

# ENVIRONMENTAL PRODUCT DECLARATION



ISO 14025 ISO 21930 EN 15804

Owner of the declaration	AS ROCKWOOL
Program holder	The Norwegian EPD Foundation
Publisher	The Norwegian EPD Foundation
Declaration number	00131E rev1
Issue date	25.10.2013
Valid to	25.10.2018

## ROCKWOOL® isolering

Product

AS ROCKWOOL

Manufacturer



## General information

### ROCKWOOL® isolering

Product

#### Program holder:

The Norwegian EPD Foundation  
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#### Declaration number:

00131E rev1

#### This declaration is based on Product Category Rules:

CEN Standard EN 15804 serve as core PCR  
Product Group Insulation materials, NPCR 012rev,

#### Declared unit:

1 m<sup>2</sup> of 37mm thick stone wool insulation product with a density of 29 kg/m<sup>3</sup> and a thermal resistance of R=1 m<sup>2</sup> K/W.

#### Declared unit with option:

#### Functional unit:

#### The environmental product declaration has been worked out by:

Rasmus Nielsen and  
Anders Schmidt, Ph.D.,  
FORCE Technology,  
Lyngby, Denmark



#### Verification:

Independent verification of data and other environmental information has been carried out in accordance with ISO14025, 8.1.3.

externally  internally

*Joep Meijer*  
President Joep Meijer

(Independent verifier approved by EPD Norway)

### AS ROCKWOOL

Manufacturer

#### Owner of the declaration:

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Phone: 00 47 22 02 40 00  
e-mail: [Torkel.Weringsaasen@rockwool.com](mailto:Torkel.Weringsaasen@rockwool.com)

#### Place of production:

Vamdrup and Doense, Denmark  
Trondheim and Moss, Norway

#### Management system:

ISO 9001, ISO14001, EN13.162, EN13.172, EN14303

#### Org. No:

923828583

#### Issue date:

25.10.2013

#### Valid to:

25.10.2018

#### Comparability:

EPD of construction products may not be comparable if they not comply with EN 15804

#### Year of study:

2013

Approved according to ISO14025, 8.1.4

*Sverre Fossdal*

Dr. ing. Sverre Fossdal

(Chairman of the Verification Group of EPD-Norway)

#### Declared unit:

1 m<sup>2</sup> of 37 mm thick stone wool insulation product with a density of 29 kg/m<sup>3</sup> and a thermal resistance of R=1 m<sup>2</sup> K/W.

Key environmental indicators	Unit	Cradle to gate A1 - A3	Transport Production site - central warehouse Norway
Global warming	kg CO <sub>2</sub> -eqv	1,27	1,19*10 <sup>-2</sup>
Energy use	MJ	13,8	0,17
Dangerous substances	*		

\* The product contains no substanses from the REACH Candidate list or the Norwegian priority list

## Product

### Product description:

Stone wool insulation from ROCKWOOL is a firesafe\* material for insulation against heat, cold, fire, vibrations and noise. The product is wrapped with PE-foil and placed on wooden pallets for further distribution.

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Stone wool insulation from ROCKWOOL for the Scandinavian market is supplied by two production sites in Norway (Moss and Trondheim) as well as two sites in Denmark (Doense and Vamdrup), each with two lines. The properties of the ROCKWOOL products from the different production sites are identical. The EPD is based on LCA inventory data from the 4 plants. The reference flow is a weighted average and is calculated using the following distribution of production capacity (2011) on the four production sites: Vamdrup 30,6%, Doense 35,7%, Trondheim 11,9%, Moss 21,7%.

\* A1 when tested according to EN 13501-1 (Euroclasses)

### Description of manufacturing processes:

The furnace used in all four production sites is an oven with coke as the main energy source. The virgin stone raw materials used at all sites are mainly basalt, diabase and dolomite. The Danish sites also use various secondary materials, including internal wool waste, which is mixed with cement into briquettes. The mineral raw materials are melted and spun into fibers at a temperature of about 1500°C. A synthetic binder and a water-repellant agent are added, whereafter the final curing (polymerisation) and forming takes place at a temperature of about 230°C. Finally the product is cut into the desired dimensions and packed in PE foil.

