

# ENVIRONMENTAL PRODUCT DECLARATION

in accordance with /ISO 14025/ and /EN 15804/

Owner of the declaration	GDA - Gesamtverband der Aluminiumindustrie e.V.
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Coil Coated Aluminium Sheet  
GDA- Gesamtverband der Aluminiumindustrie  
e.V.

[www.ibu-epd.com](http://www.ibu-epd.com) / <https://epd-online.com>



The logo of GDA (Gesamtverband der Aluminiumindustrie) features the letters "GDA" in a bold, white, stylized font on a dark blue background. The letters are interconnected, with the "G" and "D" sharing a vertical stroke.



## 1. General Information

<p>GDA - Gesamtverband der Aluminiumindustrie e.V.</p> <hr/> <p><b>Programme holder</b> IBU - Institut Bauen und Umwelt e.V. Panoramastrasse 1 10178 Berlin Germany</p> <hr/> <p><b>Declaration number</b> EPD-GDA-2019131-IBG1-EN</p> <hr/> <p><b>This declaration is based on the following product category rules:</b> Products manufactured from aluminium and aluminium alloys, 07/2014 (PCR tested and approved by the independent advisory board (SVR))</p> <hr/> <p><b>Issue date</b> 16/01/2020</p> <hr/> <p><b>Valid to</b> 15/01/2025</p> <hr/> <p>Dipl. Ing. Hans Peters (President of Institut Bauen und Umwelt e.V.)</p> <hr/> <p>Dr. Alexander Röder (Executive Director IBU)</p>	<p>Coil coated aluminium sheet</p> <hr/> <p><b>Owner of the declaration</b> Gesamtverband der Aluminiumindustrie e.V. Fritz-Vomfelde-Strasse 30 40547 Düsseldorf Germany</p> <hr/> <p><b>Declared product/declared unit</b> 1 kg coil coated aluminium sheet.</p> <hr/> <p><b>Scope:</b> This document relates to the manufacture of 1 kg of coil coated aluminium sheet. This model EPD is based on a specific product which has been weighted towards the production output of three companies.  It can be assumed that the representativeness of the data is good due to the comparable production technologies of the individual companies. The data was collected during 2017.</p> <p>The owner of the declaration is liable for the basic information and supporting evidence; any liability of the IBU in relation to manufacturer's information, LCA data and supporting evidence is excluded. This document is a translation from German to English. It is based on the original declaration number EPD-GDA-2019131-IBG1-DE.</p> <hr/> <p><b>Verification</b></p> <table border="1"> <tr> <td>European standard /EN 15804/ serves as the core PCR</td> </tr> <tr> <td>Verification of the declaration and statements by an independent body in accordance with /ISO 14025:2010/</td> </tr> <tr> <td><input type="checkbox"/> internal      <input checked="" type="checkbox"/> external</td> </tr> </table> <hr/> <p>Dipl. Natw. ETH Sascha Iqbal, Independent verifier appointed by SVR</p>	European standard /EN 15804/ serves as the core PCR	Verification of the declaration and statements by an independent body in accordance with /ISO 14025:2010/	<input type="checkbox"/> internal <input checked="" type="checkbox"/> external
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## 2. Product

### 2.1 Product description/Product definition

Coil coated aluminium sheets are used for applications of all kinds in indoor and outdoor building. The sheets are rolled to the required thickness from aluminium and aluminium alloys and thermally treated according to customer requirements. They are organically coated after metallic manufacturing. Product dimensions and also the type, thickness and the optical design of the surface finishing are determined according to customer requirements.

The specific product was calculated weighted according to the quantity produced by three member companies of the Gesamtverband der Aluminiumindustrie (GDA).

Since coil coated aluminium sheets are semi-finished products they are not subject to any EU harmonisation legislation.

The respective national regulations apply to use of the product at the use location, in Germany for example the /building regulations of the federal states/ and the technical regulations based on these regulations.

### 2.2 Application

The sheets are supplied as semi-finished products and can be adapted for a large number of applications through industrial or manual further processing.

