HSB Process Pump
The pump characterised 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:
Oil & Gas, Hydrocarbon Processing, Power Generation and Waste Water Industries. The fluids pumped include hydrocarbons, crude charge, boiler feed, water feed and waste water.

Type:
Horizontal Split Casing, Dual Volute, Double Suction Single Stage Pump (ISO 13709, API 610, Type BB1)

Rated power:
1,800 kW

Manufacturer:
Sulzer Pumps USA

CPC classification:
4322

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

Electricity mix considered for usage: USA

Key economic and environmental advantages
- High availability of more than 98% (Customers typically buy two pumps for each service - one is standby)
- Design life of the pump is 20 years in accordance with API 610
- High efficiency and improved seal technology means lower energy consumption and hence lower emissions
- Variable frequency drives allow flexible performance and improved energy-efficiency
- Comprehensive training and professional service enable customers to operate the pump more reliably
- Retrofit service to re-establish the best efficiency point if operating conditions change
- Common API 610 materials are well suited for recycling.

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

Costs
€ 9,815,000
- Procurement / manufacturing 3.6%
- Usage: electricity 94.6%
- Usage: service 1.8%

Energy consumption
1,399,000 GJ-Eq
777 GJ-Eq/kW
- Procurement 0.06%
- Manufacturing 0.03%
- Usage 99.91%

CO₂ emissions
84,288 tonnes CO₂-Eq
46.8 tonnes CO₂-Eq/kW
- Procurement 0.05%
- Manufacturing <0.01%
- Usage 99.94%

Weight & composition
7,681 kg
4.27 kg/kW
- Cast iron 50.8%
- Alloved / high alloyed steel 49.2%
- Oil <0.01%
- Others1) <0.01%

1) e.g. varnishes, seals

Environmental Product Declaration - EPD
Environmental and economic life cycle performance including climate-related data
**Functional unit**
The functional unit is defined as 1 kW hydraulic power of the pump at best efficiency point.

**Composition of the product**

<table>
<thead>
<tr>
<th>Material</th>
<th>kg</th>
<th>% 1)</th>
<th>kg / kW 2)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cast iron</td>
<td>3 901</td>
<td>50.8%</td>
<td>2.17</td>
</tr>
<tr>
<td>Steel (high alloyed)</td>
<td>3 778</td>
<td>49.2%</td>
<td>2.10</td>
</tr>
<tr>
<td>Oil</td>
<td>2</td>
<td>0.0%</td>
<td>0.00</td>
</tr>
<tr>
<td><strong>Total</strong></td>
<td>7 681</td>
<td>100%</td>
<td>4.27</td>
</tr>
</tbody>
</table>

1) By weight.  2) Rated power.

The pump consists of 49.2% alloyed and high alloyed steels, 50.8% of 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 0.01% of the total weight and have as such been omitted.

**Material consumption during life cycle per pump**

<table>
<thead>
<tr>
<th>Material</th>
<th>Procurement 2)</th>
<th>Manufacturing at Sulzer</th>
<th>Usage / end of life</th>
<th>Total</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>kg</td>
<td>kg / kW</td>
<td>kg</td>
<td>kg / kW</td>
</tr>
<tr>
<td>Steel (alloyed), casting</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>for pump</td>
<td>7 990</td>
<td>4.44</td>
<td>7 670</td>
<td>4.26</td>
</tr>
<tr>
<td>for spare parts</td>
<td>320</td>
<td>0.18</td>
<td>310</td>
<td>0.17</td>
</tr>
<tr>
<td>Oil</td>
<td>30</td>
<td>0.02</td>
<td>30</td>
<td>0.02</td>
</tr>
<tr>
<td>Waste production (total)</td>
<td>n.a.</td>
<td>n.a.</td>
<td>1 930</td>
<td>1.07</td>
</tr>
<tr>
<td>Hazardous waste</td>
<td>n.a.</td>
<td>n.a.</td>
<td>370</td>
<td>0.21</td>
</tr>
<tr>
<td>Municipal waste</td>
<td>n.a.</td>
<td>n.a.</td>
<td>230</td>
<td>0.13</td>
</tr>
<tr>
<td>Recycling (total)</td>
<td>n.a.</td>
<td>n.a.</td>
<td>1 330</td>
<td>0.74</td>
</tr>
<tr>
<td>metals (pump)</td>
<td>n.a.</td>
<td>n.a.</td>
<td>320</td>
<td>0.18</td>
</tr>
<tr>
<td>metals (spare parts)</td>
<td>n.a.</td>
<td>n.a.</td>
<td>10</td>
<td>0.006</td>
</tr>
<tr>
<td>others</td>
<td>n.a.</td>
<td>n.a.</td>
<td>1 000</td>
<td>0.56</td>
</tr>
<tr>
<td><strong>Renewable resources</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Wood (packaging)</td>
<td>330</td>
<td>0.18</td>
<td>320</td>
<td>0.18</td>
</tr>
<tr>
<td>Water consumption 4)</td>
<td>n.a.</td>
<td>n.a.</td>
<td>49 030</td>
<td>27.2</td>
</tr>
<tr>
<td><strong>Non-renewable resources</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Total</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

n.a.: not available, values per kW related to 1,800kW 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)**

