

# ENVIRONMENTAL PRODUCT DECLARATION

In compliance with ISO 14025 and EN15804 + A2:2019

## COLD ROLLED STEEL RECOILED WIRE

Program operator: EPDITALY

Published by: FERRIERE NORD S.p.A.

Declaration n.: EPDribobinato\_2024

EPDITALY registration code : EPDITALY0637

Published: 05/04/2024

Valid until: 05/04/2029

Production site: Osoppo (UD) - Italy



# General Information



## **EPD DECLARATION OWNER:**

FERRIERE NORD S.p.A.  
Zona industriale Rivoli di Osoppo  
Osoppo (UD), Italy.

## **PROGRAM OPERATOR:**

EPDITALY  
Via Gaetano de Castillia 10  
Milan (MI), Italy.

## **INDEPENDENT EVALUATION BY:**

ICMQ S.p.A.  
Via Gaetano de Castillia 10  
Milan (MI), Italy.

## **PLANT LOCATION:**

FERRIERE NORD S.p.A.  
Zona industriale Rivoli di Osoppo  
Osoppo (UD), Italy.



# Company Profile



Pittini Group, with more than 60 years of experience in the steel sector, is an international reference in the production of **long steel products** for **mechanical industry** and **building sector**.

With a production of almost 3 million tons per year, 18 manufacturing and logistics facilities and 1,800 workers, Pittini Group is a strong company, focused on constant growth, guided by hi-tech investments, product innovation and a strict environmental sustainability policy (**Environmental Management System**, ISO 14001-certified since 2009).

Pittini Group **covers the whole production cycle**: from raw material (recycled ferrous materials) to the finished product, producing billets, wire rod, hot-rolled reinforcing steel bars and coils.

# Field of application and EPD type

✓	A1	Raw material supply	PRODUCTION STAGE
✓	A2	Transport	
✓	A3	Manufacturing	
MND	A4	Transport	CONSTRUCTION PROCESS
MND	A5	Construction/installation	
MND	B1	Use	USE
MND	B2	Maintenance	
MND	B3	Repair	
MND	B4	Replacement	
MND	B5	Refurbishment	
MND	B6	Operational energy use	
MND	B7	Operational water use	
✓	C1	De-commissioning \ Demolition	END OF LIFE
✓	C2	Transport	
✓	C3	Waste processing	
✓	C4	Disposal	
✓	D	Reuse \ Recovery \ Recycling potential	BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARY

MND = Module Not Declared

**MODULES:** The system modules include the compulsory modules A1, A2, A3, C1, C2, C3, C4 and D as per EN 15804 standard, following a “from cradle to gate with modules C1-C4 and D” approach.

**EPD TYPE:** Specific for the recoiled wire produced in Osoppo (UD).

**GEOGRAPHICAL LOCATION:** Performances were calculated considering the plant of Osoppo with reference to the national market.

