



SHI-PRODUKTPASS

Produkte finden - Gebäude zertifizieren

SHI-Produktpass-Nr.:

15548-10-1001

Aluminium Haustür KÖSTER Advance 88

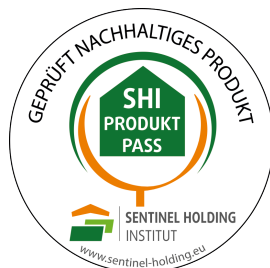
Warengruppe: Türen & Tore - Haustüren - Innenausbau

KÖSTER 

Köster Aluminium GmbH & Co. KG
Hansaallee 6-8
58636 Iserlohn



Produktqualitäten:



Köttner

Helmut Köttner
Wissenschaftlicher Leiter
Freiburg, den 19.03.2026



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Wir sind stolz darauf, dass die SHI-Datenbank, die erste und einzige Datenbank für Bauprodukte ist, die ihre umfassenden Prozesse sowie die Aktualität regelmäßig von dem unabhängigen Prüfunternehmen SGS-TÜV Saar überprüfen lässt.





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SHI-Produktbewertung 2024

Seit 2008 etabliert die Sentinel Holding Institut GmbH (SHI) einen einzigartigen Standard für schadstoffgeprüfte Produkte. Experten führen unabhängige Produktprüfungen nach klaren und transparenten Kriterien durch. Zusätzlich überprüft das unabhängige Prüfunternehmen SGS-TÜV Saar regelmäßig die Prozesse und Aktualität.

Kriterium	Produktkategorie	Schadstoffgrenzwert	Bewertung
SHI-Produktbewertung	sonstige Produkte	TVOC $\leq 300 \mu\text{g}/\text{m}^3$ Formaldehyd $\leq 24 \mu\text{g}/\text{m}^3$	Schadstoffgeprüft



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QNG - Qualitätssiegel Nachhaltiges Gebäude

Das Qualitätssiegel Nachhaltiges Gebäude, entwickelt durch das Bundesministerium für Wohnen, Stadtentwicklung und Bauwesen (BMWSB), legt Anforderungen an die ökologische, soziokulturelle und ökonomische Qualität von Gebäuden fest. Das Sentinel Holding Institut prüft Bauprodukte gemäß den QNG-Anforderungen für eine Zertifizierung und vergibt das QNG-ready Siegel. Das Einhalten des QNG-Standards ist Voraussetzung für den KfW-Förderkredit. Für bestimmte Produktgruppen hat das QNG derzeit keine spezifischen Anforderungen definiert. Diese Produkte sind als nicht bewertungsrelevant eingestuft, können jedoch in QNG-Projekten genutzt werden.

Kriterium	Pos. / Bauproduktgruppe	Betrachtete Stoffe	QNG Freigabe
3.1.3 Schadstoffvermeidung in Baumaterialien			QNG-ready nicht bewertungsrelevant



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DGNB Neubau 2023

Das DGNB-System (Deutsche Gesellschaft für Nachhaltiges Bauen) bewertet die Nachhaltigkeit von Gebäuden verschiedener Art. Das System ist sowohl anwendbar für private und gewerbliche Großprojekte als auch für kleinere Wohngebäude. Die Version 2023 setzt hohe Standards für ökologische, ökonomische, soziokulturelle und funktionale Aspekte während des gesamten Lebenszyklus eines Gebäudes.

Kriterium	Bewertung
ENV 1.1 Klimaschutz und Energie (*)	Kann Gesamtbewertung positiv beeinflussen
Nachweis: WICONA Zertifikat Hydro CIRCAL, Die Energieersparnis im Herstellungsprozess beträgt dabei bis zu 95% im Vergleich zu herkömmlichem Aluminium.	

Kriterium	Bewertung
ECO 1.1 Gebäudebezogene Kosten im Lebenszyklus (*)	Kann Gesamtbewertung positiv beeinflussen
Nachweis: Leistungserklärung des Produktes (individuell zum Auftrag), WICONA Zertifikat Hydro CIRCAL	

Kriterium	Bewertung
ECO 2.6 Klimaresilienz (*)	Kann Gesamtbewertung positiv beeinflussen
Nachweis: Leistungserklärung des Produktes (individuell zum Auftrag)	

Kriterium	Bewertung
SOC 1.1 Thermischer Komfort (*)	Kann Gesamtbewertung positiv beeinflussen
Nachweis: Produkteigenschaften	

Kriterium	Bewertung
SOC 1.3 Schallschutz und akustischer Komfort (*)	Kann Gesamtbewertung positiv beeinflussen
Nachweis: Prüfbericht für Modell 5510	



Kriterium	Bewertung
SOC 2.1 Barrierefreiheit (*)	Kann Gesamtbewertung positiv beeinflussen

Kriterium	Bewertung
TEC 1.3 Qualität der Gebäudehülle (*)	Kann Gesamtbewertung positiv beeinflussen
Nachweis: Leistungserklärung des Produkts	

Kriterium	Bewertung
TEC 1.4 Einsatz und Integration von Gebäudetechnik (*)	Kann Gesamtbewertung positiv beeinflussen
Nachweis: Optionale motorische Verriegelungen möglich	

Kriterium	Pos. / Relevante Bauteile / Bau-Materialien / Flächen	Betrachtete Stoffe / Aspekte	Qualitätsstufe
ENV 1.2 Risiken für die lokale Umwelt, 03.05.2024 (3. Auflage)	32 Sämtliche Aluminium und Edelstahlbauteile	Chrom-VI	Qualitätsstufe: 4
Nachweis: Herstellererklärung vom 16.03.2026			

Kriterium	Pos. / Relevante Bauteile / Bau-Materialien / Flächen	Betrachtete Stoffe / Aspekte	Qualitätsstufe
ENV 1.2 Risiken für die lokale Umwelt, 29.05.2025 (4. Auflage)	32 Sämtliche Aluminium und Edelstahlbauteile	Chrom-VI	Qualitätsstufe: 4
Nachweis: Herstellererklärung vom 16.03.2026			



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DGNB Neubau 2018

Das DGNB-System (Deutsche Gesellschaft für Nachhaltiges Bauen) bewertet die Nachhaltigkeit von Gebäuden verschiedener Art. Das System ist sowohl anwendbar für private und gewerbliche Großprojekte als auch für kleinere Wohngebäude.

Kriterium	Pos. / Relevante Bauteile / Bau-Materialien / Flächen	Betrachtete Stoffe / Aspekte	Qualitätsstufe
ENV 1.2 Risiken für die lokale Umwelt	32 Sämtliche Aluminium- und Edelstahlbauteile der Hülle. Nicht betrachtet werden Sonnenschutzlamellen, Rolladenkästen sowie Edelstahlgeländer	Chrom-VI	Qualitätsstufe: 4
Nachweis: Herstellererklärung vom 16.03.2026			



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BNB-BN Neubau V2015

Das Bewertungssystem Nachhaltiges Bauen ist ein Instrument zur Bewertung von Büro- und Verwaltungsgebäuden, Unterrichtsgebäuden, Laborgebäuden sowie Außenanlagen in Deutschland. Das BNB wurde vom damaligen Bundesministerium für Umwelt, Naturschutz, Bau und Reaktorsicherheit (BMUB) entwickelt und unterliegt heute dem Bundesministerium für Wohnen, Stadtentwicklung und Bauwesen.

