

# ALPENA CEMENT PLANT

ENVIRONMENTAL PRODUCT DECLARATION



## About this EPD

This is a cradle-to-gate environmental product declaration for Portland (Type I/II low alkali and III), Blended Type IL and Masonry (Type S) cements as produced at Holcim's Alpena, MI plant. The life cycle assessment was prepared according to ISO 14025:2006, ISO 21930:2017 (the core PCR) and the NSF product category rules for Portland, Blended, Masonry, Mortar and Plastic (stucco) Cements (subcategory PCR). This environmental product declaration (EPD) is intended for business-to-business audiences.

## General Summary

### EPD Commissioner and Owner

**Holcim (US) Inc.**  
8700 W Bryn Mawr Ave  
Chicago, IL 60631  
Phone: 626-852-6200  
[www.holcim.us](http://www.holcim.us)



Holcim provided both LCI and meta-data for limestone quarrying, clinker production and cement manufacture for reference year 2019. The owner of the declaration is liable for the underlying information and evidence.

*For any explanatory material, regarding this EPD, please contact Sonia Gagnon ([sonia.gagnon@holcim.com](mailto:sonia.gagnon@holcim.com)).*

### Product Group and Name

*Cement, UN CPC 3744.*

### Product Definition

**Portland cement** is defined as a hydraulic cement produced by pulverizing clinker, consisting essentially of crystalline hydraulic calcium silicates, and usually containing one or more of the following: water, calcium sulfate, up to 5% limestone, and processing additions (NSF PCR 2020, ASTM C150, ASTM C219).

Portland Cement *Type I*—For use when the special properties specified for any other type are not required.

Portland Cement *Type II*—For general use, more especially when moderate sulfate resistance is desired.

Portland Cement *Type III*—For use when high early strength is desired.

Some cements are designated with a combined type classification, such as Type I/II, indicating that the cement meets the requirements of the indicated types and is being offered as suitable for use when either type is desired.

**Blended cement** is a hydraulic cement consisting of two or more inorganic constituents (at least one of which is not Portland cement or Portland cement clinker) which separately or in combination contribute to the strength gaining properties of the cement, (made with or without other constituents, processing additions and functional additions, by intergrinding or other blending).

- Type IL (ASTM C595) — is a Portland-limestone cement and is a hydraulic cement in which the limestone content is more than 5 % but less than or equal to 15 % by mass of the blended cement.

**Masonry cements** are hydraulic cements manufactured for use in mortars for masonry construction or in plasters, or both, which contain a plasticizing material and, possibly, other performance-enhancing addition(s). Mortar cements are produced in Type N, Type S, and Type M classifications for use in preparation of ASTM Specification C270.

Product Category Rules (PCR)	NSF International, Product Category Rules for Preparing an Environmental Product Declaration for Portland, Blended Hydraulic, Masonry, Mortar, and Plastic (Stucco) Cements, V3.1, September 2020 [2].
Date of Issue & Validity Period	02.26.2021 – 5 years
Declared Unit	1 metric ton of cement

### EPD and Project Report Information

Program Operator	ASTM International
Declaration Number	EPD 173
Declaration Type	Cradle-to-gate (modules A1 to A3). Facility and product-specific.
Applicable Countries	United States
Product Applicability	Cement is the basic ingredient of concrete. Concrete, one of the most widely used construction materials in the world, is formed when Portland cement creates a paste with water that binds with sand and rock to harden.
Content of the Declaration	This declaration follows Section 9; Content of an EPD, NSF International, Product Category Rules for Preparing an Environmental Product Declaration for Portland, Blended Hydraulic, Masonry, Mortar, and Plastic (Stucco) Cements, V3.1, September 2020 [2].
This EPD was independently verified by ASTM in accordance with ISO 14025 and the reference PCR:	Tim Brooke ASTM International 100 Barr Harbor Drive PO Box C700 West Conshohocken PA 19428-2959, USA <a href="mailto:cert@astm.org">cert@astm.org</a>
Internal                      External X	
The Project Report	Cradle-to-Gate Life Cycle Assessment of Holcim USA Cement Plants, Prepared for Holcim US, February 2021 (Revised May 2022).
LCA report and EPD Prepared by:	Lindita Bushi, PhD, Jamie Meil & Grant Finlayson Athena Sustainable Materials Institute 280 Albert Street, Suite 404 Ottawa, Ontario, Canada K1P 5G8 <a href="mailto:info@athenasmi.org">info@athenasmi.org</a> <a href="http://www.athenasmi.org">www.athenasmi.org</a>



