

Canberra Hospital



# ENVIRONMENTAL PRODUCT DECLARATION

## GS SLCF40S80 80 MPa (SLCF40S80)

### ELVIN GROUP (ACT)

### READY-MIXED CONCRETE

In accordance with ISO 14025 and EN 15804:2012+A2:2019

Programme:

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

Regional programme:

EPD Australasia Limited, [www.epd-australasia.com](http://www.epd-australasia.com)

EPD type:

EPD of multiple products, based on a representative product

EPD registration number:

EPD-IES-0019670:001

Publication date:

2025-03-07

Valid until:

2030-03-07

EPD Process Certified by:

Epsten Group, Inc.  
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[www.epstengroup.com](http://www.epstengroup.com)

*An EPD should provide current information and may be updated if conditions change. The stated validity is therefore subject to the continued registration and publication at [www.environdec.com](http://www.environdec.com)*

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| Version number | Date       | Description of changes | Approved      |
|----------------|------------|------------------------|---------------|
| 1.0            | 07/03/2025 |                        | Njoud Willans |

## General information

### Programme and verification information

**Declaration Owner:** Elvin Group (ACT) Pty Ltd  
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|                                |   |
|--------------------------------|---|
| <b>Version</b>                 | 1.0   |
| <b>EPD Registration Number</b> | EPD-IES-0019670:001   |
| <b>Valid From</b>              | 2025-03-07  |
| <b>Valid Until</b>             | 2030-03-07  |
| <b>Reference year for data</b> | 2023 (Elvin Group ACT mix design and production data)         |
| <b>Geography</b>               | Australia   |
| <b>EPD Type</b>                | EPD of multiple products, based on a representative product   |
| <b>Product Category Rules</b>  | PCR 2019:14 Construction Products (EN 15804:A2) Version 1.3.4 |

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

Product category rules (PCR):

PCR 2019:14 Construction Products Version 1.3.4 (EN 15804:A2) and complementary PCRs – PCR 2019:14-c-PCR-003 c-PCR-003 Concrete and Concrete Elements (EN 16757) (2023-01-02)

Referenced by the GCCA Industry EPD Tool for Cement and Concrete (v5.0), International Version, verified to comply with the General Programme Instructions (GPI 4.0) of the International EPD® System.

PCR review was conducted by: The Technical Committee of the International EPD System. Review chair: Claudia A. Peña. A full list of members available on [www.environdec.com](http://www.environdec.com). The review panel may be contacted via [info@environdec.com](mailto:info@environdec.com).

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

EPD process certification  EPD verification

EPD Process Certified by:

Megan Blizzard

Epstengroup  
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Accredited by: A2LA, Certificate #3142.03

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 registered in different EPD programmes, or not compliant with EN 15804, may not be comparable. For two EPDs to be comparable, they must be based on the same PCR (including the same version number) or be based on fully-aligned PCRs or versions of PCRs; cover products with identical functions, technical performances and use (e.g. identical declared/functional units); have equivalent system boundaries and descriptions of data; apply equivalent data quality requirements, methods of data collection, and allocation methods; apply identical cut-off rules and impact assessment methods (including the same version of characterisation factors); have equivalent content declarations; and be valid at the time of comparison. For further information about comparability, see EN 15804 and ISO 14025.

## Company information

*Owner of the EPD:* Elvin Group (ACT)

*Contact:* Njoud Willans – Technical Manager

*About Elvin Group (ACT):*

The Elvin Group has evolved from a family owned and operated business in the early 1970s into the predominant producer of pre-mixed concrete in the Canberra region. The Group has three concrete plants and the largest fleet of trucks enabling it to provide unmatched production and delivery rates in the region.

The locally based management team has driven Elvin's growth and evolution through its focus on continuous improvement, team building and the adoption of improved practices and technologies. Minimising the Group's environmental impact has been a core value, for many years the plants have used recyclers and generated solar power.

Recently, Elvins became a fully owned subsidiary of Heidelberg Construction Materials.

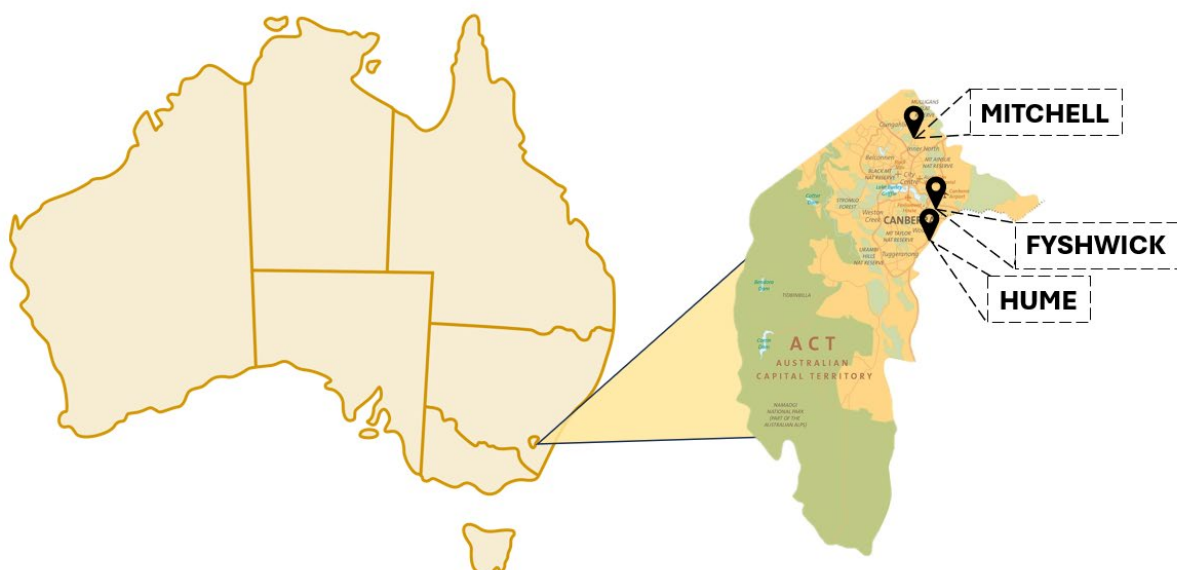
*Product-related or management system-related certifications:*

The IMS of Elvin Group (ACT) meets the requirements of:

- Statutory regulations
- Product standards
- ISO 9001:2015 Quality Management Systems
- ISO 14001:2015 Environmental Management Systems; and
- AS/NZS 4801:2001 Occupational Health & Safety Management Systems.

*Name and location of production sites:*

Elvin Group (ACT) operates through 3 primary locations within the Australian Capital Territory, these being Mitchell, Fyshwick and Hume.



