

Owner: Egersund Wienerberger A/S:  
Helligsø Teglværk  
No.: MD-22004-EN  
Issued: 25-02-2022  
Valid to: 25-02-2027

3<sup>rd</sup> PARTY VERIFIED

**EPD**

VERIFIED ENVIRONMENTAL PRODUCT DECLARATION | ISO 14025 & EN 15804:2012  
+ A1:2013



**Owner of declaration**

Egernsund Wienerberger A/S  
Rørmoesevej 85  
DK-3200 Helsingør  
CVR: 10502306



**Issued:**  
25-02-2022

**Valid to:**  
25-02-2027

**Basis of calculation**

This Environmental Product Declaration is developed in accordance with ISO 14025 and EN 15804:2012 + A1:2013.

**Programme operator**

Danish Technological Institute  
Gregersensvej  
2630 Taastrup



**Comparability**

EPDs of construction products may not be comparable if they do not comply with the requirements in EN 15804:2012 + A1:2013. EPD data may not be comparable if the datasets used are not developed in accordance with EN 15804:2012 + A1:2013 and if the background systems are not based on the same database.

**Programme**

EPD Danmark  
Gregersensvej  
2630 Taastrup  
www.epddanmark.dk



**Validity**

This EPD has been verified in accordance with ISO 14025 and is valid for 5 years from the date of issue.

**Use**

The intended use of an EPD is to communicate scientifically based environmental information for construction products, for the purpose of assessing the environmental performance of buildings.

**Declared product**

1 tonne of "yellow" bricks (yellow and sand-colored bricks) based on Danish yellow-, and red-firing clay, e.g. EW2134, EW2136 and EW2169. Produced using certified green electricity and either natural gas or certified biogas (bionaturgas).

**EPD type**

- Cradle-to-gate
- Cradle-to-gate with options
- Cradle-to-grave

**Production site**

Helligsø Teglværk  
Helligsøvej 15,  
7760 Hurup

Tiles & Bricks Europe (2014) PCR for Clay Construction Products – "Guidance document for developing an EPD" serves as the cPCR

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

- internal
- external

Third party verifier:

Ninkie Bendtsen

**Product use**

Bricks are used to build walls, pillars and partitions.

Martha Katrine Sørensen  
EPD Danmark

**Declared unit**

1 tonne of "yellow" bricks (yellow and sand-colored bricks) based on Danish yellow-, and red-firing clay and produced at Helligsø Teglværk using either natural gas or certified biogas. Certified green electricity is used at production site. Expected average reference service life of 150 years.

**Life cycle stages and modules (MND = module not declared)**

| Product             |           |               | Construction process |                      | Use |             |        |             |               |                        |                       | End of life                |           |                  | Beyond the system boundary |  |
|---------------------|-----------|---------------|----------------------|----------------------|-----|-------------|--------|-------------|---------------|------------------------|-----------------------|----------------------------|-----------|------------------|----------------------------|--|
| Raw material supply | Transport | Manufacturing | Transport            | Installation process | Use | Maintenance | Repair | Replacement | Refurbishment | Operational energy use | Operational water use | De-construction demolition | Transport | Waste processing | Disposal                   | Re-use, recovery and recycling potential |
| A1                  | A2        | A3            | A4                   | A5                   | B1  | B2          | B3     | B4          | B5            | B6                     | B7                    | C1                         | C2        | C3               | C4                         | D  |
| X                   | X         | X             | X                    | X                    | X   | X           | X      | X           | X             | X                      | X                     | X                          | X         | X                | X                          | X  |

# Product information

## Product description

The product is a “yellow” brick based on Danish yellow-, and red-firing clay (yellow and sand-colored bricks). Produced using green electricity and either natural gas or biogas. The product components and packaging materials are shown in the tables below.

| Material         | Weight-% of declared product |
|------------------|------------------------------|
| Danish red clay  | 2,9                          |
| Danish blue clay | 58                           |
| Chamotte         | 5,7                          |
| Sand             | 31                           |
| Manganese oxide  | 0,51                         |
| Engobe           | 0,19                         |
| Barium carbonate | 0,063                        |
| Water            | 2,0                          |
| <b>TOTAL</b>     | <b>100</b>                   |

| Packaging           | Weight-% of packaging |
|---------------------|-----------------------|
| LDPE-film           | 96                    |
| Plastic strap (PET) | 4                     |
| <b>TOTAL</b>        | <b>100</b>            |

## Representativeness

This declaration, including data collection, the modelled foreground system and the results, represents 1 tonne of bricks from the production site located in Hurup Thy, Denmark. Product specific data are based on average values collected from 2020.

