

## Environmental Product Declaration - EPD

Environmental and economic life cycle performance including climate-related data

### MD 150-360 High Pressure Stage Casing Pump

The pump characterized in this EPD is inherently configurable. Configuration and efficiency depends on customer specification. The data given below are illustrative and only valid for the defined parameters (see chapter "Life cycle, coverage, assumptions, and exclusions").

**Main applications:**

Power generation, i.e. boiler feed in industrial power plants and combined cycle power plants.

**Type:**

Horizontal, radially split, centerline mounted, multistage ring section pump. Pump configured according to customer requirements.

**Rated power:**

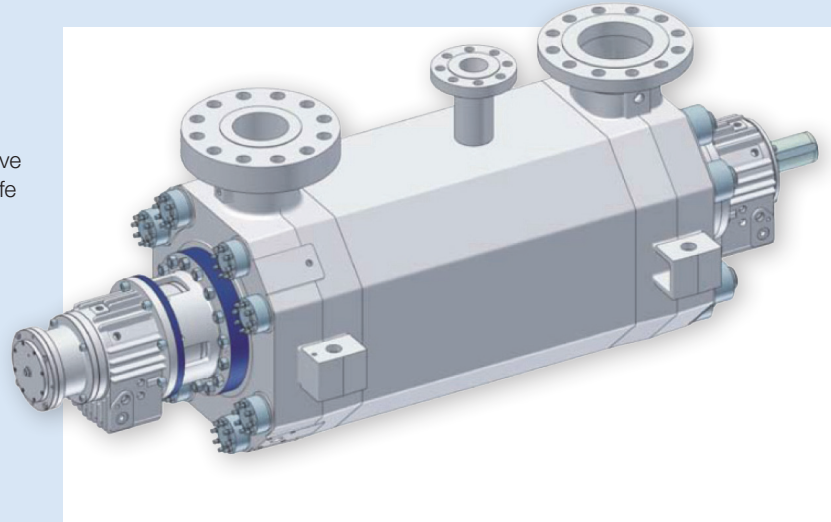
2,300 kW

**Manufacturer:**

Sulzer Pumpen (Deutschland) GmbH, Germany

**CPC classification:**

43220



**Components included:**

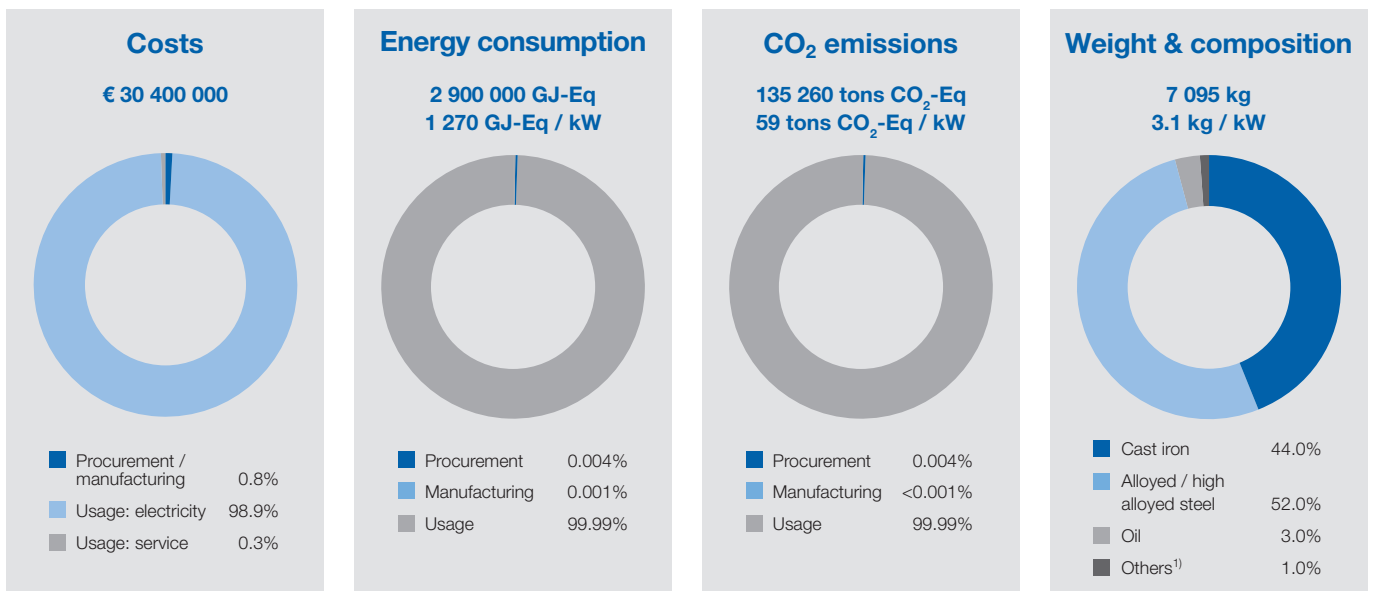
- Pump including casing, baseplate, shaft, impeller, bearings
- Gearbox
- Motor
- Frequency inverter
- Piping system

