

AIR POLLUTION CONTROL PERMIT TO CONSTRUCT

Permittee: Name: Hiland Partners Holdings, LLC	Permit Number: ACP-18286 v 1.0
Address: 1001 Louisiana Street, Suite 1000 Houston, TX 77002	Permit Description: Synthetic Minor; Existing Title V
Source Name & Location: Watford City Gas Plant 14933 35th St NW Alexander, North Dakota 58831 SE ¼, Sec. 6, T151N, R102W McKenzie County	Source Type: Natural Gas Processing Plant
Date of Application: January 15, 2025	

Pursuant to Chapter 23.1-06 of the North Dakota Century Code (NDCC), and the Air Pollution Control Rules of the State of North Dakota (Article 33.1-15 of the North Dakota Administrative Code or NDAC), and in reliance on statements and representations heretofore made by the permittee (i.e., owner) designated above, a Permit to Construct is hereby issued authorizing such permittee to construct and initially operate the source unit(s) at the location designated above. This Permit to Construct is subject to all applicable rules and orders now or hereafter in effect of the North Dakota Department of Environmental Quality (Department) and to any conditions specified below:

Date: _____

James L. Semerad
Director
Division of Air Quality

1. Project and Facility Emissions Units:

This Permit to Construct allows the construction and initial operation of the herein-mentioned new or modified equipment at the source. The source may be operated under this Permit to Construct until a Permit to Operate is issued unless this permit is suspended or revoked. The source is subject to all applicable rules, regulations, and orders now or hereafter in effect of the North Dakota Department of Environmental Quality and to the conditions specified herein.

Table 1-1 lists the new emissions units associated with the Project.

Table 1-2 lists all emissions units associated with the facility upon Project completion.

Table 1-1: Project Emissions Units (new to facility)

Emission Unit Description ^A	Emission Unit (EU)	Emission Point (EP)	Air Pollution Control Equipment
Waukesha 7044 GSI S5 (4SRB) natural gas-fired compressor engine rated at 1,900 bhp (manuf. 08/2019, NSPS JJJJ, NSPS OOOOa, MACT ZZZZ)	1	1	Non-selective catalytic reduction (NSCR)
Tri-ethylene glycol (TEG) dehydration unit rated at 40 MMscfd (MACT HH)	25	COM-1	BTEX Combustor ^B
BTEX Combustor	COM-1	COM-1	N/A
Fugitives (NSPS OOOOb)	FUG 1	FUG 1	Leak detection and repair (LDAR) program

^A All emission unit ratings are considered nominal ratings.

^B Rich TEG from the gas dehydrator (contactor) is routed to a flash tank (depressurized) and the flash tank emissions are recycled back into the process. Vapors from the TEG regenerator (stripper) are routed to a condenser. The condenser overheads are routed to the BTEX combustor which assumes a 98% VOC (BTEX) destruction efficiency.

Table 1-2: Facility Emissions Units upon Project Completion

Emission Unit Description ^A	Emission Unit (EU)	Emission Point (EP)	Air Pollution Control Equipment
Waukesha 7044 GSI S5 (4SRB) natural gas-fired compressor engine rated at 1,900 bhp (manuf. 08/2019, NSPS JJJJ, NSPS OOOOa, MACT ZZZZ) ^B	1	1	NSCR
Waukesha L-5794 GSI (4SRB) natural gas-fired compressor engine rated at 1,380 bhp (manuf. 12/2008, NSPS JJJJ, MACT ZZZZ)	2	2	Catalytic Converter
Waukesha L-7044 GSI (4SRB) natural gas-fired compressor engine rated at 1,680 bhp (manuf. 06/2011, NSPS JJJJ, MACT ZZZZ)	3	3	Catalytic Converter
Hot oil, natural gas-fired heater rated at 41.65 MMBtu/hr (NSPS Dc)	4	4	None
Tri-ethylene glycol (TEG) dehydration unit rated at 30 MMscfd (MACT HH)	5	COM-1	BTEX Combustor
210 bbl condensate storage tank	6	24	Submerged Fill Pipe (SFP) & EU 24 Combustor
Process/Emergency Flare	8	8	N/A
Waukesha 7044 GSI (4SRB) natural gas-fired compressor engine rated at 1,680 bhp (manuf. 8/2008, NSPS JJJJ, MACT ZZZZ)	9	9	Catalytic Converter
Waukesha 7044 GSI (4SRB) natural gas-fired compressor engine rated at 1,680 bhp (manuf. 11/2010, NSPS JJJJ, MACT ZZZZ)	10	10	Catalytic Converter
Waukesha 7044 GSI (4SRB) natural gas-fired compressor engine rated at 1,680 bhp (manuf. 06/4/2007, NSPS OOOO, MACT ZZZZ)	11	11	Catalytic Converter