### Technical data:

Scaling factors for ROCKWOOL Insulation materials in this EPD can be seen in the table below. The scaling factors show how much to multiply the environmental burdens by in order to obtain a thermal resistance of R=1 m<sup>2</sup> K/W with other ROCKWOOL products. The R-values used for scaling gives a very good indication of the amount of materials needed to achieve the desired insulation effect of other product types, but is not an exact measure. Stone wool insulation products marked with an asterisk (\*) in the table are sold with extra features for special applications e.g. with wire netting, a bitumen membrane or aluminium foil. The extra features are not covered by this LCA.

The products covered by the EPD are produced at all production lines in a full year. The variation between production lines has not been determined.

### Market:

Scandinavia

### Reference service life:

The service life of the product is >> 60 years and built into a construction and will last the construction lifetime.

### Product specification

Material input per functional unit

Material	kg	% of total
Stones	0,902	67,1
Secondary resources mostly slag	0,251	18,7
Cement	0,087	6,46
Formaldehyde (37%)	0,052	3,89
Urea (46%)	0,021	1,57
Phenol	0,016	1,21

Products	Scaling Factor
B-plate	1.0
Bjälklagsskiva med vindskydd*	
Bygggrulle med vindskydd*	
A-Murbatts	1.1
Isolerasjäl	
Stålrégelskiva 40	1.2
Flexibatts 35	
Flexibatts	
Flexi A-plate	
Takstolplate	
Takstolsskiva med vindskydd*	
I-plate A	
Stålstenderplate	1.3
Roxremsa	
A-Rullebatts	1.4
BD-60 FlexiBatts	
Lamelmatte*	
Murplate	
Brannplate 50	1.6
Skalmursskiva	
SuperFlexiBatts	
Super A-Murbatts	1.7
Stålrégelskiva 37	
Lydplate	2.0
Rockvegg	
Rockorbit	
RockOrbit	
Flex Systemplate	2.0
FlexExtrem 33	
REDAirFLEXsystem	

Products	Scaling Factor
Super VentiBatts	2.1
Hardrock Elementbatts	
RockProfil skiva	
A-Pladebatts 10	2.3
Plätunderlagsskiva 80	
Betonelementbatts 35	2.6
Västkostskiva	
Trådvävsmätte 80 *	
Betonelementplate	2.8
Conlit Brannmatte*	
Alu Brandmatte 80*	
Toprock Lamell	2.9
Underlag Energy	
Trådvävsmätte 105*	3.4
Brandbatts	
Hardrock Energy	3.5
Stålunderlag Energy	
Drensplate	3.6
RockTorv	
Støpeplate Pluss	
Hardrock Fasadeplate	
Fallunderlagsplate	
Lydunderlagsplate	
Ljudunderlagsskiva	
Underlagsskiva stål & betong	3.7
Facadebatts	
Gulvrenoveringsplade	3.8
Terrænbatte Erhverv	
Universal rørskål *	4.5
Hardrock Energy	

Products	Scaling Factor
Markplate	4.7
Tungplate 150	
Marksskiva Industri	
Stegjudsskiva	5.7
Väggboard	
Conlit 150	6.0
Trinnlytplate	
Renoveringsboard	6.2
TF-plate	
TF-Takkile	
Hardrock Energy Takfall	
TF Renneplate	
Fallränna TF	
Hardrock Takfall 1:40/60	
Hardrock kilskiva 1:40/60	
Rännalskil 180	
Takboard	
Takkil	11.2
TopRock Takboard	
TF-Plade	
Conlit 300	

\*: Products marked with an \* are specialty products with extra features like wire netting and aluminium foil. The extra features are not included in the EPD-calculations

