

# Environmental Product Declaration



THE INTERNATIONAL EPD® SYSTEM

**for Ready Mixed Concrete  
C20/25, XC1, S4, gravel, fast set**

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

Programme operator: EPD International AB

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in accordance with ISO 14025:2006, 21930:2017 and EN 15804:2012+A2:2019/AC:2021  
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 the website.  
EPD of identical products, based on a representative plant.





# General information

| Programme | The International EPD® System                                       |
|-----------|---------------------------------------------------------------------|
| Address:  | EPD International AB<br>Box 210 60<br>SE-100 31 Stockholm<br>Sweden |
| Website:  | www.environdec.com                                                  |
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| Accountabilities for PCR, LCA and third-party verification                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Product Category Rules (PCR)                                                                                                                           | <p>ISO standard ISO 21930 and CEN standard EN 15804 serve as the core Product Category Rules (PCR)</p> <p>Product Category Rules (PCR):<br/>PCR 2019:14 Construction products (EN 15804:A2); Version 1.3.4; 2024-04-30<br/>c-PCR-003 Concrete and concrete elements (EN 16757); Version 2024-04-30</p> <p>PCR review was conducted by: The Technical Committee of the International EPD® System. See <a href="http://www.environdec.com">www.environdec.com</a> for a list of members. Review chair: Claudia A. Peña, University of Concepción, Chile.<br/>The review panel may be contacted via the Secretariat. <a href="http://www.environdec.com/contact">www.environdec.com/contact</a></p> |
| Life Cycle Assessment (LCA)                                                                                                                            | LCA accountability: TITAN Cement Company S.A.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
| Third-party verification                                                                                                                               | <p>Independent third-party verification of the declaration and data, according to ISO 14025:2006, via:</p> <p><input checked="" type="checkbox"/> EPD verification by accredited certification body</p> <p>Third-party verification: Eurocert S.A. is an approved certification body accountable for the third-party verification.</p> <p>The certification body is accredited by: ESYD, Accreditation number 21</p>                                                                                                                                                                                                                                                                             |
| Procedure for follow-up of data during EPD validity involves third party verifier: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> 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                                            | Interbeton Building Materials S.A., a member of TITAN Group.<br>22A Halkidos Str., 11143 Athens, Greece                                                                                                                                                                                                                                                                                                                                                                                     |
|-------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Contact                                                     | Katsakou Martha, Quality Assurance & Control Manager Concrete Operations,<br>Titan Greece, T: +30 210 259 1456, E: <a href="mailto:main@interbeton.gr">main@interbeton.gr</a>                                                                                                                                                                                                                                                                                                               |
| Description of the organisation                             | Building materials manufacturer                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
| Product-related or management system-related certifications | Product group classification: UN CPC 375, ISO standard ISO 21930 and CEN standard EN 15804 serve as the core Product Category Rules (PCR), PCR 2019:14 Construction products (EN 15804:A2); Version 1.3.4; 2024-04-30 c-PCR-003 Concrete and Concrete Elements (EN 16757), Version 2024-04-30, PCR review was conducted by The Technical Committee of the International EPD® System and Independent third-party verification of the declaration and data in accordance with ISO 14025:2006. |

# Introduction

Building on more than 120 years of industry experience and driven by its commitment to sustainable growth, TITAN Group has become an international cement and building materials producer, serving customers in more than 25 countries worldwide through a network of 14 integrated cement plants and three cement grinding plants. TITAN also operates quarries, ready-mix plants, terminals, and other production and distribution facilities. We create value by transforming raw materials into products – cement, concrete, aggregates, dry mortars and other building materials. We serve society’s need for safe, durable, resilient, and affordable housing and infrastructure.

Climate change has mobilized organizations, in many sectors, towards a carbon-neutral future. In 2020, the Global Cement and Concrete Association (GCCA) announced its members’ Climate ambition to drive down the CO<sub>2</sub> footprint of operations and products and deliver carbon-neutral concrete to society by 2050. Meanwhile, there is a growing need for enhanced transparency of environmental performance of building materials, such as greenhouse gas (GHG) emissions. Cement is the key ingredient in manufacturing concrete, the second most

used commodity in the world and among the major contributors to the embodied GHG of buildings and infrastructure works.

