



# ViroDecs™ Special

*Holcim Australia Ready-Mix Concrete*

*Queensland – Brisbane – ECOPact Range*

*Environmental Product Declaration*

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

Programme: The International EPD® System | [www.environdec.com](http://www.environdec.com)

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Version Number	Reversion Date	Description of Changes
4.0	24 April 2024	Additional mixes added.

# Introduction

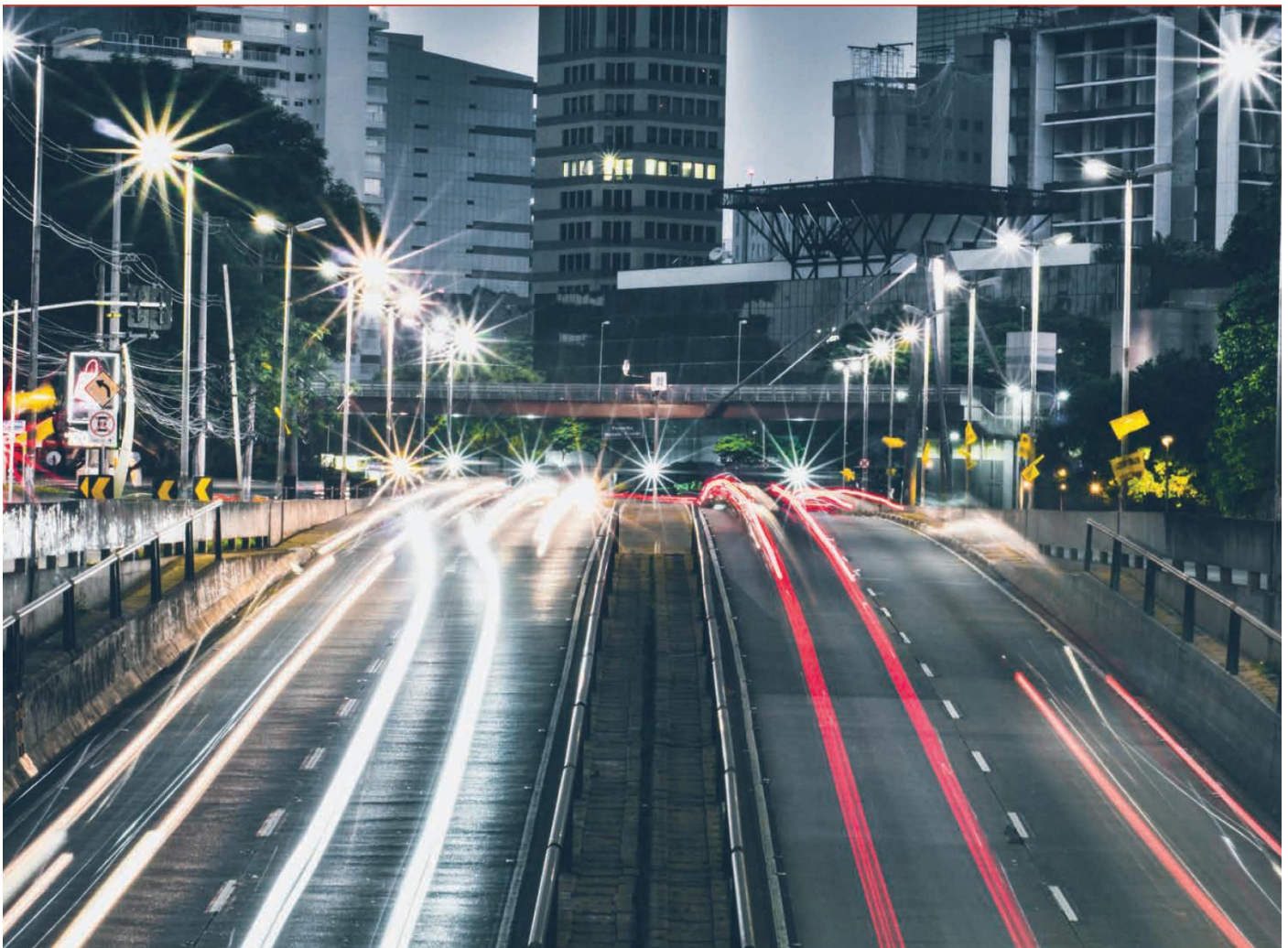
All around the world, the expectation for Governments and organisations to provide enhanced transparency and disclosure of environmental impacts, such as greenhouse gas (GHG) emissions, has been growing. This follows the landmark COP 21 Paris Agreement in 2015 in which all nations agreed to ambitiously pursue efforts to combat climate change and its effects.

At the same time, the global demand for construction materials is also growing due to worldwide population growth and an increase in urbanisation. In fact, concrete is the second most used commodity in the world behind water, and typically a major contributor to the embodied GHG emissions of an infrastructure or property asset.

This clearly demonstrates both the essential need for construction materials now and in the future, as well as the necessity for the construction materials industry to be a leading part of the solution addressing climate change.

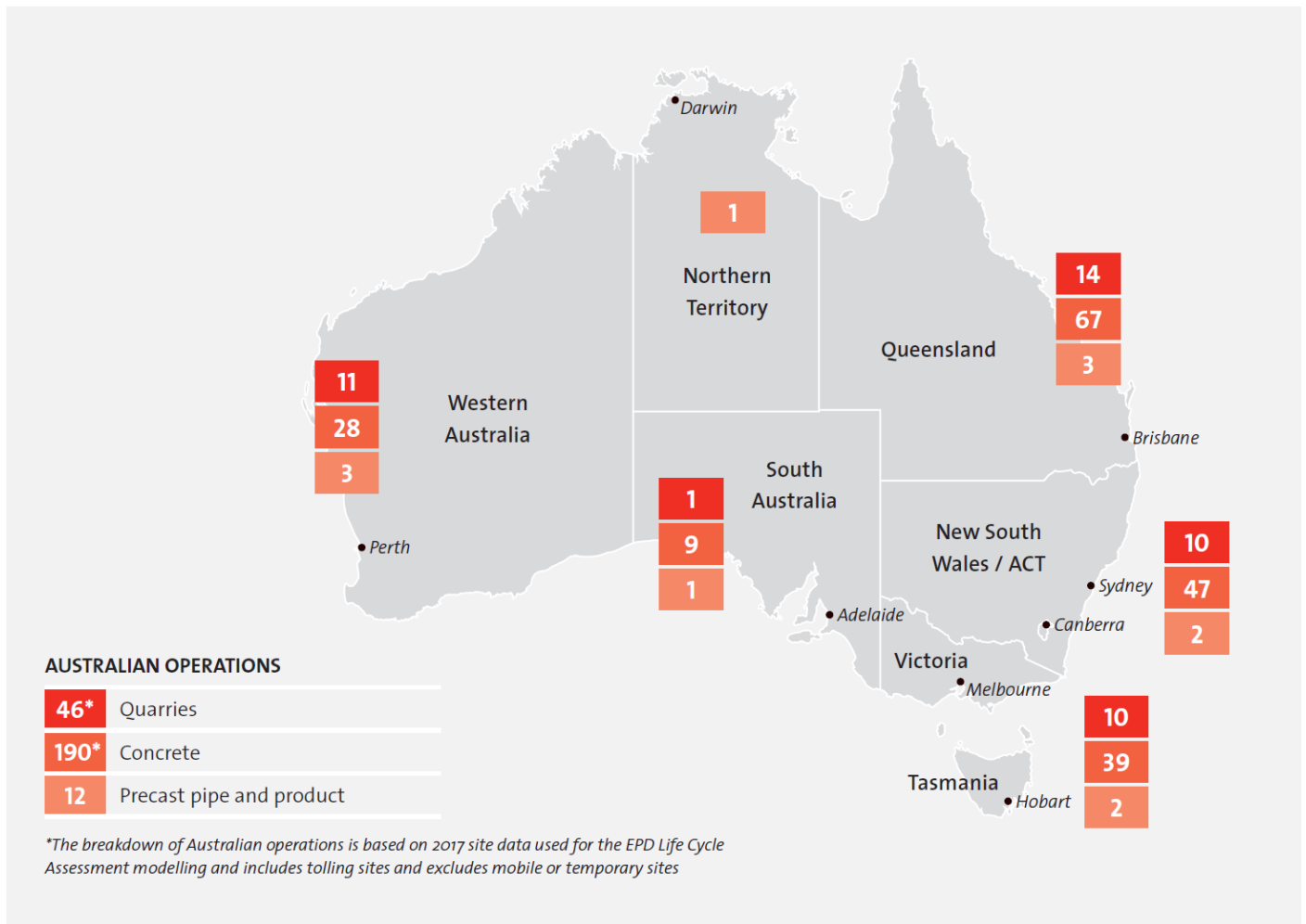
At Holcim, we recognise our responsibility to contribute to global emissions reduction targets and we have developed a roadmap with a number of actions to direct our efforts.

Our ViroDecs™ range of ready-mix concrete represented by an Environmental Product Declaration (EPD) is one such initiative for Holcim in Australia.





# About Holcim



## About Holcim

Holcim Australia is a leading supplier of construction materials in Australia, dating back to 1901. Today Holcim continues to supply essential construction materials including aggregates, sand, ready-mix concrete, engineered precast concrete and prestressed concrete solutions to a range of customers and projects throughout Australia.

Holcim operates right across the Australian continent supplying concrete from a network of concrete plants, quarries, precast and concrete pipe places, and mobile and on-site project facilities.

Sustainability is at the core of our strategy, with our industry's first 2050 net-zero targets, endorsed by the Science Based Targets initiative (SBTi).

Globally, Holcim is 70,000 people around the world who are passionate about building progress for people and the planet through four business segments: Cement, Ready-Mix Concrete, Aggregates and Solutions & Products.

Holcim builds progress for people and the planet. As a global leader in innovative and sustainable building solutions, Holcim is enabling greener cities, smarter infrastructure and improving living standards around the world. With sustainability at the core of its strategy Holcim is becoming a net zero company, with its people and communities at the heart of its success. The company is driving circular construction as a world leader in recycling to build more with less.

# ViroDecs™ Special – a first for ready-mix concrete in Australia

## ViroDecs™ Special at a glance

The Holcim ViroDecs™ Special provides project-specific, on-demand Environmental Product Declarations (EPDs) to Holcim's customers. This capability represents a significant step in Holcim's sustainability journey and embodies our multi-disciplinary approach to embedding sustainability into our organisation and operations. With the introduction of our ViroDecs™ Special, third-party verified data will underpin our capability to work with our customers from tender through to design and construction to optimise ready-mix concrete mix designs and report on sustainability performance.

The publication of the original ViroDecs™ EPD in 2019 introduced quality, third-party verified embodied life cycle impact data for ready-mix concrete into the Australian market for the first time. Holcim has been pleased by the positive response from the industry. The message was loud and clear: "we want transparency and we want an evidence-based approach to specification, procurement and reporting". With the introduction of our ViroDecs™ Special, Holcim's customers can now specify concrete sustainability performance in terms of CO<sub>2</sub>-e, with the confidence that our claims are backed by our third-party verified EPD Process Certification.

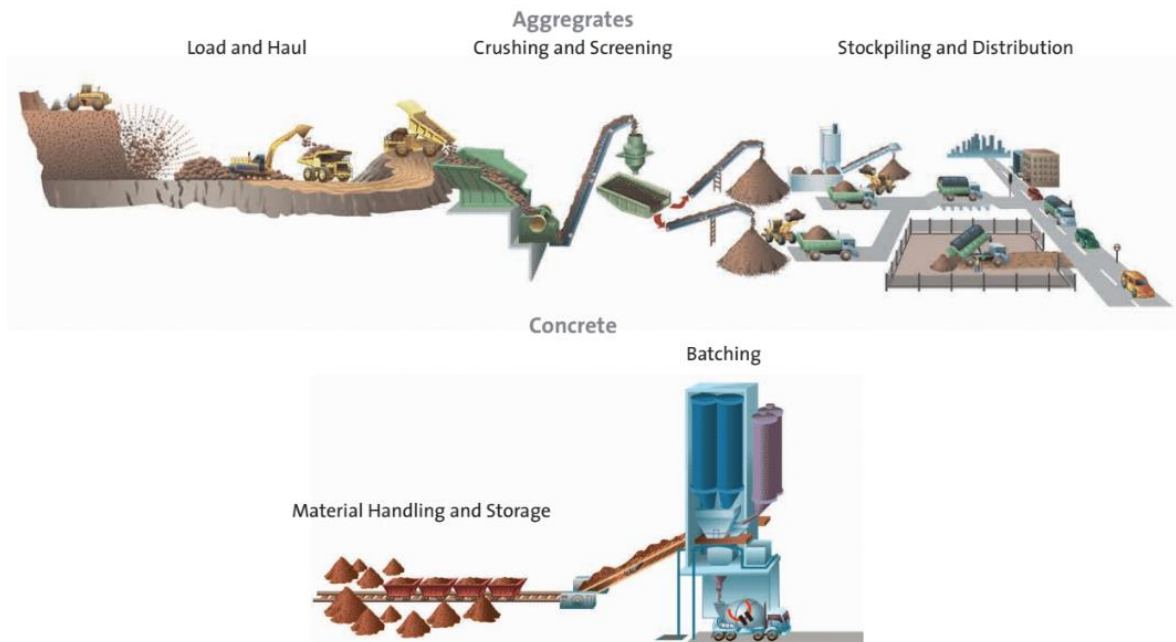
Holcim ViroDecs™ Special is backed by an EPD Process Certification. It's not only a first for concrete but a first for any product in Australia. Our EPD Process Certification is a stamp of approval to produce compliant EPDs in-house, opening up significant capability and flexibility in producing and using life cycle impact data to inform our operations and our customers.

