

Environmental Product Declaration (EPD)



In accordance with ISO 14025:2006 and EN 15804:2012+A2:2019/AC:2021 standards for:

High-Frequency Welded carbon steel pipes (HFW)

Manufactured by

**Amenduni Tubi Acciaio S.r.l. at the Alessio Tubi S.p.A.
plant**



EPD of multiple products, based on the average results of the group of products.
It covers electro-welded carbon steel pipes for structural, steelwork and pipeline applications.

Programme:

Programme operator:

Registration number:

Release date:

Valid until:

Revision date:

The International EPD® System, www.environdec.com

EPD International AB

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2024-06-25

2029-06-25

2024-09-09

An Environmental Product Declaration must provide up-to-date information and it can be revised when conditions change. The declared validity is therefore subject to maintaining registration and publication at www.environdec.com



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General information

About the programme

Programme:	The International EPD® System
Address:	EPD International AB Box 210 60 SE-100 31 Stockholm Sweden
Website:	www.environdec.com
E-mail:	info@environdec.com

Responsibility for Product Category Rules (PCR), Life-Cycle Assessment (LCA) and third-party verification

Product Category Rules (PCR)

CEN standard EN 15804 serves as the *core Product Category Rules (PCR)*

Product category rule (PCR): Construction products, 2019:14, version 1.3.4

Review of the PCR conducted by the *technical committee of the International EPD® System*. Please log on to www.environdec.com for the list of members. Review chaired by Claudia A. Peña, University of Concepción, Chile. The review team can be contacted via the Secretariat at www.environdec.com/contact

Life Cycle Assessment (LCA)

LCA accountability: *Studio Fieschi & soci s.r.l., 18 C.so Vittorio Emanuele II, 10123 Turin, IT - www.studiofieschi.it*

Third-party verification

Independent third-party verification of declaration and data, according to ISO 14025:2006 via:

☒ EPD verification by an individual verifier.

Third-party verifier: *Guido Croce*.

Approved by: The International EPD® System

Data follow-up procedure during EPD validity involves a third-party verifier:

☐ Yes ☒ No

The company Amenduni Tubi Acciaio S.r.l. is the sole owner and is responsible for the EPD.

EPDs belonging to the same product category but registered under different EPD programmes, or which are not conforming to EN 15804, cannot be made comparable. In order for two EPDs to be comparable, they must be based on the same PCR (including the same version number) or be based on fully aligned PCRs or PCR versions; cover products with identical functions, technical performance and use (e.g. identical units declared/functional); have equivalent system boundaries and equivalent data descriptions; apply equivalent data quality requirements, data collection and equivalent allocation methods; apply identical *cut-off* rules and impact assessment methods (including the same version of characterisation factors); have equivalent and valid content statements at the time of comparison. For further information on comparability, please refer to EN 15804 and ISO 14025.

Product information

Product name: high-frequency induction-welded carbon steel pipes.

Company details

EPD owner

Amenduni Tubi Acciaio S.r.l.

REGISTERED OFFICE

20, Corso Porta Nuova - 20121 Milan

VAT and tax ID number 06651880962

HEADQUARTERS

240/242, Via G. Mazzini

25020 Alfianello (BS)

www.amendunitubi.it

The product is manufactured at the Alessio Tubi plant
20, Strada Statale, Km. 4 – La Loggia (Turin), Italy

Contact

ata.srl@arubapec.it

Description of the organisation

Alessio Tubi has been producing welded carbon steel pipes in round, square and rectangular cross-sections since 1960, targeting both national and international markets. The company is located in the Turin industrial area of La Loggia, close to the most important communication routes. Beside the production of the standard electro-welded pipe, intended for general use, in the past years the company has equipped itself with specific finishing and non-destructive testing equipment and has developed a tubular product for pipelines, intended for use in the oil, natural gas, water and combustible fluids sectors in general. In more recent years, appropriate market awareness of the use of tubular products for structural applications has enabled the company to become a leader in Italy and the rest of Europe in this specific sector.