**Athena**  
Sustainable Materials  
Institute

This EPD project report was independently verified by in accordance with ISO 14025, ISO 14040/44, and the reference PCR:

Thomas P. Gloria, Ph. D.  
Industrial Ecology Consultants  
35 Bracebridge Rd.  
Newton, MA

## PCR Information

Program Operator	NSF International
Reference PCR	Product Category Rules for Preparing an Environmental Product Declaration for Portland, Blended Hydraulic, Masonry, Mortar, and Plastic (Stucco) Cements, V3.1, September 2020.
PCR review was conducted by:	Thomas P. Gloria, PhD (Chair), Industrial Ecology Consultants, <a href="mailto:t.gloria@industrial-ecology.com">t.gloria@industrial-ecology.com</a> Mr. Jack Geibig, EcoForm Mr. Bill Stough, Sustainable Research Group

## Holcim US Cement & Production Facility

Holcim is the global leader in building materials and solutions. As the largest cement manufacturer in the United States, Holcim's ambition is to lead the industry in reducing carbon emissions and shifting towards low-carbon construction.

In the United States, Holcim companies include close to 350 sites in 43 states and employ 7,000 people. Our customers rely on us to help them design and build better communities with innovative solutions that deliver structural integrity and eco-efficiency.

Facility Name: Holcim Alpena Cement Plant,  
1435 Ford Avenue, Alpena, MI 49707

## Product Description

This EPD reports environmental transparency information for four cement types produced by Holcim at its Alpena, MI plant. Cements are hydraulic binders and are manufactured by grinding cement clinker and other main or minor constituents into a finely ground, usually grey colored mineral powder. When mixed with water, cement acts as a glue to bind together the sand, gravel or crushed stone to form concrete, one of the most durable, resilient and widely used construction materials in the world. The Table below sets out each cement type constituents and applicable standards. All Alpena cements are sold in bulk.

## Products and Standards

Inputs	Portland Type I/II Low Alkali ASTM C150	Portland Type III ASTM C150	Blended Type II ASTM C595	Masonry Type S ASTM C91
Clinker	91%	94%	85%	58%
Gypsum	5%	5%	6%	5%
Limestone	3%	<1%	9%	37%
Other	<1%	<1%	<1%	<1%
<b>Total</b>	100%	100%	100%	100%