To gain our EPD Process Certification, Holcim invested in embedding Life Cycle Assessment (LCA) into our systems and processes. We have satisfied a rigorous, third-party evaluation in accordance with the relevant ISO standards and guidelines of the International EPD Programme and EPD Australasia.

This EPD has been developed using our EPD Process Certification for Brisbane ECOPact Range with production occurring at Brisbane regional sites.



# Ready-mix concrete



## Summary of properties and classes

Concrete is prepared by mixing cement, coarse and fine aggregates, and water, with or without the addition of auxiliary agents and additives. The fresh concrete is placed on the building site or prefabricated in factory moulds, compacted and hardened in the desired shape by the hydration of cement to form concrete.

General Australian Standard AS 1379 sets down a number of different ways of specifying and ordering concrete to promote uniformity, efficiency and economy in production and delivery. It refers to two classes of concrete: normal-class and special-class.

- **Normal-class** – designed for residential applications, low rise buildings, paving and driveways etc. Its specification and ordering have been simplified as far as practicable.
- **Special-class** – allows the purchaser to incorporate into the project specification any special requirements for the project. Special-class concrete is typically supplied to major and high-end construction projects from high rise buildings, dams and spillways, roads and bridges to public works infrastructure etc. Special-class concrete is typically specified in accordance with the technical parameters and performance requirements, which can include high-strength/high-performances concrete, high durability or marine application, post-tensioned, high-pumpability, super workable, piling concrete, architectural off-form finishes and other decorative applications.



# LCA Information

## Declared Unit

1 m<sup>3</sup> of ready-mix concrete.

## Reference Service Life (RSL)

The RSL is not specified as the scope is from cradle to gate.

## Time Representativeness

The plant data for the LCA is based on 2017 calendar year production data. The mix data for the LCA is based on 2024 calendar year production data.

## Databases and LCA Software Used

SimaPro® LCA software (v 9.1) was used for the LCA modelling which developed the LCA Calculator, used as per the certified EPD Process. It uses background data from:

1. The Australian National Life Cycle Inventory Database (AusLCI) (2018)
2. Ecoinvent 3.6 (2019)
3. Global Cement and Concrete (GCCA) EPD Tool Project Database version 3.1 (International Version) (2021); and
4. Product specific EPDs for pigments and fibres.

The environmental impacts modelled from the existing EPDs do not include impacts for the additional Green Star (v1.2) impact categories included in the environmental impact tables. The following impact categories were calculated manually for the foreground data:

- Use of renewable primary energy resources used as raw materials
- Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials
- Use of secondary material
- Use of renewable secondary fuels
- Use of non-renewable secondary fuels

## Allocation

Allocation was necessary to proportion inputs and outputs to intermediate flows at the quarry and processes at the batching plant level.

As much as possible, intermediate flows were allocated physically based on weight (quarries) or based on m<sup>2</sup> of concrete (at the batching plant). At the quarry level, whenever physical allocation was not possible, economic allocation was carried out based on Holcim's internal cost system.

Regarding inputs, it was assumed that fly ash and silica fumes are waste products and therefore burden-free. Ground granulated blast furnace slag from steel blast furnace production was allocated economically. Please refer to the "Recycled Material" section for further detail.

## Cut-Off Criteria

No flows were excluded on the basis of cut-off criteria.

## Address and Contact Information

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 Phone: +61 2 9412 6600

## Data Quality

Data quality for the foreground data was assessed in terms of geographic and temporal representativeness. All data sources were scored medium or higher.

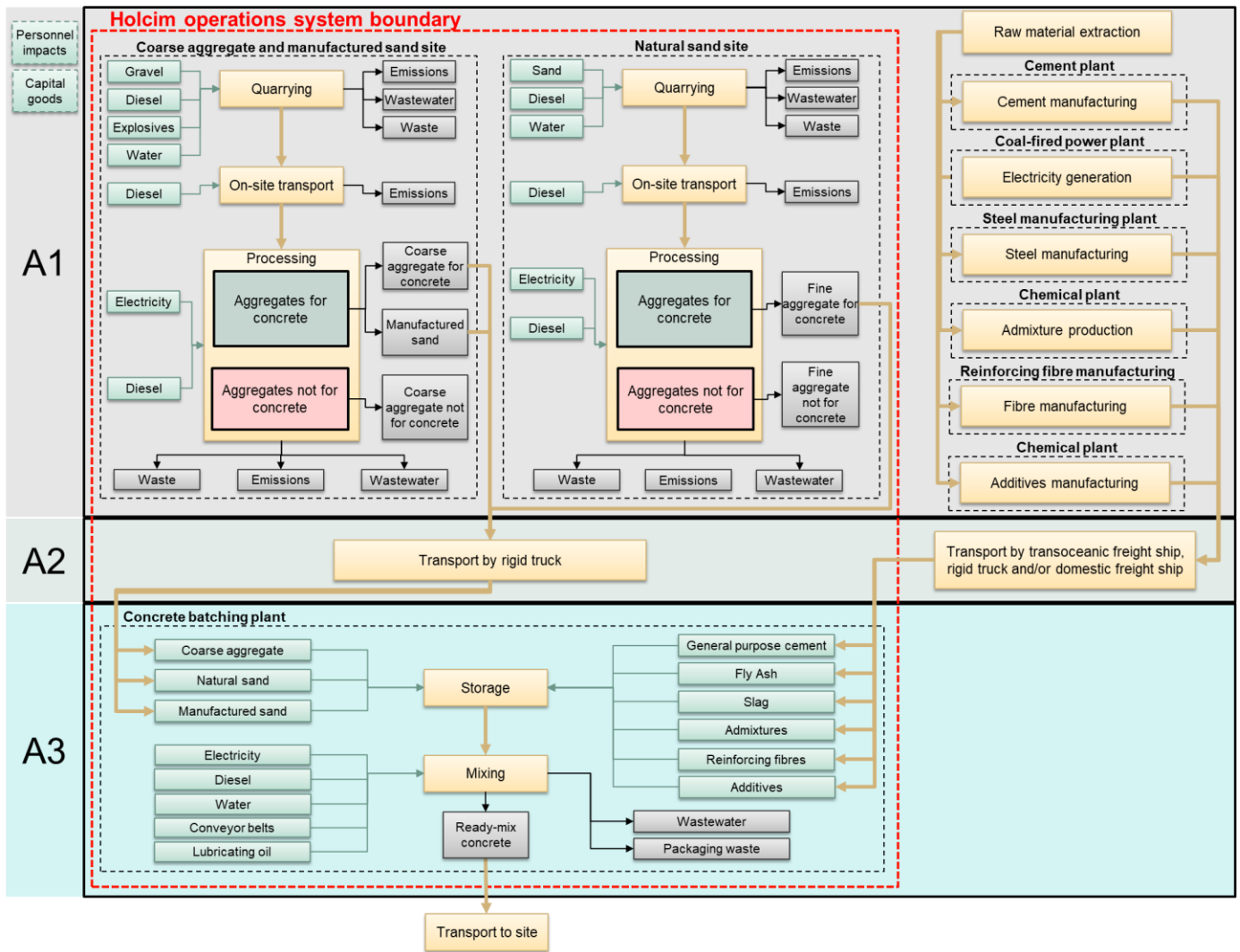
Module	Input/outputs	Sub-processes	Data source	Temporal scope	Geographic scope	Quality
A1	Coarse aggregate Manufactured sand Fine aggregate	Electricity	Electricity provider invoices	2017	All states	High
		Diesel	Supplier invoices	2017	All states	High
		Pollutants	National Pollution Inventory (NPI) data	2017	All states	High
		Mains water	Water utility invoices	2017	All states barring NSW	Medium
		Water – other sources (lakes, groundwater, rainwater)	Metered withdrawal data	2017	All states barring NSW	Medium
		Water discharge from site	Measured site data	2017	All states barring NSW	Medium
		Explosives (Manufactured sand and Coarse aggregate only)	Invoices	2017	All states (excluding the Kalgoorlie Quarry in WA which purchases raw feed from an external source)	High
		Gravel	Calculated – spoil + production amount	2017	All states	High
		Spoil	Holcim waste records	2017	All states	High
A2	Aggregate transport	Background data used to model	Actual transport distances and loads per trip	2017	All states (excluding Lynwood Quarry which transports by freight rail)	High
A3	Concrete batching plant	Electricity	Electricity provider invoices	2017	All states	High
		Diesel	Supplier invoices	2017	All states	High
		Mains water	Water metres, with utility invoices as a back-up	2017	All states	High
		Water – other sources (lakes, groundwater, rainwater)	Estimate based on water balance	2017	All states	Medium
		Water discharge from site	Estimate based on Holcim site performance metrics	2017	All states	Medium
		Lubricating oil Conveyor belt	AusLCI concrete process	2015	National	Medium
	Concrete mix designs	Background data used to model	Holcim internal technical database containing mix designs	2017	All states	High
Packaging waste	Background data used to model	Estimate based on researched packaging material and sizes	N/A	N/A	Medium	

Background data sources were also assessed with respect to their timeliness, with all data sources being updated within the 10 years required under PCR 2019:14 version 1.11.



# System Diagram

The processes included in the LCA are presented in a process diagram in the figure below.



## Description of System Boundaries and Excluded Lifecycle Stages

The scope of the LCA and EPD is from cradle to gate. Life cycle stages beyond Holcim's gate are excluded from the LCA (see figure below).

Environmental impacts relating to personnel, infrastructure and production equipment not directly consumed in the process are excluded from the system boundary as per the Product Category Rules (2019:14 Construction Production version 1.11).

Product Stage			Construction Stage		Use Stage							End of Life Stage				Benefits & loads for the next product system
Raw Material Supply	Transport	Manufacturing	Transport	Construction/installation process	Use	Maintenance incl. transport	Repair incl. transport	Replacement incl. transport	Refurbishment incl. transport	Operational Energy Use	Operational Water Use	De-construction & demolition	Transport	Re-use recycling	Final Disposal	Reuse, Recovery Recycling potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND

\*Module not declared (MND)

# EPD Product Description and Use

## ViroDecs™ Ready-mix concrete Queensland – Brisbane – ECOPact Range

A detailed breakdown of the functional properties of the ready-mix concrete included in this EPD are provided below. Product environmental information should only be compared with consideration of the product's requisite function.

