



# Environmental Product Declaration

## BILLETS

**Based on:**

PCR 2019:14  
Construction products  
v1.3.4  
EN:15804:2012+A2:2019  
ISO 14025:2006

**Programme:**

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

**Registration N°:**

EPD-IES-0017968

**CPC code:**

411

**Programme operator:**

EPD International AB

**Date of issue:**

2025-01-17

**Valid until:**

2030-01-16

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)





# General information

## EPD REFERENCES

EPD OWNER: ESF ELBE-STÄHLWERKE FERALPI GMBH, GRÖBAER STRASSE 3, 01591 RIESA  
Manufacturing plant is located in the same site

PROGRAMME OPERATOR: EPD International AB, box 21060, SE-100 31 Stockholm, Sweden; [info@environdec.com](mailto:info@environdec.com)

NEW EPD

## INDEPENDENT VERIFICATION

This declaration has been developed referring to the International EPD System, following the General Programme Instructions v 4.0; further information and the document itself are available at: [www.environdec.com](http://www.environdec.com).  
EPD document valid within the following geographical area: Germany and other countries worldwide according to sales market conditions.

ISO standard ISO 21930 and CEN standard EN 15804 served as the core PCR  
PCR 2019:14 Construction products, Version 1.3.4  
PCR review was conducted by: The Technical Committee of the International EPD® System. See [www.environdec.com/TC](http://www.environdec.com/TC) for a list of members. Review chair: Claudia A. Peña, University of Concepción, Chile.  
The review panel may be contacted via the Secretariat [www.environdec.com/contact](http://www.environdec.com/contact).

Independent verification of the declaration and data, according to EN ISO 14025 : 2010

Third party verifier: ICMQ SpA,  
via De Castillia, 10 20124 Milano  
([www.icmq.it](http://www.icmq.it))

☐ EPD process  
certification  
(Internal)

☒ EPD verification  
(External)

Accredited by: Accredia n. 0004VV

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

☐ YES

☒ NO

EPDs within the same product category but registered in different EPD programmes may not be comparable. For two EPDs to be comparable, they shall be based on the same PCR (including the same version number up to the first two digits20) 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.

The EPD owner has the sole ownership, liability, and responsibility for the EPD.

## CONTACTS

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Technical support to Feralpi Stahl was provided by Life Cycle Engineering, Italy.  
([info@lcengineering.eu](mailto:info@lcengineering.eu), [www.lcengineering.eu](http://www.lcengineering.eu)).





# Company profile

**THE FERALPI GROUP** is one of Europe's leading manufacturers of steels for use in infrastructure and construction.

The German site of the Feralpi Group, **ESF ELBE-STAHLWERKE FERALPI GMBH** (ESF), has developed into a company with a wide range of products in the field of reinforcement steel since it was founded in 1992. Through constant modernisation of our facilities, our products guarantee a high standard of quality parameters so that we can meet the requirements of our customers. ESF is continuously monitoring developments in the reinforcement steel sector in the future and incorporate them into innovative technologies and production processes. This serves not least to strive for and fulfill the goal of continuously improving our efficiency in terms of processes and resources - and thus the environmental performance of our business activities. In addition to the production areas of steelworks, rolling mill and wire processing, there is also the plant logistics department (including the connecting railway), which is responsible for all internal and external loading processes.

The steel produced by ESF Elbe-Stahlwerke Feralpi GmbH is made exclusively from scrap with the EAF route. Utilising scrap as a raw material for steel production makes an important contribution to conserving natural resources.