Kriterium	Pos. / Bauprodukttyp	Betrachtete Schadstoffgruppe	Qualitätsniveau
1.1.6 Risiken für die lokale Umwelt	27 eloxierte Aluminium- und passivierte Edelstahloberflächen	Schwermetalle (Chrom-VI)	Qualitätsniveau 5
Nachweis: Herstellererklärung vom 16.03.2026			



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EU-Taxonomie

Die EU-Taxonomie klassifiziert wirtschaftliche Aktivitäten und Produkte nach ihren Umweltauswirkungen. Auf der Produktebene gibt es gemäß der EU-Verordnung klare Anforderungen zu Formaldehyd und flüchtigen organischen Verbindungen (VOC). Die Sentinel Holding Institut GmbH kennzeichnet qualifizierte Produkte, die diesen Standard erfüllen.

Kriterium	Produkttyp	Betrachtete Stoffe	Bewertung
DNSH - Vermeidung und Verminderung der Umweltverschmutzung		Stoffe nach Anlage C	EU-Taxonomie konform
Nachweis: Herstellererklärung vom 16.03.2026			



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BREEAM DE Neubau 2018

BREEAM (Building Research Establishment Environmental Assessment Methodology) ist ein britisches Gebäudebewertungssystem, welches die Nachhaltigkeit von Neubauten, Sanierungsprojekten und Umbauten einstuft. Das Bewertungssystem wurde vom Building Research Establishment (BRE) entwickelt und zielt darauf ab, ökologische, ökonomische und soziale Auswirkungen von Gebäuden zu bewerten und zu verbessern.

Kriterium	Produktkategorie	Betrachtete Stoffe	Qualitätsstufe
Hea 02 Qualität der Innenraumluft			nicht bewertungsrelevant



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LEED v4.1

LEED (Leadership in Energy and Environmental Design) ist ein international anerkanntes Gebäudezertifizierungssystem des U.S. Green Building Council. Es zählt zu den weltweit am weitesten verbreiteten Nachhaltigkeitsstandards für Gebäude und wird insbesondere bei international ausgerichteten Projekten eingesetzt. LEED bewertet Gebäude ganzheitlich in Kategorien wie Energieeffizienz, Ressourcenschonung, Materialauswahl, Innenraumqualität und Standortqualität. Je nach erreichter Punktzahl werden die Zertifizierungsstufen LEED Certified, Silver, Gold oder Platinum vergeben.

Kriterium	Produktkategorie	Bewertung
EQ Credit: Low-Emitting Materials		nicht bewertungsrelevant



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Produktsiegel

In der Baubranche spielt die Auswahl qualitativ hochwertiger Materialien eine zentrale Rolle für die Gesundheit in Gebäuden und deren Nachhaltigkeit. Produktlabels und Zertifikate bieten Orientierung, um diesen Anforderungen gerecht zu werden. Allerdings besitzt jedes Zertifikat und Label eigene Prüfkriterien, die genau betrachtet werden sollten, um sicherzustellen, dass sie den spezifischen Bedürfnissen eines Bauvorhabens entsprechen.



EPD-Norge ist der norwegische Programmbetreiber für Environmental Product Declarations (EPDs). Das Programm richtet sich nach ISO 14025 und EN 15804 und stellt sicher, dass EPDs für Bau- und Industrieprodukte einheitlich, geprüft und vergleichbar veröffentlicht werden. Vor der Veröffentlichung wird jede EPD unabhängig verifiziert; EPD-Norge führt dafür klare Verfahren, Product Category Rules (PCR/NPCR) und ein öffentliches Register.



Produkte mit dem QNG-ready Siegel des Sentinel Holding Instituts eignen sich für Projekte, für welche das Qualitätssiegel Nachhaltiges Gebäude (QNG) angestrebt wird. QNG-ready Produkte erfüllen die Anforderungen des QNG Anhangdokument 3.1.3 "Schadstoffvermeidung in Baumaterialien". Das KfW-Kreditprogramm Klimafreundlicher Neubau mit QNG kann eine höhere Fördersumme ermöglichen.



Dieses Produkt ist schadstoffgeprüft und wird vom Sentinel Holding Institut empfohlen. Gesundes Bauen, Modernisieren und Betreiben von Immobilien erfolgt dank des Sentinel Holding Konzepts nach transparenten und nachvollziehbaren Kriterien.



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Rechtliche Hinweise

(*) Die Kriterien dieses Steckbriefs beziehen sich auf das gesamte Bauobjekt. Die Bewertung erfolgt auf der Ebene des Gebäudes. Im Rahmen einer sachgemäßen Planung und fachgerechten Installation können einzelne Produkte einen positiven Beitrag zum Gesamtergebnis der Bewertung leisten. Das Sentinel Holding Institut stützt sich einzig auf die Angaben des Herstellers.

Alle Kriterien finden Sie unter:

<https://www.sentinel-holding.eu/de/Themenwelten/Pr%C3%BCfverfahren/kriterien%20f%C3%BCr%20Produkte>

Wir sind stolz darauf, dass die SHI-Datenbank, die erste und einzige Datenbank für Bauprodukte ist, die ihre umfassenden Prozesse sowie die Aktualität regelmäßig von dem unabhängigen Prüfunternehmen SGS-TÜV Saar überprüfen lässt.



