

Environmental Product Declaration - EPD

Environmental and economic life cycle performance including climate-related data

ME 250-350 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 fossil fired power stations.

Type:

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

Rated power:

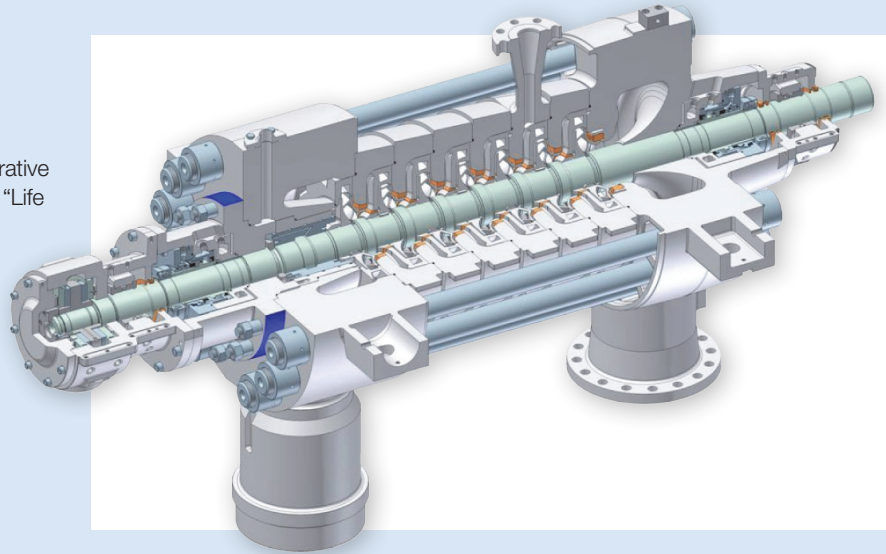
10,700 kW

Manufacturer:

Sulzer Pumpen (Deutschland) GmbH, Germany

CPC classification:

43220



Components included:

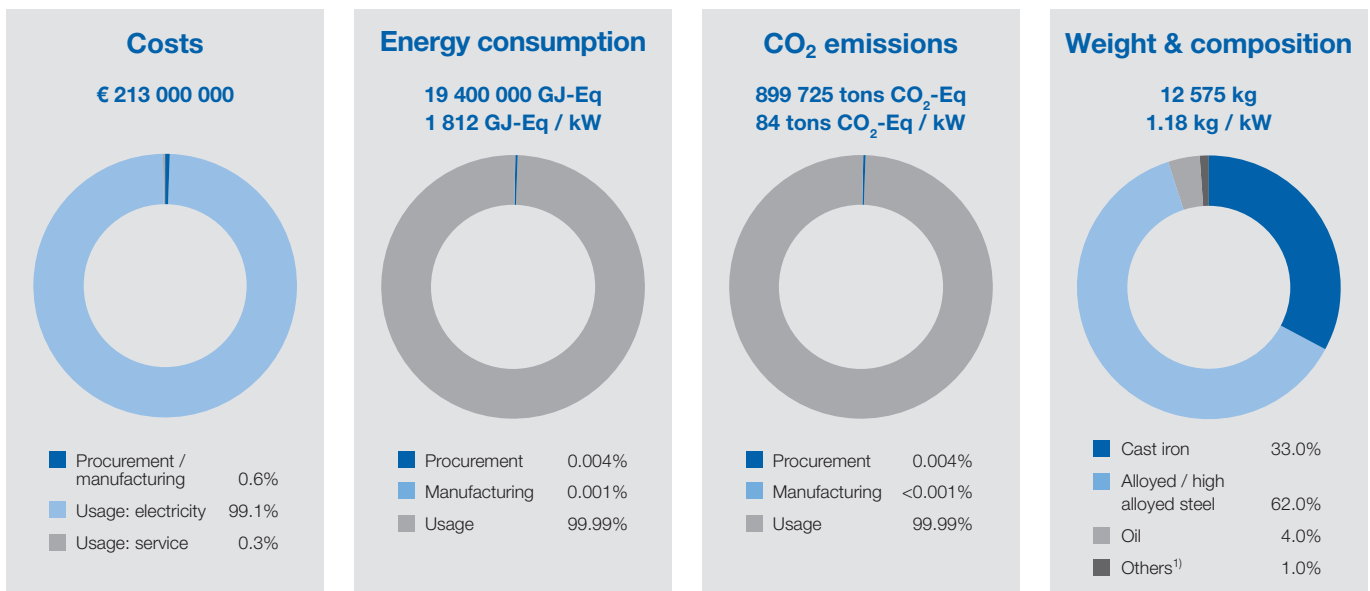
- Pump including casing, baseplate, shaft, impeller, bearings
- Gearbox
- Motor
- Frequency inverter
- Piping system

Electricity mix considered for usage: Europe (UCTE)

Key economic and environmental advantages

- High availability of more than 98%
- Life-time of 30 years
- High efficiency of the pump means lower energy consumption and emissions
- Frequency inverter allows 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 30 years



¹⁾ 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	% ¹⁾	kg / kW ³⁾
Cast iron	4 200	33	0.39
Steel (high alloyed)	7 795	62	0.73
Oil	480	4	0.04
Parts not included ²⁾	<100	<0.8	<0.01
Total	12 575	100	1.18

