

**Environmental
Product
Declaration**

According to EN15804+A2

This declaration is for:

Omega 420-110

Provided by:

Trelleborg Ridderkerk BV



MRPI® registration:
1.1.00993.2025

Program operator:
Stichting MRPI®
Publisher:
Stichting MRPI®
www.mrpi.nl

Date of first issue:

15-10-2025

Date of this issue:

15-10-2025

Expiry date:

15-10-2030

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MRPI® REGISTRATION

1.1.00993.2025

DATE OF THIS ISSUE

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EXPIRY DATE

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SCOPE OF DECLARATION

This MRPI®-EPD certificate is verified by Tim Mol, EcoReview. The LCA study has been done by Ayan Arinov, Trelleborg Ridderkerk BV. The certificate is based on an LCA-dossier according to EN15804+A2. It is verified according to the 'MRPI®-EPD verification protocol November 2020.v4.0'. EPDs of construction products may not be comparable if they do not comply with EN15804+A2. Declaration of SVHC that are listed on the 'Candidate list of Substances of Very High Concern for authorisation' when content exceeds the limits for registration with ECHA.

PROGRAM OPERATOR

Stichting MRPI®
Kingsfordweg 151
1043 GR
Amsterdam

PRODUCT

Omega 420-110

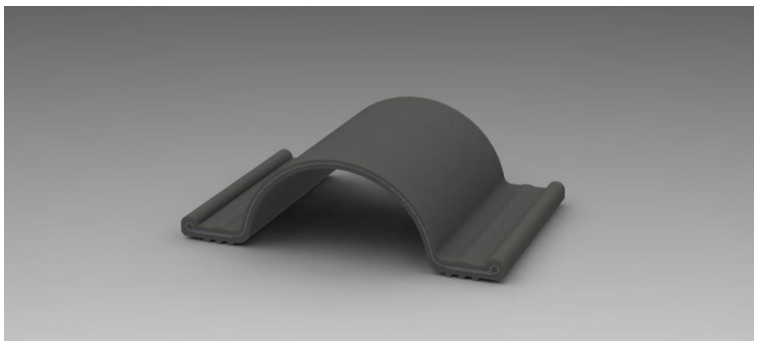
DECLARED UNIT / FUNCTIONAL UNIT

1 Layer thickness (m)

DESCRIPTION OF PRODUCT

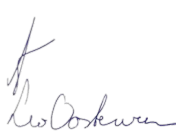
Omega seal is a secondary seal for immersed tunnels to prevent water ingress by hydrostatic pressure.

VISUAL PRODUCT



MORE INFORMATION

<https://www.trelleborg.com/en/marine-and-infrastructure/products-solutions-and-services/infrastructure/seals/omega>

Ing. L. L. Oosterveen MSc. MBA Managing Director MRPI	DEMONSTRATION OF VERIFICATION
	CEN standard EN15804 serves as the core PCR [1] Independent verification of the declaration an data according to EN15804+A2 Internal: External: X
	Third party verifier: Tim Mol, EcoReview 
	[1] PCR = Product Category Rules

DETAILED PRODUCT DESCRIPTION

This EPD covers a seal, model 420-110 produced by Trelleborg. The Omega seal is an engineered rubber compound made of synthetic rubber (SBR), carbon black (CB), and relevant additives. The Omega seal provides the unique properties to withstand high water pressure in combination with large movements in all directions. The Omega seal provides an ideal solution for joints where large gap movements are expected as a result of temperature effects and/or settlement. The seals are produced in Trelleborg's production site in Qingdao, China.

The reference unit for a seal is 1m of the Omega seal, which consists of 8.39kg of a rubber compound. Wooden boxes are used as a packaging material

Product specification	Omega 420-110
Product length [m]	1
Product weight per 1 m length [kg]	8.39
Packaging weight [kg]	2.52
Product service life [years]	200
Area of application	Immersed tunnels
Geographic region of manufacturing	China

Component (>0,5%)	%
SBR	Confidential
Carbon black	Confidential
Oil	Confidential
Antioxidants	Confidential
Sulfur	Confidential

SCOPE AND TYPE

This EPD is a specific EPD made for Omega 420-110, produced in a factory in Qingdao, China. The material input is from suppliers across China. The product is intended for use in the Fehmarn Island tunnel, Germany - Denmark, Europe. At the end of its service life, the product is also assumed to reach its End-of-Life (EoL) stage in Europe.