Background data are based on the GaBi database, supplemented with a few datasets from Ecoinvent. Generally, the used background datasets are of high quality and less than or 5 years old. All datasets are less than 10 years old.

## Dangerous substances

Bricks do not contain substances listed in the “Candidate List of Substances of Very High Concern for authorisation” (<http://echa.europa.eu/candidate-list-table>)  
Absence of these substances are declared by the producer.

## Essential characteristics (CE)

Bricks are covered by the scope of the harmonized standard EN 771-1:2011+A1:2015. Furthermore, DoP’s (Declaration of Performance) exist for each covered brick.

DoP’s Egersund Wienerberger’s website.  
(<https://www.egernsund.com/vaerktojer-service/projektberegning-teknisk-information/dop-ce-deklarationer.html>).

For further technical information can be obtained by contacting the manufacturer or on the manufacturers website:

<https://www.egernsund.com>

**Reference Service Life (RSL)** 150 years.

RSL is based on the cPCR for clay construction products:  
*"For clay construction products, the RSL is 150 years. Studies have shown that clay construction products stand out with their high durability and prevail with no maintenance and a life span of 150 years or more".*

**Product illustrations:** The illustrated products below are examples of products covered by this EPD.



EW2134 White Gobi



EW2136 Light Coal



EW2169 Cold Hawaii

# LCA background

## Declared unit

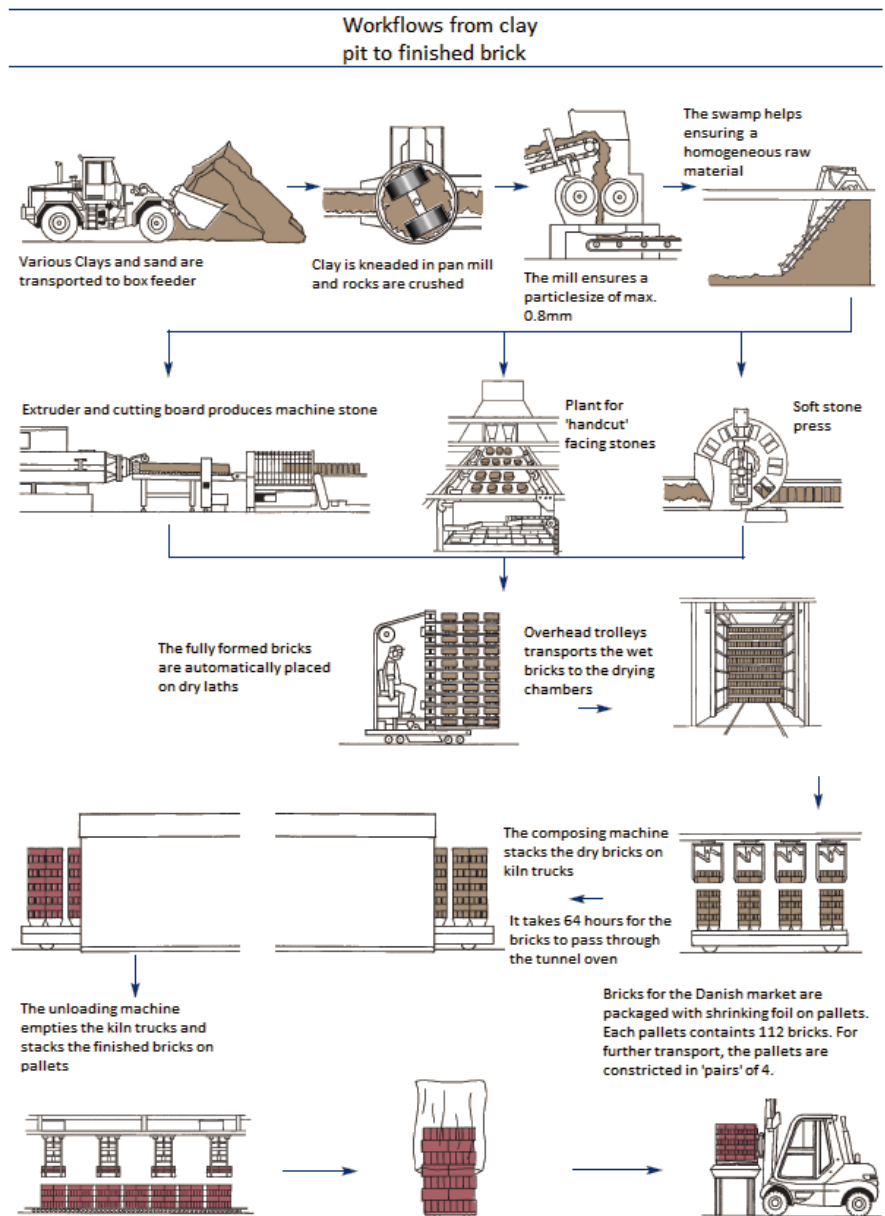
The LCI and LCIA results in this EPD relates to 1 tonne of bricks.