## Product information

### *Product identification:*

Concrete is a construction material made from the combination of cement, water, fine aggregates (such as sand), and coarse aggregates (such as crushed stone). In Australia, AS1379 details the specification and supply of concrete based on compressive strength, slump, mix proportions, durability criteria and testing methods. The standards define two classes of concrete in relation to their design and application, these being normal and special.

Normal class concrete is typically used for residential applications, such as house slabs and driveways, where compressive strength is the sole specification. Special class concrete, however, is commonly used for commercial projects, such as bridges, roads, and high-rise buildings, with more detailed specifications which may require concrete of high strength, performance, slump, workability or durability.

*UN CPC code:* 54 [Construction services]

*CPV code:* 44114000-3 [Ready-mixed concrete]

*ANZSIC code:* 203 [Cement, Lime, Plaster and Concrete Manufacturing]  
2033 [Ready-mixed Concrete Manufacturing]

### *Product name:*

This EPD aims to assess the potential environmental impacts of **ready-mixed concrete** produced by Elvin Group (ACT). This EPD covers a variety of special class mixes produced by Elvin Group (ACT), these which are referred to as **GS** mixes.

### *Product description:*

Elvin Group (ACT) has implemented GS mixes as a more sustainable alternative to conventional concrete. GS mixes are designed with lower embodied carbon for applications ranging from general, structural, to those requiring high performance, high early strength and durability, all with a technical service life of 50 years. The reduction in embodied carbon is primarily attributed to significant replacement of general purpose cement with supplementary cementitious materials (referred to as SCMs hereafter). The main sources of SCMs used by Elvin Group (ACT) are fly ash and slag. GS mix SCM blend makeups are detailed below:

F – Fly ash is the primary SCM, used alongside general purpose cement

S – Slag is the primary SCM, used alongside general purpose cement

T – A combination of fly ash and slag is used alongside general purpose cement as a ternary blend

For the purpose of the EPD, GS mixes have been grouped into product families based on their application, SCM blend type and proportion. Three primary applications and their corresponding sub-families are listed below:

| Sub-family | Description                 | Application      | SCM makeup (fly ash, slag or ternary) |
|------------|-----------------------------|------------------|---------------------------------------|
| LC         | Low Carbon                  | General          | F/S/T                                 |
| SLC        | Structural Low Carbon       | Structural       | F/S/T                                 |
| LCHP       | Low Carbon High Performance | High Performance | F/T                                   |

Family groupings of GS mixes covered in the EPD are provided below, alongside their descriptions and applications. It is important to note a fair comparison of environmental performance of products, 60 in total grouped into 14 families, should consider consistent applications, i.e. fit for purpose concrete products.

| Family        | Strength (MPa) | Product code | Description            | Application |
|---------------|----------------|--------------|------------------------|-------------|
| <b>LCF30</b>  | 20             | LCF30G20     | Special 20 MPa 30% SCM | General     |
|               | 25             | LCF30G25     | Special 25 MPa 30% SCM | General     |
|               | 32             | LCF30G32     | Special 32 MPa 30% SCM | General     |
|               | 40             | LCF30G40     | Special 40 MPa 30% SCM | General     |
| <b>LCF40</b>  | 32             | LCF40G32     | Special 32 MPa 40% SCM | General     |
|               | 40             | LCF40G40     | Special 40 MPa 40% SCM | General     |
|               | 50             | LCF40G50     | Special 50 MPa 40% SCM | General     |
|               | 65             | LCF40G65     | Special 65 MPa 40% SCM | General     |
| <b>LCT40</b>  | 20             | LCT40G20     | Special 20 MPa 40% SCM | General     |
|               | 25             | LCT40G25     | Special 25 MPa 40% SCM | General     |
|               | 32             | LCT40G32     | Special 32 MPa 40% SCM | General     |
|               | 40             | LCT40G40     | Special 40 MPa 40% SCM | General     |
|               | 50             | LCT40G50     | Special 50 MPa 40% SCM | General     |
|               | 65             | LCT40G65     | Special 65 MPa 40% SCM | General     |
| <b>SLCF40</b> | 32             | SLCF40S32    | Special 32 MPa 40% SCM | Structural  |
|               | 40             | SLCF40S40    | Special 40 MPa 40% SCM | Structural  |
|               | 50             | SLCF40S50    | Special 50 MPa 40% SCM | Structural  |
|               | 65             | SLCF40S65    | Special 65 MPa 40% SCM | Structural  |
|               | 80             | SLCF40S80    | Special 80 MPa 40% SCM | Structural  |
| <b>LCT50</b>  | 20             | LCT50G20     | Special 20 MPa 50% SCM | General     |
|               | 25             | LCT50G25     | Special 25 MPa 50% SCM | General     |
|               | 32             | LCT50G32     | Special 32 MPa 50% SCM | General     |
|               | 40             | LCT50G40     | Special 40 MPa 50% SCM | General     |
|               | 50             | LCT50G50     | Special 50 MPa 50% SCM | General     |
|               | 65             | LCT50G65     | Special 65 MPa 50% SCM | General     |

|                  |    |             |                        |                  |
|------------------|----|-------------|------------------------|------------------|
| <b>SLCT50</b>    | 32 | SLCT50S32   | Special 32 MPa 50% SCM | Structural       |
|                  | 40 | SLCT50S40   | Special 40 MPa 50% SCM | Structural       |
|                  | 50 | SLCT50S50   | Special 50 MPa 50% SCM | Structural       |
|                  | 65 | SLCT50S65   | Special 65 MPa 50% SCM | Structural       |
|                  | 80 | SLCT50S80   | Special 80 MPa 50% SCM | Structural       |
| <b>LCT60</b>     | 25 | LCT60G25    | Special 25 MPa 60% SCM | General          |
|                  | 32 | LCT60G32    | Special 32 MPa 60% SCM | General          |
|                  | 40 | LCT60G40    | Special 40 MPa 60% SCM | General          |
|                  | 50 | LCT60G50    | Special 50 MPa 60% SCM | General          |
|                  | 65 | LCT60G65    | Special 65 MPa 60% SCM | General          |
| <b>SLCT60</b>    | 32 | SLCT60S32   | Special 32 MPa 60% SCM | Structural       |
|                  | 40 | SLCT60S40   | Special 40 MPa 60% SCM | Structural       |
|                  | 50 | SLCT60S50   | Special 50 MPa 60% SCM | Structural       |
|                  | 65 | SLCT60S65   | Special 65 MPa 60% SCM | Structural       |
|                  | 80 | SLCT60S80   | Special 80 MPa 60% SCM | Structural       |
| <b>LCHP20</b>    | 32 | LCHP20HE32  | Special 32 MPa 20% SCM | High Performance |
|                  | 40 | LCHP20HE40  | Special 40 MPa 20% SCM | High Performance |
|                  | 50 | LCHP20HE50  | Special 50 MPa 20% SCM | High Performance |
| <b>LCHP25</b>    | 32 | LCHP25HE32  | Special 32 MPa 25% SCM | High Performance |
|                  | 40 | LCHP25HE40  | Special 40 MPa 25% SCM | High Performance |
|                  | 50 | LCHP25HE50  | Special 50 MPa 25% SCM | High Performance |
| <b>LCHP30</b>    | 50 | LCHP30HE50  | Special 50 MPa 30% SCM | High Performance |
|                  | 65 | LCHP30HE65  | Special 65 MPa 30% SCM | High Performance |
| <b>LCHP40HPX</b> | 32 | LCHP40HPX32 | Special 32 MPa 40% SCM | High Performance |
|                  | 40 | LCHP40HPX40 | Special 40 MPa 40% SCM | High Performance |
|                  | 50 | LCHP40HPX50 | Special 50 MPa 40% SCM | High Performance |
|                  | 65 | LCHP40HPX65 | Special 65 MPa 40% SCM | High Performance |
| <b>LCHP50HPX</b> | 32 | LCHP40HPX32 | Special 32 MPa 50% SCM | High Performance |
|                  | 40 | LCHP40HPX40 | Special 40 MPa 50% SCM | High Performance |
|                  | 50 | LCHP40HPX50 | Special 50 MPa 50% SCM | High Performance |
|                  | 65 | LCHP40HPX65 | Special 65 MPa 50% SCM | High Performance |
| <b>LCHP60HPX</b> | 32 | LCHP60HPX32 | Special 32 MPa 60% SCM | High Performance |
|                  | 40 | LCHP60HPX40 | Special 40 MPa 60% SCM | High Performance |
|                  | 50 | LCHP60HPX50 | Special 50 MPa 60% SCM | High Performance |
|                  | 65 | LCHP60HPX65 | Special 65 MPa 60% SCM | High Performance |



