

# ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804+A2

Owner of the Declaration	Sika Sverige AB
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-SIK-20240396-CBA1-EN
Issue date	22/01/2025
Valid to	21/01/2030

**Sika® Sigunit® L-2655 AF**  
**Sika Sverige AB**

[www.ibu-epd.com](http://www.ibu-epd.com) | <https://epd-online.com>



## General Information

### Sika Sverige AB

#### Programme holder

IBU – Institut Bauen und Umwelt e.V.  
Hegelplatz 1  
10117 Berlin  
Germany

#### Declaration number

EPD-SIK-20240396-CBA1-EN

#### This declaration is based on the product category rules:

Concrete admixtures, 01/08/2021  
(PCR checked and approved by the SVR)

#### Issue date

22/01/2025

#### Valid to

21/01/2030



Dipl.-Ing. Hans Peters  
(Chairman of Institut Bauen und Umwelt e.V.)



Florian Pronold  
(Managing Director Institut Bauen und Umwelt e.V.)

### Sika® Sigunit® L-2655 AF

#### Owner of the declaration

Sika Sverige AB  
Domnarvsgatan 15  
16308 Spanga  
Sweden

#### Declared product / declared unit

1 kg of Sika® Sigunit® L-2655 AF with a Density of 1.51 kg/dm<sup>3</sup>

#### Scope:

This core-EPD relates to 1kg of Sika® Sigunit® L-2655 AF (admixture group of Set Accelerator) applied into the building, manufactured at Sika's plant in Domnarvsgatan 15, 163 53 Spånga/ Sweden and is representative for the year 2023.

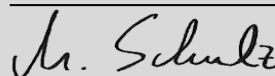
The results in this core-EPD were calculated using an LCA-tool verified by IBU in 2023.

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

The EPD was created according to the specifications of EN 15804+A2. In the following, the standard will be simplified as *EN 15804*.

#### Verification

The standard EN 15804 serves as the core PCR	
Independent verification of the declaration and data according to ISO 14025:2011	
<input type="checkbox"/>	internally
<input checked="" type="checkbox"/>	externally



Matthias Schulz,  
(Independent verifier)

## Product

### Product description/Product definition

Sika® Sigunit® L-2655 AF is a liquid alkali-free shotcrete accelerator.

Sika® Sigunit® L-2655 AF meets the requirements of EN 934-5:2007, admixtures which permit very early setting of the shotcrete and, unlike products in line with EN 934-2:2009+A1:2012 can be added to concrete with max. 12 % by mass, whereby set accelerators for shotcrete and so-called non-alkali set accelerators with a maximum alkali content of 1.0 % (indicated as a Na<sub>2</sub>O equivalent) (in relation to the admixture mass) are specified for shotcrete.

For the purposes of this EPD, Sika's plant in Domnarvsgatan 15, 163 53 Spånga/ Sweden manufacturing site was selected. The product needs a declaration of performance taking into consideration EN 934-5: 2007 Admixtures for concrete, mortar and grout – Part 5: Admixtures for sprayed concrete – Definitions, requirements, conformity, marking and labelling. For the application and use the respective national provisions apply.

### Application

The main fields of application for Sika® Sigunit® L-2655 AF are:

- Temporary support in tunneling,
- Rock support and Slope protection
- High-quality lining shotcrete.

Sika® Sigunit® L-2655 AF ensures to achieve high early strength development with minimal strength loss of the accelerated concrete.

### Technical Data

Sika® Sigunit® L-2655 AF meets the requirements of EN 934-5:2007, admixtures which permit very early setting of the shotcrete.