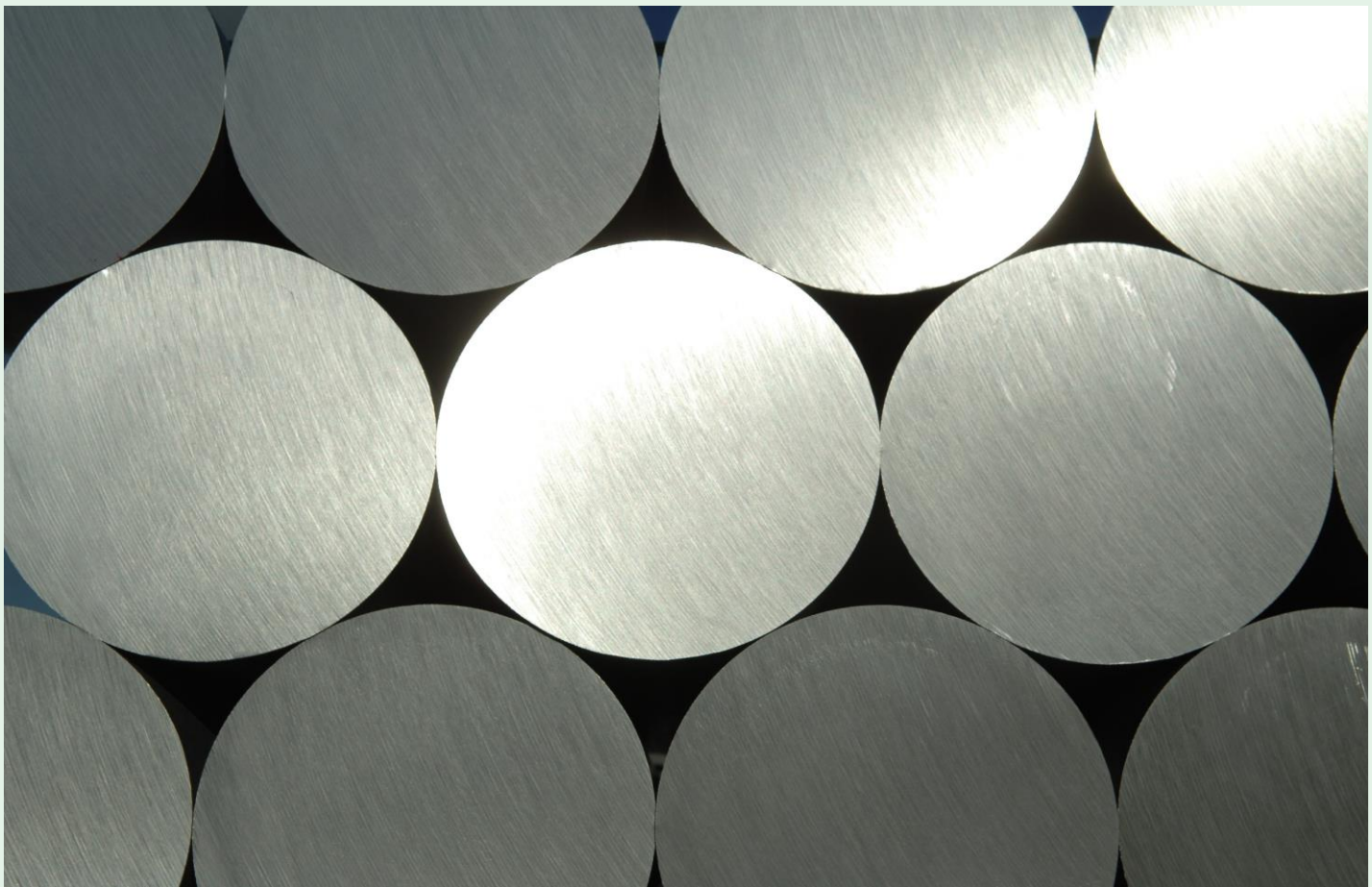
Herausgeber

Sentinel Holding Institut GmbH
Bötzingen Str. 38
79111 Freiburg im Breisgau
Tel.: +49 761 590 481-70
info@sentinel-holding.eu
www.sentinel-holding.eu

Environmental Product Declaration

In accordance with 14025 and EN15804 +A2

Hydro 75R, Aluminium Extrusion Ingot



The Norwegian
EPD Foundation

Owner of the declaration:

Hydro Aluminium AS
Drammensveien 264, N-0283 Oslo
www.hydro.com

Product name:

Hydro 75R, Aluminium Extrusion Ingot

Declared unit:

1 kg Aluminium extrusion ingot from the
Azuqueca, Clervaux, and Wrexham aluminium
recycling plants.

Product category /PCR:

NPCR 013, "Version 3.0 Part B for steel and
aluminium construction products" and NPCR
Part A: Construction Products and Services
Version 2.0

Program holder and publisher:

The Norwegian EPD foundation

Declaration number:

NEPD-6067-5327-EN

Registration Number:

NEPD-6067-5327-EN

Issue date:

13.02.2024

Valid to:

13.02.2029

General information

Product:

Hydro 75R, Aluminium Extrusion Ingot

Program Operator:

The Norwegian EPD Foundation
Post Box 5250 Majorstuen, 0303 Oslo, Norway
Phone: +47 23 08 80 00
e-mail: post@epd-norge.no

Declaration Number:

NEPD-6067-5327-EN

This declaration is based on Product Category Rules:

CEN Standard EN 15804 serves as core PCR
NPCR 013, "Version 3.0 Part B for steel and
aluminium construction products" 2021
NPCR Part A: Construction Products and Services
Version 2.0:2021

Statements:

The owner of the declaration shall be liable for the
underlying information and evidence. EPD
Norway shall not be liable with respect to
manufacturer, life cycle assessment data and
evidences.

Declared unit:

1 kg 75R Aluminium extrusion ingot from the
Azuqueca, Clervaux, and Wrexham aluminium
recycling plants.

Declared unit with option:

Includes modules: A1-A4, C1-C4, and D

Verification:

Independent verification of the declaration and
data, according to ISO14025:2010
internal ☐ external ☐

Sign

Linda Høiby

Life Cycle Assessment Consulting

Independent verifier approved by EPD Norway

Owner of the declaration:

Hydro Aluminium As
Contact person: Stig Tjøtta
Phone: +47 908 88 767
e-mail: stig.tjotta@hydro.com

Manufacturer:

Hydro Aluminium As
Drammensveien 264, N-0283 Oslo
Phone: +47 22538100
e-mail: greener.aluminium@hydro.com

Place of production:

Hydro Clervaux- Luxembourg ; Hydro Azuqueca-
Spain ; Hydro Wrexham- Wales

Management system:

ISO 14001, ISO 9001, ISO 50001, 45001

Organisation no:

917537534

Issue date:

13.02.2024

Valid to:

13.02.2029

Year of study:

[xxxx]

Comparability:

EPDs from other programmes than [Name of
Program operator] may not be comparable.

This average EPD has been worked out by:

Valentina Pauna, Andreas Brekke, and Maciej
Biedacha, all from NORSUS AS

Approved



Manager of EPD Norway

Product/Process

Hydro Aluminium Extrusion Ingot from Hydro Aluminium Metal

Norsk Hydro ASA is the mother company of Hydro Energy and Hydro Aluminium AS. The latter is divided into Hydro Bauxite and Alumina, Hydro Aluminium Metal, and Hydro Extrusions. Hydro Aluminium Metal is a leading supplier of cast house products from a global network of casthouses supplied in the form of extrusion ingots, sheet ingots, foundry alloys, forging ingots and wire rods with a total volume of around 3 million metric tons per year.

The production sites for products of primary aluminium are:

- Sunndalsøra, Norway: Extrusion Ingots, Foundry Alloys
- Karmøy, Norway: Extrusion Ingots, Wire Rod
- Husnes, Norway: Extrusion Ingots, Forging Ingots
- Årdal, Norway: Sheet Ingots, Foundry Alloys
- Høyanger, Norway: Sheet Ingots
- Slovalco, Slovakia: Extrusion Ingots, Foundry Alloys
- Qatalum, Qatar: Extrusion Ingots, Foundry Alloys
- Albras, Brasil: Foundry Alloys, Standard Ingots

The production sites for products of recycled aluminium are:

- Rackwitz, Germany: Extrusion Ingots, Forging Ingots (from 2023)
- Clervaux, Luxembourg: Extrusion Ingots
- Luce, France: Extrusion Ingots
- Wrexham, UK: Extrusion Ingots
- Azuqueca, Spain: Extrusion Ingots
- Commerce, TX USA: Extrusion Ingots
- Henderson, KY USA: Extrusion Ingots
- Cassopolis, MI USA: Extrusion Ingots (from 2023)