**DATABASE:** Ecoinvent 3.9.1

**SOFTWARE:** SimaPro 9.5.0.2

# The product: recoiled wire

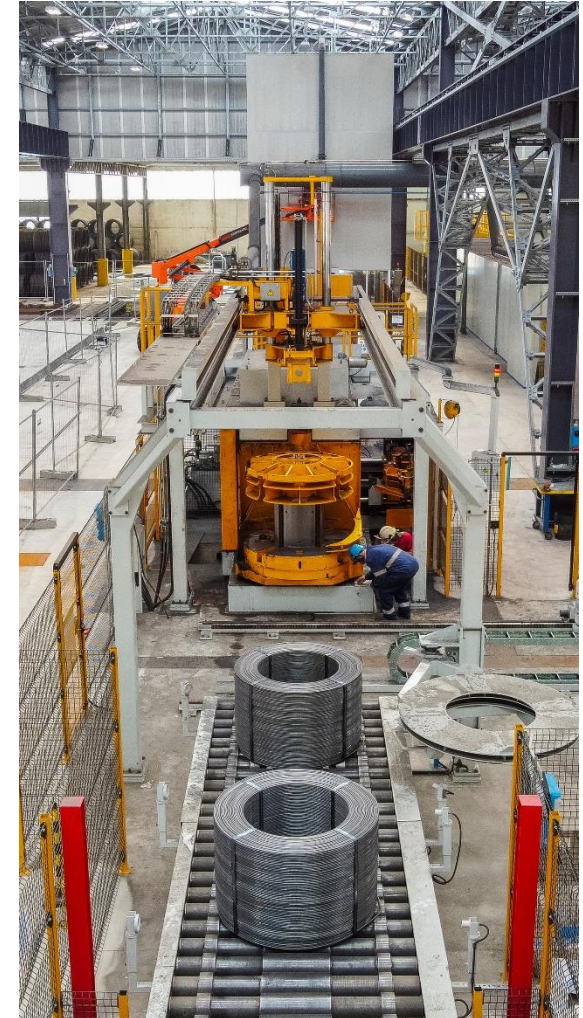
## DECLARED UNIT: 1,000 kg of recoiled wire

The plants of the Pittini Group also manufacture rebars in coils using the traditional process, i.e. stretching (recoiling) from ribbed wire rod for reinforced concrete.

The recoiled wire is an extremely versatile product thanks to its workability and the high quality standard with which it is produced.

The mechanical characteristics together with a small package size facilitates storage in limited spaces, benefits that allow for widespread use within the ironworking industry, for uses in reinforced concrete construction.

The coil-on-coil winding ensures a perfect and fast unwinding of the roll, guaranteeing users high production standards that, together with a reduction in the number of daily changes thanks to its packaging, lead to a reduction of machine downtime and optimization of scrap production.





# Main raw materials

Main raw materials used to produce recoiled steel wire are:



**FERROUS METAL SCRAP**

The main material used



**PIG IRON**



**REDUCED IRON**



**FERRO-ALLOYS**



**LIME**



**COAL**



**REFRACTORY  
MATERIALS**

# Field of application and EPD type

## DESCRIPTION OF THE PROCESSES INCLUDED

**Transport of material from production sites** to Ferriere Nord S.p.a. in Osoppo has been included.

All **transports of scrap and raw material from suppliers** to the plant in Osoppo are included in the primary-information model. **INVENTORY QUANTITY**, expressed in kgkm, is defined as the product between the mass of the material and the distance covered.

**Transport of waste from the plants in Osoppo** to the processing plants is included in the model relying on primary data.

**Processing of materials** entering Ferriere Nord, **melting and manufacturing processes** to obtain meshes and lattice girders are included.

**A1 ENERGY AND RAW MATERIAL SUPPLY**

**A2 TRANSPORT**

**A3 MANUFACTURING (WASTE PROCESSING, ANCILLARY MATERIALS, EMISSIONS)**

# Field of application and EPD type

Following the review of the EN 15804 standard, groups C1, C2, C3, C4 and D have been included.

The groups C1-C4 include the impacts associated with the removal of the material from the building in which it is installed, the transport of the waste to the treatment center and the related activities (recycling, treatment ecc.), including the disposal in landfill.

The group D, includes the benefits coming from the outputs of recycling (intended as avoided products) and energy recovery operations.

- C1 DE-CONSTRUCTION/DEMOLITION**
- C2 TRANSPORT**
- C3 WASTE PROCESSING**
- C4 DISPOSAL**
- D REUSE-RECOVERY-RECYCLING POTENTIAL**



# Field of application and EPD type



SCRAP  
**PREPARATION**  
PROCESSES FOR  
**FURNACE MELTING**  
AND RAW MATERIALS  
EXTRACTION

**Ferrous scrap, pig iron and HBI processing:** mechanical treatment of scrap, weighing, storage, basket preparation, handling with overhead cranes and sending to furnace;

