

Golden Bay®

# Building a Better Future

Delivering innovation to help reduce the impact on the built environment in New Zealand



## Environmental Product Declaration

EcoSure® GP cement  
EcoFast® HE cement

In accordance with ISO 14025 and EN 15804+A1



Publication date: 12 May 2019 (Version 1.0)

Revision date: 12 June 2023 (Version 1.1)

Valid until: 11 May 2024

Geographical scope: Global, based on manufacture in New Zealand

No. S-P-01170

# Golden Bay

Golden Bay's Portland Manufacturing Plant is the only fully integrated cement manufacturing plant remaining in New Zealand. The Plant, located on the southern shore of the Whangarei Harbour in Northland, is a contemporary world class cement production facility, with a very long successful innovative history. The Portland Plant recently celebrated a century of cement production at the present site.

Sustainability underpins everything we do at Golden Bay, as we lead the industry in pioneering sustainable and ethical practices with minimal impact on the environment. We are proud to already offer the lowest carbon GP cement at scale in New Zealand. Making it easy for our customers to reduce their carbon emissions without having to make changes to their operations. We are committed to reducing our carbon footprint by 30% by 2030<sup>1</sup> which we are well on the path to exceed.

Our manufacturing processes are driving our reduction in carbon by reducing our reliance on fossil fuels and investing in a circular strategy to replace fossil fuels such as coal with recycled materials. This includes a partnership with the government to recycle end-of-life tyres. As at June 2022, we have disposed of 3,000,000 tyres, or 30,000 tons of tyres per year. 1 ton of tyres displaces 1.12

tons of coal. Over the 15 months since introduction of the tyres we have reduced CO2 emissions by 24,000 tons. This combined with our construction wood waste and other alternative fuels has allowed us to displace 50% of our coal for circular fuel sources. Diverting 80,000 tons of waste from landfill in 2022. We will be adding in waste plastic to our fuel substitution to reach an 80% substitution of fossil fuels over the next 2 years. We continue to assess the use of further alternative fuel sources as part of our overall strategy to reduce our reliance on fossil fuels and to reduce our CO2 emissions.

Our decarbonisation strategy also includes the circular use of waste, not only in our fuels, but also our product materials, including waste streams like Pond Ash from Genesis, helping us reach our 30% carbon reduction by 2030.

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<sup>1</sup> Find out more at <https://fletcherbuilding.com/sustainability/sustainability-reports-publications-and-policies/>

Golden Bay also benefit from New Zealand's unique renewable electricity generation position contributing to lower emissions than if thermal generation sources were used.

Golden Bay are members of the New Zealand Green Building Council, and, as a business unit of Fletcher Building Ltd, we are a member of the Sustainable Business Council and the Sustainable Business Network.

Golden Bay prides itself on manufacturing a cement that is tailored for New Zealand conditions and our ability to maintain a high level of quality and product consistency that our market requires. We operate a fully TELARC certified ISO 9001 Quality Management System and all testing is monitored by our IANZ accredited laboratory.

This EPD document refers to the Type GP (General Purpose) and HE (High Early) cement products that are produced at this facility.

From the facility the cement is distributed in road tankers, bags, ISO containers and by coastal shipping. The majority of the cement is distributed by coastal shipping and is stored at a number of key locations around New Zealand and then road tankers deliver to our customer silos.

Under the New Zealand Green Building Council's Green Star rating system, up to three points can be awarded under MAT-7 Concrete and Aggregate, Criteria A, where it can be demonstrated that all concrete used has a reduced environmental impact.

Environmental Product Declarations are a recognised initiative to demonstrate these criteria.

**For more information, see: [www.goldenbay.co.nz/sustainability](http://www.goldenbay.co.nz/sustainability)**



**Version History:**

**V1.0**

**V1.1**

Initial version of 12 May 2019

Revised version with updated product composition and fuel split for clinker production.

Renamed products EverSure™ GP cement and EverFast™ HE cement to EcoSure® GP cement and EcoFast® HE cement, respectively.