### 2.3 Technical data

The constructional data presented here is relevant for the product.

#### Constructional data

Name	Value	Unit
Bulk density in accordance with DIN 1306/	2700	kg/m <sup>3</sup>
Melting point /Kammer 2009/	660	°C
Electrical conductivity at 20°C /Kammer 2009/	37.7	m/Ωmm <sup>2</sup>
Thermal conductivity /ISO 7345/	235	W/(mK)
Thermal expansion coefficient /ISO 6892-1/	23.1	10 <sup>-6</sup> K <sup>-1</sup>
Elasticity coefficient /ISO 6892-1/	70000	N/mm <sup>2</sup>
Specific thermal capacity /ISO 7345/	0.9	kJ/kgK
Yield strength Rp 0.2 min. /ISO 6892-1/	35 - 250	N/mm <sup>2</sup>
Tensile strength Rm min. /ISO 6892-1/	100 - 350	N/mm <sup>2</sup>
Elongation at break A5 min. /ISO 6892-1/	6 - 30	%

Product performance values in relation to its characteristics are in accordance with the relevant technical purpose (no CE labelling).

### 2.4 Delivery status

The material is supplied as a semi-finished product for further processing in customer-specific dimensions and with customer-specific surface coatings.

### 2.5 Base materials/auxiliary materials

The most important basic material is aluminium which is obtained by electrolysis from bauxite or from recycling aluminium scrap.

Further basic materials used include alloying elements such as silicon, iron, magnesium and zinc in varying concentrations. The end products contain over 90% aluminium.

Typical aluminium alloys for the construction industry comply with the 3000 and 5000 series in accordance with /EN 573/. Approximately 90% water-based alloy-specific synthetic and mineral-based oil emulsions are used as auxiliary materials in the rolling process.

These emulsions are maintained within a closed cycle. Coating materials with a mass share of approximately 3% are applied to the sheet for the coating. The functional chemical group for coil coated aluminium sheet is a fluoropolymer (polyvinylidene fluoride) which belongs to the group of fluorinated hydrocarbons.

Does the product contain substances which are on the candidate list /(16/07/2019) at a mass concentration above 0.1 %: no

Does the product contain further Category 1A or 1B CMR materials which are not on the candidate list at a mass concentration of above 0.1% in at least one partial product: no

Were biocidal products added to this building product or was it treated with biocidal products (is this therefore a processed product in terms of the /Biocide Product Directive/): no

### 2.6 Manufacturing

Generally, rolling ingots are cast from the application-specific aluminium alloy, or the continuous casting method is applied. These rolling ingots are pushed between two rotating steel rollers which are spaced slightly less far apart than the thickness of the rolled material. The rollers pick it up due to friction and compress it to the distance between the rollers. This forming takes place above all longitudinally so that the rolled material becomes elongated. Several rolling sequences are usually necessary to reach the final thickness. Thermal treatment may be carried out as required to achieve the desired material properties with regard to workability and rigidity. Following metal forming, the sheets are coated once or several times in a continuous process. The organic coatings available offer an almost inexhaustible variety of colours.

### 2.7 Environment and health during use

In recent years, the European semi-finished aluminium goods industry has successfully made great efforts to conserve the environment and resources.

For example, continuous optimisations of the rolling and coating processes for aluminium panels make a contribution to resource efficiency (/European Aluminium Association 2018/). This is ensured by management systems (such as /ISO 14001/, /ISO 50001/ and /ISO 45001/) and continuously monitored by accredited certification bodies.

The coating requires the use of organic and inorganic solvents. Solvent vapours which are produced are used as a source of thermal energy by combustion on the works site. No measures are required beyond those prescribed by law.

### 2.8 Product processing/installation

The product can be worked using all familiar industrial and manual metalworking processes including sawing, drilling, welding, glueing, riveting, bending and roll forming. Metalworking occupational safety measures must be observed during working. No specific environmental protection measures are necessary when working and handling aluminium sheets. The general work protection and health instructions for building sites apply.