Strength (MPa)	Mix code	Description of use	Strength (MPa)	Mix code	Description of use
20	QE203EBMX / EE203EBMX	S20/3/200 ECOPact Blockmix	40	QE402LPN2 / EE402LPN2	S40/20/120 ECOPact Penetron Concrete
25	QE253EBMX / EE253EBMX	S25/3/200 ECOPact Blockmix	50	QE502LPN2 / EE502LPN2	S50/20/120 ECOPact Penetron Concrete
32	QE323EBMX / EE323EBMX	S32/3/200 ECOPact Blockmix	32	QE327ETOP / EE327ETOP	S32/7/80 ECOPact Topping Concrete
20	QE207EBMX / EE207EBMX	S20/7/200 ECOPact Blockmix	32	QE327LSPR / EE327LSPR	S32/7/70 ECOPact Super Spray Concrete
25	QE257EBMX / EE257EBMX	S25/7/200 ECOPact Blockmix	40	QE407LSPR / EE407LSPR	S40/7/70 ECOPact Super Spray Concrete
32	QE327EBMX / EE327EBMX	S32/7/200 ECOPact Blockmix	32	QE322L652 / EE322L652	S32/20/120 ECOPact 650 Nominal Shrinkage Concrete
40	QE407EBMX / EE407EBMX	S40/7/200 ECOPact Blockmix	40	QE402L652 / EE402L652	S40/20/120 ECOPact 650 Nominal Shrinkage Concrete
50	QE507EBMX / EE507EBMX	S50/7/200 ECOPact Blockmix	65	QE651E200 / EE651E200	S65/10/200 ECOPact Concrete
20	QE202E / EE202E	S20/20/80 ECOPact Concrete	80	QE801E200 / EE801E200	S80/10/200 ECOPact Concrete
25	QE252E / EE252E	S25/20/80 ECOPact Concrete	65	QE651EDUF / EE651EDUF	S65/10/650 ECOPact UltraFlow Concrete
32	QE322E / EE322E	S32/20/80 ECOPact Concrete	80	QE801EDUF / EE801EDUF	S80/10/650 ECOPact UltraFlow Concrete
40	QE402E / EE402E	S40/20/80 ECOPact Concrete	40	QE401LMO1 / EE401LMO1	S40/10/100 Mosaic ECOPact Concrete
50	QE502E / EE502E	S50/20/80 ECOPact Concrete	40	QE402LMO1 / EE402LMO1	S40/20/100 Mosaic ECOPact Concrete
20	QE201E100 / EE201E100	S20/10/100 ECOPact Concrete	32	QE322EXT1 / EE322EXT1	S32/20/100 ECOPact Concrete
25	QE251E100 / EE251E100	S25/10/100 ECOPact Concrete	40	QE402EBR1 / EE402EBR1	S40/20/100 ECOPact Concrete
32	QE321E100 / EE321E100	S32/10/100 ECOPact Concrete	40	QE402EBR2 / EE402EBR2	S40/20/120 ECOPact Concrete
40	QE401E100 / EE401E100	S40/10/100 ECOPact Concrete	40	QE401ECFA / EE401ECFA	S40/10/600 ECOPact Concrete
50	QE501E100 / EE501E100	S50/10/100 ECOPact Concrete	40	QE401ELCF / EE401ELCF	S40/10/600 ECOPact Concrete
20	QE202E100 / EE202E100	S20/20/100 ECOPact Concrete	50	QE501ECFA / EE501ECFA	S50/10/600 ECOPact Concrete
25	QE252E100 / EE252E100	S25/20/100 ECOPact Concrete	50	QE501ELCF / EE501ELCF	S50/10/600 ECOPact Concrete
32	QE322E100 / EE322E100	S32/20/100 ECOPact Concrete	65	QE651ECFA / EE651ECFA	S65/10/600 ECOPact Concrete
40	QE402E100 / EE402E100	S40/20/100 ECOPact Concrete	65	QE651ELCF / EE651ELCF	S65/10/600 ECOPact Concrete
50	QE502E100 / EE502E100	S50/20/100 ECOPact Concrete	50	QE502MRF4 / EE502MRF4	S50/20/180 ECOPact Fibre Concrete
20	QE201EEZY / EE201EEZY	S20/10/120 ECOPact 2EZY Concrete	25	QE252ESF / EE252ESF	S25/20/80 ECOPact Steel Fibre Concrete
25	QE251EEZY / EE251EEZY	S25/10/120 ECOPact 2EZY Concrete	25	QE252ESF1 / EE252SF1	S25/20/100 ECOPact Steel Fibre Concrete



Strength (MPa)	Mix code	Description of use	Strength (MPa)	Mix code	Description of use
32	QE321EEZY / EE321EEZY	S32/10/120 ECOPact 2EZY Concrete	32	QE322ESF / EE322ESF	S25/20/80 ECOPact Steel Fibre Concrete
40	QE401EEZY / EE401EEZY	S40/10/120 ECOPact 2EZY Concrete	32	QE322ESF1 / EE322ESF1	S25/20/100 ECOPact Steel Fibre Concrete
50	QE501EEZY / EE501EEZY	S50/10/120 ECOPact 2EZY Concrete	40	QE402EBF1 / EE402EBF1	S40/20/110 ECOPact Steel Fibre Concrete
20	QE202EEZY / EE202EEZY	S20/20/120 ECOPact 2EZY Concrete	40	QE402EBF2 / EE402EBF2	S40/20/120 ECOPact Steel Fibre Concrete
25	QE252EEZY / EE252EEZY	S25/20/120 ECOPact 2EZY Concrete	40	QE402EXT1 / EE402EXT1	S40/20/100 ECOPact Concrete
32	QE322EEZY / EE322EEZY	S32/20/120 ECOPact 2EZY Concrete	65	QE652E160 / EE652E160	S65/20/160 ECOPact Concrete
40	QE402EEZY / EE402EEZY	S40/20/120 ECOPact 2EZY Concrete	65	QE651E160 / EE651E160	S65/10/160 ECOPact Concrete
50	QE502EEZY / EE502EEZY	S50/20/120 ECOPact 2EZY Concrete	25	QE252EHF / EE252EHF	S25/20/80 ECOPact High Fibre Concrete
20	QE201EL21 / EE201EL21	S20/10/100 ECOPact 2 Inch Line Concrete	25	QE252EHF1 / EE252EHF1	S25/20/100 ECOPact High Fibre Concrete
25	QE251EL21 / EE251EL21	S25/10/100 ECOPact 2 Inch Line Concrete	32	QE322EHF / EE322EHF	S32/20/80 ECOPact High Fibre Concrete
32	QE321EL21 / EE321EL21	S32/10/100 ECOPact 2 Inch Line Concrete	32	QE322EHF1 / EE322EHF1	S32/20/100 ECOPact High Fibre Concrete
40	QE401EL21 / EE401EL21	S40/10/100 ECOPact 2 Inch Line Concrete	25	QE252EFB / EE252EFB	S25/20/80 ECOPact Fibre Concrete
50	QE501EL21 / EE501EL21	S50/10/100 ECOPact 2 Inch Line Concrete	25	QE252EFB1 / EE252EFB1	S25/20/100 ECOPact Fibre Concrete
40	QE401E200 / EE401E200	S40/10/200 ECOPact Concrete	32	QE322EFB / EE322EFB	S32/20/80 ECOPact Fibre Concrete
50	QE501E200 / EE501E200	S50/10/200 ECOPact Concrete	32	QE322EFB1 / EE322EFB1	S32/20/100 ECOPact Fibre Concrete
40	QE401EDUF / EE401EDUF	S40/10/600 ECOPact UltraFlow Concrete	25	QE25XDIA / EE25XDIA	S25/10/90 ECOPact Diamantina Concrete
50	QE501EDUF / EE501EDUF	S50/10/620 ECOPact UltraFlow Concrete	40	QE40XDIA / EE40XDIA	S40/10/90 ECOPact Diamantina Concrete
40	QE402PT1 / EE402PT1	S40/20/100 ECOPact PT Concrete	50	QE502LPMR / EE502LPMR	S50/20/680 ECOPact MRTS70 Concrete
40	QE402PT2 / EE402PT2	S40/20/120 ECOPact PT Concrete	32	QE322EMR1 / EE322EMR1	S32/20/100 ECOPact MRTS70 Concrete
40	QE402PT3 / EE402PT3	S40/20/150 ECOPact PT Concrete	55	QE552PL18 / EE552PL18	S55/20/180 ECOPact Piling Concrete
32	QE322LPN2 / EE322LPN2	S32/20/120 ECOPact Penetron Concrete	55	QE552PL20 / EE552PL20	S55/20/200 ECOPact Piling Concrete

Note: Some customer invoices may have a Z as the second character in their mix code (e.g. QZ202E). This indicates that the mix was sold as a carbon neutral ready-mix concrete (i.e. the residual Global Warming Potential was offset). To find the applicable mix code, please substitute the second character in the mix code with an E (e.g. QE202E).

## Content Declaration

The following table provides a summary of the materials included in Holcim ready-mix concrete and their relative composition by weight.

Material	Content
General purpose cement	5-21%
Aggregate	67-84%
Supplementary cementitious materials	0-11%
Water	11.6-12%
Admixtures	0.01-0.02%

Holcim Ready-mix concrete is classified as Non-Dangerous Goods according to the Australian Code for the Transport of Dangerous Goods by Road and Rail. The [safety data sheet for pre-mixed concrete](#) lists all associated hazard phrases.

The gross weight of this declared material makes up a minimum of 99% of the products covered by this EPD.

## Packaging

Holcim ready-mix concrete is delivered in bulk with no packaging.

Default background data from LCA databases was used to model the above co-products:

## Recycled Material

BS EN 16757:2017 specifically lists the following materials relevant to the study as co-products:

- Fly ash;
- Ground granulated blast furnace slag; and
- Silica fume

- Fly ash: AusLCI process for fly ash treats it as a waste material and only includes transport impacts.
- Ground granulated blast furnace slag: the AusLCI process for slag is allocated based on economic value, as the product has a significant economic value at the point of collection.
- Silica fume: the ecoinvent process for silica fume treat it as a waste material and only includes transport impacts.

As such, the above materials are considered as co-products of their production process and the impacts for their production process are allocated according to PCR 2019:14 Construction Products version 1.11 (co-produced goods, multi-output allocation).

The allocation approach of the AusLCI LCA database was adopted as a default for secondary data and processes (e.g. secondary fuel in cement production). The AusLCI dataset conforms to EN 15804 when applying allocation to its various processes and sub-processes.

# Environmental Performance

The environmental impacts considered in this EPD are listed in the table below. All further tables from this point will contain abbreviation only.

Impact Category	Abbreviation	Measurement Unit
<b>Potential Environmental Impacts</b>		
Total global warming potential	GWPT	kg CO <sub>2</sub> equivalents (GWP100)
Global warming potential (fossil)	GWPF	kg CO <sub>2</sub> equivalents (GWP100)
Global warming potential (biogenic)	GWPB	kg CO <sub>2</sub> equivalents (GWP100)
Global warming potential (land use/ land transformation)	GWPL	kg CO <sub>2</sub> equivalents (GWP100)
Ozone depletion potential	ODP	kg CFC 11 equivalents
Acidification potential	AP	mol H <sup>+</sup> eq.
Eutrophication – aquatic freshwater	EP - freshwater	kg PO <sub>4</sub> <sup>3-</sup> equivalents
Eutrophication – aquatic freshwater	EP - freshwater	kg P equivalent
Eutrophication – aquatic marine	EP - marine	kg N equivalent
Eutrophication – terrestrial	EP – terrestrial	mol N equivalent
Photochemical ozone creation potential	POCP	kg NMVOC equivalents
Abiotic depletion potential (elements)	ADPE	kg Sb equivalents
Abiotic depletion potential (fossil fuels)	ADPF	MJ net calorific value
Water Depletion Potential	WDP	m <sup>3</sup> equivalent deprived
<b>Resource use</b>		
Use of renewable primary energy excluding renewable primary energy resources used as raw materials	PERE	MJ, net calorific value
Use of renewable primary energy resources used as raw materials	PERM	MJ, net calorific value
Total use of renewable primary energy resources (primary energy and primary energy resources used as raw materials)	PERT	MJ, net calorific value
Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials	PENRE	MJ, net calorific value
Use of non-renewable primary energy resources used as raw materials	PENRM	MJ, net calorific value
Total use of non-renewable primary energy resources (primary energy and primary energy resources used as raw materials)	PENRT	MJ, net calorific value
Use of secondary material	SM	kg
Use of renewable secondary fuels	RSF	MJ, net calorific value
Use of non-renewable secondary fuels	NRSF	MJ, net calorific value
Use of net fresh water	FW	m <sup>3</sup>



Impact Category	Abbreviation	Measurement Unit
<b>Waste categories and Output flows</b>		
Hazardous waste disposed	HWD	kg
Non-hazardous waste disposed	NHWD	kg
Radioactive waste disposed/stored	RWD	kg
Components for reuse	CFR	kg
Materials for recycling	MFR	kg
Materials for energy recovery	MFEE	kg
Exported energy	EE - e	MJ per energy carrier
Exported energy, thermal	EE - t	MJ per energy carrier
<b>Additional environmental impacts</b>		
Particulate matter	PM	disease incidence
Ionising radiation - human health	IRP	kBq U-235 eq
Eco-toxicity (freshwater)	ETP-fw	CTUe
Human toxicity potential - cancer effects	HTP-c	CTUh
Human toxicity potential - non cancer effects	HTP-nc	CTUh
Soil quality	SQP	dimensionless