**Coal and lime processing:** weighing, insufflation and sending to furnace;

**Processing of electrodes and refractories:** weighing and sending to furnace;

**Processing ladle slag with iron:** cooling, iron removal, screening, pneumatic transport and injection into furnace.

# Field of application and EPD type



**IN-HOUSE  
TRANSPORT**  
AND OPERATING  
MACHINES USED AT  
FERRIERE NORD

**Inbound transport** of materials by train and truck

**In-house transport** with wheel loader and truck

**Handling the finished product** with forklift

**Waste transport** to destination facilities

# Field of application and EPD type



## MELTING AND CASTING PROCESSES

### **Melting process:**

oxygen production,  
cooling water recirculation, electric arc furnace melting;

### **Secondary metallurgy process:**

refining and additives addition,  
ferro-alloys processing (weighing and sending to secondary  
furnace), ladle preparation and maintenance;

### **Casting process:**

steel casting and billet production,  
preparation and maintenance of tundishes.



# Field of application and EPD type



**HOT ROLLING  
PROCESSES**

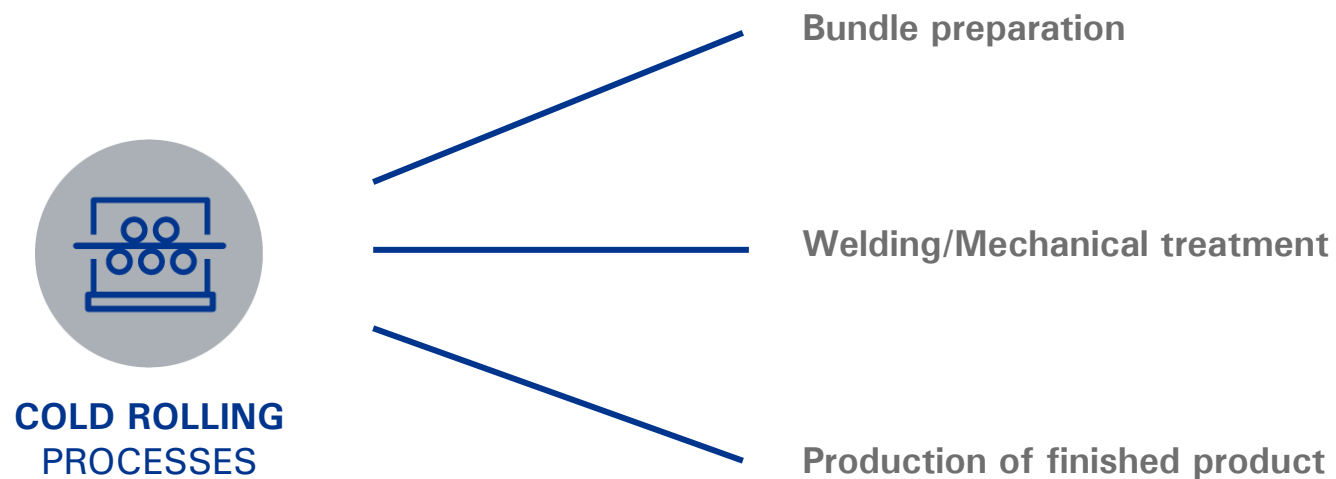
Billet pre-heating in furnace

Removal of surface layers of scale

Hot rolling

Wire rod production

# Field of application and EPD type



# Field of application and EPD type



**END OF LIFE  
MANAGEMENT**

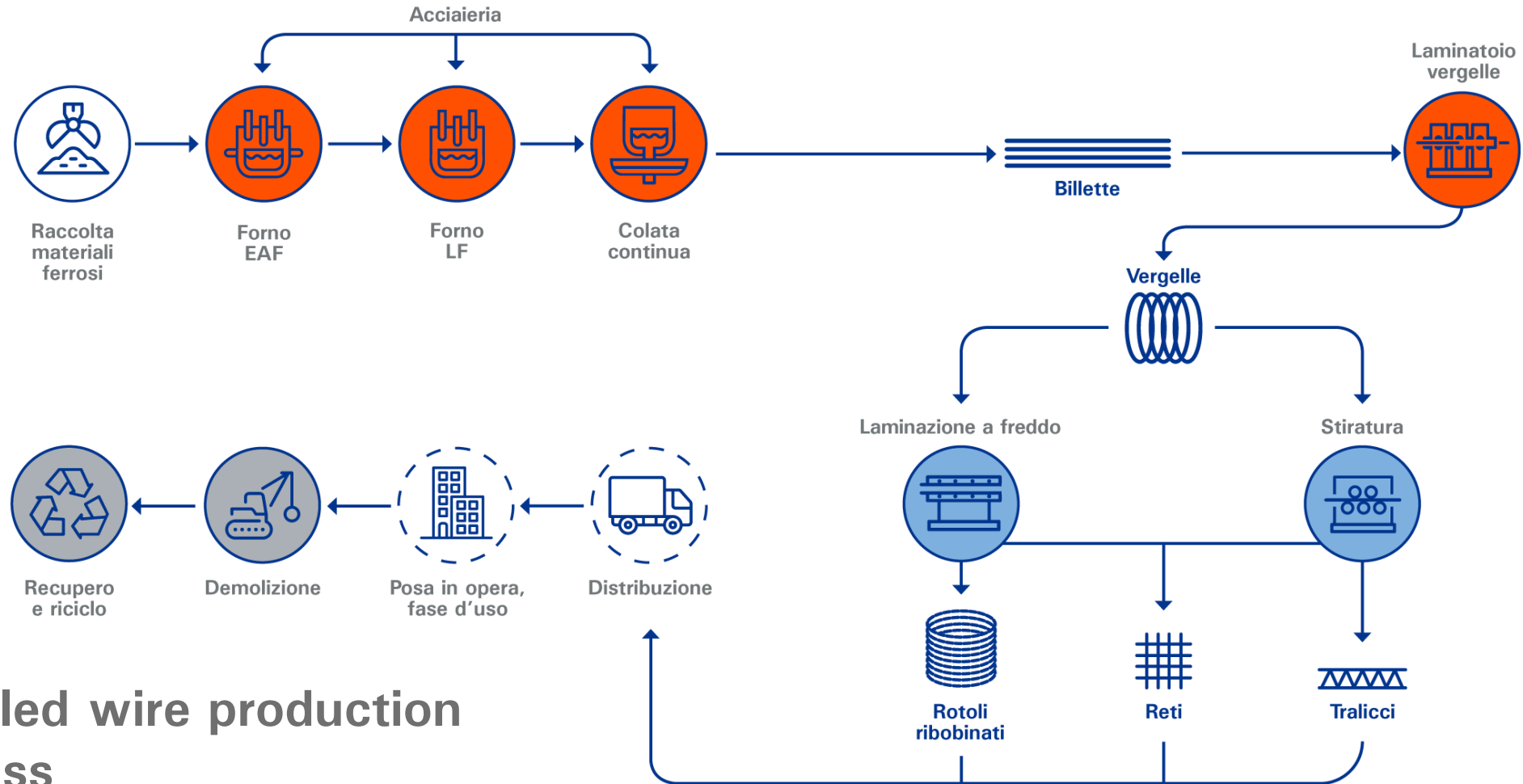
Demolition of the structure, including  
the use of machinery

Transport to separation centers and  
separation process.