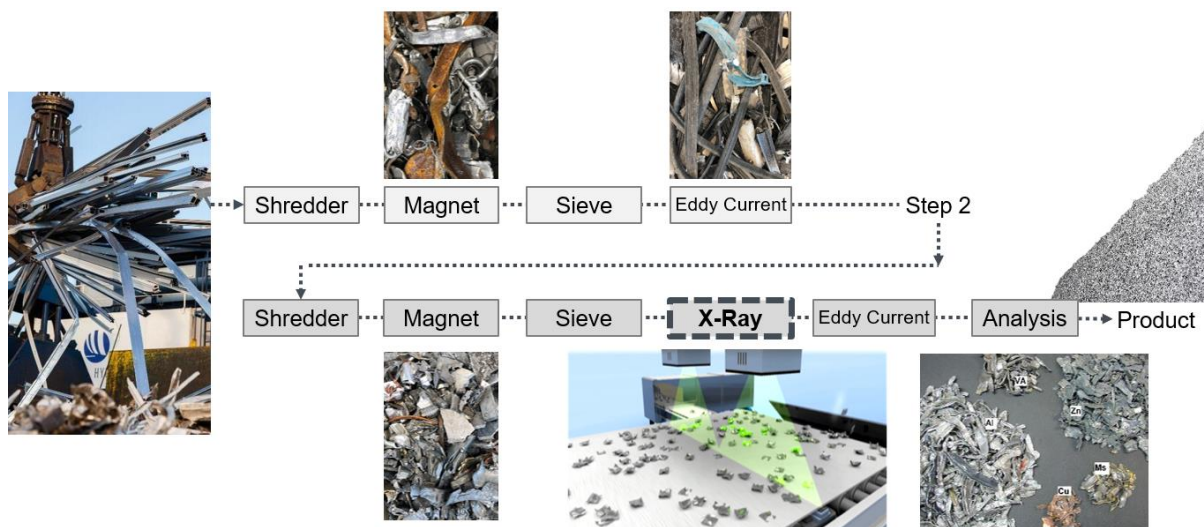
Hydro 75R

Hydro 75R is Extrusion Ingots tailor-made for the circular economy with a guaranteed minimum content of Post-Consumer Scrap of 75% (also denoted End of Life Scrap).

Average raw material used are:

- Post-Consumer Scrap: 81%
- Primary Ingot: 11%
- Process Scrap (also denoted pre-consumer scrap): 8%
- Alloying Materials: 0.1%

Most of the Post-Consumer scrap used are shredded and sorted to remove all foreign materials to ensure a close to 100% aluminium fraction:



The shredded scrap is further treated in the cast house through an innovative and energy efficient process in which the scrap goes through a de-lacquering process. Here, the organic content is removed through pyrolysis in which a gas at 500 degrees burns off the paint. The resulting hot gas then rich in hydrocarbons is blown into a specially designed combustion chamber in the melting furnace. This way of utilizing the energy embedded in the paint reduces the total energy consumption in the melting process by around 25%.

To ensure traceability of the post-consumer scrap used to produce Hydro 75R procedures are developed including certification of suppliers, intake control and segregation of the scrap through production. This is documented batch by batch through the production system. The procedures, documentation and processes are verified annually by third party certification body DNV.

The total production of Hydro 75R was 55,000 metric tons in 2022 in the following cast houses certified for 75R production:

- Clervaux, Luxembourg
- Azuqueca, Spain
- Wrexham, UK
- Commerce, TX USA
- Cassopolis, MI USA (from 2023)

48,000 metric tons were produced in the three European plants Clervaux, Azuqueca, and Wrexham covered by this EPD.

Aluminium production starts with mining of bauxite at specific locations around the Equator with Australia, Guinea, China, and Brazil as the four main producers. Alumina (also called aluminium oxide) is refined and after several processes alumina emerges as a fine white powder. Alumina is further smelted using the Hall-Héroult electrolytic process, an electrolysis process driven by electrical current. Finally, the aluminium goes to a casthouse process, being casted into semi-finished products. During this process, various sources and amounts of cold metals (primary aluminium from other producers) and alloys such as silicon, magnesium or manganese are added, depending on the final desired functions of the aluminium product.

In an aluminium recycling plant, extrusion ingots are made from smelting a mix of end-of-life scrap (post-consumer scrap), process scrap (pre-consumer scrap), and primary aluminium and forming this in cylindrical shapes.

Extrusion ingots are transported to an extrusion plant. In the extrusion process the aluminium is shaped through a hole in a die. Extruded material emerges as a long piece with the same profile as the die opening. The largest quantity of extruded profiles is used in the construction sector.

Recycling requires only 5% of the energy required for production of primary metal (Hydro, 2023). Hence, the direct emissions from plants recycling aluminium are small in comparison to the production of primary aluminium. The emissions connected to a recycling unit are therefore mainly determined by the indirect emissions, in other words from the production and transportation of raw materials used.

The contribution from different factors to impacts on climate change (GWP-Total in kg CO₂/kg Al) for 75R is shown in Fig. 1.

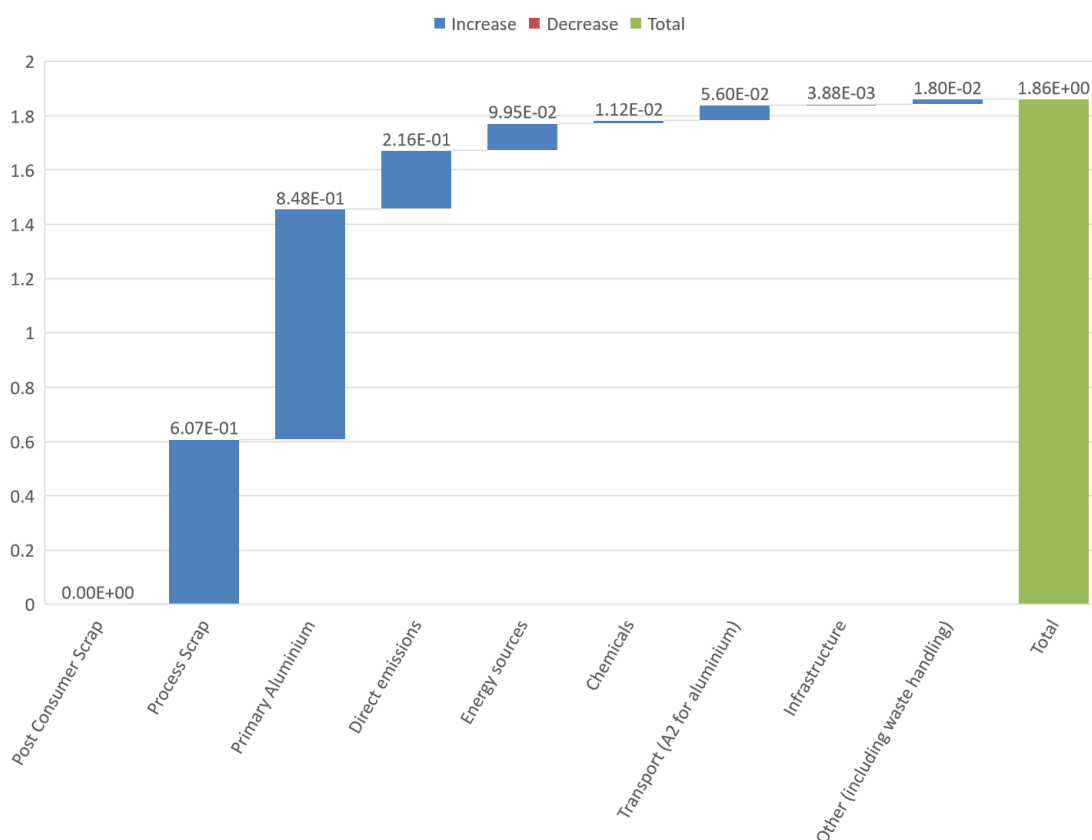


Fig. 1 Waterflow diagram showing the contributions to climate change (GWP-Total in kg CO₂/kg Al) for 75R for modules A1-A3.

The reason why post-consumer scrap has no contribution is that this is considered a waste product with zero impact. Only transport impacts are included for this material flow, and this is included in the bar called 'Transport (A2 for aluminium)'.

