ENVIRONMENTAL PRODUCT DECLARATION

In accordance with ISO 14025 and EN 15804 for:

HUILITONG Steel hollow sections

From

TIANJIN HUILITONG STEEL TUBE CO., LTD

Declared product:



Programme operator:	EPD China
Registration number:	EPD-CN-00021
Issued date:	2025-07-07
Valid until:	2030-07-06

Programme Information

EPD Owner	TIANJIN HUILITONG STEEL TUBE CO., LTD
Product Name	HUILITONG Steel Hollow Sections
Production Site	Beihuan Industry Area Jinghai, Tianjin, China
Identification of product	UNCPC Code 412 Products of iron or steel
Field of Application	HUILITONG steel hollow sections are used in petroleum and natural gas transportation, water transportation, and mineral powder transportation, and also used in steel pipe and pile steel pipe for industrial and civil building structures. They can be electric resistance welded pipes, spiral submerged arc welded pipes, square and rectangular pipe.
Programme Operator	EPD China Address of Headquarter: Tianping Road, Xuhui District, Shanghai Website: www.epdchina.cn Email: info@epdchina.cn | secretary@epdchina.cn
LCA Practitioner	Yufei Jiang support@1mi1.cn Ecovane Environmental Co., Ltd
Responsibility	The EPD owner has the sole ownership, liability, and responsibility for the EPD
Comparability	EPDs within same category of product in different programme operator are not suggested to be compared. Full conformance with a PCR allows EPD comparability only when all stages of a life cycle have been considered. However, variations and deviations are possible even applying the same PCR.
Liability	The EPD owner has the sole ownership, liability, and responsibility for the EPD.
Validity	The EPD is published on 2025-07-07 and valid to 2030-07-06
LCA Software (version)	Simapro 9.6
LCI Dataset (version)	Ecoinvent 3.10
Year(s) of Primary Data	01/2024-12/2024
PCR	EPDCN-PCR-202204: PCR for Construction Products and Construction Services to EN 15804 V2.1
Other Reference Document	EN 15804:2012+A2:2019 Sustainability of construction works — Environmental product declarations — Core rules for the product category of construction products
Verification statement according EN15804	
Independent verification of the declaration and data according to EN ISO 14025:2010 ☐ internal ☒ external Third-party institution verification: <Fang Wang, LRQA Industrial Technical Services (Shanghai) Co., Ltd. > is an approved certification body accountable for third-party verification Approved by: EPD China	
Procedure for follow-up of data during EPD validity involves a third-party certification body: ☐ Yes ☒ No	

General Information

1.1 Company information

Owner of the EPD: TIANJIN HUILITONG STEEL TUBE CO., LTD

Address: Beihuan Industry Area Jinghai, Tianjin, China

Website: www.huilitong.com.cn

Contact: huilitong@huilitong.com.cn

Description of the Company:

Located in Beihuan Industrial Park, Jinghai District, Tianjin, TIANJIN HUILITONG STEEL TUBE CO., LTD. abbreviated as HUILITONG, is a company specialized in the production of electric-resistance arc welding, spirally submerged arc welding, square/rectangular pipe and anti-corrosion. The company covers an area of 150,000 square meters, the company has a complete variety of production equipment and testing equipment, the annual production scale of more than 350,000 tons.

With strong professional and technical advantages, and a number of professional and technical personnel and testing personnel, the company has established a perfect technical support system and quality assurance system, to establish corporate image by quality, win customer trust by service, and carry out strict management; the company has obtained certifications of ISO9001 quality system, ISO14000 environmental management system and ISO45001 occupational health and safety system, the special equipment pressure pipeline manufacturing license and the use right certificate for API logo. The company's products can meet API 5L PSL2, API 5CT, GB/T9711 PSL2, GB/T13793, EN10210, EN10217, EN10219 and other industry standards, and are widely used in petroleum, natural gas transportation, water and gas transportation, sewage treatment and discharge, bridges, ports, industrial piles and pipes and other kinds of structures.

Product-related or management system-related certifications:

➢ GB/T13793, GB/T9711 PSL2
➢ EN10219, EN10210, EN 10217
➢ API 5L PSL2, API 5CT

1.2 Scope and type of EPD

Declare unit: One ton of HUILITONG steel hollow sections.

