



SHI PRODUCT PASSPORT

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SHI Product Passport No.:

15548-10-1001

Aluminium Haustür KÖSTER Advance 88

Product group: Doors & Gates - Front doors - Interior construction



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



Product qualities:



Köttner

Helmut Köttner
Scientific Director

Freiburg, 19 March 2026



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The SHI Database is the first and only database for construction products whose comprehensive processes and data accuracy are regularly verified by the independent auditing company SGS-TÜV Saar





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SHI Product Assessment 2024

Since 2008, Sentinel Holding Institut GmbH (SHI) has been establishing a unique standard for products that support healthy indoor air. Experts carry out independent product assessments based on clear and transparent criteria. In addition, the independent testing company SGS regularly audits the processes and data accuracy.

Criteria	Product category	Harmful substance limit	Assessment
SHI Product Assessment	Other products	TVOC $\leq 300 \mu\text{g}/\text{m}^3$ Formaldehyd $\leq 24 \mu\text{g}/\text{m}^3$	Indoor Air Quality Certified



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QNG - Qualitätssiegel Nachhaltiges Gebäude

The Qualitätssiegel Nachhaltiges Gebäude (Quality Seal for Sustainable Buildings), developed by the German Federal Ministry for Housing, Urban Development and Building (BMWSB), defines requirements for the ecological, socio-cultural, and economic quality of buildings. The Sentinel Holding Institut evaluates construction products in accordance with QNG requirements for certification and awards the QNG ready label. Compliance with the QNG standard is a prerequisite for eligibility for the KfW funding programme. For certain product groups, the QNG currently has no specific requirements defined. Although classified as not assessment-relevant, these products remain suitable for QNG-certified projects.

Criteria	Pos. / product group	Considered substances	QNG assessment
3.1.3 Schadstoffvermeidung in Baumaterialien			QNG ready - Not relevant for assessment



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DGNB New Construction 2023

The DGNB System (German Sustainable Building Council) assesses the sustainability of various types of buildings. It can be applied to both large-scale private and commercial projects as well as smaller residential buildings. The 2023 version sets high standards for ecological, economic, socio-cultural, and functional aspects throughout the entire life cycle of a building.

Criteria	Assessment
ENV1.1 Climate action and energy (*)	May positively contribute to the overall building score
Verification: WICONA Zertifikat Hydro CIRCAL, Die Energieersparnis im Herstellungsprozess beträgt dabei bis zu 95% im Vergleich zu herkömmlichem Aluminium.	

Criteria	Assessment
ECO1.1 Life cycle cost (*)	May positively contribute to the overall building score
Verification: Leistungserklärung des Produktes (individuell zum Auftrag), WICONA Zertifikat Hydro CIRCAL	

Criteria	Assessment
ECO2.6 Climate resilience (*)	May positively contribute to the overall building score
Verification: Leistungserklärung des Produktes (individuell zum Auftrag)	

Criteria	Assessment
SOC1.1 Thermal comfort (*)	May positively contribute to the overall building score
Verification: Produkteigenschaften	

Criteria	Assessment
SOC1.3 Sound insulation and acoustic comfort (*)	May positively contribute to the overall building score
Verification: Prüfbericht für Modell 5510	



Criteria	Assessment
SOC2.1 Barrier-free design (*)	May positively contribute to the overall building score

Criteria	Assessment
TEC1.3 Quality of the building envelope (*)	May positively contribute to the overall building score
Verification: Leistungserklärung des Produkts	

Criteria	Assessment
TEC1.4 Use and integration of building technology (*)	May positively contribute to the overall building score
Verification: Optionale motorische Verriegelungen möglich	

Criteria	No. / Relevant building components / construction materials / surfaces	Considered substances / aspects	Quality level
ENV 1.2 Local environmental impact, 03.05.2024 (3rd edition)	32 All of the shell's aluminium and stainless steel building components.	Chromium VI	Quality level 4
Verification: Herstellererklärung vom 16.03.2026			

Criteria	No. / Relevant building components / construction materials / surfaces	Considered substances / aspects	Quality level
ENV 1.2 Local environmental impact, 29.05.2025 (4th edition)	32 All of the shell's aluminium and stainless steel building components	Chromium VI	Quality level 4
Verification: Herstellererklärung vom 16.03.2026			



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DGNB New Construction 2018

The DGNB System (German Sustainable Building Council) assesses the sustainability of various types of buildings. It can be applied to both large-scale private and commercial projects as well as smaller residential buildings.