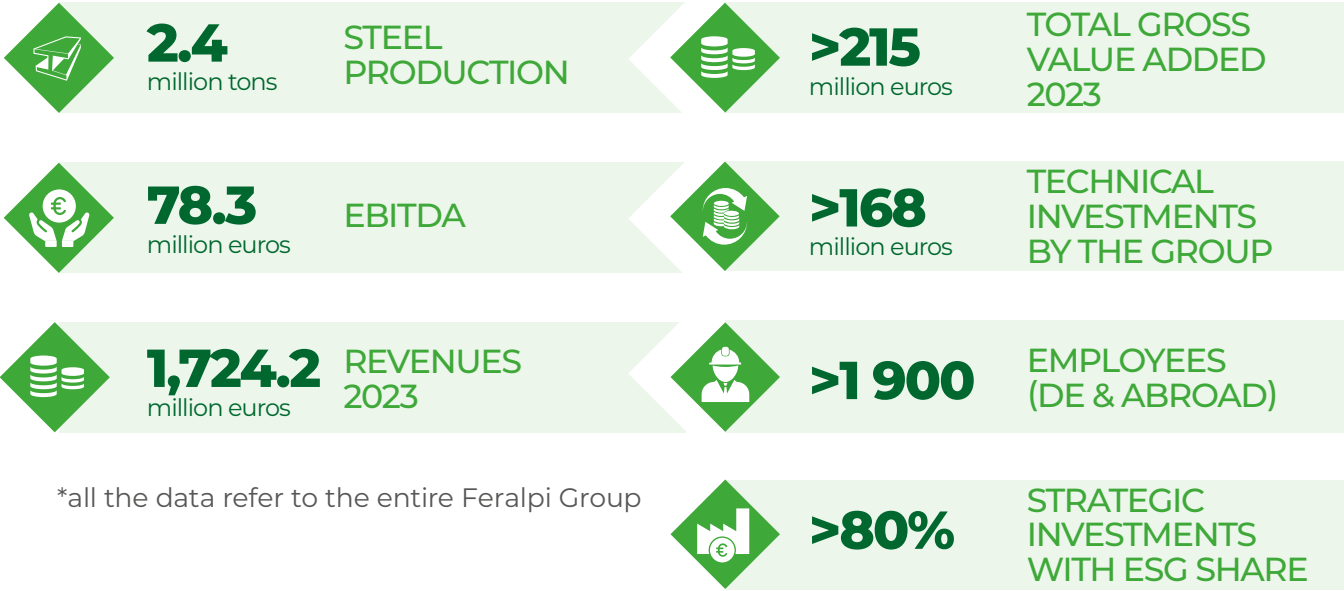
The management systems implemented at the entire company site have been merged into an Integrated Management System (IMS) since 2015. The IMS includes the requirements of the standards DIN EN ISO 9001, DIN EN ISO 14001, EMAS III, and DIN EN ISO 50001 as well as the monitoring of the specialised waste management company in accordance with Sections 56 and 57 KrWG and, in addition to ESF, also includes Feralpi Stahlhandel GmbH and Feralpi-Logistik GmbH.

**Environmental protection, energy efficiency and the circular economy** determine the production processes. New technologies, environmental protection and energy efficiency measures are consistently implemented. The basis for the continuous improvement of environmental performance is a functioning environmental and energy management system that integrates all processes and stakeholders: from waste avoidance to reducing energy consumption.

For EPD purposes: ISO standard ISO 21930 compliance has been included in order to allow the selling outside Europe.



## FERALPI GROUP | KEY FIGURES 2023\*



**Riesa**

ESF Elbe-Stahlwerke  
Feralpi GmbH  
established in  
1992

# Scope and Type of EPD

THE APPROACH USED IN THIS EPD IS “CRADLE-TO-GATE WITH OPTIONS” WITH OPTIONAL MODULES (A4).

Table of modules

	PRODUCT STAGE			CONSTRUCTION PROCESS STAGE		UTILISATION STAGE							END OF LIFE STAGE				BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARIES
	Raw material supply	Transport	Manufacturing	Transport to the site	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction 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	✓	✓	✓	✓	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND
geography	DE	DE	DE	EU	-	-	-	-	-	-	-	-	MND	MND	MND	MND	MND
specific data used	>90%			-	-	-	-	-	-	-	-	-	-	-	-	-	-
variations - products	0%			-	-	-	-	-	-	-	-	-	-	-	-	-	-
variations - sites	0%			-	-	-	-	-	-	-	-	-	-	-	-	-	-

**SOFTWARE:** SimaPro ver. 9.6  
**MAIN DATABASE:** Ecoinvent 3.10  
**REPORT LCA:** Life cycle assessment applied to billet, wire rod, reinforcing steel bars, reinforcing steel in coils and electrowelded mesh  
**GEOGRAPHICAL SCOPE OF THE EPD:** Europe according to sales market conditions  
**TYPE OF EPD:** Specific for Crude steel

# The product

**Billets** are semi-finished products with a square cross-section that are produced in the steelworks of ESF Elbe-Stahlwerke Feralpi GmbH using the continuous casting process. The billets are used as input material for the hot rolling process.

