

Environmental Product Declaration



In accordance with
ISO 14025 and UNI EN 15804:2012+A2:2019/AC:2021 for:

TUBE PROFILED BY COLD STRIP

Marcegaglia Carbon Steel S.p.A.

This EPD covers multiple products, based on the average results of the product group

Programme: **The International EPD® System**,
www.environdec.com

Programme operator: **EPD International AB**
EPD registration number: **EPD-IES-0031787:001**
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*An EPD may be updated or depublished if
conditions change. To find the latest version of
the EPD and to confirm its validity, see
www.environdec.com*

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GENERAL INFORMATION

PROGRAMME INFORMATION

Programme:	The International EPD® System
Address:	EPD International AB Box 210 60 SE-100 31 Stockholm Sweden
Website:	www.environdec.com
E-mail:	info@environdec.com

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

Product category rules (PCR):

Construction products, 2019:14, version 2.0.1., CPC 4128

PCR review was conducted by:

The Technical Committee of the International EPD System.

Review chair: Rob Rouwette (chair), Noa Meron (co-chair) – Contact through the secretariat www.environdec.com/contact

Life Cycle Assessment (LCA)

LCA accountability: Made HSE S.r.l.

Third-party verifier:

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

☒ EPD verification by accredited certification body

Third-party verification: *Bureau Veritas Italia S.p.A.* is an approved certification body accountable for the third-party verification

The certification body is accredited by: *Accredia*

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

☒ Yes ☐ No

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

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

COMPANY INFORMATION

Owner of the EPD:

Marcegaglia Carbon Steel S.p.A

Contact:

For more information on this product declaration and/or its configurations, the following references are available:

Mail: info.carbonsteel@marcegaglia.com - Tel.: +39 0376 6851

Company description:

Marcegaglia Carbon Steel S.p.A. is the company of the Marcegaglia Group that transforms and markets flat products (coils, strips, and sheets) in carbon and pre-painted steel (PPGI) and carbon steel pipes. The company, thanks to advanced production technology and the most modern automation systems, enters the market for the creation of any type of finish on components and accessories, allowing it to satisfy the most demanding and customized requests.

Product/system certifications:

- Quality management system ISO 9001;
- Environmental management system ISO 14001;
- Health and safety management system ISO 45001;
- Energy management system ISO 50001;
- Social responsibility management system SA 8000;
- Carbon Footprint Product systematic approach ISO 14067;
- Organisation Carbon Footprint ISO 14064.

Production site's name and localization:

- Casalmaggiore plant: Vanoni street, 25 – 26041 Casalmaggiore (CR);
- Dusino San Michele plant: Corso Industria street, 20 – 14010 - Dusino San Michele (AT);
- Gazoldo degli Ippoliti plant: Bresciani street, 16 – 46040 - Gazoldo Degli Ippoliti (MN);
- Lomagna plant: Milano street, 41 – 23871 – Lomagna (LC).



PRODUCTS INFORMATION

Product name: Tube profiled by cold strip

Product identification: Tube profiled by cold strip (eventually heat-treated, straightened and cut)

Product description:

From the very first stage of processing, and as part of its fully integrated production cycle, Marcegaglia Carbon Steel manufactures the world's most extensive range of carbon steel welded tubes. These tubes, produced from hot-rolled, cold-rolled, and galvanized strips, are designed for a broad spectrum of applications, ensuring excellent suitability for further processing.

Thanks to exceptional versatility and adaptability, Marcegaglia's precision tubes are engineered to meet the specific requirements of numerous sectors, including radiators, roller systems, greenhouses, doors and windows, fencing, furniture, sports equipment, automotive, mechanical engineering, and many others. Marcegaglia offers the most comprehensive range globally of welded and cold-drawn precision steel tubes, catering to the unique demands of every market segment.

The product range includes round, square, rectangular, oval, elliptical, triangular, and semi-oval tubes, complemented by a wide selection of customized special profiles tailored to customer specifications.

Marcegaglia also supplies an extensive portfolio of cold-formed welded tubes for structural applications, compliant with CE certification, as well as hollow sections made from unalloyed and fine-grain steels, available in hot-finished or cold-formed variants with heat treatment for demanding structural applications.