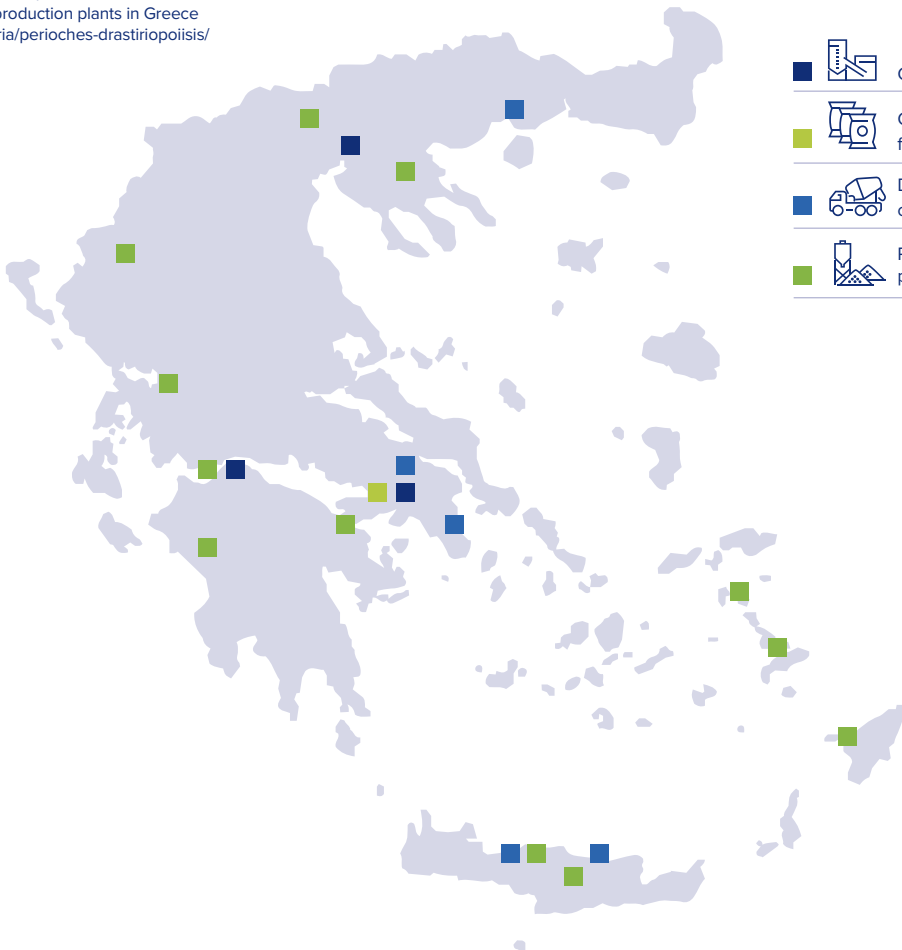
TITAN is working across the built environment value chain to deliver a carbon-neutral future in a circular economy, life cycle context. Aiming for a 35% reduction of the net direct specific CO<sub>2</sub> emissions by 2030 (compared to 1990 levels), TITAN has defined a road map for developing lowcarbon cementitious products and collaborating in carbon capture R&D projects at the cement plants. The publication of the ready-mixed concrete Environmental Product Declaration (EPD) is an important milestone in the road map, helping to communicate to customers the environmental performance of INTERBETON concretes.

Cement, concrete and other building materials EPDs will help shape the way the construction industry analyses the environmental impact of buildings and infrastructure works, now and in the future. Our EPDs will also provide a rigorous, science-based framework for driving environmental improvement throughout TITAN’s and INTERBETON’s sites and supply chain, offering at the same time an advantage to customers wanting to be leaders in the sustainable infrastructure and building industry.

## Geographical Scope: National (Greece)

This EPD concerns exclusively the plants: Koropi and Helliniko. All of INTERBETON’s ready-mix concrete production plants in Greece are available at <https://interbeton.gr/i-etairia/perioches-drastiriopoiisi/>

- 1 METAMORFOSI, Attiki
- 2 KOROPi, Attiki
- 3 PAIANIA, Attiki
- 4 MALAKASA, Attiki
- 5 MANDRA, Attiki
- 6 HELLINIKO, Attiki
- 7 THERMI, Thessaloniki
- 8 NEOCHOROU DA, Thessaloniki
- 9 RAIDESTOS, Thessaloniki
- 10 NEA EFKARPIA, Thessaloniki
- 11 FLOGITA, Chalkidiki
- 12 KASSANDRINO, Chalkidiki
- 13 LAKKOMA, Chalkidiki
- 14 VOLOS-OBRIA, Magnisia
- 15 LAMIA, Fthiotida
- 16 KORINTHOS, Korinthia
- 17 XYLOKASTRO, Korinthia
- 18 THERIANO, Achaia
- 19 KALITHEA, Achaia
- 20 DREPANO, Achaia
- 21 AMALIADA, Hleia
- 22 PYRGOS, Hleia
- 23 BIPE IOANNINON, Ioannina
- 24 KOSKINOI, Rodos
- 25 GENNADI, Rodos
- 26 ANTIMACHIA, Kos
- 27 MESSARIA, Kos
- 28 BIPE HERAKLION, Heraklion
- 29 ZOFOROI, Heraklion
- 30 KASTELLI, Heraklion
- 31 LATZIMAS, Rethymno



-  Cement plants
-  Cement grinding facility
-  Distribution centers
-  Regional ready-mix plants and quarries



3 Cement plants

1 Cement Grinding Facility

31 Ready-mix Plants

26 Quarries

1 Dry mortar Plant

2 Processed engineered fuel facilities



# Product information

## Product name:

20C14G1001051 - C20/25, XC1, S4, gravel, fast set

## Product identification:

Compressive Strength 28 days (Mpa): 25

## Product description:

Concrete is a material formed by mixing cement, coarse and fine aggregate and water, with or without the incorporation of admixtures and additions. Fresh concrete is manufactured at ready-mix batch plants and is delivered to the construction sites in a liquid state. Fresh concrete is placed, compacted and hardened in the desired shape, via a chemical reaction: the hydration of cement. The cement is the binding agent in concrete: it is a finely ground powder that when hydrated forms

The technical characteristics and composition of the product are shown in the table below. Product declarations and certificates can be found on the company's website [www.interbeton.gr](http://www.interbeton.gr)

a paste that sets, hardens, and adheres to other materials and after hardening retains its strength even underwater. It is used as the main raw material in the production of concrete, mortar, grouts and plasters.