The pump consists of 62% alloyed and high alloyed steels and 33% 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% 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 pump¹⁾ (material balance sheet)

Non-renewable resources	Procurement ²⁾		Manufacturing at Sulzer		Usage / end of life	
	kg	kg / kW	kg	kg / kW	kg	kg / kW
Steel (alloyed), casting			³⁾	³⁾		
for pump	12 500	1.17	12 000	1.12	12 000	1.12
for spare parts	500	0.05	480	0.04	480	0.04
Oil	8 200	0.77	8 200	0.77	8 200	0.77
Waste production (total)	n.a.	n.a.	1 220	0.11	20 680	1.93
Hazardous waste	n.a.	n.a.	150	0.01	8 200	0.77
Municipal waste	n.a.	n.a.	270	0.03	n.a.	n.a.
Recycling (total)	n.a.	n.a.	800	0.07	12 480	1.17
metals (pump)	n.a.	n.a.	500	0.05	12 000	1.12
metals (spare parts)	n.a.	n.a.	20	0.002	480	0.04
others	n.a.	n.a.	280	0.03	n.a.	n.a.
Renewable resources	kg	kg / kW	kg	kg / kW	kg	kg / kW
Wood (packaging)	370	0.03	360	0.03	360	0.03
Water consumption ⁴⁾	n.a.	n.a.	30 700	2.9	n.a.	n.a.

n.a.: not available, values per kW related to 10 700 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.

4) In manufacturing: used for testing purposes.

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

	Procurement ²⁾		Manufacturing at Sulzer		Usage / end of life ³⁾		Total	
	GJ-Eq	GJ-Eq/kW	GJ-Eq	GJ-Eq/kW	GJ-Eq	GJ-Eq/kW	GJ-Eq/	GJ-Eq/kW
Electricity	94.6	0.009	⁶⁾	⁶⁾	19 383 797	1 812	19 383 891	1 812
Gases ¹⁾	7.0	<0.001	⁶⁾	⁶⁾	0	0	7.0	<0.001
Fuel oils	32.6	0.003	⁶⁾	⁶⁾	0	0	32.6	0.003
Materials	1 329	0.12	0	0	0	0	1 329	0.12
Transports	14.3	0.001	33.5	0.0031	815	0.08	863	0.08
Disposal, waste water ⁷⁾	n.a.	n.a.	0.4	0.00003	-310	-0.03	-309	-0.03
Non-renewable energy sources⁵⁾	1 367	0.128	33.3	0.0031	18 193 823	1 700	18 195 223	1 700
Total renewable energies^{4) 5)}	111	0.010	0.5	<0.001	1 190 479	111	1 190 590	111
Total energy sources⁵⁾	1 477	0.138	33.8	0.0032	19 384 302	1 812	19 385 813	1 812

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 10 700 kW rated power.

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

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

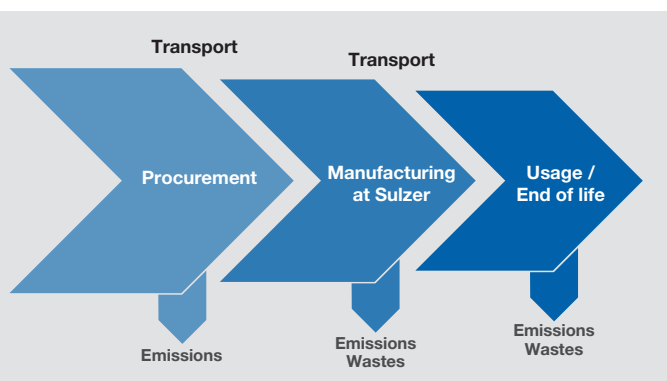
	Procurement		Manufacturing at Sulzer		Usage / end of life ¹⁾		Total	
	t	kg / kW	t	kg / kW	t	kg / kW	t	kg / kW
Greenhouse Gas Potential (CO ₂ -equivalents)	43.4	4.05	2.22	0.21	899 680	84 082	899 725	84 086
Acidification potential (SO _x -equivalents - AP)	3.5	0.32	0.10	0.009	14 583	1 363	14 586	1 363
Photosmog potential (ethylene equivalents)	0.008	0.001	<0.001	<0.001	35.7	3.34	35.7	3.34
Ozone depleting potential (CFC11-equivalents) ²⁾	<0.001	<0.001	³⁾	³⁾	0.05	0.004	0.05	0.004
Biological Oxygen Demand (O ₂ -equivalents)	0.09	0.009	n.a.	n.a.	345	32.2	345.1	32.3

n.a.: not available, kW related to 10 700 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 transport 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 η	Power consumption
Phases of load level	years	hours / year	%	kW
Phase 1: full load	15	8 000	85%	10 700
Phase 2: middle load	10	6 000	82%	5 910
Phase 3: low load	5	4 000	84.5%	4 000

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

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Further information about products of Sulzer Pumps can be found at: www.sulzerpumps.com/products

This and other EPDs are available online at: www.sulzer.com/sustainability.

Further information about Sulzer: www.sulzer.com

Further information about the Sulzer sustainability program: www.sulzer.com/sustainability

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