminum sources. This particularity implies savings in natural resources and energy which would otherwise have been consumed. The aluminum based recycled materials result from the production of secondary aluminum and as such are classified as pre-consumer recycled materials according to the standard ISO 14021. Following rules set in this standard, the recycled material content of **ALI PRE GREEN** and **ALI CEM GREEN** is at 48.1% and 37.8% respectively.

## EPD type and programme operator

This is an Environmental Product Declaration (EPD) compliant to a Type III environmental declaration as defined by ISO 14025:2006. **ALI CEM GREEN** and **ALI PRE GREEN** are construction products therefore this EPD is compliant to EN 15804:2012+A2:2019. The EPD is subject to the International EPD System (IES) which acts as the Programme Operator and is aligned to the Product Category Rules (PCR) for the assessment of the environmental performance of UN CPC 374 relative to cement (C-PCR-001 “Cement and building lime” (EN 16908) to PCR 2019:14 Construction products, version 1.11). The General Programme Instructions (version 4.0 dated 2021-03-29) of the IES have been implemented. Further information on IES is available on the official website [www.environdec.com](http://www.environdec.com). The EPD refers to a cradle-to-gate boundary so as to meet the following goals:

- Establish third party verified environmental information
- Provide information and data for business-to-business communication

This EPD applies to the production of **ALI PRE GREEN** and **ALI CEM GREEN** in Italy during the year 2022. It results from the life cycle assessment study carried out following the principles contained in the ISO 14040 series of standards.

EPDs within the same product category but from different EPD Programmes shall not be comparable. Moreover, as stated in EN 15804:2012+A2:2019, the comparison of products on the basis of their EPD is defined by the contribution they make to the environmental performance of the building. Consequently, comparison of the environmental performance of construction products using this EPD information shall be based on the product's use in and its impacts on the building and shall consider the complete life cycle of the product within the building or construction works.

# Declaration of environmental parameters derived from LCA

## Scope

Declared unit	1000 kg (1 tonne) ALI PRE GREEN
Declared unit	1000 kg (1 tonne) ALI CEM GREEN
Temporary boundary	Year 2022 production
System boundary	From cradle to gate A1-A3  A1 (Upstream processes) - Raw material and fuel acquisition, Electricity generation & distribution  A2 (Upstream processes) - Transportation to plant.  A3 (Core processes) - Manufacturing processes in plant, treatment waste from manufacturing processes.

The results in terms of environmental impacts, resource use and other environmental information are based on the declared unit.

The LCA model includes a representative inventory of the product system in line with cut-off requirements of the reference PCR. Input materials and energy input to the product system do not contain biogenic carbon, consequently there is no Greenhouse Gas emission from biogenic sources.

The Global Cement and Concrete Association (GCCA) Industry EPD Tool for Cement and Concrete v.4.0 (EPD Tool), pre-verified against requirements of the reference cement PCR, was used in computing Life cycle impacts of **ALI PRE GREEN** and **ALI CEM GREEN**. The Tool applies specific datasets of the cement production process together with representative datasets in Ecoinvent version 3.5 to compute environmental parameters of the product under study.



### Core environmental impact indicators

The following information on core environmental impacts are expressed in terms of impact category parameters using characterization factors. Additional indicators are not declared.

IMPACT CATEGORY PER TON	Unit	ALI PRE GREEN CRADLE TO GATE A1-A3	ALI CEM CRADLE TO GATE A1-A3
<b>GWP-tot</b> (Global Warming Potential total)	kg CO <sub>2</sub> eq.	7.32E+02	6.14E+02
<b>GWP-fos</b> (Global Warming Potential fossil fuels)	kg CO <sub>2</sub> eq.	7.32E+02	6.14E+02
<b>GWP-bio</b> (Global Warming Potential biogenic)	kg CO <sub>2</sub> eq.	1.75E-01	1.67E-01
<b>GWP-luc</b> (Global Warming Potential land use and land use change)	kg CO <sub>2</sub> eq.	1.31E-01	1.26E-01
<b>ODP</b> (Depletion potential of the stratospheric ozone layer)	kg CFC 11 eq.	3.93E-05	3.63E-05
<b>AP</b> (Acidification potential, Accumulated Exceedance)	mol H <sup>+</sup> eq.	2.81E+00	2.41E+00
<b>EP-fw</b> (Eutrophication potential, fraction of nutrients reaching freshwater end compartment)	kg PO <sub>2</sub> eq.	4.96E-02	4.61E-02
<b>EP-mar</b> (Eutrophication potential, fraction of nutrients reaching marine end compartment)	kg N eq.	3.77E-03	3.49E-03
<b>EP-ter</b> (Eutrophication potential, Accumulated Exceedance)	mol N eq.	9.86E+00	8.21E+00
<b>POCP</b> (Formation potential of tropospheric ozone)	kg NMVOC eq.	2.47E+00	2.09E+00
<b>ADPE</b> (Abiotic depletion potential for non- fossil resources)	kg Sb eq.	2.83E-04	2.80E-04
<b>ADPF</b> (Abiotic depletion for fossil resources potential)	MJ, net calorific value	6.10E+03	5.36E+03
<b>WDP</b> (Water (user) deprivation potential, deprivation-weighted water consumption)	m <sup>3</sup> world eq. deprived	3.40E+01	3.11E+01