# Products covered by this Environmental Product Declaration (EPD)

This EPD covers two cement products manufactured at Golden Bay facilities in New Zealand. They include:

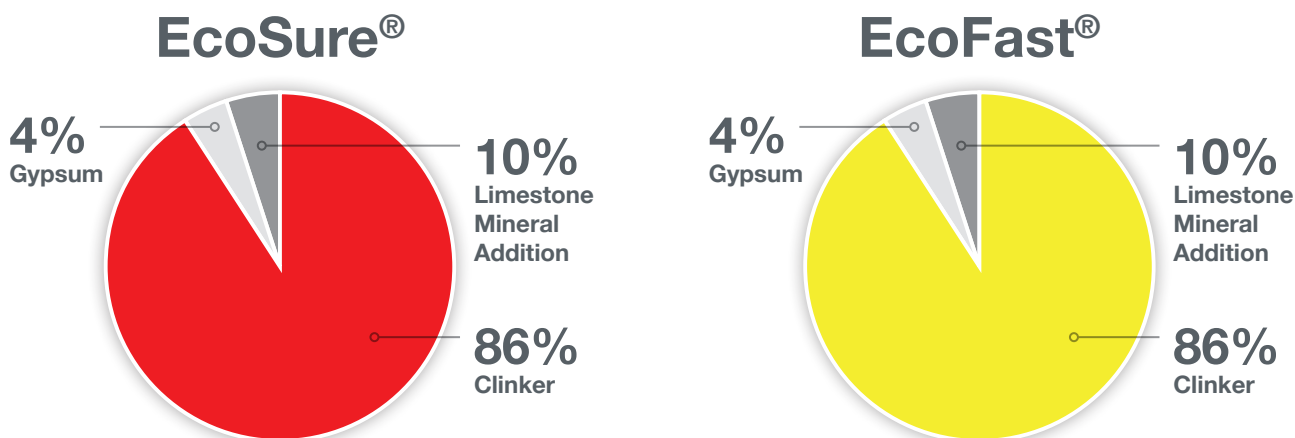
1. Bulk type cement, 20kg, 40kg EcoSure® General Purpose (GP) Cement
2. Bulk type cement, 20kg, 40kg EcoFast® High Early Strength (HE) Cement

## Applications

EcoSure® (GP) Cement is used in commercial, industrial and residential construction, including structural concrete, mortars, renders, grouts and cement-based products. It can also be used as a general binder for applications such as soil stabilisation. EcoFast® (HE) Cement has a finer grain size and is specifically designed for precast concrete products.

## Composition

Golden Bay products have a typical composition as follows:



Composition of both EcoSure® GP and EcoFast® HE were reduced to 86% clinker from 92% in previous version.

Golden Bay products are compliant with the European REACH regulation (EC) 1907/2006\* and do not release any hazardous substances when in use. For safe use and maintenance, refer to the appropriate product's Safety Data Sheet (SDS) at [www.goldenbay.co.nz/products](http://www.goldenbay.co.nz/products).

## Environmental certifications

EcoSure® GP and EcoFast® HE have Declare labels and are certified Red List Free by the International Living Future Institute. For more information, visit: <https://declare.living-future.org/products/golden-bay-cement-everasure-gp-and-everfast-he-cement>

## Industry classifications

All products in this EPD fall under the UN CPC classification '3744 Cement' and ANZSIC classification '2031 Cement and Lime Manufacturing'.

\*Regulation on Registration, Evaluation, Authorisation and Restriction of Chemicals.