Recovery, recycle, disposal



# Field of application and EPD type



**Recoiled wire production process**

# Environmental performance: recoiled wire

Data referring to 1000 kg of recoiled wire


ENVIRONMENTAL IMPACT PARAMETERS	UNIT	A1	A2	A3	A1-A3	A4, A5, B1 ÷ B7	C1	C2	C3	C4	D
Climate Change	kg CO2 eq	6,41E+2	2,65E+1	1,15E+2	7,83E+2	MND	7,12E+0	1,94E+1	1,52E+0	1,04E+0	2,05E+1
Climate Change - Fossil	kg CO2 eq	6,26E+2	2,65E+1	1,15E+2	7,67E+2	MND	7,11E+0	1,93E+1	1,42E+0	1,04E+0	2,05E+1
Climate Change - Biogenic	kg CO2 eq	1,52E+1	2,09E-2	8,12E-1	1,61E+1	MND	2,87E-3	4,93E-2	9,99E-2	2,53E-3	8,86E-5
Climate Change – LU&T	kg CO2 eq	4,44E-1	1,74E-2	1,15E-2	4,73E-1	MND	7,86E-4	9,22E-3	3,25E-3	5,32E-4	2,92E-3
Ozone Depletion	kg CFC11 eq	1,41E-5	4,70E-7	2,76E-7	1,49E-5	MND	1,10E-7	4,13E-7	2,53E-8	2,43E-8	4,28E-7
Acidification	mol H+ eq	2,43E+0	3,68E-1	5,64E-2	2,86E+0	MND	6,44E-2	1,07E-1	7,34E-3	6,30E-3	8,13E-2
Eutrophication Aquatic Freshwater	kg P eq	1,78E-1	1,37E-3	4,26E-3	1,83E-1	MND	2,13E-4	1,32E-3	1,19E-3	7,48E-5	8,75E-3
Eutrophication Aquatic Marine	kg N eq	5,29E-1	9,04E-2	2,48E-2	6,44E-1	MND	2,98E-2	4,51E-2	1,51E-3	2,57E-3	1,86E-2
Eutrophication Terrestrial	mol N eq	5,64E+0	9,94E-1	1,72E-1	6,81E+0	MND	3,24E-1	4,85E-1	1,41E-2	2,76E-2	2,01E-1
Photochemical Ozone Formation	kg NMVOC eq	1,53E+0	2,46E-1	6,86E-2	1,84E+0	MND	7,80E-2	1,19E-1	3,56E-3	6,79E-3	6,35E-2
ADP - Mineral And Metals *	kg Sb eq	2,08E-3	4,61E-5	1,96E-4	2,32E-3	MND	2,42E-6	6,05E-5	3,19E-6	2,69E-6	1,75E-4
ADP – Fossil *	MJ	9,47E+3	3,45E+2	1,80E+2	9,99E+3	MND	9,10E+1	2,69E+2	3,10E+1	1,77E+1	1,80E+2
Water Use *	m3 depriv.	1,58E+2	1,20E+0	5,39E+1	2,13E+2	MND	1,86E-1	1,07E+0	3,14E-1	3,74E-1	3,87E+0

MND = Module Not Declared

\* The results of these environmental impact indicators shall be used with care as the uncertainties on these results are high or as there is limited experienced with the indicator.

# Environmental performance: recoiled wire

Data referring to 1000 kg of recoiled wire


 RENEWABLE RESOURCES	UNIT	A1	A2	A3	A1-A3	A4, A5, B1 ÷ B7	C1	C2	C3	C4	D
Use of renewable primary energy excluding renewable primary energy resources used as raw materials (PERE)	MJ	5,42E+2	2,91E+0	2,68E+1	5,72E+2	MND	4,14E-1	3,14E+0	4,85E+0	1,63E-1	8,57E+0
Use of renewable primary energy resources used as raw materials (PERM)	MJ	1,24E+2	9,76E-1	4,00E+0	1,29E+2	MND	1,04E-1	1,01E+0	8,78E-1	5,62E-2	2,91E+0
Total use of renewable primary energy resources (PERT)	MJ	6,66E+2	3,89E+0	3,08E+1	7,01E+2	MND	5,18E-1	4,15E+0	5,73E+0	2,20E-1	1,15E+1

