

Environmental Product Declaration



In accordance with ISO 14025:2006 and EN 15804:2012+A2:2019/AC:2021, ISO 21930 for:

Steel strut and fittings products

EPD of multiple products, based on the average results of the product group, including: 15/8" Strut & Fittings, 11/4" Strut & Fittings, 13/16" Strut & Fittings, Concrete Inserts and Prime Angle.

from

Atkore



Programme:	The International EPD® System, www.environdec.com
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An EPD should provide current information and may be updated if conditions change. The stated validity is therefore subject to the continued registration and publication at www.environdec.com



General information

Programme information

Programme:	The International EPD® System
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Website:	www.environdec.com
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Accountabilities for PCR, LCA and independent, third-party verification
Product Category Rules (PCR)
CEN standard EN 15804 serves as the Core Product Category Rules (PCR)
Product Category Rules (PCR): <i>PCR 2019:14 Construction products v1.3.4</i>
PCR review was conducted by: <i>The Technical Committee of the International EPD System. See www.environdec.com for a list of members. Review chair: Claudia A. Peña, University of Concepción, Chile. The review panel may be contacted via the Secretariat www.environdec.com/contact</i>
Life Cycle Assessment (LCA)
LCA accountability: <i>Marcella Volta, ERM, marcella.volta@erm.com</i>
Third-party verification
Independent third-party verification of the declaration and data, according to ISO 14025:2006, via: <input checked="" type="checkbox"/> EPD verification by individual verifier Third-party verifier: <i>Matt Fishwick, Fishwick Environmental Ltd</i> Approved by: The International EPD® System Procedure for follow-up of data during EPD validity involves third party verifier: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No

The EPD owner has the sole ownership, liability, and responsibility for the EPD.

EPDs within the same product category but registered in different EPD programmes, or not compliant with EN 15804, may not be comparable. For two EPDs to be comparable, they must be based on the same PCR (including the same version number) or be based on fully-aligned PCRs or versions of PCRs; cover products with identical functions, technical performances and use (e.g. identical declared/functional units); have equivalent system boundaries and descriptions of data; apply equivalent data quality requirements, methods of data collection, and allocation methods; apply identical cut-off rules and impact assessment methods (including the same version of characterisation factors); have equivalent content declarations; and be valid at the time of comparison. For further information about comparability, see EN 15804 and ISO 14025.

Company information

Atkore
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Description of the organisation: Atkore is a leading manufacturer of electrical and critical infrastructure products for commercial, industrial, data center, telecommunications, water, and solar applications. Significant product categories include metal conduit, plastic conduit, electrical cable and flexible conduit, metal framing, and cable management systems.

Website: <https://www.Atkore.com>

Product-related or management system-related certifications: BS6946:1988¹

Name and location of production site(s):

Minto, Australia
Hamilton, New Zealand
North York, Toronto-Canada
Hobart, IN-USA
Harvey, IL-USA
Phoenix, AZ-USA
Wayne, NJ-USA
West Bromwich, UK

Product information

Product name: Steel strut and fittings products

Product identification: Steel strut and fittings products made of steel.



Figure 1: Steel strut and fittings products

Yield Tensile Strength: 30 ksi min.

Material density: 7861 kg/m³

Product description: Steel metal framing products are offered in a variety of configurations and their associated accessories include fittings, clamps, hangers, and hardware. Applicable regional standards include BS6946:1988¹. They are used in a variety of applications across every industry as an engineered building and support system. Offered as Atkore brands: Unistrut®, Power-Strut®, and Sasco Strut®. Product families included in this study are listed below:

- **15/8" Strut & Fittings**
- **11/4" Strut & Fittings**
- **13/16" Strut & Fittings**
- **Concrete Inserts**
- **Prime Angle**

Further information can be found at <https://www.atkore.com/Products/Strut-and-Fittings>

Steel Strut and Fittings products are produced at 8 sites. For each site, raw materials, packaging, ancillary material, energy consumption and waste production were measured at the factory level.

The EPD is an EPD of multiple products based on the average product in each site and presents results as averages for annual productions from each site having similar productions (having same core material and similar manufacturing processes). The average was calculated as a weighted average based on production volume from each site. Where different products were manufactured in the same site, the inputs and outputs were allocated based on mass. The different products were grouped based on the materials and production processes used.

According to the PCR 2019:14 variance within each site must be less than 10% for all mandatory impact categories. Product groups were organized based on the main material used, therefore the variance within any given site will mainly be associated with processing requirements.