The type of products produced place Alessio Tubi in a highly competitive free market served by many other major manufacturers; despite the high level of competition, product quality and service reliability (lead times, customer focus, promptness in providing information, the option of offering products with various certifications) are key factors thanks to which Alessio Tubi has succeeded in developing and maintaining a loyal customer base over time. Alessio Tubi implements and maintains a Quality Management System compliant with the requirements of UNI EN ISO 9001:2015 and API Spec. Q1; the Quality System was launched in 1988.

This System is intended as a corporate means for streamlining and ongoing improvement of the company's operations with a view to achieving the required Quality, in order for it to meet the specified standards and any additional requirements of the Customer.

Product certifications:

- TÜV certification for products intended for use in pressure systems with reference to specifications AD 2000-Merkblatt W0/W4 Pressure Equipment Directive 2014/68/EU, Annex I, Section 4.3.
- Reference standards EN 10217, parts 1/2/3.
- TÜV certification of products for pressure, water and gas transportation, reference standard EN 10255.
- IGQ certification for cold-formed construction products used in accordance with CPR 305/2011 - CE marking.
- Reference standard EN 10219.
- IGQ certification for hot-finished construction products, used in accordance with CPR 305/2011 - CE marking.
- API 5L - 0115 Certification for products intended for use in the oil and gas pipeline industry.
- Reference standard API 5L.
- API 5CT certification - 0144 for products intended for use in the oil drilling industry.
- API 5CT Reference standard.

Product identification and description

High-frequency induction-welded steel pipes (HFW) produced in accordance with the following standards:

- EN 10219-1/2;
- EN 10217-1/2/3;
- EN 10224;
- EN ISO 3183;
- EN 10255;
- EN 10305-3/5;
- ASTM A53/ASME SA53;
- ASTM A500;
- ASTM A252;
- ASTM A795;
- ASTM A135;
- API 5L;
- API 5CT.

The carbon steel pipes produced by Alessio Tubi, according to EN European standard and API and/or ASTM American standards can be used in multiple sectors and uses such as:

- Pressure applications in numerous industrial and civil sectors;
- Construction of water, gas or oil pipelines;
- Construction of pipelines for oil extraction;
- Civil and industrial construction engineering;
- Structures and plants subjected to dynamic loads;
- Mechanical industry applications;
- Agricultural sector applications;
- General use.

The production process takes place in the following stages:

- ↓ Coils reception;
- ↓ Cutting in strips;
- ↓ Shaping of the strip in a circular section;
- ↓ High-Frequency Welding (HFW);
- ↓ Heat treatment for welding normalisation;
- ↓ In-line eddy current testing;
- ↓ Ultrasound welding testing;
- ↓ Final gauging/sizing;
- ↓ Cutting to size;
- ↓ End-to-end butt joining;
- ↓ Hydraulic pressure testing;
- ↓ Non-destructive final checks with Flux leakage;
- ↓ Marking;
- ↓ Bundling and identification;
- ↓ Storage.

All product tests checking compliance of the mechanical properties and the chemical analysis required by the reference standard are carried out in the in-house test laboratory.

The test laboratory shall carry out:

- Tensile tests;
- Impact strength tests;
- Spectrometric chemical analysis;
- Metallographic analysis (micrographs, macrographs, micro-hardness).

UN CPC Coding

41285 - Line pipe of a kind used for oil or gas pipelines, welded, of steel

41286 - Casing and tubing, of a kind used in the drilling for oil or gas, welded, of steel

41287 - Other tubes and pipes, of circular cross-section, welded, of steel

41288 - Tubes and pipes, of non-circular cross-section, welded, of steel

Geographical scope: global

LCA information

Unit declared: 1 tonne of packed steel pipe, ready for shipment (average profile calculated as the arithmetic mean between the environmental profile of the product that undergoes the most and the least processing/refining).

Reference service life: NA

Time representativeness: all data on product composition, production and distribution refer to the year 2023. Secondary data are the most recent available at the time of the study and are representative for the period 2018-2023.

Database(s) and LCA software used: Ecoinvent v.3.9.1, SimaPro v.9.6.0.1

Mandatory environmental impact indicators method EN 15804+A2 based on EF 3.1 characterisation factors.