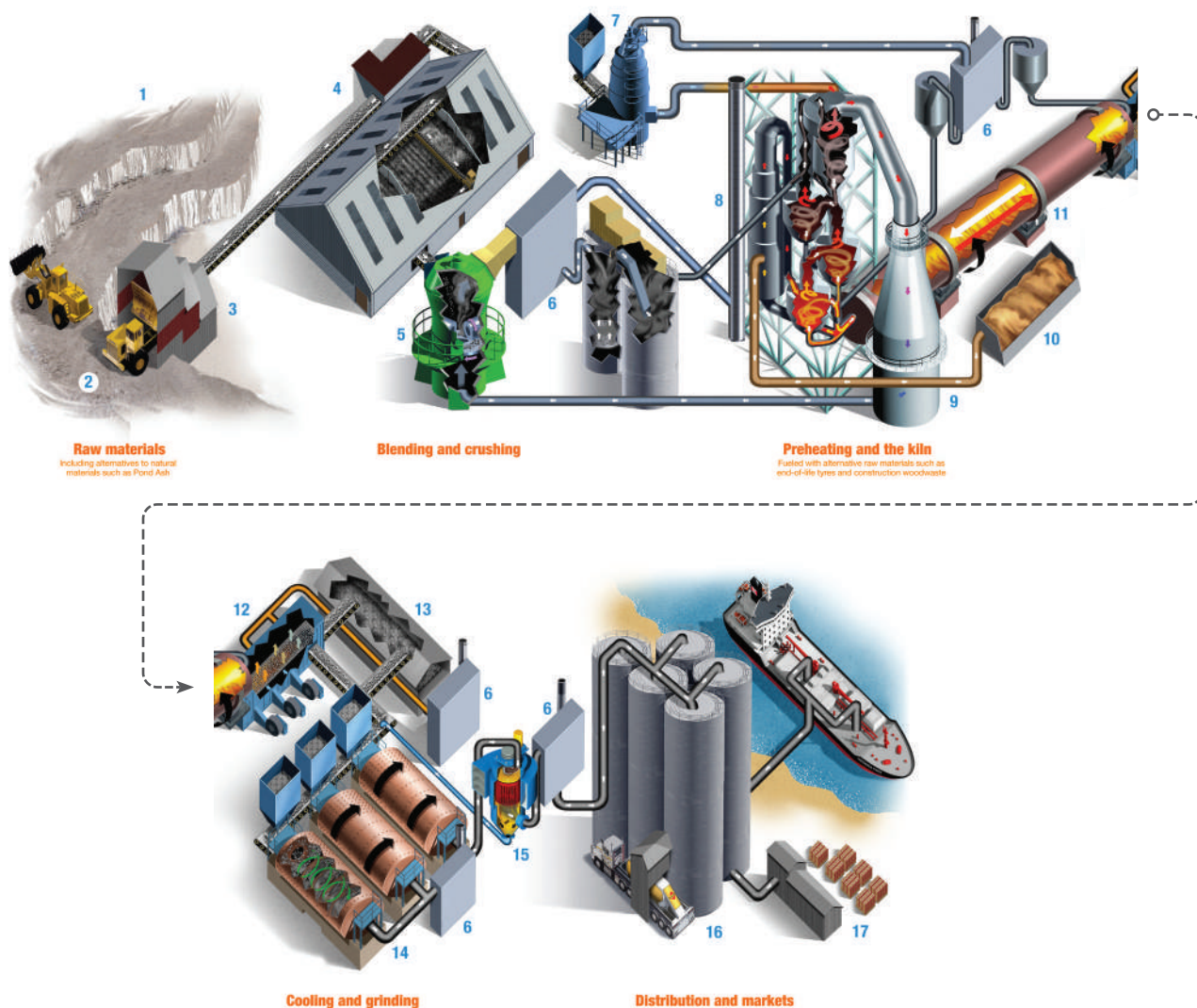
# Manufacturing of Golden Bay

Cement rock and limestone are quarried at the Portland and Wilsonville quarries respectively. Explosives are used to blast the rock apart, then mobile plant (loaders and dump trucks) transfer the rock. Road trucks are used to transport the limestone to Portland quarry. Rock is loaded into a crusher and onto a conveyor belt leading to the manufacturing plant. A portion of high quality limestone is processed by a mobile crusher for use as an extender. The crushed cement rock and limestone are fed into the raw mill along with iron sand and alternative raw materials such as Pond Ash. The raw meal produced is then blended and fed into the precalciner and kiln where clinker is produced at high temperatures by firing coal and alternative fuels, followed by cooling in the clinker cooler.