Lastly, Marcegaglia Carbon Steel offers a comprehensive range of precision cold-drawn tubes, both welded and seamless, available in all standard grades of carbon and low-alloy steels, ideal for use in automotive, hydraulic, and mechanical systems.

Detailed technical specifications for all products can be found in the product catalogues available on the company's website.

UN CPC code: 4128 Tubes, pipes and hollow profiles, of steel

Geographical scope: Global

LCA INFORMATION

Functional unit:

The functional unit of the system considered is 1 ton of tube product.

Reference service life – RSL:

For the products under study it is not possible to quantify the exact useful life as much also depends on their future use. However, it is emphasized that even when the deadline is reached, the product can be recycled and reused again to generate other raw materials.

Time representativeness:

The data used is representative of the year 2025.

Database e software:

Ecoinvent database v.3.11, April 2025 / Software used SimaPro rel. 10.3.0.1.

Description of system boundaries:

The study is entitled "Cradle to gate with modules C1–C4 and module D (A1–A3 + C + D)"

Modules A1-A3 cover material procurement processes (raw and auxiliary materials) as well as production processes.

Modules C1-C4 consider the uninstallation, transport, sorting and disposal of components resulting from end-of-life operations of the product. These operations are not directly controlled by the company: in this regard, data from the construction sector are therefore used:

- an average diesel consumption equivalent to 46 MJ for each ton of material demolished;
- an average distance of 80 km to transport the material to the recovery center;
- an average electricity consumption of 28 kWh for each ton of material sorted.

Module D considers the potential for recovery and recycling of steel from end-of-life processes: the calculation of the environmental benefits of steel recovery is based on the guidelines provided in the document "Product Category Rules for Type III environmental product declaration of construction products to EN 15804:2012 – Par. 6.3.4.6. Benefits and loads beyond the product system boundary, information Module D".



DESCRIPTION OF MAIN ACTIVITIES

This EPD refers only to tubes profiled from cold strip (strip subjected to cold rolling, annealing and skin-passing): the raw material (A1) may change, but the profiling process (input, central and output sections) is carried out in the same way regardless of the input material.

Beginning with carbon steel strips—primarily sourced from the Marcegaglia Carbon Steel S.p.A. facilities in Ravenna and Gazoldo degli Ippoliti—the tubes are manufactured at the production sites in Gazoldo degli Ippoliti, Casalmaggiore, Lomagna, and Dusino. This is done using equipment known as “tube mills,” designed for the induction welding of steel profiles. These systems are typically divided into three main sections: inlet, central, and outlet. In particular, the strips are processed by profiling machines composed of operating heads equipped with steel rollers to obtain the tubes welded in line. Operationally, the following steps are carried out:

INPUT SECTION: consists of a feeding zone and a strip accumulation area;

CENTRAL SECTION: is the portion of the system dedicated to the creation of the profile. It consists of:

