Government of Western Australia
Department of Water and Environmental Regulation

Licence

Licence number	L9184/2018/1
Licence holder	SAMI Bitumen Technologies Pty Ltd
ACN	001 089 416
Registered business address	Unit 2, 3-5 Gibbon Road WINSTON HILLS NSW 2153
DWER file number	DER2018/001632
Duration	23/09/2019 to 22/09/2039
Date of issue	23/9/2019
Date of amendment	20/12/2023
Premises details	SAMI Bitumen Kwinana 57 Port Road KWINANA BEACH WA 6167 Legal description – Part of Lot 108 on Plan 400167 As defined by the coordinates in Schedule 1

Prescribed premises category description (Schedule 1, Environmental Protection Regulations 1987)	Assessed production capacity
Category 36: Bitumen manufacturing: premises on which bitumen is mixed or prepared for use at places or premises other than those premises.	90,000 tonnes per annum

This amendment to the licence is granted to the licence holder, subject to the attached conditions, on 20 December 2023 by:

Daniel Hartnup

Digitally signed by Daniel Hartnup
Date: 2023.12.20 09:25:21 +08'00'

Daniel Hartnup
A/MANAGER, PROCESS INDUSTRIES
REGULATORY SERVICES
an officer delegated under section 20 of the *Environmental Protection Act 1986* (WA)

Licence history

Date	Ref number	Summary of changes
23/09/2019	L9184/2018/1	Licence granted
23/06/2022	L9184/2018/1	Amended Licence to remove vapour recovery unit requirements for monitoring and efficiency limit. Licence format updated in addition to administrative updates to conditions.
16/02/2023	L9184/2018/1	Amended licence to include stage 2 infrastructure
20/12/2023	L9184/2018/1	Amendment to remove the requirement for vapour recovery from the bitumen tanks, tanker loading, final product tanks, and mixing vessels and replace with passive breathing via vents and stacks

Interpretation

In this licence:

(a) the words 'including', 'includes' and 'include' in conditions mean 'including but not limited to', and similar, as appropriate;
(b) where any word or phrase is given a defined meaning, any other part of speech or other grammatical form of that word or phrase has a corresponding meaning;
(c) where tables are used in a condition, each row in a table constitutes a separate condition;
(d) any reference to an Australian or other standard, guideline or code of practice in this licence:
    (i) if dated, refers to that particular version; and
    (ii) if not dated, refers to the latest version and therefore may be subject to change over time;
(e) unless specified otherwise, any reference to a section of an Act refers to that section of the EP Act; and
(f) unless specified otherwise, all definitions are in accordance with the EP Act.

NOTE: This licence requires specific conditions to be met but does not provide any implied authorisation for other emissions, discharges, or activities not specified in this licence.

Licence conditions

The licence holder must ensure that the following conditions are complied with:

Infrastructure and equipment

1. The licence holder must ensure that the site infrastructure and equipment listed in Table 1 and located at the corresponding infrastructure location is maintained and operated in accordance with the corresponding operational requirement set out in Table 1.

Table 1: Infrastructure and equipment requirements

	Site infrastructure and equipment	Operational requirement	Infrastructure location
1	Heated bitumen storage tanks	a) All storage tanks to be located in a bunded area; b) Tank vapours must be vented via atmospheric breathers located at least 17 m above ground level.	Figure 2 of Schedule 1 TK7-TK10, TK27 and TK33-TK34

