WELDING AND CUTTING

A. GENERAL

EAGLE INDUSTRIAL INSTRUMENTATIONwill ensure that work practices that involve Welding, Cutting and Brazing equipment/operations are evaluated to determine if proper safety precautions are instituted. The Occupational Safety and Health Administration (OSHA) recommends that certain guidelines be adhered to regarding these hazards. Our training program is intended to address comprehensively the issues of; using, evaluating and identifying the specific hazards where hot work is performed, communicating information concerning these hazards, and establishing appropriate procedures, and protective measures for our employees.

B. RESPONSIBILITY

The Operation Manager is solely responsible for all aspects of this program and has full authority to make necessary decisions to ensure success of the program. **EAGLE INDUSTRIAL INSTRUMENTATION**has expressly authorized the Safety Coordinator to halt any operation where there is danger of serious personal injury.

C. FIRE PREVENTION AND PROTECTION

Fire and explosion pose a serious risk to our employees during welding, cutting, and brazing operations. Sparks can travel as much as 35', and spatter can bounce on the floor or fall through openings creating hazards in other work areas of our facility.

1. **BASIC SAFETY PRECAUTIONS**. The below listed basic safety precautions will be followed by all employees performing welding, cutting, brazing operations. The basic precautions for fire prevention in welding or cutting work are:

    a. Fire hazards. If the object to be welded or cut cannot readily be moved, all movable fire hazards in the vicinity shall be taken to a safe place.
    b. Guards. If the object to be welded or cut cannot be moved and if all the fire hazards cannot be removed, then guards shall be used to confine the heat, sparks, and slag, and to protect the immovable fire hazards.
    c. Restrictions. If the requirements stated for Fire hazards and Guards cannot be followed then welding and cutting shall not be performed.

2. **SPECIAL PRECAUTIONS**. When the nature of the work to be performed requires the use of guarding devices certain additional precautions may be necessary:

    a. **Combustible material**. Wherever there are floor openings or cracks in the flooring that cannot be closed, precautions shall be taken so that no

readily combustible materials on the floor below will be exposed to sparks which might drop through the floor. The same precautions shall be observed with regard to cracks or holes in walls, open doorways and open or broken windows.

b. **Fire extinguishers**. Suitable fire extinguishing equipment shall be maintained in a state of readiness for instant use. Such equipment may consist of pails of water, buckets of sand, hose or portable extinguishers depending upon the nature and quantity of the combustible material exposes.

c. Fire watch.

1) Fire watchers shall be required whenever welding or cutting is performed in locations where other than a minor fire might develop, or any of the following conditions exist:
   a) Appreciable combustible material, in building construction or contents, closer than 35' to the point of operation.
   b) Appreciable combustibles are more than 35' away but are easily ignited by sparks.
   c) Wall or floor openings within a 35' radius expose combustible material in adjacent areas including concealed spaces in walls or floors.
   d) Combustible materials are adjacent to the opposite side of metal partitions, walls, ceilings, or roofs and are likely to be ignited by conduction or radiation.
2) Fire watchers shall have fire extinguishing equipment readily available and be trained in its use. They shall be familiar with facilities for sounding an alarm in the event of a fire. They shall watch for fires in all exposed areas, try to extinguish them only when obviously within the capacity of the equipment available, or otherwise sound the alarm. A fire watch shall be maintained for at least a half hour after completion of welding or cutting operations to detect and extinguish possible smoldering fires.

d. **Authorization**. Before cutting or welding is permitted, the area shall be inspected by the individual responsible for authorizing cutting and welding operations. He/she shall designate precautions to be followed in granting authorization to proceed preferably in the form of a written permit.

e. **Floors.** Where combustible materials such as paper clippings, wood shavings, or textile fibers are on the floor, the floor shall be swept clean for a radius of 35'. Combustible floors shall be kept wet, covered with damp sand, or protected by fire-resistant shields. Where floors have been wet down, personnel operating arc welding or cutting equipment shall be protected from possible shock.

f. **Prohibited areas**. Cutting or welding shall not be permitted in the following situations:

1) In areas not authorized by management.
2) In sprinklered buildings while such protection is impaired.

3) In the presence of explosive atmospheres (mixtures of flammable gases, vapors, liquids, or dusts with air), or explosive atmospheres that may develop inside uncleaned or improperly prepared tanks or equipment which have previously contained such materials, or that may develop in areas with an accumulation of combustible dusts.
4) In areas near the storage of large quantities of exposed, readily ignitable materials such as bulk sulfur, baled paper, or cotton.

g. **Relocation of combustibles**. Where practicable, all combustibles shall be relocated at least 35' from the work site. Where relocation is impracticable, combustibles shall be protected with flame-proofed covers or otherwise shielded with metal or asbestos guards or curtains.

h. **Ducts**. Ducts and conveyor systems that might carry sparks to distant combustibles shall be suitably protected or shut down.

i. **Combustible walls**. Where cutting or welding is done near walls, partitions, ceiling, or roof of combustible construction, fire-resistant shields or guards shall be provided to prevent ignition.