Criteria	No. / Relevant building components / construction materials / surfaces	Considered substances / aspects	Quality level
ENV 1.2 Local environmental impact	32 All aluminium and stainless steel components in the building envelope	Chromium VI	Quality level 4
Verification: Herstellererklärung vom 16.03.2026			



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BNB-BN Neubau V2015

The Bewertungssystem Nachhaltiges Bauen (Assessment System for Sustainable Building) is a tool for evaluating public office and administrative buildings, educational facilities, laboratory buildings, and outdoor areas in Germany. The BNB was developed by the former Federal Ministry for the Environment, Nature Conservation, Building and Nuclear Safety (BMUB) and is now overseen by the Federal Ministry for Housing, Urban Development and Building (BMWSB).

Criteria	Pos. / product type	Considered substance group	Quality level
1.1.6 Risiken für die lokale Umwelt	27 Anodized aluminum and passivated stainless steel surfaces	Heavy metals (chromium VI)	Quality level 5

Verification: Herstellererklärung vom 16.03.2026



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EU taxonomy

The EU Taxonomy classifies economic activities and products according to their environmental impact. At the product level, the EU regulation defines clear requirements for harmful substances, formaldehyde and volatile organic compounds (VOCs). The Sentinel Holding Institut GmbH labels qualified products that meet this standard.

Criteria	Product type	Considered substances	Assessment
DNSH - Pollution prevention and control		Substances according to Annex C	EU taxonomy compliant

Verification: Herstellererklärung vom 16.03.2026



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BREEAM DE Neubau 2018

BREEAM (Building Research Establishment Environmental Assessment Methodology) is a UK-based building assessment system that evaluates the sustainability of new constructions, refurbishments, and conversions. Developed by the Building Research Establishment (BRE), the system aims to assess and improve the environmental, economic, and social performance of buildings.

Criteria	Product category	Considered substances	Quality level
Hea 02 Indoor Air Quality			Not relevant for assessment



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LEED v4.1

LEED (Leadership in Energy and Environmental Design) is an internationally recognised building certification system developed by the U.S. Green Building Council. It is one of the most widely used sustainability standards for buildings worldwide and is particularly applied in internationally oriented projects. LEED assesses buildings holistically across categories such as energy efficiency, resource conservation, material selection, indoor environmental quality and site sustainability. Depending on the number of points achieved, projects are awarded one of the certification levels: LEED Certified, Silver, Gold or Platinum.

Criteria	Product category	Assessment
EQ Credit: Low-Emitting Materials		Not relevant for assessment



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Product labels

In the construction industry, high-quality materials are crucial for a building's indoor air quality and sustainability. Product labels and certificates offer guidance to meet these requirements. However, the evaluation criteria of these labels vary, and it is important to carefully assess them to ensure products align with the specific needs of a construction project.



EPD-Norge is the Norwegian program operator for Environmental Product Declarations (EPDs). The program follows ISO 14025 and EN 15804 and ensures that EPDs for construction and industrial products are published in a consistent, verified and comparable manner. Before publication, each EPD undergoes independent third-party verification; EPD-Norge provides clear procedures, Product Category Rules (PCR/NPCR) and a public register for this purpose.



Products bearing the Sentinel Holding Institute QNG-ready seal are suitable for projects aiming to achieve the "Qualitätssiegel Nachhaltiges Gebäude" (Quality Seal for Sustainable Buildings). QNG-ready products meet the requirements of QNG Appendix Document 3.1.3, "Avoidance of Harmful Substances in Building Materials." The KfW loan program Climate-Friendly New Construction with QNG may allow for additional funding.



This product is SHI Indoor Air Quality certified and recommended by Sentinel Holding Institut. Indoor-air-focused construction, renovation, and operation of buildings is made possible by transparent and verifiable criteria thanks to the Sentinel Holding concept.



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Legal notices

(*) These criteria apply to the construction project as a whole. While individual products can positively contribute to the overall building score through proper planning, the evaluation is always conducted at the building level. The information was provided entirely by the manufacturer.