*Low Carbon Concrete projects:*

**25 Catalina Drive, Majura Avenue**



**Contractor:**  
Construction Control

**Supply period:**  
Nov-2020 to Apr-2022

**Concrete supply:**  
~12,000 m<sup>3</sup>

**GP replacement by SCMs:**  
31%

**Queanbeyan Civic and Cultural Precinct**

**Contractor:**  
ADCO Constructions

**Supply period:**  
Nov-2021 to Oct-2023

**Concrete supply:**  
~7,000 m<sup>3</sup>

**GP replacement by SCMs:**  
34%



**Canberra Hospital Expansion Project**



**Contractor:**  
Multiplex

**Supply period:**  
Mar-2022 to Jul-2024

**Concrete supply:**  
~ 23,000 m<sup>3</sup>

**GP replacement by SCMs:**  
33%

### **AWM Bean Building and Central Energy Plant**



**Contractor:** Hindmarsh

**Supply period:** Oct-2022 to Jul-2024

**Concrete supply:** ~5,000 m<sup>3</sup>

**GP replacement by SCMs:** 31%

### **North Gungahlin High School**

**Contractor:** Hindmarsh

**Supply period:**  
Aug-2023 to Aug-2024

**Concrete supply:** ~6,000 m<sup>3</sup>

**GP replacement by SCMs:** 31%



### **Gugan Galwan Indigenous Youth Centre**



**Contractor:** Projex Building Group

**Supply period:** Mar-2024 to Jun-2024

**Concrete supply:** ~500 m<sup>3</sup>

**GP replacement by SCMs:** 35%

### **ANZAC Park East**

**Contractor:** Construction Control

**Supply period:** Ongoing at time of publication (supply commencing Mar-2024)

**Concrete supply:** ~10,000 m<sup>3</sup> (at time of publication)

**GP replacement by SCMs:** ~35% (at time of publication)



## LCA information

*Declared unit: 1 m<sup>3</sup> of ready-mixed concrete.*

*Reference service life:*

The reference service life is not specified as it is outside the scope of the study (use stage B is excluded).

*Time representativeness:*

Primary input data for all company owned processes in the product stage (A1-A3) and construction stage (A4 but excluding A5) is based on Elvin's annual plant production, fleet and mix data collected in 2023 (1-year data), while the remaining stages and processes rely on secondary input data dating largely to 2018 (6-year data).

*Databases and LCA software used:*

GCCA's Industry EPD Tool for Cement and Concrete (International), developed by GCCA and Quantis, is a web-based calculation tool which was used to create the EPD. The tool produces two major outputs: a self-declaration summary of general information and LCA results, and a background report with the complete set of input data and LCA results, the latter containing all necessary information required to both produce an EPD and for verification purposes. The tool refers to the LCA database provided alongside, this containing background data from ecoinvent (v3.10) (2018) cut-off system model.

*Allocation:*

Allocation procedures were selected according to ISO 14044:2006, clause 4.3.4 and PCRs EN15804:2012+A2:2019. As such, relevant material flows were allocated on a physical (mass) basis, proportional to weighted average plant production capacities. Secondary materials considered as waste products, such as fly ash and silica fume, were allocated on a physical basis. Secondary materials with significant positive economic value were identified as co-products, hence were allocated on an economic basis, such co-products in the scope of the EPD include granulated blast furnace slag from steel production. It is also worth noting that the GGCA Tool allocates impacts from either mass or volumetric inputs (converted to a mass if applicable as part of a mass balance) to the declared unit of 1 m<sup>3</sup> through user-specified concrete densities relative to the product type and composition.