MND = Module Not Declared



# Environmental performance: recoiled wire



Data referring to 1000 kg of recoiled wire

 NON-RENEWABLE RESOURCES	UNIT	A1	A2	A3	A1-A3	A4, A5, B1 ÷ B7	C1	C2	C3	C4	D
Use of non renewable primary energy excluding non renewable primary energy resources used as raw materials (PENRE)	MJ	9,47E+3	3,45E+2	1,80E+2	9,99E+3	MND	9,10E+1	2,69E+2	3,10E+1	1,77E+1	1,80E+2
Use of non renewable primary energy resources used as raw materials (PENRM)	MJ	0,00E+0	0,00E+0	0,00E+0	0,00E+0	MND	0,00E+0	0,00E+0	0,00E+0	0,00E+0	0,00E+0
Total use of non renewable primary energy resources (PENRT)	MJ	9,47E+3	3,45E+2	1,80E+2	9,99E+3	MND	9,10E+1	2,69E+2	3,10E+1	1,77E+1	1,80E+2

MND = Module Not Declared

# Environmental performance: recoiled wire

Data referring to 1000 kg of recoiled wire

 <b>USE OF SECONDARY RAW MATERIALS</b>	UNIT	A1	A2	A3	A1-A3	A4, A5, B1 ÷ B7	C1	C2	C3	C4	D
<b>Use of secondary materials (SM)</b>	kg	9,62E+2	0,00E+0	0,00E+0	9,62E+2	MND	0,00E+0	0,00E+0	0,00E+0	0,00E+0	0,00E+0
<b>Use of renewable secondary fuels (RSF)</b>	MJ	0,00E+0	0,00E+0	0,00E+0	0,00E+0	MND	0,00E+0	0,00E+0	0,00E+0	0,00E+0	0,00E+0
<b>Use of non renewable secondary fuels (NRSF)</b>	MJ	0,00E+0	0,00E+0	0,00E+0	0,00E+0	MND	0,00E+0	0,00E+0	0,00E+0	0,00E+0	0,00E+0
 <b>USE OF FRESH WATER</b>											
<b>Net use of fresh water (FW)</b>	m3	4,99E+0	3,82E-2	1,26E+0	6,29E+0	MND	6,44E-3	3,58E-2	2,33E-2	9,29E-3	7,33E-2

MND = Module Not Declared

# Environmental performance: recoiled wire

Data referring to 1000 kg of recoiled wire

 WASTE DISPOSAL	UNIT	A1	A2	A3	A1-A3	A4, A5, B1 ÷ B7	C1	C2	C3	C4	D
Hazardous waste disposed (HWD)	kg	8,57E-2	1,98E-3	7,38E-4	8,85E-2	MND	6,12E-4	1,71E-3	4,66E-5	1,04E-4	2,21E-3
Non-hazardous waste disposed (NHWD)	kg	1,32E+2	1,53E+1	1,02E+1	1,58E+2	MND	1,30E-1	1,30E+1	9,30E-2	5,05E+1	4,75E+0
Radioactive waste disposed (RWD)	kg	1,29E-2	7,41E-5	3,62E-4	1,34E-2	MND	9,97E-6	8,69E-5	2,16E-4	4,38E-6	-2,30E-4
Components for re-use (CRU)	kg	0,00E+0	0,00E+0	0,00E+0	0,00E+0	MND	0,00E+0	0,00E+0	0,00E+0	0,00E+0	0,00E+0
Materials for Recycling (MFR)	kg	0,00E+0	0,00E+0	0,00E+0	0,00E+0	MND	0,00E+0	0,00E+0	0,00E+0	0,00E+0	0,00E+0
Materials for Energy Recovery (MER)	kg	0,00E+0	0,00E+0	0,00E+0	0,00E+0	MND	0,00E+0	0,00E+0	0,00E+0	0,00E+0	0,00E+0
Exported Energy (EE)	MJ	0,00E+0	0,00E+0	0,00E+0	0,00E+0	MND	0,00E+0	0,00E+0	0,00E+0	0,00E+0	0,00E+0