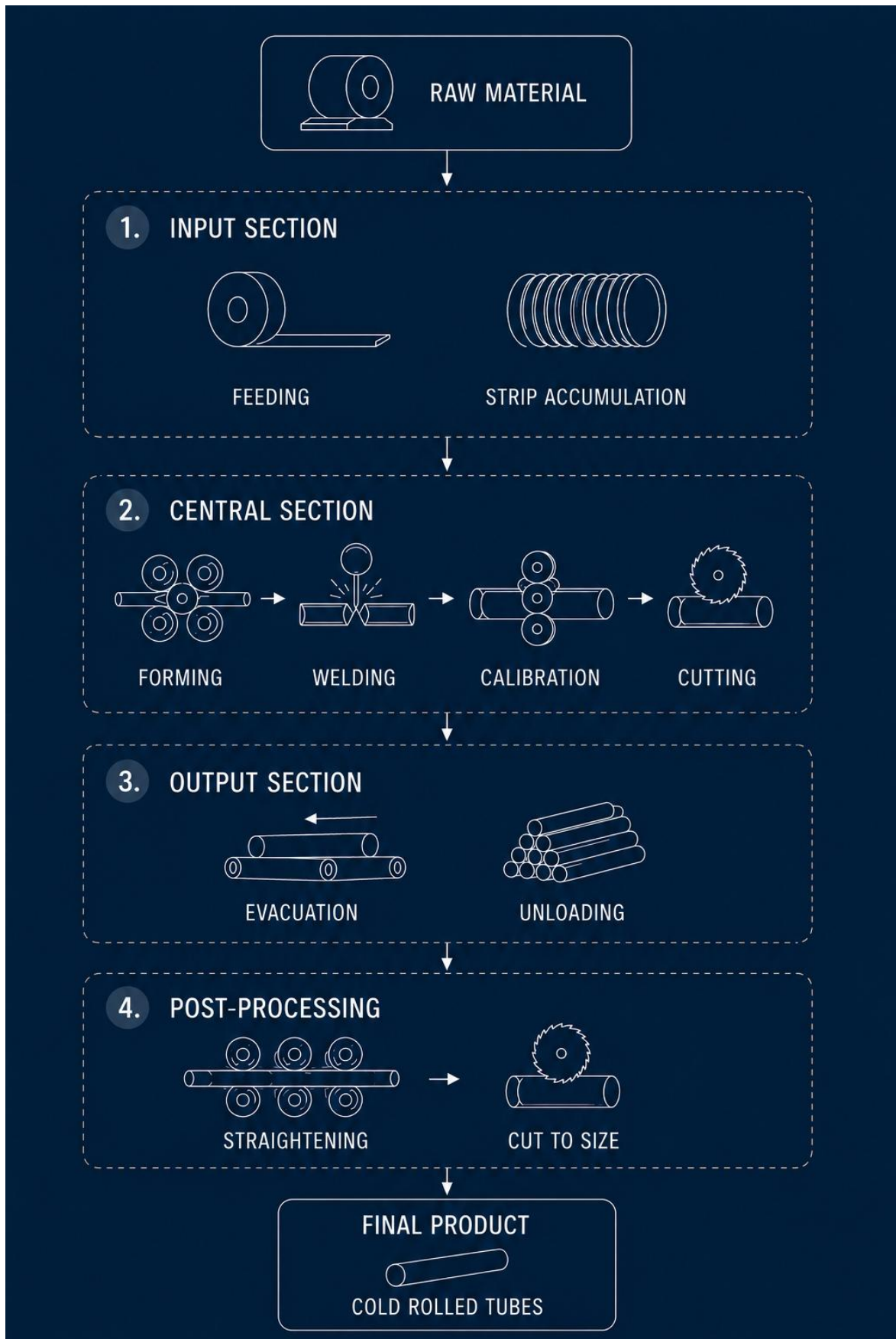
- Forming - Finishing;
- Welding;
- Calibration;
- Cutting.

OUTPUT SECTION: is the portion of the system dedicated to the evacuation and unloading of the profile.

After forming, the tube may be:

- in line heat-treated;
- straightened;
- cut to size.

SYSTEM DIAGRAM



CONTENT INFORMATION

Product content	Weight, kg	Pre and Post-consumer recycled content	Biogenic material, weight-% and kg C/kg
Carbon steel	1,000	19.0%	0

Packaging materials	Weight, kg	Weight-% (versus the product)	Biogenic material, kg C/product or declared unit
plastic	10.4	1.04%	-
wood	2.06	0.21%	< 5%
steel	1.85	0.19%	-

The quantities of such packaging in relation to one ton of final product represent less than 1%.

Electricity information

The electricity used in the manufacturing process of module A3 accounts less than 30% of the GWP-GHG results of modules A1-A3. The climate impact of electricity used by Marcegaglia Carbon Steel S.p.A. in module A3 is calculated as a weighted average of the electricity impacts of the different production sites, based on their respective production volumes, and amounts to 0.246 kg CO₂ eq./kWh. The electricity mix is composed of grid electricity almost entirely covered by Guarantees of Origin, on-site photovoltaic systems installed in approximately half of the facilities and cogeneration units.

Allocation rules

An allocation was made on a mass basis for energy consumption, water discharges, atmospheric emissions and waste.