### Constructional data

Name	Value	Unit
Density (ISO 758)	1.48 - 1.54	g/ml
Solids content (EN 480-8)	48.45 - 53.55	M.-%
pH value (ISO 4316)	2.5 - 3.5	-log <sub>10</sub> (a <sub>H</sub> <sup>+</sup> )
Chloride content (EN 480-10)	<0.1	M.-%
Alkali content (EN 480-12)	<1.0	M.-%
Corrosion behavior (EN 934-1 / EN 480-14)	No corrosion behavior test is required for admixtures which only contain active substances in the list of approved substances to EN 934-1, Annex A.	μ A/cm <sup>2</sup>
SiO <sub>2</sub> content (EN 192-2)	Maximum value must only be indicated when SiO <sub>2</sub> percentage by mass > 5 %	M.-%
Compressive strength (EN 12390-3)	At 28 days: Test mix ≥ 90 % of control mix At 90 days: Test mix ≥ test mix at 28 days	N/mm <sup>2</sup>
Setting time (EN 480-2) Accelerator/Retarder	Start of setting process: ≤ 10 min. End of setting process: ≤ 60 min.	min

Performance data of the product in accordance with the declaration of performance with respect to its essential characteristics according to EN 934-2: 2009+A1:2012, Admixtures for concrete, mortar and grout – Part 2: Concrete admixtures –Definitions, requirements, conformity, marking and labelling (for set accelerators for concrete)  
EN 934-5:2007, Admixtures for concrete, mortar and grout – Part 5: Admixtures for sprayed concrete –Definitions, requirements, conformity, marking and labelling (for set accelerators for concrete).

### Base materials/Ancillary materials

The raw materials and additives of Sika® Sigunit® L-2655 AF can be given as follows:

Name	Value	Unit
Aluminum Sulphate	60-80	%
Water	30-40	%
Magnesium Hydroxide	2-5	%
Additives	1-2	%

In particular:

This product contains substances listed in the candidate list (date: 27.06.2024) exceeding 0.1 percentage by mass: No  
This product contains other CMR substances in categories 1A or 1B which are not on the candidate list, exceeding 0.1 percentage by mass: No  
Biocide products were added to this construction product or it has been treated with biocide products (this then concerns a treated product as defined by the (EU) Ordinance on Biocide Products No. 528/2012): No

### Reference service life

The durability of concrete admixtures is normally at least as long as the lifetime of the building in which it is used. The experimental data show that the reference life is greater than 50 years.

The documentation of the RSL is not required for the EPDs calculated using the EPD tool from Sika since the entire life

cycle is not declared. Only modules A1-A3, A4, A5, C1-C4 and

D are considered.

## LCA: Calculation rules

### Declared Unit

The EPD refers to the declared unit of 1kg of concrete admixture (setting accelerator) applied into the building with a density of 1.51 g/ml in accordance with IBU PCR 04-2023 part B.

### Declared unit and mass reference

Name	Value	Unit
Declared unit	1	kg
Gross density	1510	kg/m <sup>3</sup>

### System boundary

Declaration type with respect to life cycle stages covered according to clause 5.2 EN 15804+A2 is cradle to gate with modules C1-C4 and module D (A1-A3, A4, A5, C and D).

Modules taken into account:

- A1: Production of preliminary products
- A2: Transport to the plant
- A3: Production including provision of energy, production of auxiliaries and consumables and waste treatment
- A4: Transport from the construction site to the installation site
- A5: Installation, admixtures applied into the building during A5 phase operations. At this stage, an impact of the production and treatment of installation residue equal to 1% of the product is considered.
- C1-C2-C3-C4-D: The building deconstruction (demolition

process) takes place in C1 module which considers energy production and consumption in terms of diesel and all the emissions connected with the fuel-burning process. After the demolition, the admixture is transported to the end-of-life processing (C2 module) where all the impacts related to the transport processes are considered. C3: Waste processing. No waste processing is considered.

One scenario is considered for the final treatment of the waste: 100% disposal (C4), modelled by landfill process where admixtures end their life cycle.

Module D accounts for benefits that are beyond the defined system boundaries. Credits are generated during the incineration of the installation scrap in module A5.

### Geographic Representativeness

Land or region, in which the declared product system is manufactured, used or handled at the end of the product's lifespan: Sweden

### Comparability

Basically, a comparison or an evaluation of EPD data is only possible if all the data sets to be compared were created according to EN 15804 and the building context, respectively the product-specific characteristics of performance, are taken into account. Sphera LCA for Expert software (version 10) and Managed LCA Content (2022.2) have been used.

## LCA: Scenarios and additional technical information

### Characteristic product properties of biogenic carbon

No biogenic carbon is contained in the product. Since the product is delivered to the installation site in tank trucks, or in reusable containers no packaging is considered.

