

In accordance with ISO 14025 and EN 15804:2012+A2:2019

# Spirally Welded Bare Pipes 2

*BF Routed Steel*

*from*

## Borusan Pipe



**PROGRAMME**

The International EPD® System  
[www.environdec.com](http://www.environdec.com)

**EPD REGISTRATION NUMBER**

S-P-04856

**PROGRAMME OPERATOR**

EPD International AB

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**LOCAL OPERATOR**

EPD Turkey

**VALID UNTIL**

2027-08-20



THE INTERNATIONAL EPD® SYSTEM



ENVIRONMENTAL PRODUCT DECLARATIONS



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: [environdec.com](http://environdec.com)



# PROGRAMME INFORMATION

## Programme Information

**Programme** : The International EPD® System  
**Address** : EPD International AB Box 21060 SE-100 31 Stockholm, Sweden  
**Website** : [www.environdec.com](http://www.environdec.com)  
**E-mail** : [info@environdec.com](mailto:info@environdec.com)

## Information about verification and reference PCR:

*CEN standard EN 15804 serves as the Core Product Category Rules (PCR)*

### Product category rules (PCR)

PCR 2019:14 Construction products (EN 15804:A2) Version 1.1

### PCR review was conducted by

The Technical Committee of the International EPD® System. See [www.environdec.com/TC](http://www.environdec.com/TC) 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](http://www.environdec.com/contact).

Independent third-party verification of the declaration and data, according to ISO 14025:2006:

EPD process verification  EPD verification

### Third party verifier

Sunil Kumar  
 SimaPro partners for India & Sri Lanka, SIPL Pvt Ltd

### Approved by

International EPD System Technical Commiee,  
 supported by the Secretariat

Procedure for follow-up of data during EPD validity involves third party verifier:

Yes  No

## LCA Study & EDP Design Conducted by

Semtrio Sustainability Consulting  
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[www.semtrio.com](http://www.semtrio.com)



*Borusan Pipe has the sole ownership, liability, and responsibility for the EPD.*

*EPDs within the same product category but from different programmes may not be comparable. EPDs of construction products may not be comparable if they do not comply with EN 15804. For further information about comparability, see EN 15804 and ISO 14025.*

# COMPANY INFORMATION

## Owner of the EPD

**Borusan Birleşik Boru Fabrikaları San. ve Tic. A. Ş.**  
Ata Mh. Sanayi Cd. No: 54/68 16601  
Gemlik/Bursa

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The first industrial enterprise of one of Türkiye's foremost business conglomerates, the Borusan Group, Borusan Pipe, marked its 65th anniversary in 2023. Since its founding on the first day, Borusan Pipe has continued investing in solutions that create value for its partners with a global vision.

Today, Borusan Pipe continues its global business with more than 2,800 employees and offers more than 4,000 product varieties. Its eleven facilities across three continents and high sales volume have placed it on the map as a leading manufacturer in the steel pipe industry in Europe and the world.

Borusan Pipe brings its experience, expertise, and passion worldwide with state-of-the-art pipes addressing all areas ranging from automotive to construction and energy to machinery production. The company continued its investments with a global perspective following market dynamics. It made its first overseas investment in 2001 when it bought the facility in Vobarno and founded Borusan Vobarno Tubi S.p.A. The company then established Borusan Pipe US Inc. in 2014 to manage its Houston Baytown factory investment in the United States. Borusan Pipe US Inc. achieved success soon thanks to its advanced technology and innovative products. It won the "Best Pipe Manufacturer" award given by one of the most prestigious publications in the United States, the American Metal Market, in 2016, 2017, and 2020. In 2023, within the scope of its strategy to become a local player in global markets, Borusan Pipe acquired Berg Pipe, which produces at the highest quality and largest capacity in the USA

Having entered Türkiye's pioneering overseas investors with these breakthroughs, Borusan Pipe seeks investment opportunities in different countries and aims to boost Türkiye's competitiveness.