### Additional environmental impact indicators

IMPACT CATEGORY PER TON	Unit	ALI PRE GREEN CRADLE TO GATE A1-A3	GREEN ALI CEM CRADLE TO GATE A1-A3
<b>GWP-GHG</b> (Global warming potential, GHG)	kg CO2 eq.	7.32E+02	6.14E+02
<b>PM</b> (Potential incidence of disease due to pm emissions)	Disease incidence	ND	ND
<b>IRP</b> (Potential human exposure efficiency relative to U235)	kBq U235 eq.	ND	ND
<b>ETP</b> (Potential comparative toxic unit for ecosystems)	CTUe	ND	ND
<b>HTPC</b> (Potential comparative toxic unit for humans)	CTUh	ND	ND
<b>HTPNC</b> (Potential comparative toxic unit for humans)	CTUh	ND	ND
<b>SQP</b> (Potential soil quality index)	dimensionless	ND	ND

### Parameters describing resource use

The following environmental parameters apply data based on LCI. They describe the use of renewable and non- renewable material resources, renewable and non- renewable primary energy, water use and electricity use during manufacturing.

IMPACT CATEGORY PER TON	Unit	ALI PRE GREEN CRADLE TO GATE A1-A3	GREEN ALI CEM CRADLE TO GATE A1-A3
<b>PERE</b> Use of renewable primary energy excluding renewable primary energy resources used as raw materials	MJ, net calorific value	1.94E+02	1.77E+02
<b>PERM</b> Use of renewable primary energy resources used as raw materials	MJ, net calorific value	0.00	0.00
<b>PERT</b> Total use of renewable primary energy resources	MJ, net calorific value	1.94E+02	1.77E+02
<b>PENRE</b> Use of non-renewable primary energy excluding non- renewable primary energy resources used as raw materials	MJ, net calorific value	6.10E+03	5.36E+03
<b>PENRM</b> Use of non-renewable primary energy resources used as raw materials	MJ, net calorific value	0.00	0.00
<b>PENRT</b> Total use of non-renewable primary energy resources	MJ, net calorific value	6.10E+03	5.36E+03
<b>SM</b> Use of secondary material	kg	5.40E+02	4.24E+02
<b>RSF</b> Use of renewable secondary fuels	MJ, net calorific value	0.00	0.00
<b>NRSF</b> Use of non-renewable secondary fuels	MJ, net calorific value	0.00	0.00
<b>NFW</b> Net use of fresh water	m <sup>3</sup>	1.05E+00	9.65E-01

## Other environmental indicators

The following parameters describe waste categories and other flows derived from LCI.

PRODUCTION PER TON	Unit	ALI PRE GREEN CRADLE TO GATE A1-A3	ALI CEM CRADLE TO GATE A1-A3
Hazardous waste	kg	1.99E-1	1.56E-1
Non-hazardous waste	kg	2.74E0	2.15E0

**Components for re-use, Materials for recycling, Materials for energy recovery, Exported energy and Radioactive waste disposed** are zero for both **ALI PRE GREEN** and **ALI CEM GREEN**.