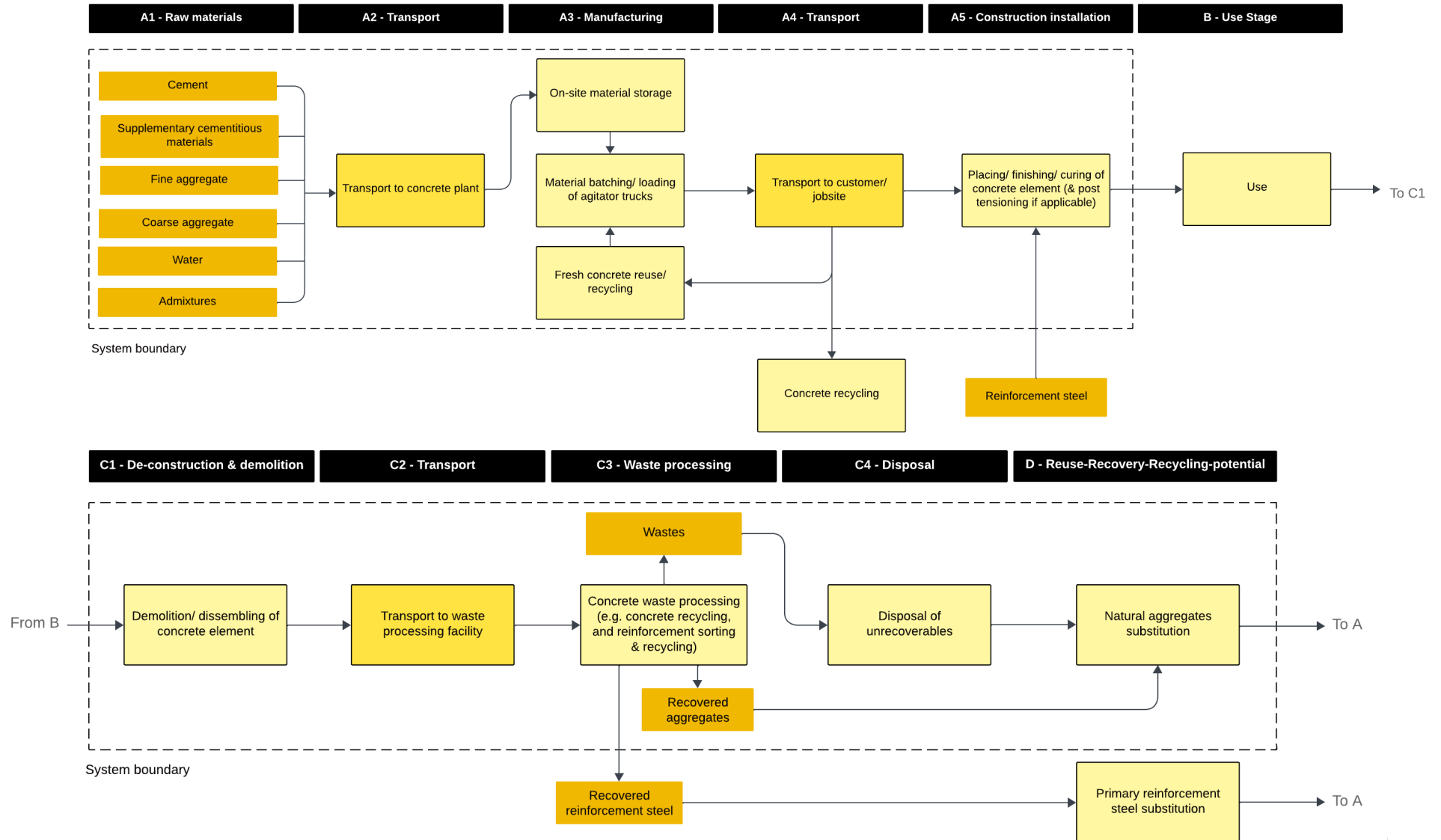
*Cut-off rules:*

No mass and energy flows are excluded from sub-processes using company specific primary data. The only exception to this is the omission of packaging of silica fume additives which accounts for <0.01% of mass inputs to the ready-mixed concrete manufacturing process (refer to *Packaging* for further details). In all processes which reference the ecoinvent database, default cut-off criteria of 1% of total mass input are used, as well as a maximum of 5% cut-off of total mass and energy flows in the stages from cradle to construction, adhering to EN 15804:2012+A2:2019.

*Description of system boundaries:*

The EPD covers the life cycle of GS ready-mixed concrete from cradle to grave (modules A1-A3, A4-A5, C1-C4 & D), excluding module B (use stage). Refer to the system diagram and modules declared below:

System diagram:



Modules declared:

|                        | 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             | X                          | X                         | ND        | ND          | ND     | ND          | ND            | ND                     | ND                    | X                            | X            | X                | X                       | X                                  |
| Geography              | AU + GLO + RER      | GLO + EURO 4 + AU | AU + RoW      | AU + GLO                   | GLO                       | -         | -           | -      | -           | -             | -                      | -                     | GLO                          | GLO + EURO 4 | AU + GLO + RoW   | GLO                     | GLO                                |
| Share of specific data | >60%*               |                   |               | -                          | -                         | -         | -           | -      | -           | -             | -                      | -                     | -                            | -            | -                | -                       | -                                  |
| Variation - products   | <10%                |                   |               | -                          | -                         | -         | -           | -      | -           | -             | -                      | -                     | -                            | -            | -                | -                       | -                                  |
| Variation - sites      | <10%                |                   |               | -                          | -                         | -         | -           | -      | -           | -             | -                      | -                     | -                            | -            | -                | -                       | -                                  |

X – Module declared  
 ND - Module not declared

\* The percentage of specific data is assumed to be larger than 60%, but it cannot be proved since one or several EPDs that are used as data sources lack information on the percentage of specific data used.

*Share of specific data (in GWP-GHG indicator) and data variation:*

For the purpose of the EPD, multiple concrete mixes were combined into a single representative product group through averaging constituent materials, noting GWP-GHG variation between primary and secondary products is <10% absolute. Operational-specific data is averaged across all three plant locations based on weighted annual volume production (m<sup>3</sup>), i.e. 49%, 38% & 13% of production in 2023 from Mitchell, Hume and Fyshwick respectively, noting again the GWP-GHG variation among sites is <10%. Both specific data, from company owned processes and available material and energy primary data, and generic data, sourced largely from GCCA, Quantis and ecoinvent v3.10, is used throughout the LCA process. A combination of specific and generic data is used within upstream stages A1-A4, while remaining downstream stages (A5, C1-C4 and D) rely on the latter.

*Geographical and temporal relevance of data:*

The GGCA EPD Tool uses regionalised data where applicable, utilising ASO (Asia and Oceania) in the current EPD to represent Australia-specific data in exchanges such as:

- Default electricity mix in manufacturing (overwritten in the current EPD with Australia specific)
- Default emission standards for road transport
- Default clinker (not applicable in the current EPD)
- Default cement (clinker factor and MICs) (overwritten in the current EPD with specific third-party cement EPD)

*Data quality:*

A table outlining the processes of the declared modules is found below, stating the relevant data use, sources and corresponding data quality adhering to the UN Environmental Global Guidance on LCA database development scheme from EN 15804-A2.