System boundaries

For the products subject to study, the boundaries defined as '*cradle-to-gate*' with modules C1-C4 and D are adopted, i.e. including modules A1-A3 + C + D.

Modules A4-A5 and modules B1-B7 are excluded.

System boundaries include:

- **A1:** production of raw materials and semi-finished steel products and other components required to manufacture the product;
- **A2:** transport of raw materials (semi-finished products, purchase components) to the company's production site;
- **A3:** manufacture of products at the company's production site. Production and consumption of electricity used in production processes. Production and consumption of fossil fuels used for internal product handling, disposal of waste (including packaging) produced by the factory. The processes covered by this module include:
 - receiving coils;
 - cutting coils into strips;
 - profiling:
 - forming the strip into a round shape
 - welding
 - final gauging/sizing
 - cutting to length
 - finishing (for rebar and ducts only);
 - packaging, storage and loading for shipment.
- **C1:** dismantling and demolition process;
- **C2:** waste transfer to processing/disposal points;
- **C3:** waste processing prior to recovery/recycling;
- **C4:** final disposal.

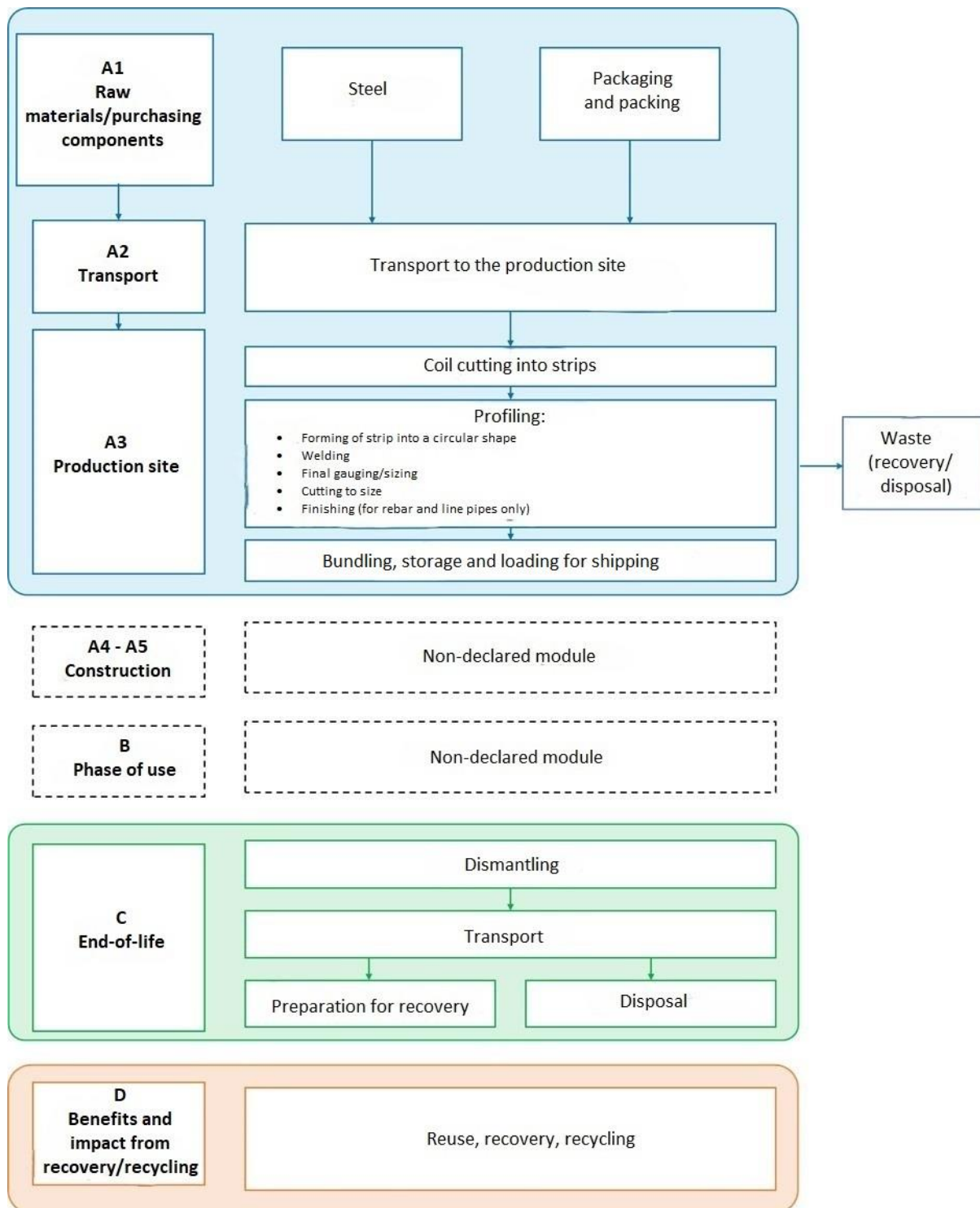
Module D: potential benefits and impact related to recovery-reuse-recycling of materials and energy throughout the life-cycle. In this module an assessment is made of the benefits and/or impact related to the potential recycling of end-life materials making up the products under study. The modelling of recovery-reuse-recycling benefits is carried out according to EN 15804:2012 + A2:2019 § 6.4.3.3 requirements.