j. **Noncombustible walls**. If welding is to be done on a metal wall, partition, ceiling, or roof, precautions shall be taken to prevent ignition of combustibles on the other side, due to conduction or radiation, preferably by relocating combustibles. Where combustibles are not relocated, a fire watch on the opposite side from the work shall be provided.

k. **Combustible cover**. Welding shall not be attempted on a metal partition, wall, ceiling, or roof having a combustible sandwich-type panel construction.

l. **Pipes**. Cutting or welding on pipes or other metal in contact with combustible walls, partitions, ceilings or roofs shall not be undertaken if the work is close enough to cause ignition by conduction.

m. **Management**. Management shall recognize its responsibility for the safe usage of all cutting and welding equipment and:
1) Ensure that all cutters, welders and their supervisors are suitably trained in the safe operation of their equipment.
2) Advise all contractors about flammable materials or hazardous conditions of which they may not be aware.

n. **Supervisor**. The first line supervisor:
1) Shall be responsible for the safe handling and use of the cutting or welding equipment.
2) Shall determine the combustible materials and hazardous areas present or likely to be present in the work location.
3) Shall protect combustibles from ignition by the following:
a) Have the work moved to a location free from dangerous combustibles.
b) If the work cannot be moved, have the combustibles moved to a safe distance from the work or have the combustibles properly shielded against ignition.

c) See that cutting and welding are so scheduled that any processes or operations that might expose combustibles to ignition are not started during cutting or welding.

4) Shall secure authorization before the cutting or welding operations begins.

5) Shall ensure that fire protection and extinguishing equipment are properly located at the site.

6) Where fire watches are required, he/she shall see that they are available at the site.

o. **Fire prevention precautions**. Cutting or welding shall be permitted only in areas that are or have been made fire safe. When work cannot be moved practically, as in most construction work, the area shall be made safe by removing combustibles or protecting combustibles from ignition sources.

3. **WELDING OR CUTTING CONTAINERS.**

a. **Used containers**. No welding, cutting, or other hot work shall be performed on used drums, barrels, tanks, or other containers until they have been cleaned so thoroughly as to make absolutely certain that there are no flammable materials present or any substances such as greases, tars, acids, or other materials which when subjected to heat, might produce flammable or toxic vapors. Any pipe lines or connections to the drum or vessel shall be disconnected or blanked.

b. **Venting and purging**. All hollow spaces, cavities or containers shall be vented to permit the escape of air or gases before preheating, cutting or welding. Purging with inert gas is recommended.

4. **CONFINED SPACES**.

a. **Accidental contact**. When arc welding is to be suspended for any substantial period of time, such as during lunch or overnight, all electrodes shall be removed from the holders and the holders carefully located so that accidental contact cannot occur and the machine be disconnected from the power source.

b. **Torch valve**. In order to eliminate the possibility of gas escaping through leaks or improperly closed valves, when gas welding or cutting, the torch valves shall be closed and the gas supply to the torch positively shut off at some point outside the confined area whenever the torch is not to be used for a substantial period of time, such as during lunch hour or overnight. Where practicable, the torch and hose shall also be removed from the confined space.

D. PROTECTION OF PERSONNEL

1. GENERAL

a. **Railings.** Employee's working on platforms, scaffolds, or runways shall be protected against falling. This may be accomplished by the use of railings, safety belts, life lines, or some other equally effective safeguards.

b. **Welding cables**. Employee's shall place welding cables and other equipment so that it is clear of passageways, ladders, and stairways.

2. EYE PROTECTION

a. **Selection**

1) Helmets or hand shields shall be used during all arc welding or arc cutting operations, excluding submerged arc welding. Helpers or attendants shall be provided with proper eye protection.

2) Goggles or other suitable eye protection shall be used during all gas welding or oxygen cutting operations. Spectacles without side shields, with suitable filter lenses are permitted for use during gas welding operation on light work, for torch brazing or for inspection.

3) All operators and attendants of resistance welding or resistance brazing equipment shall use transparent face shields or goggles, depending on the particular job, to protect their faces or eyes, as required.

4) Eye protection in the form of suitable goggles shall be provided where needed for brazing operations.

b. **Specifications for protectors**

1) Helmets and hand shields shall be made of material, which is an insulator for heat and electricity. Helmets, shields and goggles shall be not readily flammable and shall be capable of withstanding sterilization.

2) Helmets and hand shields shall be arranged to protect the face, neck and ears from direct radiant energy from the arc.

3) Helmets shall be provided with filter plates and cover plates designed for easy removal.

4) All parts shall be constructed of a material, which will not readily corrode or discolor the skin.

5) Goggles shall be ventilated to prevent fogging of the lenses as much as practicable.

6) All glass for lenses shall be tempered, substantially free from streaks, air bubbles, waves, and other flaws. Except when a lens is ground to provide proper optical correction for defective vision, the front and rear surfaces of lenses and windows shall be smooth and parallel.

7) Lenses shall bear some permanent distinctive marking by which the source and shade may be readily identified.

8) The following is a guide for the selection of the proper shade numbers. These recommendations may be varied to suit the individual's needs.