Product specification:

Cast aluminium products contain alloying materials and these are designated different numbers depending on what materials they contain which also give specific product characteristics. Most of the Extrusion Ingots produced belong to the 6000 alloy family from all major alloy groups with compositions shown in Table 1. All products are produced according to EN 486 :2009.

<https://www.hydro.com/en/aluminium/products/casthouse-products/extrusion-ingots/>

Table 1 Comparing scrap chemistry with standard alloy group. Scrap chemistry averages from 9 months production in 2017. The only limitation being a minimum level of selected elements

Alloy	Mg	Mn	Fe	Si	Cu	Zn	Cr	Ti	Other	Al
6005A	0.4-0.7	≤0.50	≤0.35	0.5-0.9	≤0.30	≤0.20	≤0.30	≤0.10	≤0.05	Rest
6060	0.35-0.6	≤0.10	0.10-0.30	0.3-0.6	≤0.10	≤0.15	≤0.05	≤0.10	≤0.05	Rest
6061	0.8-1.2	≤0.15	≤0.7	0.4-0.8	0.15-0.40	≤0.25	0.04-0.35	≤0.15	≤0.05	Rest
6063	0.45-0.9	≤0.10	≤0.35	0.2-0.40	≤0.10	≤0.10	≤0.10	≤0.10	≤0.05	Rest
6082	0.6-1.2	0.4-1.0	≤0.50	0.7-1.3	≤0.10	≤0.20	≤0.25	≤0.10	≤0.05	Rest
6106	0.4-0.8	0.05-0.2	≤0.35	0.3-0.6	≤0.25	≤0.15	≤0.20	≤0.10	≤0.05	Rest

This EPD covers all the alloys described in Table 1. The difference in environmental impacts between the alloys are negligible (<1%) in the final product, because of small variations in the amount of alloying elements between the different groups.

Technical data:

Typical technical properties for the alloys covered by this EPD are shown in Table 2.

Table 2 Technical properties for the extrusion ingot aluminium alloys covered in this EPD.

Name	Typical Values 6xxx alloys	Unit
Density	2.66 – 2.71	(Kg/m ³) * 10 ³
Melting point (Typical)	575-655	°C
Electrical conductivity (Typical) at 20°C/at 68°F	Equal Volume: 22-36	MS/m (0.58*%IACS)
Thermal conductivity (Typical) at 25°C/at 77°F	130-220	W/(m*k)
Average Coefficient of thermal expansion (Typical) 20° to 100°C/68° to 212°F	19.4-24.1	Per °C
Modulus of elasticity (Typical)	69-72	MPa * 10 ³
Chemical composition	Varying alloy by alloy, most case Al > 98	% by mass

Market:

The 75R product covered by this EPD has Europe as its main market. The main portion goes to building and construction, but it is also employed in other sectors (general engineering, solar panels, automotive industry, transport, and consumer goods).

LCA: Calculation rules

Declared unit:

1 kg of 75R aluminium extrusion ingot manufactured at the aluminium recycling plants Azuqueca, Clervaux, and Wrexham.

The 75R product is produced in more than one location. This product is therefore made as a weighted average between the three locations Azuqueca (Spain), Clervaux (Luxembourg) and Wrexham (England). These three locations have different power input, namely the market mix

in each individual country, but the mix of metal sources is more important for the environmental impacts, and we see these products as interchangeable between the countries.

Data quality:

The data quality for the foreground system is very good with specific data for the year 2021 for all inputs and outputs from the recycling plant. The data quality is good for all the main material input which is primary aluminium and pre- and post-consumer scrap from specific suppliers. Data for the background system are mainly from ecoinvent 3.8 (Wernet et al. 2016 and Ecoinvent 2022) as implemented in the software SimaPro, version 9.3 (Pré 2022). Some data for background systems have also been collected and implemented in the model as part of the project.

Allocation:

The allocation is made in accordance with the provisions of EN 15804. Infrastructure of the plant, incoming energy, water and waste production in-house is allocated equally among all products (conversion volumes, full price/direct sales, and 75R) through mass allocation. Allocation between aluminium hydroxide and aluminium oxide in the production of alumina for primary metal added in the process are done through economic allocation. The potential environmental impacts from production of primary aluminium are not transferred to post-consumer recycled aluminium. Only the recycling process and transportation of the material is allocated to the post-consumer scrap used for the aluminium at the aluminium recycling plants producing 75R. Fig. 2 shows the incoming materials to the recycling plant and the return of materials from customers.

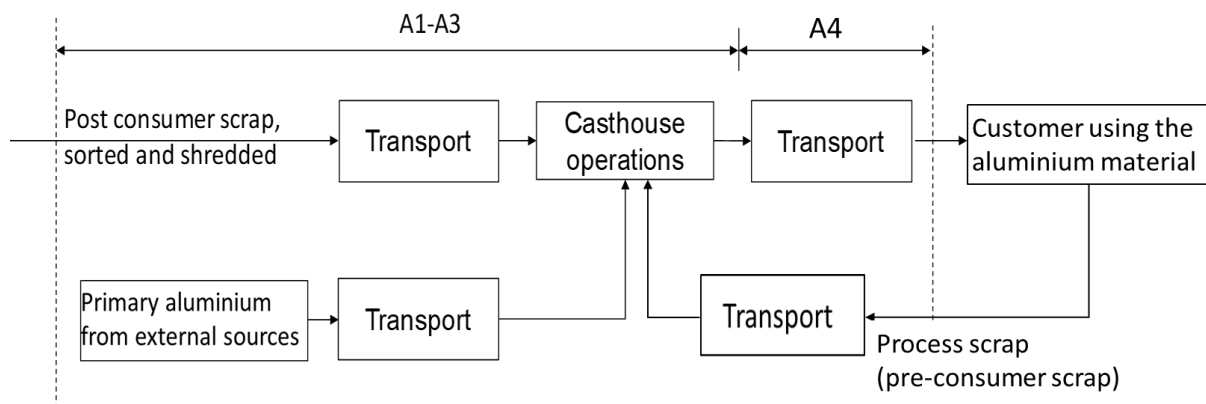


Fig. 2 Flow sheet for modules A1 – A4 for 1 kg of aluminium extrusion ingot from aluminium recycling plant.

At the far left of the figure, where post-consumer scrap and primary aluminium enters the process (from module A1), there are several different suppliers of both post-consumer scrap and primary aluminium. The names of these are not disclosed here for reasons of confidentiality. At the far right, there is an arrow with process scrap going back to cathouse operations. This flow is modelled as 'closed loop' recycling: in other words, it contains the embodied impacts of the initial material.

