

Environmental Product Declaration - EPD

Environmental and economic life cycle performance including climate-related data

BBS Process 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:

Designed for a wide variety of pumping applications covering a full range of higher pressure applications such as sour water, propane, light hydrocarbons, hot and corrosive naphenic crude oil, hot sandy crude oil and vacuum bottoms.

Type:

Double suction between bearings single stage process pump.

Rated power:

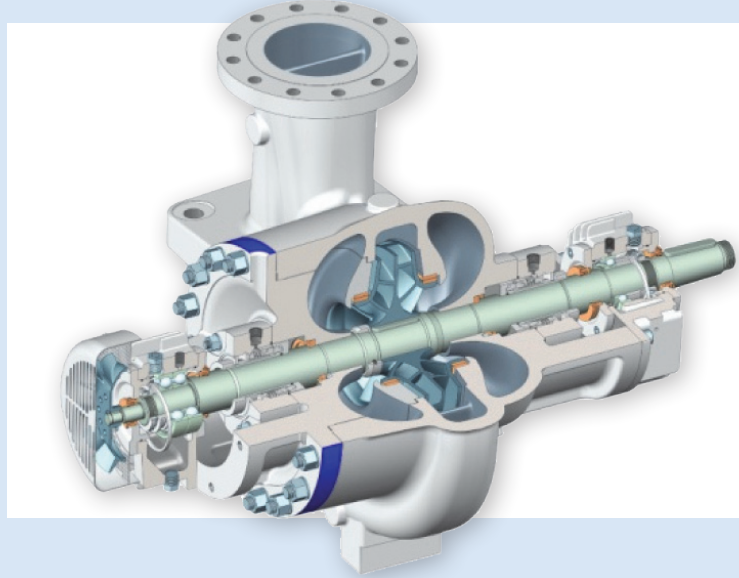
1,070 kW

Manufacturer:

Sulzer Pumps Mexico, S.A. de C.V.

CPC classification:

4322



Components included:

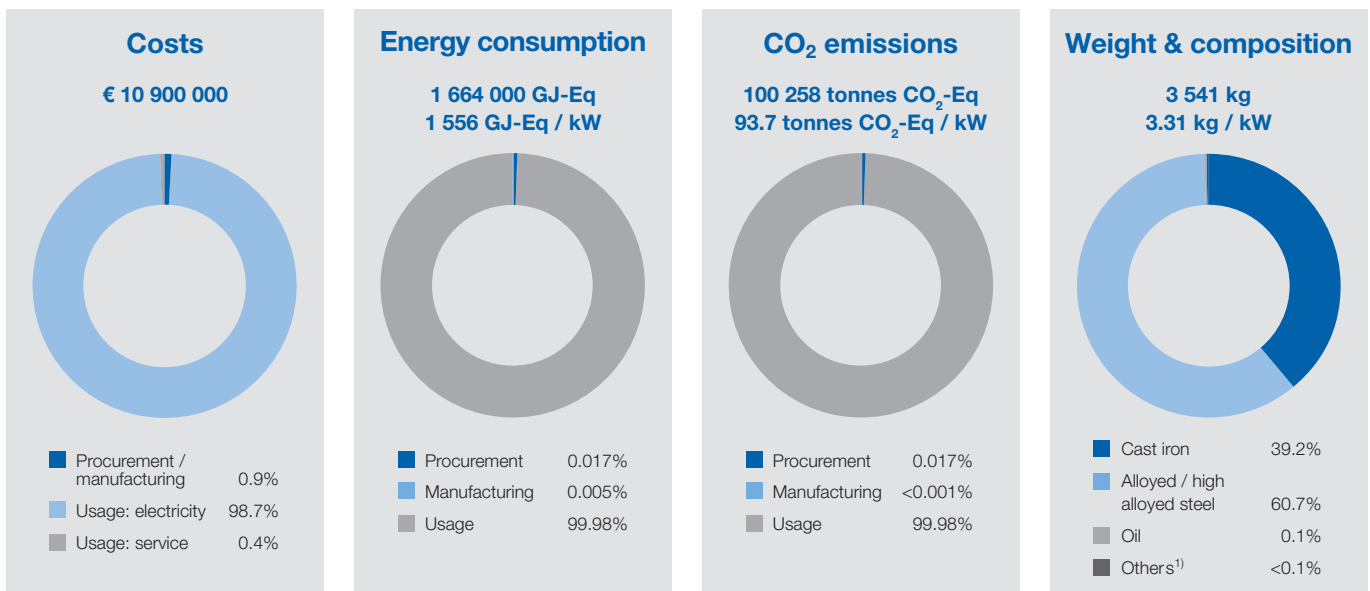
- Pump including casing, baseplate, shaft, impeller, bearings
- Gearbox
- Motor
- Frequency inverter
- Piping system

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



¹⁾ e.g. varnishes, seals

Functional unit

The functional unit is defined as 1 kW hydraulic power of the pump at best efficiency point.

Composition of the product

Material	kg	% ¹⁾	kg / kW ²⁾
Cast iron	1 389	39%	1.30
Steel (high alloyed)	2 148	61%	2.01
Oil	4	0%	0.00
Total	3 541	100%	3.31

The pump consists of 61% alloyed and high al-loyed steels and 39% 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.