It is to be noted, the treatment of missing data is managed by the EPD owner through appropriate procedures and documentation used in third-party EPD Process verification. This includes periodic checks (on an annual basis) of all user inputs to the GCCA Tool to identify unaccounted data, assess their cruciality to the EPD process and results, and seek out estimation techniques using primary data as a priority if applicable, or through use of relevant secondary/industry data to estimate data values.

| Stage | Process  | Data used   | Source   | Geography         | Year        | Data Quality |
|-------|--|---|--|-------------------|-------------|--------------|
| A1    | Raw material supply (inclusive of upstream extraction and processing of primary and secondary materials) | Specific cement defined by supplier EPD clinker factor, kiln fuels and emissions, EFs and MICs (overwriting ASO default)  | Cement Australia                                 | AU-NSW / ACT      | 2023        | Very good    |
|       |  | Fly ash from hard coal and silica fume as waste products, and granulated slag from steel production as a co-product (economic allocation)   | GCCA / Quantis / Elvin Group (ACT) data / AusLCI | GLO / AU-NSW / AU | 2018 / 2023 | Good         |
|       |  | Natural crushed aggregates, natural alluvial sand, and manufactured sand  | ecoinvent v3.10                                  | GLO               | 2018        | Good         |
|       |  | Plasticisers and superplasticisers as admixtures  | EFCA   | RER               | 2015        | Fair         |
|       |  | Annual plant mix design and production data (material quantities)   | Elvin Group (ACT) primary data                   | AU-ACT            | 2023        | Very good    |
| A2    | Transport of raw materials to plants   | Product based mode of transport and regionalised emission standards   | ecoinvent v3.10 / GCCA                           | GLO / EURO 4      | 2018        | Good         |
|       |  | Truck distances between raw material manufacturers and Elvin plants   | Elvin Group (ACT) primary data                   | AU-ACT            | 2023        | Very good    |
| A3    | Manufacturing of concrete (including waste management)   | Electricity, water, diesel and gas consumption in plant operation, alongside solar generation and reuse/ recycling logs   | Elvin Group (ACT) primary data                   | AU-ACT            | 2022 / 2023 | Very good    |
|       |  | Australia region-specific electricity mix (overwriting ASO default)   | DCCEEW   | AU                | 2023        | Very good    |
|       |  | On-site transportation fuel emissions (diesel)  | ecoinvent v3.10                                  | RoW               | 2018        | Good         |
| A4    | Transport of concrete to site  | Product based mode of transport – customised as agitator truck with fuel allowances for mixing/ discharge/ washing  | ecoinvent v3.10 / Quantis / GCCA                 | GLO               | 2018        | Good         |
|       |  | Average truck fleet distances between plant and point of use  | Elvin Group (ACT) primary data                   | AU-ACT / NSW      | 2023        | Very good    |
| A5    | Construction-installation process of building  | Diesel powered building machines, electricity consumption, water consumption, wastewater and waste concrete (default 3%)  | ecoinvent v3.10 / Quantis                        | GLO               | 2018        | Good         |
| C1    | Deconstruction – demolition of concrete structure  | Diesel powered building machines and particulate emissions  | ecoinvent v3.10 / Quantis                        | GLO               | 2018        | Good         |
| C2    | Transport of demolished concrete to end-of-life processing   | Product based mode of transport and regionalised emission standards   | ecoinvent v3.10 / GCCA LCA Model report          | GLO / EURO 4      | 2018        | Good         |
|       |  | Transport distance from demolition to waste processing facilities is estimated from Model for LCA of buildings  | JRC Technical report                             | EU27              | 2018        | Good         |
| C3    | Waste processing and recovery of concrete  | Waste concrete processing at dry sorting plant, using electricity and excavation by hydraulic digger, specified by recycling rate (specific Australia C&D recovery rate)  | ecoinvent v3.10 / Quantis                        | GLO / RoW / AU    | 2018 / 2022 | Good         |
| C4    | Disposal of unrecoverables   | Inert material to landfill, including recarbonation   | ecoinvent v3.10 / Quantis                        | GLO               | 2018        | Good         |
| D     | Benefits and loads of recycled materials   | Concrete and steel: difference between impacts of recycling 1 kg of material and impacts of 1 kg primary material avoided, multiplied by mass flow sent to recycling minus initial recycled material content, including recarbonation | ecoinvent v3.10 / GCCA LCA                       | GLO/ RoW          | 2018        | Good         |

### *Company-specific Manufacturing Process (Module A3):*

ISO 14044 Section 5.2 requires company-specific processes to be described in qualitative and quantitative detail. The manufacturing of concrete products at each plant location first consists of delivered raw material storage in silos (cement, fly ash and slag), bins (sand and aggregates) and tanks (admixtures and water). These raw materials serve as mass inputs to the manufacturing process, consisting of the precise weighing and batching through computer-controlled systems and plant equipment (such as conveyer belts). The operation of batching plant systems requires the consumption of electricity from the grid; however, on-site solar generation is provided to the grid as a co-product.

On-site transportation via diesel powered loaders is required to transfer sand and aggregates to the weighing and batching plant, whereas powdered and liquid material is discharged directly from storage. Additionally, for concrete mixes requiring hot water, natural gas is consumed in the heat exchanging system.

Batched materials are loaded into agitator trucks where they are thoroughly mixed to create a consistent concrete mix, ready for transport to site. Before this occurs, the trucks are washed with water to ensure no material or debris is present on the exterior, this water which is reclaimed and recycled where possible.

Lastly, output flows (apart from the concrete product) from the manufacturing process consist of components for reuse and materials or waste to recycling. Waste management systems ensure the reuse of leftover concrete where appropriate and according to AS1379, as well as the use of the on-site recycler to separate water, aggregates and sludge sheets from unused loads if viable or alternatively, the production of hardened/crushed concrete for landscaping purposes.

Quantitative manufacturing process data is addressed in the EPD Process procedures and documentation developed and maintained by Elvin Group (ACT) for third-party verification.

### *Key Assumptions & Limitations:*

1. Plant specific data is collected over a period of 1 year (from January to December) and is thereby representative of the annual collection period.
2. Gross GWP is reported which includes the greenhouse gas emissions from the incineration of secondary fuels in clinker production.
3. Environmental exposure classes of A1 & A2 are selected based on concrete mix design and usage.
4. Transport of raw materials are representative of bulk one-way delivery. Distances are estimated from direct routes of origin to destination and weighted by 2023 annual plant production.
5. Grid purchased electricity is based on the reported 2023 Australian energy mix, overwriting the default GCCA ASO regionalised electricity mix. For this EPD, the energy mix comprises of coal (46.0%), oil (1.78%), natural gas (17.1%), wind (11.7%), solar (16.5%), biofuels and waste (1.14%) and hydro (5.85%). The grid purchased electricity climate impact (GWP-GHG) is 0.72 kg CO<sub>2</sub> eq./kWh.
6. Transport of concrete to site accounts for the entirety of distance travelled by truck fleet in 2023.
7. Onsite transport by loaders and forklifts accounts for the entirety of fuel consumption in 2023.
8. No hazardous or non-hazardous waste is directly produced during the manufacturing stage of the EPD as all non-product output flows are accounted for as either components for reuse or materials/waste for recycling (as determined by waste management logs).



9. Annual batching and mix production exports from plant operation software programs are used in determining the material quantities consumed and total quantities of concrete produced.
10. To account for seasonal changes, the average of summer and winter admixture dosage extremes are used in concrete mix design quantities.
11. Default approaches for recarbonation are implemented in the GCCA Tool during the Waste Processing (C3) and Disposal (C4) modules and are thus reflected in the EPD results. See *Additional information* for more detail.
12. End of life treatment of concrete is based on the scenario outlined by GCCA where at the end of its use stage (excluded from the system boundary), concrete products are demolished, crushed and followed by either landfilling or recycling for primary aggregate substitution (module D). A recycling rate of 78% is adopted from the 2022 National Waste Report which indicates the recovery of C&D waste in Australia in 2020-21. Refer to *Additional Information* for further detail on module C end of life scenarios.
13. The environmental performance of concrete products is reflective of the quality and accuracy of primary and generic data used within the LCA process.