**Electricity mix considered for usage: Europe (UCTE)**

**Key economic and environmental advantages**

- High availability of more than 98%
- Life-time of 20 years
- High efficiency of the pump means lower energy consumption and emissions
- Frequency inverter would allow flexible and energy-efficient adaptation to the effective power used
- Comprehensive training and professional service enable customers to operate the pump cost and energy-efficiently
- Retrofit service to re-establish the best efficiency point if operating conditions change
- Simple to dismantle, well suited for recycling due to high quantity of high alloyed steels (> 95% by weight) that easily can be separated: metal parts are marked to identify composition.

**Key economic and environmental indicators over life-cycle of 20 years**



<sup>1)</sup> e.g. varnishes, seals

## Functional unit

The functional unit is 1 kW of rated hydraulic power at optimum efficiency.

## Composition of the product

Material	kg	% <sup>1)</sup>	kg / kW <sup>3)</sup>
Cast iron	3 100	44	1.35
Steel (high alloyed)	3 705	52	1.61
Oil	190	3	0.08
Parts not included <sup>2)</sup>	<100	<1.4	<0.04
<b>Total</b>	<b>7 095</b>	<b>100</b>	<b>3.08</b>

The pump consists of 52% alloyed and high alloyed steels and 44% cast iron.

The indicated quantity of oil refers to the initial fill of the pump, the oil is replaced every second year after installation.

Remaining components such as paints and seals amount to less than 1.4% of the total weight and have as such been omitted.

1) By weight. 2) Weight not included in assessment. 3) Rated power.

## Material consumption during life cycle per pump<sup>1)</sup> (material balance sheet)

Non-renewable resources	Procurement <sup>2)</sup>		Manufacturing at Sulzer		Usage / end of life	
	kg	kg / kW	kg	kg / kW	kg	kg / kW
Steel (alloyed), casting			<sup>3)</sup>	<sup>3)</sup>		
for pump	7 100	3.09	6 800	2.96	6 800	2.96
for spare parts	280	0.12	270	0.12	270	0.12
Oil	1 900	0.83	1 900	0.83	1 900	0.83
Waste production (total)	n.a.	n.a.	1 220	0.53	8 970	3.90
Hazardous waste	n.a.	n.a.	150	0.07	1 900	0.83
Municipal waste	n.a.	n.a.	270	0.12	n.a.	n.a.
Recycling (total)	n.a.	n.a.	800	0.35	7 070	3.07
metals (pump)	n.a.	n.a.	300	0.13	6 800	2.96
metals (spare parts)	n.a.	n.a.	10	0.004	270	0.12
others	n.a.	n.a.	490	0.21	n.a.	n.a.
<b>Renewable resources</b>	<b>kg</b>	<b>kg / kW</b>	<b>kg</b>	<b>kg / kW</b>	<b>kg</b>	<b>kg / kW</b>
Wood (packaging)	370	0.16	360	0.16	360	0.16
Water consumption <sup>4)</sup>	n.a.	n.a.	30 700	13.3	n.a.	n.a.

n.a.: not available, values per kW related to 2 300 kW rated power.

1) Material resources related to supply of energy to site are not considered.

2) Covers all resources procured during the life cycle by Sulzer, including the oil used to operate the pump.