This is an average EPD for the declared products which comply with the requirements of ELOT EN 206 and the Concrete Technology Regulation KTS 2016. These specific concrete mix designs are produced nationwide by Interbeton Building Materials S.A.

These specific types of concrete have a wide range of applications and are mainly utilized in civil engineering works and in residential and commercial construction.

The product is delivered in bulk with ready-mix trucks.



## Technical characteristics according to ELOT EN 206 and the Concrete Technology Regulation KTS 2016

|                       |                                                                  |       |
|-----------------------|------------------------------------------------------------------|-------|
| Mechanical properties | Characteristic Compressive Strength f <sub>ck</sub> , cube (Mpa) | 25    |
| Product Density       | Kg/m <sup>3</sup>                                                | 2,302 |

UN CPC code: 375

# Content Information

| Product                                                | Concrete Density (Kg/m <sup>3</sup> ) | Cement (kg) | Coarse Aggregate (kg) | Fine Aggregate (kg) | Water (kg) | Admixtures (kg) |
|--------------------------------------------------------|---------------------------------------|-------------|-----------------------|---------------------|------------|-----------------|
| C20/25, XC1, S4, gravel, fast set - ERP# 20C14G1001051 | 2,302                                 | 15.0-16.0%  | 25.0-28.0%            | 48.0-51.0%          | 8.5-9.5%   | 0.10%           |

# LCA information

**Functional unit / declared unit:** The declared unit is one (1) cubic meter (m<sup>3</sup>).

**Reference service life:** 50 years.

**Production Process:** Interbeton manufactures ready-mixed concrete in state-of-the-art facilities in Greece. The production process is fully automated to ensure superior quality products, conforming to the national and European concrete standards. The raw materials (cement, aggregates, water, admixtures etc.) are accurately weighed according to the proprietary Interbeton mix designs to produce ready-mixed concrete with specific characteristics (strength, durability, finishability, pumpability etc.). Once manufactured, the fresh concrete is transported with concrete trucks to the construction sites. The production process is exactly the same at every Interbeton production facility.

**Time representativeness:** The data used in this study cover from January 2023 to December 2023.

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

**Goal and scope:** This EPD evaluates the environmental impacts of one cubic meter of concrete from Cradle to grave, and module D (A+B+C+D).

**Data quality:** ISO 14044 was applied in terms of data collection and quality requirements. The data concerning the modules A1 (raw material supply), A2 (transportation) and A3 (product manufacturing) were provided by Interbeton Building Materials S.A., incorporating cement EPD data for Titan Cement Company S.A. and involved all input and output materials to each ready-mix plant, the consumed utilities (energy and the distances and means of transport for each input stream. Regarding electricity mix, the latest (2023) national residual electricity mix as published in DAPEEP SA, were utilized (<https://www.dapeep.gr/viosimi-anaptixi/energeiakomeigma/>). The background data for the module A1 e.g. raw materials (amount used by type) as well energy consumption, waste production and transport distances of raw materials and aggregates from cement plants, quarries have been obtained from the company's ERP system and correspond the exact and accurate mix designs for each ready-mix plant. Core indicators for every cement type / cement sourcing plant are obtained from the TITAN CEMENT S.A. publicly available cement EPDs.

The GCCA Environmental Product Declaration tool (v4.2). GCCA's Industry EPD Tool for Cement and Concrete is a web-based calculation tool for EPDs of clinker, cement, concrete, mortars and precast elements, available in both International and North American versions. The present report refers to the International version only.

The latter complies with the latest cement and concrete PCRs registered at the International EPD® System (Environdec), namely c-PCR-001 Cement and building limes (EN 16908) for cement and c-PCR003 Concrete and concrete elements (EN 16757) for concrete and precast elements, both registered as complementary PCRs of PCR 2019:14 Construction products (EN 15804+A2).

The GCCA EPD tool (v4.2) is developed by Quantis <https://quantis-intl.com/> and verified by Studio Fieschi <http://www.studiofieschi.it/en>. The International EPD® System, which provides the framework to develop and publish EPDs based on ISO 14025 and EN 15804, gives the final approval of the tool's compliance with the rules. The underpinning database for the GCCA EPD tool is the version of the Ecoinvent database (v.3.5) and cement manufacturing data obtained through the GNR process (<https://gccassociation.org/sustainabilityinnovation/gnr-gcca-in-numbers/>).