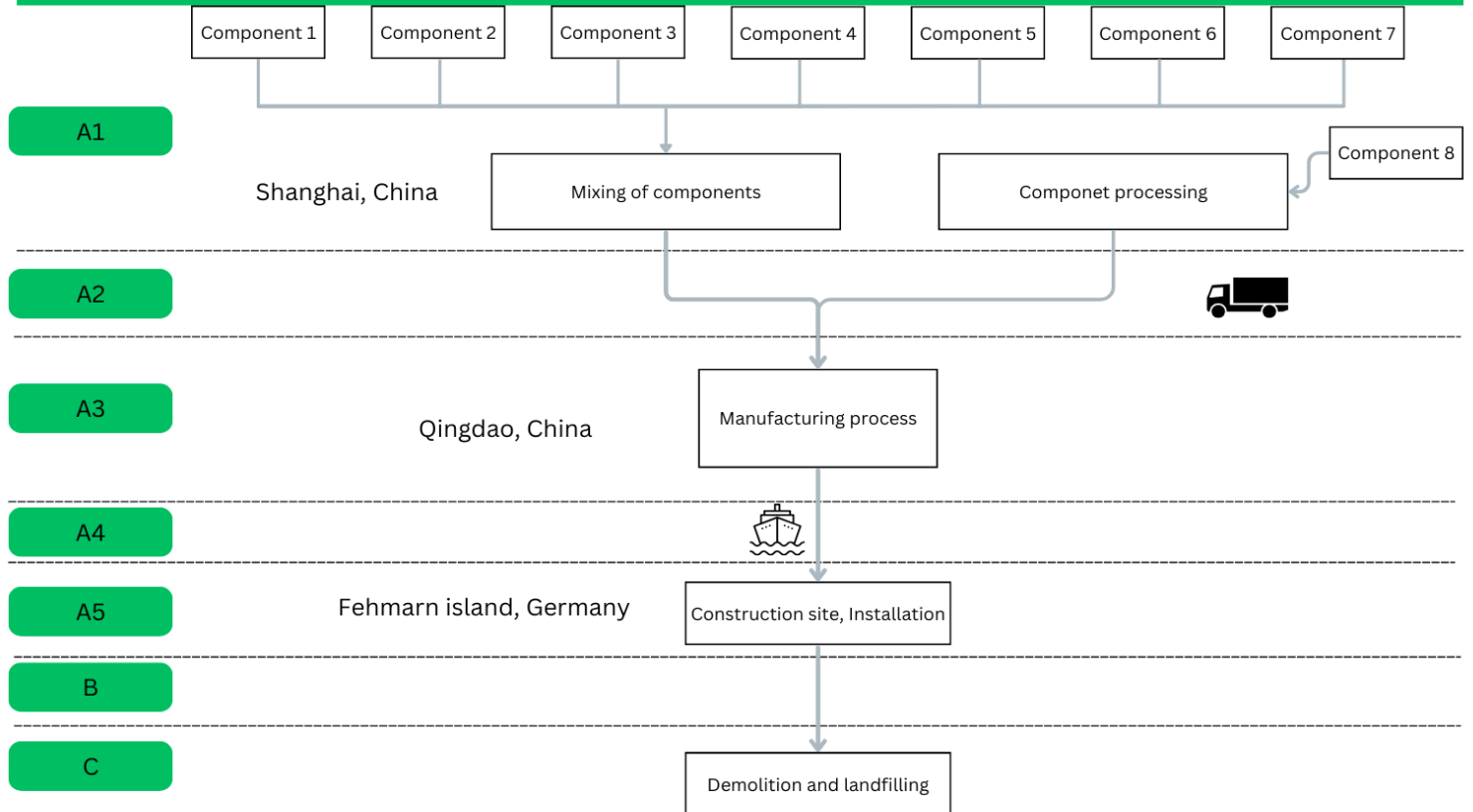
Data collection was completed in 2024. The results are calculated with SimaPro 9.6.0.1, using the Ecoinvent 3.10 database (cut-off).

PRODUCT STAGE			CONSTRUCTION PROCESS STAGE		USE STAGE							END OF LIFE STAGE				BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARIES
Raw material supply	Transport	Manufacturing	Transport gate to 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	x	X	ND	ND	ND	ND	X	X	X	X	X

X = Modules Assessed

ND = Not Declared

SYSTEM BOUNDARY



ENVIRONMENTAL IMPACT per functional unit or declared unit (core indicators A2)

