Environmental Product Declaration

Seamless Steel Structural Tube

BASED ON:
PCR 2012:01
version 2.3
Construction products and construction services

EN 15804:2012
ISO 14025

REGISTRATION N°:
S-P-01239

DATE OF REVISION:
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VALID UNTIL:
2024/02/19

LATIN AMERICA
General information

EPD® REFERENCES

EPD OWNER: TENARIS S.A. - 29 AVENUE DE LA PORTE-NEUVE, L2227- LUXEMBOURG

PROGRAMME: THE INTERNATIONAL EPD® SYSTEM, www.environdec.com
EPD registered thorough the fully aligned regional programme/hub: EPD LATIN AMERICA, www.epdlatinamerica.com

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Mexico: Av. Convento de Actopan 24 Int. 7A, Colonia Jardines de Santa Mónica, Tlalnepantla de Baz, Estado de México, México

INDEPENDENT VERIFICATION

EPD document valid worldwide, according to sales market conditions

CEN standard EN 15804 served as the core PCR (PCR 2012:01, Construction products and construction services, version 2.3, 2018-11-15) PCR review was conducted by the Technical Committee of the International EPD® System.

Independent verification of the declaration and data, according to EN ISO 14025:2010

Third party verifier: Claudia A. Peña. ADDERE Research & Technology
Approved EPD verifier, cpena@addere.cl, claudia@ped-amricalatina.com

Accredited by: The International EPD® System

Environmental declaration published within the same product category, through originating from different programs, may not be comparable. EPDs of construction products may not be comparable if they do not comply with EN 15804. EPD owner has the sole ownership, liability, and responsibility for the EPD.

CONTACTS

Tenaris Corporate is available to release an Environmental Product Declaration for one specific product if requested by the customer

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Tenaris Group

Tenaris is a leading supplier of tubes and related services for world energy industry, construction and other industrial applications worldwide.

The mission is to deliver value to customers through product development, manufacturing excellence and supply chain management.

A global leader around the world is committed to continuous improvement by sharing knowledge across a single global organization. All of manufacturing facilities share a unified global quality policy and have QHSE Policy, ISO 9001, ISO 14001 and OHSAS 18001 certifications.

The Tenaris industrial center in Mexico is TenarisTamsa. It is one of the largest in the world in the manufacture of steel tubes for the energy industry and others with an annual global production capacity of 1.2 million tons of seamless steel.

In its segment of mechanical and structural tubes, tubular products produced are used in standard mechanical engineering applications, as well as in civil and industrial installations, and for the manufacture of earthmoving machinery, architectural structures, non-oil drilling systems, among other.

The structural tube, object of this study, is a product for civil structure with characteristics and specific mechanical properties for its final application.

This EPD is representative for seamless steel structural tubes used in the construction industry manufactured in TenarisTamsa (Mexico) during 2017. Primary data come from TenarisTamsa production site and cover a range of outside diameters. Life Cycle Inventory was produced for the reference product produced for year 2017.

TAMSA-MEXICO

Core business: seamless steel tubes for energy industry.
Production capacity: 1 230 000 tons of seamless steel tubes.
Main features: 1 steel shop, 3 rolling mills.
Certifications: Clean Industry, ISO 9001, ISO 14001 and OHSAS 18001
Tenaris Group

Tenaris produces a large range of dimensions in tubular structural hollow sections. This EPD is representative for Tenaris seamless steel structural tubes in different steel grades, for use in construction with applications in civil structures including stadiums, bridges, airports, hangars, commercial buildings among others that require light structures to sustain high loads. Its properties of compression, traction and buckling capacity, combined with the use of different materials, allow different shapes, colors, uses and sizes, ideal for design. The size of the product is based on the requirements of the project.

Due to excellent mechanical characteristics, very good weldability and geometric tolerances, steel tube for engineering applications are ideal for those types of constructions where light weight, high load-bearing structures with a contained overall weight are required.

Steel can be reused many times without losing its properties. Tenaris structural tube has a high content of recycled material thereby energy efficiency and environmental impact are favored.

The range of dimensions of the structural tube is wide, the measurements of wall thickness fluctuate from 4 to 10 mm and the size of the external diameters from 48.3 to 711 mm, in accordance with the ranges established in the standard EN 10210-2.

This Environmental Product Declaration (EPD) is in accordance with ISO 14025 and EN 15804. EPD of constructions products may not be comparable if they do not comply with EN 15804 Sustainability of constructions works – Environmental product declarations – Core rules for product category of construction products.
Scope and type of EPD®

The approach of this EPD is from the cradle to gate, as system boundary. Excluded lifecycle stages are construction process, use and end-of-life.