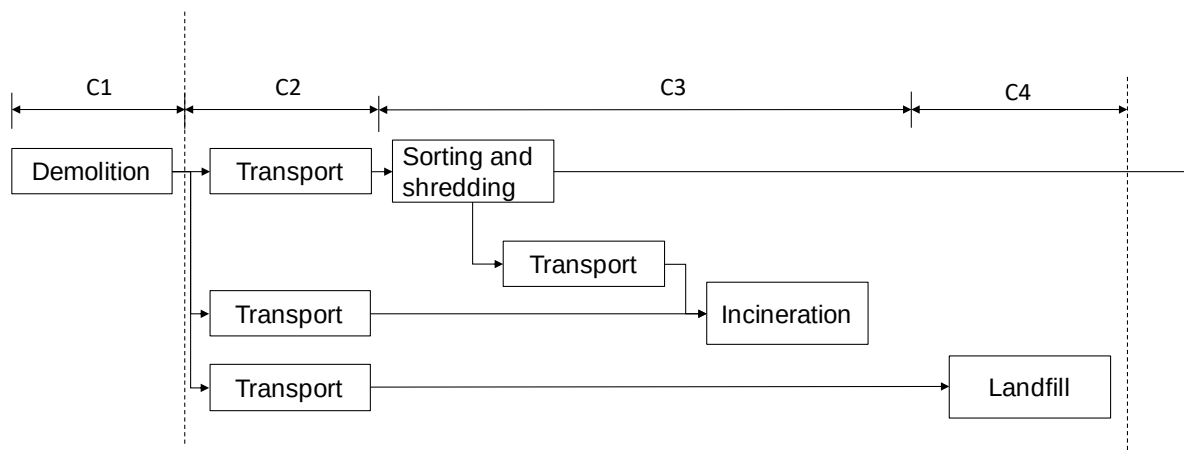


Fig. 3 Flow sheet for modules C1 – C4 for 1 of aluminium extrusion ingot after end of useful life. C1 is included but assumed negligible because the material and energy used to dismantle or demolish extruded aluminium is typically insignificant.

System boundary:

The system boundary is cradle-to-gate with options. The following stages have been declared: A1-A4, C1-C4, and D, which are specified in the process flow sheets shown in Figure 2 and 3. Module A5 and all modules B are not declared in this EPD because the extrusion ingot is used for many different applications.

Module D covers the potential benefits from the recycling of 75R aluminium extrusion ingot after end of life. Module D covers all necessary processes from C3 until the aluminium is back on the market and can be compared to the environmental performance of an average market aluminium extrusion ingot. The module is further specified in the section LCA: Scenarios and additional technical information.

Cut-off criteria:

All major raw materials and all the essential energy is included. Detailed production processes for raw materials and both renewable and non-renewable energy flows that are included with very small amounts (<1%) are not included.

When applying the cut-off criteria for this EPD, mass and energy flows have been gathered for the entire production system and all processes in the foreground system including A1 to A4. Cut-off has only been applied to module C1 where it is assumed that renewable and non-renewable energy and material use is less than 1% of the total use of materials, that none of these are hazardous and does not contribute to significant environmental impacts. The total exclusion of mass and energy flows is well below 5% per module and for the system in total.

LCA: Scenarios and additional technical information

The following information describe the scenarios in the different modules of the EPD.

Transport from production place to assembly/user (A4)

Module A4 describes the transport based on lorry from the production sites of 75R to the average customer location in Europe. The average distance is approximately 200 km. Values for capacity utilisation and fuel consumption is gathered from Hydro (2022) and ecoinvent (2016, updated 2022) as shown in Table 3.

Table 3 Specification of important parameters for module A4

Type	Capacity utilisation (incl. return) %	Type of vehicle	Distance KM	Fuel/Energy consumption value (l/tkm)
Truck	50	Lorry, >32 metric tons, Euro V	200	1.63E-02

End of Life (C1, C3, C4)

After end of useful life, most aluminium used for construction purposes is collected (approximately 96%) and recycled (approximately 97% of the collected aluminium), giving a total of 93% recycled aluminium. The aluminium is transported to a material processing site where different materials are sorted and sent to recycling. Hydro has a DNV certified process in the recycling plants and therefore, closed loop recycling is assumed for pre-consumer scrap, and open loop recycling to the same facility for the post-consumer scrap. Table 4 shows the material flows at the end of life for the product.

Table 4 The material quantities at the fate of the product after end of life.

	Unit	Value
Hazardous waste disposed	Kg	0
Collected as mixed construction waste	Kg	0.96
Reuse	Kg	0
Recycling	Kg	0.933
Energy recovery	Kg	0.027*
To landfill	Kg	0.04**

* 27 grams of the original 1 kilogram of aluminium is going to incineration. No loads or benefits are attributed to this flow.

** There will be a small portion of extruded aluminium ending as aggregate at the construction site. This is included under "To landfill" where no loads or benefits are included.

Transport to waste processing (C2)

Module C2 describes the transport back to the waste processing after the end of life. The model is based on real distances to Hydro facilities and data from ecoinvent (Hydro 2022 and ecoinvent 2016/2022) as shown in

Table 5.

Table 5 Specification of important parameters for module C2

Type	Capacity utilisation (incl. return) %	Type of vehicle	Distance KM	Fuel/Energy consumption value (l/tkm)
Truck	50	Lorry, >32 metric tons, Euro V	269	2.42E-02

Aluminium from the shredder to waste handling site is assumed to be transported in an older medium-sized lorry with smaller capacity utilization than in the production system.

Benefits and loads beyond the system boundaries (D)

Aluminium collected and recycled is assumed to replace a virgin aluminium product representing the European average primary aluminium used for extrusion ingot. The flow of material being sent to recycling and the actual amount of primary aluminium being substituted is shown in Table 6.

Table 6 The flow of material that replaces primary material in other life cycles.

	Unit	Value
Aluminium extrusion ingot to material recycling	g	190
Aluminium extrusion ingot recycled and substituting primary aluminium	g	123

The initial content of secondary material is not included in the calculations for module D, therefore only 190 grams of material is used in the calculations as sent to recycling. As described under “End of life” in Table 4, there is a loss in the handling of scrap metal after the end-of-waste state which means that 123 grams of primary aluminium is substituted. The entire loss is being calculated as primary material. This is a conservative assumption.

LCA: Results

All results are calculated with the use of SimaPro v.9.4 (2022) and impact methods according to ISO 15804+A2:2019.

System boundaries (X=included, MND= module not declared, MNR=module not relevant)

Product stage			Assembly stage		Use stage							End of life stage				Benefits & loads beyond system boundary
Raw materials	Transport	Manufacturing	Transport	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	X	MNR	MNR	MNR	MNR	MNR	MNR	MNR	MNR	X	X	X	X	X

Core environmental impact indicators

Indicator	Unit	A1-A3	A4	C1*	C2	C3	C4	D
GWP-total	kg CO2 eq.	1.86E+00	1.74E-02	0	2.54E-02	2.50E-01	6.14E-04	-1.11E+00
GWP-fossil	kg CO2 eq.	1.80E+00	1.74E-02	0	2.54E-02	2.46E-01	5.24E-04	-1.09E+00
GWP-biogenic	kg CO2 eq.	1.34E-02	1.85E-05	0	2.70E-05	3.30E-03	9.04E-05	-4.38E-03
GWP-LULUC	kg CO2 eq.	4.42E-02	6.53E-06	0	9.54E-06	1.15E-04	1.69E-07	-1.98E-02
ODP	kg CFC11 eq.	1.90E-07	4.34E-09	0	6.33E-09	9.71E-09	1.49E-10	-8.15E-08
AP	mol H ⁺ eq.	1.18E-02	5.54E-05	0	8.08E-05	8.10E-04	4.24E-06	-7.47E-03
EP-freshwater	kg P eq.	5.43E-05	1.24E-07	0	1.81E-07	9.05E-06	6.00E-09	-4.08E-04
EP-marine	kg N eq.	1.55E-03	1.22E-05	0	1.78E-05	8.98E-05	1.58E-06	-1.07E-03
EP-terrestrial	mol N eq.	1.74E-02	1.36E-04	0	1.97E-04	1.12E-03	1.78E-05	-1.05E-02
POCP	kg NMVOC eq.	5.99E-03	5.34E-05	0	7.78E-05	3.21E-04	5.04E-06	-3.51E-03
ADP-M&M	kg Sb eq.	3.40E-06	4.16E-08	0	6.12E-08	7.46E-06	2.81E-09	2.51E-06
ADP-fossil	MJ	2.38E+01	2.83E-01	0	4.13E-01	1.45E+00	1.23E-02	-1.36E+01
WDP	m ³	4.39E-01	9.74E-04	0	1.42E-03	1.47E-02	6.63E-05	-2.24E-01