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

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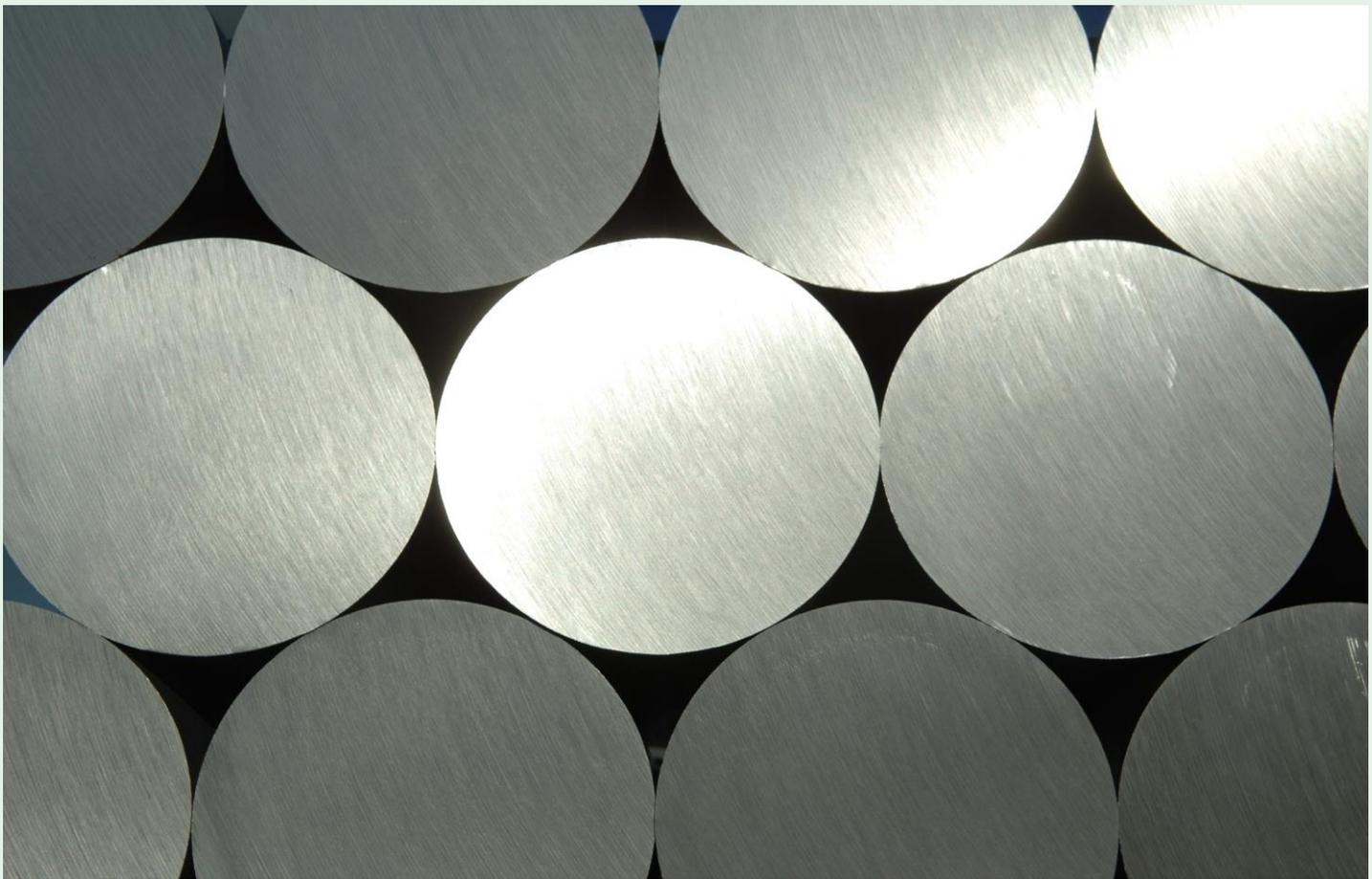
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www.sentinel-holding.eu

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 Høibye

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)