**The main materials of the final product are:** iron > 96%; alloy elements 2% c.a.; other elements complementary to 100%; for (post-consumer) recycled content see section Other optional additional environmental information.

**Declared unit for the study is one tonne of billets.**

SVHC Information: The product does not contain any hazardous substance according to REACH Regulation.

INFORMATION	DESCRIPTION
PRODUCT DESCRIPTION	Billet (semi-finished product/semi-finished product that can be further processed into reinforcing bars, ribbed or smooth wire rod / or other rolled products such as profile steels )
STEEL GRADE	Crude steel from post and pre-consumer scrap
PRODUCTION ROUTE	EAF
DIAMETER RANGE	130 mm x 130 mm; 140 mm x 140 mm; 150 mm X 150 mm; 160 mm x 160 mm (standard)
PRODUCTIONS	Total amount of products covered by this EPD, year 2023: 81 163 t
	Total production, for selling purpose, year 2023: 81 163 t

# Environmental performance

The detailed environmental performance (in terms of use of resources, pollutant emissions and waste generation) is presented for the three phases **Upstream, Core** related sub-phases (A1-A2-A3). The numbers reported in the following tables are the outcome of rounding. For this reason total results could slightly differ from the sum of contributions of the different phases.

The energy sources behind the electricity grid used in manufacturing is a mix between German Supplier mix 2023 and renewable energy with Guarantees of Origin related network losses and transformation. Final emission factor is 0,22 kg CO<sub>2</sub> eq./kWh.

The estimated impact results are only relative statements which do not indicate the end points of the impact categories, exceeding threshold values, safety margins or risks.

Environmental impacts per declared unit

	UNITS	UPSTREAM - CORE PROCESS	DOWNSTREAM
		A1:A3	A4
GWP	kg CO <sub>2</sub> eq	2.89E+02	1.57E+01
GWP,f	kg CO <sub>2</sub> eq	2.88E+02	1.57E+01
GWP,b	kg CO <sub>2</sub> eq	1.62E-01	3.07E-02
GWP,luluc	kg CO <sub>2</sub> eq	1.54E-01	4.19E-02
GWP,ghg	kg CO <sub>2</sub> eq	2.89E+02	1.57E+01
ODP	kg CFC-11 eq	2.49E-06	2.59E-07
AP	mol H+ eq	1.06E+00	9.26E-02
EP,f	kg P eq	1.16E-02	1.29E-03
EP,m	kg N eq	2.56E-01	2.18E-02
EP,t	mol N eq	2.86E+00	2.41E-01
POCP	kgNMVOCeq	8.89E-01	7.38E-02
ADP,e*	kg Sb eq	1.99E-04	9.09E-07
ADP,f*	MJ	3.36E+03	3.52E+02
WDP*	m <sup>3</sup>	3.58E+01	3.51E+00

**GWP** Global warming potential, total  
**GWP,f** Global warming potential, fossil  
**GWP,b** Global warming potential, biogenic  
**GWP,luluc** Global warming potential, land use & land use change  
**GWP,ghg** Global warming potential, excluding biogenic uptake, emission and storage

**ODP** Ozone depletion potential  
**AP** Acidification potential  
**EP,f** Eutrophication potential, freshwater  
**EP,m** Eutrophication potential, marine  
**EP,t** Eutrophication potential, terrestrial  
**POCP** Photochemical ozone creation potential  
**ADP,e** Abiotic depletion potential minerals

& metals\*  
**ADP,f** Abiotic depletion potential fossil fuels\*  
**WDP** Water use deprivation potential\*  
\*: The results of these environmental impact indicators shall be used with care as the uncertainties on these results are high or as there is limited experience with the indicator.

