



FLORA BIS Sp. z o.o.



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Green Wall acoustic panels Flora C type: C3, C4, C5 and C6



Owner of the EPD:

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ITB is the verified member of The European Platform for EPD program operators and LCA practitioner www.eco-platform.org

Basic information

This declaration is the Type III Environmental Product Declaration (EPD) based on EN 15804+A2 and verified according to ISO 14025 by an external auditor. It contains the information on the impacts of the declared construction materials on the environment and their aspects verified by the independent body according to ISO 14025. Basically, comparison or evaluation of EPD data is possible only if all the compared data were created according to EN 15804+A2.

Life cycle analysis (LCA): A1-A3, A4-A5, C1-C4 and D modules in accordance with EN 15804+A2
(Cradle-to-Gate with options)

The year of preparing the EPD: 2024

Product standards: PN EN 14389, PN-EN 13501-1+A1, PN EN 1794-2

Service Life: 25 years

PCR: ITB-PCR A (v1.6, 2023)

Declared unit: 1 m²

Reasons for performing LCA: B2B

Representativeness: Poland, Europe, 2023

MANUFACTURER

The company **Flora Bis Sp. z o. o.** was formed in 2009, as a continuation of a sole proprietorship established in 1994. Manufacturer provides comprehensive solutions for road infrastructure. Company offer spans a broad range of products, from noise insulation panels. In addition, it specializes in the production of steel structures not only for the development of insulation panels, but also other key components of road investments.

Company operates an extensive machinery park and a large production and machine backlot (Krzepice, Poland), enabling comprehensive development of investments as well as delivery timeliness. Company conducts research and development operations, continuously introducing innovations in care for the needs and requirements of customers. Exports account for a significant proportion of company sales. Company contractors include retail chains from Germany, Denmark, Sweden, Belgium and southern European countries.

For all products company has the relevant technical approvals issued by the Road and Bridge Research Institute (Warsaw, Poland), certificates documenting their quality and allowing them to be placed on the market. Company also hold CE certificates for the acoustic panels, confirmed by reports from the TSUS institute - Building Testing and Research Institute in Bratislava.

PRODUCTS DESCRIPTION

The Green Wall acoustic panels (covered by EPD) are made up of a steel frame made of horizontal cold-formed C-profiles connected by a tongue and groove system. The frame has a 6 mm dia. rod grid welded on, with a mesh size of 150 mm x 150 mm. All steel components are abrasion-treated and then corrosion-protected by hot-dip galvanization with a coating thickness of 90 µm. This guarantees product durability. Inside there are two layers of acoustic insulation wool of a specific thickness and density, separated by felt. The green, light grey or dark grey colour is conveyed by the PE mesh and technical fabric placed between the steel mesh and the mineral wool. Due to the acoustic layers of the fill and the acoustic parameters, company differentiates between three panel types:

- Flora C type C3 – the most commonly used panel
- Flora C type C4 – increased insulation capacity panel
- Flora C type C6 – significantly increased insulation capacity panel

The standard panel height is up to 2000 mm – whereby it may be increased even up to 4000 mm if pillars are spaced at 2000 mm. Please note that the top panel length is 6000 mm.

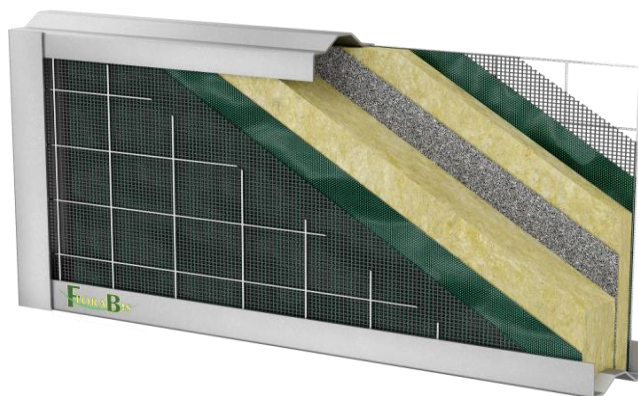


Figure 1 Cross section of The Green Wall FLORA C

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The Flora C type panels are adapted to standard HE160 I-beams in terms of width. It is possible to install them in larger I-beams. The width of the GREEN WALL acoustic screen is fixed and is 129 mm. Galvanized according to the PNEN 1461 standard, min. 85 μm .