### TABLE OF MODULES

<table>
<thead>
<tr>
<th>PRODUCT STAGE</th>
<th>CONSTRUCTION PROCESS STAGE</th>
<th>USE STAGE</th>
<th>END OF LIFE STAGE</th>
<th>BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARIES</th>
</tr>
</thead>
<tbody>
<tr>
<td>Raw material supply</td>
<td>Transport</td>
<td>Manufacturing</td>
<td>Transport from the gate to the site</td>
<td>Assembly</td>
</tr>
<tr>
<td>A1</td>
<td>A2</td>
<td>A3</td>
<td>A4</td>
<td>A5</td>
</tr>
<tr>
<td>X</td>
<td>X</td>
<td>X</td>
<td>MND</td>
<td>MND</td>
</tr>
</tbody>
</table>

**SOFTWARE:** SimaPro ver. 8.3.00  
**MAIN DATABASE:** Ecoinvent 3.3  
**REPORT LCA:** Life Cycle Assessment applied to seamless steel structural tube for EPD® purposes  
**GEOGRAPHICAL SCOPE OF THE EPD:** World according to sales market conditions  
**TYPE OF EPD:** Representative for one ton of seamless steel structural tube  

**CAPTION**  
MND = Module Not Declared
## Detailed product description

### PRODUCT COMPOSITION

<table>
<thead>
<tr>
<th></th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>32.5%</td>
<td>IRON</td>
</tr>
<tr>
<td>67.4%</td>
<td>STEEL SCRAP</td>
</tr>
</tbody>
</table>

### INFORMATION |
### DESCRIPTION |

<table>
<thead>
<tr>
<th>PRODUCT IDENTIFICATION</th>
<th>Seamless steel structural tube</th>
</tr>
</thead>
<tbody>
<tr>
<td>PRODUCT FEATURES</td>
<td>OD range from 48.3 to 711 mm and WT from 4 to 10 mm.</td>
</tr>
<tr>
<td>PRODUCT PROPERTIES</td>
<td>Steel grades and properties according to international standard EN 10210-1 and customer requirements</td>
</tr>
<tr>
<td>MANUFACTURING PLANT</td>
<td>TenarisTamsa</td>
</tr>
</tbody>
</table>

None of the content of this product is in the "Candidate List of Substances of Very High Concern".
General Facturing Specification
Detail Product Description

STEEL SHOP
Furnaces in steel shop are loaded mostly by pre-selected scrap, pig iron and hot briquetted iron. Metallic charge is melted by an electric arc and by the use of chemical energy coming from natural gas, coal and oxygen. Once the slag has been removed the liquid steel at a temperature of around 1,650°C is poured into the ladle. In the ladle furnace argon bubbling, addition of ferroalloys and temperature recovering operations are carried out. Continuous casting transforms liquid steel into round section solid bars for subsequent rolling. All production processes in the steel shop are controlled by an integrated system including the furnace power management, the furnace fumes emissions, the addition of ferroalloys to reach the required chemical composition, and the control of the casting parameters until the cut-to-length of the bars.

MANDREL ROLLING
After passing through a rotary hearth furnace, the bars are transferred to the hot rolling mill in order to carry out the piercing process, thickness rolling and diameter sizing. The piercing process transforms the hot bar into a hollow. The bar turns due to the movement of two skewed opposing rollers. As a result of the internal tension generated, a hollow is created in the center of the bar. Lamination takes place in order to reach final dimensions in terms of length and thickness according to customer’s request.

HEAT TREATMENTS
In order to obtain the required mechanical properties, heat treatment of normalizing or quenching and tempering are performed depending on tube dimensions.

FINISHING
Tube is finalized in the finishing lines that include the placement of couplings, calibration, identification, varnishing and packaging with a performing combination of non-destructive testing to guarantee high quality of the product. Coating may be applied according to customer’s request.
Environmental Performance

Detailed environmental performance (in terms of potential environmental impacts, use of resources and waste generation) is presented for the product stage that includes the modules A1 RAW MATERIALS SUPPLY, A2) TRANSPORT and 3) MANUFACTURING.

DECLARED UNIT:
The declared unit is one ton of steamless steel structural tube.