| Name                       | Value     | Unit              |
|----------------------------|-----------|-------------------|
| Declared unit              | 1         | tonne             |
| Density                    | 1650-1700 | kg/m <sup>3</sup> |
| Conversion factor to 1 kg. | 0,001     | -                 |

## PCR

This EPD is developed according to the core rules for the product category of construction products in EN 15804:2012 + A1:2013 and the product specific PCR "TBE PCR for clay construction products" (cPCR). This EPD does not include additional impact categories recommended in the PCR since these have not commonly been included in former danish EPDs on bricks and since these categories are now outdated and new versions included in EN15804+A2.

Flow diagram



The flow diagram conforms with the requirements in the modular approach and shows the production phase A3 for brick production (Helligsø Teglværk uses "soft stone press" and "extruder" but no "handcut"). The remaining phases are described below.

## System boundary

This EPD is based on a cradle-to-grave LCA (module A1-D), in which 100 weight-% has been accounted for. All relevant processes during the life cycle of the product has been accounted for and no life cycle stages has been omitted, in which significant environmental impacts are taking place. The use stage B1-B7 is assessed to be not relevant.

The general rules for the exclusion of inputs and outputs follows the requirements in EN 15804:2012 + A1:2013, 6.3.5, where the total of neglected input flows per module shall be a maximum of 5 % of energy usage and mass and 1 % of energy usage and mass for unit processes.

Key assumptions for the system boundary are described in each life cycle phase.

### **Product stage (A1-A3) includes:**

- A1 – Extraction and processing of raw materials
- A2 – Transport to the production site
- A3 – Manufacturing processes

The product stage comprises the acquisition of all raw materials, products and energy, transport to the production site, packaging and waste processing up to the "end-of-waste" state or final disposal. The LCA results are declared in aggregated form for the product stage, which means, that the sub-modules A1, A2 and A3 are declared as one module A1-A3.

The bricks are packed on wooden pallets which are part of a return system. The impacts from the pallets are deemed to be less than 1 ‰ and they are therefore excluded.

### **Construction process stage (A4-A5) includes:**

The construction process stage includes:

- A4 – transport to the building site
- A5 – installation into the building

This includes the provision of all materials, products and energy, as well as waste processing up to the end-of-waste state or disposal of final residues during the construction process stage. The use of mortar is excluded according to the cPCR. These information modules also include all impacts and aspects related to any losses during this construction process stage. The loss of bricks is set equal to 3% in mass according to the cPCR. The lost bricks are landfilled, and the packaging is incinerated with energy recovery and the credit is declared in module D.