Unit	A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
GWP-total kg CO2 eq.	3,55E+01	1,60E+00	5,11E+00	4,22E+01	2,49E+00	7,71E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	8,15E-01	2,42E-01	0,00E+00	3,05E+00	-2,16E-01
GWP-fossil kg CO2 eq.	3,86E+01	1,60E+00	5,11E+00	4,53E+01	2,49E+00	4,58E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	8,15E-01	2,42E-01	0,00E+00	3,05E+00	-2,14E-01
GWP-biogenic kg CO2 eq.	-3,13E+00	0,00E+00	0,00E+00	-3,13E+00	0,00E+00	3,13E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
GWP-luluc kg CO2 eq.	1,44E-02	6,36E-04	2,05E-03	1,71E-02	1,30E-03	2,77E-03	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	8,12E-05	7,97E-05	0,00E+00	1,17E-03	-1,09E-03
ODP kg CFC11 eq.	7,37E-07	2,25E-08	1,25E-08	7,72E-07	3,58E-08	4,00E-08	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,25E-08	4,84E-09	0,00E+00	1,49E-08	-1,85E-09
AP mol H+ eq.	1,45E-01	5,47E-03	2,38E-02	1,75E-01	7,23E-02	2,56E-02	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	7,32E-03	9,63E-04	0,00E+00	9,82E-03	-1,38E-03
EP-fresh water kg PO4 eq.	5,22E-03	1,25E-04	1,38E-03	6,72E-03	8,04E-05	1,05E-02	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	3,07E-05	1,62E-05	0,00E+00	1,14E-03	-7,67E-05
EP-marine kg N eq.	2,99E-02	1,80E-03	4,82E-03	3,65E-02	1,80E-02	7,18E-03	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	3,39E-03	3,63E-04	0,00E+00	2,92E-03	-4,26E-04
EP-terrestrial mol N eq.	2,55E-01	1,96E-02	5,01E-02	3,24E-01	2,00E-01	7,62E-02	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	3,71E-02	3,95E-03	0,00E+00	3,25E-02	-4,71E-03
POCP kg NMVOC eq.	1,41E-01	7,61E-03	1,39E-02	1,63E-01	5,42E-02	2,34E-02	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,11E-02	1,47E-03	0,00E+00	9,46E-03	-1,48E-03
ADP-minerals & metals kg Sb eq.	1,44E-04	5,12E-06	4,03E-06	1,53E-04	2,45E-06	6,26E-05	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	2,92E-07	7,77E-07	0,00E+00	8,03E-06	-4,55E-07
ADP-fossil MJ, net calorific value	7,66E+02	2,24E+01	7,51E+01	8,64E+02	3,06E+01	5,01E+01	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,07E+01	3,42E+00	0,00E+00	1,85E+01	-2,63E+00
WDP m3 world eq. Deprived	1,18E+01	1,23E-01	5,85E-01	1,25E+01	9,31E-02	9,57E-01	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	3,25E-02	1,90E-02	0,00E+00	3,57E-01	-3,48E-02

GWP-total	=	Global Warming Potential total
GWP-fossil	=	Global Warming Potential fossil fuels
GWP-biogenic	=	Global Warming Potential biogenic total
GWP-luluc	=	Global Warming Potential land use and land use change
ODP	=	Depletion potential of the stratospheric ozone layer
AP	=	Acidification Potential, Accumulated Exceedence
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 Exceedence
POCP	=	Formation potential of tropospheric ozone photochemical oxidants
ADP-minerals & metals	=	Abiotic Depletion Potential for non-fossil resources [1]
ADP-fossil	=	Abiotic Depletion for fossil resources potential [1]
WDP	=	Water (user) deprivation potential, deprivation-weighted water consumption [1]

Disclaimer [1]:

- 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 experience with the indicator.

ENVIRONMENTAL IMPACT per functional unit or declared unit (additional indicators A2)

Unit		A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
PM	Disease incidence	1,78E-06	1,27E-07	5,60E-07	2,46E-06	7,60E-08	4,77E-07	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	2,08E-07	1,96E-08	0,00E+00	1,03E-07	-7,03E-08
IRP	kBq U235 eq.	7,52E-01	1,84E-02	3,53E-01	1,12E+00	1,41E-02	2,00E-01	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	6,02E-03	4,39E-03	0,00E+00	2,94E-02	-1,38E-02
ETP-fw	CTUe	1,45E+02	4,33E+00	2,48E+01	1,74E+02	3,93E+00	2,80E+01	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,17E+00	7,36E-01	0,00E+00	2,12E+02	-8,11E-01
HTP-c	CTUh	2,02E-07	8,29E-09	1,09E-08	2,21E-07	1,05E-08	7,00E-08	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	3,18E-09	1,70E-09	0,00E+00	4,16E-09	-1,45E-09
HTP-nc	CTUh	2,05E-07	1,44E-08	2,34E-08	2,42E-07	8,02E-09	6,19E-08	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,48E-09	2,20E-09	0,00E+00	2,49E-08	-1,91E-09
SQP	-	4,65E+02	1,34E+01	1,46E+01	4,93E+02	2,82E+00	2,04E+01	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	7,56E-01	2,03E+00	0,00E+00	1,93E+01	-2,49E+02