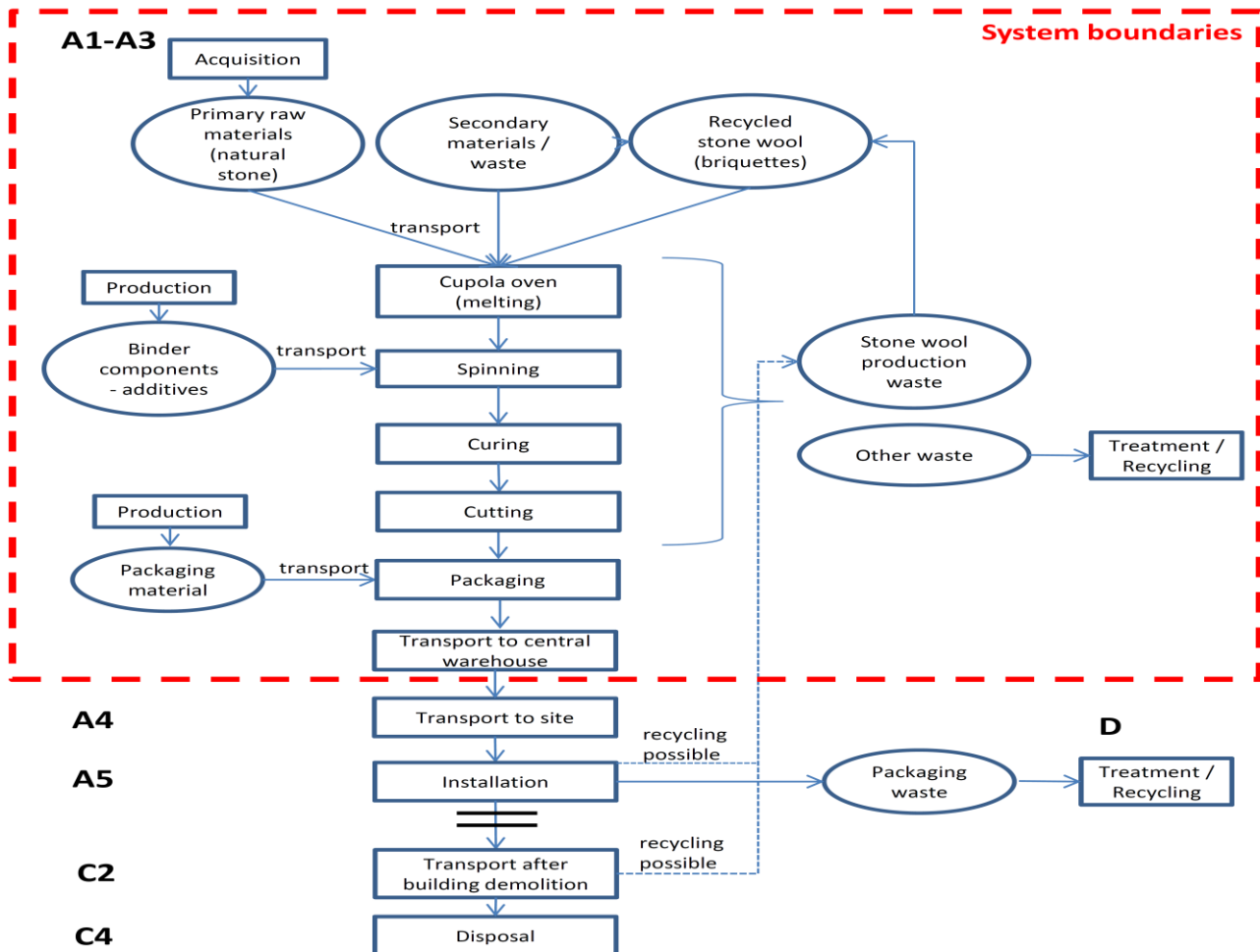
## LCA: Calculation rules

### Declared unit:

1 m<sup>2</sup> of 37 mm thick stone wool insulation product with a density of 29 kg/m<sup>3</sup> and a thermal resistance of R=1 m<sup>2</sup> K/W.