Table 1 Specification of The Green Wall FLORA C

Single-digit R_w indicator: – type C3 – 32 dB – type C4 – 33 dB – type C6 – 38 dB	Single-digit ΔL_R indicator: – type C3 – 27 dB – type C4 – 29 dB class B3 – type C6 – 33 dB	Single-digit ΔL_{α} indicator: – type C3 – 15 dB Class A4 – type C3 (reverse side) – 11 dB Class A3 – type C4 – 15 dB Class A4 – type C6 – 15 dB Class A4
Fire resistance	Class 2 Class D-s1,d0	PN EN 1794-2 PN-EN 13501-1+A1
Secondary hazards	Class 6 (6,0 kJ)	PN EN 1794-2
Stone impact resistance	Fulfilled/ not damaged	PN EN 1794-2
Acoustic durability	DL_{α} -5/20 years DL_R -4/20 years	PN EN 14389
Non-acoustic durability	At least 30 years	PN EN 14389

All additional technical information about the product is available on the manufacturer's website and [catalogues](#).

LIFE CYCLE ASSESSMENT (LCA) – general rules applied

Unit

The declared unit is 1 m² of products (average mass for LCA is 32.5 kg/m²).

System boundary

The life cycle analysis of the declared products covers “Product Stage” A1-A3, A4-A5, C2-C4+D modules in accordance with EN 15804+2 and ITB PCR A (cradle to gate with options). Energy and water consumption, emissions as well as information on generated wastes were inventoried and were included in the calculation. It can be assumed that the total sum of omitted processes does not exceed 5% of all impact categories. In accordance with EN 15804+A2, machines and facilities (capital goods) required for the production as well as transportation of employees were not included in LCA.

Allocation

The allocation rules used for this EPD are based on general ITB 's document PCR A. In the modules A1-A3, material losses in the assembly of the products in the factory are defined on the averaged specific values for the site. Input and output data from the production is inventoried and allocated to the production on the mass basis The declaration covers a wide range of products (averaged). Their production resources and processing stages are basically similar.

System limits

99.5% materials and energy consumption were inventoried in a factory and were included in calculation. In the assessment, all significant parameters from gathered production data are considered, utilized energy, and electric power consumption, direct production waste, and available emission measurements. The total of neglected input flows per module A1-A3 does not exceed the permitted maximum of 1 % of energy usage and product mass. Tires consumption for transport was

not taken into account. The components like: welding wire with a percentage share of less than 0.5% were not included in the calculations. It is assumed that the total sum of omitted processes does not exceed 1% of all impact categories. In accordance with EN 15804 machines and facilities (capital goods) required for and during production are excluded, as is transportation of employees.

Modules A1 and A2: Raw materials supply and transport

Steel semi-finished products used for the production comes from various steel plants. Wool and ancillary materials such as welding wires, gases used for welding purposes and packaging materials come from local Polish suppliers. Data on transport of the different products to the manufacturing plants is collected and modelled for factory by assessor. Data on transport of the different products to the manufacturing plants is collected and modelled for factory by assessor. Module A2 (transport) includes truck transport and uses European averages for fuel data. Delivery quantities and distances were inventoried.

Module A3: Production

At the beginning of the production process, the required materials are collected. Prepared steel sections and mesh are subjected to cutting, marking and welding. The component undergoes operations providing the proper quality of its edges and is assembled and welded according to a project. Next, mineral wool and polyethylene is assembled to the screen. The production processes carried out is shown in Figure 2.