### 2.9 Packaging

The material is supplied as a rolled coil or sheet metal in the dimensions required by the customer. Wooden and plastic pallets, plastic films and steel, plastic or paper roll cores are used. The packaging materials can be reused or recycled after use. Wooden pallets, plastics and paper can therefore be collected separately and recycled. The most frequently used packaging materials are paper and plastic film.

### 2.10 Condition of use

The condition of use of the material, which is supplied as a semi-finished product, depends on prior treatment by metalworking and installing companies. With appropriate use of the product, no change in material composition either during working or during use is to be expected.

### 2.11 Environment and health during use

No effect relationships with regard to the environment and health are known if coil coated aluminium sheets are used appropriately.

### 2.12 Reference period of use

The period of use for many aluminium applications in the construction sector is frequently determined by the building's period of use. Repair and maintenance are minimal due to the self-passivating surface. With appropriate use, a period of use of more than 70 years can be assumed.

### 2.13 Extraordinary influences

#### Fire

Aluminium and aluminium alloys comply with building material class A1 according to /DIN 4102/ and /EN 13501/ as well as /Directive 96/603/EC/ and therefore do not make any contribution in case of fire. The melting point of aluminium is 660 °C.

Name	Value
Building material class	A1
Flaming droplets	NA
Flue gas development	None
Toxicity of flue gases	NA

#### Water

No environmental effects are known of in case of the unforeseen impact of water. Coil coated aluminium sheets themselves are not affected by water.

#### Mechanical destruction

All materials remain in a bonded state following mechanical destruction.

### 2.14 End-of-life phase

The product is not intended to be reused. The material is completely recyclable. After use, the product can be recycled by a specialist aluminium recycling company. The material produced from this recycling can be reused just like primary material. Current data collected by European Aluminium has ascertained an average recycling rate of over 95% for aluminium applications in the construction sector in Germany and the EU.

### 2.15 Disposal

Aluminium scrap from building applications is an important raw material for future aluminium supplies. The recycling infrastructure is established and available worldwide.

The waste code for aluminium according to the /European Waste Catalogue/ (EAK) is 17 04 02.

The disposal of packaging materials is important for conserving resources. The waste codes for paper, plastic, wood, metal and composite packaging are: 15 01 01, 15 01 02, 15 01 03, 15 01 04, 15 01 05.

### 2.16 Further information

Further information is available at:  
[www.aluinfo.de](http://www.aluinfo.de)

## 3. LCA: Calculation rules

### 3.1 Declared unit

The declared unit relates in each case to 1 kg of average coil coated aluminium sheet.

#### Specification of the declared unit

Name	Value	Unit
Declared unit	1	kg
Conversion factor to 1 kg	1	-

### 3.2 System boundary

EPD type: Cradle to gate with options.

This LCA includes the lifecycle stage of product manufacture and also end of life (EoL).

- The product stage covers Module A1 (Raw materials provision), A2 (Transport) and A3 (Manufacture).
- The EoL includes environmental effects which occur due to waste treatment (material recycling of aluminium sheet). The quantity of aluminium which is recycled (material for recycling, MFR) and the thermal recycling of the core material are declared in C3. The material losses assumed are balanced out in C4.
- Credits from reuse, recovery and recycling potential are shown in Module D in accordance with /EN 15804/.

Due to the low environmental influence of the packaging, its disposal was cut off in Module A5 and the end-of-life of the packaging was not included (cut-off).

### 3.3 Estimations and assumptions

Thermal energy from natural gas was used to estimate the thermal energy from the burning of the solvent. The heating value of the solvent was used for this. NMVOC emissions from combustion (1% of the input) were additionally assumed.

The data record from the EPD entitled "Bare aluminium sheet" (Declaration number: EPD-GDA-2019129-IBG1-EN) was used for the pre-product. It is assumed that the aluminium ingots are transported a distance of 350 km to the place of manufacture.

### 3.4 Cut-off rules

All operating data collected was included in the balance. Processes whose total contribution to the final result by mass and in all impact categories examined is less than 1% were ignored. It can be assumed that the ignored processes contribute less than 5 % each to the impact categories included.