MND = Module Not Declared



# Calculation rules

## DECLARED UNIT: 1,000 kg of recoiled wire

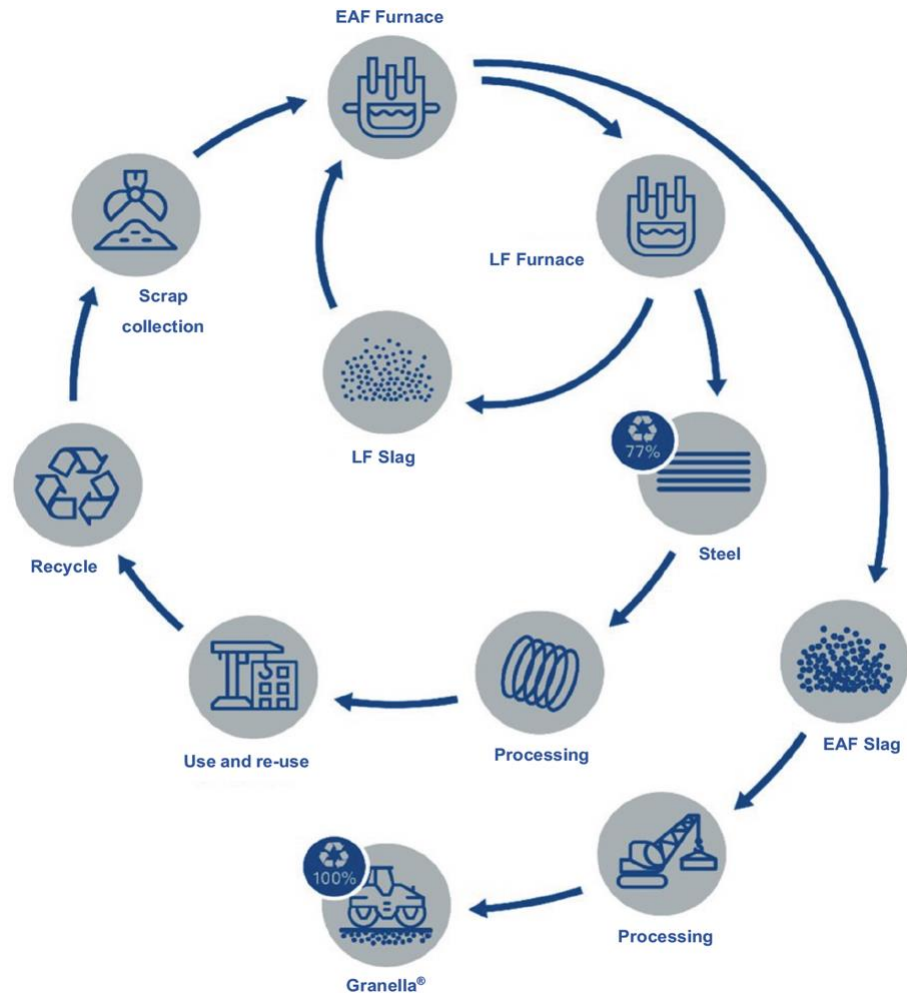
**ASSUMPTIONS:** System boundaries include the compulsory modules A1, A2, A3, C1, C2, C3, C4 and D as required by EN 15804 Standard, according to a “from cradle to gate with modules C1-C4 and D” approach. It should be noted that **building, maintenance and decommissioning of the infrastructures - intended as buildings - and use of industrial ground, were not taken into consideration**, because their contribution to environmental impact relating to the declared unit is deemed negligible. **Consumption of oils, detergents and other technical materials for machine maintenance, energy consumption for plant lighting, energy consumption for office activities related to the management of the steel mill are included.** Moreover, it should be noted that product distribution, use and disposal phases are not included in this study.