<table>
<thead>
<tr>
<th>Energy source</th>
<th>Procurement 2)</th>
<th>Manufacturing at Sulzer</th>
<th>Usage / end of life 3)</th>
<th>Total</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>GJ-Eq</td>
<td>GJ-Eq/kW</td>
<td>GJ-Eq</td>
<td>GJ-Eq/kW</td>
</tr>
<tr>
<td>Electricity</td>
<td>334.6</td>
<td>0.186</td>
<td>63 (6)</td>
<td>0 (6)</td>
</tr>
<tr>
<td>Gases 1)</td>
<td>62.4</td>
<td>0.0347</td>
<td>0 (6)</td>
<td>0 (6)</td>
</tr>
<tr>
<td>Fuel oils</td>
<td>0.0</td>
<td>0.000</td>
<td>0 (6)</td>
<td>0 (6)</td>
</tr>
<tr>
<td>Fuels</td>
<td>n.a.</td>
<td>n.a.</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>District heating</td>
<td>n.a.</td>
<td>n.a.</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>Materials</td>
<td>421</td>
<td>0.23</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>Transports</td>
<td>42.8</td>
<td>0.024</td>
<td>35.2</td>
<td>0.0196</td>
</tr>
<tr>
<td>Disposal, waste water</td>
<td>n.a.</td>
<td>n.a.</td>
<td>5.6</td>
<td>0.00311</td>
</tr>
<tr>
<td>**Non-renewable energy sources 5)</td>
<td>792</td>
<td>0.440</td>
<td>40.2</td>
<td>0.0223</td>
</tr>
<tr>
<td>**Total renewable energies 4) 5)</td>
<td>68</td>
<td>0.038</td>
<td>0.00037</td>
<td>49 156</td>
</tr>
<tr>
<td>**Total energy sources 5)</td>
<td>861</td>
<td>0.478</td>
<td>0.0227</td>
<td>1 398 421</td>
</tr>
</tbody>
</table>

1) Natural gas, butane, propane. 2) Including transportation to Sulzer.
3) Including transportation to customer. 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. 8) Imported as heat. 9) See p.3 of this EPD for more information.

Eq: equivalents, kW related to 1,800 kW rated power.

The pump is used in Canada; a factor for Canada in not currently available, the USA energy mix was therefore applied.
Emissions during life cycle (primarily from usage / end of life)

<table>
<thead>
<tr>
<th></th>
<th>Procurement</th>
<th>Manufacturing at Sulzer</th>
<th>Usage / end of life</th>
<th>Total</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>t</td>
<td>kg / kW</td>
<td>t</td>
<td>kg / kW</td>
</tr>
<tr>
<td>Greenhouse Gas Potential (CO₂-equivalents)</td>
<td>44.0</td>
<td>24.46</td>
<td>3.15</td>
<td>1.750</td>
</tr>
<tr>
<td>Acidification potential (SOx-equivalents - AP)</td>
<td>2.0</td>
<td>1.125</td>
<td>0.113</td>
<td>0.063</td>
</tr>
<tr>
<td>Photosmog potential (ethylene equivalents)</td>
<td>0.007</td>
<td>0.004</td>
<td>0.00014</td>
<td>0.0008</td>
</tr>
<tr>
<td>Ozone depleting potential (CFC11-equivalents)</td>
<td>&lt;0.001</td>
<td>&lt;0.001</td>
<td>n.a.(^{2})</td>
<td>&lt;0.001</td>
</tr>
<tr>
<td>Biological Oxygen Demand (O₂-equivalents)</td>
<td>0.05</td>
<td>0.029</td>
<td>n.a.(^{3})</td>
<td>24.4</td>
</tr>
</tbody>
</table>

n.a.: not available, kW related to 1,800 kW rated power. 1) Emissions are dominated by emissions in usage from 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 pump is assembled in the USA; therefore the USA emissions factor for the electricity generating mix has been applied for electricity used during manufacturing.

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 also 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 to 100% for both.

Pump is used in Canada, as no factor is available, the US electricity mix was assumed. The price for electricity applied is € 0.07 per kWh and is quoted in Euros for comparability with similar EPDs.

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. This conservative assumption was based on the fact that the use of recycled steel saves between 47% and 65% of energy compared to virgin steel (Volkshausen 2003; Wuppertal-Institut 2008).

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 Ecoinvent 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 Ecoinvent v.2 database, 2010.
Applied load levels of pump during life cycle
The applied load levels are summarized in the table below. Based on expected usage characteristics advised by customers, the pump is expected to be operated at full load throughout its life.

<table>
<thead>
<tr>
<th>Phases of load level</th>
<th>Duration of phase</th>
<th>Operating hours per year</th>
<th>Efficiency $\eta$</th>
<th>Effective Rating $kW$</th>
</tr>
</thead>
<tbody>
<tr>
<td>Phase 1: full load</td>
<td>10 years</td>
<td>4 000</td>
<td>84%</td>
<td>1 800</td>
</tr>
<tr>
<td>Phase 2: middle load</td>
<td>6</td>
<td>3 200</td>
<td>82%</td>
<td>1 700</td>
</tr>
<tr>
<td>Phase 3: low load</td>
<td>4</td>
<td>800</td>
<td>72%</td>
<td>1 400</td>
</tr>
</tbody>
</table>

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.

- **Ecoinvent 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 or 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**

Product Category Rule (PCR), CPC Class 4322, Pumps for Liquids; Liquid Elevators and Mixers, PCR 2011:22, Version 1.0, 2011-12-05

Swiss Centre for Life Cycle Inventories, Ecoinvent Database 2.1, St. Gallen, 2009

The International EPD Cooperation, EPD General Instructions for Environmental Product Declaration, EPD Version 1.0: 2008-02-29.


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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