### 3.5 Background data

The /GaBi 8/ software system for an integrated approach developed by thinkstep was used to model the life-cycle for the manufacture of the coil coated aluminium sheet. The consistent data in the /GaBi database/ is documented and can be viewed online at <http://www.gabi-software.com/international/support/gabi/gabi-database-2018-lci-documentation/>.

The base data in the /GaBi database/ was used for energy, transport and auxiliary materials.

### 3.6 Data quality

Association members' data collected for the production year 2015 was used to model the product stage for coil coated aluminium sheet. Data from GSB International e.V. /GSB/ was used for coil coating. All other relevant background data used was taken from the database behind the /Gabi 8/ software. The background data used is less than 5 years old.

### 3.7 Period under review

The data basis for this LCA is based on data collected in 2017. The period under review is 12 months.

### 3.8 Allocation

The quantity of scrap required for manufacturing is first deducted from the aluminium scrap accruing in the

system from production and in end-of-life. The system's net quantity of scrap is thus calculated, i.e. The quantity of scrap which exceeds the system boundary. This results in a credit with primary material less the costs for re-smelting. This credit (substitution of primary material) is assigned to Module D taking into account a recovery rate (recycling rate 90 %).

### 3.9 Comparability

In principle, a comparison or the evaluation of EPD data is only possible if all data to be compared was compiled in accordance with /EN 15804/ and the building context or if product-specific performance characteristics have been included.

The /GaBi- database/ was used to model the product lifecycle.

## 4. LCA: Scenarios and further technical information

The end-of-life for average aluminium sheets consists of 90 % recycling and 10 % disposal in landfill with the corresponding credits and loads.

Disposal of the packaging in Module A5 was ignored due to its small influence (cut-off).

Module D contains the impact of recovery (remelting) and also credits to the emission level of the avoided primary material.

The credits and loads used are based on a Europe-wide average for aluminium scrap and not inherently on the specific scrap value of the aluminium sheets manufactured.

#### End-of-life (C4)

Name	Value	Unit
To landfill	10	%

#### Reuse, recovery and recycling potential (D), relevant scenario information

Name	Value	Unit
Recycling rate	90	%

## 5. LCA: Results

**DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; MND = MODULE NOT DECLARED; MNR = MODULE NOT RELEVANT)**

Production stage			Construction process stage		Use stage							End of life stage				Credits and loads beyond the system boundary
Raw material supply	Transport	Manufacturing	Transport from the gate to the site	Assembly	Use / application	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction / demolition	Transport	Waste processing	Disposal	Reuse, recovery or recycling potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	MND	MND	MND	MND	MNR	MNR	MNR	MND	MND	MND	X	X	X	X

### RESULTS OF THE LCA – ENVIRONMENTAL IMPACTS: 1 kg coil coated aluminium sheet

Parameter	Unit	A1-A3	C2	C3	C4	D
Global warming potential	[kg CO <sub>2</sub> eq.]	6.16E+0	5.94E-3	0.00E+0	1.59E-3	-3.68E+0
Depletion potential of the stratospheric ozone layer	[kg CFC11 eq.]	7.66E-11	1.63E-16	0.00E+0	3.55E-16	-5.12E-11
Acidification potential of land and water	[kg SO <sub>2</sub> eq.]	2.92E-2	2.48E-5	0.00E+0	9.43E-6	-1.88E-2
Eutrophication potential	[kg (PO <sub>4</sub> ) <sup>3</sup> -eq.]	1.96E-3	6.33E-6	0.00E+0	1.30E-6	-1.20E-3
Formation potential for tropospheric ozone photochemical oxidants	[kg Ethene eq.]	1.54E-3	-9.26E-6	0.00E+0	7.33E-7	-9.94E-4
Abiotic depletion potential for non-fossil resources	[kg Sb eq.]	2.85E-6	4.91E-10	0.00E+0	6.13E-10	-1.78E-6
Abiotic depletion potential for fossil resources	[MJ]	6.90E+1	8.14E-2	0.00E+0	2.06E-2	-3.86E+1