In addition to its contributions to our country with its exports to various countries in America, Europe, Africa, and Asia, it is also a driving force for the Turkish economy with the development assurance it gives for the coming years.

Having been ranked among Türkiye's top 100 industrial enterprises for 50 years, Borusan Pipe goes beyond merely manufacturing pipes with its thousands of products, reliable service, quality, and the trails it has blazed in Türkiye and the world and builds Türkiye's future. It delivers a sustainable society with management policies, a developed country, and a secure future with large-scale investments.



## Production Site

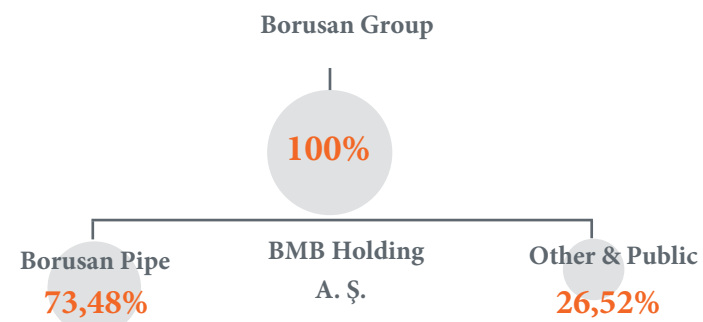
**Gemlik**  
Ata Mah. Sanayi Cad. No: 54/68  
16601 Gemlik/Bursa



- Flagship of Borusan Group with more than 60 years of pipe manufacturing experience
- Workforce of 2,800 people
- 20 years of Contract Management competency
- Has its own port (Borusan Port) adjacent to the mill, which brings operational flexibility in terms of logistics inbound and outbound
- Sole 24.5 m single seam API/ISO/EN large diameter line pipe producer in Europe

### Corporate Structure

BMB Holding A. Ş. owns 73,48% shares of Borusan Pipe and the remainder 26,52% is publicly traded. Borusan Pipe is the first industrial organization the Borusan Group, one of Türkiye's foremost business conglomerates.



# PRODUCT INFORMATION

## Product Name

Spirally Welded Bare Pipes 2

## SPIRALLY WELDED (HSAW) LINE PIPES

### Quality Certificates

- API 5L
- ISO 3183
- AD 2000 W0
- AD 2000 W4
- AD 2000 HP0
- ISO 3834-2
- CSA Z245.1

### Tests & Certificates

- Tensile Test
- Vickers Hardness Test
- Charpy Impact Test
- Weld Bend Test
- DWTT Test
- CTOD Test
- Macro and Micro Examination

- Chemical Analysis Test
- Radiographic Inspection
- Magnetic Particule Inspection
- Liquid Penetration
- Visual and Dimensional Control
- Hydrostatic Test

## Foundation / Piling Tubes

### Sizes

**Outside Diameter:** 508 mm - 3,048 mm

**Wall Thickness:** 5.16 mm - 25.4 mm

**Length:** Single lengths up to 60,0 m

### Coating Standards

- EN 12944 - 5



## SPIRALLY WELDED (HSAW) WATER LINE PIPE

### Quality Certificates

- API 5L
- ISO 3183
- AD 2000 W0
- AD 2000 W4
- AD 2000 HP0
- ISO 3834-2

### Tests

- Tensile Test
- Vickers Hardness Test
- Charpy Impact Test
- Weld Bend Test
- DWTT Test
- CTOD Test
- Macro and Micro Examination
- Chemical Analysis Test
- Radiographic Inspection
- Magnetic Particule Inspection
- Liquid Penetration
- Visual and Dimensional Control
- Hydrostatic Test