3) Machining during the manufacturing produces recyclable waste of around 4% by mass of the metals bought in.

5) In manufacturing: used for testing purposes.

## Primary energy consumption during life cycle (primarily from usage / end of life)

	Procurement <sup>2)</sup>		Manufacturing at Sulzer		Usage / end of life <sup>3)</sup>		Total	
	GJ-Eq	GJ-Eq/kW	GJ-Eq	GJ-Eq/kW	GJ-Eq	GJ-Eq/kW	GJ-Eq/	GJ-Eq/kW
Electricity	94.6	0.041	<sup>6)</sup>	<sup>6)</sup>	2 913 322	1 267	2 913 416	1 267
Gases <sup>1)</sup>	7.0	0.003	<sup>6)</sup>	<sup>6)</sup>	0	0	7.0	0.003
Fuel oils	32.6	0.014	<sup>6)</sup>	<sup>6)</sup>	0	0	32.6	0.014
Materials	514	0.22	0	0	0	0	514	0.22
Transports	6.6	0.003	19.2	0.008	459	0.20	484	0.21
Disposal, waste water <sup>7)</sup>	n.a.	n.a.	0.4	<0.001	-214	-0.09	-214	-0.09
<b>Non-renewable energy sources<sup>5)</sup></b>	<b>594</b>	<b>0.258</b>	<b>19.3</b>	<b>0.008</b>	<b>2 734 659</b>	<b>1 189</b>	<b>2 735 273</b>	<b>1 189</b>
<b>Total renewable energies<sup>4) 5)</sup></b>	<b>61</b>	<b>0.026</b>	<b>0.3</b>	<b>&lt;0.001</b>	<b>178 907</b>	<b>78</b>	<b>178 968</b>	<b>78</b>
<b>Total energy sources<sup>5)</sup></b>	<b>655</b>	<b>0.29</b>	<b>19.5</b>	<b>0.009</b>	<b>2 913 566</b>	<b>1 267</b>	<b>2 914 241</b>	<b>1 267</b>

1) Natural gas, butane, propane. 2) Including transportation to Sulzer (< 1%).

3) Including transportation to customer (< 1%).

4) Hydro power, solar power, wind power, biomass.

5) Including waste and waste water treatment. 6) Fully allocated to procurement.

7) Including credit from recycling of pump at end of life-time.

Eq: equivalents, kW related to 2 300 kW rated power.

The pump is used in Europe, the European energy mix was applied (UCTE mix).

## Emissions during life cycle (primarily from usage / end of life)

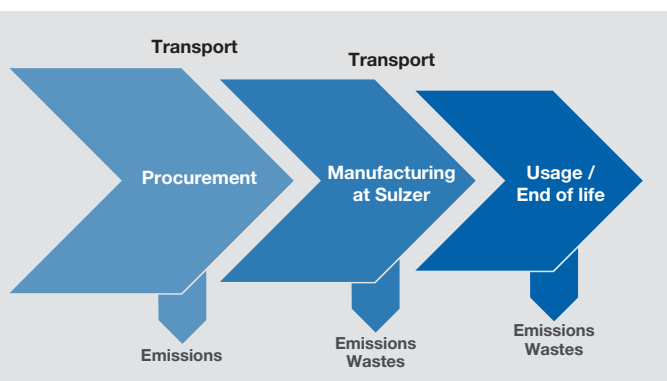
	Procurement		Manufacturing at Sulzer		Usage / end of life <sup>1)</sup>		Total	
	t	kg / kW	t	kg / kW	t	kg / kW	t	kg / kW
Greenhouse Gas Potential (CO <sub>2</sub> -equivalents)	25.4	11.06	1.37	0.60	135 232	58 797	135 259	58 808
Acidification potential (SO <sub>x</sub> -equivalents - AP)	1.8	0.768	0.051	0.022	2 192	953	2 194	954
Photosmog potential (ethylene equivalents)	0.005	0.002	<0.001	<0.001	5.4	2.34	5.4	2.34
Ozone depleting potential (CFC11-equivalents) <sup>2)</sup>	<0.001	<0.001	<sup>3)</sup>	<sup>3)</sup>	0.007	0.003	0.007	0.003
Biological Oxygen Demand (O <sub>2</sub> -equivalents)	0.05	0.023	n.a.	n.a.	51.9	22.6	52.0	22.6

n.a.: not available, kW related to 2 300 kW rated power. 1) Emissions are dominated by emissions in usage caused by electricity consumption.