Emission Unit Description ^A	Emission Unit (EU)	Emission Point (EP)	Air Pollution Control Equipment
Waukesha L-7044 GSI (4SRB) natural gas-fired compressor engine rated at 1,680 bhp (manuf. 06/2023, NSPS JJJJ, MACT ZZZZ)	12	12	Catalytic Converter
Hot oil, natural gas-fired heater rated at 38.72 MMBtu/hr (NSPS Dc)	13	13	Low NO _x Burner
400 bbl condensate storage tank	15	24	SFP & EU 24 Combustor
400 bbl condensate storage tank	16	24	SFP & EU 24 Combustor
400 bbl condensate storage tank	17	24	SFP & EU 24 Combustor
Hot oil, natural gas-fired heater rated at 43.5 MMBtu/hr (NSPS Dc)	18	18	None
TEG dehydration unit rated at 4 MMscfd (MACT HH)	19	COM-1	BTEX Combustor
Waukesha 7044 GSI (4SRB) natural gas-fired compressor engine rated at 1,680 bhp (manuf. 10/2014, NSPS JJJJ, NSPS OOOOa, MACT ZZZZ)	20	20	Catalytic Converter
Hot oil, natural gas-fired heater rated at 37.75 MMBtu/hr (NSPS Dc)	21	21	Ultra-low NO _x Burners
Hot oil, natural gas-fired heater rated at 21.0 MMBtu/hr (NSPS Dc)	22	22	None
Condensate Truck Loading Rack	23	23	None
Tank Combustor	24	24	N/A
TEG dehydration unit rated at 40 MMscfd (MACT HH)	25	COM-1	BTEX Combustor
BTEX Combustor	COM-1	COM-1	N/A
Compressor Blowdowns	BD	BD	EU 8 Flare
Fugitive Emissions (NSPS OOOO, NSPS OOOOa, NSPS OOOOb)	FUG 1	FUG1	None

^A All emission unit ratings are considered nominal ratings.

^B This unit replaces the previous EU 1, Ajax DCP-2804 LE

2. Applicable Standards, Restrictions and Miscellaneous Conditions:

A. New Source Performance Standards (NSPS):

The permittee shall comply with all applicable requirements of the following NSPS subparts, in addition to Subpart A, as referenced in Chapter 33.1-15-12 of the North Dakota Air Pollution Control Rules and 40 CFR 60.

- 1) Subpart JJJJ - Standards of Performance for Stationary Spark Ignition Internal Combustion Engines (EU 1)
- 2) Subpart OOOO - Standards of Performance for Crude Oil and Natural Gas Facilities for which Construction, Modification or Reconstruction Commenced After August 23, 2011 and On or Before September 18, 2015. The compressor driven by EU 11 and FUG 1 are subject to this subpart. (Applicability to this subpart is not affected with this permit action.)
- 3) Subpart OOOOa - Standards of Performance for Crude Oil and Natural Gas Facilities for which Construction, Modification or Reconstruction Commenced After September 18, 2015. The compressors driven by EU 1 and EU 20, and FUG 1 are subject to this subpart.
- 4) Subpart OOOOb - Standards of Performance for Crude Oil and Natural Gas Facilities for which Construction, Modification or Reconstruction Commenced after December 6, 2022 (FUG 1)

B. National Emissions Standards for Hazardous Air Pollutants (NESHAP) for Source Categories/Maximum Achievable Control Technology (MACT):

The permittee shall comply with all applicable requirements of the following MACT subparts, in addition to Subpart A, as referenced in Chapter 33.1-15-22 of the North Dakota Air Pollution Control Rules and 40 CFR 63.

- 1) Subpart HH - National Emission Standards for Hazardous Air Pollutants From Oil and Natural Gas Production Facilities (EU 25)
- 2) Subpart ZZZZ - National Emissions Standards for Hazardous Air Pollutants for Stationary Reciprocating Internal Combustion Engines (EU 1)

C. Fuel Restrictions:

- 1) Natural gas-fired engines (EU 1) are restricted to combusting only natural gas containing no more than 2 grains of sulfur per 100 standard cubic feet.

D. Combustor Restrictions (EU 24 and COM-1):

- 1) Each combustor must be equipped and operated with an automatic ignitor or a continuous burning pilot which must be maintained in good working order as outlined in NDAC 33.1-15-07-02.