Energy contribution is below 10% for all impact categories, ensuring the difference in impact between the average product and variants of this group is kept below 10%. To evaluate the impact of these in case of variation, a worst-case sensitivity analysis was carried out where energy use was increased by 50% in each site. Results for GWP are <1.5% in all sites. No other impact categories showed variance of more than 10% under this scenario.

UN CPC code: 42190

Geographical scope: Global

LCA information

Declared unit:

The declared unit is **1 kg of average steel strut and fittings products**.

Reference service life:

Not applicable

Time representativeness:

Primary data for the core process was gathered for one year of operation (2023).

Database(s) and LCA software used:

¹ BS 6946:1988 Specification for metal channel cable support systems for electrical installations (en-standard.eu)

The LCA software SimaPro (version 9.5.0.0) was used to build a model for the product systems under investigation using specific and generic inventory data. Primary data used was based on the manufacturer’s specific data inventory. The secondary data was sourced from the LCI database ecoinvent v3.9.1 (cut-off) (ecoinvent, 2020) and Industry data 2.0 (Worldsteel). In addition, SimaPro was used to apply characterization models and factors from the impact assessment methods to generate LCIA results.

Description of system boundaries:

This study is a cradle-to-gate (A1-A3) with modules C1-C4 and module D, carried out based on EN15804+A2 and the relevant PCR 2019:14 version 1.3.4 (Construction Products). The study comprises extraction of raw materials, transportation of raw materials to manufacturing plant, and the manufacturing of the product itself. This also includes the end-of-life of the product and the benefits and loads arising from the product life cycle.

The life cycle stages descriptions are shown below Figure 2. Modules declared, geographical scope, share of specific data (in GWP-GHG indicator) and data variation are presented in Table 1.