The system boundaries do not include:

- A4-A5 relating to the distribution and installation of the product;
- Staff-related impact (e.g. commuting to and from work, electricity and water consumption in offices, etc.);
- Impact related to the production and transport of incoming semi-finished packaging materials;
- Input and output flows related to the implementation of end-of-life of capital goods and infrastructure¹, in accordance with PCR 2019:14 (§4.3.2) requirements.

¹ The exclusion of capital goods and infrastructure is limited to core processes (foreground processes, modelled directly in the study). Impact related to these processes could still be included in the background data (e.g. Ecoinvent data).

System boundaries



Additional information: modules C and D are tailored on the basis of product distribution volumes.

Modules declared

Geographical scope, share of specific data (in GWP-GHG results) and data variation (in GWP-GHG results):

	Product stage			Construction process stage		Use stage							End-of-life stage				Resource recovery stage
	Raw material supply	Transport	Manufacturing	Transport	Construction installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
Module	A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Modules declared	X	X	X	ND	ND	ND	ND	ND	ND	ND	ND	ND	X	X	X	X	X
Geography	GLO	GLO	IT	-	-	-	-	-	-	-	-	-	GLO	GLO	GLO	GLO	GLO
Specific data used	>90%			-	-	-	-	-	-	-	-	-	-	-	-	-	-
Variation – products ²	<10%			-	-	-	-	-	-	-	-	-	-	-	-	-	-
Variation – sites	0			-	-	-	-	-	-	-	-	-	-	-	-	-	-

² In a multi-product EPD, the difference (in %) between the declared GWP-GHG result and the product with the GWP-GHG results furthest from the declared results, for modules A1-A3, shall be reported in the EPD. Variations greater than 10% are allowed if supported in the LCA report and if the EPD states the variation in results for each impact indicator for which the variation is greater than 10%.

Cut-off rules

The cut-off rules in EN 15804:2012 + A2:2019 §6.3.6 and PCR 2019:14 §4.4 apply.

As their total contribution was less than 1% of the impact of the reference module, the following contributions were excluded from the model:

- Steel supply from foreign supplier representing 0.05% of the total.

Allocation rules

In the case of multi-function situations, i.e. where there are systems producing multiple products, the allocation rules set out in PCR 2019:14 apply.

A mass allocation was made to the entire production (in terms of tonnes) for general plant consumption - electricity, fuels, auxiliary materials, water - that could not be attributed to specific product categories; company outputs - waste, emissions - were also allocated to the entire production of the reference year. Where energy or material consumption could be associated with a specific product, these were allocated entirely to the product itself.

Rules for materials recycling/recovery

In case of material flows that leave the system boundaries, the 'polluter pays' principle applies, according to which impact related to the production of recycling flows is charged to the system that produced them until they reach *end-of-waste* status (PCR 2019:14 §4.5.2). Downstream impact (e.g. impact of secondary raw material preparation processes) is charged to the system using secondary material.