# Environmental performance

Additional environmental impacts per declared unit

	UNITS	UPSTREAM - CORE PROCESS	DOWNSTREAM
		A1:A3	A4
PM	disease inc.	5.04E-05	7.48E-07
IRP**	kBq U-235 eq	5.16E+00	2.89E+00
ETP,fw*	CTUe	3.08E+03	8.03E+00
HTP,c*	CTUh	9.00E-06	4.48E-09
HTP,nc*	CTUh	1.99E-06	8.06E-08
SQP*	Pt	5.86E+02	4.60E+01

Resource use per declared unit

	UNITS	UPSTREAM - CORE PROCESS	DOWNSTREAM
		A1:A3	A4
PERE	MJ	1.06E+03	7.41E+01
PERM	MJ	2.29E-03	0.00E+00
PERT	MJ	1.06E+03	7.41E+01
PENRE	MJ	3.36E+03	3.52E+02
PENRM	MJ	3.21E-01	0.00E+00
PENRT	MJ	3.36E+03	3.52E+02
SM	kg	1.06E+03	0.00E+00
RSF	MJ	0.00E+00	0.00E+00
NRSF	MJ	0.00E+00	0.00E+00
FW	m <sup>3</sup>	5.08E+00	2.67E-01

Additional environmental impact indicators are computed in the LCA report but not reported in the EPD.  
\*The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experience with the indicator.

\*\*This impact category deals mainly with the eventual impact of low dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure nor due to radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, from radon and from some construction materials is also not measured by this indicator.

It is not recommended to use results of modules A1-A3 without considering also module C.

**PM** Particulate matter  
**IRP** Ionising radiation  
**ETP,fw** Ecotoxicity freshwater  
**HTP,c** Human toxicity cancer  
**HTP,nc** Human toxicity non cancer  
**SQP** Land use  
**PERE** Use of renewable primary energy excluding renewable primary energy resources

used as raw materials  
**PERM** Use of renewable primary energy resources used as raw materials  
**PERT** Total use of renewable primary energy resources  
**PENRE** Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials

**PENRM** Use of non-renewable primary energy resources used as raw materials  
**PENRT** Total use of non-renewable primary energy resources  
**SM** Use of secondary raw materials  
**RSF** Use of renewable secondary fuels  
**NRSF** Use of non-renewable secondary fuels  
**FW** Use of net fresh water



# Environmental performance

>>Produce and grow with respect  
for the people and the environment.<<

Carlo N. Pasini | Founder of the Feralpi Group

Output flows and waste categories per declared unit

	UNITS	UPSTREAM - CORE PROCESS	DOWNSTREAM
		A1:A3	A4
HWD	kg	8.10E-03	6.31E-04
NHWD	kg	1.68E+02	1.87E-01
RWD	kg	3.97E-03	2.35E-03
CRU	kg	0.00E+00	0.00E+00
MFR	kg	1.56E+02	0.00E+00
MER	kg	0.00E+00	0.00E+00
EE	MJ	0.00E+00	0.00E+00

**HWD** Hazardous waste disposed

**NHWD** Non-hazardous waste disposed

**RWD** Radioactive waste disposed

**CRU** Components for re-use

**MFR** Materials for recycling

**MER** Materials for energy recovery

**EE** Exported energy

# Calculation rules

The environmental burden of the product has been calculated according to EN 15804:2012+A2:2019 and PCR 2019:14 v 1.3.4.

This declaration is a Cradle-to-Gate with options with optional modules (A4) EPD type, based on the application of Life Cycle Assessment (LCA) methodology to the whole life-cycle system. In the whole LCA model, infrastructures and production equipments are not taken into account.

**Steel billets at plant level** is described by using specific data from manufacturing facility (Elbe-Stahlwerke Feralpi GmbH, Gröbaer Straße 3, 01591 Riesa) for the year 2023.

Customized LCA questionnaires were used to gather in-depth information about all aspects of the production system (for example, raw materials contents and specifications, pre-treatments, process efficiencies, air and water emissions, waste management), in order to provide a complete picture of the environmental burden of the system from raw materials supply (A1) to Transport (A2) and Manufacturing (A3). The use phase was not considered according to EN:15804 and PCR 2019:14 v 1.3.4. Therefore, in nominal installation and operating conditions, no emissions to air nor to water shall occur.

According to ISO 14040 and 14044, allocation is avoided whenever possible by dividing the system into sub-systems. When allocation cannot be avoided physical properties are used to drive flow analysis. Due to the presence of co-products in steel mill, an economic allocation were used in that phase.