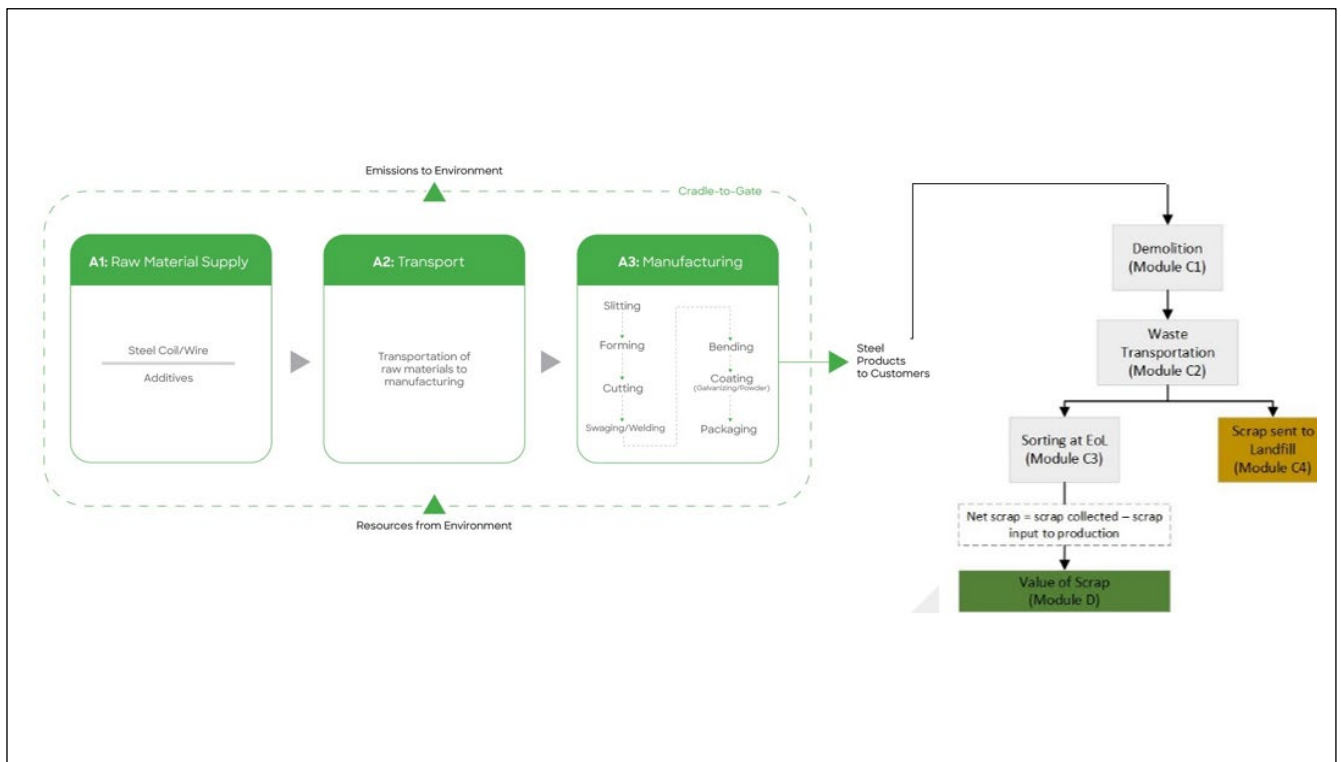


Figure 2 System boundary of the life cycle assessment for steel strut and fittings products

The life cycle stages included within the system boundaries are:

- **A1. Raw materials supply**

- Raw materials extraction and production used for products manufacturing in Atkore sites are included in this module. Raw materials used are steel supplied in coils and wire and additives.

- Generation of electricity and heat from primary energy resources, also including their extraction, refining and transport according to EN 15804 +A2 (BS EN 15804:2012+A2:2019, 2019)²

- **A2. Transport**

This stage includes the transportation of all raw materials, auxiliaries and outbound packaging from suppliers to production site by truck.

- **A3. Manufacturing**

- Packaging of the finished product. Different types of packaging are used: cardboard boxes, steel strapping and seals, nylon, and steel banding.
- Treatment of waste generated from the manufacturing processes up to the end-of-waste state.
- Generation of electricity and heat from primary energy resources, also including their extraction, refining and transport according to ISO 21930 (ISO 21930, 2017)¹

The manufacturing of steel strut and fittings products includes several processes: Slitting, Forming, Cutting, Swaging/Welding, Bending, Galvanizing.

- **C1. Deconstruction and demolition**

Products at the end-of-life are deconstructed manually, and therefore no burdens are applied.

- **C2. Transport to waste processing**

Accounts for transportation of waste e.g. to recycling site or to final disposal.

- **C3. Transport to waste processing**

Sorting, collection, processing of waste fabricated products for the different routes (reuse, recycling, energy recovery, final disposal) at a waste processing facility.

- **C4. Waste disposal**

Final disposal at disposal site, including any required pre-treatment and the management of the disposal facility.

- **D. Potential benefits and loads beyond the system boundary, expressed as net impacts and benefits**

Benefits and burdens associated with recovery/recycling that affects previous or future life cycles.

Cut-off rules:

Exclusions considered in the study:

- Materials contributing less than 1% of mass: Lubricants used in the manufacturing process.
- Specific exclusions
 - Pallets for packaging: pallets are often re-used multiple times and numbers of uses was not always available. Pallets are considered as capital goods.
 - Water consumption for sanitary use and natural gas consumption for office heating.
- General exclusions: processes of infrastructure or capital goods; personal related activities, research and development related activities and maintenance operations.

Assumptions and limitations:

- Gases used in production: production of welding gases (argon and helium) were modelled together with related emissions to air as they do not end up in the final product.

² Results of modules A1-A3 shall be declared in aggregated form in EPD as required by Product Category Rule (PCR, 2019:14). This solves the problem that EN 15804 and ISO 21930 assign some processes (e.g., generation of electricity) to different modules. By declaring modules A1-A3 in aggregated form, the EPD can conform to both EN 15804 and ISO 21930.

- Zinc coating: when mass of zinc coating was provided by Atkore, a conversion to coating surface was done to allow the use of the available dataset (Zinc coating, coils) having 1 square meter as reference flow. The following formula was applied for units' conversion:

$$Area (m^2) = \frac{coating\ weight}{coating\ thickness * density}$$

Where:

- Thickness: 0.13 mm (data provided in the dataset)
- Density: 7,135 kg/m³
- Transport data: when primary data on distance travelled and mode of transport from suppliers to Atkore's site were not available, 100 km by a 16–32-ton EURO 5 truck was assumed.
- Secondary material: as recycled content data were not available as official declaration from suppliers, the Worldsteel dataset was used as representative of global steel production andecoinvent dataset for global aluminium production.
- End-of-life scenarios: end-of-life was modelled based on information from prEN 17662 (prEN 17662 , 2021), considering 90% to recycling and 10% to landfill.

Electricity: Purchased electricity used in the manufacturing process of module A3 has been modelled as residual mix for all sites. The weighted average electricity mix climate impact as GWP-GHG indicator is 0.337 kg CO₂ eq./kWh.