GWP-total: Global Warming Potential; **GWP-fossil:** Global Warming Potential fossil fuels; **GWP-biogenic:** Global Warming Potential biogenic; **GWP-LULUC:** Global Warming Potential land use and land use change; **ODP:** Depletion potential of the stratospheric ozone layer; **AP:** Acidification potential, Accumulated Exceedance; **EP-freshwater:** Eutrophication potential, fraction of nutrients reaching freshwater end compartment; See “additional Norwegian requirements” for indicator given as PO₄ eq. **EP-marine:** Eutrophication potential, fraction of nutrients reaching freshwater end compartment; **EP-terrestrial:** Eutrophication potential, Accumulated Exceedance; **POCP:** Formation potential of tropospheric ozone; **ADP-M&M:** Abiotic depletion potential for non-fossil resources (minerals and metals); **ADP-fossil:** Abiotic depletion potential for fossil resources; **WDP:** Water deprivation potential, deprivation weighted water consumption

* C1 is assumed negligible, and the value is therefore set equal to zero. To show the uncertainty for this assumption, no decimals are used.

Additional environmental impact indicators

Indicator	Unit	A1-A3	A4	C1*	C2	C3	C4	D
PM	Disease incidence	1.38E-07	2.02E-09	0	2.93E-09	1.40E-08	8.67E-11	-8.55E-08
IRP	kBq U235 eq.	1.06E-01	1.23E-03	0	1.79E-03	3.42E-03	8.33E-05	-1.45E-01
ETP-fw	CTUe	3.67E+01	2.21E-01	0	3.23E-01	5.88E+00	2.48E+01	-1.87E+01
HTP-c	CTUh	4.11E-09	6.03E-12	0	8.82E-12	1.56E-10	1.15E-12	-2.67E-09
HTP-nc	CTUh	6.21E-08	2.33E-10	0	3.39E-10	6.75E-09	2.11E-11	-3.31E-08
SQP	Dimensionless	2.77E+00	3.24E-01	0	4.70E-01	1.43E+00	2.57E-02	-1.26E+00

PM: Particulate matter emissions; **IRP:** Ionising radiation, human health; **ETP-fw:** Ecotoxicity (freshwater); **ETP-c:** Human toxicity, cancer effects; **HTP-nc:** Human toxicity, non-cancer effects; **SQP:** Land use related impacts / soil quality

* C1 is assumed negligible, and the value is therefore set equal to zero. To show the uncertainty for this assumption, no decimals are used.

Classification of disclaimers to the declaration of core and additional environmental impact indicators

ILCD classification	Indicator	Disclaimer
ILCD type / level 1	Global warming potential (GWP)	None
	Depletion potential of the stratospheric ozone layer (ODP)	None
	Potential incidence of disease due to PM emissions (PM)	None
	Acidification potential, Accumulated Exceedance (AP)	None
	Eutrophication potential, Fraction of nutrients reaching marine end compartment (EP-marine)	None
ILCD type / level 2	Eutrophication potential, Accumulated Exceedance (EP-terrestrial)	None
	Formation potential of tropospheric ozone (POCP)	None
	Potential Human exposure efficiency relative to U235 (IRP)	1
ILCD type / level 3	Abiotic depletion potential for non-fossil resources (ADP-minerals&metals)	2
	Abiotic depletion potential for fossil resources (ADP-fossil)	2
	Water (user) deprivation potential, deprivation-weighted water consumption (WDP)	2
	Potential Comparative Toxic Unit for ecosystems (ETP-fw)	2
	Potential Comparative Toxic Unit for humans (HTP-c)	2
	Potential Comparative Toxic Unit for humans (HTP-nc)	2
	Potential Soil quality index (SQP)	2
Disclaimer 1 – This impact category deals mainly with the eventual impact of low dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure nor due to radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, from radon and from some construction materials is also not measured by this indicator.		
Disclaimer 2 – The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experienced with the indicator		

Resource use

Indicator	Unit	A1-A3	A4	C1*	C2	C3	C4	D
RPEE	MJ	1.11E+01	3.61E-03	0	5.28E-03	1.99E-01	2.29E-03	-4.85E+00
RPEM	MJ	0.00E+00	0.00E+00	0	0.00E+00	0.00E+00	0.00E+00	0.00E+00
TPE	MJ	1.11E+01	3.61E-03	0	5.28E-03	1.99E-01	2.29E-03	-4.85E+00
NRPE	MJ	2.38E+01	2.83E-01	0	4.13E-01	1.45E+00	1.23E-02	-1.36E+01
NRPM	MJ	0.00E+00	0.00E+00	0	0.00E+00	0.00E+00	0.00E+00	0.00E+00
TRPE	MJ	2.38E+01	2.83E-01	0	4.13E-01	1.45E+00	1.23E-02	-1.36E+01
SM	kg	8.89E-01	0.00E+00	0	0.00E+00	0.00E+00	0.00E+00	-1.23E-01
RSF	MJ	0.00E+00	0.00E+00	0	0.00E+00	0.00E+00	0.00E+00	0.00E+00
NRSF	MJ	0.00E+00	0.00E+00	0	0.00E+00	0.00E+00	0.00E+00	0.00E+00
W	m ³	7.35E-02	3.37E-05	0	4.91E-05	8.09E-04	1.78E-05	-2.66E-02

RPEE Renewable primary energy resources used as energy carrier; **RPEM** Renewable primary energy resources used as raw materials; **TPE** Total use of renewable primary energy resources; **NRPE** Non-renewable primary energy resources used as energy carrier; **NRPM** Non-renewable primary energy resources used as materials; **TRPE** Total use of non-renewable primary energy resources; **SM** Use of secondary materials; **RSF** Use of renewable secondary fuels; **NRSF** Use of non-renewable secondary fuels; **W** Use of net fresh water

* C1 is assumed negligible, and the value is therefore set equal to zero. To show the uncertainty for this assumption, no decimals are used.

End of life - Waste

Indicator	Unit	A1-A3	A4	C1*	C2	C3	C4	D
HW	kg	1.86E-03	6.85E-07	0	1.00E-06	6.17E-03	1.51E-08	-3.21E-04
NHW	kg	9.41E-01	2.81E-02	0	4.08E-02	1.25E+00	8.22E-02	-5.39E-01
RW	kg	1.02E-04	1.92E-06	0	2.80E-06	4.25E-06	8.49E-08	-5.59E-05

HW Hazardous waste disposed; **NHW** Non-hazardous waste disposed; **RW** Radioactive waste disposed.

* C1 is assumed negligible, and the value is therefore set equal to zero. To show the uncertainty for this assumption, no decimals are used.