2) Ozone depleting substances are not in use at the manufacturing site. 3) No related substances used in production.

### Life-cycle – coverage, assumptions, and exclusions

**System boundary:** The EPD covers all relevant environmental aspects in relation to the life cycle phase diagram below.



The construction of buildings, production machinery and transport infrastructure are all excluded.

Manufacturing and usage of the motor, frequency inverter, and the piping used to operate the pump are excluded from the functional unit.

**Procurement** includes the extraction of raw materials and production of semi-finished products, consumables, and energy by suppliers. Production data were converted into environmental effects via factors from the Ecolnvent Database; based on the component parts for this product as assembled by Sulzer.

The consideration of externally sourced parts has been limited to the casing, baseplate, shaft, impeller, motor, gearbox, and bearings; which together account for over 99% of the product weight.

Due to low masses or rates of usage, small components such as solvents, varnishes and plastics (for e.g. seals) have not been included.

**Manufacturing at Sulzer** covers all product manufacturing activities undertaken at the manufacturing site including engineering, welding, grinding, machining, painting and assembly. Data used are drawn from the yearly Sulzer SEED data collection which includes energy (e.g. electricity, natural gas, butane, propane, fuel oils, district heating, coal and coke etc.) water consumptions and waste water, emissions to air and waste production. The energy used includes both manufacturing and on-site office activities. The emissions to air from the use of paints and solvents are included, however related consumption of the varnishes and paints are excluded. The environmental burden from waste and wastewater treatment has been calculated using factors from the Ecolnvent Database.

The pump is assembled in Germany, and the mean European Union emissions factor for the electricity generating mix has been applied.

The packaging of the pump for transportation to the customer is a wooden crate, which has been included.

**Usage / end of life** includes the usage and servicing of the product. It includes the production and disposal of spare parts and of oil.

The motor and frequency inverter are not part of the system. The electricity consumption of the pump has therefore been calculated assuming an efficiency of both to 100%.

The pump is used in Europe, the European energy (UCTE) mix was assumed. The price for electricity applied is € 0.10.

The yearly costs for maintenance are set at 2% of the purchase price of the pump, and the assumed average increase in prices is at 2% per year.

4% of the total weight of the pump is typically replaced during the lifetime and includes bearings, seals, impeller, and wearing rings.

For recycling purposes, a credit of 50% of the initial materials burden to produce the pump has been assumed.

Costs and effects of dismantling are not considered and are assumed minor compared with the usage phase. Monetary benefits through selling the pump as scrap have not been considered, as the lifetime of the product is too long to make a robust estimate).

Spent oil is disposed as hazardous waste and incinerated accordingly; its environmental effects have been calculated based on factors from the Ecolnvent Database.

**Transportation** to Sulzer (depending on the location of the supplier, variously by truck, train, ship or airplane) is included in the procurement phase. Transportation to the customer following the manufacturing phase is by truck, and transportation for service activities in usage is by van for service at the customer site, or by truck if the pump is serviced at Sulzer's site. Transportation of the dismantled pump at the end of its working life is not considered.

**Allocation:** For manufacturing, data collected on the annual consumption of energy and water, emissions to air, waste water and waste production (from SEED) have been divided by the total number of pumps produced by the site to estimate the resource consumption per pump. For procurement and usage all resources, emissions, and wastes have been fully allocated to the pump.

**Referenced period for underlying data:** Data taken from the Sulzer SEED database and Ecolnvent database origin from the year 2009.

## Applied load levels of pump during life cycle

The applied load levels are summarized in the table below. The pump is operated in three sequential load level phases that differ in duration, yearly operating hours, efficiency, and power consumption. A frequency inverter drive allows a flexible end energy efficient adaptation to the effective power used. The total life-time of a pump is specified by the customer, the distribution of operational load levels across the three categories is based on expert knowledge at Sulzer Pumps.