Therefore, depending on the material's intended use, the following types of impact have been identified:

- Recycling: impacts of transport to and preparation for recycling;
- Landfilling: impact of transport to landfill and disposal thereof.

Consequently, recycled materials enter the system associated with the recycling impact but not of the recycling preparation stage.

As required by EN 15804 §6.3.5.2, waste leaving the system to reach *end-of-waste* state in the A1-A3 phase must be allocated as co-products. In this declaration and in accordance with PCR 2019:14 §4.5.1, a conservative approach is taken and no allocation of environmental flows to these co-products is applied, and they are allocated entirely to the main products.

Electricity mix

The electricity supplied by the grid during production was modelled using the supplier's billed data. The GWP-GHG of the electricity mix used by Alessio Tubi is 0.405 kg CO₂ eq./kWh.

Assumptions for end-of-life scenarios (modules C1-C4)

Module C1: the demolition process requires energy to operate the excavators and other machinery needed for the process. It is assumed that the energy source used for this purpose is diesel oil and the average energy consumption at this stage is 0.07 MJ/kg³.

Module C2: includes the transport of end-of-life materials to processing facilities for recovery or landfilling. For the transport of materials to processing facilities for recovery or landfilling, an average distance of 50 km travelled by land is assumed. Transport has been modelled on the basis of the geographical reference area, assuming that it is done by means of a 16-32 tonne truck (Euro 6 standard)

Modules C3-C4: includes all operations necessary to process the product until the end-of-waste state is reached.

The following considerations apply:

- The product is made of steel only; specific end-of-life scenarios separating between recycling and landfilling are applied for this material. No energy recovery is envisaged;
- The amount of material sent for recycling comes from the Product Environmental Footprint (PEF);
- The amount of material sent for disposal is taken from the PEF data on recycling; it is assumed that the same breakdown also applies to scenarios abroad.

³ JRC, 2018, Model for LCA of buildings.

Product content declaration

Product components	Weight, kg	Post-consumer material, weight-%	Biogenic material, weight-% and kg C/kg
Carbon steel	1000	1.55%	0.0%
Total	1000	1.55%	0.0%
Packaging materials	Weight, kg	Weight - % (on product)	Biogenic carbon weight, kg C/kg
Galvanized steel	1.17	0.12%	0.0
Total	1.17	0.12%	0.0

The minimum content of (pre- and post-consumer) recycled material is 32%. It is calculated as the weighted average over the last mix of steels considered for the calculation of the product's environmental profile.

In accordance with the CAM⁴ requirements, the table below details the recovered, recycled or by-product material content, calculated as above, subdivided into integral-cycle steel and EAF steel.

	Integral-cycle steel	EAF steel
Total content of recycled material (pre- and post-consumer)	12.5%	88.9%
Total content of recovered material	0%	0%
Total by-product content	0%	0%
Supply used for EPD calculation	74%	26%

The declared product does not contain substances listed in the Candidate List of Substances of Very High Concern (SVHC) for authorisation in a concentration $\geq 0.1\%$

⁴ CAM – Italian acronym for *Minimum Environmental Criteria* as stated by the Ministry of Ecological Transition, 2022, Legislative Decree of 23 June 2022: 'Minimum Environmental Criteria' for awarding design services for construction works, their execution and the joint awarding of design and execution of construction works'. Criterion 2.5.4. Steel

Results of environmental performance indicators

Results per 1 tonne of average packed product

The results of the estimated impact are only relative statements, which do not indicate the end points of the impact categories, threshold excess, safety margins and/or risks.

It is not recommended to use the results of modules A1-A3 without taking modules C1-C4 into account as well.