The database of Ecoinvent v.3.5 was used to complete any missing data. Generic data used in this study concerning:

- CO<sub>2</sub> emission factors for different transportation way
- CO<sub>2</sub> emission factors for plant diesel and raw materials
- Specific emission factor of used energy mix (kg CO<sub>2</sub>/kWh)
- The energy source behind electricity is GWP-GHG=7,41E-01 kg CO<sub>2</sub> eq./kWh
- CO<sub>2</sub> emission factors for conventional transport to the construction site (ready mix truck)
- CO<sub>2</sub> emission factors for energy and fuels used during construction

- Water and waste-water usage during construction
- Recarbonation during use (B)
- Fuels, emissions and recarbonation during end of life (C) (demolition, transport, waste processing and disposal)
- Recarbonation and emissions for Benefits and Loads (D).

There is no missing data for this concrete mix, since all the required raw data were provided from the ERP system (SAP) that company uses. Data collection and processing for EPD and LCA development is performed according to INTERBETON quality systems.

**Geographical scope:** National (Greece)

**Allocations:** The allocation is performed according to the PCR. As no co-products are produced, the flow of materials and energy and the associated release of substances and energy into the environment is related exclusively to the concrete produced. No by-products occur during ready mix concrete production; therefore, there is no need for allocations in by-products.

The study does not include the followings:

- Capital equipment production
- Equipment maintenance
- Human labour and employee transport

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

Pre-defined cement and clinker data provided by the GCCA tool are used for TITAN cements manufactured at Kamari, Patras and Thessaloniki cement plants.

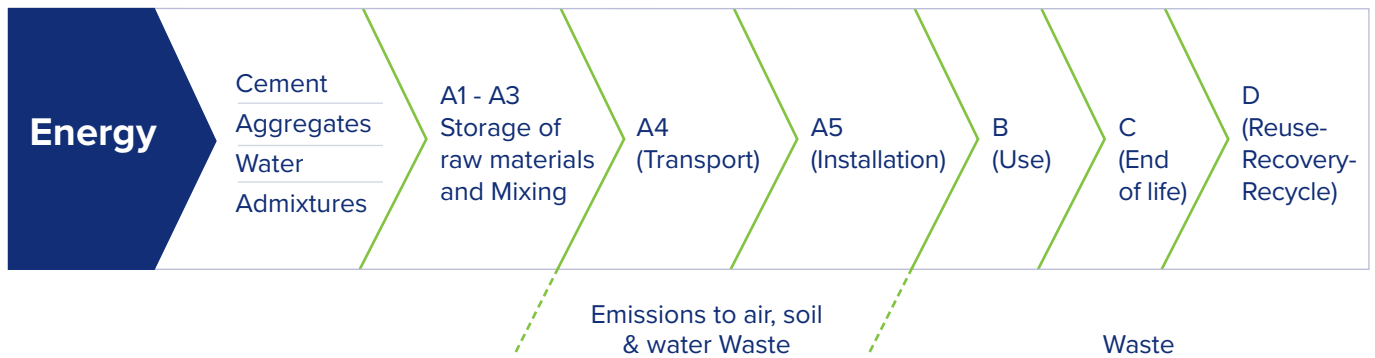
- All modelling assumptions adopted from the GCCA Tool.
- Raw material (inbound) transport distances are generated from ERP data and are accurate across operations.
- For generic EPDs, travel from concrete production site to customer site is calculated at 10 km, the average travel distance across operations.
- Concrete mixes are assumed to use an equal amount of site fuel and energy and responsible for an equal amount of waste flows from A to D.
- The calculation of the bill of materials for every plant is based on ERP data. The concrete mix design (materials percentage participation) was defined by the pre-verified and automated ERP system (SAP) that company uses.
- Water usage in batching operations is, per mix design.

Regarding road transportation, a ready-mix truck with a 9 m<sup>3</sup> concrete capacity, EURO4, was used. The representative plant is defined via systematic methodologies, well described and documented within the relevant LCA content, taking into consideration material sourcing, sales volumes and geographic specificity.

**Cut-off rules:** The cut-off rule for insufficient data or data gaps that are less than 1% of the total input mass or mass per module was applied. In case of insufficient input data or data gaps for a unit process, the cut-off criteria was defined as 1% of renewable and non-renewable primary energy usage and 1% of the total mass input of that unit process. The total of neglected input flows for the stages 'cradle through gate' were calculated to be less than 5% of energy usage and mass." (EN 15804:2012+A2:2019). Regarding the LCA model, the default cut-off criteria are applied for all processes from the Ecoinvent database. In addition, all custom processes developed for the specific purposes of the project are consistent with the rules and guidelines of the Ecoinvent database, and hence the same cut-off criteria are applied.

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

**Description of system boundaries:** The scope of this study is "Cradle to grave" covering A1-A5, B1-B7, C1-C4 and D.



## System diagram

The scope of this study is Cradle to grave, A1-A5, B1-B7, C1-C4 and D.