### Information on describing the biogenic carbon content at factory gate

Name	Value	Unit
Biogenic carbon content in product	-	kg C
Biogenic carbon content in accompanying packaging	-	kg C

Note: 1 kg of biogenic carbon is equivalent to 44/12 kg of CO<sub>2</sub>.

### Transport from the gate to the side (A4)

Name	Value	Unit
Transport distance Train	900	km
Transport distance Truck	380	km

### Assembly (A5)

Name	Value	Unit
Other resources	-	kg
Material loss	0.01	kg

Material loss regards the amount of product not used during the application phase into the building. This amount is 1 % of the product, impacts related to the production of this part are charged to the A5 module. This percentage is considered as waste to incineration since the product has a calorific value and impacts of its end of life have been considered in the LCA model and declared in A5.

### End of life (C1-C4)

C1: This module considers the use of machinery (7.5E-5 kg of diesel for kg handled) to dismantle the product to enable its subsequent transport.

C2: The concrete demolition waste is transported from the building site to a treatment plant or disposal site by truck and an average distance of 50 km is considered.

C3: Waste processing. No waste processing is considered.

C4: The results for the end-of-life are declared for one scenario:

Name	Value	Unit
Landfill percentage	100	%
Landfilling	1	kg



## LCA: Results

DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; MND = MODULE OR INDICATOR NOT DECLARED; MNR = MODULE NOT RELEVANT)

Product stage			Construction process stage		Use stage							End of life stage				Benefits and loads beyond the system boundaries
Raw material supply	Transport	Manufacturing	Transport from the gate to the site	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	X	MND	MND	MNR	MNR	MNR	MND	MND	X	X	X	X	X

### RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A2: 1 kg Sika® Sigunit® L-2655 AF

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
GWP-total	kg CO <sub>2</sub> eq	2.45E-01	2.8E-02	1.22E-02	2.83E-04	6.27E-03	0	1.45E-02	-3.15E-03
GWP-fossil	kg CO <sub>2</sub> eq	2.4E-01	2.71E-02	6.98E-03	2.7E-04	6E-03	0	1.49E-02	-3.13E-03
GWP-biogenic	kg CO <sub>2</sub> eq	5.34E-03	9.26E-04	5.22E-03	1.23E-05	2.71E-04	0	-4.42E-04	-1.47E-05
GWP-luluc	kg CO <sub>2</sub> eq	8.61E-05	1.36E-06	8.82E-07	1.25E-08	2.72E-07	0	2.75E-05	-3.1E-07
ODP	kg CFC11 eq	7.39E-14	6.81E-14	3.04E-15	2.82E-17	6.15E-16	0	3.51E-14	-1.85E-14
AP	mol H <sup>+</sup> eq	2.47E-03	8.43E-05	3.05E-05	3.62E-06	1.91E-05	0	1.06E-04	-3.83E-06
EP-freshwater	kg P eq	5.88E-07	7.77E-09	6.67E-09	6.41E-11	1.4E-09	0	2.53E-08	-3.79E-09
EP-marine	kg N eq	2.46E-04	3.8E-05	4.74E-06	1.65E-06	8.89E-06	0	2.71E-05	-1.07E-06
EP-terrestrial	mol N eq	2.66E-03	4.16E-04	5.49E-05	1.81E-05	9.78E-05	0	2.97E-04	-1.15E-05
POCP	kg NMVOC eq	8.16E-04	8.78E-05	1.4E-05	4.95E-06	1.77E-05	0	8.22E-05	-3.02E-06
ADPE	kg Sb eq	2.64E-08	1.87E-09	3.01E-10	1.44E-11	3.14E-10	0	1.53E-09	-4.32E-10
ADPF	MJ	6.61E+00	4.27E-01	7.52E-02	3.84E-03	8.39E-02	0	1.95E-01	-5.29E-02
WDP	m <sup>3</sup> world eq deprived	4.07E-02	5.54E-04	2.02E-03	7.43E-07	1.62E-05	0	1.64E-03	-2.93E-04