Reference service life: N/A

Time representativeness: 2024.1-2024.12

Description of system boundaries: Cradle-to-gate with options, modules C1-C4 and module D (A1-A3 + C + D and additional modules: A4)

Excluded life cycle stages: A5 and B1-B7

Table1 Process stages and EPD modules

PRODUCT STAGE			CONSTRUCTION PROCESS STAGE		USE STAGE							END OF LIFE STAGE				BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARIES
Raw material supply	Transport	Production	Transport	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction/ 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	x	ND	ND	ND	ND	ND	ND	ND	ND	x	x	x	x	x

A1 Raw material supply:

Production starts with the material supply. This module includes the mining and pretreatment processes before production. Steel coils are the main raw material used for hollow sections production.

A2 Transportation of raw materials to manufacturer

Transportation module includes the delivery of raw materials from suppliers to the gate of manufacturing plant. Steel coils are transported by lorry to HUILITONG plant from suppliers located in China.

A3 Manufacturing

The manufacturing process of HUILITONG steel hollow sections are shown in Figure 2, which involves raw materials, energy, water, and emissions during the process.

A4 Transportation of products

According to HUILITONG, steel hollow sections are consumed to China and overseas.

C1 De-construction and demolition

The impact of the dismantling phase was considered negligible.

C2 Transportation to waste processing

The discarded product is transported either to the recycling site or to landfills for final disposal. As a conservative assumption, a distance of 100 km to waste processing sites is assumed.

C3 Waste processing for reuse, recovery and/or recycling

According to World Steel Association, the average recycling rate of steel after its life cycle is 85%. The rest 15% is assumed to be landfilled. Recycling includes sorting and pressing.

C4 Disposal

Usually, a small amount of the waste remains either at the deconstruction site or during the separation. This small portion will be landfilled. In relation to the C3 stage explained above, 15% of steel after its life cycle will be landfilled.

D Reuse-Recovery-Recycling-potential

Module D consists of avoided burdens related to the potential reuse and/or recycling of the product after its end-of-life stage. The reuse/recycling rates of steel is 85%.

2 Detailed Product Description

2.1 Description of the product

Product name: HUILITONG Steel Hollow Sections

Product identification: UNCPC Code 412 Products of iron or steel

Table 2 Product specification and technical performance:

Yield strength	Product code	Component
235	S235JRH	C≤0.17%
245	L245M/BM	C≤0.22%
275	S275JOH/S275J2H/S275MH/S275MLH	S275JOH/S275J2H C≤0.20% S275MH/S275MLH C≤0.13%
355	S355J0H/S355J2H/Q355K2H/S355MH /S355MLH	S355J0H/S355J2H/Q355K2H C≤0.22% S355MH/S355MLH C≤0.14%
420	S420MH/S420MLH	C≤0.16%
460	S460MH/S460MLH	C≤0.16%
other	X42M, X46M, X52M, X56M, X60M, X65M, X70M, X80M	X42M, X46M, X52M, X56M C≤0.22% X60M, X65M, X70M, X80M C≤0.12%

Figure 1 Picture of the declared product.

Intended application: HUILITONG steel hollow sections are for structural use and pile driving for industrial and civil building structures.

Target group: Contractor, stockholder.

They can be electric resistance welded pipes, spiral submerged arc welded pipes, square and rectangular pipe.