## Additional information

Guardiaregia plant, certified according to ISO 14001:2015 and ISO 9001:2015, covers a total surface area of 96700 m<sup>2</sup> and has been in operation for 60 years. The quarry supplying limestone for production activities is at 4 km from the plant and has a surface area of 425.730 m<sup>2</sup>. Safety data sheets of **ALI PRE GREEN** and **ALI CEM GREEN** provide information on proper handling of these products. They are intended for use by professionals and enable them to take necessary measures as regards health, safety and environment at worksites.

Safety data sheets and other technical documents of **ALI CEM GREEN** and **ALI PRE GREEN** can be consulted on the Heidelberg Materials Italia website [www.heidelbergmaterials.it](http://www.heidelbergmaterials.it). Product innovation is one of the strategic pillars of **Heidelberg Materials Italia Cementi Spa** and the parent Company, Heidelberg Materials.

Consequently, the production of **ALI PRE GREEN** and **ALI CEM GREEN** is in line with Group Sustainability Commitments 2030 advocating product design suitable for energy efficiency in buildings, sustainable construction and optimizing the use of recycled materials. Moreover, new clinker, cements or binders alternative to Ordinary Portland Cement are under development. In particular, research focuses on the use of renewable and reusable raw materials and the development of specialty admixtures and special additions for concrete, also through investigations and experiments based on nano and biotechnologies applied to the construction materials sector. More information on Sustainability can be accessed at the official website. [heidelbergmaterials.com/en/sustainability](http://heidelbergmaterials.com/en/sustainability)


## Changes versus previous version

This release takes onboard the variations and the updates of the reference documents which occurred in recent years; the biggest variation is related to the implementation of the Amendment 2 of the EN 15804:2012, released in 2019 and to the new version of GCCA EPD Tool v.4.0. Despite there are no relevant changes in the production process and in the mix of fuels and raw materials used, this version includes the core (and additional) environmental impact indicators defined by the amended standard.



## References

- ISO 14025:2010- Environmental labels and declarations - Type III environmental declarations
- ISO 14040:2021- Environmental management - Life cycle assessment - Principles and Framework
- ISO 14044:2021 - Environmental management - Life cycle assessment - Requirements and Guidelines
- ISO 14021:2016 - Environmental labels and declarations – Self-declared environmental claims (Type II Environmental labelling)
- GPI General Programme Instructions of IES [www.environdec.com](http://www.environdec.com) (v 4.0)
- EN 15804:2012 + A2:2019/AC:2021 - Sustainability of construction works - Environmental product declarations Core rules for the product category of construction products
- PCR for cement - [www.environdec.com](http://www.environdec.com) PRODUCT CATEGORY RULES (PCR) for Product Group “Cement”, CPC 374, C-PCR-001 “Cement and building lime” (EN 16908) to PCR 2019:14 Construction products, version 1.2.5

# Demostration of verification

Programme:	<div>EPD®</div> <div>The international EPD® System</div>
PCR	UN CPC 374 - C-PCR-001 "Cement and building lime" (EN 16908) v. 2019-12-20 to PCR 2019:14 "Construction Products" v.1.2.5
PCR Moderator	Martin Erlandson, IVL Swedish Environmental Research Institute, martin.erlandson@ivl.se
PCR Comitee	IVL Swedish Environmental Research Institute Secretariat of the International EPD® System
Independent verification of the declaration and data, according to ISO 14025:2010	<div><input checked="" type="checkbox"/> EPD Process Certification (Internal)</div> <div><input type="checkbox"/> EPD Verification (External)</div>
EPD Registration No.	S-P-00404
Date of Certification	2013/02/22
Version date	2023/10/30
Validity	2024/06/07
Third part Independent Verifier:	Certiquality Srl (Number of accreditation: 003H rev.17)
Accredited by:	Accredia

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## Glossary

<i>Ozone layer depletion 20a</i>	<i>Destrattive effects on the stratospheric ozone layer over a time horizon of 20 years.</i>
<i>Acidification</i>	<i>Increase of soil and water acidity.</i>
<i>Eutrophication</i>	<i>Excessive levels of macronutrients in the environment caused by emissions of nutrients to air, water and soil.</i>
<i>Photochemical oxidation</i>	<i>Oxidizing of volatile compounds in the presence of nitrogen oxides (NOx) which frees ozone in the low atmosphere.</i>
<i>Abiotic depletion</i>	<i>Extraction of minerals and fossil fuels due to inputs in the system.</i>