*More information:*

The GCCA EPD Tool can be found online at <https://concrete-epd-tool.org/>

The Tool references the database: GCCA\_EPD-Tool\_LCA-Database-v4.0\_2023-04-28.xlsx'.

Refer to the GCCA LCA Model report and User Guide for additional information on assumptions, data quality, allocation, declared stages and associated processes/ exchanges accounted for in the LCA study.

All necessary procedures and documentation have been created and managed by Elvin Group (ACT) for third-party verification. Included in this documentation is the study goal, treatment of missing data, comprehensive company-specific data and relevant assumptions and explanations used in primary data preparation.

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## Content information

The table below provides estimated contributions of materials used in the entire range of GS ready-mixed concrete produced by Elvin Group (ACT) on a weight basis (w/w%):

| Product components | Content (%) |
|--------------------|-------------|
| GP cement          | 5 – 19      |
| SCMs               | 3 – 17      |
| Coarse aggregates  | 28 – 43     |
| Fine aggregates    | 22 – 46     |
| Admixtures         | 0.1 – 0.3   |
| Water              | 7 – 8       |

No dangerous substances from the candidate list of SVHC are reported, or these are negligible.

### *Packaging*

No packaging is declared as the materials used in concrete production are delivered to Elvin Group (ACT) in bulk and transported directly from plants to site via agitator truck.

It is noted that silica fume arrives at the plants pre-packaged in paper bags, however, as mentioned in *Cut-off rules* the quantities of packaging are excluded in the ready-mixed concrete manufacturing process. The quantity of packaging of silica fume used in the entire process is estimated as <0.01% by mass. Additionally, this packaging is not considered hazardous and does not introduce any significant effects or energy use in their extraction, use or disposal, and thus affirms the omission of silica fume packaging.

### *Co-products and recycled materials*

As beforementioned in *Allocation*, the SCM of slag is considered as a co-product of relevant production processes and therefore introduces economically allocated impacts. The SCMs of fly ash and silica fume are considered as waste products, and hence only introduce impacts in their transport to plant. In addition to co-products, Elvin Group (ACT)'s GS concrete products comprise of recycled waste materials. Up to 83% of fresh water is replaced by recycled and/or reclaimed water, consisting of reclaimed water from on-site recycling facilities. Similarly, fine aggregates consist of a 50:50 blend of natural and manufactured sand, the latter collected as a waste dust from quarry operation.

## Product identification

A summary of the properties of the GS ready-mixed concrete product group covered in this EPD is provided below:

| Product Identification      |                          |
|-----------------------------|--------------------------|
| Product name                | GS SLCF40S80 80 MPa      |
| Product code                | SLCF40S80                |
| EPD registration code       | EPD-IES-0019670:001      |
| Description                 | Special 80 MPa 40% SCM   |
| Application                 | Structural               |
| Strength                    | 80 MPa                   |
| Density                     | 2330 kg/m <sup>3</sup>   |
| Functional unit             | 1 m <sup>3</sup>         |
| LCA scope                   | Modules A1-A5, C1-C4 & D |
| Geographical region         | Australia                |
| Primary data reference year | 2023                     |

## Environmental information

The environmental indicators used in the EPD are listed below with their abbreviations and units:

| Indicator  | Abbreviation   | Units                                |
|--|----------------|--------------------------------------|
| <b>Core environmental impact indicators</b>  |                |                                      |
| Global Warming Potential total   | GWP-total      | kg CO <sub>2</sub> eq.               |
| Global Warming Potential fossil fuels  | GWP-fossil     | kg CO <sub>2</sub> eq.               |
| Global Warming Potential biogenic  | GWP-biogenic   | kg CO <sub>2</sub> eq.               |
| Global Warming Potential land use and land use change  | GWP-luluc      | kg CO <sub>2</sub> eq.               |
| Depletion potential of the stratospheric ozone layer   | ODP            | kg CFC 11 eq.                        |
| Acidification potential, Accumulated Exceedance  | AP             | mol H <sup>+</sup> eq.               |
| Eutrophication potential, fraction of nutrients reaching freshwater end compartment                        | EP-freshwater  | kg PO <sub>4</sub> <sup>3-</sup> eq. |
| Eutrophication potential, fraction of nutrients reaching freshwater end compartment                        | EP-freshwater  | kg P eq.                             |
| Eutrophication potential, fraction of nutrients reaching marine end compartment                            | EP-marine      | kg N eq.                             |
| Eutrophication potential, Accumulated Exceedance   | EP-terrestrial | mol N eq.                            |
| Formation potential of tropospheric ozone  | POCP           | kg NMVOC eq.                         |
| Abiotic depletion potential for non-fossil resources   | ADPE**         | kg Sb eq.                            |
| Abiotic depletion for fossil resources potential   | ADPF**         | MJ                                   |
| Water (user) deprivation potential, deprivation-weighted water consumption                                 | WDP            | m <sup>3</sup>                       |
| <b>Additional environmental impact indicators</b>  |                |                                      |
| Global Warming Potential greenhouse gas  | GWP-GHG*       | kg CO <sub>2</sub> eq.               |
| Potential incidence of disease due to pm emissions   | PM             | Disease incidence                    |
| Potential human exposure efficiency relative to U235   | IRP            | kBq U235 eq.                         |
| Potential comparative toxic unit for ecosystems  | ETP            | CTUe                                 |
| Potential comparative toxic unit for humans  | HTPC           | CTUh                                 |
| Potential comparative toxic unit for humans  | HTPNC          | CTUh                                 |
| Potential soil quality index   | SQP            | dimensionless                        |
| <b>Parameters describing resource use</b>  |                |                                      |
| Use of renewable primary energy excluding renewable primary energy resources used as raw materials         | PERE           | MJ                                   |
| Use of renewable primary energy resources used as raw materials  | PERM           | MJ                                   |
| Total use of renewable primary energy resources  | PERT           | MJ                                   |
| Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials | PENRE          | MJ                                   |
| Use of non-renewable primary energy resources used as raw materials  | PENRM          | MJ                                   |
| Total use of non-renewable primary energy resources  | PENRT          | MJ                                   |
| Use of secondary material  | SM             | kg                                   |

|                                      |      |                |
|--------------------------------------|------|----------------|
| Use of renewable secondary fuels     | RSF  | MJ             |
| Use of non-renewable secondary fuels | NRSF | MJ             |
| Use of net fresh water               | FW   | m <sup>3</sup> |