Mandatory impact indicators according to EN 15804

Results by unit declared							
Indicator	Unit of measurement	A1-A3	C1	C2	C3	C4	D
GWP-fossil	kg CO ₂ eq.	2.07E+03	6.54E+00	7.64E+00	1.51E+01	8.37E-01	-9.31E+02
GWP-biogenic	kg CO ₂ eq.	4.93E+00	4.30E-04	4.98E-04	1.34E+01	4.31E-03	1.81E-01
GWP-luluc	kg CO ₂ eq.	1.80E+00	2.67E-04	1.51E-04	7.83E-03	3.33E-04	-5.80E-02
GWP-total	kg CO ₂ eq.	2.08E+03	6.54E+00	7.64E+00	2.86E+01	8.42E-01	-9.31E+02
ODP	kg CFC 11 eq.	4.32E-05	1.03E-07	1.64E-07	1.04E-07	1.13E-08	-2.00E-05
AP	mol H ⁺ eq.	8.98E+00	6.26E-02	1.99E-02	3.86E-02	7.12E-03	-3.77E+00
EP-freshwater	kg P eq.	1.17E-01	5.59E-06	6.18E-06	4.79E-04	9.24E-06	-4.01E-02
EP-marine	kg N eq.	1.92E+00	2.94E-02	7.79E-03	2.86E-02	3.08E-03	-7.69E-01
EP-terrestrial	mol N eq.	2.13E+01	3.20E-01	8.24E-02	1.38E-01	3.35E-02	-8.91E+00
POCP	kg NMVOC eq.	1.05E+01	9.41E-02	3.21E-02	4.63E-02	9.97E-03	-4.87E+00
ADP-minerals&metals*	kg Sb eq.	1.28E-03	2.75E-07	2.65E-07	4.02E-07	3.19E-08	-9.01E-03
ADP-fossil*	MJ	2.32E+04	8.60E+01	1.02E+02	9.92E+01	1.08E+01	-8.29E+03
WDP*	m ³	5.57E+02	1.10E-01	9.37E-02	1.23E+00	3.60E-02	-6.68E+01
Acronyms	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; EP-marine = Eutrophication potential, fraction of nutrients reaching marine end compartment; EP-terrestrial = Eutrophication potential, Accumulated Exceedance; POCP = Formation potential of tropospheric ozone; ADP-minerals&metals = Abiotic depletion potential for non-fossil resources; ADP-fossil = Abiotic depletion for fossil resources potential; WDP = Water (user) deprivation potential, deprivation-weighted water consumption						

* Disclaimer: The results of this Impact Indicator should be used with caution as uncertainties about the results are high or experience in using the indicator is limited.

Additional impact indicators

Results by unit declared							
Indicator	Unit of measurement	A1-A3	C1	C2	C3	C4	D
GWP-GHG ⁵	kg CO ₂ eq.	2.08E+03	6.54E+00	7.64E+00	2.86E+01	8.42E-01	-9.31E+02

Resource use indicators

Results by unit declared							
Indicator	Unit of measurement	A1-A3	C1	C2	C3	C4	D
PERE	MJ	1.49E+03	1.68E-01	2.65E-01	1.34E+01	2.64E-01	-5.95E+02
PERM	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
PERT	MJ	1.49E+03	1.68E-01	2.65E-01	1.34E+01	2.64E-01	-5.95E+02
PENRE ⁶	MJ	2.32E+04	8.60E+01	1.02E+02	9.92E+01	1.08E+01	-8.29E+03
PENRM ⁶	MJ	2.17E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
PENRT	MJ	2.32E+04	8.60E+01	1.02E+02	9.92E+01	1.08E+01	-8.29E+03
SM	kg	3.22E+02	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
RSF	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
NRSF	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
FW	m ³	1.39E+01	4.27E-03	4.26E-03	7.30E-02	1.49E-03	-1.74E+00
Acronyms	PERE = Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM = Use of renewable primary energy resources used as raw materials; PERT = Total use of renewable primary energy resources; PENRE = Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials; PENRM = Use of non-renewable primary energy resources used as raw materials; PENRT = Total use of non-renewable primary energy re-sources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Use of net fresh water						

⁵ This indicator takes into account all greenhouse gases, except the absorption and emission of biogenic carbon dioxide and biogenic carbon stored in the product. As such, the indicator is identical to GWP-total, except for the fact that the CF for biogenic CO₂ is set to zero.

⁶ The primary energy contained in the packaging is not taken into account and is considered lost.

Waste production indicators

Results by unit declared							
Indicator	Unit of measurement	A1-A3	C1	C2	C3	C4	D
Hazardous waste disposed*	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Non-hazardous waste disposed*	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Radioactive waste disposed**	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

*The Hazardous Waste Disposed and Non-Hazardous Waste Disposed indicators are set to 0 because all relevant waste treatment processes are included in the system boundaries.