### **Use stage (B1-B7) includes:**

The use stage, related to the building fabric includes:

- B1 - use or application of the installed product
- B2 - maintenance
- B3 - repair
- B4 - replacement
- B5 – refurbishment

The use stage related to the operation of the building includes:

- B6 - operational energy use

**B7 - operational water use**

These information modules include provision and transport of all materials, products, as well as energy and water provisions, waste processing up to the end-of-waste state or disposal of final residues during this part of the use stage.

According to the cPCR these modules do in general not generate relevant environmental impacts and therefore has a value of zero.

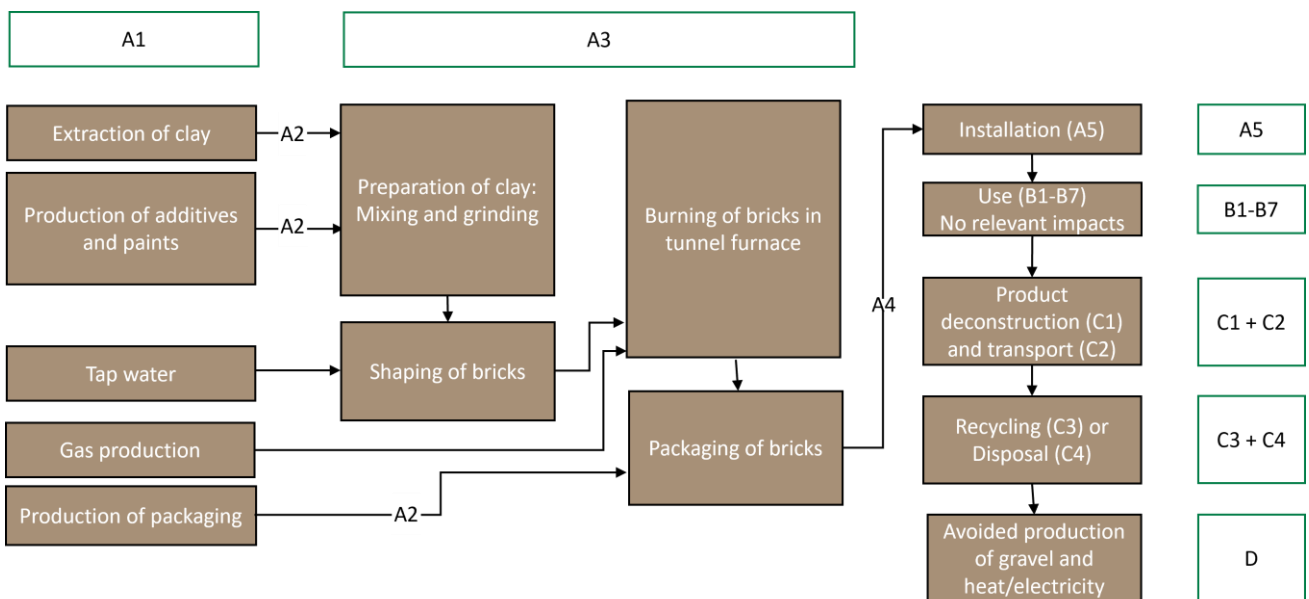
**End-of-life stage (C1-C4 + D)**

The end-of-life stage includes:

- C1 - de-construction, demolition
- C2 - transport to waste processing
- C3 - waste processing for reuse, recovery and/or recycling
- C4 - disposal

C1 can be ignored according to the cPCR, whereas the rest of the modules are included using national scenarios. In C4 1% of the bricks are landfilled.

Module D includes the reuse, recovery and/or recycling potentials, expressed as net impacts and benefits. These include the energy produced in A5 (incineration of packaging) and substitution of gravel from the recycling of crushed bricks.



**Cut-off criteria**

The general rules for cut-offs of inputs and outputs in the EPD follows the rules in EN 15804:2012 + A1:2013 chapter 6.3.5. The maximum cut-off of input flows for a module is 5% for energy use and mass, while it is maximum 1% for unit processes.