- PM = Potential incidence of disease due to PM emissions
- IRP = Potential Human exposure efficiency relative to U235 [1]
- ETP-fw = Potential Comparative Toxic Unit for ecosystems [2]
- HTP-c = Potential Comparative Toxic Unit for humans, cancer [2]
- HTP-nc = Potential Comparative Toxic Unit for humans, non-cancer [2]
- SQP = Potential soil quality index [2]

Disclaimer [1]:

- This impact category deals mainly with the eventual impact of low dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure nor due to radioactive waste.

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 experience with the indicator.

OUTPUT FLOWS AND WASTE CATEGORIES per functional unit or declared unit (A1 en A2)

	Unit	A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
HWD	kg	1,65E+00	3,93E-02	1,16E+00	2,85E+00	4,08E-02	6,31E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,20E-02	4,92E-03	0,00E+00	1,70E+01	-1,75E-02
NHWD	kg	2,50E+01	7,38E-01	7,74E+00	3,34E+01	5,56E-01	8,53E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,97E-01	1,04E-01	0,00E+00	1,69E+00	-3,50E-01
RWD	kg	1,83E-04	4,51E-06	8,66E-05	2,74E-04	3,44E-06	4,95E-05	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,54E-06	1,09E-06	0,00E+00	7,28E-06	-3,36E-06
CRU	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	ND	ND	ND	ND	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
MFR	kg	4,28E-03	1,65E-04	1,62E-03	6,06E-03	3,60E-03	8,69E-02	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	3,26E-05	2,57E-05	0,00E+00	2,22E-04	-7,53E-05
MER	kg	3,58E-05	1,45E-06	2,65E-06	3,99E-05	5,76E-07	3,55E-05	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,46E-07	2,17E-07	0,00E+00	2,63E-06	-2,07E-07
EEE	MJ	6,11E-02	1,63E-03	9,14E-04	6,36E-02	1,43E-03	1,36E-02	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,70E-03	5,82E-04	0,00E+00	2,28E-03	-1,06E-03
ETE	MJ	1,06E-01	3,29E-03	3,99E-03	1,13E-01	1,01E-03	4,43E-02	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	2,71E-04	8,43E-04	0,00E+00	2,08E-03	-2,56E-04

HWD = Hazardous Waste Disposed
 NHWD = Non Hazardous Waste Disposed
 RWD = Radioactive Waste Disposed
 CRU = Components for reuse
 MFR = Materials for recycling
 MER = Materials for energy recovery
 EEE = Exported Electrical Energy
 ETE = Exported Thermal Energy

RESOURCE USE per functional unit or declared unit (A1 and A2)

	Unit	A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
PERE	MJ	7,89E+01	2,94E-01	4,27E+00	8,35E+01	2,29E-01	7,05E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	8,50E-02	5,79E-02	0,00E+00	7,75E-01	-4,09E+01
PERM	MJ	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	ND	ND	ND	ND	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
PERT	MJ	7,89E+01	2,94E-01	4,27E+00	8,35E+01	2,29E-01	7,05E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	8,50E-02	5,79E-02	0,00E+00	7,75E-01	-4,09E+01
PENRE	MJ	7,66E+02	2,24E+01	7,51E+01	8,64E+02	3,06E+01	5,01E+01	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,07E+01	3,42E+00	0,00E+00	1,85E+01	-2,64E+00
PENRM	MJ	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	ND	ND	ND	ND	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
PENRT	MJ	7,66E+02	2,24E+01	7,51E+01	8,64E+02	3,06E+01	5,01E+01	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,07E+01	3,42E+00	0,00E+00	1,85E+01	-2,64E+00
SM	kg	1,24E+00	1,01E-02	6,37E-03	1,26E+00	1,46E-02	2,74E-01	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	4,41E-03	1,57E-03	0,00E+00	4,65E-03	-2,25E-03
RSF	MJ	1,48E-03	1,28E-04	5,81E-05	1,66E-03	3,37E-05	1,03E-03	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	1,16E-05	1,98E-05	0,00E+00	1,02E-04	-1,83E-04
NSRF	MJ	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	ND	ND	ND	ND	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
FW	m3	2,81E-01	3,00E-03	1,63E-02	3,00E-01	2,28E-03	2,81E-02	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	7,94E-04	4,68E-04	0,00E+00	8,70E-03	-9,28E-04