## Queensland – Brisbane – ECOPact Range

Primary indicators - 1m<sup>3</sup> of ViroDecs™ ready-mix concrete

PRIMARY ENVIRONMENTAL INDICATORS		GWPT	GWPF	GWPB	GWPL	ODP	AP	EP - freshwater	EP - freshwater2	EP - marine	EP - terrestrial	POCP	ADPE	ADPF	WDP
Strength (MPa)	Mix Code	kg CO2 eq.	kg CO2 eq.	kg CO2 eq.	kg CO2 eq.	kg CFC 11 eq.	mol H+ eq.	kg PO43- eq.	kg P eq.	kg N eq.	mol N eq.	kg NMVOC eq.	kg Sb eq.	MJ	m3
20	QE203EBMX	210	209	0.16	1.08E-03	5.35E-06	1.14E+00	8.31E-01	2.93E-03	3.10E-01	3.49E+00	9.01E-01	1.14E-04	9.59E+02	1.09E+03
25	QE253EBMX	221	221	0.17	1.14E-03	5.57E-06	1.20E+00	8.80E-01	3.09E-03	3.25E-01	3.66E+00	9.44E-01	1.19E-04	1.01E+03	1.15E+03
32	QE323EBMX	258	258	0.20	1.40E-03	6.50E-06	1.40E+00	1.04E+00	4.17E-03	3.73E-01	4.24E+00	1.09E+00	1.35E-04	1.19E+03	1.34E+03
20	QE207EBMX	190	190	0.14	9.54E-04	4.87E-06	1.01E+00	7.60E-01	2.28E-03	2.81E-01	3.14E+00	8.15E-01	1.09E-04	8.62E+02	9.92E+02
25	QE257EBMX	206	206	0.15	1.03E-03	5.23E-06	1.10E+00	8.29E-01	2.46E-03	3.03E-01	3.39E+00	8.80E-01	1.16E-04	9.40E+02	1.08E+03
32	QE327EBMX	229	229	0.17	1.15E-03	5.72E-06	1.23E+00	9.26E-01	2.71E-03	3.35E-01	3.75E+00	9.72E-01	1.26E-04	1.05E+03	1.21E+03
40	QE407EBMX	258	258	0.19	1.42E-03	6.71E-06	1.41E+00	1.04E+00	4.23E-03	3.74E-01	4.25E+00	1.09E+00	1.40E-04	1.21E+03	1.36E+03
50	QE507EBMX	299	299	0.23	1.66E-03	7.54E-06	1.62E+00	1.23E+00	4.98E-03	4.26E-01	4.85E+00	1.24E+00	1.56E-04	1.39E+03	1.57E+03
20	QE202E	151	151	0.10	7.43E-04	4.31E-06	8.46E-01	5.77E-01	1.90E-03	2.35E-01	2.63E+00	6.85E-01	9.48E-05	7.18E+02	8.16E+02
25	QE252E	163	163	0.11	8.06E-04	4.54E-06	9.05E-01	6.30E-01	2.02E-03	2.50E-01	2.80E+00	7.28E-01	9.97E-05	7.69E+02	8.77E+02
32	QE322E	181	181	0.13	8.92E-04	4.90E-06	9.98E-01	7.08E-01	2.12E-03	2.75E-01	3.07E+00	7.99E-01	1.08E-04	8.48E+02	9.72E+02
40	QE402E	219	219	0.16	1.09E-03	5.64E-06	1.19E+00	8.81E-01	2.53E-03	3.25E-01	3.63E+00	9.43E-01	1.24E-04	1.02E+03	1.17E+03
50	QE502E	287	286	0.22	1.45E-03	6.95E-06	1.53E+00	1.18E+00	3.25E-03	4.12E-01	4.62E+00	1.20E+00	1.53E-04	1.31E+03	1.53E+03
20	QE201E100	156	156	0.11	7.69E-04	4.34E-06	8.68E-01	6.02E-01	1.94E-03	2.41E-01	2.69E+00	6.99E-01	9.54E-05	7.36E+02	8.40E+02
25	QE251E100	164	164	0.12	8.15E-04	4.51E-06	9.11E-01	6.41E-01	2.03E-03	2.51E-01	2.81E+00	7.31E-01	9.90E-05	7.73E+02	8.84E+02
32	QE321E100	191	191	0.14	9.48E-04	5.04E-06	1.05E+00	7.58E-01	2.21E-03	2.87E-01	3.21E+00	8.33E-01	1.11E-04	8.89E+02	1.02E+03
40	QE401E100	231	231	0.17	1.16E-03	5.81E-06	1.25E+00	9.38E-01	2.65E-03	3.39E-01	3.79E+00	9.84E-01	1.28E-04	1.07E+03	1.23E+03
50	QE501E100	302	302	0.23	1.53E-03	7.19E-06	1.61E+00	1.26E+00	3.41E-03	4.32E-01	4.83E+00	1.25E+00	1.58E-04	1.38E+03	1.60E+03
20	QE202E100	153	153	0.11	7.56E-04	4.35E-06	8.57E-01	5.88E-01	1.92E-03	2.38E-01	2.66E+00	6.92E-01	9.55E-05	7.28E+02	8.28E+02
25	QE252E100	165	165	0.12	8.19E-04	4.58E-06	9.16E-01	6.42E-01	2.05E-03	2.53E-01	2.83E+00	7.36E-01	1.01E-04	7.80E+02	8.90E+02
32	QE322E100	185	185	0.13	9.19E-04	4.99E-06	1.02E+00	7.31E-01	2.17E-03	2.81E-01	3.14E+00	8.16E-01	1.10E-04	8.70E+02	9.98E+02
40	QE402E100	224	224	0.17	1.12E-03	5.73E-06	1.22E+00	9.04E-01	2.58E-03	3.31E-01	3.70E+00	9.61E-01	1.26E-04	1.04E+03	1.20E+03
50	QE502E100	294	294	0.23	1.49E-03	7.09E-06	1.57E+00	1.22E+00	3.33E-03	4.22E-01	4.72E+00	1.22E+00	1.56E-04	1.35E+03	1.57E+03
20	QE201EEZY	161	161	0.11	7.94E-04	4.43E-06	8.91E-01	6.23E-01	1.99E-03	2.47E-01	2.76E+00	7.17E-01	9.72E-05	7.56E+02	8.63E+02
25	QE251EEZY	175	175	0.13	8.72E-04	4.76E-06	9.69E-01	6.88E-01	2.15E-03	2.66E-01	2.98E+00	7.75E-01	1.04E-04	8.23E+02	9.40E+02
32	QE321EEZY	193	193	0.14	9.61E-04	5.09E-06	1.06E+00	7.70E-01	2.24E-03	2.90E-01	3.24E+00	8.43E-01	1.12E-04	9.00E+02	1.04E+03
40	QE401EEZY	234	234	0.18	1.17E-03	5.84E-06	1.26E+00	9.49E-01	2.67E-03	3.42E-01	3.83E+00	9.93E-01	1.29E-04	1.07E+03	1.25E+03
50	QE501EEZY	307	307	0.24	1.56E-03	7.27E-06	1.63E+00	1.28E+00	3.45E-03	4.38E-01	4.90E+00	1.27E+00	1.60E-04	1.40E+03	1.63E+03
20	QE202EEZY	158	158	0.11	7.80E-04	4.43E-06	8.80E-01	6.09E-01	1.97E-03	2.44E-01	2.73E+00	7.10E-01	9.73E-05	7.47E+02	8.51E+02
25	QE252EEZY	171	171	0.12	8.48E-04	4.72E-06	9.48E-01	6.66E-01	2.11E-03	2.62E-01	2.92E+00	7.61E-01	1.03E-04	8.06E+02	9.19E+02

PRIMARY ENVIRONMENTAL INDICATORS		GWPT	GWPF	GWPB	GWPL	ODP	AP	EP - freshwater	EP - freshwater2	EP - marine	EP - terrestrial	POCP	ADPE	ADPF	WDP
Strength (MPa)	Mix Code	kg CO2 eq.	kg CO2 eq.	kg CO2 eq.	kg CO2 eq.	kg CFC 11 eq.	mol H+ eq.	kg PO43- eq.	kg P eq.	kg N eq.	mol N eq.	kg NMVOC eq.	kg Sb eq.	MJ	m3
32	QE322EEZY	188	188	0.14	9.29E-04	5.02E-06	1.03E+00	7.41E-01	2.19E-03	2.84E-01	3.17E+00	8.24E-01	1.11E-04	8.78E+02	1.01E+03
40	QE402EEZY	227	227	0.17	1.13E-03	5.77E-06	1.23E+00	9.15E-01	2.61E-03	3.34E-01	3.74E+00	9.71E-01	1.27E-04	1.05E+03	1.21E+03
50	QE502EEZY	299	299	0.23	1.52E-03	7.18E-06	1.60E+00	1.24E+00	3.38E-03	4.29E-01	4.80E+00	1.24E+00	1.58E-04	1.37E+03	1.59E+03
20	QE201EL21	160	160	0.11	7.87E-04	4.39E-06	8.86E-01	6.18E-01	1.97E-03	2.45E-01	2.74E+00	7.13E-01	9.64E-05	7.49E+02	8.55E+02
25	QE251EL21	175	175	0.13	8.71E-04	4.74E-06	9.70E-01	6.88E-01	2.14E-03	2.67E-01	2.98E+00	7.76E-01	1.04E-04	8.22E+02	9.39E+02
32	QE321EL21	198	198	0.15	9.80E-04	5.14E-06	1.08E+00	7.87E-01	2.28E-03	2.96E-01	3.31E+00	8.59E-01	1.13E-04	9.16E+02	1.05E+03
40	QE401EL21	239	239	0.18	1.20E-03	5.94E-06	1.29E+00	9.73E-01	2.72E-03	3.50E-01	3.91E+00	1.02E+00	1.31E-04	1.10E+03	1.27E+03
50	QE501EL21	311	310	0.24	1.57E-03	7.32E-06	1.65E+00	1.29E+00	3.48E-03	4.42E-01	4.96E+00	1.28E+00	1.61E-04	1.41E+03	1.65E+03
40	QE401E200	233	233	0.18	1.97E-03	6.14E-06	1.28E+00	9.38E-01	4.39E-03	3.41E-01	3.87E+00	9.94E-01	1.34E-04	1.10E+03	1.23E+03
50	QE501E200	336	336	0.24	2.37E-03	7.20E-06	1.63E+00	1.24E+00	5.83E-03	4.52E-01	5.16E+00	1.31E+00	1.70E-04	1.39E+03	1.62E+03
40	QE401EDUF	253	253	0.19	2.15E-03	6.72E-06	1.39E+00	1.02E+00	5.42E-03	3.66E-01	4.20E+00	1.07E+00	1.42E-04	1.20E+03	1.33E+03
50	QE501EDUF	280	280	0.21	2.31E-03	7.28E-06	1.53E+00	1.14E+00	5.93E-03	4.00E-01	4.59E+00	1.17E+00	1.53E-04	1.32E+03	1.47E+03
40	QE402PT1	293	293	0.19	1.11E-03	5.38E-06	1.29E+00	9.23E-01	3.05E-03	3.88E-01	4.36E+00	1.11E+00	1.44E-04	1.07E+03	1.32E+03
40	QE402PT2	293	293	0.19	1.13E-03	5.36E-06	1.29E+00	9.24E-01	3.04E-03	3.88E-01	4.35E+00	1.11E+00	1.44E-04	1.07E+03	1.32E+03
40	QE402PT3	294	294	0.19	1.16E-03	5.48E-06	1.30E+00	9.24E-01	3.41E-03	3.89E-01	4.38E+00	1.11E+00	1.44E-04	1.08E+03	1.32E+03
32	QE322LPN2	262	261	0.16	1.06E-03	4.58E-06	1.06E+00	8.11E-01	3.46E-03	3.35E-01	3.77E+00	9.55E-01	1.29E-04	8.80E+02	1.08E+03
40	QE402LPN2	290	289	0.18	1.18E-03	4.90E-06	1.16E+00	9.05E-01	3.82E-03	3.66E-01	4.12E+00	1.04E+00	1.39E-04	9.64E+02	1.19E+03
50	QE502LPN2	398	398	0.26	1.64E-03	6.13E-06	1.54E+00	1.27E+00	5.21E-03	4.87E-01	5.48E+00	1.38E+00	1.79E-04	1.29E+03	1.62E+03
32	QE327ETOP	255	255	0.17	1.08E-03	5.21E-06	1.19E+00	8.79E-01	2.72E-03	3.50E-01	3.92E+00	1.00E+00	1.31E-04	9.94E+02	1.20E+03
32	QE327LSPR	274	273	0.65	1.08E-03	4.47E-06	1.09E+00	8.60E-01	2.79E-03	3.47E-01	3.89E+00	9.92E-01	1.32E-04	9.03E+02	1.13E+03
40	QE407LSPR	322	322	0.69	1.27E-03	5.01E-06	1.26E+00	1.03E+00	3.23E-03	4.01E-01	4.51E+00	1.15E+00	1.50E-04	1.05E+03	1.32E+03
32	QE322L652	236	235	0.15	9.03E-04	4.07E-06	9.55E-01	7.29E-01	2.41E-03	3.05E-01	3.42E+00	8.69E-01	1.18E-04	7.89E+02	9.84E+02
40	QE402L652	287	287	0.18	1.10E-03	4.61E-06	1.14E+00	9.05E-01	2.89E-03	3.62E-01	4.07E+00	1.03E+00	1.37E-04	9.42E+02	1.19E+03
65	QE651E200	353	353	0.26	2.46E-03	7.50E-06	1.71E+00	1.31E+00	6.13E-03	4.74E-01	5.40E+00	1.37E+00	1.77E-04	1.46E+03	1.70E+03
80	QE801E200	419	419	0.31	2.81E-03	8.73E-06	2.02E+00	1.57E+00	7.33E-03	5.55E-01	6.35E+00	1.61E+00	2.05E-04	1.72E+03	2.01E+03
65	QE651EDUF	355	355	0.26	2.54E-03	7.74E-06	1.73E+00	1.31E+00	6.93E-03	4.75E-01	5.46E+00	1.38E+00	1.77E-04	1.48E+03	1.70E+03
80	QE801EDUF	421	421	0.31	2.91E-03	9.02E-06	2.04E+00	1.57E+00	8.29E-03	5.57E-01	6.42E+00	1.62E+00	2.05E-04	1.75E+03	2.01E+03
40	QE401LMO1	310	310	0.20	1.15E-03	4.79E-06	1.22E+00	9.42E-01	3.09E-03	3.88E-01	4.36E+00	1.10E+00	1.45E-04	1.00E+03	1.28E+03
40	QE402LMO1	301	301	0.19	1.11E-03	4.74E-06	1.19E+00	9.11E-01	3.02E-03	3.79E-01	4.26E+00	1.08E+00	1.42E-04	9.80E+02	1.24E+03
32	QE322EXT1	240	240	0.15	9.24E-04	4.65E-06	1.07E+00	7.45E-01	2.53E-03	3.25E-01	3.64E+00	9.29E-01	1.23E-04	8.90E+02	1.09E+03
40	QE402EBR1	297	296	0.19	1.15E-03	5.38E-06	1.30E+00	9.36E-01	3.08E-03	3.91E-01	4.39E+00	1.12E+00	1.44E-04	1.08E+03	1.34E+03