|                                                                                      | Product stage        |           |               | Construction process stage |                           | Use stage |             |        |             |               |                        |                       | End-of-life stage              |           |                                                       |          | Resource recovery stage            |
|--------------------------------------------------------------------------------------|----------------------|-----------|---------------|----------------------------|---------------------------|-----------|-------------|--------|-------------|---------------|------------------------|-----------------------|--------------------------------|-----------|-------------------------------------------------------|----------|------------------------------------|
|                                                                                      | Raw Materials Supply | Transport | Manufacturing | Transport                  | Construction installation | Use       | Maintenance | Repair | Replacement | Refurbishment | Operational energy use | Operational water use | De-construction and demolition | Transport | Waste processing for reuse, recovery and/or recycling | 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                         | X         | X           | X      | X           | X             | X                      | X                     | X                              | X         | X                                                     | X        | X                                  |
| Geography                                                                            | GR                   | GR        | GR            | GR                         | GR                        | GR        | GR          | GR     | GR          | GR            | GR                     | GR                    | GR                             | GR        | GR                                                    | GR       | GR                                 |
| Specific data used                                                                   | > 90%                |           |               | -                          | -                         | -         | -           | -      | -           | -             | -                      | -                     | -                              | -         | -                                                     | -        | -                                  |
| Variation - products                                                                 | Not relevant         |           |               | -                          | -                         | -         | -           | -      | -           | -             | -                      | -                     | -                              | -         | -                                                     | -        | -                                  |
| Variation - sites                                                                    | < 10%                |           |               | -                          | -                         | -         | -           | -      | -           | -             | -                      | -                     | -                              | -         | -                                                     | -        | -                                  |
|                                                                                      | A1-A3                |           |               | A4-A5                      |                           | B1-B7     |             |        |             |               |                        |                       | C1-C4                          |           |                                                       |          | D                                  |
|                                                                                      | V                    |           |               | V                          |                           | V         |             |        |             |               |                        |                       | V                              |           |                                                       |          | V                                  |
|  |                      |           |               |                            |                           |           |             |        |             |               |                        |                       |                                |           |                                                       |          |                                    |

X = included, MND = module not declared.

The final product does not contain dangerous substances of high concern from the candidate list of SVHC for Authorization.

- **A1-A3 Product stage**

- A1 Raw materials supply: this module takes into account the extraction and processing of raw materials and the associated energy that is produced prior to manufacturing concrete.
- A2 Transport: this module includes the transport of the different raw materials from the supplier to the ready-mix plant.
- A3 Manufacturing: this module includes the consumption of energy and water during the concrete manufacturing process, as well as the transport and management of the factory-produced waste. The manufacture of concrete or mortar consists mainly of a mixing process of different components.

- **A4-A5 Construction process**

- A4 Transport

| PARAMETERS FOR A4 - TRANSPORT                                                                                          |                                                          |
|------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------|
| PARAMETER                                                                                                              | VALUE / DESCRIPTION                                      |
| Fuel type and consumption of vehicle used for transport, e.g. ready-mix truck, aggregates or cement truck, vessel etc. | Truck of 32 tn. Fuel consumption according to GCCA model |
| Distance (Delivery/ready-mix truck)                                                                                    | Ready-mix truck, 10 Km (declared average)                |
| Capacity Utilization (including empty returns)                                                                         | 100%                                                     |
| Bulk density of transported concrete                                                                                   | Expressed in LCA information section                     |
| Volume capacity utilization factor                                                                                     | 99%                                                      |

- A5 Construction/Installation The product is directly transferred from the truck to the construction site

| PARAMETERS FOR A5 - CONSTRUCTION / INSTALLATION                                                   |                                       |
|---------------------------------------------------------------------------------------------------|---------------------------------------|
| PARAMETER                                                                                         | VALUE / DESCRIPTION                   |
| Auxiliary materials for installation                                                              | No auxiliary material used            |
| Use of water                                                                                      | 669 lt/m <sup>3</sup>                 |
| Use of waste\water                                                                                | 0,669 lt/m <sup>3</sup>               |
| Use of other resources                                                                            | No other resource consumption         |
| Quantitative description of the energy (regional mix) and the consumption during the installation | Electricity: 2.776 Kwh/m <sup>3</sup> |
| Quantitative description of diesel and the consumption during the installation                    | Diesel: 1.669 lt/m <sup>3</sup>       |
| Wastage of materials at job site before waste processing, generated by the product's installation | Product losses 1%                     |

- B Use stage: the product's fix CO<sub>2</sub>, by carbonatation during the use phase (B1), and do not require maintenance (B2), repair (B3), replacement (B4), refurbishment (B5), operational energy use (B6) or operational water use (B7) during its Reference Service Life. CO<sub>2</sub> by carbonatation of cement during the use phase has been included as required in c-PCR, following the methodology explained in EN 16757.
- C End of life stage
  - C1 Deconstruction/demolition: the use of diesel during the demolition process has been included.
  - C2 Transport to waste processing: the model use for the transportation (see A4, transportation to the building site) is applied.
  - C3 Waste processing for reuse, recovery and/or recycling: the product is 50% recycled.
  - C4 Disposal: the product is 50% landfilled.



| PARAMETERS FOR C End of life                               |                                                          |
|------------------------------------------------------------|----------------------------------------------------------|
| PARAMETER                                                  | VALUE / DESCRIPTION                                      |
| Collection process specified by type                       | The product is collected mixed with construction waste   |
| Recovery system specified by type                          | 50% recycled                                             |
| Disposal specified by type                                 | 50% landfilled                                           |
| Assumptions for scenario development (e.g. transportation) | 16-32 tn truck, Fuel consumption according to GCCA model |
| Diesel in building/demolition equipment                    | 2.674 lt / m <sup>3</sup>                                |
| Transport distances (truck)                                | 31.5 km                                                  |

**Disclaimer:** Considering that Module C is included in this EPD, is discouraged to use the results of modules A1-A3 (A1-A5 for services) without considering the results of module C.