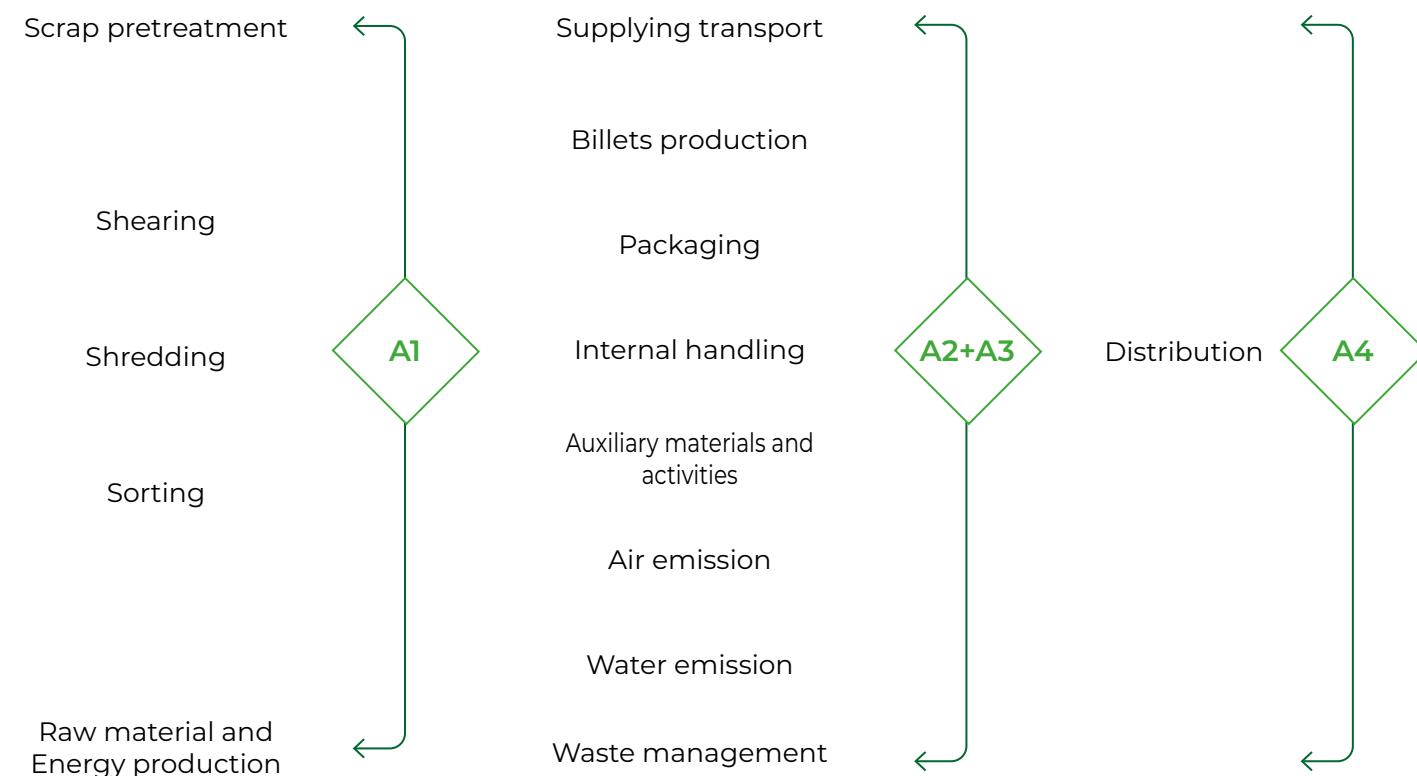
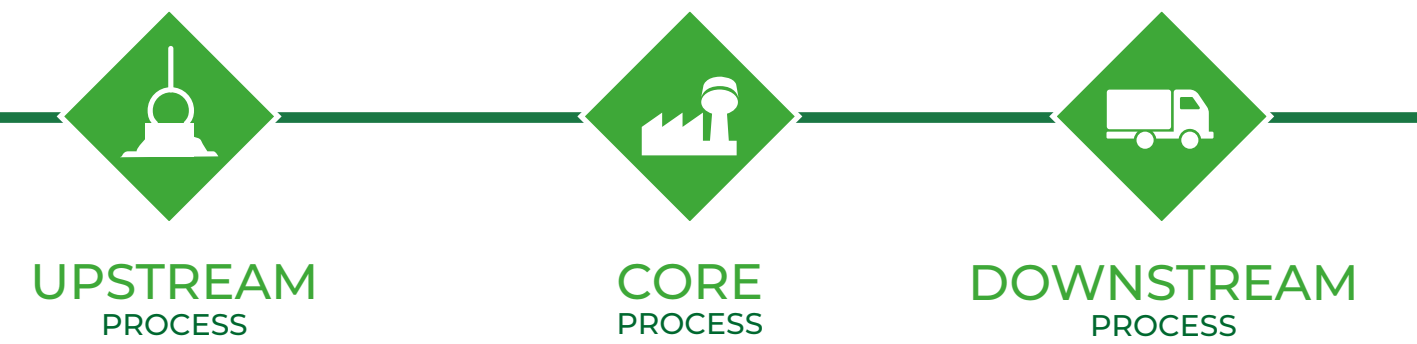
Scrap pre and post consumer has been modeled following new PCR 2019:14 v1.3.4 rules by adding environmental loads on pre-consumer with an economic allocation method.