### System boundary:

The overall system boundaries include extraction and transportation of raw materials as well as all manufacturing processes (cradle-to-gate). Transport from all factories to a central storage in Norway has been included. See Figure below for details



### Data quality:

High quality data from GaBi 6 and ecoinvent have been used for acquisition of raw materials and transportation. Legally required information has been used for manufacturing processes at ROCKWOOL. The age of the oldest dataset in the database is 13 years and the vast majority of datasets are under 5 years old. The data collected from the sites are from 2011. Accordingly, the overall quality is judged to be good to very good.

### Allocation:

Allocation has been made according to the provisions in EN 15804. Impacts from recycled material have been allocated to the primary product, except transportation. ROCKWOOL supply district heating in Denmark. Respectively 7,3% and 9,4% of the energy consumed in the two production sites in Denmark have been allocated to district heating, using the energy content as the allocation key. The emissions associated with energy production have been allocated in the same way. A sensitivity analysis of the results using a different allocation key, such as the economic value, or substitution approach has not been performed.

### Cut-off criteria:

All inputs of raw materials and energy have been included. Please note that products with special features e.g. wire netting, bitumen membrane or alufoil are not included in the EPD. Please consult ROCKWOOL AS for more information.

## LCA: Scenarios and additional technical information

The following information describe the scenarios in the different modules of the EPD.

### Transport from production site to central warehouse in Norway

Type	Capacity utilisation	Gross density of products	Type of vehicle	Distance km	Fuel/Energy consumption	Value (l/t)
Truck*	30		****	127	$1,7 \cdot 10^{-2}$ l/tkm	2,16
Truck**	30		****	50	$1,7 \cdot 10^{-2}$ l/tkm	0,860
Boat***	48		*****	149	$4,6 \cdot 10^{-3}$ l/tkm	0,685

- \* Transport by Truck (weighted average). From Danish production sites to Moss in Norway
- \*\* Transport by Truck. From Moss and Trondheim to central warehouse in Norway
- \*\*\* Transport by Boat (weighted average). From Denmark to Norway (Frederikshavn terminal to Oslo)
- \*\*\*\* Dataset from GaBi with a Euro class 3 truck-trailer with a payload of 22 tons.
- \*\*\*\*\* Dataset from GaBi with a Bulk commodity carrier with 1,500-20,000 dwt. payload capacity and light fuel oil driven.

## LCA: Results

### System boundaries (X=included, MND=module not declared, MNR=module not relevant)

Product stage			Construction installation stage		Use stage							End of life stage				Beyond the system boundaries
Raw materials	Transport	Manufacturing	Transport	Construction installation stage	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-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	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND

### Environmental impact

Parameter	A1 - A3								
GWP	1,27								
ODP	$1,48 \cdot 10^{-9}$								
POCP	$6,92 \cdot 10^{-4}$								
AP	$8,96 \cdot 10^{-3}$								
EP	$8,87 \cdot 10^{-4}$								
ADPM	$2,52 \cdot 10^{-7}$								
ADPE	12,5								

**GWP** Global warming potential (kg CO<sub>2</sub>-eqv.); **ODP** Depletion potential of the stratospheric ozone layer (kg CFC11-eqv.); **POCP** Formation potential of tropospheric photochemical oxidants (kg C<sub>2</sub>H<sub>4</sub>-eqv.); **AP** Acidification potential of land and water (kg SO<sub>2</sub>-eqv.); **EP** Eutrophication potential (kg PO<sub>4</sub><sup>-3</sup>-eqv.); **ADPM** Abiotic depletion potential for non fossil resources (kg Sb -eqv.); **ADPE** Abiotic depletion potential for fossil resources (MJ)

Reading example:  $9,0 \cdot 10^{-3} = 0,009$

### Resource use

Parameter	A1 - A3								
RPEE	0,543								
RPEM	0,906								
TPE	1,45								
NRPE	12,97								
NRPM	0,00								
TRPE	12,97								
SM	0,281								
RSF	$3,89 \cdot 10^{-2}$								
NRSF	0,202								
W	$3,39 \cdot 10^{-3}$								