- 2) The presence of a flame shall be monitored using a thermocouple or any other equivalent device approved by the Department.
- 3) COM-1 shall be operated with no visible emissions, except for periods not to exceed a total of 2 minutes during any hour. A visible emissions test shall be performed in accordance with Condition 4.B.3 of AOP-28406 v2.0.
- 4) Emissions from EU 5, 19, and 25 must be routed to EU COM-1 for combustion, with the exception of 100 hours per calendar year of allowable maintenance downtime.

3. Emission Unit Limits:

Emission limits from the operation of the source unit(s) identified in Table 1-1 of this Permit to Construct (hereafter referred to as "permit") are as follows. Source units not listed are subject to the applicable emission limits specified in the North Dakota Air Pollution Control Rules.

Table 3-1: Permit Emissions Limits

Emission Unit Description	Emission Unit (EU)	Emission Point (EP)	Pollutant / Parameter	Emission Limit ^A
Waukesha 7044 GSI (Inlet #1) 1900 bhp	1	1	NOX	0.90 g/hp-hr ^B
			CO	0.90 g/hp-hr ^C
			VOC	0.65 g/hp-hr ^D
			Opacity	20% ^E
Waukesha L-5794 GSI (Residue #1)	2	2	NOx	0.65 g/hp-hr ^B
			CO	0.65 g/hp-hr ^C
			VOC	0.7 g/hp-hr or 60 ppmvd ^F
			Opacity	20% ^E
Waukesha 7044 GSI (Residue #2)	3	3	NOx	0.65 g/hp-hr ^B
			CO	0.65 g/hp-hr ^C
			VOC	0.7 g/hp-hr or 60 ppmvd ^F
			Opacity	20% ^E
Hot Oil Heater - 41.65 MMBtu/hr	4	4	Opacity	20% ^E
Process/Emergency Flare	8	8	Opacity	20% ^G
Waukesha 7044 GSI (Residue #3)	9	9	NOx	0.65 g/hp-hr ^B
			CO	0.65 g/hp-hr ^C
			VOC	0.7 g/hp-hr or 60 ppmvd ^F
			Opacity	20% ^E
Waukesha 7044 GSI (Residue #4)	10	10	NOx	0.65 g/hp-hr ^B
			CO	0.65 g/hp-hr ^C
			VOC	0.7 g/hp-hr or 60 ppmvd ^F
			Opacity	20% ^E

Emission Unit Description	Emission Unit (EU)	Emission Point (EP)	Pollutant / Parameter	Emission Limit ^A
Waukesha 7044 GSI (Residue #5)	11	11	NO _x	0.65 g/hp-hr
			CO	0.65 g/hp-hr
			Opacity	20% ^E
Waukesha 7044 GSI (Inlet #2)	12	12	NO _x	0.65 g/hp-hr ^B
			CO	0.65 g/hp-hr ^C
			VOC	0.7 g/hp-hr or 60 ppmvd ^F
			Opacity	20% ^E
Hot Oil Heater - 38.72 MMBtu/hr	13	13	Opacity	20% ^E
Hot Oil Heater - 43.5 MMBtu/hr	18	18	Opacity	20% ^E
Waukesha 7044 GSI (Residue #6)	20	20	NO _x	1.0 g/hp-hr or 82 ppmvd ^F
			CO	2.0 g/hp-hr or 270 ppmvd ^F
			VOC	0.7 g/hp-hr or 60 ppmvd ^F
			Opacity	20% ^E
Hot Oil Heater - 37.75 MMBtu/hr	21	21	Opacity	20% ^E
Hot Oil Heater - 21.0 MMBtu/hr	22	22	Opacity	20% ^E
Tank Combustor	24	24	Opacity	20% ^E
BTEX Combustor	COM-1	COM-1	Opacity	Condition 2.D

^A The emission limit applies to each emission point (EP).

^B Less restrictive 40 CFR 60 Subpart JJJJ limits also apply as follows: NO_x of 1.0 g/hp-hr or 82 ppmvd @ 15% O₂.

^C Less restrictive 40 CFR 60 Subpart JJJJ limits also apply as follows: CO of 2.0 g/hp-hr or 270 ppmvd at 15% O₂.

^D Less restrictive 40 CFR 60 Subpart JJJJ limits also apply as follows: VOC of 0.7 g/hp-hr or 60 ppmvd at 15% O₂.

^E 40% opacity permissible for not more than one six-minute period per hour.

^F ppmvd limits apply at 15% O₂.

^G 60% opacity permissible for not more than one six-minute period per hour.