<table>
<thead>
<tr>
<th>POTENTIAL ENVIRONMENTAL IMPACTS</th>
<th>UNITS / D.U.</th>
<th>PRODUCT PHASE</th>
<th>TOTAL</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>A1 RAW MATERIALS 1 SUPPLY</td>
<td>A2 TRANSPORT</td>
</tr>
<tr>
<td>GWP</td>
<td>kg CO₂ eq</td>
<td>1 085</td>
<td>167</td>
</tr>
<tr>
<td>ODP</td>
<td>g CFC 11 eq</td>
<td>0.18</td>
<td>0.03</td>
</tr>
<tr>
<td>AP</td>
<td>g SO₂ eq</td>
<td>5 662</td>
<td>1 626</td>
</tr>
<tr>
<td>EP</td>
<td>g PO₄³⁻ eq</td>
<td>1 180</td>
<td>216</td>
</tr>
<tr>
<td>POCP</td>
<td>g C₁₄H₁₀ eq</td>
<td>572</td>
<td>66</td>
</tr>
<tr>
<td>ADPE</td>
<td>g Sb eq</td>
<td>5.98</td>
<td>0.19</td>
</tr>
<tr>
<td>ADPF</td>
<td>MJ</td>
<td>21 462</td>
<td>2 551</td>
</tr>
<tr>
<td>WS</td>
<td>m³ eq</td>
<td>9.20</td>
<td>4.70</td>
</tr>
</tbody>
</table>

Environmental potential impacts were calculated using CML-IA method version 3.04 (Guinee et al. 2001; Huijbregts et al. 2003; Wegener et al. 2008) as implemented in SimaPro 8.4. Water scarcity potential was calculated using AWARE method (Boulay et al. 2018).

Impact categories declared in this EPD are mandatory according PCR 2012-01 v2.3 Construction products and construction services demands. Water scarcity was included as an additional indicator because Mexican steel sector is measuring this impact.
Resource use indicator were calculated with Cumulated Energy Demand method version 1.08 (Frischknecht et al. 2003) and ReCiPe Midpoint version 2016 (Huijbregts et al. 2016) for use of net fresh water.

<table>
<thead>
<tr>
<th>PRODUCT PHASE</th>
<th>A1 RAW MATERIALS 1 SUPPLY</th>
<th>A2 TRANSPORT</th>
<th>A3 MANUFACTURING</th>
<th>TOTAL</th>
</tr>
</thead>
<tbody>
<tr>
<td>PERE</td>
<td>MJ</td>
<td>364</td>
<td>51</td>
<td>154</td>
</tr>
<tr>
<td>PERT</td>
<td>MJ</td>
<td>0</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>PENRE</td>
<td>MJ</td>
<td>21 778</td>
<td>2 619</td>
<td>1 843</td>
</tr>
<tr>
<td>PENRM</td>
<td>MJ</td>
<td>0</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>PENRT</td>
<td>MJ</td>
<td>21 778</td>
<td>2 619</td>
<td>1 843</td>
</tr>
<tr>
<td>SM</td>
<td>kg</td>
<td>0</td>
<td>0</td>
<td>764</td>
</tr>
<tr>
<td>RSF</td>
<td>MJ</td>
<td>0</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>NRSF</td>
<td>MJ</td>
<td>0</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>FW</td>
<td>m³</td>
<td>2.70</td>
<td>0.50</td>
<td>5.40</td>
</tr>
</tbody>
</table>

**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 raw materials
**RSF** Use of renewable secondary fuels
**NRSF** Use of non-renewable secondary fuels
**FW** Use of net fresh water

Resource use indicator were calculated with Cumulated Energy Demand method version 1.08 (Frischknecht et al. 2003) and ReCiPe Midpoint version 2016 (Huijbregts et al. 2016) for use of net fresh water.

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<tr>
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<th>A2 TRANSPORT</th>
<th>A3 MANUFACTURING</th>
<th>TOTAL</th>
</tr>
</thead>
<tbody>
<tr>
<td>HWD</td>
<td>kg</td>
<td>0.08</td>
<td>1.46E-03</td>
<td>0.05</td>
</tr>
<tr>
<td>NHWD</td>
<td>kg</td>
<td>31</td>
<td>119</td>
<td>19</td>
</tr>
<tr>
<td>RWD</td>
<td>kg</td>
<td>0.01</td>
<td>0.02</td>
<td>0.01*</td>
</tr>
<tr>
<td>CRU</td>
<td>kg</td>
<td>0</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>MFR</td>
<td>kg</td>
<td>0</td>
<td>0</td>
<td>19.5</td>
</tr>
<tr>
<td>MER</td>
<td>kg</td>
<td>0</td>
<td>0</td>
<td>15.0</td>
</tr>
<tr>
<td>EET</td>
<td>MJ</td>
<td>0</td>
<td>0</td>
<td>0</td>
</tr>
</tbody>
</table>

*They relate only to the generation of waste during the procurement of auxiliary supplies such as gases, packaging, transport and waste treatment and others.