# LCA results

| ENVIRONMENTAL IMPACTS PER TONNE |   |                        |                   |           |           |          |           |          |          |           |
|---------------------------------|---|------------------------|-------------------|-----------|-----------|----------|-----------|----------|----------|-----------|
| Parameter                       | Unit  | A1-A3<br>(Natural gas) | A1-A3<br>(Biogas) | A4        | A5        | B1-C1    | C2        | C3       | C4       | D         |
| GWP                             | [kg CO <sub>2</sub> -eq.]   | 2,16E+02               | 1,22E+02          | 3,23E+00  | 2,52E+00  | 0,00E+00 | 2,46E+00  | 7,03E-01 | 1,39E-01 | -2,64E+00 |
| ODP                             | [kg CFC11-eq.]  | 1,69E-06               | 1,69E-06          | 5,63E-16  | 2,58E-15  | 0,00E+00 | 4,28E-16  | 1,23E-16 | 7,59E-16 | -3,75E-14 |
| AP                              | [kg SO <sub>2</sub> -eq.]   | 5,83E-01               | 1,11E+00          | 2,36E-03  | 3,51E-03  | 0,00E+00 | 1,79E-03  | 2,11E-03 | 8,31E-04 | -1,07E-02 |
| EP                              | [kg PO <sub>4</sub> <sup>3-</sup> -eq.]   | 1,18E-01               | 3,16E-01          | 4,70E-04  | 5,19E-04  | 0,00E+00 | 3,57E-04  | 4,92E-04 | 9,42E-05 | -2,12E-03 |
| POCP                            | [kg ethene-eq.]   | 3,14E-02               | 5,11E-02          | -3,76E-05 | -7,64E-05 | 0,00E+00 | -2,86E-05 | 2,18E-04 | 6,38E-05 | -1,02E-03 |
| ADPE                            | [kg Sb-eq.]   | 2,70E-04               | 4,35E-04          | 2,52E-07  | 6,92E-08  | 0,00E+00 | 1,91E-07  | 5,52E-08 | 1,40E-08 | -5,03E-07 |
| ADPF                            | [MJ]  | 2,69E+03               | 6,83E+02          | 4,37E+01  | 1,02E+01  | 0,00E+00 | 3,32E+01  | 9,58E+00 | 1,89E+00 | -3,47E+01 |
| Caption                         | GWP = Global warming potential; ODP = Ozone depletion potential; AP = Acidification potential of soil and water; EP = Eutrophication potential; POCP = Photochemical ozone creation potential; ADPE = Abiotic depletion potential for non fossil resources; ADPF = Abiotic depletion potential for fossil resources |                        |                   |           |           |          |           |          |          |           |

| RESOURCE USE PER TONNE |   |                        |                   |          |          |          |          |          |          |           |
|------------------------|---|------------------------|-------------------|----------|----------|----------|----------|----------|----------|-----------|
| Parameter              | Unit  | A1-A3<br>(Natural gas) | A1-A3<br>(Biogas) | A4       | A5       | B1-C1    | C2       | C3       | C4       | D         |
| PERE                   | [MJ]  | 6,71E+02               | 7,06E+03          | 2,45E+00 | 1,09E+00 | 0,00E+00 | 1,87E+00 | 5,38E-01 | 2,62E-01 | -1,42E+01 |
| PERM                   | [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  |
| PERT                   | [MJ]  | 6,71E+02               | 7,06E+03          | 2,45E+00 | 1,09E+00 | 0,00E+00 | 1,87E+00 | 5,38E-01 | 2,62E-01 | -1,42E+01 |
| PENRE                  | [MJ]  | 2,76E+03               | 7,87E+02          | 4,40E+01 | 1,04E+01 | 0,00E+00 | 3,35E+01 | 9,65E+00 | 1,95E+00 | -4,06E+01 |
| PENRM                  | [MJ]  | 2,41E+01               | 2,41E+01          | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00  |
| PENRT                  | [MJ]  | 2,78E+03               | 8,11E+02          | 4,40E+01 | 1,04E+01 | 0,00E+00 | 3,35E+01 | 9,65E+00 | 1,95E+00 | -4,06E+01 |
| SM                     | [kg]  | 6,45E+01               | 6,45E+01          | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00  |
| RSF                    | [MJ]  | 3,71E+02               | 1,31E+03          | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00  |
| NRSF                   | [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  |
| FW                     | [m <sup>3</sup> ]   | 4,89E-01               | 1,83E+00          | 2,81E-03 | 5,60E-03 | 0,00E+00 | 2,14E-03 | 6,15E-04 | 4,80E-04 | -1,11E-02 |
| Caption                | PERE = Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM = Use of renewable primary energy resources used as raw materials; PERT = Total use of renewable primary energy resources; PENRE = Use of non renewable primary energy excluding non renewable primary energy resources used as raw materials; PENRM = Use of non renewable primary energy resources used as raw materials; PENRT = Total use of non renewable primary energy resources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non renewable secondary fuels; FW = Use of net fresh water |                        |                   |          |          |          |          |          |          |           |