Bulk type cements, EcoSure® GP and EcoFast® HE, comprise of clinker, gypsum and extender rock (limestone with a higher purity of calcium carbonate extracted at Wilsonville Quarry). These are milled in the cement mills by steel grinding media. EcoFast® type HE cement is milled for a longer period in the cement mills to achieve a smaller average particle size relative to the EcoSure® type GP cement.

1. Quarry
2. Mobile plant
3. Crusher
4. Raw materials reclaimer
5. Raw mill
6. Baghouse dust collector
7. Coal mill
8. Preheater/precalciner
9. Gas conditioning tower
10. Alternative/bio fuels (end-of-life tyres, construction woodwaste)
11. Kiln
12. Clinker cooler
13. Clinker storage
14. Cement mills
15. Classifier
16. Bulk cement storage and loading
17. Bagging plant

## Manufacturing Plant Process



# Scope of EPD

This is a 'cradle-to-gate' EPD covering modules A1 to A3 from European Standard EN 15804:2012 +A1:2013 (see Table 1). Modules A4-A5, B1-B7, C1-C4 and D are excluded from this EPD as they are dependent on how the product is used and should be developed as part of holistic assessment of specific construction works.

**Table 1 - Scope of EPD**

Product stage			Construction process stage		Use stage						End of life stage				Recovery stage	
Raw material supply	Transport	Manufacturing	Transport	Installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction / demolition	Transport	Waste processing	Disposal	Future reuse, recycling or energy recovery 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	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND

X = module declared; MND = module not declared (such a declaration shall not be regarded as an indicator result of zero)

The scope of the study includes all processes from the mining of natural resources ('cradle') to the production of cement that is ready for transport to customers at Golden Bay's factory gate. This includes mining of raw materials, such as cement rock and limestone, transport to and within the manufacturing sites, clinker manufacture, ancillary service operations and cement production, up to the point where the final cement is ready for dispatch to customers at the exit gate of the manufacturing site. Packaging of cement is excluded since bulk type products are loaded directly onto the distribution vessel.

The system boundary also includes manufacture of other required input materials, transport between processing operations, the production of external services such as electricity, natural gas and water, and the production of co-product materials within the cement manufacturing process. Waste and emissions to air, land and water are also included where appropriate.

## Declared unit

The declared unit is one tonne of cement, ready for distribution at the outbound gate of the respective manufacturing site. The gate for bulk cement is Portland, Whangarei.

## LCA methodology and data

This EPD has been produced in conformance with the requirements of PCR 2012:01 Construction Products and Construction Services v2.2.

## Data

Primary data was used for all manufacturing operations up to the factory gate. Data for manufacturing of the cement types was provided by Golden Bay. All relevant and available data was collected. All raw materials inputs and flows have been captured to produce cement.

Background data from GaBi Life Cycle Inventory Database 2022.1 (Sphera, 2022) or literature was used when no site-specific data was available for upstream (A1) inputs. Most upstream datasets are representative of Europe, particularly Germany. The use of such proxies is due to the lack of New Zealand-specific datasets. Use of background data was not required within the gate-to-gate (A3) scope.

## Period

Product composition and fuel split for clinker production have been updated to reflect period from 1st July 2021 to 30th June 2022. Upstream processes such as mining remain as per base year (1 July 2013 to 30 June 2014).

As required by EN 15804, all primary data has been updated within the last five years and all background data has been updated within the last 10 years.

## Cut-off criteria

Cut-off criteria according to EN 15804 has been used:

- <1% of total mass or energy inputs to any unit process are excluded.
- <5% of the total energy or mass flows are excluded.

## Allocation

Allocation was carried out in accordance with PCR 2012:01 section 7.7. Co-product allocation was carried out based on physical relationships in any cases except for wood waste, where economic allocation was applied due to a large difference in economic value between co-products.

## Key assumptions

- **Upstream data:** With the exception of data for energy, which correctly reflect New Zealand conditions, most upstream data used were European due to a lack of consistent LCI data for New Zealand at the time this study was conducted.
- **Electricity:** New Zealand electricity is assumed to be the 2018 national average with a Global Warming Potential of 124 g CO<sub>2</sub>e/kWh, made up of 74% renewable (57.02% hydro, 17.9% geothermal, 4.85% wind, 0.74% biomass, 0.59% biogas) and 26% fossil fuels (15.97% natural gas, 1.26% hard coal, 1.44% coal gases, 0.05% lignite) (Sphera, 2022).