**Radioactive waste is not considered relevant within the value chains included in the study.

Outflow indicators

Results by unit declared							
Indicator	Unit of measurement	A1-A3	C1	C2	C3	C4	D
Components for re-use	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Material for recycling	kg	0.00E+00	0.00E+00	0.00E+00	8.50E+02	0.00E+00	0.00E+00
Materials for energy recovery	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Exported energy	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

Additional social and economic information

The company has achieved gender equality management system certification in accordance with UNI/PdR 125.

Changes compared to previous versions

Revision 2024-09-09: the recycled material content has been expressed in such a way as to highlight the product's compliance with the Legislative Decree of 23 June 2022: 'Minimum Environmental Criteria' for awarding design services for construction works, their execution and the joint awarding of design and execution of construction works'. Criterion 2.5.4. Steel.

References

- EN 15804:2012 + A2:2019 + AC, Sustainability of construction works – Environmental Product Declaration – Core rules for the product category of construction products.
- International EPD System, General Programme Instructions, version 4.0
- International EPD System, PCR 2019:14 – Construction products – version 1.3.4
- ISO 14025:2010 *Environmental labels and declarations - Type III environmental statements - Principles and reporting frameworks*;
- ISO 14040:2021 *Environmental management - Life cycle assessment - Principles and reporting framework*;
- ISO 14044:2021 *Environmental management - Life cycle assessment - Principles and requirements and guidelines*.
- Association of Issuing Bodies, European Residual Mixes 2021.
- PlasticsEurope, Eco-profiles and Environmental Product Declarations of the European Plastics Manufacturers, April 2014, December 2016: update water balance.
- European Commission, 2021, *Recommendation 2021/2279 on the use of the Environmental Footprint methods to measure and communicate the life cycle environmental performance of products and organisations* Studio Fieschi & soci, 2022, *Carbon Footprint of copper-nickel surface treatment process*.
- International Copper Study Group, *The World Copper Factbook 2022*.
- International Zinc Association, 2022, *ZINC RECYCLING Stocks + Flows*.
- Gervasio, H., Dimova, S., 2018, *Model for Life Cycle Assessment (LCA) of buildings*, EC JRC technical reports.
- Eurostat waste database <https://ec.europa.eu/eurostat/web/waste/data/database>
- What a waste database: <https://datacatalog.worldbank.org/search/dataset/0039597/What-a-Waste-Global-Database>

English summary

Description of the organisation

Alessio Tubi has been producing welded carbon steel pipes in round, square and rectangular cross-sections since 1960, targeting both national and international markets. The company is located in the Turin industrial area of La Loggia, close to the most important communication routes.

Besides the production of the standard electro-welded pipe, intended for general use, in the past few years the company has equipped itself with specific finishing and non-destructive testing equipment and has developed a tubular product for pipelines, intended for use in the oil, natural gas, water and combustible fluids sectors in general. In more recent years, appropriate market awareness of the use of tubular products for structural applications has enabled the company to become a leader in Italy and the rest of Europe in this specific sector.

The type of products produced place Alessio Tubi in a highly competitive and free market served by many other major manufacturers; despite the high level of competition, product quality and service reliability (lead times, customer focus, promptness in providing information, the option of offering products with various certifications) are key factors thanks to which Alessio Tubi has succeeded in developing and maintaining a loyal customer base over time. Alessio Tubi implements and maintains a Quality Management System compliant with the requirements of UNI EN ISO 9001:2015 and API Spec. Q1. The company's Quality System was launched in 1988.

This System is intended as a corporate means for streamlining and ongoing improvement of the company's operations with a view to achieving the required Quality, in order for it to meet the specified standards and Customer's any additional requirements.

Product name

HFW carbon steel pipes

Product identification and description

The carbon steel pipes produced by Alessio Tubi, according to EN European standard and API and/or ATSM American standards can be used in multiple sectors and uses such as:

- Pressure application in numerous industrial and civil sectors;
- Construction water, gas or oil pipelines;
- Construction of pipelines for oil extraction;
- Civil and industrial construction engineering;
- Structures and plants subjected to dynamic loads;
- Mechanical industry applications;
- Agricultural sector applications;
- General use.