| WASTE CATEGORIES AND OUTPUT FLOWS PER TONNE |   |                        |                   |          |          |          |          |          |          |           |
|---|---|------------------------|-------------------|----------|----------|----------|----------|----------|----------|-----------|
| Parameter                                   | Unit  | A1-A3<br>(Natural gas) | A1-A3<br>(Biogas) | A4       | A5       | B1-C1    | C2       | C3       | C4       | D         |
| HWD   | [kg]  | 3,07E-07               | 4,66E-06          | 2,22E-09 | 8,88E-10 | 0,00E+00 | 1,69E-09 | 4,86E-10 | 2,07E-10 | -1,16E-08 |
| NHWD  | [kg]  | 1,49E+01               | 1,95E+01          | 6,54E-03 | 3,00E+01 | 0,00E+00 | 4,97E-03 | 1,43E-03 | 9,71E+00 | -4,00E+01 |
| RWD   | [kg]  | 2,25E-03               | 1,00E-02          | 5,32E-05 | 8,05E-05 | 0,00E+00 | 4,05E-05 | 1,17E-05 | 2,04E-05 | -2,28E-03 |
| 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  |
| MFR   | [kg]  | 2,78E+01               | 2,78E+01          | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 9,60E+02 | 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  |
| EEE   | [MJ]  | 0,00E+00               | 0,00E+00          | 0,00E+00 | 3,80E+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 | 6,80E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00 | 0,00E+00  |
| Caption                                     | HWD = Hazardous waste disposed; NHWD = Non hazardous waste disposed; RWD = Radioactive waste disposed; CRU = Components for re-use; MFR = Materials for recycling; MER = Materials for energy recovery; EEE = Exported electrical energy; EET = Exported thermal energy |                        |                   |          |          |          |          |          |          |           |

# Additional information

## Technical information on scenarios

### Transport to the building site (A4)

| Parameter                                   | Value   | Unit              |
|---|---|-------------------|
| Fuel type and consumption                   | Diesel (0,018 L/tkm)  | -                 |
| Truck type                                  | Euro 6 more than 32t gross weight / 24,7 t payload capacity | -                 |
| Transport distance                          | 50  | km                |
| Capacity utilisation (including empty runs) | 61  | %                 |
| Gross density of transported product        | 1650-1700   | kg/m <sup>3</sup> |
| Capacity utilisation, volume factor         | 1   | -                 |

### Installation of the product in the building (A5)

| Parameter                               | Value | Unit |
|---|-------|------|
| Waste material (bricks)                 | 30    | kg   |
| Waste material (packaging)              | 0,57  | kg   |
| Direct emissions to air, soil and waste | 0     | kg   |

### Use (B1-B7)

| Parameter    | Value | Unit |
|--------------|-------|------|
| Not relevant |       |      |