#### Information describing waste categories

|                              |      |    |
|------------------------------|------|----|
| Hazardous waste disposed     | HWD  | kg |
| Non-hazardous waste disposed | NHWD | kg |
| Radioactive waste disposed   | RWD  | kg |

#### Outputs

|                               |        |    |
|-------------------------------|--------|----|
| Components for re-use         | CFR    | kg |
| Material for recycling        | MFR    | kg |
| Materials for energy recovery | MFEE   | kg |
| Exported energy, electricity  | EE - e | MJ |
| Exported energy, thermal      | EE - t | MJ |

#### Extra indicators

|   |          |                        |
|---|----------|------------------------|
| Emissions from calcination and removals from carbonation                                  | CC       | kg CO <sub>2</sub> eq. |
| Emissions from combustion of waste from renewable sources                                 | CWRS     | kg CO <sub>2</sub> eq. |
| Emissions from combustion of waste from non-renewable sources                             | CWNRS    | kg CO <sub>2</sub> eq. |
| Removals and emissions associated with biogenic carbon content of the bio-based product   | GWP-prod | kg CO <sub>2</sub> eq. |
| Removals and emissions associated with biogenic carbon content of the bio-based packaging | GWP-pack | kg CO <sub>2</sub> eq. |

#### Notes

The LCIA results are relative expressions and do not predict impacts on category endpoints, the exceeding of thresholds, safety margins or risks.

Module C is included in the EPD; this it is discouraged to use the results of modules A1-A3 (A1-A5 for services) without considering the results of module C.

## Product Environmental Performance

### Potential environmental impact – mandatory indicators according to EN 15

| Indicator      | Unit                                 | SLCF40S80 |          |          |          |          |          |           |           |
|----------------|--------------------------------------|-----------|----------|----------|----------|----------|----------|-----------|-----------|
|                |                                      | A1-A3     | A4       | A5       | C1       | C2       | C3       | C4        | D         |
| GWP-total      | kg CO <sub>2</sub> eq.               | 3.81E+02  | 1.94E+00 | 2.09E+01 | 9.64E+00 | 1.01E+01 | 2.86E+00 | -3.28E+00 | -1.31E+01 |
| GWP-fossil     | kg CO <sub>2</sub> eq.               | 3.80E+02  | 1.94E+00 | 2.09E+01 | 9.63E+00 | 1.01E+01 | 2.85E+00 | -3.28E+00 | -1.30E+01 |
| GWP-biogenic   | kg CO <sub>2</sub> eq.               | 1.73E-01  | 7.95E-05 | 1.53E-02 | 1.05E-03 | 2.16E-03 | 6.60E-03 | 4.40E-04  | -3.25E-02 |
| GWP-luluc      | kg CO <sub>2</sub> eq.               | 5.75E-02  | 7.86E-04 | 4.37E-03 | 8.36E-04 | 4.84E-03 | 6.80E-03 | 1.64E-03  | -1.03E-02 |
| ODP            | kg CFC 11 eq.                        | 7.69E-06  | 3.02E-08 | 4.34E-07 | 1.47E-07 | 1.46E-07 | 4.23E-08 | 9.23E-08  | -1.06E-07 |
| AP             | mol H <sup>+</sup> eq.               | 2.13E+00  | 8.07E-03 | 1.46E-01 | 8.69E-02 | 5.24E-02 | 3.06E-02 | 2.26E-02  | -8.24E-02 |
| EP-freshwater  | kg PO <sub>4</sub> <sup>3-</sup> eq. | 2.41E-01  | 1.49E-04 | 8.63E-03 | 2.75E-04 | 1.01E-03 | 2.25E-03 | 2.59E-04  | -3.53E-03 |
| EP-freshwater  | kg P eq.                             | 8.03E-02  | 4.97E-05 | 2.88E-03 | 9.17E-05 | 3.38E-04 | 7.50E-04 | 8.65E-05  | -1.18E-03 |
| EP-marine      | kg N eq.                             | 8.44E-02  | 2.94E-03 | 3.30E-02 | 4.03E-02 | 1.96E-02 | 7.08E-03 | 8.62E-03  | -1.95E-02 |
| EP-terrestrial | mol N eq.                            | 4.39E+00  | 3.20E-02 | 4.58E-01 | 4.41E-01 | 2.13E-01 | 7.35E-02 | 9.41E-02  | -2.48E-01 |
| POCP           | kg NMVOC eq.                         | 1.14E+00  | 1.17E-02 | 1.32E-01 | 1.32E-01 | 7.15E-02 | 2.20E-02 | 3.37E-02  | -6.71E-02 |
| ADPE*          | kg Sb eq.                            | 2.38E-04  | 5.45E-06 | 2.62E-05 | 3.53E-06 | 2.76E-05 | 2.91E-05 | 5.09E-06  | -6.92E-05 |
| ADPF*          | MJ                                   | 2.71E+03  | 2.83E+01 | 2.05E+02 | 1.26E+02 | 1.42E+02 | 7.15E+01 | 7.83E+01  | -1.56E+02 |
| WDP*           | m <sup>3</sup>                       | 5.63E+01  | 1.36E-01 | 2.44E+00 | 3.09E-01 | 8.28E-01 | 1.14E+00 | 2.19E-01  | -2.62E+01 |

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

### Potential environmental impact – additional mandatory and voluntary indicators

| Indicator | Unit                   | SLCF40S80 |          |          |          |          |          |           |           |
|-----------|------------------------|-----------|----------|----------|----------|----------|----------|-----------|-----------|
|           |                        | A1-A3     | A4       | A5       | C1       | C2       | C3       | C4        | D         |
| GWP-GHG*  | kg CO <sub>2</sub> eq. | 3.81E+02  | 1.94E+00 | 2.09E+01 | 9.64E+00 | 1.01E+01 | 2.86E+00 | -3.28E+00 | -1.31E+01 |
| PM        | Disease incidence      | 1.40E-05  | 1.98E-07 | 2.11E-06 | 2.47E-06 | 1.10E-06 | 3.55E-07 | 5.14E-07  | -1.34E-06 |
| IRP       | kBq U235 eq.           | 3.70E+03  | 2.50E-02 | 1.11E+02 | 5.65E-02 | 1.83E-01 | 6.82E-01 | 4.99E-02  | -1.13E+00 |
| ETP       | CTUe                   | 2.12E+02  | 6.80E+00 | 1.73E+02 | 1.79E+01 | 4.09E+01 | 1.76E+01 | 1.07E+01  | -8.36E+01 |
| HTPC      | CTUh                   | 1.09E-06  | 9.68E-09 | 7.40E-08 | 3.77E-08 | 6.46E-08 | 1.37E-08 | 1.44E-08  | -1.54E-07 |
| HTPNC     | CTUh                   | 2.24E-05  | 1.87E-08 | 7.31E-07 | 1.72E-08 | 9.11E-08 | 4.99E-08 | 1.41E-08  | -1.06E-07 |
| SQP       | dimensionless          | 1.48E+03  | 2.85E+01 | 7.32E+01 | 8.86E+00 | 1.32E+02 | 3.90E+01 | 1.54E+02  | -1.66E+02 |