### Applicable Standards:

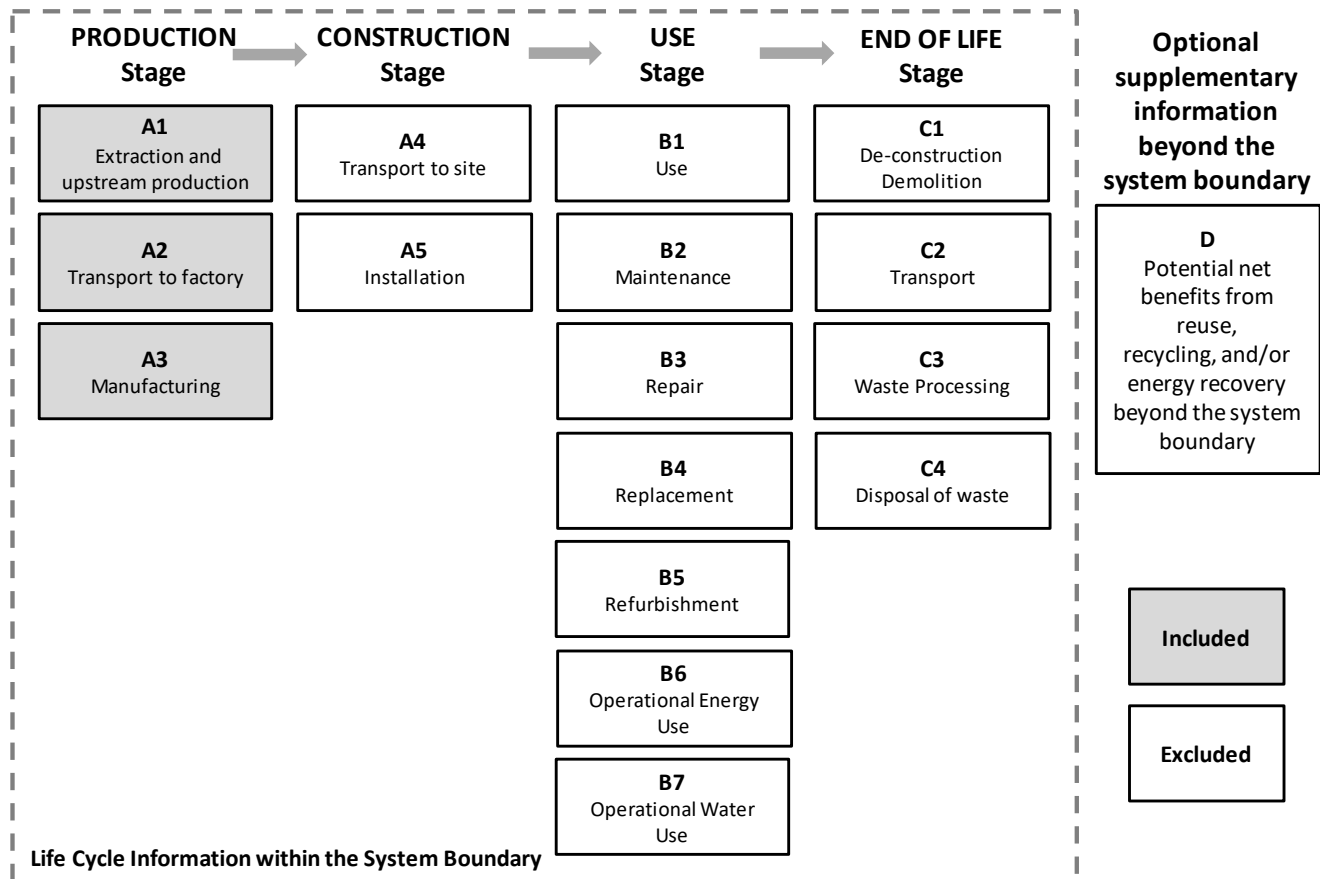
ASTM C150 / C150M – 20 Standard Specification for Portland Cement  
ASTM C595 / C595M – 20 Standard Specification for Blended Hydraulic Cement  
ASTM C91 / C91M – 18 Standard Specification for Masonry Cement  
ASTM C1157 / C1157M – 20 Standard Performance Specification for Hydraulic Cements  
AASHTO M 85-20 Standard Specification for Portland Cement (ASTM Designation: C150 / C150M - 20)

### Declared Unit

The declared unit is one metric tonne of cement.

### System Boundary

This EPD is a cradle-to-gate EPD covering the production stage (A1-A3) as depicted in the figure below. The production stage includes extraction of raw materials (cradle) through the manufacture of cements ready for shipment (gate). The Alpena, MI cement plant sources its limestone supply from an adjacent quarry.



### Items excluded from the system boundary include:

- Production, manufacture, and construction of manufacturing capital goods and infrastructure
- Production and manufacture of production equipment, delivery vehicles, and laboratory equipment
- Personnel-related activities (travel, furniture, and office supplies)

- Energy and water use related to company management and sales activities that may be located either within the factory site or at another location

#### Cut-off Criteria

The cut-off criteria as per NSF PCR, Section 7.1.8 [2] and ISO 21930, 7.1.8 [3] were followed. Per ISO 21930, 7.1.8 [3], all input/output data required were collected and included in the LCI modelling. No substances with hazardous and toxic properties that pose a concern for human health and/or the environment were identified in the framework of this EPD. Any plant specific data gaps for the reference year 2019 e.g., amount of lubricants and refractory were filled in with industry data (secondary data).

#### Data Collection

Gate-to-gate input/output flow data were collected for the following processes for the reference year 2019:

- Limestone quarry, clinker production and cement manufacture – Alpena, MI.