**RPEE** Renewable primary energy resources used as energy carrier (MJ); **RPEM** Renewable primary energy resources used as raw materials (MJ); **TPE** Total use of renewable primary energy resources (MJ); **NRPE** Non renewable primary energy resources used as energy carrier (MJ); **NRPM** Non renewable primary energy resources used as materials (MJ); **TRPE** Total use of non renewable primary energy resources (MJ); **SM** Use of secondary materials (kg); **RSF** Use of renewable secondary fuels (MJ); **NRSF** Use of non renewable secondary fuels (MJ); **W** Use of net fresh water (m<sup>3</sup>)

### End of life - Waste

Parameter	A1 - A3								
HW	$7,22 \cdot 10^{-3}$								
NHW	0,226								
RW	n/a								

**HW** Hazardous waste disposed (kg); **NHW** Non hazardous waste disposed (kg), **RW** Radioactive waste disposed (kg)

### End of life - Output flow

Parameter	A1 - A3								
CR	0								
MR	$2,63 \cdot 10^{-2}$								
MER	$8,29 \cdot 10^{-4}$								
EEE	0								
ETE	0								

**CR** Components for reuse (kg); **MR** Materials for recycling (kg); **MER** Materials for energy recovery (kg); **EEE** Exported electric energy (MJ); **ETE** Exported thermal energy ( MJ)

Reading example:  $9,0 \cdot 10^{-3} = 0,009$

## Specific Norwegian requirements

### Electricity

Electricity used in the manufacturing processes has been accounted for using the process Danish Electricity grid mix (1kV-60kV) from GaBi6 (reference year 2009).

Greenhouse gas emissions 0,139 kg CO<sub>2</sub> eqv/MJ

and the process Norwegian Electricity grid mix (1kV-60kV) from GaBi6 (reference year 2009).

Greenhouse gas emissions 0,011 kg CO<sub>2</sub> eqv/MJ

### Dangerous substances

None of the following substances have been added to the product: Substances on the REACH Candidate list of substances of very high concern (of 25.10.2013) substances on the Norwegian Priority list (pr.25.10.2013) and substances that lead to the product being classified as hazardous waste. The chemical content of the product complies with regulatory levels as given in the Norwegian Product Regulations.

### Transport

Transport from production site to central warehouse in Norway is 326 km

**Indoor environment**





In general, ROCKWOOL products have been assessed using the Finnish M1 emission classes for building material. In total 32 specific ROCKWOOL products have been tested representing a wide range of products. To be granted the M1 quality label, an emission test (incl. ammonia, formaldehyde, and carcinogens) and an odour test has to be performed. The time period of testing is 28 days. Criteria: TVOC (Minimum of 70% of the compounds shall be identified): <0,2 mg/m<sup>2</sup>h, Formaldehyde (HCHO): < 0,05 mg/m<sup>2</sup>h, Ammonia (NH<sub>3</sub>): <0,03 mg/m<sup>2</sup>h, Carcinogenic compounds (belonging to category 1 of IARC monographs): <0,005 mg/m<sup>2</sup>h, Odour (dissatisfaction with odour shall be below 15%): No Odour. The M1 is the highest achievable best rank in the classification system.  
(<https://www.rakennustieto.fi/index/english/emissionclassificationofbuildingmaterials.html>)

**Carbon footprint**

Carbon footprint has not been worked out for the product.

**Bibliography**

ISO 14025:2006	<i>Environmental labels and declarations - Type III environmental declarations - Principles and procedures</i>
ISO 14044:2006	Environmental management - Life cycle assessment - Requirements and guidelines
EN 15804:2012	<i>Sustainability of construction works - Environmental product declaration - Core rules for the product category of construction products</i>
ISO 21930:2007	<i>Sustainability in building construction - Environmental declaration of building products</i>
Schmidt A, Nielsen. R. (2013).	<i>LCA of stone wool insulation on the Scandinavian market from ROCKWOOL, Project report, FORCE Technology. 2013</i>
PCR 2012	<i>Product-Category Rules. NPCR 12 rev. Insulation materials, epd-norge.no, 2012</i>

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