4. Emission Testing Requirements:

A. Initial testing:

All initial testing will require a minimum of three runs, one hour each, unless otherwise specified in a federal subpart.

Table 4-1: Initial Emissions Testing for Project

Description (EU)	EP	Contaminant	EPA Ref. Method
Inlet #1 engine rated at 1900 bhp	1	NO _x	7E
		CO	10
		VOC	25A

A signed copy of the test results shall be furnished to the Department within 60 days of the test date. The basis for this condition is NDAC 33.1-15-01-12 which is hereby incorporated into this permit by reference. To facilitate preparing for and conducting such tests, and to facilitate reporting the test results to the Department, the permittee shall follow the procedures and formats in the Department's Emission Testing Guideline.¹

1) Test:

Within 180 days after initial startup, the permittee shall conduct emissions tests at the emission units listed in Table 4-1 using an independent testing firm, to determine the compliance status of the facility with respect to the emission limits specified in Table 3-1. Emissions testing shall be conducted for the pollutant(s) listed above in accordance with EPA Reference Methods listed in 40 CFR 60, Appendix A. Test methods other than those listed above may be used upon approval by the Department.

2) Notification:

The permittee shall notify the Department using the form in the Emission Testing Guideline, or its equivalent, at least 30 calendar days in advance of any tests of emissions of air contaminants required by the Department. If the permittee is unable to conduct the performance test on the scheduled date, the permittee shall notify the Department at least five days prior to the scheduled test date and coordinate a new test date with the Department.

3) Sampling Ports/Access:

¹ See February 7, 2020, North Dakota Department of Environmental Quality Division of Air Quality Emissions Testing Guidelines. Available at: https://www.deq.nd.gov/publications/AQ/policy/PC/Emission_Testing_Guide.pdf

Sampling ports shall be provided downstream of all emission control devices and in a flue, conduit, duct, stack or chimney arranged to conduct emissions to the ambient air. The ports shall be located to allow for reliable sampling and shall be adequate for test methods applicable to the facility. Safe sampling platforms and safe access to the platforms shall be provided. Plans and specifications showing the size and location of the ports, platform and utilities shall be submitted to the Department for review and approval.

4) Other:

- a) The Department may require the permittee to have tests conducted to determine the emission of air contaminants from any source, whenever the Department has reason to believe that an emission of a contaminant not addressed by the permit applicant is occurring, or the emission of a contaminant in excess of that allowed by this permit is occurring. The Department may specify testing methods to be used in accordance with good professional practice. The Department may observe the testing. All tests shall be conducted by reputable, qualified personnel. A signed copy of the test results shall be furnished to the Department within 60 days of the test date.

All tests shall be made available, and the results calculated in accordance with test procedures approved by the Department. All tests shall be made under the direction of persons qualified by training or experience in the field of air pollution control as approved by the Department.

- b) The Department may conduct tests of emissions of air contaminants from any source. Upon request of the Department, the permittee shall provide necessary holes in stacks or ducts and such other safe and proper sampling and testing facilities, exclusive of instruments and sensing devices, as may be necessary for proper determination of the emission of air contaminants.

B. Sampling and Testing:

The Department may require the permittee to conduct tests to determine the emission rate of air contaminants from the source. The Department may observe the testing and may specify testing methods to be used. A signed copy of the test results shall be furnished to the Department within 60 days of the test date. The basis for this condition is NDAC 33.1-15-01-12 which is hereby incorporated into this permit by reference. To facilitate preparing for and conducting such tests, and to facilitate reporting the test results to the Department, the permittee shall follow the procedures and formats in the Department's Emission Testing Guideline.

5. General Conditions (Equipment):

A. Best Management Practices:

At all times, including periods of startup, shutdown, and malfunction, the permittee shall, to the extent practicable, maintain and operate any affected facility including associated air pollution control equipment in a manner consistent with good air pollution control practice for minimizing emissions.

B. Operation of Air Pollution Control Equipment:

The permittee shall maintain and operate all air pollution control equipment in a manner consistent with good air pollution control practice for minimizing emissions.

C. Stack Heights:

Emission Point	Minimum Stack Height (feet)
1	35

D. Like-Kind Engine/Turbine Replacement:

This permit allows the permittee to replace an existing engine or turbine with a like-kind unit. Replacement is subject to the following conditions:

- 1) The Department must be notified within 10 days after change-out of the unit.
- 2) The replacement unit shall operate in the same manner, provide no increase in throughput and have equal or less emissions than the unit it is replacing.
- 3) The date of manufacture of the replacement unit must be included in the notification. The facility must comply with any applicable federal standards (e.g. NSPS, MACT) triggered by the replacement.
- 4) The replacement unit is subject to the same state emission limits as the existing unit in addition to any NSPS or MACT emission limit that is applicable. Testing shall be conducted to confirm compliance with the emission limits within 180 days after start-up of the unit.