### RESULTS OF THE LCA – RESOURCE USE: 1 kg coil coated aluminium sheet

Parameter	Unit	A1-A3	C2	C3	C4	D
Renewable primary energy as energy carrier	[MJ]	3.10E+1	4.50E-3	0.00E+0	2.65E-3	-2.06E+1
Renewable primary energy resources as material utilisation	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Total use of renewable primary energy resources	[MJ]	3.10E+1	4.50E-3	0.00E+0	2.65E-3	-2.06E+1
Non-renewable primary energy as energy carrier	[MJ]	8.00E+1	8.16E-2	0.00E+0	2.14E-2	-4.55E+1
Non-renewable primary energy resources as material utilisation	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Total use of non-renewable primary energy resources	[MJ]	8.00E+1	8.16E-2	0.00E+0	2.14E-2	-4.55E+1
Use of secondary materials	[kg]	4.78E-1	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Use of renewable secondary fuels	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Use of non-renewable secondary fuels	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Use of net fresh water	[m <sup>3</sup> ]	7.75E-2	8.30E-6	0.00E+0	4.08E-6	-5.22E-2

### RESULTS OF THE LCA: OUTPUT FLOWS AND WASTE CATEGORIES: 1 kg coil coated aluminium sheet

Parameter	Unit	A1-A3	C2	C3	C4	D
Hazardous waste disposal	[kg]	7.81E-8	4.72E-9	0.00E+0	3.68E-10	-3.21E-8
Non-hazardous waste disposal	[kg]	1.62E+0	6.84E-6	0.00E+0	1.00E-1	-1.11E+0
Radioactive waste disposal	[kg]	4.32E-3	1.12E-7	0.00E+0	3.05E-7	-2.71E-3
Components for reuse	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Materials for recycling	[kg]	0.00E+0	0.00E+0	4.52E-1	0.00E+0	0.00E+0
Materials for energy recovery	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Exported electrical energy	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Exported thermal energy	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0

## 6. LCA: Interpretation

Modules A1-A3 bear the main environmental loads of the lifecycle. Pre-production provision for the manufacture of the aluminium rolling ingots dominates in all impact categories. The influence is to be classified as significant (> 50 %).

Compared to the old EPD from 2013, the global warming potential in the manufacturing phase is

significantly reduced as approximately 43 % of secondary material is used in the product. The environmental effects have been reduced in all further impact categories through the increased secondary share. By contrast, the environmental effects of energy use and the coil coating are insignificant in all impact categories (< 10%).

## 7. Requisite evidence

The product under review is a semi-finished product. Evidence, for example on weathering, can only be

provided for individual specifically designed and used end products, not for semi-finished goods.

## 8. References

### **/Ordinance on Biocidal Products/**

EU Ordinance No. 528/2012 of the European Parliament and Council of 22<sup>nd</sup> May 2012 on the Provision on the Market and Use of Biocidal Products, 2012

### **/DIN 1306/**

DIN 1306:1984-06 Density; concepts, presentation of values.

### **/DIN 18516/**

DIN 18516-1:2010-06 Cladding for external walls, ventilated at rear - Part 1: Requirements, principles of testing.

### **/DIN 4102/**

DIN 4102:1998- 05, Fire behaviour of building materials and building components.

### **/EN 1090-5/**

DIN EN 1090-5:2020-06 Execution of steel structures and aluminium structures - Part 5: Technical requirements for cold-formed structural aluminium elements and cold-formed structures for roof, ceiling, floor and wall applications.

### **/EN 13501-1/**

/DIN EN 13501-1:2010-01/, Fire classification of construction products and building elements.

### **/EN 1396/**

DIN EN 1396:2015-06 Aluminium and aluminium alloys - Coil coated sheet and strip for general applications - Specifications.

### **/EN 13964/**

DIN EN 13964:2014-08 Suspended ceilings - Requirements and test methods.