MODULES DECLARED

Modules declared, geographical scope, share of specific data (in GWP-GHG indicator) and data variation:

Module	A1-A3 Product stage			A4-A5 Construction process stage		B1-B7 Use stage							C1-C4 End of life stage				D Benefits and loads beyond the system boundary
	Raw material supply	Transport	Manufacturing	Transport	Construction	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling- potential
Module	A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Modules declared	X	X	X	ND	ND	ND	ND	ND	ND	ND	ND	ND	X	X	X	X	X
Geography	GLO	GLO	IT	-	-	-	-	-	-	-	-	-	GLO	GLO	GLO	GLO	IT
Specific data	55%					-	-	-	-	-	-	-	-	-	-	-	-
Variations-product	< 10%					-	-	-	-	-	-	-	-	-	-	-	-
Variations-site	< 10%					-	-	-	-	-	-	-	-	-	-	-	-

X = Module considered

ND = Module not declared

GLO = Global

IT = Italy

DATA QUALITY

Data quality was assessed in accordance with EN15804+A2 and the General Programme Instructions of the International EPD System (version 5.0.1, Annex A).

The EPD is based on data collected by Marcegaglia over a one-year period (2025). It is a representation of the production of tube profiled by cold strip (which could also be subjected to thermally treatment, straightening, and cutting).

The EPD incorporates both primary data collected directly from the company and secondary data come from Ecoinvent database. The quality of the data assessed in terms of temporal coverage, geographical, and technological representativeness is rated as very good.

Life cycle stage	Data contribution to GWP [%]	Geographical representativeness	Temporal representativeness	Technological representativeness
A1 Production of steel	95.3%	Very good	Very good	Very good

Process	Source type	Source	Reference year	Data category	Share of primary data, of GWP-GHG results for A1-A3
Manufacturing of product	Collected data	EPD owner	2025	Primary data	2.84%
Generation of electricity used in manufacturing of product	European Residual Mixes 2024 Association of Issuing Bodies	AIB Version 1.0, 2025-05-30	2024	Primary data	2.6%
Transport of steel to manufacturing site	Database	Ecoinvent v3.11	2007/2015	Primary data	0.4%
Production of steel	EPD Database	EPD Ecoinvent v3.11	2025	Primary data, secondary data	85.7%
Production of packaging	Database Collected data	Ecoinvent v3.11 EPD owner	2018	Primary data, secondary data	0.7%
Total share of primary data, of GWP-GHG results for A1-A3					55%

ENVIRONMENTAL INFORMATION

The environmental performance indicators refer to 1 ton of tubes. The characterization factors used in this assessment are based on EN 15804+A2 - EF 3.1, which provide a method for quantifying the environmental impact.

Environmental impact

Impact category	Abb.	Unit
Climate change - total	GWP - t	kg CO ₂ eq
Climate change - Fossil	GWP - fossil	kg CO ₂ eq
Climate change - Biogenic	GWP - biogenic	kg CO ₂ eq
Climate change - Land use and LU change	GWP - luluc	kg CO ₂ eq
Climate change - Greenhouse Gases	GWP - GHG	kg CO ₂ eq.
Ozone depletion	ODP	kg CFC11 eq
Photochemical ozone formation	POCP	kg NMVOC eq
Acidification of land and water	AP	mol H ⁺ eq
Eutrophication	EP - freshwater	kg P eq
	EP - marine	kg N eq
	EP - terrestrial	mol N eq
Water use *	WDP	m ³ depriv.
Resource use, fossils *	ADP - F	MJ
Resource use, minerals, and metals *	ADP - MM	kg Sb eq

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

Resource use

Impact category	Abb.	Unit
Use of renewable primary energy excluding renewable primary energy resources used as raw materials	PERE	MJ
Use of renewable primary energy resources used as raw materials	PERM	MJ
Total use of renewable primary energy resources (primary energy and primary energy resources used as raw materials)	PERT	MJ
Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials	PENRE	MJ
Use of non-renewable primary energy resources used as raw materials	PENRM	MJ
Total use of non-renewable primary energy resources (primary energy and primary energy resources used as raw materials)	PENRT	MJ
Use of secondary material	SM	kg
Use of renewable secondary fuels	RSF	MJ
Use of non-renewable secondary fuels	NRSF	MJ
Use of net fresh water	FW	m ³

Waste production

Impact category	Abb.	Unit
Hazardous waste disposed	HW	kg
Non-hazardous waste disposed	NHW	kg
Radioactive waste disposed	RW	kg

Output flows

Impact category	Abb.	Unit
Reuse	REUSE	kg
Materials for recycling	RECYCLE	kg
Materials for energy recovery	EN-REC	kg
Exported energy-electricity	EE-E	MJ
Exported energy-thermal energy	EE-T	MJ