Allocation:

Mass allocation was used in preference to economic allocation to assign energy and packaging to specific product groups within each site.

Most sites produce several types of products with several different materials belonging to the same category. While raw materials and waste were provided in specific product groups (e.g., steel for steel strut and fittings products), energy consumption and outbound packaging were available at plant level. Therefore, allocation was used to assign energy and packaging to the specific product groups.

In the case of end-of-life allocation of generic data, the ecoinvent v3.9.1 with a cut-off by classification end-of-life allocation method was used. In this approach, environmental burdens and benefits of recycled/reused materials are given to the product system consuming them, rather than the system providing them, and are quantified based on recycling content of the material under investigation.

In the case of end-of-life allocation of generic data, the ecoinvent v3.9.1 with a cut-off by classification end-of-life allocation method was used.

For module D, there was no consideration of scrap inputs that have undergone co-product allocation (e.g. for pre-consumer scrap). Co-product allocation for scrap from manufacturing process (module A3) was not conducted as scrap is sent to off-site recycling.

In the case of end-of-life allocation of generic data, the ecoinvent v3.9.1 with a cut-off by classification end-of-life allocation method was used.

Data quality:

Data quality has been assessed using the quality matrix adapted from Weidema et al. (2013). Data quality indicators were applied whereby key data were assigned scores between 1 (best) and 5 (worst). Data quality value obtained is 3.14.

Modules declared, geographical scope, share of specific data (in GWP-GHG results) and data variation (in GWP-GHG results):

Table .1 Description of the system boundary according to the PCR

	Product stage			Construction process stage		Use stage							End of life stage				Resource recovery stage
	Raw material supply	Transport	Manufacturing	Transport	Construction installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
Module	A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Modules declared	x	x	x	ND	ND	ND	ND	ND	ND	ND	ND	ND	x	x	x	x	x
Geography	AUS, BE,NZ, USA, UK	AUS, BE,NZ, USA, UK	AUS, BE,NZ, USA, UK	-	-	-	-	-	-	-	-	-	GLO	GLO	GLO	GLO	GLO
Specific data used	3.56%			-	-	-	-	-	-	-	-	-	-	-	-	-	-
Variation – products	<10%			-	-	-	-	-	-	-	-	-	-	-	-	-	-
Variation – sites	1% / -37%			-	-	-	-	-	-	-	-	-	-	-	-	-	-

Key: X: included in LCA; ND: module not declared; NR: module not relevant

Content information

Product components	Weight, (%)	Weight range, (%)	Post-consumer material, weight-%	Weight biogenic carbon, kg C/kg	Weight biogenic carbon, Kg CO ₂ eq./DU
Steel	29.9%	9%-100%	5%	0	0
Galvanized steel	69.7%	0%-100%	8.61%	0	0
Stainless steel	0.26%	0%-4%	0%	0	0
Aluminum	<1%	0%-6%	0%	0	0
Coating	<1%	0%-<1%	0%	0	0
TOTAL	100%		13.61%	0	0
Packaging materials	Weight, (%)	Weight range, (%)	Weight-% (versus the product)	Weight biogenic carbon, kg C/kg	Weight biogenic carbon, Kg CO ₂ eq./DU
Cardboard	65%	34%-99%	0.21%	1.56E-04	5.73E-04
PE film	0%	0%-5%	0.00%	0	0
PP film	23%	0%-60%	0.07%	0	0
PS	2%	0%-6%	0.01%	0	0
Steel	10%	0%-100%	0.03%	0	0
TOTAL	100%		0.60%	1.56E-04	5.73E-04

Dangerous substances from the candidate list of SVHC for Authorisation	EC No.	CAS No.	Weight-% per declared unit
Not applicable	N/a	N/a	N/a

No substance, listed in the Candidate List of Substances of Very High Concern for Authorization under the REACH Regulations are used in this product, either above the threshold limit or above 0.1% (wt/wt).

Results of the environmental performance indicators

This EPD contains environmental information for the declared unit of 1kg of steel strut and fittings products indicator values calculated using the methods specified in EN 15804:2019+A2, covering environmental impact potentials, resource and energy use, and waste generation for all declared modules; the A1 - A3 modules are shown on an aggregated basis.

Disclaimer: The results of modules A1-A3 should not be used without considering the results of module C.

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.