PERE	=	Use of renewable primary energy excluding renewable primary energy 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 resources excluding non-renewable 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 materials
RSF	=	Use of renewable secondary fuels
NSRF	=	Use of non-renewable secondary fuels
FW	=	Use of net fresh water

BIOGENIC CARBON CONTENT per functional unit or declared unit (A1 and A2)

	Unit	A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
BBCpr	kg C	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	ND	ND	ND	ND	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
BCCpa	kg C	-8,53E-01	0,00E+00	0,00E+00	-8,53E-01	0,00E+00	8,53E-01	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00

BCCpr	=	Biogenic carbon content in product
BCCpa	=	Biogenic carbon content in packaging

CALCULATION RULES

No cut-offs were intentionally applied to inputs and outputs within the system boundaries of the models. All known energy and material flows within the system boundaries are considered.

Specific data was collected from Trelleborg's Qingdao facility through a questionnaire, covering details such as exact raw material composition, energy consumption, packaging, logistics (e.g., transport), and production information. The end-of-life scenario is based on industry practices for similar products. The data collection period for specific data was the year 2024.

As the manufacturing process takes place in China, country and region-specific datasets for electricity were used:

Electricity, low voltage {CN-SD}| electricity production, photovoltaic, 3kWp slanted-roof installation, multi-Si, panel, mounted | EN15804, U for installed solar panels energy, SD- Shandong region;

Electricity, medium voltage {CN-ECGC}| market for electricity, medium voltage | EN15804, U for electricity grid, ECGC - East Grid where part of the manufacturing operation happens;

Electricity, medium voltage {CN-SWG}| market for electricity, medium voltage | EN15804, U for electricity grid, SWG - SouthWest grid, where part of the manufacturing operation happens.

Global warming potential of the electricity used	value
GWP-total of the electricity in kg CO2e/kWh	0.78
GWP-total [kg]	3.39
Total electricity used [kWh]	4.33

SCENARIOS AND ADDITIONAL TECHNICAL INFORMATION

A1. Raw Material Supply

This module considers the extraction and processing of all raw materials and energy used upstream in the manufacturing process of the Omega 420-110 seal.

A2. Transport of Raw Materials to Manufacturer

This module accounts for the transportation of raw materials to the manufacturing facility via road. Distances and transport modes were modeled using primary data.

A3. Manufacturing

This stage describes the production process of Trelleborg's Omega seals, including the use of electricity, steam, and solar energy (via PV panels).

Data on seal production was collected from the manufacturing site. Transportation distances and modes for raw materials, packaging materials, and deliveries to customers were provided by Trelleborg and its suppliers.

The construction site data includes factors such as lights, heating, and office facilities. However, the manufacture of production equipment and infrastructure is excluded from the system boundary. Manufacturing waste and production loss treatment are included in this module.

A4. Transport to Customer

Seals are transported from the production facility to customers primarily via road and sea transport. Fehmarn Island has been chosen as the final destination for this assessment.

A5. Installation Process

This module covers the environmental aspects and impacts of attaching the seal to the tunnel block. The installation process involves building equipment such as drills and lifting machines, and their energy consumption is considered. Additionally, product packaging is discarded, and its waste treatment is included in this module.

B1 – B3. Use stage.

B1 (Use Stage), B2 (Maintenance) & B3 (Repair): The Omega seal is installed within tunnel blocks, which are then immersed to each other. As a result, no use, maintenance, or repair impacts are associated with these stages. No further inputs or outputs are related to the use stage, as there are no emissions from the products.

C1. Deconstruction and demolition. This module includes the disassembly and demolition of the seal at the end of life. The removal of the gasket from the tunnel block is done using the building equipment.

C2. Transport of waste. This module includes one-way transportation distance to a landfill site.

C3. Waste processing and C4. Disposal The end-of-life stage is encompassed in these modules. The end-of-life scenario of the seal is based on the industry practices assumption. Due to the release of biogenic carbon as a result of landfilling the seals at the end of life, the result in module C4 was adjusted based on the biogenic uptake in modules A1-A3.

D. Reuse, recovery, recycling potential Module D provides information on the potential burdens and benefits from recycling of the product packaging.

Scenario	Value
Product share goes to landfilling [%]	100
Distance to landfilling site [km]	150

DECLARATION OF SVHC

No SVHCs were present in the product or factory during the manufacturing of the materials in concentrations exceeding 0.1% w/w. This determination is based on engineering evaluations, testing conducted in a manufacturing facility, and supplier declarations.

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