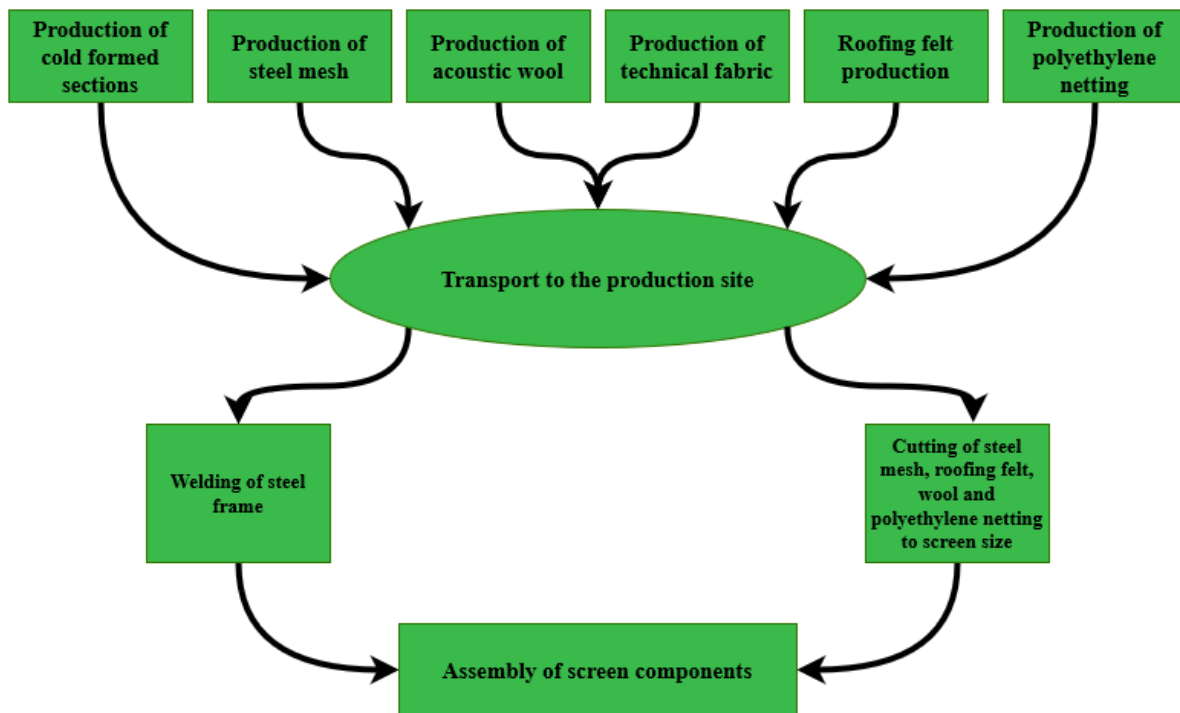


Figure 2 Manufacturing process scheme (A1-A3), with assembly process in Krzepice (A3)

Module A4 -A5: transport and installation

Vehicle transport at distance 100 km is considered (emission standard: Euro 5) with 100% load capacity. On-site installation of acoustic panels requires the use of power tools and a lifting device

Modules C and D: End-of-life (EOL)

Due to the fact that the declaration covers a wide range of products for various purposes and usage scenarios, it is not possible to directly specify the de-construction technology and the amount of energy for disassembly in C1 module (so this set is generic). In the adapted end-of-life scenario, the

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de-constructed steel products are transported to a metal mill distant by 100 km on > 16t lorry EURO 5 where are used as scrap to produce a new metals. The recycling potential of C3 module is 98% for steel and it is assumed that only 2% of the products will end up in a landfill – C4 module (Table 2). It is assumed that after demolition, mineral wool (100%) is not suitable for further use and is transported to a landfill. Module D presents credits resulting from the recycling of the scrap (used for steel production), calculated in accordance with the approach developed by World Steel Association.

Table 2 End-of-life scenario for the Green Wall acoustic panels Flora C type: C3, C4, C5 and C6

Material	Material recovery	Recycling	Landfilling
steel	100%	98%	2%
wool	100%	0%	100%
other	100%	0%	100%

Electricity at end-of-life (module C) has been modelled using an average Polish electricity mix as the location where the product reaches end-of-life is unknown.

Data collection period

The data for manufacture of the declared products refer to period between 01.01.2023 – 31.12.2023 (1 year). The life cycle assessments were prepared for Poland and Europe as reference area.

Data quality

The data selected for LCA originate from ITB-LCI questionnaires completed by FLORA BIS Sp. z o.o. and verified during data audit. No data collected is older than five years and no generic datasets used are older than ten years. The representativeness, completeness, reliability, and consistency is judged as good. The background data for the processes come from the following resources database Ecoinvent v.3.10 (felt, reinforcement mesh, polyethylene mesh, fabric) and specific EPDs (steel and wool).

Assumptions and estimates

The impacts of the representative products were aggregated using weighted average.

Calculation rules

LCA was performed using ITB-LCA tool developed in accordance with EN15804+A2. Emission of greenhouse gases was calculated using the IPCC 2013 GWP method with a 100-year horizon. Emission of acidifying substances, Emission of substances to water contributing to oxygen depletion, Emission of gases that contribute to the creation of ground-level ozone, Abiotic depletion, and ozone depletion emissions where all calculated with the CML-IA baseline method

Additional information

Polish electricity (Ecoinvent v 3.10 supplemented by actual national data) emission factor used is 0.685 kg CO₂/kWh. As a general rule, no particular environmental or health protection measures other than those specified by law are necessary.