TUBE PROFILED BY COLD STRIP (EVENTUALLY HEAT-TREATED, STRAIGHTENED AND CUT)

Abb.	Unit	A1-A3	C1	C2	C3	C4	D
GWP - t	kg CO ₂ eq	3,122E+03	4,697E+00	9,697E+00	5,247E+00	9,555E-01	-1,279E+03
GWP - fossil	kg CO ₂ eq	3,126E+03	4,696E+00	9,688E+00	5,222E+00	9,512E-01	-1,252E+03
GWP - biogenic	kg CO ₂ eq	-1,07E+01	9,43E-04	5,89E-03	2,42E-02	1,07E+01	-2,658E+01
GWP - luluc	kg CO ₂ eq	6,935E+00	4,807E-04	3,415E-03	5,154E-04	4,922E-04	-8,088E-01
GWP - GHG	kg CO ₂ eq	3,135E+03	2,406E+01	2,766E+01	8,534E+00	6,234E+00	-1,251E+03
ODP	kg CFC-11 eq	2,461E-05	6,970E-08	2,115E-07	1,119E-07	2,511E-08	-6,136E-06
POCP	kg NMVOC eq	1,453E+01	6,399E-02	4,985E-02	1,399E-02	9,210E-03	-4,218E+00
AP	mol H+ eq	1,195E+01	4,197E-02	3,180E-02	1,870E-02	6,095E-03	-5,413E+00
EP - freshwater	kg P eq	1,177E+00	1,510E-04	6,776E-04	1,243E-03	8,078E-05	-7,377E-01
EP - marine	kg N eq	3,059E+00	1,953E-02	1,078E-02	3,500E-03	2,348E-03	-1,229E+00
EP - terrestrial	mol N eq	2,988E+01	2,139E-01	1,173E-01	3,632E-02	2,564E-02	-1,261E+01
WDP	m ³ depriv.	8,900E+02	1,770E-01	7,756E-01	6,024E-01	3,006E-01	-2,821E+02
ADP - F	MJ	3,368E+04	6,115E+01	1,406E+02	7,927E+01	9,476E+00	-2,158E+03
ADP - MM	kg Sb eq	1,277E-02	1,637E-06	2,859E-05	4,144E-06	1,816E-06	-9,465E-03
PERE	MJ	4,035E+03	3,836E-01	2,199E+00	4,050E+00	2,206E-01	-1,323E+03
PERM	MJ	0,000E+00	0,000E+00	0,000E+00	0,000E+00	0,000E+00	0,000E+00
PERT	MJ	4,035E+03	3,836E-01	2,199E+00	4,050E+00	2,206E-01	-1,323E+03
PENRE	MJ	3,370E+04	6,115E+01	1,406E+02	7,927E+01	9,478E+00	-2,160E+03
PENRM	MJ	0,000E+00	0,000E+00	0,000E+00	0,000E+00	0,000E+00	0,000E+00
PENRT	MJ	3,370E+04	6,115E+01	1,406E+02	7,927E+01	9,478E+00	-2,160E+03
SM	kg	2,729E+02	2,530E-02	6,025E-02	9,515E-03	3,053E-03	-3,676E+01
RSF	MJ	3,301E+00	6,630E-05	7,940E-04	6,236E-05	5,142E-05	-2,245E-02
NRSF	MJ	0,000E+00	0,000E+00	0,000E+00	0,000E+00	0,000E+00	0,000E+00
FW	m ³	3,198E+01	4,312E-03	1,908E-02	1,440E-02	7,228E-03	-8,841E+00
HW	kg	1,220E+03	6,856E-02	2,041E-01	2,119E-01	2,107E-02	-4,437E+02
NHW	kg	1,156E+04	9,987E-01	4,219E+00	6,386E+00	6,834E-01	-4,348E+03
RW	kg	3,371E-02	6,390E-06	3,937E-05	9,774E-05	1,926E-06	-1,603E-03
REUSE	kg	0,000E+00	0,000E+00	0,000E+00	0,000E+00	0,000E+00	0,000E+00
RECYCLE	kg	4,546E+00	2,723E-04	1,694E-03	4,393E-03	5,969E-02	-1,060E-01
EN-REC	kg	1,301E-02	8,688E-07	6,906E-06	1,110E-06	2,833E-07	-8,402E-04
EE-E	MJ	1,178E+01	2,892E-03	2,468E-02	3,955E-03	4,889E-02	-5,849E-01
EE-T	MJ	2,802E+01	1,355E-03	2,742E-02	4,060E-03	1,088E-02	-1,107E+00