	Duration of phase	Operating hours per year	Efficiency $\eta$	Power consumption
Phases of load level	years	hours / year	%	kW
Phase 1: full load	10	8 000	81.5%	2 300
Phase 2: middle load	5	5 000	79%	2 000
Phase 3: low load	5	3 000	70%	1 620

## Glossary

**Life cycle assessment, LCA** is a management tool for appraising and quantifying the total environment impact of products or activities during the entire life cycle.

**Life cycle costs** are based on LCAs and cover the total costs of a product during the entire life cycle from the extraction of resources to the disposal of the product.

A **Functional Unit** is a concept that is used to compare the life cycle costs of different products on a like-for-like basis.

**CPC** (Central Product Classification) is a UN-based scheme for statistical division of product categories and service types.

**Ecolnvent Database** contains international industrial life cycle inventory data.

**Acidification** occurs through deposition of soluble sulphur and nitrogen compounds from agricultural and combustion processes. Acidification can be harmful to sensitive ecosystems.

**Eutrophication** is the often anthropogenic enrichment of bodies of water by nitrates and phosphates. This increases the growth of aquatic plants that deoxygenate water and outcompete other aquatic life.

**Global warming potential, GWP** is the potency of 1 kg of a gas as a radiative forcing agent relative to an emission of 1 kg of carbon dioxide over 100 years.

**Ozone depletion potential, ODPs** are calculated as the change that would result from the emission of 1 kg of a substance compared to that from the emission of 1 kg of CFC-11 (trichlorofluoromethane).

**Photochemical ozone creation potential, POCP** refers to the change in of ground level ozone concentration potentially caused by the emission of 1 kg of a gas compared to that from the emission of 1 kg of ethene.

**SEED** is the database that Sulzer uses to collect, validate, and report on social, economic, and ecological data.

## Sulzer Pumps

Sulzer Pumps is a world leader in reliable products and innovative pumping solutions. The global network of modern manufacturing and packaging facilities together with sales offices, service centres and representatives located close to major markets provide fast responses to customer needs.

Sulzer Pumps has a long history of providing innovative pumping solutions to business partners in the following industries: Oil and Gas, Hydrocarbon Processing, Pulp and Paper, Power Generation, General Industry, Chemical Process Industry, Water and Wastewater

All manufacturing sites operate business man-agements systems certified to ISO 9001, ISO 14001, and OHSAS 18001.

## Sustainability program of Sulzer

Sustainability is a key factor for the success of Sulzer.

The company is committed to creating long term economic value, while proactively assuming its social and environmental responsibility. Sulzer continuously assesses its sustainability activities. Extensive programs have been initiated to meet the expectations of Sulzer's stakeholders.

## Applied standards and limitations

The document was prepared based on the EPD General Program Instructions, the PCR for pumps for liquids, liquid elevators and mixers (4322), and the ISO 14025:2010 standard.

Environmental product declarations from different programs with different product category rules may not be comparable.

## Verification

The EPD has been externally verified by Atkins Ltd, United Kingdom. The verification was undertaken in two sections; a review of the relevant documentation followed by a review of underlying data using a combination of a desk based review, a site visit and information exchange with Sulzer. This EPD has been verified against the updated PCR for Pumps for Liquids; Liquid Elevators and Mixers (CPC Class 4322), valid until 2014-12-05.

## References

Environmental labels and declarations – Type III environmental declarations – Principles, EN ISO 14025:2010, Berlin 2010

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Wuppertal Institut für Klima, Umwelt Energie GmbH (2008): Stahl – ein Werkstoff mit

Innovationspotenzial, Ergebnisse des ‚Zukunftsdialogs Rohstoffproduktivität und Ressourcenschonung‘, June 2008

Further information about products of Sulzer Pumps can be found at: [www.sulzerpumps.com/products](http://www.sulzerpumps.com/products)

This and other EPDs are available online at: [www.sulzer.com/sustainability](http://www.sulzer.com/sustainability).

Further information about Sulzer: [www.sulzer.com](http://www.sulzer.com)

Further information about the Sulzer sustainability program: [www.sulzer.com/sustainability](http://www.sulzer.com/sustainability)

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