# Glossary

## Global Warming Potential (GWP)

### -> Climate Change

A measure of greenhouse gas emissions, such as carbon dioxide and methane. These emissions increase absorption of radiation emitted by the earth, intensifying the natural greenhouse effect.

## Ozone Depletion Potential (ODP)

### -> Ozone Hole

A measure of air emissions that contribute to the depletion of the stratospheric ozone layer, causing higher levels of ultraviolet B (UVB) to reach the earth's surface with detrimental effects on humans, animals and plants.

## Acidification Potential (AP)

### -> Acid Rain

A measure of emissions that cause acidifying effects to the environment. Acidification potential is a measure of a molecule's capacity to increase the hydrogen ion (H<sup>+</sup>) concentration in the presence of water, thus decreasing the pH value. Potential effects include fish mortality, forest decline and the deterioration of building materials.

## Eutrophication Potential (EP)

### -> Algal Blooms

A measure of nutrient enrichment that may cause an undesirable shift in species composition and elevated biomass production in both aquatic and terrestrial ecosystems. It includes potential impacts of excessively high levels of macronutrients, the most important of which are nitrogen (N) and phosphorus (P).

## Photochemical Ozone Creation Potential (POCP)

### -> Smog

A measure of emissions of precursors that contribute to ground level smog formation (mainly ozone O<sub>3</sub>), produced by the reaction of volatile organic compounds (VOCs) and carbon monoxide in the presence of nitrogen oxides under the influence of UV light. Ground level ozone may be harmful to human and ecosystem health and may also damage crops.

## Abiotic Depletion Potential (ADP)

### -> Resource Consumption

The consumption of non-renewable resources leads to a decrease in the future availability of the functions supplied by these resources. Depletion of mineral resource elements (ADPE) and non-renewable fossil energy resources (ADPF) are reported separately.





# Results of assessment

Table 2: Environmental impact indicator results per 1 tonne of cement

Indicator	Unit	GP, EcoSure®, A1-A3	HE, EcoFast®, A1-A3
Global warming potential (GWP)	[kg CO <sub>2</sub> -Equiv.]	699	703
Depletion potential of the stratospheric ozone layer (ODP)	[kg CFC 11-eq.]	4.25E-11	5.17E-11
Acidification potential of land and water (AP)	[kg SO <sub>2</sub> -eq.]	0.702	0.713
Eutrophication potential (EP)	[kg PO <sub>4</sub> <sup>3--</sup> -eq.]	0.188	0.190
Photochemical ozone creation potential (POCP)	[kg C <sub>2</sub> H <sub>4</sub> -eq.]	0.0575	0.0582
Abiotic depletion potential – elements (ADPE)	[kg Sb-eq.]	3.64E-06	4.49E-06
Abiotic depletion potential – fossil fuels (ADPF)	[MJ]	2,240	2,280



Table 3: Use of Resources per 1 tonne of cement

Indicator	Unit	GP, EcoSure®, A1-A3	HE, EcoFast®, A1-A3
Renewable Primary Energy as Energy Carrier (PERE)	[MJ]	762	983
Renewable Primary Energy Resources as Material Utilisation (PERM)	[MJ]	0	0
Total use of Renewable Primary Energy Resources (PERT)	[MJ]	762	983
Non renewable Primary Energy as Energy Carrier (PENRE)	[MJ]	2250	2290
Non renewable Primary Energy as Material Utilisation (PENRM)	[MJ]	0	0
Total use of non renewable Primary Energy Resources (PENRT)	[MJ]	2250	2290
Use of Secondary Material (SM)	[kg]	7.79	7.79
Use of Renewable Secondary Fuels (RSF)	[MJ]	690	690
Use of Non Renewable Secondary Fuels (NRSF)	[MJ]	0.621	0.621
Use of net Fresh Water (FW)	[m <sup>3</sup> ]	2.20	2.77