### Sizes

#### SPIRALLY WELDED (HSAW) LINE PIPES

**Outside Diameter**  
508 mm - 3,048 mm

**Wall Thickness**  
5.16 mm - 25.4 mm

**Length**  
Single lengths up to 24,50 m

#### SPIRALLY WELDED (HSAW) WATER LINE PIPE

**Outside Diameter**  
508 mm - 3,048 mm

**Wall Thickness**  
5.16 mm - 25.4 mm

**Length**  
Single lengths up to 24.50 m

### Production Standards & Material Qualities

**EN 10219-1**

**ASTM A252**

Grade including S355, J2H, S460 MH, S550 J2H

Grade including Grade 3

## Technical Specifications

Production Standards	Steel Grades
SPIRALLY WELDED (HSAW) LINE PIPES	
API 5L (PSL1 - PSL2)	Up to X80 M
ISO 3183 (PSL1 - PSL2)	Up to L555 M, ME
GOST 20295	Up to K60
SPIRALLY WELDED (HSAW) WATER LINE PIPE	
EN 10217-1	P195 - P265 TR1&TR2
EN 10224	L235 - L355
AWWA C 200	Grade 30 - Grade 50



### LCA Information

**Declared unit**

1 tonne (1000kg) of fabricated steel product manufactured in Gemlik facility (TR).

**Reference service life**

Not applicable

**Time representatives**

The production data in this LCA study represents the period of 1st January 2021 and 30th September 2021.

**Database(s) and LCA software used**

Simpro v9.2 and Ecoinvent v3.7.1

**Description of system boundaries**

Cradle to gate (A1-3) with options, modules C1-C4, module D.

**Data quality and data collection**

According to EN 15804:2012+A2:2019 specific data was used for module A3 (Processes the manufacturer has influence over) and was gathered from Borusan Gemlik plant. Specific data includes actual product weights, amounts of raw materials used, product content, energy consumption, transport figures, water consumption and amounts of wastes. For A1 and A2 modules, according to EN 15804:2012+A2:2019, generic data was applied and was obtained from Ecoinvent v3.7.1

**Allocation**

Mass allocation has been applied for preconsumer recycled materials according to EN 15804:2012+A2:2019.