- D Reuse-Recovery-Recycling potential the product is recycled in 50%. As a consequence, the module D has been calculated where the results of recycled content that the product already includes has been taken into account. The avoided product is considered crushed aggregate.

| PRODUCT DATA SOURCES                                                                                       |                                          |                          |                                                                                                     |                               |                 |
|------------------------------------------------------------------------------------------------------------|------------------------------------------|--------------------------|-----------------------------------------------------------------------------------------------------|-------------------------------|-----------------|
| In Accordance with Environdec c-PCR-003 Concrete, concrete elements (EN I 16757), ISO 14025 and EN15804:A2 |                                          |                          |                                                                                                     |                               |                 |
| LCA Stage                                                                                                  | Input/output                             | Sub Process              | Data Source                                                                                         | Temporal Scope                | Quality         |
| <b>Product Description</b>                                                                                 | Product description and specific density |                          | INTERBETON ERP report Bill of Materials (BoM) and material specific data                            | January 2023 to December 2023 | High            |
| <b>A1</b>                                                                                                  | Raw Materials                            | Background modeling data | INTERBETON internal Quality Assurance database, ERP systems                                         | January 2023 to December 2023 | High            |
| <b>A2</b>                                                                                                  | Cement and Aggregate Transport           | Background modeling data | Actual transport distances - ERP invoices to haulers. Sea transport based on port-to-port distances | 2023                          | High            |
| <b>A3</b>                                                                                                  | Concrete Batching                        | Electricity              | Provider Invoices                                                                                   | 2023                          | High            |
|                                                                                                            |                                          | Diesel                   | Supplier Invoices                                                                                   | 2023                          | High            |
|                                                                                                            |                                          | Water                    | Utility Invoices                                                                                    | 2023                          | High            |
|                                                                                                            |                                          | Electricity sources      | As published in DAPEEP SA                                                                           | 2023                          | High            |
|                                                                                                            | Waste                                    | Background Data          | Invoices for waste transportation                                                                   | January 2023 to December 2023 | Medium          |
| <b>A4-A5 Construction</b>                                                                                  | Outbound travel distance                 | Background modeling data | Average distances to construction sites                                                             | January 2023 to December 2023 | High            |
| <b>B Use</b>                                                                                               | Re-carbonation*                          | Modeling data            | Default GCCA Quantis tool settings                                                                  | N/A                           | Proxy-Medium    |
| <b>C1. End of Life Demolition</b>                                                                          | Demolition                               |                          | Default GCCA Quantis tool settings                                                                  | N/A                           | Proxy-Medium    |
| <b>C2. End of Life Transport</b>                                                                           | Transport                                |                          | Default GCCA Quantis tool settings                                                                  | N/A                           | Proxy-Medium    |
| <b>C3. End of Life Waste Processing</b>                                                                    | Recycling Rate at End of life            |                          | Default GCCA Quantis tool settings                                                                  | N/A                           | Proxy-Medium    |
| <b>C4. End of Life Disposal</b>                                                                            | Disposal Rate at End of life             |                          | Default GCCA Quantis tool settings                                                                  | N/A                           | Proxy-Medium    |
| <b>D. Benefits and Loads</b>                                                                               |                                          |                          | Default GCCA Quantis tool settings                                                                  | N/A                           | N/A             |
| <b>GENERAL</b>                                                                                             | General                                  | General                  | Ecoinvent database                                                                                  | As updated                    | Secondary, High |

\* Regarding recarbonation benefits the scenario are 10m<sup>2</sup> free surface per m<sup>3</sup> of concrete and 50 years of Reference Life Cycle.

# Environmental information

The following tables contain the environmental indicators for the following plants: Koropi and Helliniko.

All ready-mix plants have lower than ±10% differences between the environmental indicators for the product mix designs described in the EPD. They are presented in the same EPD using the impacts of an environmentally representative plant. The following environmental information are for the representative plant and its associated mix design, based on criteria of 1) Importance and relevance of the cement supplying plant and 2) Relevance of raw material transport. No allocation was needed.

For construction services, the total value of A1-A3 shall be replaced with the total value of A1-A5.

The EN 15804 reference package based on EF 3.1 has been used.