PRIMARY ENVIRONMENTAL INDICATORS		GWPT	GWPF	GWPB	GWPL	ODP	AP	EP - freshwater	EP - freshwater2	EP - marine	EP - terrestrial	POCP	ADPE	ADPF	WDP
Strength (MPa)	Mix Code	kg CO2 eq.	kg CO2 eq.	kg CO2 eq.	kg CO2 eq.	kg CFC 11 eq.	mol H+ eq.	kg PO43- eq.	kg P eq.	kg N eq.	mol N eq.	kg NMVOC eq.	kg Sb eq.	MJ	m3
40	QE402EBR2	304	303	0.20	1.17E-03	5.45E-06	1.32E+00	9.60E-01	3.14E-03	3.99E-01	4.48E+00	1.14E+00	1.47E-04	1.10E+03	1.36E+03
40	QE401ECFA	289	289	0.16	2.53E-03	6.17E-06	1.34E+00	2.57E+00	6.29E-03	3.80E-01	4.41E+00	1.10E+00	1.49E-04	1.11E+03	1.31E+03
40	QE401ELCF	289	289	0.17	2.96E-03	6.17E-06	1.35E+00	3.38E+00	6.29E-03	3.81E-01	4.41E+00	1.10E+00	1.49E-04	1.12E+03	1.30E+03
50	QE501ECFA	320	320	0.18	2.75E-03	6.70E-06	1.47E+00	2.88E+00	7.02E-03	4.16E-01	4.83E+00	1.21E+00	1.61E-04	1.22E+03	1.44E+03
50	QE501ELCF	320	320	0.19	3.23E-03	6.70E-06	1.48E+00	3.78E+00	7.02E-03	4.17E-01	4.84E+00	1.21E+00	1.61E-04	1.23E+03	1.44E+03
65	QE651ECFA	369	369	0.21	3.09E-03	7.55E-06	1.69E+00	3.36E+00	8.16E-03	4.74E-01	5.52E+00	1.38E+00	1.80E-04	1.40E+03	1.65E+03
65	QE651ELCF	370	370	0.22	3.66E-03	7.55E-06	1.70E+00	4.42E+00	8.16E-03	4.75E-01	5.53E+00	1.38E+00	1.81E-04	1.41E+03	1.65E+03
50	QE502MRF4	400	400	0.33	1.96E-03	6.10E-06	1.54E+00	1.22E+00	5.69E-03	4.76E-01	5.43E+00	1.36E+00	1.78E-04	1.38E+03	1.58E+03
25	QE252ESF	199	198	0.23	8.79E-04	2.50E-03	1.01E+00	7.02E-01	2.10E-03	2.70E-01	3.02E+00	8.01E-01	2.88E-03	1.10E+03	9.56E+02
25	QE252ESF1	204	204	0.23	8.94E-04	2.51E-03	1.04E+00	7.25E-01	2.15E-03	2.78E-01	3.10E+00	8.22E-01	2.89E-03	1.12E+03	9.84E+02
32	QE322ESF	217	217	0.24	9.74E-04	2.51E-03	1.10E+00	7.84E-01	2.29E-03	2.94E-01	3.29E+00	8.70E-01	2.89E-03	1.18E+03	1.05E+03
32	QE322ESF1	222	222	0.25	1.00E-03	2.51E-03	1.13E+00	8.07E-01	2.35E-03	3.01E-01	3.36E+00	8.90E-01	2.89E-03	1.20E+03	1.08E+03
40	QE402EBF1	334	333	0.34	1.18E-03	3.51E-03	1.37E+00	9.72E-01	3.16E-03	4.00E-01	4.49E+00	1.17E+00	4.04E-03	1.48E+03	1.37E+03
40	QE402EBF2	341	341	0.35	1.21E-03	3.51E-03	1.40E+00	9.96E-01	3.24E-03	4.09E-01	4.58E+00	1.19E+00	4.04E-03	1.50E+03	1.40E+03
40	QE402EXT1	297	296	0.19	1.15E-03	5.38E-06	1.30E+00	9.36E-01	3.08E-03	3.91E-01	4.39E+00	1.12E+00	1.44E-04	1.08E+03	1.34E+03
65	QE652E160	358	358	0.27	1.96E-03	7.69E-06	1.78E+00	1.78E+00	5.25E-03	4.88E-01	5.54E+00	1.41E+00	1.75E-04	1.52E+03	1.77E+03
65	QE651E160	359	359	0.27	1.97E-03	7.73E-06	1.78E+00	1.78E+00	5.39E-03	4.89E-01	5.56E+00	1.42E+00	1.76E-04	1.52E+03	1.77E+03
25	QE252EHF	219	218	0.28	8.29E-04	3.51E-03	1.08E+00	5.42E-01	2.23E-03	2.86E-01	3.19E+00	8.52E-01	4.00E-03	1.26E+03	1.02E+03
25	QE252EHF1	222	222	0.28	8.59E-04	3.51E-03	1.10E+00	5.54E-01	2.42E-03	2.90E-01	3.24E+00	8.64E-01	4.00E-03	1.27E+03	1.04E+03
32	QE322EHF	240	240	0.30	9.22E-04	3.51E-03	1.19E+00	6.06E-01	2.46E-03	3.13E-01	3.50E+00	9.31E-01	4.01E-03	1.35E+03	1.13E+03
32	QE322EHF1	243	242	0.30	9.49E-04	3.51E-03	1.20E+00	6.08E-01	2.66E-03	3.16E-01	3.55E+00	9.42E-01	4.01E-03	1.36E+03	1.14E+03
25	QE252EFB	197	197	0.21	7.74E-04	5.18E-06	1.01E+00	5.02E-01	2.09E-03	2.71E-01	3.03E+00	7.96E-01	1.06E-04	1.29E+03	9.59E+02
25	QE252EFB1	201	201	0.21	8.00E-04	5.27E-06	1.03E+00	5.09E-01	2.26E-03	2.75E-01	3.08E+00	8.07E-01	1.07E-04	1.30E+03	9.73E+02
32	QE322EFB	219	219	0.23	8.60E-04	5.58E-06	1.11E+00	5.53E-01	2.31E-03	2.98E-01	3.34E+00	8.75E-01	1.15E-04	1.38E+03	1.07E+03
32	QE322EFB1	221	221	0.23	8.85E-04	5.67E-06	1.13E+00	5.55E-01	2.50E-03	3.02E-01	3.38E+00	8.85E-01	1.16E-04	1.39E+03	1.08E+03
25	QE25XDIA	222	222	0.14	8.34E-04	4.24E-06	9.67E-01	6.40E-01	2.32E-03	2.99E-01	3.35E+00	8.54E-01	1.14E-04	8.01E+02	9.79E+02
40	QE40XDIA	298	298	0.20	1.12E-03	5.16E-06	1.26E+00	8.80E-01	3.05E-03	3.86E-01	4.33E+00	1.10E+00	1.43E-04	1.05E+03	1.30E+03
50	QE502LPMR	368	368	0.24	3.60E-03	6.31E-06	1.48E+00	1.05E+00	8.19E-03	4.50E-01	5.21E+00	1.29E+00	1.80E-04	1.24E+03	1.48E+03
32	QE322EMR1	217	217	0.16	9.92E-04	5.37E-06	1.14E+00	6.87E-01	2.48E-03	3.15E-01	3.52E+00	9.13E-01	1.21E-04	9.71E+02	1.13E+03
55	QE552PL18	310	310	0.18	4.54E-03	7.10E-06	1.55E+00	2.64E+00	7.20E-03	4.22E-01	4.83E+00	1.23E+00	1.78E-04	1.28E+03	1.52E+03
55	QE552PL20	310	310	0.18	4.56E-03	7.15E-06	1.56E+00	2.64E+00	7.40E-03	4.22E-01	4.84E+00	1.23E+00	1.78E-04	1.29E+03	1.52E+03

Resource use parameters - 1m<sup>3</sup> of ViroDecs™ ready-mix concrete

PARAMETERS DESCRIBING RESOURCE USE		PERE	PERM	PERT	PENRE	PENRM	PENRT	SM	RSF	NRSF	FW
Strength (MPa)	Mix Code	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	kg	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	m <sup>3</sup>
20	QE203EBMX	2.67E+01	1.46E-03	2.67E+01	9.06E+02	2.63E+02	1.17E+03	2.03E+02	1.86E-05	0.00E+00	1.31E-01
25	QE253EBMX	2.81E+01	1.54E-03	2.81E+01	9.51E+02	2.65E+02	1.22E+03	2.14E+02	1.97E-05	0.00E+00	1.37E-01
32	QE323EBMX	3.27E+01	1.84E-03	3.27E+01	1.10E+03	2.92E+02	1.40E+03	2.56E+02	2.65E-05	0.00E+00	1.57E-01
20	QE207EBMX	2.43E+01	1.33E-03	2.43E+01	8.25E+02	2.04E+02	1.03E+03	1.85E+02	1.81E-05	0.00E+00	1.21E-01
25	QE257EBMX	2.65E+01	1.46E-03	2.65E+01	8.99E+02	2.05E+02	1.10E+03	2.03E+02	1.94E-05	0.00E+00	1.30E-01
32	QE327EBMX	2.96E+01	1.63E-03	2.96E+01	1.00E+03	2.08E+02	1.21E+03	2.26E+02	2.13E-05	0.00E+00	1.43E-01
40	QE407EBMX	3.32E+01	1.84E-03	3.32E+01	1.12E+03	2.57E+02	1.38E+03	2.56E+02	2.65E-05	0.00E+00	1.60E-01
50	QE507EBMX	3.83E+01	2.18E-03	3.83E+01	1.29E+03	2.67E+02	1.56E+03	3.03E+02	3.18E-05	0.00E+00	1.81E-01
20	QE202E	2.00E+01	9.94E-04	2.00E+01	6.93E+02	1.93E+02	8.86E+02	1.38E+02	1.45E-05	0.00E+00	1.02E-01
25	QE252E	2.15E+01	1.09E-03	2.15E+01	7.41E+02	1.94E+02	9.35E+02	1.52E+02	1.56E-05	0.00E+00	1.08E-01
32	QE322E	2.38E+01	1.23E-03	2.38E+01	8.17E+02	1.98E+02	1.02E+03	1.71E+02	1.31E-05	0.00E+00	1.19E-01
40	QE402E	2.86E+01	1.54E-03	2.86E+01	9.75E+02	2.01E+02	1.18E+03	2.15E+02	1.64E-05	0.00E+00	1.40E-01
50	QE502E	3.72E+01	2.09E-03	3.72E+01	1.25E+03	2.07E+02	1.46E+03	2.92E+02	2.23E-05	0.00E+00	1.77E-01
20	QE201E100	2.06E+01	1.04E-03	2.06E+01	7.09E+02	1.92E+02	9.01E+02	1.45E+02	1.50E-05	0.00E+00	1.04E-01
25	QE251E100	2.17E+01	1.11E-03	2.17E+01	7.44E+02	1.93E+02	9.37E+02	1.55E+02	1.58E-05	0.00E+00	1.08E-01
32	QE321E100	2.50E+01	1.32E-03	2.50E+01	8.55E+02	1.99E+02	1.05E+03	1.85E+02	1.41E-05	0.00E+00	1.23E-01
40	QE401E100	3.01E+01	1.65E-03	3.01E+01	1.02E+03	2.02E+02	1.22E+03	2.30E+02	1.75E-05	0.00E+00	1.45E-01
50	QE501E100	3.91E+01	2.23E-03	3.91E+01	1.31E+03	2.10E+02	1.52E+03	3.10E+02	2.36E-05	0.00E+00	1.84E-01
20	QE202E100	2.03E+01	1.02E-03	2.03E+01	7.03E+02	1.91E+02	8.94E+02	1.41E+02	1.48E-05	0.00E+00	1.03E-01
25	QE252E100	2.18E+01	1.11E-03	2.18E+01	7.51E+02	1.92E+02	9.43E+02	1.55E+02	1.58E-05	0.00E+00	1.09E-01
32	QE322E100	2.44E+01	1.27E-03	2.44E+01	8.37E+02	1.96E+02	1.03E+03	1.78E+02	1.35E-05	0.00E+00	1.21E-01
40	QE402E100	2.93E+01	1.59E-03	2.93E+01	9.95E+02	2.00E+02	1.19E+03	2.21E+02	1.69E-05	0.00E+00	1.42E-01
50	QE502E100	3.81E+01	2.16E-03	3.81E+01	1.28E+03	2.06E+02	1.49E+03	3.01E+02	2.29E-05	0.00E+00	1.80E-01
20	QE201EEZY	2.12E+01	1.08E-03	2.12E+01	7.27E+02	1.94E+02	9.21E+02	1.50E+02	1.54E-05	0.00E+00	1.06E-01
25	QE251EEZY	2.30E+01	1.20E-03	2.30E+01	7.91E+02	2.01E+02	9.92E+02	1.68E+02	1.67E-05	0.00E+00	1.15E-01
32	QE321EEZY	2.53E+01	1.35E-03	2.53E+01	8.65E+02	2.00E+02	1.07E+03	1.89E+02	1.43E-05	0.00E+00	1.25E-01
40	QE401EEZY	3.04E+01	1.67E-03	3.04E+01	1.03E+03	2.01E+02	1.23E+03	2.33E+02	1.78E-05	0.00E+00	1.47E-01
50	QE501EEZY	3.97E+01	2.27E-03	3.97E+01	1.33E+03	2.10E+02	1.54E+03	3.16E+02	2.41E-05	0.00E+00	1.87E-01
20	QE202EEZY	2.09E+01	1.05E-03	2.09E+01	7.20E+02	1.95E+02	9.15E+02	1.47E+02	1.52E-05	0.00E+00	1.05E-01
25	QE252EEZY	2.25E+01	1.16E-03	2.25E+01	7.76E+02	2.01E+02	9.77E+02	1.62E+02	1.63E-05	0.00E+00	1.13E-01
32	QE322EEZY	2.47E+01	1.29E-03	2.47E+01	8.45E+02	2.00E+02	1.04E+03	1.80E+02	1.37E-05	0.00E+00	1.22E-01