### **/EN 14783/**

DIN EN 14783:2013-07 Fully supported metal sheet and strip for roofing, external cladding and internal lining - Product specification and requirements.

### **/EN 1999-1/**

DIN EN 1999-1-1:2014-03 Design of aluminium structures.

### **/EN 485-2/**

DIN EN 485- 2:2018- 12, Aluminium and aluminium alloys - Extruded rod/bar, tube and profiles - Part 2: Mechanical properties.

### **/EN 507/**

DIN EN 507:2019-10 Roofing and cladding products from metal sheet - Specification for fully supported products of aluminium sheet.

### **/EN 508-2/**

DIN EN 508-2:2019-10 Roofing and cladding products from metal sheet - Specification for self-supporting products of steel, aluminium or stainless steel sheet - Part 2: Aluminium.

### **/EN 573-3/**

DIN EN 573- 3:2013- 12, Aluminium and aluminium alloys - Chemical composition and form of semi-finished products - Part 3: Chemical composition and form of products.

### **/European Aluminium Association 2018/**

/European Aluminium Association: 2018-02, Environmental Profile Report.

### **/European Waste Catalogue/**

Commission decision 2000/532/EC

### **/GaBi database/**

GaBi software and database for Life Cycle Engineering, IABP, University of Stuttgart und thinkstep AG, 2018, <http://www.gabi-software.com/international/support/gabi/gabi-database-2018-lci-documentation/>.

### **/GaBi 8/**

GaBi 8 software and database for lifecycle engineering. (SP 36), IABP, University of Stuttgart and thinkstep AG, 2018.

### **/GSB/**

GSB International e.V. Fritz-Vomfelde-Strasse 30 40547 Düsseldorf. <https://gsb-international.de>.

### **/ISO 14001/**

DIN EN ISO 14001:2015- 11, Environmental management systems - Requirements with guidance on use (ISO 14001: 2015).

### **/ISO 45001/**

ISO 45001:2018- 03, Occupational health and safety management systems - Requirements with guidance for use.

### **/ISO 50001/**

ISO 50001:2018- 08, Energy management systems - Requirements with guidance for use.

### **/ISO 6892-1/**

DIN EN ISO 6892-1:2020-06 Metallic materials - Tensile testing - Part 1: Method of test at room temperature.

### **/ISO 7345/**

DIN EN ISO 7345:2018-07 Thermal performance of buildings and building components - Physical quantities and definitions.

### **/Kammer 2009/**

Kammer 2009: Aluminium pocketbook 2009, 16th Edition, Dr.-Ing. C.Kammer, Aluminium-Verlag Marketing und Kommunikation GmbH, Düsseldorf.

### **/Candidate list/**

European Chemicals Agency (ECHA), candidate list of substances of very high concern for authorisation: <https://echa.europa.eu/candidate-list-table> (Date: 16/07/2019; 201 entries)

### **/PCR Part A/**

PCR Part A, calculation rules for the LCA and

requirements of the project report, Version 1.7, Institut Bauen und Umwelt e.V., [www.bau-umwelt.com](http://www.bau-umwelt.com), 2018

**/PCR Part B/**

PCR Part B: Requirements of the EPD for aluminium and aluminium alloy products, Version 1.6, Institut Bauen und Umwelt e.V., [www.ibu-epd.com](http://www.ibu-epd.com), 2017

**/Directive 96/603/EG/**

/Directive 96/603/EC/1996-10 Establishing the list of products belonging to Classes A "No contribution to fire" provided for in Decision 94/611/EC implementing Article 20 of Council Directive 89/106/EEC on construction products.

**/IBU 2016/**

IBU (2016): General EPD programme instructions from Institut Bauen und Umwelt e.V. (IBU). Version 1.1, Institut Bauen und Umwelt e.V., Berlin.

**/ISO 14025/**

DIN EN /ISO 14025:2011-10/, Environmental labels and declarations - Type III environmental declarations - Principles and procedures.

**/EN 15804/**

/EN 15804:2012-04+A1 2013/, Sustainability of construction works - Environmental product declarations - Core rules for the product category of construction products.



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