### Use of resources

| Indicator | Unit           | SLCF40S80 |          |          |          |          |          |          |           |
|-----------|----------------|-----------|----------|----------|----------|----------|----------|----------|-----------|
|           |                | A1-A3     | A4       | A5       | C1       | C2       | C3       | C4       | D         |
| PERE      | MJ             | 2.95E+01  | 3.72E-01 | 6.23E+00 | 7.73E-01 | 2.77E+00 | 9.09E+00 | 7.27E-01 | -1.30E+01 |
| PERM      | MJ             | 0.00E+00  | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  |
| PERT      | MJ             | 2.95E+01  | 3.72E-01 | 6.23E+00 | 7.73E-01 | 2.77E+00 | 9.09E+00 | 7.27E-01 | -1.30E+01 |
| PENRE     | MJ             | 6.55E+02  | 2.83E+01 | 1.44E+02 | 1.26E+02 | 1.42E+02 | 7.15E+01 | 7.83E+01 | -1.56E+02 |
| PENRM     | MJ             | 0.00E+00  | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  |
| PENRT     | MJ             | 6.55E+02  | 2.83E+01 | 1.44E+02 | 1.26E+02 | 1.42E+02 | 7.15E+01 | 7.83E+01 | -1.56E+02 |
| SM        | kg             | 5.94E+02  | 0.00E+00 | 1.78E+01 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  |
| RSF       | MJ             | 4.24E+01  | 0.00E+00 | 1.27E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  |
| NRSF      | MJ             | 5.70E+01  | 0.00E+00 | 1.71E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  |
| FW        | m <sup>3</sup> | 9.90E-01  | 4.17E-03 | 4.71E-02 | 8.19E-03 | 2.37E-02 | 3.25E-02 | 8.12E-02 | -6.20E-01 |

\* This indicator accounts for all greenhouse gases except biogenic carbon dioxide uptake and emissions and biogenic carbon stored in the product. As such, the indicator is identical to GWP-total except that the CF for biogenic CO<sub>2</sub> is set to zero.

### Waste production and output flows

| Indicator | Unit | SLCF40S80 |          |          |          |          |          |          |           |
|-----------|------|-----------|----------|----------|----------|----------|----------|----------|-----------|
|           |      | A1-A3     | A4       | A5       | C1       | C2       | C3       | C4       | D         |
| HWD       | kg   | 0.00E+00  | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  |
| NHWD      | kg   | 7.13E-02  | 0.00E+00 | 1.56E+01 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 5.18E+02 | 0.00E+00  |
| RWD       | kg   | 2.86E-04  | 6.11E-06 | 5.75E-05 | 1.38E-05 | 4.50E-05 | 1.67E-04 | 1.22E-05 | -2.74E-04 |
| CFR       | kg   | 1.12E+01  | 0.00E+00 | 3.36E-01 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  |
| MFR       | kg   | 1.38E+02  | 0.00E+00 | 5.84E+01 | 0.00E+00 | 0.00E+00 | 1.81E+03 | 0.00E+00 | 0.00E+00  |
| MFEE      | kg   | 0.00E+00  | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  |
| EE - e    | MJ   | 1.27E+00  | 0.00E+00 | 3.81E-02 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  |
| EE - t    | MJ   | 0.00E+00  | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  |

### Extra environmental Indicators

| Indicator | Unit                   | SLCF40S80 |          |          |          |          |           |           |          |
|-----------|------------------------|-----------|----------|----------|----------|----------|-----------|-----------|----------|
|           |                        | A1-A3     | A4       | A5       | C1       | C2       | C3        | C4        | D        |
| CC        | kg CO <sub>2</sub> eq. | 1.85E+02  | 0.00E+00 | 5.27E+00 | 0.00E+00 | 0.00E+00 | -2.69E+00 | -6.47E+00 | 0.00E+00 |
| CWRS      | kg CO <sub>2</sub> eq. | 4.20E-02  | 0.00E+00 | 1.26E-03 | 0.00E+00 | 0.00E+00 | 0.00E+00  | 0.00E+00  | 0.00E+00 |
| CWNRS     | kg CO <sub>2</sub> eq. | 9.86E-01  | 0.00E+00 | 2.96E-02 | 0.00E+00 | 0.00E+00 | 0.00E+00  | 0.00E+00  | 0.00E+00 |
| GWP-prod  | kg CO <sub>2</sub> eq. | 0.00E+00  | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  | 0.00E+00  | 0.00E+00 |
| GWP-pack  | kg CO <sub>2</sub> eq. | 0.00E+00  | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00 | 0.00E+00  | 0.00E+00  | 0.00E+00 |



## Additional information

### *Module C - End of life scenarios*

The end of life of ready-mixed concrete products is based on generic scenarios as detailed in EN 15804:2012+A2:2019 and EN 16757:2022:

- C1, de-construction, demolition
- C2, transport to waste processing
- C3, Waste processing for reuse, recycling and energy recovery
- C4, disposal and the associated processes

In particular, EN 16757:2022 outlines four specific waste processing scenarios for module C3, each introducing benefits and loads outside the system boundary except for scenario 1:

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

In the current EPD, end of life treatment of concrete is based on scenario 4ii, described by GCCA where at the end of its use stage, concrete products are demolished, crushed and followed by either landfilling or recycling through a region-specific recycling rate. The recycling of concrete in this scenario allows the substitution of natural aggregates in fresh concrete and depending on the product system boundary, also steel reinforcement in primary material inputs (steel reinforcement is excluded from the system boundary in the current EPD). The GCCA Tool also considers incineration and energy recovery as part of waste processing, however, this is not applicable to the geographical region of the EPD.

The recycled crushed concrete is considered to have reached its end of waste state once subjected to further processing to separate by size fraction and stockpiled, and with immediate market demand. The crushed recycled aggregates as an output of C3 then enters module D to replace virgin crushed aggregates, introducing benefits and loads beyond the system boundary.

### *Module C - Recarbonation*

As stated by GCCA, carbonation of concrete is a process by which CO<sub>2</sub> in the ambient air penetrates the concrete, reacts with hydration products to form carbonates. Recarbonation is accounted for by GCCA at both waste processing (C3) and disposal (C4) stages, as presented in the GCCA LCA Model. The modelling for recarbonation during the life cycle of the concrete products follows the guidance provided in EN 16757 – Annex BB – CO<sub>2</sub> uptake by carbonation – Guidance on calculation, and EN 15804 – Annex C.

## Differences versus previous versions

No previous versions of this EPD exist.

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