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LIFE CYCLE ASSESSMENT (LCA) – Results

Declared unit

The declaration refers to declared unit (DU) – 1 m² of Green Wall acoustic panels Flora C type: C3, C4, C5 and C6 produced in Poland. The following life cycle modules (Table 3) were included in the analysis. The following tables 4-7 show the environmental impacts of the life cycle of selected modules (A1-A5+C1-C4+D).

Table 3 System boundaries for the environmental characteristic of the product.

Environmental assessment information (MD – Module Declared, MND – Module Not Declared, INA – Indicator Not Assessed)																
Product stage			Construction process		Use stage							End of life				Benefits and loads beyond the system boundary
Raw material supply	Transport	Manufacturing	Transport to construction site	Construction-installation process	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction 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
MD	MD	MD	MD	MD	MND	MND	MND	MND	MND	MND	MND	MD	MD	MD	MD	MD

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Table 4 Life cycle assessment (LCA) results for specific product – environmental impacts of (DU: 1 m²)

Indicator	Unit	A1	A2	A3	A1-A3	A4	A5	C1	C2	C3	C4	D
Global Warming Potential	eq. kg CO ₂	5.16E+01	8.50E-01	2.39E+00	5.49E+01	5.42E-01	1.11E-01	1.11E-01	5.42E-01	1.38E+00	1.21E-01	-1.94E+01
Greenhouse potential - fossil	eq. kg CO ₂	1.79E+01	8.46E-01	2.18E+00	2.09E+01	5.40E-01	1.11E-01	1.11E-01	5.40E-01	1.38E+00	1.20E-01	-1.95E+01
Greenhouse potential - biogenic	eq. kg CO ₂	4.92E-01	3.44E-03	1.97E-01	6.93E-01	1.85E-03	3.25E-03	3.25E-03	1.85E-03	2.87E-04	1.21E-03	-6.58E-02
Global warming potential - land use and land use change	eq. kg CO ₂	1.94E-02	3.54E-04	3.70E-03	2.35E-02	2.12E-04	3.90E-05	3.90E-05	2.12E-04	2.17E-04	1.21E-04	-1.52E-03
Stratospheric ozone depletion potential	eq. kg CFC 11	1.39E-06	1.94E-07	2.96E-07	1.88E-06	1.25E-07	2.28E-09	2.28E-09	1.25E-07	1.68E+01	3.64E-08	-6.97E-07
Soil and water acidification potential	eq. mol H ⁺	5.64E-01	3.51E-03	7.22E-03	5.75E-01	2.19E-03	1.24E-03	1.24E-03	2.19E-03	1.15E-02	1.01E-03	-7.73E-02
Eutrophication potential - freshwater	eq. kg P	1.48E+00	6.35E-05	2.43E-03	1.49E+00	3.63E-05	2.11E-04	2.11E-04	3.63E-05	9.31E-06	3.48E-05	-8.36E-03
Eutrophication potential - seawater	eq. kg N	3.24E-02	1.07E-03	1.81E-03	3.53E-02	6.62E-04	1.79E-04	1.79E-04	6.62E-04	3.90E-02	3.48E-04	-1.69E-02
Eutrophication potential - terrestrial	eq. mol N	2.04E+00	1.17E-02	1.41E-02	2.07E+00	7.22E-03	1.51E-03	1.51E-03	7.22E-03	7.37E-02	3.79E-03	-1.85E-01
Potential for photochemical ozone synthesis	eq. kg NMVOC	8.77E-02	3.55E-03	4.58E-03	9.58E-02	2.21E-03	4.23E-04	4.23E-04	2.21E-03	1.61E-02	1.10E-03	-9.74E-02
Potential for depletion of abiotic resources - non-fossil resources	eq. kg Sb	1.33E-03	3.03E-06	3.68E-06	1.34E-03	1.92E-06	5.43E-07	5.43E-07	1.92E-06	3.12E-07	4.05E-07	-3.64E-04
Abiotic depletion potential - fossil fuels	MJ	6.08E+02	1.26E+01	4.44E+01	6.65E+02	8.02E+00	1.89E+00	1.89E+00	8.02E+00	1.31E+00	2.77E+00	-1.62E+02
Water deprivation potential	eq. m ³	1.05E+01	6.23E-02	3.93E-01	1.09E+01	3.71E-02	3.90E-02	3.90E-02	3.71E-02	3.06E-02	1.61E-02	-2.84E+00

