



# ENVIRONMENTAL PRODUCT DECLARATION

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

## MASTER POWER 32.5 (CEM II/C-M (V-L) 32.5R) ÇİMSA Çimento San. ve Tic.

An EPD should provide current information and may be updated if conditions change. The stated validity is therefore subject to the continued registration and publication at [www.environdec.com](http://www.environdec.com).



**Programme:**

The International EPD® System  
[www.environdec.com](http://www.environdec.com)

**Programme Operator:**

EPD International AB

**Licensee:**

EPD Türkiye

**EPD Registration Number:**

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**Version Date:**

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**Validity Date:**

2029-12-22

**Geographical Scope:**

Global

# Programme Information

## Licensee

EPD registered through fully aligned regional programme: EPD Türkiye

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

Product Category Rules (PCR):

PCR 2019:14 Construction products, version 1.3.4, Construction EN 15804:2012+A2:2019/AC:2021 Sustainability of Construction Works and c-PCR-001 Cement and building lime (EN 16908) (2024-04-30).

UN CPC Code: 3744

“Portland cement, aluminous cement, slag cement, and similar hydraulic cement, except in the form of clinkers.”

PCR review was conducted by: The Technical Committee of the International EPD® System. Review chair: Claudia A. Peña, University of Concepción, Chile

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

EPD process certification

EPD verification **X**

Third party verifier: Stephen Forson, ViridisPride Ltd.

Approved by: The International EPD® System

Procedure for follow-up of data during EPD validity involves third party verifier:

Yes

No **X**

LCA practitioner: Yıldırım Yılmaz & Işıl Atalay Sirt -- Metsims Sustainability Consulting

EPDs within the same product category but registered in different EPD programmes may not be comparable. 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 versions of PCRs; cover products with identical functions, technical performances and use (e.g. identical declared/functional units); have equivalent system boundaries and descriptions of data; apply equivalent data quality requirements, methods of data collection, and allocation methods; apply identical cut-off rules and impact assessment methods (including the same version of characterisation factors); have equivalent content declarations; and be valid at the time of comparison. The EPD owner has the sole ownership, liability, and responsibility for the EPD.

# About Company

Çimsa, a subsidiary of Sabancı Holding, was founded in Mersin in 1972. Today, the company operates four integrated production plants in Türkiye, located in Mersin, Eskişehir, and Afyonkarahisar. In addition to producing grey cement, Çimsa leads the Turkish cement and building materials sector in innovation, offering specialized products such as white cement and CAC (calcium aluminate cement). Committed to delivering profitable growth and creating value for all stakeholders, Çimsa remains focused on sustaining this trajectory into the future.

Çimsa, one of the world's foremost brands in white cement and one of the world's top three producers of CAC with the latest investment completed in Mersin, manages its international operations through its Netherlands based subsidiary, Cimsa Building Solutions BV.

Cimsa Building Solutions BV has emerged as a key player in the international white cement market, with a white cement production plant in Valencia, Spain, a grinding plant in Houston, USA, and terminals in Hamburg, Germany, Trieste, Italy, and Seville, Spain.

Further expanding its global footprint, Cimsa Building Solutions BV acquired Ireland-based Mannok Holdings in October 2024, a company specializing in cement, cement-based products (such as tiles, precast materials, and concrete), insulation materials, and recycled plastic packaging.

Çimsa, which develops new technologies that shed light on the future of the building materials industry in Türkiye through its first R&D Center, Formula Center—approved by the Ministry of Industry and Technology—operates at the Mersin Plant. This is the only integrated facility in the world capable of producing grey cement, white cement, and CAC and has at the same time extended its innovation power to Europe through the Sabancı Technology Center located on the campus of the Technical University of Munich in Germany. Çimsa ensures the complete and timely fulfillment of its customers' product and service needs through its market-focused approach and extensive distribution network. As a trusted partner to its stakeholders, the company delivers essential materials for living spaces and infrastructures designed to endure for generations to come.