**Data quality** has been assessed and validated during data collection process. According to EN:15804 the applied cut-off criterion for mass and energy flows is 1%.



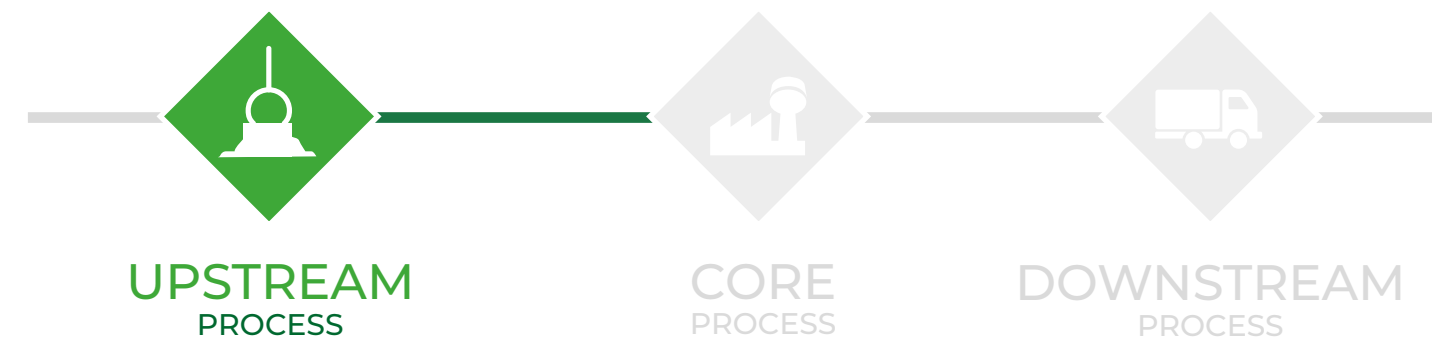


# Scenarios and additional technical information

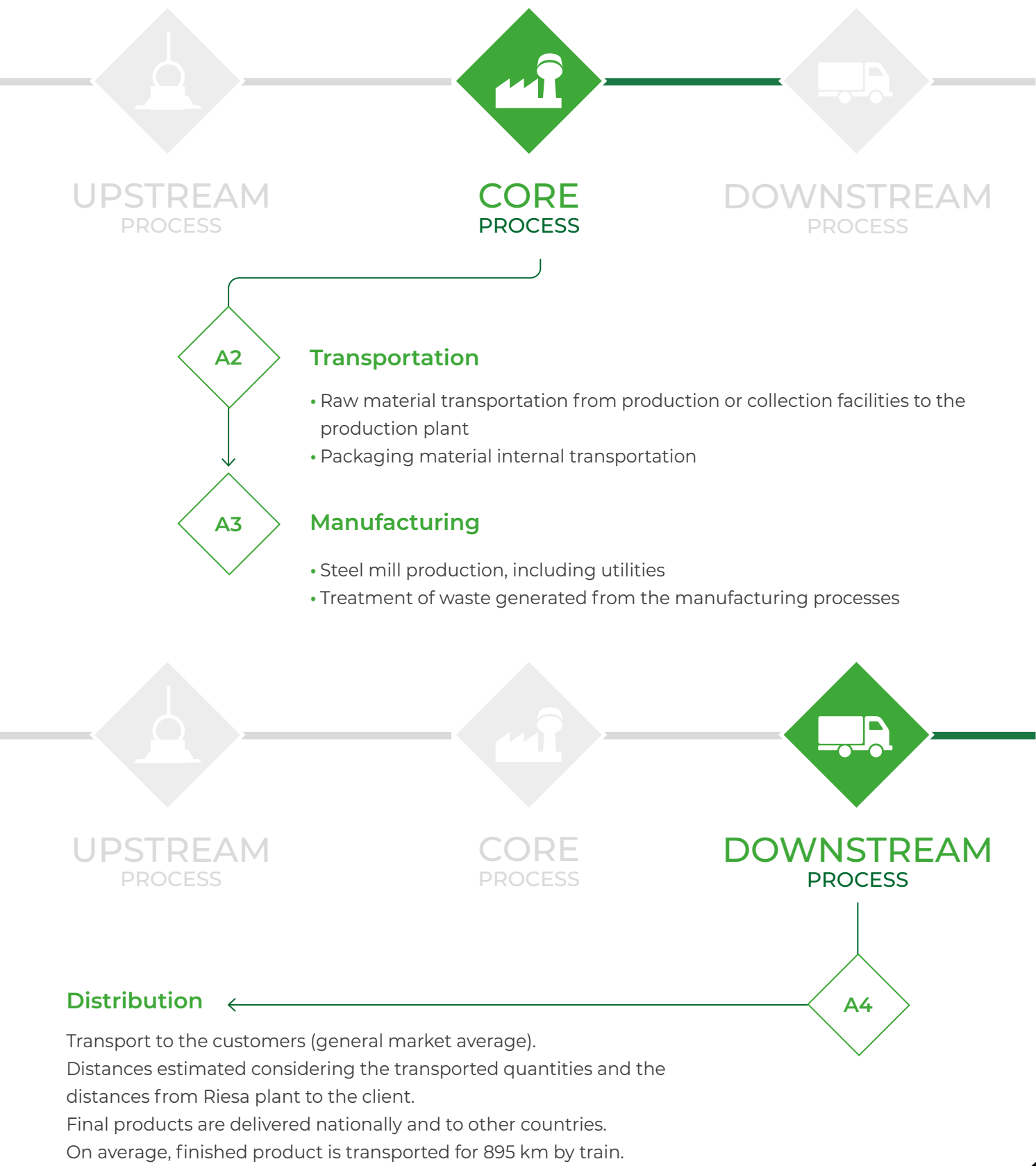


Broad scheme of steel billets production, in which the main activities included in the system boundaries are listed and divided in the three subsystems: **UPSTREAM Process**, **CORE Module**.

## Upstream process



Core process



Other optional additional environmental information

Strategic projects to improve process efficiency and environmental performance: New **resource-saving hot rolling mill** (rolling mill B) with inductive billet heating furnace, new **scrap processing** for more efficient scrap utilisation and production process, new **transformer station** in which the use of the usual sulphur hexafluoride (SF 6) can be completely dispensed, new **logistics concept** for faster and more efficient processing of logistics orders.

MINIMUM CONTENT OF RECYCLED, RECOVERED, BY-PRODUCT MATERIALS								
PRODUCT TYPE	PRODUCT NAME	RECYCLED MATERIAL			RECOVERED MATERIAL	BY-PRODUCT MATERIAL		TOTAL CONTENT OF RECYCLED, RECOVERED, BY-PRODUCT MATERIAL
		Total	Pre-consumer	Post-consumer		Internal	External	
		[%]	[%]	[%]		[%]	[%]	
CASTED STEEL	Billetts	97,75	7,72	90,03	0	1,0	0	98,75

Recycled content verified according to ICMQ CP DOC 262 regulation, certification n. P605 rev. 2.2 and calculated according to UNI EN ISO 14021, publication date 14/06/2024, referred to 2023 year.





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for the people and the environment.«**

Carlo N. Pasini | Founder of the Feralpi Group

## References

- EN 15804:2012+A2:2019
- ISO 14040 and 14044:2006
- UNI EN ISO 14021:2021
- Life cycle assessment applied to billet, wire rod, reinforcing steel bars, reinforcing steel in coils and electrowelded mesh v2.0
- General Programme Instructions, v4.0
- PCR 2019:14 - Construction products - v 1.3.4
- JRC EF package v3.1