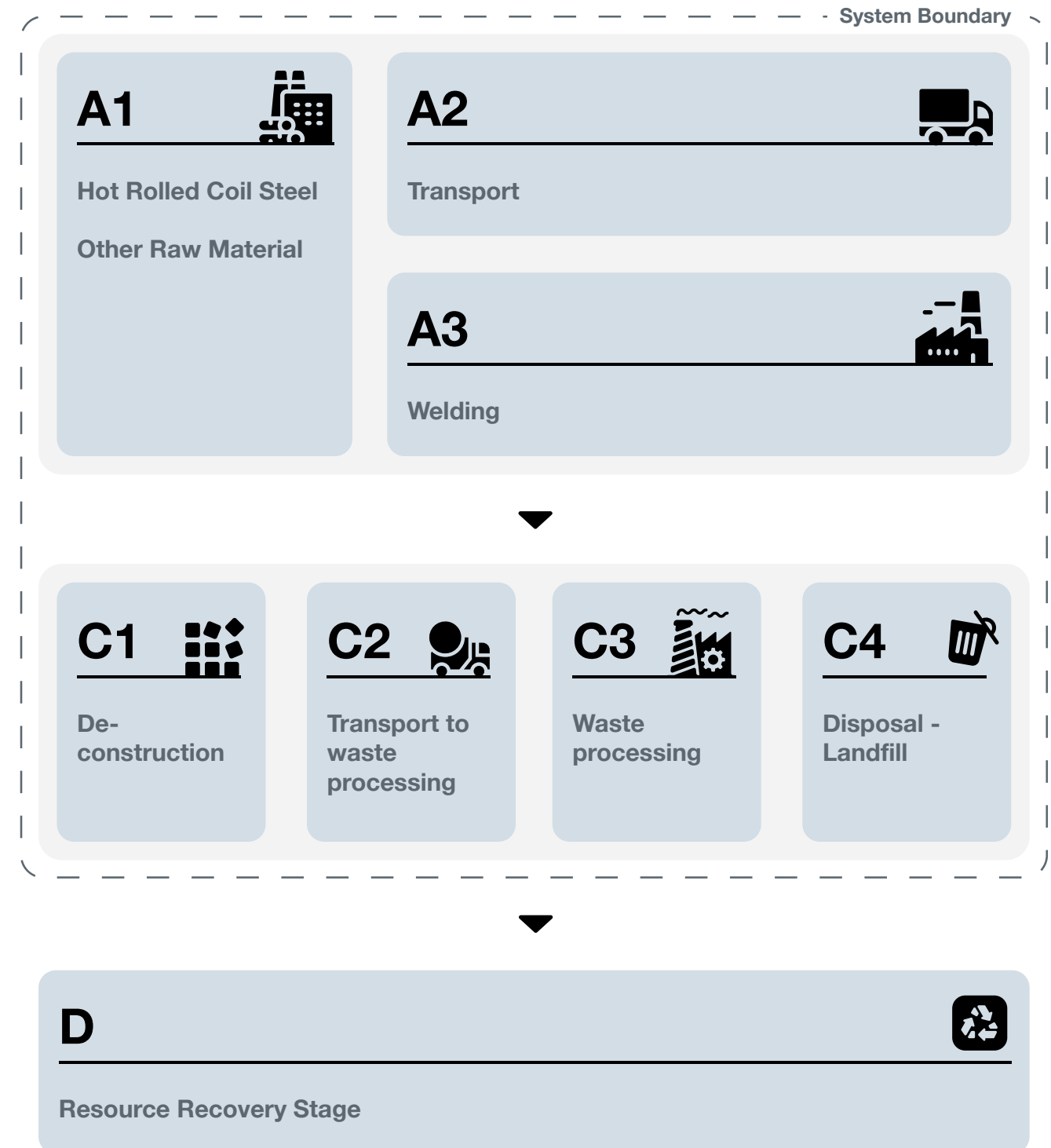
**Cut-off rules**

Life Cycle Inventory data for a minimum of 99% of total inflows to the three life cycle stages have been included and a cut-off rule of 1% regarding energy, mass and environmental relevance was applied. Impacts caused by treatment operations have been calculated lower than 1% environmental relevance.

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

	Product Stage			Construction Process Stage		Use Stage							End of Life Stage				Resource Recovery Stage
	Raw Material Supply	Transport	Manufacturing	Transport from the gate to the site	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational Energy Use	Operational Water Use	De-construction	Transport	Disposal	Waste Processing	Reuse - Recovery - Recycling Potential
Modules	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	GLO	GLO	TR	-	-	-	-	-	-	-	-	-	GLO	GLO	GLO	GLO	GLO
Specific data used	>99.5%			-	-	-	-	-	-	-	-	-	-	-	-	-	-
Variation-products	Not Relevant			-	-	-	-	-	-	-	-	-	-	-	-	-	-
Variation-sites	Not Relevant			-	-	-	-	-	-	-	-	-	-	-	-	-	-

### System Diagram



## Description of Raw Materials

### A1 - Raw Materials Supply

This stage takes into account raw material extraction, processing and energy used in the production process.

### A2 - Transport to the Manufacturer

This stages include transportation of the raw materials from supplier to factory gate. Transportation types are considered as seaway, road, etc.

### A3 - Manufacturing

This stage includes energy and water consumption during the manufacturing process. Additionally, packaging materials are covered by this stage. Followed production processes are as;

- Tape slitting section
- Welding

### C1 - De-construction

The dismantling of steel pipe has a very low impact considering the impact throughout the life of the installation. It is assumed that, in C1 module, same electricity and diesel is consumed as during the construction installation of steel pipe.

### C2 - Transport to Waste Processing

An average distance of 100km has been assumed for the transport to recycling facility. Transport is calculated on the basis of a scenario with the parameters described in the table below.

#### Parameters C2 Module

Transport by road\* Lorry >32 metric ton

Distance (km) 100

Database Ecoinvent v3.7.1

\*Technology is euro 6

### C3 - Waste Processing for Reuse, Recovery and/or Recycling

The material and energy expenses required for Module C3 are negligible. It is assumed that there is no sorting or processing required for steel pipes.