**HWD** Hazardous waste disposed
**NHWD** Non-hazardous waste disposed
**RWD** Radioactive waste disposed
**CRU** Components for re-use
**MFR** Materials for recycling
**MER** Materials for energy recovery
**EEE** Exported electrical energy
**EET** Exported thermal energy

Output flows and waste categories were calculated with EDIP 2003 version 1.06 method (Hauschild and Potting, 2005) and from TenarisTamsa information.
Calculation Rules

According to the PCR 2012:01 v.2.3, the main activities from the product stage are listed and divided in three modules: UPSTREAM process (A1 RAW MATERIALS SUPPLY) and CORE process (A2 TRANSPORT and A3 MANUFACTURING).

LCA METHODOLOGY

The environmental burden of the product has been processed according to the general rules of the EPD (Environmental Product Declaration) International Programme and the N.PCR 2012:01 (versions 2.3), construction products and construction services - Multiple UN CPC codes (Cradle to gate with options). This declaration is based on the application of Life Cycle Assessment (LCA) methodology to the whole life-cycle system. Seamless steel structural tube at plant level, was described by using specific data from Tenaris Tamsa manufacturing facility for year 2017.

Customized LCA questionnaires were used to gather in-depth information about all aspects of the production system (for example, raw materials specifications, pre-treatments, process efficiencies, air emissions, waste management), ultimately providing a complete picture of the environmental burden of the system: Raw materials supply (A1), Transport (A2) and Manufacturing (A3).

CUT-OFF CRITERIA

A minimum of 95% of the total flows (matter and energy) in modules A1 and A3 modules were included. Company infrastructure, employee’s transportation and administrative activities were kept out of the scope of this study.

ALLOCATION

Allocation of inputs and outputs of the system between product and coproducts was based on a mass relation, considering the quantity produced per year of each product and coproduct at the level of unit process. This procedure was used in the same way for material flows as for the energy flows along the modules evaluated for the structural tube.
Upstream Process
(A1 RAW MATERIALS SUPPLY)

According to the PCR 2012:01 v.2.3, the main activities from the product stage are listed and divided in three modules: UPSTREAM process (A1 RAW MATERIALS SUPPLY) and CORE process (A2 TRANSPORT and A3 MANUFACTURING).
Core Process

(A2 TRANSPORTATION + A3 MANUFACTURING)

A1
UPSTREAM
Process

A2+A3
CORE
Process

RAW AND ANCILLARY MATERIALS TRANSPORT AND INTERNAL TRANSPORT

MANUFACTURING PROCESS INCLUDING STEEL MILL, ROLLING MILL, THERMAL TREATMENT AND FINISHING PROCESS

TREATMENT PROCESS OF WASTE GENERATED BY THE MANUFACTURING PROCESS

EMISSIONS TO AIR AND WATER

ANCILLARY PRODUCTION
Additional Information

Tenaris is committed to minimizing the environmental footprint of its operations and products. The company has obtained a multisite certification of its environmental management system according to ISO 14001 standards. Tenaris is committed to building a culture of transparency and integrity based on ethical behavior and compliance with the law. The company believes that this is essential for the sustainability of the activities.

**TENARIS**

Applies Best Available Technologies on the design of new lines and the steel making production technology is 100% Electric Arc Furnace.

**SCRAP RECYCLING**

Is one way to minimize the environmental footprint of Tenaris operations, and an important opportunity for the steel industry to contribute to the emission reduction. Scrap is the main prime material used in Tenaris steel making process, all scrap from steel and downstream pipe production is collected and reused, as well as post-consumer scrap. Scrap used is classified in different types to allow the most efficient charge bucket preparation.

**TENARIS STEEL MILLS**

Have continuous emission monitoring systems for particulate material emissions in order to efficiently control emission levels and filters performance. Tenaris plants capture systems are under an investment to improve its efficiency. Besides that, the particulate material limits defined in Tenaris procedures are stricter than those in the local regulation.

**DIOXINS EMISSIONS**

Are monitored in the steel mill.

**SLAGS AND SCALE MILL**

Are co-product for steel operation sold as inert material for construction applications, cement production and other operations.

**MANY OF TENARIS FURNACES**

Have low-NOx high efficiency burners, which allow lower emission levels, better combustion and improved gas consumption efficiency.

**WATER RECYCLING**

Tenaris sites have water recycling systems.

**TENARISTAMSA PLANT**

The last rolling mill, heat treatment and finishing lines built that started to operate in 2012 obtained the LEED certification.

**REFERENCES**

- ISO 14025:2010
- ISO 14040:2006
- ISO 14044:2006
- EN15804:2014
- PCR 2012:01, “Construction products and construction services”, v.2.3, 2018
- “Life Cycle Assessment applied to seamless steel structural tube”