2.2 Description of the production process

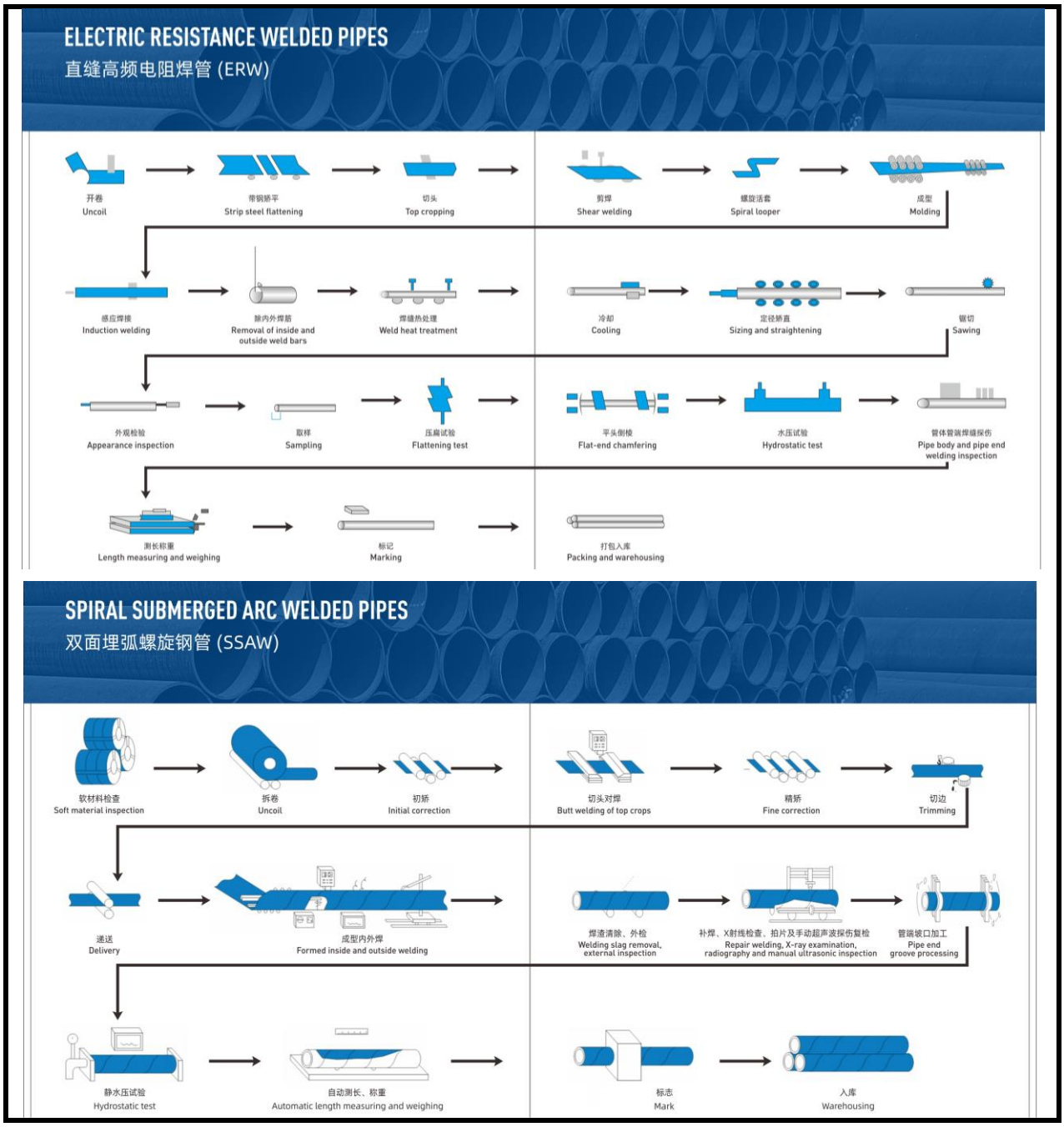

Figure 2 Manufacturing process of HUILITONG steel hollow section product

Table 3 Main product components per unit

Product components	Weight, t	Weight-% (versus the product)
Steel coil	1.04	104
Auxiliary materials	**Weight, kg**	**Weight-% (versus the product)**
Welding wire	9.78	0.978
Welding flux	4.22	0.422

The included product contains no substances in the “Candidate List of Substances of Very High Concern for authorization” registration with the European Chemicals Agency.

3 LCA results according to EN 15804

3.1 Environmental Impacts

The results of the underlying LCA is provided in this section as environmental impacts, resource use, output flows and additional information on biogenic carbon. All pre-set parameters of EN 15804 are required. Note that the results are calculated based on the average case for the product group, the range of the LCIA result may vary slightly depending on the production line.