PARAMETERS DESCRIBING RESOURCE USE		PERE	PERM	PERT	PENRE	PENRM	PENRT	SM	RSF	NRSF	FW
Strength (MPa)	Mix Code	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	kg	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	m <sup>3</sup>
40	QE402EEZY	2.96E+01	1.61E-03	2.96E+01	1.01E+03	2.04E+02	1.21E+03	2.24E+02	1.71E-05	0.00E+00	1.44E-01
50	QE502EEZY	3.88E+01	2.20E-03	3.88E+01	1.30E+03	2.10E+02	1.51E+03	3.07E+02	2.34E-05	0.00E+00	1.83E-01
20	QE201EL21	2.10E+01	1.07E-03	2.10E+01	7.21E+02	2.00E+02	9.21E+02	1.49E+02	1.54E-05	0.00E+00	1.06E-01
25	QE251EL21	2.30E+01	1.20E-03	2.30E+01	7.90E+02	2.08E+02	9.97E+02	1.68E+02	1.67E-05	0.00E+00	1.15E-01
32	QE321EL21	2.58E+01	1.38E-03	2.58E+01	8.80E+02	2.07E+02	1.09E+03	1.92E+02	1.46E-05	0.00E+00	1.27E-01
40	QE401EL21	3.10E+01	1.71E-03	3.10E+01	1.05E+03	2.11E+02	1.26E+03	2.39E+02	1.82E-05	0.00E+00	1.50E-01
50	QE501EL21	4.00E+01	2.29E-03	4.01E+01	1.34E+03	2.17E+02	1.56E+03	3.19E+02	2.44E-05	0.00E+00	1.89E-01
40	QE401E200	3.01E+01	1.65E-03	3.01E+01	1.02E+03	2.42E+02	1.26E+03	2.30E+02	1.84E-05	0.00E+00	1.46E-01
50	QE501E200	3.97E+01	2.18E-03	3.97E+01	1.28E+03	2.65E+02	1.55E+03	2.52E+02	2.48E-05	0.00E+00	1.95E-01
40	QE401EDUF	3.24E+01	1.80E-03	3.24E+01	1.10E+03	2.77E+02	1.37E+03	2.51E+02	2.38E-05	0.00E+00	1.56E-01
50	QE501EDUF	3.57E+01	2.01E-03	3.57E+01	1.21E+03	2.87E+02	1.49E+03	2.80E+02	2.65E-05	0.00E+00	1.71E-01
40	QE402PT1	3.29E+01	1.56E-03	3.29E+01	1.03E+03	2.01E+02	1.23E+03	1.27E+02	1.63E-05	0.00E+00	1.69E-01
40	QE402PT2	3.28E+01	1.58E-03	3.28E+01	1.02E+03	2.04E+02	1.23E+03	1.28E+02	1.67E-05	0.00E+00	1.69E-01
40	QE402PT3	3.28E+01	1.58E-03	3.28E+01	1.03E+03	2.19E+02	1.24E+03	1.28E+02	1.86E-05	0.00E+00	1.69E-01
32	QE322LPN2	2.71E+01	1.40E-03	2.71E+01	8.25E+02	2.17E+02	1.04E+03	1.02E+02	2.84E-05	0.00E+00	1.48E-01
40	QE402LPN2	2.98E+01	1.57E-03	2.98E+01	9.01E+02	2.20E+02	1.12E+03	1.15E+02	3.18E-05	0.00E+00	1.62E-01
50	QE502LPN2	4.04E+01	2.22E-03	4.04E+01	1.20E+03	2.35E+02	1.43E+03	1.63E+02	4.52E-05	0.00E+00	2.15E-01
32	QE327ETOP	2.96E+01	1.52E-03	2.96E+01	9.51E+02	2.19E+02	1.17E+03	1.58E+02	1.62E-05	0.00E+00	1.52E-01
32	QE327LSPR	2.82E+01	1.52E-03	2.82E+01	8.55E+02	2.13E+02	1.07E+03	1.30E+02	1.76E-05	0.00E+00	1.54E-01
40	QE407LSPR	3.29E+01	1.82E-03	3.29E+01	9.89E+02	2.22E+02	1.21E+03	1.52E+02	2.03E-05	0.00E+00	1.78E-01
32	QE322L652	2.47E+01	1.25E-03	2.47E+01	7.53E+02	1.97E+02	9.50E+02	9.17E+01	1.33E-05	0.00E+00	1.36E-01
40	QE402L652	2.97E+01	1.57E-03	2.97E+01	8.94E+02	2.00E+02	1.09E+03	1.15E+02	1.66E-05	0.00E+00	1.61E-01
65	QE651E200	4.17E+01	2.31E-03	4.17E+01	1.35E+03	2.70E+02	1.61E+03	2.67E+02	2.64E-05	0.00E+00	2.04E-01
80	QE801E200	4.93E+01	2.77E-03	4.93E+01	1.58E+03	2.93E+02	1.88E+03	3.21E+02	3.24E-05	0.00E+00	2.39E-01
65	QE651EDUF	4.17E+01	2.31E-03	4.17E+01	1.35E+03	3.03E+02	1.65E+03	2.67E+02	3.06E-05	0.00E+00	2.04E-01
80	QE801EDUF	4.93E+01	2.77E-03	4.93E+01	1.59E+03	3.32E+02	1.92E+03	3.21E+02	3.75E-05	0.00E+00	2.39E-01
40	QE401LMO1	3.20E+01	1.62E-03	3.20E+01	9.53E+02	2.00E+02	1.15E+03	1.03E+02	1.73E-05	0.00E+00	1.72E-01
40	QE402LMO1	3.11E+01	1.57E-03	3.11E+01	9.32E+02	1.99E+02	1.13E+03	9.96E+01	1.66E-05	0.00E+00	1.68E-01
32	QE322EXT1	2.72E+01	1.27E-03	2.72E+01	8.56E+02	1.94E+02	1.05E+03	1.02E+02	1.35E-05	0.00E+00	1.42E-01
40	QE402EBR1	3.32E+01	1.61E-03	3.32E+01	1.03E+03	1.98E+02	1.23E+03	1.29E+02	1.71E-05	0.00E+00	1.70E-01
40	QE402EBR2	3.39E+01	1.65E-03	3.39E+01	1.05E+03	2.00E+02	1.25E+03	1.32E+02	1.75E-05	0.00E+00	1.74E-01



PARAMETERS DESCRIBING RESOURCE USE		PERE	PERM	PERT	PENRE	PENRM	PENRT	SM	RSF	NRSF	FW
Strength (MPa)	Mix Code	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	kg	MJ <sub>NCV</sub>	MJ <sub>NCV</sub>	m <sup>3</sup>
40	QE401ECFA	3.23E+01	2.91E-03	3.23E+01	1.02E+03	2.55E+02	1.28E+03	1.69E+02	2.24E-05	0.00E+00	1.66E-01
40	QE401ELCF	3.23E+01	3.88E-03	3.23E+01	1.02E+03	2.67E+02	1.29E+03	1.70E+02	2.46E-05	0.00E+00	1.66E-01
50	QE501ECFA	3.55E+01	3.25E-03	3.55E+01	1.12E+03	2.65E+02	1.38E+03	1.89E+02	2.56E-05	0.00E+00	1.81E-01
50	QE501ELCF	3.56E+01	4.34E-03	3.56E+01	1.12E+03	2.80E+02	1.40E+03	1.90E+02	2.81E-05	0.00E+00	1.81E-01
65	QE651ECFA	4.09E+01	3.81E-03	4.09E+01	1.28E+03	2.82E+02	1.56E+03	2.22E+02	3.05E-05	0.00E+00	2.06E-01
65	QE651ELCF	4.09E+01	5.08E-03	4.09E+01	1.28E+03	2.99E+02	1.58E+03	2.22E+02	3.34E-05	0.00E+00	2.06E-01
50	QE502MRF4	4.40E+01	2.12E-03	4.40E+01	1.28E+03	2.54E+02	1.53E+03	1.45E+02	2.35E-05	0.00E+00	2.11E-01
25	QE252ESF	4.32E+01	1.21E-03	4.32E+01	1.09E+03	1.99E+02	1.29E+03	1.68E+02	1.28E-05	0.00E+00	1.18E-01
25	QE252ESF1	4.39E+01	1.23E-03	4.39E+01	1.11E+03	1.99E+02	1.31E+03	1.73E+02	1.29E-05	0.00E+00	1.21E-01
32	QE322ESF	4.55E+01	1.35E-03	4.55E+01	1.16E+03	2.00E+02	1.36E+03	1.89E+02	1.44E-05	0.00E+00	1.28E-01
32	QE322ESF1	4.62E+01	1.40E-03	4.62E+01	1.18E+03	2.01E+02	1.38E+03	1.94E+02	1.48E-05	0.00E+00	1.31E-01
40	QE402EBF1	6.18E+01	1.65E-03	6.18E+01	1.45E+03	1.98E+02	1.65E+03	1.32E+02	1.71E-05	0.00E+00	1.76E-01
40	QE402EBF2	6.26E+01	1.69E-03	6.26E+01	1.48E+03	1.99E+02	1.68E+03	1.36E+02	1.80E-05	0.00E+00	1.79E-01
40	QE402EXT1	3.32E+01	1.61E-03	3.32E+01	1.03E+03	1.98E+02	1.23E+03	1.29E+02	1.71E-05	0.00E+00	1.70E-01
65	QE652E160	4.35E+01	2.86E-03	4.35E+01	1.41E+03	2.54E+02	1.67E+03	2.67E+02	2.50E-05	0.00E+00	2.09E-01
65	QE651E160	4.35E+01	2.86E-03	4.35E+01	1.41E+03	2.64E+02	1.68E+03	2.67E+02	2.57E-05	0.00E+00	2.09E-01
25	QE252EHF	5.27E+01	1.04E-03	5.27E+01	1.25E+03	1.95E+02	1.45E+03	1.83E+02	1.33E-05	0.00E+00	1.25E-01
25	QE252EHF1	5.31E+01	1.07E-03	5.31E+01	1.26E+03	1.99E+02	1.46E+03	1.85E+02	1.43E-05	0.00E+00	1.26E-01
32	QE322EHF	5.54E+01	1.18E-03	5.54E+01	1.34E+03	1.96E+02	1.53E+03	2.06E+02	1.50E-05	0.00E+00	1.36E-01
32	QE322EHF1	5.57E+01	1.19E-03	5.57E+01	1.35E+03	2.01E+02	1.55E+03	2.09E+02	1.61E-05	0.00E+00	1.38E-01
25	QE252EFB	2.87E+01	9.76E-04	2.87E+01	1.29E+03	1.95E+02	1.48E+03	1.71E+02	1.24E-05	0.00E+00	1.17E-01
25	QE252EFB1	2.90E+01	9.92E-04	2.90E+01	1.30E+03	1.99E+02	1.50E+03	1.73E+02	1.34E-05	0.00E+00	1.18E-01
32	QE322EFB	3.13E+01	1.09E-03	3.13E+01	1.37E+03	1.96E+02	1.57E+03	1.94E+02	1.41E-05	0.00E+00	1.28E-01
32	QE322EFB1	3.16E+01	1.10E-03	3.16E+01	1.38E+03	2.00E+02	1.58E+03	1.97E+02	1.51E-05	0.00E+00	1.30E-01
25	QE25XDIA	2.43E+01	1.12E-03	2.43E+01	7.70E+02	1.89E+02	9.59E+02	9.50E+01	1.24E-05	0.00E+00	1.31E-01
40	QE40XDIA	3.23E+01	1.56E-03	3.23E+01	9.99E+02	1.93E+02	1.19E+03	1.32E+02	1.73E-05	0.00E+00	1.69E-01
50	QE502LPMR	3.70E+01	1.86E-03	3.70E+01	1.10E+03	3.17E+02	1.42E+03	1.35E+02	3.11E-05	0.00E+00	1.98E-01
32	QE322EMR1	2.76E+01	1.33E-03	2.76E+01	9.31E+02	1.93E+02	1.12E+03	2.17E+02	1.61E-05	0.00E+00	1.37E-01
55	QE552PL18	3.73E+01	2.97E-03	3.73E+01	1.22E+03	2.16E+02	1.43E+03	2.58E+02	1.85E-05	0.00E+00	1.82E-01
55	QE552PL20	3.73E+01	2.97E-03	3.73E+01	1.22E+03	2.21E+02	1.44E+03	2.58E+02	1.96E-05	0.00E+00	1.82E-01