1) By weight. 2) 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	3 680	3.34	3 530	3.30	3 530	3.30
for spare parts	150	0.14	140	0.13	140	0.13
Oil	70	0.07	70	0.07	70	0.07
Waste production (total)	n.a.	n.a.	660	0.62	3 740	3.50
Hazardous waste	n.a.	n.a.	30	0.03	70	0.07
Municipal waste	n.a.	n.a.	120	0.11	n.a.	n.a.
Recycling (total)	n.a.	n.a.	510	0.48	3 670	3.43
metals (pump)	n.a.	n.a.	150	0.14	3 530	3.30
metals (spare parts)	n.a.	n.a.	10	0.009	140	0.13
others	n.a.	n.a.	350	0.33	n.a.	n.a.
Renewable resources	kg	kg / kW	kg	kg / kW	kg	kg / kW
Wood (packaging)	130	0.12	120	0.12	120	120
Water consumption ⁴⁾	n.a.	n.a.	23 260	21.7	n.a.	n.a.

n.a.: not available, values per kW related to 1 070 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	65.1	0.061	0 ⁶⁾	0 ⁶⁾	1 662 798	1 554	1 662 863	1 554
Gases ¹⁾	4.5	0.0042	0 ⁶⁾	0 ⁶⁾	0	0	4.5	0.0042
Fuel oils	0.1	0.000	0 ⁶⁾	0 ⁶⁾	0	0	0.1	0.000
Fuels	n.a.	n.a.	0	0	0	0	0.0	n.a.
District heating ⁸⁾	n.a.	n.a.	0	0	0	0	0.0	n.a.
Materials	206	0.19	0	0	0	0	206	0.19
Transports	26.6	0.025	19.6	0.0184	1402	1.31	1 448	1.354
Disposal, waste water ⁷⁾	n.a.	n.a.	0.1	0.00006	-125	-0.116	-125 ⁹⁾	-0.116
Non-renewable energy sources ⁵⁾	271	0.254	19.4	0.0182	1 605 561	1 501	1 605 852	1 501
Total renewable energies ^{4) 5)}	32	0.029	0.3	0.00026	58 515	55	58 547	55
Total energy sources ⁵⁾	303	0.283	19.7	0.0184	1 664 076	1 555	1 664 399	1 556

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 1070 kW rated power.

The USA is a representative market for this product; hence the USA national energy mix has been applied.

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

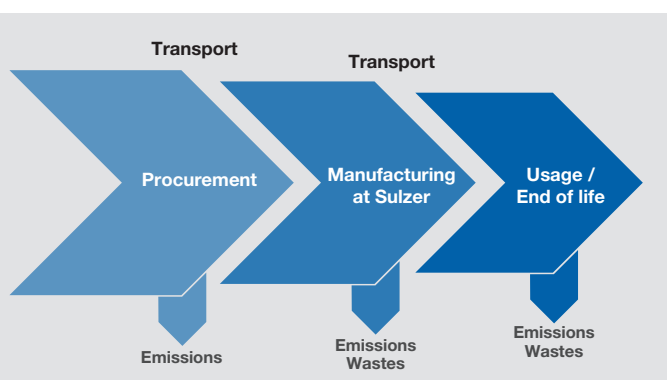
	Procurement		Manufacturing at Sulzer		Usage end of life ¹⁾		Total	
	t	kg / kW	t	kg / kW	t	kg / kW	t	kg / kW
Greenhouse Gas Potential (CO ₂ -equivalents)	16.2	15.17	1.26	1.174	100 240	93 682	100 258	93 699
Acidification potential (SO _x -equivalents - AP)	1.1	0.984	0.060	0.056	132	1 272	1 362	1 273
Photosmog potential (ethylene equivalents)	0.003	0.003	<0.001	<0.001	0.4	3.88	4.2	3.88
Ozone depleting potential (CFC11-equivalents)	<0.001	<0.001	n.a. ²⁾	n.a. ²⁾	<0.001	<0.001	<0.001	<0.001
Biological Oxygen Demand (O ₂ -equivalents)	0.03	0.028	n.a. ³⁾	n.a. ³⁾	2.9	27.2	29.1	27.2

n.a.: not available, kW related to 1070 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 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 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 Mexico; as the Mexico factor is not currently available; the USA 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 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 of 100% for both.

The pump is used in Louisiana (USA), the USA electricity mix was assumed. The price for electricity applied is € 0.07 per kWh and is quoted in Eu-ros 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 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 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.

Phases of load level	Duration of phase	Operating hours per year	Efficiency η	Effective Rating
	years	hours / year	%	kW
Phase 1: full load	10	8 000	82%	1 070
Phase 2: middle load	6	6 000	80%	930
Phase 3: low load	4	4 000	70%	670

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.

EcolInvent 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 managements 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
 - 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, EcolInvent Database 2.1, St. Gallen, 2009
 - The International EPD Cooperation, EPD General Instructions for Environmental Product Declaration, EPD Version 1.0; 2008-02-29.
 - Volkshausen, W. (2003): Methodische Beschreibung und Bewertung der umweltgerechten Gestaltung von Stahlwerkstoffen und Stahlerzeugnissen, Dissertation, TU Freiberg
 - 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

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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