- Additional impact results for 100% Landfill end-of-life scenarios:

Abb.	Unit	A1-A3	C1	C2	C3	C4	D
GWP - t	kg CO ₂ eq	3,122E+03	4.697E+00	9.697E+00	1,694E-02	6,309E+00	0,000E+00
GWP - fossil	kg CO ₂ eq	3,126E+03	4.696E+00	9.688E+00	1,695E-02	6,258E+00	0,000E+00
GWP - biogenic	kg CO ₂ eq	-1,071E+01	9.424E-04	5.887E-03	-1,189E-05	4,808E-02	0,000E+00
GWP - luluc	kg CO ₂ eq	6,935E+00	4.808E-04	3.414E-03	1,782E-06	3,589E-03	0,000E+00
GWP - GHG	kg CO ₂ eq	3,135E+03	9.231E+01	9.184E+01	1,695E-02	6,263E+00	0,000E+00
ODP	kg CFC-11 eq	2,461E-05	6.969E-08	2.114E-07	3,039E-10	1,745E-07	0,000E+00
POCP	kg NMVOC eq	1,453E+01	6.399E-02	4.985E-02	4,864E-05	6,632E-02	0,000E+00
AP	mol H+ eq	1,195E+01	4.197E-02	3.180E-02	7,682E-05	4,383E-02	0,000E+00
EP - freshwater	kg P eq	1,177E+00	1.511E-04	6.775E-04	5,161E-06	5,480E-04	0,000E+00
EP - marine	kg N eq	3,059E+00	1.953E-02	1.078E-02	1,329E-05	1,682E-02	0,000E+00
EP - terrestrial	mol N eq	2,988E+01	2.139E-01	1.173E-01	1,379E-04	1,838E-01	0,000E+00
WDP	m ³ depriv.	8,900E+02	1.770E-01	7.756E-01	1,781E-03	1,730E-01	0,000E+00
ADP - F	MJ	3,368E+04	6.115E+01	1.406E+02	2,419E-01	0,000E+00	0,000E+00
ADP - MM	kg Sb eq	1,277E-02	1.635E-06	2.861E-05	1,323E-08	9,159E-06	0,000E+00

- Additional impact results for 100% Recycling end-of-life scenarios:

Abb.	Unit	A1-A3	C1	C2	C3	C4	D
GWP - t	kg CO ₂ eq	3,122E+03	4.697E+00	9.697E+00	1,694E-02	0,000E+00	-1,533E+03
GWP - fossil	kg CO ₂ eq	3,126E+03	4.696E+00	9.688E+00	1,695E-02	0,000E+00	-1,495E+03
GWP - biogenic	kg CO ₂ eq	-1,071E+01	9.424E-04	5.887E-03	-1,189E-05	0,000E+00	-3,744E+01
GWP - luluc	kg CO ₂ eq	6,935E+00	4.808E-04	3.414E-03	1,782E-06	0,000E+00	-9,680E-01
GWP - GHG	kg CO ₂ eq	3,135E+03	9.231E+01	9.184E+01	1,695E-02	0,000E+00	-1,497E+03
ODP	kg CFC-11 eq	2,461E-05	6.969E-08	2.114E-07	3,039E-10	0,000E+00	-7,348E-06
POCP	kg NMVOC eq	1,453E+01	6.399E-02	4.985E-02	4,864E-05	0,000E+00	-5,042E+00
AP	mol H+ eq	1,195E+01	4.197E-02	3.180E-02	7,682E-05	0,000E+00	-6,470E+00
EP - freshwater	kg P eq	1,177E+00	1.511E-04	6.775E-04	5,161E-06	0,000E+00	-8,807E-01
EP - marine	kg N eq	3,059E+00	1.953E-02	1.078E-02	1,329E-05	0,000E+00	-1,469E+00
EP - terrestrial	mol N eq	2,988E+01	2.139E-01	1.173E-01	1,379E-04	0,000E+00	-1,508E+01
WDP	m ³ depriv.	8,900E+02	1.770E-01	7.756E-01	1,781E-03	0,000E+00	-3,123E+02
ADP - F	MJ	3,368E+04	6.115E+01	1.406E+02	2,419E-01	0,000E+00	0,000E+00
ADP - MM	kg Sb eq	1,277E-02	1.635E-06	2.861E-05	1,323E-08	0,000E+00	-1,136E-02

ADDITIONAL LCA RESULTS OF THE PRODUCT

The grouping of these products within a single EPD is considered appropriate, as they belong to the same functional family. Variations above 10% are therefore justified and transparently reported in the LCA results, in accordance with the applicable EPD requirements.