Mandatory impact category indicators according to EN 15804 + A2³

Results per 1 kg of steel strut and fittings products							
Indicator	Unit	A1-A3	C1	C2	C3	C4	D
GWP-fossil	kg CO ₂ eq.	2.70E+00	0.00E+00	1.54E-02	0.00E+00	2.74E-04	-1.38E+00
GWP-biogenic	kg CO ₂ eq.	2.08E-03	0.00E+00	2.21E-06	0.00E+00	1.83E-07	5.99E-04
GWP-luluc	kg CO ₂ eq.	7.47E-04	0.00E+00	5.29E-07	0.00E+00	1.88E-08	-3.11E-05
GWP-total	kg CO ₂ eq.	2.70E+00	0.00E+00	1.54E-02	0.00E+00	2.75E-04	-1.38E+00
ODP	kg CFC 11 eq.	3.29E-09	0.00E+00	2.10E-10	0.00E+00	4.04E-12	-5.07E-12
AP	mol H ⁺ eq.	6.93E-03	0.00E+00	4.50E-05	0.00E+00	2.54E-06	-3.07E-03
EP-freshwater	kg P eq.	3.23E-05	0.00E+00	3.04E-07	0.00E+00	9.61E-09	-4.31E-07
EP-marine	kg N eq.	1.48E-03	0.00E+00	1.66E-05	0.00E+00	1.15E-06	-5.40E-04
EP-terrestrial	mol N eq.	1.54E-02	0.00E+00	1.76E-04	0.00E+00	1.25E-05	-4.74E-03
POCP	kg NMVOC eq.	5.23E-03	0.00E+00	6.31E-05	0.00E+00	3.73E-06	-2.19E-03
ADP-minerals&metals*	kg Sb eq.	1.15E-05	0.00E+00	9.15E-10	0.00E+00	1.13E-11	-3.55E-06
ADP-fossil*	MJ	2.95E+01	0.00E+00	2.05E-01	0.00E+00	3.52E-03	-1.31E+01
WDP*	m ³	-1.07E+01	0.00E+00	2.91E-04	0.00E+00	5.26E-06	-1.71E+01
Acronyms	GWP-fossil = Global Warming Potential fossil fuels; GWP-biogenic = Global Warming Potential biogenic; GWP-luluc = Global Warming Potential land use and land use change; ODP = Depletion potential of the stratospheric ozone layer; AP = Acidification potential, Accumulated Exceedance; EP-freshwater = Eutrophication potential, fraction of nutrients reaching freshwater end compartment; EP-marine = Eutrophication potential, fraction of nutrients reaching marine end compartment; EP-terrestrial = Eutrophication potential, Accumulated Exceedance; POCP = Formation potential of tropospheric ozone; ADP-minerals&metals = Abiotic depletion potential for non-fossil resources; ADP-fossil = Abiotic depletion for fossil resources potential; WDP = Water (user) deprivation potential, deprivation-weighted water consumption						

³ "EN 15804 reference package" is based on EF 3.1 version

* 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.

Additional mandatory and voluntary impact category indicators**

Results per 1 kg of steel strut and fittings products							
Indicator	Unit	A1-A3	C1	C2	C3	C4	D
GWP-GHG ⁴	kg CO ₂ eq.	2.70E+00	0.00E+00	1.54E-02	0.00E+00	2.75E-04	-1.38E+00
Global warming potential ⁵	[kg CO ₂ eq.]	2.63E+00	0.00E+00	1.51E-02	0.00E+00	2.66E-04	-1.34E+00
Ozone layer depletion ⁵	[kg CFC-11 eq.]	2.39E-09	0.00E+00	1.64E-10	0.00E+00	3.14E-12	-4.84E-12
Acidification ⁵	[kg SO ₂ eq.]	5.50E-03	0.00E+00	3.32E-05	0.00E+00	1.76E-06	-2.49E-03
Eutrophication ⁵	[kg PO ₄ --eq.]	5.85E-04	0.00E+00	6.85E-06	0.00E+00	4.10E-07	-1.82E-04
Photochemical oxidant formation ⁵	[kg NMVOC] *	5.07E-03	0.00E+00	6.19E-05	0.00E+00	3.66E-06	-2.16E-03
Global warming potential ⁶	[kg CO ₂ eq.]	2.61E+00	0.00E+00	1.50E-02	0.00E+00	2.64E-04	-1.33E+00
Ozone depletion ⁶	[kg CFC-11 eq.]	3.26E-09	0.00E+00	2.18E-10	0.00E+00	4.19E-12	-7.71E-12
POCP ⁶	[kg O ₃ eq.]	8.56E-02	0.00E+00	9.99E-04	0.00E+00	7.09E-05	-2.69E-02
Acidification ⁶	[kg SO ₂ --eq.]	5.61E-03	0.00E+00	3.96E-05	0.00E+00	2.28E-06	-2.36E-03
Eutrophication ⁶	[kg N] *	4.21E-04	0.00E+00	5.67E-06	0.00E+00	2.18E-07	-7.20E-05

* 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.