E. Organic Compound Emissions:

The permittee shall comply with all applicable requirements of NDAC 33.1-15-07 – Control of Organic Compounds Emissions.

F. Air Pollution from Internal Combustion Engines:

The permittee shall comply with all applicable requirements of NDAC 33.1-15-08-01 – Internal Combustion Engine Emissions Restricted.

G. Fugitive Emissions:

The release of fugitive emissions shall comply with the applicable requirements in NDAC 33.1-15-17.

6. General Conditions (Procedural):

A. Construction:

Construction of the above-described facility shall be in accordance with information provided in the permit application as well as any plans, specifications and supporting data submitted to the Department. The Department shall be notified 10 days in advance of any significant deviations from the specifications furnished. The issuance of this Permit to Construct may be suspended or revoked if the Department determines that a significant deviation from the plans and specifications furnished has been or is to be made.

Any violation of a condition issued as part of this permit to construct as well as any construction which proceeds in variance with any information submitted in the application, is regarded as a violation of construction authority and is subject to enforcement action.

B. Startup Notice:

A notification of the actual date of initial startup shall be submitted to the Department within 15 days after the date of initial startup.

C. Permit Invalidation:

This permit shall become invalid if construction is not commenced within 18 months after issuance of such permit, if construction is discontinued for a period of 18 months or more; or if construction is not completed within a reasonable time.

D. Source Operations:

Operations at the installation shall be in accordance with statements, representations, procedures and supporting data contained in the initial application, and any supplemental information or application(s) submitted thereafter. Any operations not listed in this permit are subject to all applicable North Dakota Air Pollution Control Rules.

E. Alterations, Modifications, or Changes:

Any alteration, repairing, expansion, or change in the method of operation of the source which results in the emission of an additional type or greater amount of air contaminants or which results in an increase in the ambient concentration of any air contaminant, must be reviewed and approved by the Department prior to the start of such alteration, repairing, expansion or change in the method of operation.

F. Recordkeeping:

The permittee shall maintain any compliance monitoring records required by this permit or applicable requirements. The permittee shall retain records of all required monitoring data and support information for a period of at least five years from the date of the monitoring sample, measurement, report or application. Support information may include all calibration and maintenance records and all original strip-chart recordings/computer printouts for continuous monitoring instrumentation, and copies of all reports required by the permit.

G. Annual Emission Inventory/Annual Production Reports:

The permittee shall submit an annual emission inventory report and/or an annual production report upon Department request, on forms supplied or approved by the Department.

H. Malfunction Notification:

The permittee shall notify the Department of any malfunction which can be expected to last longer than twenty-four hours and can cause the emission of air contaminants in violation of applicable rules and regulations.

I. Nuisance or Danger:

This permit shall in no way authorize the maintenance of a nuisance or a danger to public health or safety.

J. Transfer of Permit to Construct:

The holder of a permit to construct may not transfer such permit without prior approval from the Department.

K. Right of Entry:

Any duly authorized officer, employee or agent of the North Dakota Department of Environmental Quality may enter and inspect any property, premise or place at which the source listed in Condition 1 of this permit is located at any time for the purpose of ascertaining the state of compliance with the North Dakota Air Pollution Control Rules. The Department may conduct tests and take samples of air contaminants, fuel, processing material, and other materials which affect or may affect emissions of air contaminants from any source. The Department shall have the right to access and copy any records required by the Department's rules and to inspect monitoring equipment located on the premises.

L. Other Regulations:

The permittee of the source unit(s) described in Condition 1 of this permit shall comply with all State and Federal environmental laws and rules. In addition, the permittee shall comply with all local burning, fire, zoning, and other applicable ordinances, codes, rules and regulations.

M. Permit Issuance:

This permit is issued in reliance upon the accuracy and completeness of the information set forth in the application. Notwithstanding the tentative nature of this information, the conditions of this permit herein become, upon the effective date of this permit, enforceable by the Department pursuant to any remedies it now has, or may in the future have, under the North Dakota Air Pollution Control Law, NDCC Chapter 23.1-06.

7. **State Enforceable Only Conditions (not Federally enforceable)**

A. Odor Restrictions:

The permittee shall not discharge into the ambient air any objectionable odorous air contaminant which is in excess of the limits established in NDAC 33.1-15-16.