LCA result of one declared unit product	Unit	Min	Max
GWP - t	kg CO2 eq	-4%	4%
GWP - fossil	kg CO2 eq	-4%	3%
GWP - biogenic	kg CO2 eq	-37%	9%
GWP - luluc	kg CO2 eq	-35%	46%
GWP - GHG	kg CO2 eq	-4%	4%
ODP	kg CFC11 eq	-29%	12%
POCP	kg NMVOC eq	-4%	4%
AP	mol H+ eq	-4%	4%
EP - freshwater	kg P eq	-3%	4%
EP - marine	kg N eq	-5%	4%
EP - terrestrial	mol N eq	-4%	4%
WDP	m3 depriv.	-16%	10%
ADP - F	MJ	-8%	6%
ADP - MM	kg Sb eq	-4%	3%

ADDITIONAL ENVIRONMENTAL INFORMATION

The steel used has an average recycled content of 19%: this percentage is calculated as a weighted average of the incoming raw material (from Type III environmental declarations). The steel supplies come from blast furnace (with an average recycled content of 12.6%) or from an electric arc furnace (with an average recycled content of 76.7%).

Regardless of the type of product considered, the element that most affects the final result is the purchased steel. It should be noted that at the end of its useful life, the product is destined for recycling. In particular, the amount of steel destined for recycling is 88.8 % in line with what is indicated in the "Special waste report" of ISPRA – No. 416/2025.

The products do not contain hazardous substances from the SVHC Candidate List for Authorization in quantities greater than 0.1%.

VERSION HISTORY

This is the original version of EPD according to PCR 2.0.1 / GPI 5.0.1.

ABBREVIATIONS

Abbreviation	Definition
EN	European Norm (Standard)
GPI	General Programme Instructions
ISO	International Organization for Standardization
CEN	European Committee for Standardization
CPC	Central product classification
SVHC	Substances of Very High Concern
ND	Not Declared
D	Declared

REFERENCES

- General Programme Instructions of the International EPD® System. Version 5.0.1;
- PCR 2019:14 Construction products (EN 15804+A2) vers. 2.0.1 (2025-06-05) ;
- Product Category Rules for Type III environmental product declaration of construction products to EN 15804:2012;
- Ecoinvent database v.3.11 – April, 2025;
- ISO 14025: 2010 “Environmental labels and declarations - Type III environmental declarations - Principles and procedures”;
- ISO 14040:2021 “Environmental management - Life cycle assessment - Principles and framework”;
- ISO 14044:2021 “Environmental management - Life cycle assessment - Requirements and guidelines”;
- ISO 15804:2021 “Sustainability of buildings - Environmental product declarations - Development framework rules by product category”;
- CSIRO “Metal recycling: The need for a life cycle approach” – May 2013;
- IFEU-Institut and Sineco “Recovery of demolition materials of CaseClima” – September 2012;
- European Residual Mixes 2024 Association of Issuing Bodies “European Residual Mixes Results of the calculation of Residual Mixes for the calendar year 2024” – 2025-05-30;
- ISPRA “Special waste report” – n° 416/2025 – Ed. 2025;



Registered seat:

Via Bresciani, 16 – 46040, Gazoldo degli Ippoliti (MN) – Italy

Main offices and plants:

Vanoni street, 25 – 26041

Casalmaggiore (CR) - Italy;

Corso Industria street, 20 – 14010

Dusino San Michele (AT) – Italy

Bresciani street, 16 – 46040

Gazoldo Degli Ippoliti (MN) – Italy

Milano street, 41 – 23871

Lomagna (LC) – Italy

Phone +39 0376 6851

info.carbonsteel@marcegaglia.com