Waste categories and output flows - 1m<sup>3</sup> of ViroDecs™ ready-mix concrete

WASTE CATEGORIES AND OUTPUT FLOWS		HWD	NHWD	RWD	CFR	MFR	MFEE	EE - e	EE - t
Strength (MPa)	Mix Code	kg	kg	kg	kg	kg	kg	MJ	MJ
20	QE203EBMX	6.99E+01	9.39E+00	3.30E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE253EBMX	7.42E+01	9.84E+00	3.50E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE323EBMX	1.04E+02	1.14E+01	4.22E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
20	QE207EBMX	5.18E+01	8.83E+00	2.99E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE257EBMX	5.64E+01	9.47E+00	3.27E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE327EBMX	6.28E+01	1.04E+01	3.66E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE407EBMX	1.04E+02	1.16E+01	4.22E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE507EBMX	1.25E+02	1.33E+01	5.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
20	QE202E	3.92E+01	7.32E+00	2.24E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE252E	4.28E+01	7.79E+00	2.45E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322E	4.58E+01	8.54E+00	2.76E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402E	5.75E+01	1.01E+01	3.46E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE502E	7.79E+01	1.28E+01	4.69E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
20	QE201E100	4.09E+01	7.46E+00	2.34E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE251E100	4.36E+01	7.80E+00	2.50E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE321E100	4.93E+01	8.89E+00	2.96E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE401E100	6.14E+01	1.05E+01	3.69E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE501E100	8.28E+01	1.34E+01	4.98E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
20	QE202E100	4.00E+01	7.41E+00	2.28E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE252E100	4.36E+01	7.89E+00	2.50E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322E100	4.74E+01	8.73E+00	2.85E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402E100	5.90E+01	1.03E+01	3.55E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE502E100	8.03E+01	1.31E+01	4.83E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
20	QE201EEZY	4.24E+01	7.64E+00	2.43E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE251EEZY	4.68E+01	8.26E+00	2.69E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE321EEZY	5.00E+01	8.99E+00	3.01E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE401EEZY	6.22E+01	1.06E+01	3.74E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE501EEZY	8.44E+01	1.36E+01	5.08E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
20	QE202EEZY	4.14E+01	7.58E+00	2.37E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE252EEZY	4.52E+01	8.13E+00	2.60E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322EEZY	4.80E+01	8.80E+00	2.89E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

WASTE CATEGORIES AND OUTPUT FLOWS		HWD	NHWD	RWD	CFR	MFR	MFEE	EE - e	EE - t
Strength (MPa)	Mix Code	kg	kg	kg	kg	kg	kg	MJ	MJ
40	QE402EEZY	5.98E+01	1.04E+01	3.60E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE502EEZY	8.18E+01	1.33E+01	4.92E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
20	QE201EL21	4.21E+01	7.57E+00	2.41E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE251EL21	4.68E+01	8.24E+00	2.69E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE321EL21	5.12E+01	9.13E+00	3.08E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE401EL21	6.38E+01	1.08E+01	3.84E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE501EL21	8.53E+01	1.37E+01	5.13E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE401E200	9.37E+01	1.11E+01	4.27E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE501E200	1.26E+02	1.42E+01	5.49E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE401EDUF	1.21E+02	1.19E+01	4.66E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE501EDUF	1.35E+02	1.30E+01	5.15E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402PT1	5.71E+01	1.11E+01	3.46E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402PT2	5.84E+01	1.12E+01	3.52E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402PT3	6.81E+01	1.12E+01	3.55E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322LPN2	6.87E+01	1.00E+01	3.19E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402LPN2	7.71E+01	1.09E+01	3.58E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE502LPN2	1.09E+02	1.45E+01	5.08E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE327ETOP	5.67E+01	1.04E+01	3.41E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE327LSPR	5.82E+01	1.08E+01	3.43E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE407LSPR	6.90E+01	1.25E+01	4.09E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322L652	4.66E+01	9.10E+00	2.80E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402L652	5.82E+01	1.08E+01	3.50E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
65	QE651E200	1.34E+02	1.49E+01	5.78E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
80	QE801E200	1.64E+02	1.74E+01	6.85E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
65	QE651EDUF	1.55E+02	1.49E+01	5.84E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
80	QE801EDUF	1.90E+02	1.75E+01	6.93E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE401LMO1	6.06E+01	1.13E+01	3.64E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402LMO1	5.82E+01	1.11E+01	3.50E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322EXT1	4.72E+01	9.39E+00	2.84E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402EBR1	5.98E+01	1.13E+01	3.60E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402EBR2	6.14E+01	1.15E+01	3.69E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

WASTE CATEGORIES AND OUTPUT FLOWS		HWD	NHWD	RWD	CFR	MFR	MFEE	EE - e	EE - t
Strength (MPa)	Mix Code	kg	kg	kg	kg	kg	kg	MJ	MJ
40	QE401ECFA	1.19E+02	1.30E+01	5.33E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE401ELCF	1.32E+02	1.46E+01	6.87E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE501ECFA	1.35E+02	1.42E+01	5.92E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE501ELCF	1.50E+02	1.60E+01	7.64E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
65	QE651ECFA	1.61E+02	1.62E+01	6.85E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
65	QE651ELCF	1.78E+02	1.83E+01	8.86E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE502MRF4	1.19E+02	1.48E+01	5.08E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE252ESF	4.54E+01	1.44E+01	2.70E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE252ESF1	4.57E+01	1.45E+01	2.74E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322ESF	5.08E+01	1.51E+01	3.03E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322ESF1	5.24E+01	1.53E+01	3.13E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402EBF1	6.16E+01	1.99E+01	3.69E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402EBF2	6.36E+01	2.02E+01	3.79E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE402EXT1	5.98E+01	1.13E+01	3.60E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
65	QE652E160	1.26E+02	1.55E+01	6.12E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
65	QE651E160	1.30E+02	1.55E+01	6.14E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE252EHF	4.58E+01	1.68E+01	2.51E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE252EHF1	5.08E+01	1.70E+01	2.57E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322EHF	5.16E+01	1.76E+01	2.83E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322EHF1	5.70E+01	1.77E+01	2.88E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE252EFB	4.22E+01	8.10E+00	2.35E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE252EFB1	4.68E+01	8.21E+00	2.40E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322EFB	4.78E+01	8.86E+00	2.64E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322EFB1	5.27E+01	8.96E+00	2.69E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
25	QE25XDIA	4.32E+01	8.60E+00	2.55E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
40	QE40XDIA	6.02E+01	1.11E+01	3.55E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
50	QE502LPMR	1.60E+02	1.46E+01	5.85E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
32	QE322EMR1	5.51E+01	9.58E+00	3.12E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
55	QE552PL18	1.04E+02	1.52E+01	6.80E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
55	QE552PL20	1.09E+02	1.52E+01	6.81E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00



Additional indicators 1m<sup>3</sup> of ViroDecs™ ready-mix concrete

ADDITIONAL ENVIRONMENTAL IMPACT INDICATORS		PM	IRP	ETP-fw	HTP-c	HTP-nc	SQP
Strength (MPa)	Mix Code	disease incidence	kBq U-235 eq	CTUe	CTUh	CTUh	dimensionless
20	QE203EBMX	6.18E-06	4.85E+01	1.50E+03	3.41E-08	1.49E-06	2.25E+02
25	QE253EBMX	6.46E-06	5.15E+01	1.56E+03	3.57E-08	1.56E-06	2.36E+02
32	QE323EBMX	7.46E-06	9.15E+01	1.75E+03	4.41E-08	1.86E-06	2.71E+02
20	QE207EBMX	5.64E-06	1.84E+01	1.35E+03	2.90E-08	1.31E-06	2.09E+02
25	QE257EBMX	6.06E-06	1.99E+01	1.43E+03	3.10E-08	1.40E-06	2.26E+02
32	QE327EBMX	6.65E-06	2.19E+01	1.55E+03	3.39E-08	1.54E-06	2.49E+02
40	QE407EBMX	7.53E-06	9.15E+01	1.71E+03	4.45E-08	1.86E-06	2.78E+02
50	QE507EBMX	8.55E-06	1.13E+02	1.92E+03	5.12E-08	2.13E-06	3.17E+02
20	QE202E	4.76E-06	1.44E+01	1.15E+03	2.44E-08	1.09E-06	1.77E+02
25	QE252E	5.04E-06	1.55E+01	1.20E+03	2.59E-08	1.16E-06	1.88E+02
32	QE322E	5.51E-06	1.47E+01	1.30E+03	2.77E-08	1.25E-06	2.06E+02
40	QE402E	6.46E-06	1.84E+01	1.50E+03	3.25E-08	1.48E-06	2.43E+02
50	QE502E	8.15E-06	2.49E+01	1.85E+03	4.08E-08	1.87E-06	3.09E+02
20	QE201E100	4.84E-06	1.49E+01	1.17E+03	2.49E-08	1.11E-06	1.80E+02
25	QE251E100	5.05E-06	1.58E+01	1.21E+03	2.59E-08	1.16E-06	1.88E+02
32	QE321E100	5.72E-06	1.58E+01	1.35E+03	2.88E-08	1.30E-06	2.14E+02
40	QE401E100	6.73E-06	1.96E+01	1.56E+03	3.38E-08	1.54E-06	2.53E+02
50	QE501E100	8.51E-06	2.65E+01	1.93E+03	4.26E-08	1.96E-06	3.22E+02
20	QE202E100	4.80E-06	1.46E+01	1.15E+03	2.47E-08	1.10E-06	1.79E+02
25	QE252E100	5.09E-06	1.58E+01	1.21E+03	2.61E-08	1.17E-06	1.90E+02
32	QE322E100	5.62E-06	1.52E+01	1.33E+03	2.83E-08	1.28E-06	2.11E+02
40	QE402E100	6.59E-06	1.89E+01	1.53E+03	3.31E-08	1.51E-06	2.48E+02
50	QE502E100	8.33E-06	2.57E+01	1.88E+03	4.17E-08	1.91E-06	3.16E+02
20	QE201EEZY	4.95E-06	1.54E+01	1.19E+03	2.54E-08	1.14E-06	1.84E+02
25	QE251EEZY	5.34E-06	1.68E+01	1.27E+03	2.73E-08	1.23E-06	1.99E+02
32	QE321EEZY	5.79E-06	1.60E+01	1.37E+03	2.91E-08	1.32E-06	2.17E+02
40	QE401EEZY	6.79E-06	1.99E+01	1.57E+03	3.40E-08	1.56E-06	2.55E+02
50	QE501EEZY	8.62E-06	2.70E+01	1.95E+03	4.31E-08	1.99E-06	3.26E+02
20	QE202EEZY	4.92E-06	1.51E+01	1.18E+03	2.52E-08	1.13E-06	1.83E+02
25	QE252EEZY	5.26E-06	1.63E+01	1.25E+03	2.70E-08	1.21E-06	1.96E+02
32	QE322EEZY	5.68E-06	1.54E+01	1.34E+03	2.85E-08	1.29E-06	2.12E+02