** It shall be clear in the EPD that the indicators and characterization methods are from EN15804:2012+A1:2013, but other LCA rules (system boundaries, allocation, etc.) are according to EN 15804:2012+A2:2019; i.e., the results of the "A1 indicators" shall not be claimed to be compliant with EN 15804:2012+A1:2013.

⁴ This indicator accounts for all greenhouse gases except biogenic carbon dioxide uptake and emissions and biogenic carbon stored in the product. As such, the indicator is identical to GWP-total except that the CF for biogenic CO₂ is set to zero.

⁵ The indicator is calculated using the methods specified in EN 15804+A1 and ISO 21930:2017

⁶ The indicator is calculated using the methods specified in ISO 21930:2017 (TRACI 2.1)

Resource use indicators

Results per 1 kg of steel strut and fittings products							
Indicator	Unit	A1-A3	C1	C2	C3	C4	D
PERE	MJ	5.23E-01	0.00E+00	3.01E-04	0.00E+00	2.05E-05	4.12E-02
PERM	MJ	2.85E-02	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
PERT	MJ	5.52E-01	0.00E+00	3.01E-04	0.00E+00	2.05E-05	4.12E-02
PENRE	MJ	3.12E+01	0.00E+00	2.18E-01	0.00E+00	3.74E-03	-1.37E+01
PENRM	MJ	3.16E-02	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
PENRT	MJ	3.12E+01	0.00E+00	2.18E-01	0.00E+00	3.74E-03	-1.37E+01
SM	kg	1.43E-01	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
RSF	MJ	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
FW	m ³	2.00E-02	0.00E+00	1.05E-05	0.00E+00	2.04E-07	-5.99E-03
Acronyms	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 re-sources; 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 indicators

Results per 1 kg of steel strut and fittings products							
Indicator	Unit	A1-A3	C1	C2	C3	C4	D
Hazardous waste disposed	kg	3.22E-05	0.00E+00	1.38E-06	0.00E+00	2.24E-08	2.28E-07
Non-hazardous waste disposed	kg	1.97E-02	0.00E+00	5.39E-05	0.00E+00	9.99E-02	-9.54E-05
Radioactive waste disposed	kg	9.67E-06	0.00E+00	7.35E-09	0.00E+00	2.90E-10	-1.83E-09

Output flow indicators

Results per 1 kg of steel strut and fittings products							
Indicator	Unit	A1-A3	C1	C2	C3	C4	D
Components for re-use	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Material for recycling	kg	4.51E-02	0.00E+00	0.00E+00	9.00E-01	0.00E+00	0.00E+00
Materials for energy recovery	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Exported energy, electricity	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Exported energy, thermal	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

Other environmental performance indicators

Results per 1 kg of steel strut and fittings products							
Indicator	Unit	A1-A3	C1	C2	C3	C4	D
PM	disease inc.	1.09E-07	0.00E+00	1.03E-09	0.00E+00	6.99E-11	-5.20E-08
IR	kBq U-235 eq	1.72E+01	0.00E+00	3.70E-05	0.00E+00	1.30E-06	3.21E+01
ETF-fw	CTUe	9.12E+00	0.00E+00	2.16E-01	0.00E+00	5.78E-03	-1.32E+00
HTP-c	CTUh	1.47E-09	0.00E+00	1.15E-12	0.00E+00	2.51E-14	-5.80E-10
HTP-nc	CTUh	1.19E-08	0.00E+00	1.11E-10	0.00E+00	5.39E-13	1.93E-09
SQP	Pt	1.31E+00	0.00E+00	7.94E-04	0.00E+00	4.15E-03	2.16E-01
Acronyms	PM = Particulate matter emissions; IR = Ionizing radiation, human health; ETF-fw = Eco-toxicity (freshwater); HTP-c = Human toxicity, cancer effects; HTP-nc = Human toxicity, non-cancer effects, SQP = Soil quality potential/ Land use related impacts						

Differences Versus Previous Versions

2024-09-27 Version 1

2024-10-18 Version 1.1

Editorial change: *Corrected name and location of production sites.*

References

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