# About Product

Çimsa Master Power (CEM II/C-M (V-L) 32.5 R) Portland composite cement comprises portland cement clinker, fly ash, limestone, and gypsum, in accordance with the TS EN 197-5:2021 standard. Workability, consistency, and finish properties have been enhanced for plaster-mortar applications. Stability remains the central focus at Çimsa's production facilities, with product parameter variations minimized through controls carried out at every process

stage, from raw materials to delivery. The production processes hold certifications compliant with EN ISO 9001, EN ISO 14001, EN ISO 50001, ISO 10002, and ISO 45001 standards.

Çimsa Master Power cement undergoes quality control in accordance with EN 197-5 standards. The product is available in both domestic and foreign markets with a CE certificate.



## Advantages in applications;

- With its low density, the product increases the yield in plaster-mortar productions.
- The product resists cracking due to its low shrinkage property in screed concretes.
- The product also displays resistance to moisture in exterior plasters, making it ideal for projects near the sea.
- The product is compatible with building limes and plasticizing additives.
- The product complies with the chromium (VI) guideline, reducing the risk of allergic dermatitis upon contact.



## Application areas;

Çimsa Master Power portland composite cement is suitable for use in various building applications such as plaster, mortar, leveling screed, coating, insulation, tile and ceramic adhesive.



## Product Composition

*Product components	Weight, %	Post-consumer recycled material, weight-%	Biogenic material, weight of % of product
Gray clinker	50 - 55	0	0
Cementitious materials	40 - 45	0	0
Gypsum	5 - 8	0	0
SUM	100	0	0

## Packaging Composition

Packaging materials	Weight, kg	Weight-% (versus the product)	Biogenic material, kg C/declared unit
Paper bag	3.66	0.366	1.91
Big bag	0.43	0.048	0
SUM	4.09	0.409	1.91

\*Product composition is presented as percentages rather than specific weights to maintain confidentiality while transparently communicating the relative proportions of each component.

# About Product

The declared product in this EPD is Çimsa CEM II/C-M (V-L) cement, manufactured by Ç MSA at the company's production facility in Mersin, Türkiye.

This cement primarily consists of clinker, gypsum, limestone, fly ash, and GGBS, and it falls under the UN CPC Code 3744, which includes Portland cement, aluminous cement, slag cement, and similar hydraulic cements, except in the form of clinkers.



Properties	Çimsa Values	Standart Limit (EN 197-1)	
		Min.	Max.
Specific Gravity	2,93 gr/cm <sup>3</sup>	-	-
Specific Surface (Blaine)	4000-4600 cm <sup>2</sup> /gr	-	-
Initial Setting	150 -240 minutes	75	-
Final Setting	200 - 230 minutes	-	-
Water	% 28-30	-	-
Volume Constancy (Le Chatelier)	1,0 mm	-	10
0.045 mm Retained Material	2,5 - 5,0	-	-
0.090 mm Retained Material	0,1 - 0,5	-	-
2-Day Compressive Strength	14 - 21 MPa	10	-
28-Day Compressive Strength	33 - 38 MPa	32.5	52.5

Çimsa cement products are produced according to EN 197-1 standard. Production processes are certified according to EN ISO 9001, EN ISO 45001 and EN ISO 14001.