## C20/25, XC1, S4, gravel, fast set

| Core environmental impact indicators |                          |           |          |           |           |          |          |          |          |          |          |          |          |          |           |           |
|--------------------------------------|--------------------------|-----------|----------|-----------|-----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|-----------|-----------|
| Indicator                            | Unit                     | A1-A3     | A4       | A5        | B1        | B2       | B3       | B4       | B5       | B6       | B7       | C1       | C2       | C3       | C4        | D         |
| GWP-tot                              | kg CO <sub>2</sub> eq.   | 1,98E+02  | 2,02E+00 | 1,33E+01  | -9,27E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 8,99E+00 | 8,59E+00 | 9,10E+00 | -1,02E+01 | -8,80E+00 |
| GWP-GHG                              | kg CO <sub>2</sub> eq.   | 2,02E+02  | 2,02E+00 | 9,51E+00  | -9,27E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 8,99E+00 | 8,59E+00 | 9,10E+00 | -1,02E+01 | -8,80E+00 |
| GWP-fos                              | kg CO <sub>2</sub> eq.   | 2,02E+02  | 2,02E+00 | 9,51E+00  | -9,27E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 8,99E+00 | 8,58E+00 | 9,08E+00 | -1,02E+01 | -8,75E+00 |
| GWP-bio                              | kg CO <sub>2</sub> eq.   | -3,71E+00 | 8,18E-04 | 3,76E+00  | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 1,60E-03 | 6,30E-03 | 1,62E-02 | 0,00E+00  | -3,53E-02 |
| GWP-luc                              | kg CO <sub>2</sub> eq.   | 3,32E-02  | 7,07E-04 | 3,47E-03  | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 1,13E-03 | 5,12E-03 | 1,26E-02 | 0,00E+00  | -1,53E-02 |
| ODP                                  | kg CFC <sub>11</sub> eq. | 8,14E-06  | 3,99E-07 | 1,38E-06  | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 1,62E-06 | 1,48E-06 | 2,29E-06 | 0,00E+00  | -5,99E-07 |
| AP                                   | mol H <sup>+</sup> eq.   | 6,25E-01  | 6,66E-03 | 7,90E-02  | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 9,42E-02 | 4,01E-02 | 8,51E-02 | 0,00E+00  | -6,22E-02 |
| EP-fw <sup>1</sup>                   | kg PO <sub>4</sub> eq.   | 1,71E-02  | 1,56E-04 | 1,29E-03  | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 4,02E-04 | 1,18E-03 | 2,65E-03 | 0,00E+00  | -3,68E-03 |
| EP-mar                               | kg N eq.                 | 1,32E-03  | 1,35E-05 | 6,45E-04  | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 3,34E-05 | 8,70E-05 | 2,03E-04 | 0,00E+00  | -2,38E-04 |
| EP-ter                               | mol N eq.                | 1,80E+00  | 1,48E-02 | 3,19E-01  | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 4,44E-01 | 1,12E-01 | 2,63E-01 | 0,00E+00  | -1,55E-01 |
| POCP                                 | kg NMVOC eq.             | 4,50E-01  | 6,00E-03 | 8,78E-02  | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 1,22E-01 | 3,70E-02 | 7,66E-02 | 0,00E+00  | -3,93E-02 |
| ADPE <sup>2</sup>                    | kg Sb eq.                | 1,62E-04  | 3,90E-06 | 7,34E-06  | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 2,66E-06 | 1,56E-05 | 9,74E-06 | 0,00E+00  | -1,00E-04 |
| ADPF <sup>2</sup>                    | MJ                       | 1,22E+03  | 3,29E+01 | 1,28E+02  | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 1,30E+02 | 1,31E+02 | 2,24E+02 | 0,00E+00  | -1,01E+02 |
| WDP <sup>2</sup>                     | m <sup>3</sup> eq.       | 8,84E+01  | 2,43E-01 | -1,18E+00 | 0,00E+00  | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 7,67E-01 | 1,14E+00 | 9,17E+00 | 0,00E+00  | -1,71E+01 |

**GWP-GHG** = Global Warming Potential GHG; **GHG** **GWP-total** = Global Warming Potential total; **GWP-fossil** = Global Warming Potential fossil fuels; **GWP-biogenic** = Global Warming Potential biogenic; **GWP-luluc** = Global Warming Potential land use and land use change; **ODP** = Depletion potential of the stratospheric ozone layer; **AP** = Acidification potential, Accumulated Exceedance; **EP-freshwater** = Eutrophication potential, fraction of nutrients reaching freshwater end compartment; **EP-marine** = Eutrophication potential, fraction of nutrients reaching marine end compartment; **EP-terrestrial** = Eutrophication potential, Accumulated Exceedance; **POCP** = Formation potential of tropospheric ozone; **ADP-minerals&metals** = Abiotic depletion potential for non-fossil resources; **ADP-fossil** = Abiotic depletion for fossil resources potential; **WDP** = Water (user) deprivation potential, deprivation-weighted water consumption

<sup>1</sup> Eutrophication aquatic freshwater shall be given in both kg PO<sub>4</sub><sup>-3</sup> eq and kg P eq.