### Allocation Rules

Allocation follows the requirements and guidance of ISO 14044 Clause 4.3.4 [5], NSF PCR [2], and ISO 21930 section 7.2 [3]. Recycling and recycled content are modeled using the cut-off rule. The sub-category PCR recognizes fly ash, furnace bottom ash, bypass dust, mill scale, polluted soils, spent catalyst, aluminum oxide waste, silica fume, granulated blast furnace slag, iron rich waste, cement kiln dust (CKD), flue gas desulfurization (FGD) gypsum, and calcium fluoride rich waste as recovered materials and thus the environmental impacts allocated to these materials are limited to the treatment and transportation required to use as a cement material input. Further, used tires, plastics, solvents, used oil and oily waste, coal/carbon waste, roofing asphalt, household refuse-derived waste and non-hazardous liquid waste are considered non-renewable and/or renewable secondary fuels. Only the materials, water, energy, emissions, and other elemental flows associated with reprocessing, handling, sorting and transportation from the point of the generating industrial process to their use in the production process are considered. All emissions from combustion at the point of use are considered.

### Data Quality Requirements and Assessment

Data Quality Requirements	Description
<b>Technology Coverage</b>	<p>Data represents the prevailing technology in use at the Alpena, MI facility. Whenever available, for all upstream and core material and processes, North American typical or average industry LCI datasets were utilized.</p> <p>The Alpena, MI plant utilizes <i>a long dry kiln technology</i>.</p> <p><i>Technological representativeness is characterized as "high".</i></p>
<b>Geographic Coverage</b>	<p>The geographic region considered is U.S.</p> <p><i>Geographical representativeness is characterized as "high".</i></p>

<b>Time Coverage</b>	<p>Activity (primary) data are representative of 2019 calendar year (12 months).</p> <ul style="list-style-type: none"> <li>- Alpena limestone extraction,</li> <li>- Alpena clinker production,</li> <li>- Alpena cement manufacturing,</li> <li>- In-bound/out-bound transportation data - primary data collected for Alpena quarry site and cement manufacturing plant.</li> <li>- Generic data: the most appropriate LCI datasets were used as found in the ecoinvent v.3.6 database for US and global, December 2019 and US LCI Database.</li> </ul> <p><i>Electricity resource mix for RFC region includes (eGRID 2018): 35.1% coal, 29.8% nuclear, 28.5% natural gas, 3.0% wind, 1.1% hydro, 1.1% biomass, 0.5% oil, 0.2% solar, and 0.6% other fossils [14], [10].</i></p> <p><i>Temporal representativeness is characterized as “high”.</i></p>
<b>Completeness</b>	<p>All relevant, specific processes, including inputs (raw materials, energy and ancillary materials) and outputs (emissions and production volume) were considered and modeled to complete production profile for Alpena cement products.</p> <p>The relevant background materials and processes were taken from the US LCI Database (adjusted for known data placeholders), ecoinvent v 3.6 LCI database for US, and modeled in SimaPro software v.9.1.1.1, September 2020. The completeness of the cradle-to-gate process chain in terms of process steps is rigorously assessed for all cement product systems.</p>
<b>Consistency</b>	<p>To ensure consistency, the LCI modeling of the production input and output LCI data for the Alpena cement products of interest used the same LCI modeling structure, which consisted of input material and intermediate products, ancillary and packaging materials (if applicable), energy flows, water resource inputs, product outputs, co-products, by-products, emissions to air, water and soil, and solid and liquid waste disposal. Crosschecks concerning the plausibility of mass and energy flows were continuously conducted. The LCA team conducted mass and energy balances at the facility level and selected process levels to maintain a high level of consistency.</p>
<b>Reproducibility</b>	<p>Internal reproducibility is possible since the data and the models are stored and available in <i>LH_Alpenna Athena LCI database</i> developed in SimaPro, 2020. A high level of transparency is provided throughout the report as the LCI profile is presented for each of the declared products as well as major upstream inputs. Key primary (manufacturer specific) and secondary (generic) LCI data sources are also summarized in the background report. External reproducibility is not possible as the background report is confidential.</p>
<b>Transparency</b>	<p>Activity and LCI datasets are disclosed in the project report, including all data sources.</p>
<b>Uncertainty</b>	<p>A <i>sensitivity check</i> was conducted to assess the reliability of the EPD results and conclusions by determining how they are affected by uncertainties in the data or assumptions on calculation of LCIA and energy indicator results.</p>