# LCA Information

Declared Unit 1 tonnes of Master Power cement

Time Representativeness 2023

Database(s) and LCA Software Used Ecoinvent 3.10 & SimaPro 9.6

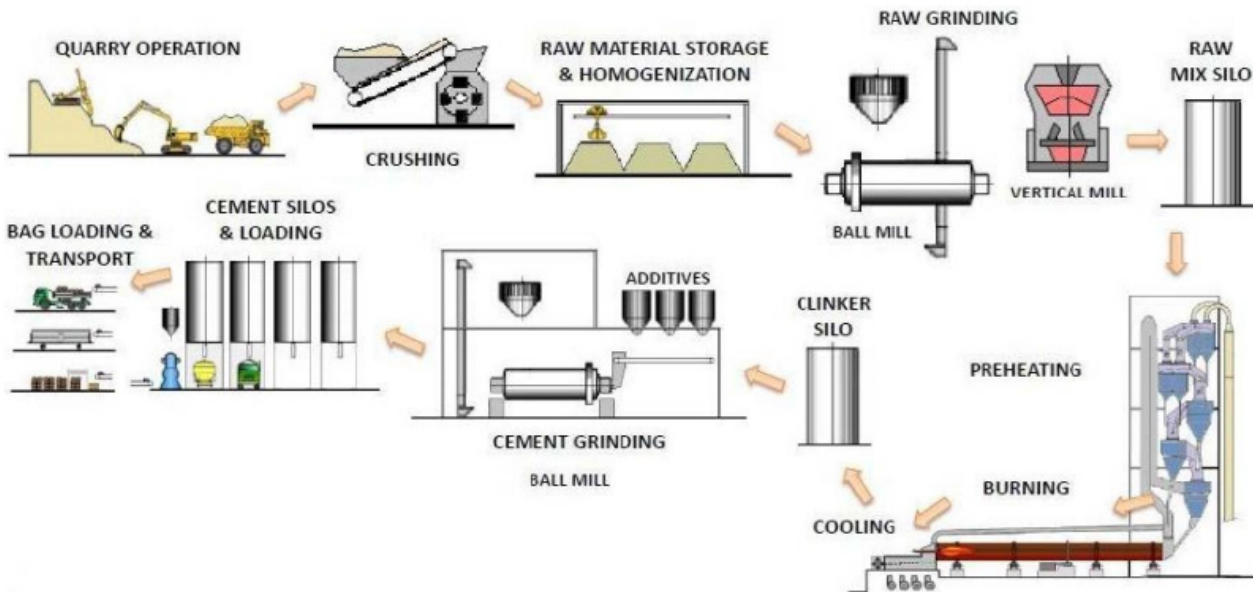
The inventory for the LCA study is based on the 2023 production figures for CEM II/C-M (V-L) 32.5 R by Çimsa produced in Mersin, Türkiye.

This EPD's system boundary is cradle to gate. The results of the LCA with the indicators as per EPD requirement are given in the following tables for product manufacture (A1, A2, A3), and transportation stages (A4). According to EN 15804+A2:2019 standard, if the product or material is physically integrated with other products during installation then they cannot be physically separated at the end of life stage. For this reason, modules C1-C4 and Module D are excluded.

	Product Stage			Construction Process Stage		Use Stage							End of Life Stage			Benefits and Loads	
	Raw Material Supply	Transport	Manufacturing	Transport	Construction Installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational Energy Use	Operational Water Use	Deconstruction / Demolition	Transport	Waste Processing		Disposal
Module	A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Modules Declared	X	X	X	X	X	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
Geography	GLO	GLO	TR	GLO	GLO	-	-	-	-	-	-	-	-	-	-	-	-
Specific Data Used	72%			-	-	-	-	-	-	-	-	-	-	-	-	-	-
Variation - Products	0%			-	-	-	-	-	-	-	-	-	-	-	-	-	-
Variation - Sites	0%			-	-	-	-	-	-	-	-	-	-	-	-	-	-

GLO: Global, TR: Türkiye, X = Module included, ND = Not declared

# System Boundary



**Process Flow Diagram**

## A1: Raw Material Supply

This stage includes raw materials extraction and pre-treatment processes before production. The investigated product is a specific calcium aluminate cement produced entirely with calcium aluminate clinker. To produce this clinker, raw materials such as limestone and bauxite are used. The impact of these raw materials are calculated at this stage.

## A2: Raw Material Transport

This stage includes transportation related impacts of needed materials for the production of clinker and subsequently the final cement. It is observed that both highway and seaway transportation are involved at this stage. Transport routes and distances are supplier-specific and provided by the manufacturer.