<sup>2</sup> 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 experienced with the indicator.

| Use of resources |                |          |          |          |          |          |          |          |          |          |          |          |          |          |          |           |
|------------------|----------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|-----------|
| Indicator        | Unit           | A1-A3    | A4       | A5       | B1       | B2       | B3       | B4       | B5       | B6       | B7       | C1       | C2       | C3       | C4       | D         |
| PERE             | MJ             | 7,99E+01 | 4,73E-01 | 7,60E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 7,59E-01 | 3,29E+00 | 9,79E+00 | 0,00E+00 | -8,26E+00 |
| PERM             | MJ             | 3,49E+01 | 0,00E+00 | 3,49E-01 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 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             | 1,15E+02 | 4,73E-01 | 7,95E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 7,59E-01 | 3,29E+00 | 9,79E+00 | 0,00E+00 | -8,26E+00 |
| PENRE            | MJ             | 1,22E+03 | 3,29E+01 | 1,28E+02 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 1,30E+02 | 1,31E+02 | 2,24E+02 | 0,00E+00 | -1,01E+02 |
| PENRM            | MJ             | 1,84E+00 | 0,00E+00 | 1,84E-02 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 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             | 1,22E+03 | 3,29E+01 | 1,28E+02 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 1,30E+02 | 1,31E+02 | 2,24E+02 | 0,00E+00 | -1,01E+02 |
| SM               | kg             | 1,13E+02 | 0,00E+00 | 1,13E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00  |
| RSF              | MJ             | 7,44E+01 | 0,00E+00 | 7,44E-01 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00  |
| NRSF             | MJ             | 1,67E+02 | 0,00E+00 | 1,67E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00  |
| NFW              | m <sup>3</sup> | 2,32E+00 | 7,26E-03 | 1,20E-01 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 1,99E-02 | 3,51E-02 | 2,25E-01 | 0,00E+00 | -4,08E-01 |

**Acronyms:** **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 re-sources; **NFW** = Use of net fresh water

| Other environmental information describing waste categories |      |          |          |          |          |          |          |          |          |          |          |          |          |          |          |          |
|-------------------------------------------------------------|------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Indicator                                                   | Unit | A1-A3    | A4       | A5       | B1       | B2       | B3       | B4       | B5       | B6       | B7       | 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 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 |
| NHWD                                                        | kg   | 0,00E+00 | 0,00E+00 | 1,15E+01 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 1,15E+03 | 0,00E+00 | 0,00E+00 |
| RWD                                                         | 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 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 |

**Acronyms:** **HWD** = Hazardous waste disposed; **NHWD** = Non-hazardous waste disposed; **RWD** = Radioactive waste disposed

| Outputs   |      |          |          |          |          |          |          |          |          |          |          |          |          |          |          |          |
|-----------|------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Indicator | Unit | A1-A3    | A4       | A5       | B1       | B2       | B3       | B4       | B5       | B6       | B7       | C1       | C2       | C3       | C4       | D        |
| CRU       | 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 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 |
| MR        | kg   | 2,65E-01 | 0,00E+00 | 1,15E+01 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 1,15E+03 | 0,00E+00 | 0,00E+00 |
| MER       | 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 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 |
| EEE       | 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 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 |
| EET       | 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 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 |

**Acronyms:** **CRU** = Components for re-use; **MR** = Materials for recycling; **MER** = Materials for energy recovery; **EEE** = Exported electrical energy; **EET** = Exported thermal energy

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

# Additional information

Interbeton Building Materials S.A. hereby declares that all ready-mix concrete products are in compliance with the REACH Regulation (EC) No 1907/2006, concerning the Registration, Evaluation, Authorization and Restriction of Chemicals. Concrete does not contain any Substances of Very High Concern (SVHC) currently on the candidate list. REACH SVHC list is not static and is updated frequently, thus the Company will continue to evaluate, research and review to fulfil the demands of the regulation. More information about cement safety handling is available at the Safety Data Sheet (SDS) published at the company's website [www.interbeton.gr](http://www.interbeton.gr).

## Differences versus previous versions

First EPD version – No previous versions

## References

**GPI v.4.0:2021-03-29** General Programme Instructions of the International EPD® System

**PCR 2019:14 v.1.3.4** Product Category rules | Construction products | The International EPD® System

**EN 15804:2012+A2:2019/AC:2021** Sustainability of construction works - Environmental Product Declarations - Core rules for the product category of construction products

**c-PCR-003** Concrete and concrete elements (EN 16757) Version 2024-04-30

**EN 16757:2022** Sustainability of construction works - Environmental product declarations - Product Category Rules for concrete and concrete elements

**ISO 21930:2017** (en) Sustainability in buildings and civil engineering works - Core rules for environmental product declarations of construction products and services

**ISO 14020:2000** Environmental labels and declarations - General principles

**ISO 14025:2006** Environmental labels and declarations - Type III environmental declarations - Principles and procedures

**ISO 14040:2006** Environmental management - Life Cycle Assessment - Principles and framework

**ISO 14044:2006** Environmental management - Life Cycle Assessment - Requirements and guidelines

**Industry EPD Tool for Cement and Concrete** (<https://concrete-epd-tool.org/>)

User Guide (v4.2, International version, 18 December 2023)

LCA Model (v4.2, International version, 18 December 2023)

LCA Database (v4.2, 23 April 2024)

**DAPEEP SA** Renewable Energy Sources Operator & Guarantees of Origin | Greece | [www.dapeep.gr](http://www.dapeep.gr)

**ELOT EN 206 EN 206+A1** Concrete – Specification, performance, production and conformity

**Hellenic Concrete Technology Regulation** KTS 2016

# Contact information

|                    |                                                                                                                                                     |                                                                                                                                                                                 |
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# Environmental Product Declaration

for Ready Mixed Concrete  
C20/25, XC1, S4, gravel, fast set