End of life – output flow

Indicator	Unit	A1-A3	A4	C1*	C2	C3	C4	D
CR	kg	0.00E+00	0.00E+00	0	0.00E+00	0.00E+00	0.00E+00	0.00E+00
MR	kg	7.99E-01	0.00E+00	0	0.00E+00	9.33E-01	0.00E+00	0.00E+00
MER	kg	0.00E+00	0.00E+00	0	0.00E+00	2.56E-02	0.00E+00	0.00E+00
EEE	MJ	1.66E-04	0.00E+00	0	0.00E+00	0.00E+00	0.00E+00	0.00E+00
ETE	MJ	2.98E-04	0.00E+00	0	0.00E+00	0.00E+00	0.00E+00	0.00E+00

CR Components for reuse; **MR** Materials for recycling; **MER** Materials for energy recovery; **EEE** Exported electric energy; **ETE** Exported thermal energy.

* C1 is assumed negligible, and the value is therefore set equal to zero. To show the uncertainty for this assumption, no decimals are used.

Reading example: $9.0 \text{ E-03} = 9.0 \times 10^{-3} = 0.009$

Information describing the biogenic carbon content at the factory gate

Biogenic carbon content	Unit	Value
Biogenic carbon content in product	kg C	0
Biogenic carbon content in the accompanying packaging	kg C	0

Additional requirements

Greenhouse gas emission from the use of electricity in the manufacturing phase

National production mix from import, low voltage (production of transmission lines, in addition to direct emissions and losses in grid) of applied electricity for the manufacturing process A3 as calculated from ecoinvent 3.8. In addition, the residual electricity mix is reported as given in AIB (2022), except for UK which is given in Carbon Footprint (2023).

Geographical location	National electricity mix [kg CO ₂ -eq/kWh]	Residual electricity mix [kg CO ₂ -eq/kWh]	Electricity used in foreground system [kWh/kg product]	Difference in GWP-total for A1-A3 [kg CO ₂ -eq]
Spain	0.33	0.3	0.13	-3.90E-03
Luxembourg	0.53	0.4	0.089	-1.16E-02
UK	0.31	0.35	0.1	4.00E-03
Average	0.39	0.35	0.11	-3.82E-03

The fact that the value for the national electricity mix is higher than the residual electricity mix for three of five locations shows that using different data sources for these electricity mixes can make non-sensical results. The result for GWP-total would *decrease* with 3.82e-03 if values for the contribution to climate change for residual electricity mix is used instead of the values for the national electricity mix.

Additional environmental impact indicators required in NPCR Part A for construction products

In order to increase the transparency of biogenic carbon contribution to climate impact, the indicator GWP-IOBC is required as it declares climate impacts calculated according to the principle of instantaneous oxidation. GWP-IOBC is also referred to as GWP-GHG in context to Swedish public procurement legislation.

Indicator	Unit	A1-A3	A4	C1*	C2	C3	C4	D
GWP-IOBC	kg CO ₂ eq	1.86E+00	2.61E-02	0	2.56E-02	2.47E-01	5.26E-04	-1.11E+00

GWP-IOBC Global warming potential calculated according to the principle of instantaneous oxidation.

* C1 is assumed negligible, and the value is therefore set equal to zero. To show the uncertainty for this assumption, no decimals are used.

Hazardous substances

The declaration is based upon reference to threshold values and/or test results and/or material safety data sheets provided to EPD verifiers. Documentation available upon request to EPD owner.

- X The product contains no substances given by the REACH Candidate list or the Norwegian priority list.
- ☐ The product contains substances given by the REACH Candidate list or the Norwegian priority list that are less than 0,1 % by weight.
- ☐ The product contains dangerous substances, more then 0,1% by weight, given by the REACH Candidate List or the Norwegian Priority list, see table.
- ☐ The product contains no substances given by the REACH Candidate list or the Norwegian priority list. The product is classified as hazardous waste (Avfallsforskriften, Annex III), see table.

Indoor environment

Not relevant

Carbon footprint

An individual carbon footprint has not been worked out for the product but impacts connected to climate change is reported in this EPD.

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Iserlohn, 16.03.2026

Unternehmenserklärung Köster Advance 75 / Köster Advance 88

Sehr geehrte Damen und Herren,

gerne bestätigen wir Ihnen mit dieser Mitteilung, dass nachstehendes Aluminiumprodukt aus unserem Hause:

- **Köster Advance 75**
- **Köster Advance 88**

folgende Kriterien erfüllt:

- Chrom-VI-oxidfreie Passivierungsmittel nach BNB / 27
- Chrom-VI-freie Passivierungsmittel nach DGNB / 32
- Keine Stoffe SVHC sowie CMR der Kat. 1A/1B < 0,1%, nach EU-Taxonomie

Mit freundlichen Grüßen


Ralf Stolte

Geschäftsführer

Köster Aluminium GmbH & Co. KG

KÖSTER ALUMINIUM GMBH & CO. KG

Geschäftsführer: Ralf Stolte

Amtsgericht Iserlohn HRA 2047

Bank

Deutsche Bank Iserlohn
Volksbank im Märkischen Kreis eG

BLZ

445 700 04
447 615 34

Kto.-Nr.

0 330 175
2 300 265 800

IBAN

DE42 4457 0004 0033 0175 00
DE20 4476 1534 2300 2658 00

SWIFT-BIC

DEUTDEDW445
GENODEM1NRD

Komplementär:
Köster Aluminium Management GmbH
USt-IdNr.: DE209438499

Handelsregister Iserlohn: HRB 2390
St.-Nr.: 328 5723 0236



ZERTIFIKAT

Köster Aluminium GmbH & Co.KG

Hiermit bestätigen wir unserem WICONA Partner den Einsatz von Systemlösungen aus dem hochwertigen End of Life (EoL) Aluminium Hydro CIRCAL.

Damit unterstreicht das Unternehmen seinen verantwortungsvollen Umgang mit wertvollen Rohstoff-Ressourcen und zeigt ein aktives Engagement für mehr Nachhaltigkeit in der Gebäudehülle.

Ihr Beitrag zum Klimaschutz im Zeitraum Januar 2024 bis Dezember 2024:

447 Tonnen Hydro CIRCAL
= Einsparung von 3.486,6 Tonnen CO₂*

WICONA®

By  Hydro

* Im Vergleich zu Primär-Aluminium im Europäischen Verbrauchsmix.



Hydro

REDUXA®

Low-Carbon
Aluminium



Hydro

CIRCAL®

Recycled
Aluminium

2023

ZERTIFIKAT

Köster Aluminium GmbH & Co. KG

Hiermit bestätigen wir unserem Partner für das Jahr 2023 den Einsatz von WICONA Systemlösungen aus hochwertigen Aluminiumlegierungen mit besonders niedrigen CO₂-Emissionen.

Mit der Entscheidung für Hydro REDUXA und/oder Hydro CIRCAL unterstreicht das Unternehmen seinen verantwortungsvollen Umgang mit wertvollen Rohstoff-Ressourcen, zeigt ein aktives Engagement für mehr Nachhaltigkeit in der Gebäudehülle – und wird zum Mitstreiter für wirksamen Klimaschutz.

Gemeinsamer Beitrag zur Senkung der CO₂-Emissionen:



CO₂-Reduzierung durch
Hydro REDUXA und Hydro CIRCAL

2.306 Tonnen*



Entspricht eingesparten
Auto-Kilometern

11.532.345**

WICONA®

By  Hydro

Quellen / Berechnungsgrundlagen: *Hydro REDUXA (4,0 kg CO₂ / kg Aluminium), Hydro CIRCAL (2,3 kg CO₂ / kg Aluminium) vs. Primäraluminium Europa (8,6 kg CO₂ / kg Aluminium), EAA 2018 | **<https://spritrechner.biz/co2-rechner-fuer-autos.html>