Transport Mode	Type
Road	Vehicle: Lorry, Size class: >32 metric ton, Emission standard: Euro6, Fuel Type: Diesel
Sea	Vehicle: Bulk carrier, DWT (Load capacity): 51000 tonnes, Fuel Type: Heavy fuel oil

# System Boundary

## A3: Manufacturing

Calcium aluminate cement (CAC) is produced by blending finely ground limestone ( $\text{CaCO}_3$ ) and bauxite ( $\text{Al}_2\text{O}_3$ ) in precise proportions. The mixture is heated in a L-shaped kilns at minimum  $1,600^\circ\text{C}$  to form clinker rich in calcium aluminate phases. The clinker is then cooled and ground into a fine powder to create the cement. All energy inputs are sourced from the manufacturer's 2023 supply.

## A4: Transport to Customer

This stage is relevant for the delivery of final product to the intended markets and customers. Highway and seaway transportation are involved in this stage. The transport routes and distances are supplier-specific and provided by the manufacturer.

Transport Mode	Type
Road	Vehicle: Lorry, Size class: >32 metric ton, Emission standard: Euro6, Fuel Type: Diesel
Sea	Vehicle: Bulk carrier, DWT (Load capacity): 51,000 tonnes, Fuel Type: Heavy fuel oil

## A5: Installation

This stage includes end-of-life impacts of packaging materials. Due to the lack of information, these packaging products are assumed to be landfilled in order not to provide false carbon benefit to the manufacturer.



## System Boundary

Cradle to gate with optional modules (A4 & A5).

## Cut-Off Rules

The criteria for exclusion were set so that individual input flows less than 1% of the total, with a cumulative limit of less than 5%, could be omitted. This was contingent upon confirming that these excluded flows did not significantly alter the reported data, with “significant” defined as affecting the total by less than 5%.

## REACH Regulation

No substances included in the Candidate List of Substances of Very High Concern for authorization under the REACH regulations are present in this product either above the threshold for registration with the European Chemicals Agency or above 0.1% (wt/wt).

## LCA Modelling, Calculation and Data Quality

The results of the LCA with the indicators as per EPD requirements are given in the LCA result tables. All energy calculations were obtained using Cumulative Energy Demand (LHV) methodology, while freshwater use is calculated with selected inventory flows in SimaPro according to the PCR. There are no co-product allocations within the LCA study underlying this EPD. The regional energy datasets were used for all energy calculations.

Characterization factors of EN 15804 reference package based on EF 3.1 are utilized. Impact of infrastructure and capital goods are excluded from the analysis.

The data used for LCA study concerns the year 2023.

## Source of Electricity

The modeled electricity data for the manufacturing of the investigated product is taken from ecoinvent 3.10 database which has carbon density of 0.575 kg CO<sub>2</sub> eq. / kWh for medium voltage electricity production. The selected electricity data consists of around 35% electricity production from hard coal and lignite, 29.2% hydro, 19.4% natural gas, 9.4% wind, 3.5% geothermal, 1.2% co-generation from natural gas, 1.1% biogas and around 1.2% from various other sources.

## Allocations

Energy consumption and raw material transportation were weighted according to 2023 production figures. In addition, hazardous and non-hazardous waste amounts were also allocated from the total waste generation in 2023.

## Assumptions

Upstream and downstream road transportation are assumed to be carried out with Euro5 motor vehicles with a size class of > 32 metric tonnes where distances acquired through Google Maps. In addition, 100 km distance for the waste transport at C2 stage is assumed.

# LCA Results

The LCA results provided below are for 1 tonne of Master Power (CEM II C-M (V-L) 32.5 R) cement. The estimated impact results are only relative statements, which do not indicate the endpoints of the impact categories, exceeding threshold values, safety margins and/or risks.