Table 4 Environmental impacts according to EN 15804

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT per declared unit								
Core indicator	Unit	A1-A3	A4	C1	C2	C3	C4	D
Global Warming Potential total (GWP-total)	[kg CO2 eq.]	2.65E+03	1.58E+02	0.00E+00	1.94E+01	8.91E+01	9.39E-01	-1.02E+02
Global Warming Potential fossil fuels (GWP-fossil)	[kg CO2 eq.]	2.64E+03	1.58E+02	0.00E+00	1.94E+01	5.23E+01	9.38E-01	-1.02E+02
Global Warming Potential biogenic (GWP-biogenic)	[kg CO2 eq.]	1.34E+00	-2.42E-02	0.00E+00	5.72E-04	3.67E+01	1.29E-04	0.00E+00
Global Warming Potential land use and land use change (GWP-luluc)	[kg CO2 eq.]	1.40E+00	7.37E-02	0.00E+00	7.80E-03	1.16E-01	4.83E-04	4.83E-01
Depletion potential of the stratospheric ozone layer (ODP)	[kg CFC 11 eq.]	1.44E-05	2.31E-06	0.00E+00	2.88E-07	6.25E-07	2.71E-08	1.06E-05
Acidification potential, Accumulated Exceedance (AP)	[mol H+ eq.]	1.11E+01	2.76E+00	0.00E+00	8.10E-02	3.47E-01	6.65E-03	-5.31E-01
Eutrophication potential, fraction of nutrients reaching freshwater end compartment (EP-freshwater)	[kg PO4 eq.]	1.03E+00	8.49E-03	0.00E+00	1.52E-03	1.12E-02	7.79E-05	-1.22E-01
Eutrophication potential, fraction of nutrients reaching marine end compartment (EP-marine)	[kg N eq.]	2.52E+00	7.24E-01	0.00E+00	2.95E-02	1.37E-01	2.53E-03	-1.10E-01
Eutrophication potential, Accumulated Exceedance (EP-terrestrial)	[mol N eq.]	2.61E+01	8.02E+00	0.00E+00	3.22E-01	1.22E+00	2.77E-02	-2.33E+00
Formation potential of tropospheric ozone (POCP)	[kg NMVOC eq.]	9.13E+00	2.27E+00	0.00E+00	1.12E-01	3.90E-01	9.91E-03	-7.18E-01
Abiotic depletion potential for non-fossil resources (ADP-minerals&metals)	[kg Sb eq.]	1.59E-02	3.21E-04	0.00E+00	6.27E-05	4.41E-04	1.47E-06	-3.75E-03
Abiotic depletion potential for fossil resources (ADP-fossil)	MJ, net calorific value	1.85E+04	1.48E+02	0.00E+00	2.66E+01	1.38E+02	1.42E+00	-2.39E+03
Water (user) deprivation potential, deprivation-weighted water consumption (WDP)	[m3 world eq. Deprived]	8.05E+02	7.08E+00	0.00E+00	1.23E+00	4.99E+00	1.01E+00	-4.76E+01

**Disclaimer: The results of this environmental impact indicator shall be used with care as the uncertainties of these results are high or as there is limited experience with the indicator.*

***For all environmental impact indicators, the estimated impact results are only relative statements, which do not indicate the endpoints of the impact categories, exceeding threshold values, safety margins and/or risks.*