### Reference service life

|   |   |
|---|---|
| Reference service Life  | 150 years   |
| Declaration of performance (at gate) etc.                             | DoP   |
| Instructions of use   | DoP   |
| Assumed quality of installation work according to producer guidelines | <a href="http://www.mur-tag.dk/udfoerelse/murerhaandbogen-2020/">www.mur-tag.dk/udfoerelse/murerhaandbogen-2020/</a>  |
| Outdoor environment – weather, wind, pollution, UV etc.               | <a href="https://www.egernsund.com/produkter/mursten/teknisk-information.html">https://www.egernsund.com/produkter/mursten/teknisk-information.html</a>                           |
| Indoor environment – temperature, moisture etc.                       | <a href="https://sbi.dk/Assets/Muret-byggeri-og-indeklima_1/Muret-byggeri-og-indeklima.pdf">https://sbi.dk/Assets/Muret-byggeri-og-indeklima_1/Muret-byggeri-og-indeklima.pdf</a> |
| Use conditions – mechanical tear, use frequency etc.                  | <a href="https://www.egernsund.com/produkter/mursten/teknisk-information.html">https://www.egernsund.com/produkter/mursten/teknisk-information.html</a>                           |
| Maintenance (frequency, type, quality, replacements etc.)             | <i>Construction Clay Products, TBE 2014</i>   |

### End of life (C1-C4)

| Parameter                    | Value | Unit |
|------------------------------|-------|------|
| Separated construction waste | 970   | kg   |
| Mixed construction waste     | 0     | kg   |
| For reuse                    | 0     | kg   |
| For recycling                | 960,3 | kg   |
| For energy recovery          | 0     | kg   |
| For landfilling              | 9,7   | Kg   |

### Reuse, recovery and/or recycling potential (D)

| Parameter      | Value | Unit |
|----------------|-------|------|
| PE             | 0,55  | kg   |
| PET            | 0,02  | kg   |
| Crushed bricks | 960,3 | kg   |

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**Indoor air**

*The EPD does not give information on release of dangerous substances to indoor air because the horizontal standards on measurement of release of regulated dangerous substances from construction products using harmonised test methods according to the provisions of the respective technical committees for European product standards are not available.*

**Soil and water**

*The EPD does not give information on release of dangerous substances to soil and water because the horizontal standards on measurement of release of regulated dangerous substances from construction products using harmonised test methods according to the provisions of the respective technical committees for European product standards are not available.*

## References

|                                      |   |
|--------------------------------------|---|
| <b>Publisher</b>                     |  epddanmark<br><a href="http://www.epddanmark.dk">http://www.epddanmark.dk</a> |
| <b>Programme operator</b>            | Danish Technological Institute<br>Gregersensvej<br>DK-2630 Taastrup<br><a href="http://www.teknologisk.dk">http://www.teknologisk.dk</a>                        |
| <b>LCA-practitioner</b>              | Danish Technological Institute<br>Gregersensvej<br>DK-2630 Taastrup<br><a href="http://www.teknologisk.dk">http://www.teknologisk.dk</a>                        |
| <b>LCA software /background data</b> | GaBi ts, version 10.5.0.78<br>GaBi ts database, version 10.5<br>(Content version 2021.2)<br>Ecoinvent, version 3.5  |
| <b>3<sup>rd</sup> party verifier</b> | Ninkie Bendtsen<br>NIRAS A/S<br>Sortemosevej 19<br>DK-3450 Allerød<br><a href="http://www.niras.dk">www.niras.dk</a>  |

### General programme instructions

Version 2.0

[www.epddanmark.dk](http://www.epddanmark.dk)

### EN 15804:2012 + A1:2013

DS/EN 15804 + A1:2013 - "Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products"

### EN 15942

DS/EN 15942:2011 – " Sustainability of construction works – Environmental product declarations – Communication format business-to-business"

### ISO 14025

DS/EN ISO 14025:2010 – " Environmental labels and declarations – Type III environmental declarations – Principles and procedures"

### ISO 14040

DS/EN ISO 14040:2008 – " Environmental management – Life cycle assessment – Principles and framework"

### ISO 14044

DS/EN ISO 14044:2008 – " Environmental management – Life cycle assessment – Requirements and guidelines"

### Tiles & Bricks Europe

TBE PCR for clay construction products (2014) Guidance document for developing an EPD