Core Environmental Impact Indicators (Mandatory)				
Impact Category	Unit	A1-A3	A4	A5
GWP - Total	kg CO <sub>2</sub> eq.	5.80E+02	5.99E+00	6.05E+00
GWP - Fossil	kg CO <sub>2</sub> eq.	5.86E+02	5.99E+00	1.35E-01
GWP - Biogenic	kg CO <sub>2</sub> eq.	-5.76E+00	1.09E-03	5.92E+00
GWP - Luluc	kg CO <sub>2</sub> eq.	3.12E-01	2.90E-03	1.94E-05
ODP	kg CFC-11 eq.	8.24E-06	9.30E-08	1.70E-09
AP	mol H <sup>+</sup> eq.	1.46E+00	5.75E-02	1.17E-03
EP - Freshwater	kg P eq.	6.42E-02	4.07E-04	2.88E-05
EP - Marine	kg N eq.	3.69E-01	1.34E-02	6.88E-04
EP - Terrestrial	mol N eq.	4.10E+00	1.48E-01	5.70E-03
POCP	kg NMVOC	1.71E+00	4.92E-02	1.44E-03
*ADPE	kg Sb eq.	7.29E-05	1.39E-05	2.07E-07
*ADPF	MJ	8.92E+02	7.16E+00	1.61E-01
*WDP	m <sup>3</sup> depriv.	6.40E+01	3.81E-01	2.24E-02
Additional environmental impact indicators (Mandatory)				
**GWP-GHG	kg CO <sub>2</sub> eq.	5.87E+02	6.00E+00	1.33E-01
Additional environmental impact indicators (Optional)				
PM	disease inc.	9.46E-06	4.65E-07	9.07E-09
***IR	kBq U-235 eq.	1.74E+01	6.75E-02	2.62E-03
ETP-FW	CTUe	3.45E+02	1.95E+01	2.47E+00
*HTP - C	CTUh	1.42E-07	3.04E-08	1.29E-09
*HTP - NC	CTUh	3.19E-06	4.60E-08	1.06E-08
*SQP	Pt	1.07E+03	6.53E+01	3.53E-01
Acronyms	GWP-total: Climate change, GWP-fossil: Climate change- fossil, GWP-biogenic: Climate change - biogenic, GWP-luluc: Climate change - land use and transformation, ODP: Ozone layer depletion, AP: Acidification terrestrial and freshwater, EP-freshwater: Eutrophication freshwater, EP-marine: Eutrophication marine, EP-terrestrial: Eutrophication terrestrial, POCP: Photochemical oxidation, ADPE: Abiotic depletion - elements, ADPF: Abiotic depletion - fossil resources, WDP: Water scarcity, PM: Respiratory inorganics - particulate matter, IR: Ionising radiation, ETP-FW: Ecotoxicity freshwater, HTP-c: Cancer human health effects, HTP-nc: Non-cancer human health effects, SQP: Land use related impacts, soil quality.			
Legend	A1: Raw Material Supply, A2: Transport, A3: Manufacturing, A4: Transport, A5: Installation			