ADDITIONAL ENVIRONMENTAL IMPACT INDICATORS		PM	IRP	ETP-fw	HTP-c	HTP-nc	SQP
Strength (MPa)	Mix Code	disease incidence	kBq U-235 eq	CTUe	CTUh	CTUh	dimensionless
40	QE402EEZY	6.65E-06	1.91E+01	1.54E+03	3.34E-08	1.52E-06	2.50E+02
50	QE502EEZY	8.46E-06	2.62E+01	1.92E+03	4.24E-08	1.95E-06	3.20E+02
20	QE201EL21	4.93E-06	1.53E+01	1.19E+03	2.53E-08	1.13E-06	1.83E+02
25	QE251EL21	5.34E-06	1.68E+01	1.28E+03	2.74E-08	1.23E-06	1.99E+02
32	QE321EL21	5.89E-06	1.64E+01	1.40E+03	2.96E-08	1.35E-06	2.20E+02
40	QE401EL21	6.93E-06	2.04E+01	1.61E+03	3.47E-08	1.59E-06	2.60E+02
50	QE501EL21	8.71E-06	2.73E+01	1.98E+03	4.36E-08	2.01E-06	3.29E+02
40	QE401E200	6.89E-06	1.06E+02	1.57E+03	6.41E-08	1.75E-06	2.54E+02
50	QE501E200	9.12E-06	1.36E+02	2.09E+03	7.74E-08	2.37E-06	3.30E+02
40	QE401EDUF	7.46E-06	1.51E+02	1.68E+03	7.10E-08	1.97E-06	2.71E+02
50	QE501EDUF	8.14E-06	1.64E+02	1.82E+03	7.54E-08	2.15E-06	2.97E+02
40	QE402PT1	7.72E-06	1.81E+01	1.85E+03	3.87E-08	1.83E-06	2.79E+02
40	QE402PT2	7.71E-06	1.86E+01	1.85E+03	3.86E-08	1.83E-06	2.78E+02
40	QE402PT3	7.77E-06	3.78E+01	1.86E+03	4.07E-08	1.88E-06	2.78E+02
32	QE322LPN2	6.78E-06	5.17E+01	1.68E+03	4.06E-08	1.69E-06	2.37E+02
40	QE402LPN2	7.39E-06	5.79E+01	1.81E+03	4.44E-08	1.85E-06	2.59E+02
50	QE502LPN2	9.76E-06	8.22E+01	2.36E+03	5.93E-08	2.48E-06	3.42E+02
32	QE327ETOP	6.96E-06	1.81E+01	1.68E+03	3.50E-08	1.64E-06	2.52E+02
32	QE327LSPR	6.98E-06	1.93E+01	1.75E+03	3.55E-08	1.69E-06	2.45E+02
40	QE407LSPR	8.06E-06	2.25E+01	2.00E+03	4.09E-08	1.96E-06	2.83E+02
32	QE322L652	6.17E-06	1.49E+01	1.55E+03	3.12E-08	1.48E-06	2.17E+02
40	QE402L652	7.29E-06	1.86E+01	1.81E+03	3.69E-08	1.76E-06	2.57E+02
65	QE651E200	9.54E-06	1.43E+02	2.17E+03	8.01E-08	2.48E-06	3.45E+02
80	QE801E200	1.12E-05	1.73E+02	2.51E+03	9.06E-08	2.92E-06	4.04E+02
65	QE651EDUF	9.65E-06	1.85E+02	2.19E+03	8.47E-08	2.58E-06	3.45E+02
80	QE801EDUF	1.13E-05	2.24E+02	2.53E+03	9.61E-08	3.05E-06	4.05E+02
40	QE401LMO1	7.77E-06	1.94E+01	1.92E+03	3.92E-08	1.88E-06	2.74E+02
40	QE402LMO1	7.60E-06	1.86E+01	1.87E+03	3.84E-08	1.83E-06	2.68E+02
32	QE322EXT1	6.49E-06	1.51E+01	1.58E+03	3.26E-08	1.53E-06	2.34E+02
40	QE402EBR1	7.77E-06	1.91E+01	1.86E+03	3.90E-08	1.84E-06	2.80E+02
40	QE402EBR2	7.92E-06	1.96E+01	1.90E+03	3.97E-08	1.88E-06	2.86E+02

ADDITIONAL ENVIRONMENTAL IMPACT INDICATORS		PM	IRP	ETP-fw	HTP-c	HTP-nc	SQP
Strength (MPa)	Mix Code	disease incidence	kBq U-235 eq	CTUe	CTUh	CTUh	dimensionless
40	QE401ECFA	7.89E-06	1.88E+02	1.84E+03	7.70E-08	2.19E-06	2.74E+02
40	QE401ELCF	7.88E-06	1.88E+02	1.84E+03	7.69E-08	2.19E-06	2.74E+02
50	QE501ECFA	8.63E-06	2.12E+02	2.00E+03	8.27E-08	2.41E-06	3.00E+02
50	QE501ELCF	8.63E-06	2.12E+02	2.00E+03	8.27E-08	2.41E-06	3.00E+02
65	QE651ECFA	9.82E-06	2.48E+02	2.25E+03	9.18E-08	2.77E-06	3.41E+02
65	QE651ELCF	9.82E-06	2.48E+02	2.25E+03	9.18E-08	2.77E-06	3.41E+02
50	QE502MRF4	9.67E-06	1.11E+02	2.32E+03	6.76E-08	2.54E-06	3.35E+02
25	QE252ESF	5.48E-06	1.44E+01	1.29E+03	2.73E-08	1.24E-06	2.04E+02
25	QE252ESF1	5.61E-06	1.44E+01	1.32E+03	2.80E-08	1.27E-06	2.09E+02
32	QE322ESF	5.93E-06	1.61E+01	1.38E+03	2.96E-08	1.34E-06	2.21E+02
32	QE322ESF1	6.06E-06	1.66E+01	1.41E+03	3.02E-08	1.37E-06	2.26E+02
40	QE402EBF1	8.03E-06	1.83E+01	1.90E+03	3.98E-08	1.89E-06	2.89E+02
40	QE402EBF2	8.19E-06	2.02E+01	1.94E+03	4.08E-08	1.93E-06	2.95E+02
40	QE402EXT1	7.77E-06	1.91E+01	1.86E+03	3.89E-08	1.84E-06	2.80E+02
65	QE652E160	9.71E-06	8.47E+01	2.20E+03	5.38E-08	2.42E-06	3.57E+02
65	QE651E160	9.74E-06	9.18E+01	2.21E+03	5.47E-08	2.44E-06	3.57E+02
25	QE252EHF	5.80E-06	1.56E+01	1.35E+03	2.88E-08	1.31E-06	2.16E+02
25	QE252EHF1	5.89E-06	2.41E+01	1.37E+03	3.01E-08	1.34E-06	2.19E+02
32	QE322EHF	6.33E-06	1.76E+01	1.46E+03	3.15E-08	1.43E-06	2.37E+02
32	QE322EHF1	6.41E-06	2.72E+01	1.47E+03	3.28E-08	1.47E-06	2.39E+02
25	QE252EFB	5.45E-06	1.46E+01	1.29E+03	2.73E-08	1.23E-06	2.03E+02
25	QE252EFB1	5.54E-06	2.24E+01	1.31E+03	2.84E-08	1.27E-06	2.06E+02
32	QE322EFB	5.98E-06	1.66E+01	1.40E+03	2.99E-08	1.36E-06	2.23E+02
32	QE322EFB1	6.05E-06	2.51E+01	1.41E+03	3.11E-08	1.39E-06	2.26E+02
25	QE25XDIA	5.97E-06	1.41E+01	1.48E+03	2.97E-08	1.41E-06	2.12E+02
40	QE40XDIA	7.67E-06	1.96E+01	1.86E+03	3.83E-08	1.83E-06	2.74E+02
50	QE502LPMR	9.34E-06	2.71E+02	2.22E+03	1.30E-07	2.71E-06	3.15E+02
32	QE322EMR1	6.30E-06	1.86E+01	1.48E+03	3.18E-08	1.45E-06	2.36E+02
55	QE552PL18	8.64E-06	2.39E+02	1.96E+03	1.46E-07	2.39E-06	3.11E+02
55	QE552PL20	8.66E-06	2.50E+02	1.96E+03	1.47E-07	2.41E-06	3.11E+02

# Other life cycle stages not included in this EPD

While the LCA study and EPD only consider the cradle to gate environmental impacts of Holcim's ready-mix concrete, practitioners using the EPD for the purpose of whole-of-life building studies or the functional comparison of different building products on a whole-of-life basis will consider concrete's other life cycle stages. Some of the environmental impacts of benefits associated with other life cycle stages not included in this EPD are described in the following sections.

## Lifetime absorption of CO<sub>2</sub>

Carbonation is a natural process whereby concrete absorbs carbon dioxide (CO<sub>2</sub>) from the atmosphere through a chemical reaction between the CO<sub>2</sub> in the ambient air and hydration products within the concrete (CaOH<sub>2</sub>). Ready-mix concrete can be subject to carbonation from the use stage onward (i.e. after construction and curing). From a life cycle impact accounting perspective, this process can also be referred to as 'reabsorption', since the CO<sub>2</sub> emitted during the cement manufacturing process can be partly offset by the lifetime absorption of CO<sub>2</sub>, therefore reducing the net CO<sub>2</sub> emissions associated with concrete over its lifetime.

The carbonisation process is a commonly known process in building design and is typically taken into consideration by engineers when specifying special-class concrete.

The total amount of CO<sub>2</sub> absorption during the life cycle of concrete is subject to a range of factors and varies over time. The calculation has been standardised in the British and European Standard BS EN 16757:2017 *Sustainability of construction works – Environmental Product Declarations – Product Category Rules for concrete and concrete elements*. It is recommended that practitioners make use of this standard when conducting whole-of-life building studies and if the building materials include substantial amounts of concrete. Please note that CO<sub>2</sub> absorption has not been considered in this EPD and is not reflected in the EPD results tables.

## End of life scenarios

BS EN 16757:2017 presents four end of life scenarios for concrete:

1. Disposal of concrete at a landfill site,
2. Reuse of recovered concrete elements in new construction works,
3. Use of concrete debris, e.g. In land restoration, or
4. Crushing/recycling of concrete:
  - a. Crushed concrete substitutes primary material without further processing, or
  - b. Substitution of natural aggregates in fresh concrete.



Scenarios 2, 3 and 4 can all result in benefits and loads outside the system boundary and thus should be considered in a whole-of-life building study or when comparing concrete products on a functional basis in line with BS EN 16757:2017.




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# Programme-related information and verification

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<b>EPD Registration Number</b>	[S-P-04658]	
<b>Valid From</b>	[20 January 2022]	
<b>Version</b>	[4.0]	
<b>Valid Until</b>	[20 January 2027]	
<b>Product category rules</b>	PCR 2019:14 Construction Products, Version 1.11, 2021-02-05	
<b>Product group classification</b>	UN CPC 54	
<b>Geographical Scope</b>	Australia	
<b>Reference Year for Data</b>	2017 Plant Data, [2024] Mix/Materials Data	

## CEN standard EN 15804:2012+A2:2019 served as the core PCR

<b>Product category rules</b>	PCR 2019:14 Construction Products, Version 1.11, 2019-02-05	
<b>PCR review was conducted by</b>	The Technical Committee of the International EPD® System. Chair: Massimo Marino. Contact via <a href="mailto:info@environdec.com">info@environdec.com</a>	
<b>Independent third-party verification of the declaration and data, according to ISO 14025:2006:</b>	<input checked="" type="checkbox"/> EPD process certification <input type="checkbox"/> EPD verification	
<b>EPD Process Certified by</b>	Epsten Group, Inc., Katherine McFeaters: Accredited by: A2LA, Certificate #3142.03	
<b>Procedure for follow-up of data during EPD validity involves third party verifier:</b>	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	

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