GWP = Global warming potential; ODP = Depletion potential of the stratospheric ozone layer; AP = Acidification potential of land and water; EP = Eutrophication potential; POCP = Formation potential of tropospheric ozone photochemical oxidants; ADPE = Abiotic depletion potential for non-fossil resources; ADPF = Abiotic depletion potential for fossil resources; WDP = Water (user) deprivation potential)

### RESULTS OF THE LCA - INDICATORS TO DESCRIBE RESOURCE USE according to EN 15804+A2: 1 kg Sika® Sigunit® L-2655 AF

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
PERE	MJ	6.75E-01	2.22E-02	8.12E-03	2.33E-05	5.08E-04	0	2.93E-02	-1.28E-02
PERM	MJ	0	0	0	0	0	0	0	0
PERT	MJ	6.75E-01	2.22E-02	8.12E-03	2.33E-05	5.08E-04	0	2.93E-02	-1.28E-02
PENRE	MJ	-9.93E-01	4.29E-01	7.52E-02	3.86E-03	8.42E-02	0	1.96E-01	-5.29E-02
PENRM	MJ	7.61E+00	0	0	0	0	0	0	0
PENRT	MJ	6.62E+00	4.29E-01	7.52E-02	3.86E-03	8.42E-02	0	1.96E-01	-5.29E-02
SM	kg	0	0	0	0	0	0	0	0
RSF	MJ	0	0	0	0	0	0	0	0
NRSF	MJ	0	0	0	0	0	0	0	0
FW	m <sup>3</sup>	1.85E-03	3.34E-05	5.62E-05	3.16E-08	6.9E-07	0	4.97E-05	-1.23E-05

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 resources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Use of net fresh water

### RESULTS OF THE LCA - WASTE CATEGORIES AND OUTPUT FLOWS according to EN 15804+A2: 1 kg Sika® Sigunit® L-2655 AF

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
HWD	kg	1.95E-09	1.11E-11	2.02E-11	1.33E-14	2.91E-13	0	1.01E-11	-7.46E-12
NHWD	kg	9.63E-02	5.94E-05	2.12E-03	3.94E-07	8.6E-06	0	1E+00	-2.52E-05
RWD	kg	8.59E-04	2.4E-05	8.86E-06	6.36E-09	1.39E-07	0	2.18E-06	-3.67E-06
CRU	kg	0	0	0	0	0	0	0	0
MFR	kg	0	0	0	0	0	0	0	0
MER	kg	0	0	0	0	0	0	0	0
EEE	MJ	0	0	1.23E-02	0	0	0	0	0
EET	MJ	0	0	2.81E-02	0	0	0	0	0

HWD = Hazardous waste disposed; NHWD = Non-hazardous waste disposed; RWD = Radioactive waste disposed; CRU = Components for re-use; MFR = Materials for recycling; MER = Materials for energy recovery; EEE = Exported electrical energy; EET = Exported thermal energy

## RESULTS OF THE LCA – additional impact categories according to EN 15804+A2-optional:

1 kg Sika® Sigunit® L-2655 AF

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
PM	Disease incidence	2.53E-08	6.16E-10	2.91E-10	1.93E-10	1.06E-10	0	1.3E-09	-3.17E-11
IR	kBq U235 eq	1.04E-01	3.52E-03	1.08E-03	9.55E-07	2.08E-05	0	2.42E-04	-6.21E-04
ETP-fw	CTUe	3.82E+00	2.47E-01	4.43E-02	2.74E-03	5.97E-02	0	1.1E-01	-1.03E-02
HTP-c	CTUh	8.25E-11	4.58E-12	1.12E-12	5.09E-14	1.11E-12	0	1.67E-11	-5.18E-13
HTP-nc	CTUh	4.48E-09	2.31E-10	7.98E-11	3.52E-12	5.51E-11	0	1.85E-09	-2.01E-11
SQP	SQP	1.33E+00	1.47E-02	1.47E-02	2.28E-05	4.98E-04	0	4.07E-02	-8.32E-03

PM = Potential incidence of disease due to PM emissions; IR = Potential Human exposure efficiency relative to U235; ETP-fw = Potential comparative Toxic Unit for ecosystems; HTP-c = Potential comparative Toxic Unit for humans (cancerogenic); HTP-nc = Potential comparative Toxic Unit for humans (not cancerogenic); SQP = Potential soil quality index

Disclaimer 1 – for the indicator “Potential Human exposure efficiency relative to U235”. 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 or radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, radon and from some construction materials is also not measured by this indicator.