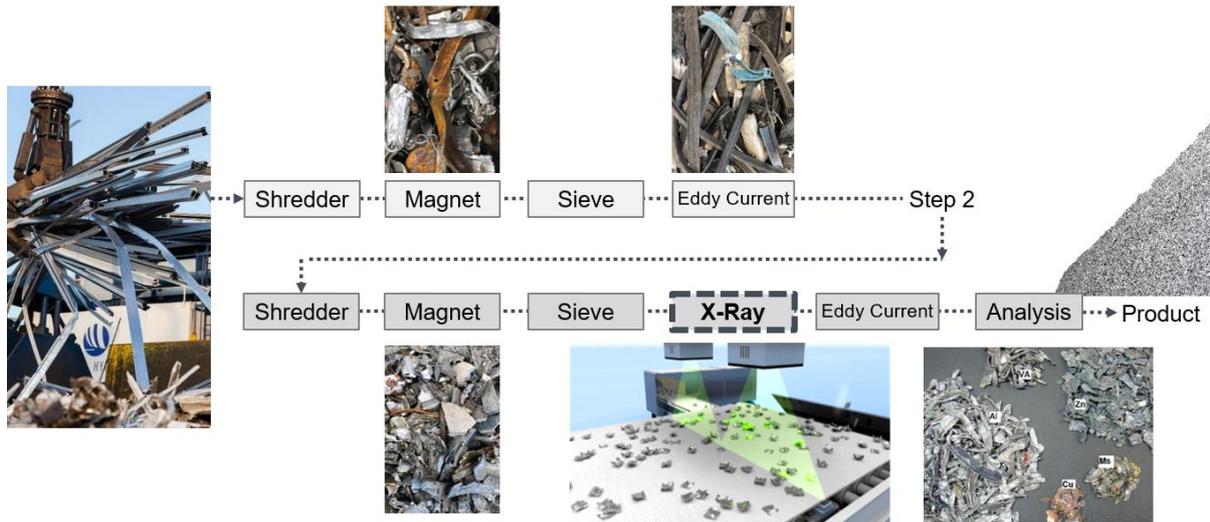
Hydro 75R

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.

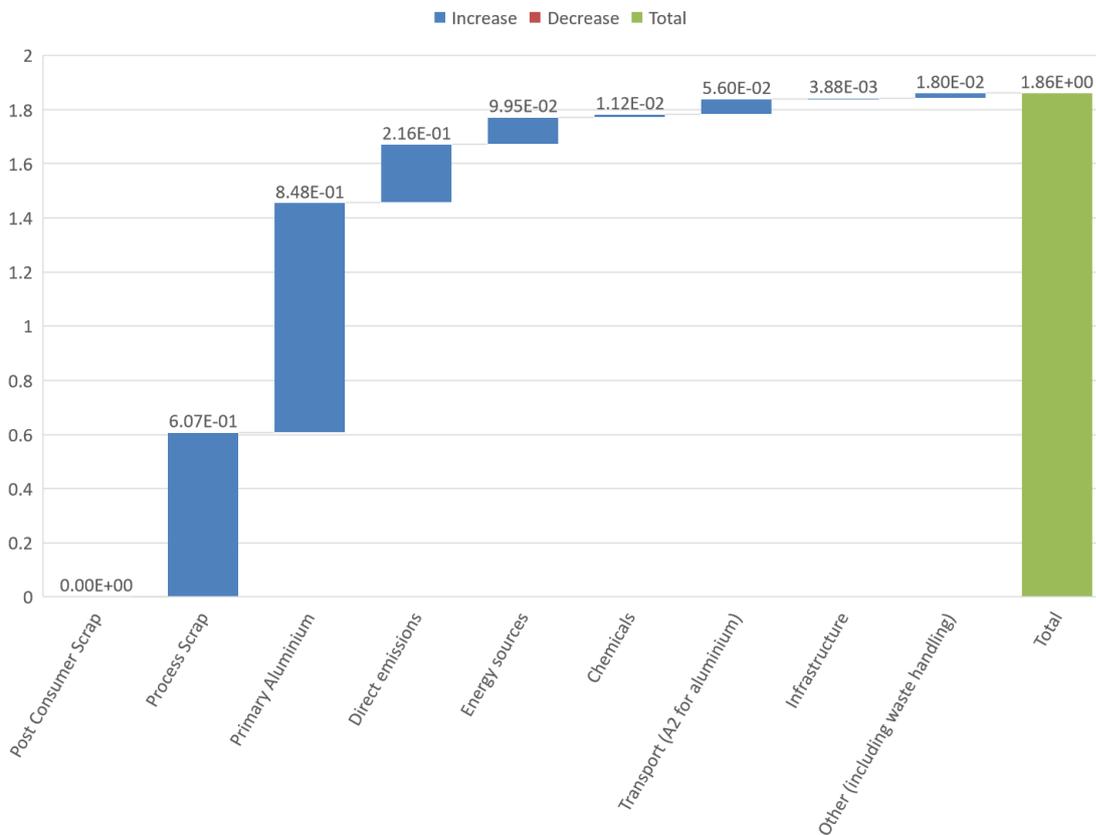


Fig. 1 Waterflow diagram showing the contributions to climate change (GWP-Total in kg CO₂/kg Al) for 75R for modules A1-A3.