Indicators describing resource use (Mandatory)				
Impact Category	Unit	A1-A3	A4	A5
PERE	MJ	3.37E+02	1.03E+00	5.17E+01
PERM	MJ	5.16E+01	0.00E+00	-5.16E+01
PERT	MJ	3.89E+02	1.03E+00	3.88E-02
PENRE	MJ	8.78E+02	7.16E+00	1.42E+01
PENRM	MJ	1.40E+01	0.00E+00	-1.40E+01
PENRT	MJ	8.92E+02	7.16E+00	1.61E-01
SM	kg	0.00E+00	0.00E+00	0.00E+00
RSF	MJ	0.00E+00	0.00E+00	0.00E+00
NRSF	MJ	0.00E+00	0.00E+00	0.00E+00
FW	m <sup>3</sup>	4.54E+00	1.37E-02	2.71E-03
Acronyms	PERE: Use of renewable primary energy excluding resources used as raw materials, PERM: Use of renewable primary energy resources used as raw materials, PERT: Total use of renewable primary energy, PENRE: Use of non-renewable primary energy excluding 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, SM: Secondary material, RSF: Renewable secondary fuels, NRSF: Non-renewable secondary fuels, FW: Net use of fresh water.			
Environmental information describing waste categories (Mandatory)				
Impact Category	Unit	A1-A3	A4	A5
HWD	kg	7.72E-02	2.13E-03	4.23E-01
NHWD	kg	1.23E+01	5.41E+00	4.09E+00
RWD	kg	4.67E-03	1.65E-05	6.68E-07
Environmental information describing Output flow (Mandatory)				
CRU	kg	0.00E+00	0.00E+00	0.00E+00
MFR	kg	0.00E+00	0.00E+00	0.00E+00
MER	kg	0.00E+00	0.00E+00	0.00E+00
EE (Electrical)	MJ	0.00E+00	0.00E+00	0.00E+00
EE (Thermal)	MJ	0.00E+00	0.00E+00	0.00E+00
Acronyms	HWD: Hazardous waste disposed, NHWD: Non-hazardous waste disposed, RWD: Radioactive waste disposed, CRU: Components for reuse, MFR: Material for recycling, MER: Materials for energy recovery, EE (Electrical): Exported energy electrical, EE (Thermal): Exported energy thermal.			
*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 experienced with the indicator			
**Disclaimer 2	GWP-GHG = Global Warming Potential total excl. biogenic carbon following IPCC AR5 methodology The indicator includes all greenhouse gases included in GWP-total but excludes biogenic carbon dioxide uptake and emissions and biogenic carbon stored in the product. This indicator is thus equal to the GWP indicator originally defined in EN 15804:2012+A1:2013			
***Disclaimer 3	This impact category deals mainly with the eventual impact of low dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure nor due to radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, from radon and from some construction materials is also not measured by this indicator.			

# References

ISO 9001:2015/ Quality Management Systems

ISO 50001:2018/ Energy Management Systems

GPI/ General Programme Instructions of the International EPD® System. Version 4.0.

ISO 14020:2000/ Environmental Labels and Declarations – General principles

EN 15804:2012+A2:2019/AC:2021 Sustainability of construction works - Environmental Product Declarations – Core rules for the product category of construction products

European Committee for Standardization (CEN). (2011). EN 197-1: Cement - Part 1: Composition, specifications and conformity criteria for common cements. Brussels, Belgium: CEN.

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International Organization for Standardization (ISO). (2018). ISO 45001: Occupational health and safety management systems - Requirements with guidance for use. Geneva, Switzerland: ISO.

International Organization for Standardization (ISO). (2015). ISO 14001: Environmental management systems - Requirements with guidance for use. Geneva, Switzerland: ISO.

ISO 14025/ DIN EN ISO 14025:2009-11: Environmental labels and declarations - Type III environmental declarations – Principles and procedures

ISO 14040/44/ DIN EN ISO 14040:2006-10, Environmental management - Life cycle assessment - Principles and framework (ISO14040:2006) and Requirements and guidelines (ISO 14044:2006)

PCR for Construction Products and Construction Services/ Prepared by IVL Swedish Environmental Research Institute, Swedish environmental Protection Agency, SP Trä, Swedish Wood Preservation Institute, Swedisol, SCDA, Svenskt Limträ AB, SSAB, The International EPD System, 2019:14 Version 1.3.4.

The International EPD® System/ The International EPD® System is a programme for type III environmental declarations, maintaining a system to verify and register EPD®s as well as keeping a library of EPD®s and PCRs in accordance with ISO 14025. [www.environdec.com](http://www.environdec.com)

Ecoinvent / Ecoinvent Centre, [www.ecoinvent.org](http://www.ecoinvent.org)

SimaPro/ SimaPro LCA Software, Pré Consultants, the Netherlands, [www.pre-sustainability.com](http://www.pre-sustainability.com)

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