3.2 Resource use and waste categories

Table 5 Resource use and waste categories according to EN 15804

RESULTS OF THE LCA - Resource use and waste categories per declared unit								
Core indicator	Unit	A1-A3	A4	C1	C2	C3	C4	D
Use of renewable primary energy excluding renewable primary energy resources used as raw materials (PERE)	MJ	2.36E+03	2.15E+01	0.00E+00	3.61E+00	2.92E+01	2.16E-01	5.95E+02
Use of renewable primary energy resources used as raw materials (PERM)	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Total use of renewable primary energy resources (PERT) (primary energy and primary energy resources used as raw materials)	MJ	2.36E+03	2.15E+01	0.00E+00	3.61E+00	2.92E+01	2.16E-01	5.95E+02
Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials (PENRE)	MJ	1.85E+04	1.48E+02	0.00E+00	2.66E+01	1.38E+02	1.42E+00	-2.39E+03
Use of non-renewable primary energy resources used as raw materials (PENRM)	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Total use of non-renewable primary energy resources (PENRT) (primary energy and primary energy resources used as raw materials)	MJ	1.85E+04	1.48E+02	0.00E+00	2.66E+01	1.38E+02	1.42E+00	-2.39E+03
Use of secondary material (SM)	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Use of renewable secondary fuels (RSF)	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Use of non-renewable secondary fuels (NRSF)	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Net use of fresh water (FW)	m3	2.52E+01	2.18E-01	0.00E+00	3.72E-02	1.53E-01	2.39E-02	-1.98E+00
Hazardous waste disposed (HWD)	kg	3.14E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Non-hazardous waste disposed (NHWD)	kg	1.90E-01	0.00E+00	0.00E+00	0.00E+00	0.00E+00	1.50E+02	0.00E+00
Radioactive waste disposed (RWD)	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Components for re-use (CRU)	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Materials for recycling (MR)	kg	4.54E+01	0.00E+00	0.00E+00	0.00E+00	8.50E+02	0.00E+00	0.00E+00
Materials for energy recovery (MER)	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Exported energy (EE)	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

3.3 Information on biogenic carbon content

Information on biogenic carbon content which shall be included in the EPD as follows:

Biogenic carbon content	Unit (expressed per functional unit or per declared unit)
Biogenic carbon content in product	0 kg C
Biogenic carbon content in accompanying packaging	0 kg C
NOTE：1 kg biogenic carbon is equivalent to 44/12 kg of CO2.	

4 Supplementary information

4.1 Calculation rules

All inputs and outputs of the production by HUILITONG were considered in the calculation. Generic data was used for the considered raw materials from the supplier due to the fact that these materials are not produced by HUILITONG.

Data was collected from primary sources including the manufacturer, suppliers and their publications on standards locations, logistics, technology, market share, management system, and commitment to improved environmental performance.

Transport assumptions are made where it is not possible to obtain the specific data. When this occurs, it is clearly stated in the report and a sensitivity analysis is conducted;

The cut-off criteria adopted are as stated in "EN 15804:2012+A2:2019". Where there are insufficient data or data gaps for a unit process, the cut-off criteria are 1% of the total mass of input of that process. The total of neglected input flows per module is a maximum of 5% of energy usage and mass. In this case, waste water is excluded because of the negligible amount.

Needed machines, plants and further infrastructure for the production at HUILITONG are not considered in the calculation.

In the production of steel hollow sections, special production is used because all the inputs and outputs are clearly corresponding to the products, and scraps are treated as by-products for sale in this situation.

The grid mix data on electricity of for the site in Tianjin is based on grid mixes of the State Grid North China Branch (NCGC). Electricity mix has been modelled from Ecoinvent database 3.10. The electricity inventory is based on the year of 2021 for Chinese electricity generation (China Energy Statistics). According to the dataset in Ecoinvent, the main part of electricity is produced by hard coal, followed by natural gas, oil and wind in China. PV power generation is another part of the electricity use, which modeled by Ecoinvent dataset "Electricity, low voltage {CN-TJ}| electricity production, photovoltaic, 3kWp slanted-roof installation, multi-Si, panel, mounted | Cut-off, U".

4.2 Scenarios and additional technical information

Table 6 Transportation of raw materials

Raw materials	Distance/km	Vehicle
Steel coil	359/132	Truck/Lorry
Welding wire	190	Lorry
Welding flux	600	Lorry

Table 7 Transportation of products

Market location	Ratio	Distance (km)	Vehicle
South China	30%	1000	Lorry
North China	30%	200	Lorry
Overseas	40%	20430	Lorry/ship

References

1. ISO 14040 (2006): Environmental Management - Life Cycle Assessment - Principles and Framework
2. ISO 14044 (2006): Environmental Management - Life Cycle Assessment - Requirements and Guidelines
3. EPDCN-PCR-202204: PCR for Construction Products and Construction Services to EN 15804 V2.1
4. China Statistical Yearbook, 2021. National Bureau of Statistics of China.
5. EN15804:2012+A2:2019/AC: Sustainability of construction works - Environmental Product Declarations - Core rules for the product category of construction products
6. General Programme Instructions for EPD China. Version 3.1
7. World Steel Association

ENVIRONMENTAL PRODUCT DECLARATION