Table 4: Wastes and other output flows per 1 tonne of cement

Indicator	Unit	GP, EcoSure®, A1-A3	HE, EcoFast®, A1-A3
Hazardous Waste Disposed (HWD)	[kg]	1.31E-08	1.62E-08
Non hazardous Waste Disposed (NHWD)	[kg]	0.138	0.174
Radioactive Waste Disposed (RWD)	[kg]	2.89E-04	3.11E-04
Components for Re-use (CRU)	[kg]	0.0229	0.0229
Materials for Recycling (MFR)	[kg]	0	0
Materials for Energy Recovery (MER)	[kg]	0	0
Exported Electrical Energy (EEE)	[MJ]	0	0
Exported Thermal Energy (EET)	[MJ]	0	0



# Interpretation

Care should be taken when comparing EPDs

While this EPD meets all requirements for reporting in PCR 2012:01, it is important to recognise that Life Cycle Assessment is not a complete assessment of all environmental or sustainability issues of the product system under study.

When comparing EPD results, note that:

- EPDs of construction products may not be comparable if they do not comply with EN 15804.
- EPDs within the same product category, but from different programmes or utilising different Product Category Rules (PCR) documents, may not be comparable.

## Impact category results

The cement kiln is the source of most 'cradle-to-gate' environmental impacts of the different products covered by the study. Energy consumption (coal, electricity and wood waste), and emissions at the kiln stacks, are particularly important.

**Global warming potential:** Emissions from the kiln processes contribute more than 90% of the impacts. This is due to carbon dioxide emissions from the combustion of coal and wood waste, and from the calcination process of calcium carbonate in the kiln.

**Ozone depletion potential:** Coal and electricity consumption for all processes are the main contributors, along with the ammonia mix in the explosives used at the quarries.

**Acidification potential, eutrophication potential and photochemical ozone creation potential:** The highest contributions to environmental impacts come from nitrogen oxides and sulphur dioxide emissions from the kiln; coal and electricity consumption; and the combustion of fuel oils for the transport of materials via sea. Acidification potential is also driven by on-site combustion, through the release of SO<sub>x</sub>, NO<sub>x</sub> and other emissions in combustion processes.

**Abiotic depletion (elements):** Natural gypsum, which is added during the cement milling process, contributes more than 99% of the impacts.

**Abiotic depletion (fossils):** The use of hard coal within the kiln contributes more than 90% of the impacts.

## Green Star compliance

This EPD meets the requirements of the New Zealand Green Building Council's Green Star rating tool as it:

- Follows ISO 14025 and EN 15804;
- Is independently verified;
- Has a cradle-to-gate scope; and
- Is product-specific.

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## References

IEPDS. (2017). PCR 2012:01, Construction products and Construction services, Version 2.2, 2017-05-30. Stockholm: International EPD® System.

Hon, Q. and McArthur, J. (2015). Life Cycle Assessment for EverSure®, EverFast® and Enviro Choice type Cement Manufactured by Golden Bay. Golden Bay, Fletcher Building Infrastructure Group. Critical review by B. Canaguier of Catalyst Ltd against ISO 14044:2006, EN 15804:2013 and PCR 2012:01 completed 17/06/2015.

ISO 9001:2015. Quality management systems – Requirements. Geneva: International Organization for Standardization.

ISO 14025:2006. Environmental labels and declarations – Type III environmental declarations – Principles and procedures. Geneva: International Organization for Standardization.

EN 15804:2012+A1:2013. Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products. Brussels: European Committee for Standardization.

Sphera. (2022). *GaBi LCA Database Documentation*. Retrieved from GaBi Life Cycle Inventory Database Documentation: <https://sphera.com/product-sustainability-gabi-data-search/>



# Verification and Contacts



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CEN standard EN 15804+A1 served as the core PCR

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## PCR

PCR 2012:01 Construction Products and Construction Services,  
Version 2.2, 2017-05-30

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## PCR review was conducted by

The Technical Committee of the International EPD® System.

**Chair:** Massimo Marino.  
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## Independent verification of the declaration and data, according to ISO 14025

- EPD process certification (Internal)  
 EPD verification (External)



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