Table 5 Life cycle assessment (LCA) results for specific product – additional impacts indicators (DU: 1 m²)

Indicator	Unit	A1-A3	A4-A5	C1-C4	D
Particulate matter	disease incidence	INA	INA	INA	INA
Potential human exposure efficiency relative to U235	eg. kBq U235	INA	INA	INA	INA
Potential comparative toxic unit for ecosystems	CTUe	INA	INA	INA	INA
Potential comparative toxic unit for humans (cancer effects)	CTUh	INA	INA	INA	INA
Potential comparative toxic unit for humans (non-cancer effects)	CTUh	INA	INA	INA	INA
Potential soil quality index	dimensionless	INA	INA	INA	INA

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Table 6 Life cycle assessment (LCA) results for specific product - the resource use (DU: 1 m²)

Indicator	Unit	A1	A2	A3	A1-A3	A4	A5	C1	C2	C3	C4	D
Consumption of renewable primary energy - excluding renewable primary energy sources used as raw materials	MJ	2.19E+01	2.05E-01	6.82E+00	2.90E+01	1.15E-01	1.40E-01	1.40E-01	1.15E-01	2.39E-02	4.86E-02	-1.35E+01
Consumption of renewable primary energy resources used as raw materials	MJ	1.06E-01	0.00E+00	0.00E+00	1.06E-01	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Total consumption of renewable primary energy resources	MJ	3.41E+01	2.05E-01	6.86E+00	4.12E+01	1.15E-01	1.40E-01	1.40E-01	1.15E-01	2.39E-02	4.86E-02	-1.35E+01
Consumption of non-renewable primary energy - excluding renewable primary energy sources used as raw materials	MJ	3.60E+02	1.26E+01	2.80E+01	4.00E+02	8.02E+00	1.89E+00	1.89E+00	8.02E+00	1.31E+00	2.99E+00	-1.55E+02
Consumption of non-renewable primary energy resources used as raw materials	MJ	5.84E+01	0.00E+00	0.00E+00	5.84E+01	0.00E+00	0.00E+00	0.00E+00	0.00E+00	6.48E+01	0.00E+00	0.00E+00
Total consumption of non-renewable primary energy resources	MJ	6.17E+02	1.26E+01	4.57E+01	6.76E+02	8.02E+00	1.89E+00	1.89E+00	8.02E+00	1.31E+00	2.99E+00	-1.55E+02
Consumption of secondary materials	kg	8.84E+00	4.50E-03	4.20E-03	8.84E+00	2.69E-03	1.72E-04	1.72E-04	2.69E-03	5.90E-04	0.00E+00	-2.56E+00
Consumption of renew. secondary fuels	MJ	1.00E-03	4.64E-05	2.78E-05	1.08E-03	2.96E-05	9.60E-07	9.60E-07	2.96E-05	8.02E-06	0.00E+00	-3.35E-03
Consumption of non-renewable secondary fuels	MJ	3.58E-02	0.00E+00	0.00E+00	3.58E-02	0.00E+00	1.53E-03	1.53E-03	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Net consumption of freshwater	m ³	3.06E-01	1.70E-03	1.65E-02	3.24E-01	1.01E-03	5.12E-04	5.12E-04	1.01E-03	1.16E-03	4.32E-04	-1.39E-01

Table 7 Life cycle assessment (LCA) results for specific product – waste categories (DU: 1 m²)

Indicator	Unit	A1	A2	A3	A1-A3	A4	A5	C1	C2	C3	C4	D
Hazardous waste	kg	3.00E-01	1.52E-02	6.84E-02	3.84E-01	9.00E-03	1.95E-05	1.95E-05	9.00E-03	9.37E-08	4.35E-06	-1.26E+01
Non-hazardous waste	kg	4.20E+01	2.80E-01	1.21E+01	5.44E+01	1.60E-01	1.01E-03	1.01E-03	1.60E-01	2.45E-01	1.14E+01	-4.74E+01
Radioactive waste	kg	1.62E-03	1.11E-06	2.47E-04	1.87E-03	5.99E-07	1.41E-06	1.41E-06	5.99E-07	6.97E-06	1.68E-05	6.40E-04
Components for re-use	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Materials for recycling	kg	1.43E+00	3.92E-05	3.26E-01	1.76E+00	2.48E-05	1.95E-06	1.95E-06	2.48E-05	8.72E-06	0.00E+00	-2.06E-03
Materials for energy recovery	kg	6.98E-06	3.22E-07	3.28E-07	7.63E-06	2.01E-07	1.71E-08	1.71E-08	2.01E-07	1.09E-07	0.00E+00	-1.29E-04
Exported Energy	MJ	4.22E-01	0.00E+00	4.18E-01	8.40E-01	0.00E+00	5.62E-03	5.62E-03	0.00E+00	1.33E+00	0.00E+00	0.00E+00