### C4 - Final Disposal

100% of used product after the lifetime will be collected and recycled into the manufacturing system. It is assumed that 5% of the product is lost during de-construction and 95% is reached to recycling system.

### D - Reuse, Recovery or Recycling Potential

Scrap inputs to the production stage are subtracted from scrap to be recycled at end of life in order to obtain the net scrap output from the product system. This remaining net scrap is then delivered to recycling process. Module D reports the environmental aspects of recycled scrap generated at the end of life minus that used at the production stage.

### Information on Which Life Cycle Stages Are Not Considered

This EPD only covers the Cradle to Gate A1-3, C1-4 and D stages because other stages are very dependent on particular scenarios and are better developed for specific building or construction works.

### Content Declaration

Content declaration of 1000kg of Spirally Pipe	
Material	Share
Steel Coil	99.0 - 99.9%
Renewable Material	0%
Biogenic Carbon	0%

\*The product does not content "Candidate List of Substances of Very High Concern (SVHC)" compounds.





# ENVIRONMENTAL PERFORMANCE

## Potential Environmental Impact

Mandatory Indicators According to EN 15804

Results for 1000kg of Spirally Pipe							
Indicator	Unit	A1:A3	C1	C2	C3	C4	D
<b>GWP-fossil</b>	kg CO2 eq	2945	1.28	8.67	0	0.262	-1647
<b>GWP-biogenic</b>	kg CO2 eq	24.2	0.031	0.019	0	8.13E-04	-8.83
<b>GWP-luluc</b>	kg CO2 eq	2.22	1.65E-03	2.53E-03	0	7.12E-05	-0.757
<b>GWP-total</b>	kg CO2 eq	2971	1.31	8.70	0	0.263	-1657
<b>ODP</b>	kg CFC 11eq	1.49E-04	7.22E-08	2.13E-06	0	1.08E-07	-7.34E-05
<b>AP</b>	mol H+ eq	13.6	6.19E-03	0.027	0	2.48E-03	-6.97
<b>EP-Freshwater</b>	kg PO43- eq	1.48	7.86E-04	3.03E-03	0	3.32E-04	-0.750
<b>EP- Aquatic Freshwater</b>	kg P eq	0.144	9.32E-05	6.50E-05	0	2.76E-06	-0.070
<b>EP-Marine</b>	kg N eq	2.80	1.28E-03	6.11E-03	0	8.60E-04	-1.44
<b>EP-Terrestrial</b>	kg N eq	31.2	0.012	0.068	0	9.47E-03	-15.9
<b>POCP</b>	kg NMVOC eq	13.6	4.50E-03	0.027	0	2.75E-03	-7.13
<b>ADP-minerals &amp; metals*</b>	kg Sb eq	0.038	9.24E-06	2.12E-05	0	5.87E-07	-0.024
<b>ADP-fossil*</b>	MJ	31383	18.9	141	0	7.35	-16065
<b>WDP</b>	m3	916	0.995	0.466	0	0.330	-299

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

\* 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.



## Potential Environmental Impact

Additional Mandatory and Voluntary Indicators

Results for 1000kg of Spirally Pipe							
Indicator	Unit	A1:A3	C1	C2	C3	C4	D
<b>GWP-GHG<sup>1</sup></b>	kg CO2 eq	2839	1.23	8.59	0	0.258	-1584
Results for 1000kg of Spirally Pipe							
<b>PM</b>	[disease inc]	1.92E-04	3.89E-07	7.57E-07	0	4.84E-08	-1.20E-04
<b>IRP</b>	[kBq U235 eq]	68.5	0.110	0.620	0	0.030	-27.2
<b>ET-freshwater</b>	[CTUe]	73556	30.8	108.345	0	4.62	-45356
<b>HT-cancer</b>	[CTUh]	1.66E-05	3.57E-08	3.31E-09	0	1.38E-10	-1.00E-05
<b>HT-non-cancer</b>	[CTUh]	6.23E-05	3.17E-08	1.12E-07	0	2.88E-09	-3.67E-05
<b>SQP</b>	[pt]	12876	4.80	162	0	15.4	-7702