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.

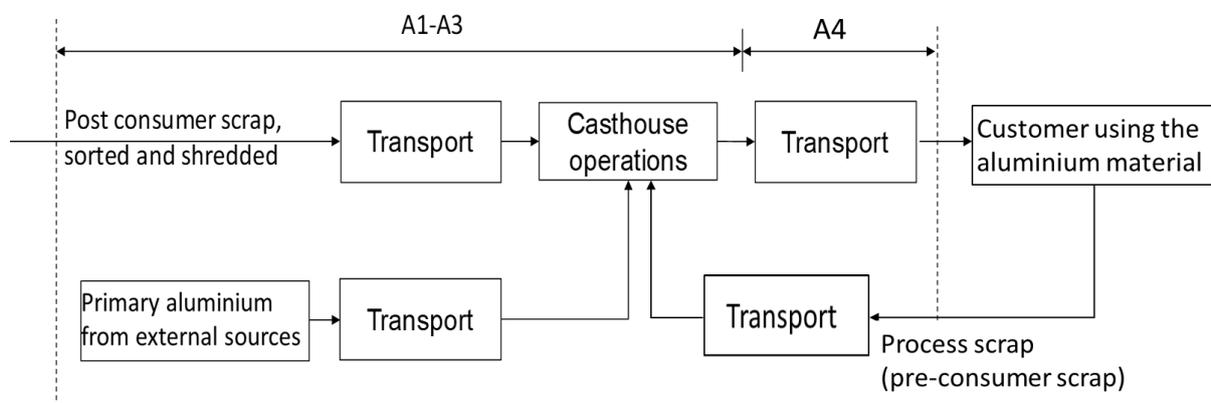


Fig. 2 Flow sheet for modules A1 – A4 for 1 kg of aluminium extrusion ingot from aluminium recycling plant.

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 casthouse operations. This flow is modelled as ‘closed loop’ recycling: in other words, it contains the embodied impacts of the initial material.

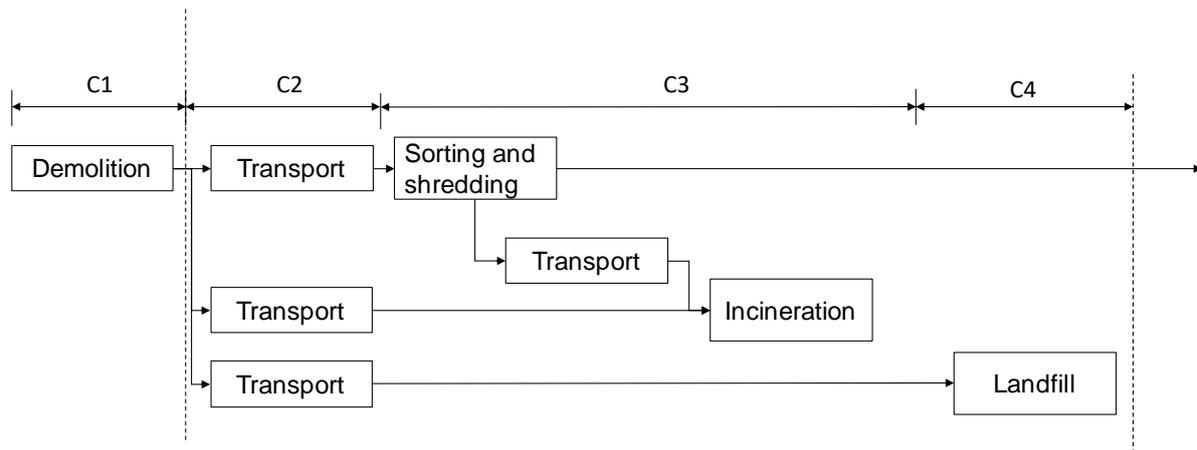


Fig. 3 Flow sheet for modules C1 – C4 for 1 of aluminium extrusion ingot after end of useful life. C1 is included but assumed negligible because the material and energy used to dismantle or demolish extruded aluminium is typically insignificant.

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
<p>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.</p>		
<p>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</p>		

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: $9.0 \text{ E-03} = 9.0 \cdot 10^{-3} = 0.009$

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 fromecoinvent 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

Unternehmensklärung 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



Hydro

CIRCAL[®]

*Recycled
Aluminium*

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.



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