	Site infrastructure and equipment	Operational requirement	Infrastructure location
		c) Must have high level alarm to prevent overfilling of bitumen storage tanks; and d) Must have automated temperature cut-off system to prevent over heating of bitumen.	
2	Containment areas and bunds	a) All containment areas are to be sealed and maintained to prevent spills from entering the environment; b) Fuel and oil spill kits to be available at all times during operation; and c) All spills of bitumen or other chemicals are to be cleaned up as soon as practicable	NA
3	Infiltration basins and first flush pits	a) All uncontaminated stormwater is to be directed to the infiltration basins; b) Stormwater collected in the first flush pits will be directed to the oily water separator prior to discharge into the infiltration basin; and c) All potentially contaminated stormwater from high risk areas including tank containment areas, sumps and loadout gantry bays is to be directed to an oily water separator prior discharge to the infiltration basin.	Figure 2 of Schedule 1 Infiltration basins and first flush pits
4	Oily water separator	a) Must be operated and maintained to ensure that treated waste water discharge complies with condition 3	Figure 2 of Schedule 1
5	Bitumen tanker loading gantries	a) Extraction system must be in operation during loading which directs vapours to stack A4.	Figure 2 of Schedule 1 PMB, CRMB, Bitumen Gantry
6	Thermal Oxidiser	a) Combustion chamber shall be held at a temperature not less than 760°C during plant operation.	Figure 2 of Schedule 1
7	Crumbed rubber modified bitumen (CRMB) and polymer modified bitumen plant (PMB)	a) Extraction system directing emissions to A5 must be in operation during PMB and CRMB manufacturing	Figure 2 of Schedule 1 Manufacturing shed
8	16 day storage tanks for PMB, CRMB bitumen	a) Tank vapours must be vented via atmospheric breathers located at least 17 m above ground level.	Figure 2 of Schedule 1 TK11-TK16, and TK18-TK19

Emissions and discharges

2. The licence holder must ensure that the emissions specified in Table 2, are discharged only from the corresponding discharge point and only at the corresponding discharge point location.

Table 2: Authorised discharge points

Emission	Discharge point	Discharge point location
VOC emissions from heated bitumen storage tanks	Tank vents at TK7-TK10, TK27 and TK33-TK34	Figure 3 of Schedule 1
VOC emissions from 16 day storage tanks for PMB, CRMB bitumen	TK11-TK16, and TK18-TK19	
Emissions from thermal oxidiser	Thermal oxidiser stack A1	
VOC emissions from transfer of heated bitumen at loading gantry	Stack A4	
Emission of combustion gases from natural gas	Oil heater stacks H1 and H2 Oil heater #1 Stack and Oil heater #2 stack	
Emission of gas from CRMB and PMB plant	Manufacturing Stack A5	
Discharge of treated water and uncontaminated stormwater to land	Infiltration basins	

Emissions to land

3. The licence holder must ensure that emissions from the discharge point listed in Table 3 for the corresponding parameter do not exceed the corresponding limit when monitored in accordance with Condition 4.

Table 3: Discharge to land limits

Discharge point	Parameter	Limit
Outlet from oily water separator	pH	pH 4 - pH 10
	TRH	15 mg/L

Monitoring

4. The licence holder must monitor emissions:

(a) at the corresponding monitoring location;
(b) for the corresponding parameter;
(c) at the corresponding frequency;
(d) for the corresponding minimum averaging period;
(e) in the corresponding unit; and

as set out in Table 4.

Table 4: Monitoring of discharges to land

Monitoring location	Parameter	Frequency	Minimum averaging period	Unit
Outlet of oily water separator	Field pH	Twice each year	Spot Sample	-
	TRH			mg/L

5. The licence holder must ensure that:

   (a) all water samples are collected and preserved in accordance with AS/NZS 5667.1;
   (b) all wastewater sampling is conducted in accordance with AS/NZS 5667.10; and
   (c) all laboratory samples are submitted to and tested by a laboratory with current NATA accreditation for the parameters being measured.

Records and reporting

6. The licence holder must record the following information in relation to complaints received by the licence holder (whether received directly from a complainant or forwarded to them by the Department or another party) about any alleged emissions from the premises:

   (a) the name and contact details of the complainant, (if provided);
   (b) the time and date of the complaint;
   (c) the complete details of the complaint and any other concerns or other issues raised; and
   (d) the complete details and dates of any action taken by the licence holder to investigate or respond to any complaint.

7. The licence holder must:

   (a) undertake an audit of their compliance with the conditions of this licence during the preceding annual period; and
   (b) prepare and submit to the CEO by no later than 28 days after the end of that annual period an Annual Audit Compliance Report in the approved form.

8. The licence holder must maintain accurate and auditable books including the following records, information, reports, and data required by this licence:

   (a) the calculation of fees payable in respect of this licence;
   (b) any maintenance of infrastructure that is performed in the course of complying with condition 1 of this licence;
   (c) monitoring programmes undertaken in accordance with condition 4 of this licence; and
   (d) complaints received under condition 6 of this licence.