Acronyms

**GWP-GHG** = Global Warming Potential total excl. biogenic carbon following IPCC AR5 methodology; **IRP** = Ionizing radiation, human health; **ET-freshwater** = Eco-toxicity (freshwater); **HT-cancer** = Human toxicity, cancer effects; **HT-non-cancer** = Human toxicity, non-cancer effects; **SQP** = Potential soil quality index (SQP)

<sup>1</sup> The indicator includes all greenhouse gases included in GWP-total but excludes biogenic carbon dioxide uptake and emissions and biogenic carbon stored in the product. This indicator is thus equal to the GWP indicator originally defined in EN 15804:2012+A1:2013.

Use of Resources

Results for 1000kg of Spirally Pipe							
Indicator	Unit	A1:A3	C1	C2	C3	C4	D
PERE	kg CO2 eq	3153	2.22	1.72	0	0.059	-1594
PERM	kg CO2 eq	0	0	0	0	0	0
PERT	kg CO2 eq	3153	2.22	1.72	0	0.059	-1594
PENRE	kg CO2 eq	33263	20.0	150	0	7.81	-17000
PENRM	kg CFC 11eq	0	0	0	0	0	0
PENRT	mol H+ eq	33263	20.0	150	0	7.81	-17000
SM	kg N eq	1047	0	0	0	0	0
RSF	kg N eq	0	0	0	0	0	0
NRSF	kg NMVOC eq	0	0	0	0	0	0
FW	kg Sb eq	115	0.170	0.129	0	0.012	-38.3

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 resources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Use of net fresh water



Differences versus Previous Versions

This EPD has been revised to reflect the organizational name change, the renewed company logo and the updated official company website address.



Waste Production

Results for 1000kg of Spirally Pipe							
Indicator	Unit	A1:A3	C1	C2	C3	C4	D
Hazardous waste disposed	kg	5.89	0	0	0	0	0
Non-hazardous waste disposed	kg	0.071	0	0	0	0	0
Radioactive waste disposed	kg	0	0	0	0	0	0

Output Flows

Results for 1000kg of Spirally Pipe							
Indicator	Unit	A1:A3	C1	C2	C3	C4	D
Component for re-use	kg	0	0	0	0	0	0
Materials for recycling	kg	0.154	0	0	0	950	0
Materials for energy recycling	kg	4.88	0	0	0	0	0
Exported energy, electricity	MJ	0	0	0	0	0	0
Radioactive waste disposed	MJ	0	0	0	0	0	0

## REFERENCES

### ISO 14020:2000

Environmental labels and declarations -- General principles

### ISO 14040:2006

Environmental management -- Life cycle assessment -- Principles and framework

### ISO 14044:2006

Environmental management -- Life cycle assessment -- Requirements and guidelines

### ISO 14025:2006

Environmental labels and declarations -- Type III environmental declarations -- Principles and procedures

### EN 15804:2012+A2:2019

Sustainability of construction works - Environmental product declarations - Core rules for the product category of construction product

### The International EPD® System

[www.environdec.com](http://www.environdec.com)

### The International EPD® System The General Programme Instructions v3.01

### The International EPD® System PCR 2029:14 Construction products v1.1 (EN 15804:A2)

### Ecoinvent 3.7.1

[www.ecoinvent.org](http://www.ecoinvent.org)

### SimaPro LCA Software

[www.simapro.com](http://www.simapro.com)

### Borusan Pipe

<https://borusanboru.com/en>

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### Owner of Declaration

Borusan Birleşik Boru Fabrikaları San. ve Tic. A. Ş.

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### LCA Study & EDP Design Conducted By

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