## Life Cycle Impact Assessment Results: Alpena, MI Cements

This section summarizes the production stage life cycle impact assessment (LCIA) results including resource use and waste generated metrics based on the cradle-to-gate life cycle inventory inputs and outputs analysis. The results are calculated based on 1 metric ton of each cement type as produced at the Alpena, MI plant. *It should be noted that LCIA results are relative expressions and do not predict impacts on category endpoints, the exceeding of thresholds, safety margins or risks [4], [5]. Further, a number of LCA impact categories and inventory items are still emerging or under development and can have high levels of uncertainty that preclude international acceptance pending further development. Use caution when interpreting results for these categories – identified with an “\*” [2].*

Only EPDs prepared from cradle-to-grave life-cycle results and based on the same function, quantified by the same functional unit, and taking account of replacement based on the product reference service life (RSL) relative to an

assumed building service life, can be used to assist purchasers and users in making informed comparisons between products [2]. Environmental declarations from different programs may not be comparable [7]. EPDs are comparable only if they comply with ISO 21930, use the same, sub-category PCR where applicable, include all relevant information modules and are based on equivalent scenarios with respect to the context of construction works [3].

**Production Stage EPD Results: Alpena, MI – per Metric Tonne**

Impact category and inventory indicators	Unit	Portland Type I/II Low Alkali ASTM C150	Portland Type III ASTM C150	Blended Type II ASTM C595	Masonry Type S ASTM C91
Global warming potential, GWP 100 <sup>1)</sup> , AR5	kg CO <sub>2</sub> eq	1,056	1,095	984	692
Ozone depletion potential, ODP <sup>2)</sup>	kg CFC-11 eq	9.5E-05	9.8E-05	8.8E-05	6.3E-05
Smog formation potential, SFP <sup>2)</sup>	kg O <sub>3</sub> eq	12.0	12.7	11.4	9.7
Acidification potential, AP <sup>2)</sup>	kg SO <sub>2</sub> eq	1.8	1.9	1.7	1.3
Eutrophication potential, EP <sup>2)</sup>	kg N eq	0.43	0.48	0.40	0.34
Abiotic depletion potential for non-fossil mineral resources, ADP elements <sup>3)</sup> *	kg Sb eq	7.6E-04	8.0E-04	7.1E-04	5.5E-04
Abiotic depletion potential for fossil resources, ADP fossil <sup>3)</sup>	MJ LHV	6,311	6,635	5,896	4,251
Renewable primary resources used as an energy carrier (fuel), RPRE*	MJ LHV	27	35	26	45
Renewable primary resources with energy content used as material, RPRM <sup>4)</sup> *	MJ LHV	0	0	0	0
Non-renewable primary resources used as an energy carrier (fuel), NRPRE*	MJ LHV	6,485	6,894	6,071	4,467
Non-renewable primary resources with energy content used as material, NRPRM <sup>4)</sup> *	MJ LHV	0	0	0	0
Secondary materials, SM <sup>4)</sup> *	kg	95	83	91	51
Renewable secondary fuels, RSF <sup>4)</sup> *	MJ LHV	0	0	0	0
Non-renewable secondary fuels, NRSF <sup>4)</sup> *	MJ LHV	5	5	5	3
Recovered energy, RE <sup>4)</sup> *	MJ LHV	207	329	198	270
Consumption of freshwater, FW <sup>4)</sup>	m <sup>3</sup>	0.3	0.3	0.3	0.2
Hazardous waste disposed, HWD <sup>4)</sup> *	kg	0.057	0.058	0.056	0.050
Non-hazardous waste disposed, NHWD <sup>4)</sup> *	kg	3.2	3.2	3.1	2.8

High-level radioactive waste, conditioned, to final repository, HLRW <sup>4)</sup> *	m <sup>3</sup>	9.2E-08	1.4E-07	9.2E-08	1.1E-07
Intermediate- and low-level radioactive waste, conditioned, to final repository, ILLRW <sup>4)</sup> *	m <sup>3</sup>	3.1E-05	3.2E-05	2.9E-05	2.1E-05
Components for re-use, CRU <sup>4)</sup> *	kg	0	0	0	0
Materials for recycling, MR <sup>4)</sup> *	kg	80.8	82.8	75.2	51.4
Materials for energy recovery, MER <sup>4)</sup> *	kg	0	0	0	0
Recovered energy exported from the product system, EE <sup>4)</sup> *	MJ LHV	61	62	57	39
<b>Additional Inventory Parameters for Transparency</b>					
Emissions from calcination <sup>5)</sup>	kg CO <sub>2</sub> eq	480	492	447	306
Biogenic CO <sub>2</sub> , reporting the removals and emissions associated with biogenic carbon content contained within biobased products	kg CO <sub>2</sub> eq	0	0	0	0

**Table Notes:**

<sup>1)</sup> Calculated as per U.S EPA TRACI v2.1, with IPCC 2013 (AR 5), SimaPro v 9.1.1.1 [10].