The production process takes place in the following stages:

- ⇓ Coils reception;
- ⇓ Cutting in strips;
- ⇓ Shaping of the strip in a circular section;
- ⇓ High frequency welding (HFW);
- ⇓ Heat treatment for welding normalization;

- ↓ In-line eddy current testing;
- ↓ Ultrasound welding testing;
- ↓ Final gauging/sizing;
- ↓ Cutting to size;
- ↓ End-to-end butt joining;
- ↓ Hydraulic pressure testing;
- ↓ Non-destructive final checks with Flux leakage;
- ↓ Marking;
- ↓ Bundling and identification;
- Storage.

All product tests checking compliance of the mechanical properties and the chemical analysis required by the reference standard are carried out in the in-house test laboratory.

The test laboratory shall carry out:

- Tensile tests;
- Impact strength tests;
- Spectrometric chemical analysis;
- Metallographic analysis (micrographs, macrographs, micro-hardness).

UN CPC Coding

41285 - Line pipe of a kind used for oil or gas pipelines, welded, of steel

41286 - Casing and tubing of a kind used in the drilling for oil or gas, welded, of steel

41287 - Other tubes and pipes, of circular cross-section, welded, of steel

41288 - Tubes and pipes, of non-circular cross-section, welded, of steel

Geographical scope: Global

LCA information

Unit declared: 1 tonne of packed steel pipe, ready for shipment (average profile calculated as the arithmetic mean between the environmental profile of the product that undergoes the most and the least processing/refining).

Reference service life: NA

Time representativeness: all data on product composition, production and distribution refer to the year 2023. Secondary data are the most recent available at the time of the study and are representative for the period 2018-2023.

Database(s) and LCA software used: Ecoinvent v.3.9.1, SimaPro v.9.6.0.1

Mandatory environmental impact indicators method EN 15804+A2 based on EF 3.1 characterisation factors.

System boundaries

Cradle-to-gate with modules C1–C4 and module D (A1–A3 + C + D).

Module A4-A5 and modules B1-B7 are excluded.

Cut-off criteria

The cut-off rules in EN 15804:2012 + A2:2019 §6.3.6 and PCR 2019:14 §4.4 apply.

As their total contribution was less than 1% of the impact of the reference module, the following contributions were excluded from the model:

- Steel supply from foreign supplier representing 0.05% of the total.

Allocation rules

The system under study produces only one product, so there is no multi-function situations.

A mass allocation was made to the entire production (in terms of tonnes) for general plant consumption - electricity, fuels, auxiliary materials, water - that could not be attributed to specific product lines; company outputs - waste, emissions - were also allocated to the entire production of the reference year. Where energy or material consumption could be associated with a specific product, these were allocated entirely to the product itself.

Electricity mix

The electricity supplied by the grid during production was modelled using the supplier's billed data. The GWP-GHG of the electricity mix used by Alessio Tubi is 0.405 kg CO₂ eq./kWh.

Assumptions for end-of-life scenarios (modules C1-C4)

Module C1: The demolition process requires energy to operate the excavators and other machinery needed for the process. It is assumed that the energy source used for this purpose is diesel fuel and that the average energy consumption at this stage is 0.07 MJ/kg.

Module C2: For the transport of materials to processing facilities for recovery or landfilling, an average distance of 50 km travelled by land is assumed. Transport has been modelled on the basis of the geographical reference area, assuming that it is done by means of a 16-32 tonne Euro 6 standard truck.

Modules C3-C4: : includes all operations necessary to process the product until the end-of-waste state is reached.

The following considerations apply:

- The product is made of steel only; specific end-of-life scenarios separating between recycling and landfilling are applied for this material. No energy recovery is envisaged;
- The share of material sent for recycling is comes from the Product Environmental Footprint (PEF);
- The share of material sent for disposal is taken from the PEF data on recycling; it is assumed that the same breakdown also applies to scenarios abroad.