Disclaimer 2 – for the indicators “abiotic depletion potential for non-fossil resources”, “abiotic depletion potential for fossil resources”, “water (user) deprivation potential, deprivation-weighted water consumption”, “potential comparative toxic unit for ecosystems”, “potential comparative toxic unit for humans – cancerogenic”, “Potential comparative toxic unit for humans - not cancerogenic”, “potential soil quality index”. The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high as there is limited experience with the indicator.

This EPD was created using a software tool.

## References

### Standards

#### EN 934-2

EN 934-2+A1:2012. Admixtures for concrete, mortar and grout, Part2: Concrete admixtures - Definitions, requirements, conformity, marking and labelling.

#### EN 934-5

EN 934-5: 2007. Admixtures for concrete, mortar and grout – Part 5: Admixtures for sprayed concrete – Definitions, requirements, conformity, marking and labelling.

#### EN 480-10

Admixtures for concrete, mortar and grout. Test methods. Determination of water soluble chloride content.

#### EN 15804

EN 15804:2012+A1:2013, Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction products.

#### EN 15804

EN 15804:2012+A2:2019+AC:2021, Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction products.

#### ISO 14025

EN ISO 14025:2011, Environmental labels and declarations — Type III environmental declarations — Principles and procedures.

### Further References

#### IBU 2021

Institut Bauen und Umwelt e.V.: General Instructions for the EPD programme of Institut Bauen und Umwelt e.V., Version .0, Berlin: Institut Bauen und Umwelt e.V., 2021  
[www.ibu\[1\]epd.com](http://www.ibu[1]epd.com)

#### LCA Calculator

LCA Calculator software (version 6). Visualize, Improve and Report on Product Sustainability. [https://sphaera.com/your-path\[1\]to-sustainability/](https://sphaera.com/your-path[1]to-sustainability/)

#### LCA for Experts

Life cycle assessment software (version 10), by Sphaera Solutions GmbH, Leinfelden-Echterdingen, 2022  
<https://sphaera.com/life-cycle-assessment-lca-software/>

#### Managed LCA Content

Life cycle assessment database, by Sphaera Solutions GmbH, Leinfelden-Echterdingen, 2022, [https://sphaera.com/life-cycle\[1\]assessment-lca-database/](https://sphaera.com/life-cycle[1]assessment-lca-database/)

#### PCR Part A

PCR - Part A: Calculation rules for the Life Cycle Assessment and Requirements on the Background Report, version 1.3, Institut Bauen und Umwelt e.V., 08-2021.

#### PCR Part B

PCR – Part B: Requirements on the EPD for Concrete admixtures, Institut Bauen und Umwelt e.V., 04-2023.

**Publisher**

Institut Bauen und Umwelt e.V.  
Hegelplatz 1  
10117 Berlin  
Germany

+49 (0)30 3087748- 0  
[info@ibu-epd.com](mailto:info@ibu-epd.com)  
[www.ibu-epd.com](http://www.ibu-epd.com)

**Programme holder**

Institut Bauen und Umwelt e.V.  
Hegelplatz 1  
10117 Berlin  
Germany

+49 (0)30 3087748- 0  
[info@ibu-epd.com](mailto:info@ibu-epd.com)  
[www.ibu-epd.com](http://www.ibu-epd.com)

BUILDING TRUST

**Author of the Life Cycle Assessment**

Sika Sverige AB  
Domnarvsgatan 15  
16308 Spanga  
Sweden

+46 (0)703536883  
[yilmaz.ipek@se.sika.com](mailto:yilmaz.ipek@se.sika.com)  
<http://swe.sika.com/>

BUILDING TRUST

**Owner of the Declaration**

Sika Sverige AB  
Domnarvsgatan 15  
16308 Spanga  
Sweden

+46 (0)703536883  
[yilmaz.ipek@se.sika.com](mailto:yilmaz.ipek@se.sika.com)  
<http://swe.sika.com/>