9. The books specified under condition 8 must:

   (a) be legible;
   (b) if amended, be amended in such a way that the original version(s) and any subsequent amendments remain legible and are capable of retrieval;
   (c) be retained by the licence holder for the duration of the licence; and
   (d) be available to be produced to an inspector or the CEO as required.

10. The licence holder must submit to the CEO by no later than 28 days after the end of each annual period, an Annual Environmental Report for that annual period for the conditions listed in Table 5, and which provides information in accordance with the corresponding requirement set out in Table 5.

Table 5: Annual Environment Report

Condition	Requirement
4	Summary and original laboratory reports
6	Summary detailing number and nature of complaints

Definitions

In this licence, the terms in Table 6 have the meanings defined.

Table 6: Definitions

Term	Definition
ACN	Australian Company Number
Annual Audit Compliance Report (AACR)	means a report submitted in a format approved by the CEO (relevant guidelines and templates may be available on the Department's website).
annual period	a 12 month period commencing from 1 July until 30 June of the immediately following year.
AS/NZS 5667.1	means the Australian Standard *AS/NZS 5667.1 Water Quality- Sampling- Guidance on the design of sampling programs, sampling techniques and the preservation and handling of samples.*
AS/NZS5667.10	means the Australian Standard *AS/NZS 5667.1 Water Quality- Sampling- Guidance on the sampling of waste waters.*
CEO	means Chief Executive Officer of the Department. "submit to / notify the CEO" (or similar), means either: Director General Department administering the *Environmental Protection Act 1986* Locked Bag 10 Joondalup DC WA 6919 info@dwer.wa.gov.au
CRMB	Crumbed rubber modified bitumen
Department	means the department established under section 35 of the *Public Sector Management Act 1994* (WA) and designated as responsible for the administration of the EP Act, which includes Part V Division 3.
EP Act	*Environmental Protection Act 1986* (WA)
EP Regulations	Environmental Protection Regulations 1987 (WA)
licence	refers to this document, which evidences the grant of a licence by the CEO under section 57 of the EP Act, subject to the specified conditions contained within.
licence holder	refers to the occupier of the premises, being the person specified on the front of the licence as the person to whom this licence has been granted.
NATA	refers to the National Association of Testing Authorities, Australia.
NATA accreditation	means in relation to the analysis of a sample that the laboratory is NATA accredited for the specified analysis at the time of the analysis.
PMB	means polymer modified bitumen
premises	refers to the premises to which this licence applies, as specified at the front of this licence and as shown on the premises map in Schedule 1, Figure 1 to this licence.
TRH	means total recoverable hydrocarbons

END OF CONDITIONS

Schedule 1: Maps

Premises map

The boundary of the prescribed premises is shown in blue in the map below

Figure 1: Map of the boundary of the prescribed premises

Figure 2: Map of the premises infrastructure layout

Figure 3: Map of authorised discharge points

Schedule 2: Premises boundary

The premises boundary is defined by the coordinates in. Table 7.

Table 7: Premises boundary coordinates

Longitude	Latitude
115° 45' 51.01634"	-32° 14' 40.41389"
115° 45' 51.05710"	-32° 14' 40.44370"
115° 45' 45.53740"	-32° 14' 37.18671"
115° 45' 53.17392"	-32° 14' 36.90815"
115° 45' 53.88048"	-32° 14' 36.90218"
115° 45' 53.68325"	-32° 14' 36.85913"
115° 45' 52.99445"	-32° 14' 36.80338"
115° 45' 53.28397"	-32° 14' 36.77198"
115° 45' 53.05957"	-32° 14' 36.72282"
115° 45' 52.45544"	-32° 14' 36.59008"
115° 45' 54.67260"	-32° 14' 35.93095"
115° 45' 46.63612"	-32° 14' 35.83917"
115° 45' 53.24308"	-32° 14' 35.61573"
115° 45' 54.98095"	-32° 14' 35.55287"
115° 45' 55.09038"	-32° 14' 35.41869"
115° 45' 47.18320"	-32° 14' 35.36664"
115° 45' 49.88278"	-32° 14' 34.72286"
115° 45' 48.69641"	-32° 14' 34.66856"
115° 45' 47.81309"	-32° 14' 34.94292"