**CUT-OFF RULES:** The criterion chosen for the initial inclusion of the inbound and outbound elements, takes into account a 1% cut-off level, both in terms of mass, energy and environmental relevance. This means that a process was neglected if responsible of less than 1% of the total amount of mass, primary energy and total impact. However, all processes for which data are available were taken into account, even though with a contribution less than 1%. As a consequence, this threshold value was used in order to avoid collecting unknown data, not with the purpose of neglecting available data.

**DATA QUALITY:** in the LCA study, particular relevance was given to primary data collected at Ferriere Nord S.p.A. and Demolizioni Industriali S.r.l. through extensive measurements carried out at the plants.

**ALLOCATIONS:** allocation was avoided, whenever possible, by dividing the system into sub-systems. Otherwise, economic allocation was applied. As for waste modeling, the "Polluter pays principle" was applied.

# Additional information



Fin Since 1995, the Pittini Group has chosen a “**Zero Waste**”, production approach - a virtuous example of **circular economy**.

Zero Waste means that, at Pittini Group, **steel production must not create waste**. Instead, waste material is transformed in order to cut on unnecessary consumption and create opportunities of new uses.

Some great examples of circular economy are: **Granelia®**, product obtained from EAF slag, residue with highest amount, that is used for the production of asphalt pavements and concrete conglomerates as an alternative to natural aggregates; Ladle furnace slag, which is later re-introduced in the production process as a substitute for lime; Dust coming from fume filtering, from which zinc and other metals are extracted; and Rolling mill scale, which is used in the production of concrete and counterweights in the household appliance industry.

# Additional information

In every product is included recycled material coming from ferrous scrap.

The product certification P251 identifies the content of recycled and/or byproduct materials in steel products for construction.

The products object of this EPD has been successfully audited for their recycled and/or byproduct content according to the standard UNI PdR 88:2020.

This certification is compliant with the scheme IGQ SC026 “Schema di certificazione del contenuto di riciclato e/o recuperato e/o sottoprodotto nei prodotti da costruzione”.

First emission: 19-01-2024  
Last update: 19-01-2024  
Due date: 31-01-2027

The outcome of the verification on the products audited are indicated in the table on the right.

Certificate n°	Product category	Product	Recycled content
P251	Hot rolled steel products	Recoiled wire	76,4%

# References



- **ISO 14040:2006/Amd 1:2020** Environmental management - Life cycle assessment - Principles and framework
- **ISO 14044:2006/Amd 2:2020** Environmental management — Life cycle assessment — Requirements and guidelines — Amendment 1
- **ISO 14020:2000** Environmental labels and declarations -- General principles
- **EN 15804:2012 + A2:2019** Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction works
- **PD CEN/TR 16970:2016** Sustainability of construction works – Guidance for the implementation of EN 15804
- **PD CEN/TR 15941:2010** Sustainability of construction works – Environmental Product Declarations – Methodology for selection and use of generic data.
- **ICMQ-001/15 PCR for construction products rev.3**
- **EPDItaly Regulation v.6 (01/12/2023)**



# General informations



*Environmental declarations published within the same product category, but belonging to different programs, might not be comparable.*

*Specifically, EPDs regarding products for the building sector may not be comparable if not compliant with the EN 15804 standard.*

**REFERENCE DOCUMENTS:** This declaration was drafted following EDPltaly's General Programme Instruction, available on [www.epditaly.it](http://www.epditaly.it).

**ICMQ-001/15 PCR for construction products rev.3**

**CPC CODE :** 4124

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**TECHNICAL SUPPORT:** Spin Life s.r.l., via E. degli Scrovegni 29, 35131 Padua (Italy)

## INDEPENDENT VERIFICATION OF DECLARATION AND DATA CARRIED OUT ACCORDING TO ISO 14025

☐ EPD Process certification  
(Internal)

☒ EPD Verification (External)