GWP 100, excludes biogenic CO<sub>2</sub> removals and emissions associated with biobased products; 100-year time horizon GWP factors are provided by the IPCC 2013 Fifth Assessment Report (AR5), TRACI v2.1 with AR5, v1.05 [10].

<sup>2)</sup> Calculated as per U.S EPA TRACI v2.1, SimaPro v 9.1.1.1 [10].

<sup>3)</sup> ADP elements: Clay, bentonite, limestone, gravel, silica, sand added to model per Table A4 in the 2019 NSF PCR for Concrete [6]. ADP fossil is calculated as per CML-IA Baseline v3.05, SimaPro v 9.1.1.1 [10]. ADP LHV, CML is required in LEED V4.1 MR Credit: Building Product Disclosure and Optimization – Environmental Product Declarations [13].

<sup>4)</sup> Calculated as per ACLCA ISO 21930 Guidance [11].

<sup>5)</sup> Total CO<sub>2</sub> facility combustion emissions are measured data from CO<sub>2</sub> Continuous Emission Monitoring System (CEMS) as reported in 2019 GHG Report submitted to US EPA. Calcination emissions are based on the Cement CO<sub>2</sub> and Energy Protocol detailed output method (B1) published by the World Business Council for Sustainable Development (WBCSD) Cement Sustainability Initiative (CSI) [15].

## LCA Interpretation

The Manufacturing module (A3) drives most of the potential environmental impacts. Manufacturing impacts are primarily driven by energy use (electricity and thermal fuels) used during the pyroprocessing of limestone in the production of clinker. Clinker content in cement similarly defines the relative environmental profile of the final cement product. Raw material extraction (A1) is the second largest contributor to the Production stage EPD results, followed by the transportation (A2).

## Additional Environmental Information

### Environmental Protection and Equipment

Holcim manufacturing facilities comply with the U.S. environmental protection agency (EPA) regulations, monitor and report the emissions to air during the manufacturing process as per the following:

- EPCRA Section 313 Toxic Release Inventory reporting (U.S) <https://www.epa.gov/toxics-release-inventory-tri-program>, accessed 08-2020.

Air pollution abatement equipment used at Holcim's Alpena plant consist of high and low temperature baghouses, cartridge filters, drum filters, dry filters, bin vents, selective non-catalytic reduction (SNCR), wet scrubbers and dry Scrubber (dry sorbent injection, DSI).

## References

1. ASTM C1157 / C1157M – 20 Standard Performance Specification for Hydraulic Cement.
2. NSF International, Product Category Rule Environmental Product Declarations, PCR for Portland, Blended, Masonry, Mortar, and Plastic (Stucco) Cements, V3.1, September 2020.
3. ISO 21930:2017 Sustainability in buildings and civil engineering works - Core rules for environmental product declarations of construction products and services.
4. ISO 14040:2006/Amd1:2020 Environmental management - Life cycle assessment - Principles and framework.
5. ISO 14044:2006/Amd1:2017/Amd2:2020 Environmental management - Life cycle assessment - Requirements and guidelines.
6. NSF International, Product Category Rule Environmental Product Declarations, PCR for Concrete, February 2020.
7. ISO 14025:2006 Environmental labeling and declarations - Type III environmental declarations - Principles and procedures.
8. ISO 14021:2016 Environmental labels and declarations -- Self-declared environmental claims (Type II environmental labelling).
9. ASTM Program Operator Rules, v 8.0, 04/29/2020.
10. PRé 2019.SimaPro LCA Software v9.1.1.1, September 2020.  
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<https://aclca.org/aclca-iso-21930-guidance/>, <https://aclca.org/wp-content/uploads/ISO-21930-Final.pdf>, accessed 08-2020.
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<https://www.cement-co2-protocol.org/en/>, accessed 08-2020.