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Verification

The process of verification of this EPD is in accordance with ISO 14025 and ISO 21930. After verification, this EPD is valid for a 5-year-period. EPD does not have to be recalculated after 5 years, if the underlying data have not changed significantly.

The basis for LCA analysis was EN 15804 and ITB PCR A
Independent verification corresponding to ISO 14025 (sub clause 8.1.3.) <input checked="" type="checkbox"/> external <input type="checkbox"/> internal
External verification of EPD: Halina Prejzner, PhD. Eng. LCI audit and verification: Michał Chwedaczuk, M.Sc. Eng. LCA, LCI audit and input data verification: Michał Piasecki, PhD., D.Sc., eng.

Note 1: The declaration owner has the sole ownership, liability, and responsibility for the information provided and contained in EPD. Declarations of construction products may not be comparable if they do not comply with EN 15804+A2. For further information about comparability, see EN 15804+A2 and ISO 14025.

Note 2: ITB is a public Research Organization and Notified Body (EC Reg. no 1488) to the European Commission and to other Member States of the European Union designated for the tasks concerning the assessment of building products' performance. ITB acts as the independent, third-party verification organization (see ISO 17025/17065/17029). ITB-EPD program is recognized and registered member of The European Platform - Association of EPD program operators and ITB-EPD declarations are registered and stored in the international [ECO-PORTAL](#).

Normative references

- ITB PCR A General Product Category Rules for Construction Products (v.1.6.,2023)
- ISO 14025:2006, Environmental labels and declarations – Type III environmental declarations – Principles and procedures
- ISO 21930:2017 Sustainability in buildings and civil engineering works – Core rules for environmental product declarations of construction products and services
- ISO 14044:2006 Environmental management – Life cycle assessment – Requirements and guidelines
- ISO 15686-1:2011 Buildings and constructed assets – Service life planning – Part 1: General principles and framework
- ISO 15686-8:2008 Buildings and constructed assets – Service life planning – Part 8: Reference service life and service-life estimation
- EN 15804:2012+A2:2019 Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products
- ISO 14067:2018 Greenhouse gases — Carbon footprint of products — Requirements and guidelines for quantification
- PN-EN 15942:2012 Sustainability of construction works – Environmental product declarations – Communication format business-to-business
- ISO 20915:2018 Life cycle inventory calculation methodology for steel products
- KOBiZE Wskaźniki emisyjności CO₂, SO₂, NO_x, CO i pyłu całkowitego dla energii elektrycznej. December 2023
- World Steel Association 2017 Life Cycle inventory methodology report for steel products

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Kwalifikowany podpis elektroniczny

Kwalifikowany podpis elektroniczny



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Thermal Physics, Acoustics and Environment Department

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CERTIFICATE № 676/2024 of TYPE III ENVIRONMENTAL DECLARATION

Products:

Green Wall acoustic panels Flora C type: C3, C4, C5 and C6

Manufacturer:

Flora Bis Sp. z o.o.

ul. Rolnicza 3, 42-160 Krzepice, Poland

confirms the correctness of the data included in the development of
Type III Environmental Declaration and accordance with the requirements of the standard

EN 15804+A2


Sustainability of construction works.

Environmental product declarations.

Core rules for the product category of construction products.

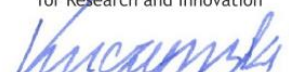
This certificate, issued on 18th October 2024 is valid for 5 years
or until amendment of mentioned Environmental Declaration

Head of the Thermal Physic, Acoustics
and Environment Department


Agnieszka Winkler-Skalna, PhD



Deputy Director
for Research and Innovation


Krzysztof Kuczyński, PhD

Warsaw, October 2024