Welding Operation	**Shade No.**
Shielded metal-arc welding: 1/16-, 3/32-, 1/8-, 5/32-inch electrodes	10
Gas-shielded arc welding (nonferrous): 1/16-, 3/32-, 1/8-, 5/32-inch electrodes	11
Gas-shielded arc welding (ferrous): 1/16-, 3/32-, 1/8-, 5/32-inch electrodes	12
Shielded metal-arc welding: 3/16-, 7/32-, 1/4 -inch electrodes 5/16-, 3/8-inch electrodes	 12 14
Atomic hydrogen welding	10-14
Carbon arc welding	14
Soldering	2
Torch brazing	3 or 4
Light cutting, up to 1 inch	3 or 4
Medium cutting, 1 inch to 6 inches	4 or 5
Heavy cutting, 6 inches or over	5 or 6
Gas welding (light) up to 1/8 inch	4 or 5
Gas welding (medium) 1/8 inch to 1/2 inch	5 or 6
Gas welding (heavy) 1/2 inch and over	6 or 8

NOTE: In gas welding or oxygen cutting where the torch produces a high yellow light, it is desirable to use a filter or lens that absorbs the yellow or sodium line in the visible light of the operation.

9) All filter lenses and plates purchased by **EAGLE INDUSTRIAL INSTRUMENTATION**shall meet the test for transmission of radiant energy prescribed by ANSI Z87.1—1968—American National Standard Practice for Occupational and Educational Eye and Face Protection.

c. **Protection from arc welding rays**. Where the work permits, the welder shall be enclosed in an individual booth painted with a finish of low reflectivity such as zinc oxide (an important factor for absorbing ultraviolet radiation) and lamp black, or shall be enclosed with noncombustible screens similarly painted. Booths and screens shall permit circulation of air at floor level. Workers or other persons adjacent to the welding areas shall be protected from the rays by noncombustible or flameproof screens or shields or shall be required to wear appropriate goggle.

3. **PROTECTIVE CLOTHING**.

General requirements. Supervisors will ensure that employees exposed to the hazards created by welding, cutting, or brazing operations be protected by personal protective equipment in accordance with the requirements of 29 CFR 1910.132 (Personal Protective Equipment, General Requirements). Appropriate protective clothing required for any welding operation will vary with the size, nature and location of the work to be performed.

4. **WORK IN CONFINED SPACES**.

a. **General**. As used herein, confined space is intended to mean a relatively small or restricted space such as a tank, boiler, pressure vessel, or small compartment of a ship.

b. **Ventilation.** Ventilation is a prerequisite to work in confined spaces. **EAGLE INDUSTRIAL INSTRUMENTATION**confined space procedures will delineate ventilation requirements for specific operations where welding or cutting is required.

c. **Securing cylinders and machinery**. When welding or cutting is being performed in any confined spaces that gas cylinders and welding machines shall be left on the outside. Before operations are started, heavy portable equipment mounted on wheels shall be securely blocked to prevent accidental movement.

d. **Lifelines.** Where a welder must enter a confined space through a manhole or other small opening, means shall be provided for quickly removing him in case of emergency. When safety belts and lifelines are used for this purpose, they shall be so attached to the welder's body that his body cannot be jammed in a small exit opening. An attendant with a pre-planned rescue procedure (see Eagle Industrial Instrumentation confined space procedures) shall be stationed outside to observe the welder at all times and be capable of putting rescue operations into effect.

e. **Electrode removal. When arc welding is to be suspended for any substantial period of time, such** as during lunch or overnight, all electrodes shall be removed from the holders and the holders carefully located so that accidental contact cannot occur and the machine disconnected from the power source.

f. **Gas cylinder shutoff**. In order to eliminate the possibility of gas escaping through leaks of improperly closed valves, when gas welding or cutting, the torch valves shall be closed and the fuel-gas and oxygen supply to the torch positively shut off at some point outside the confined area whenever the torch is not to be used for a substantial period of time, such as during lunch hour or overnight. Where practicable the torch and hose shall also be removed from the confined space.

g. **Warning signs.** After welding operation are completed, the welder shall mark the hot metal or provide some other means of warning other workers.

E. HEALTH PROTECTION AND VENTILATION

1. GENERAL

a. **Contamination**. The requirements for contamination control have been established on the basis of the following three factors in arc and gas welding which govern the amount of contamination to which welders may be exposed:
   1) Dimensions of space in which welding is to be done (with special regard to height of ceiling).
   2) Number of welders.
   3) Possible evolution of hazardous fumes, gases, or dust according to the metals involved.

b. **Screens.** When welding must be performed in a space entirely screened on all sides, the screens shall be so arranged that no serious restriction of ventilation exists. It is desirable to have the screens so mounted that they are about 2' (0.61m) above the floor unless the work is performed at so low a level that the screen must be extended nearer to the floor to protect nearby workers from the glare of welding.

c. **Maximum allowable concentration**. Local exhaust or general ventilating systems shall be provided and arranged to keep the amount of toxic fumes, gases, or dusts below the maximum allowable concentration as specified in 29 CFR 1910.1000 (Toxic and Hazardous Substances).

d. **Precautionary labels**. A number of potentially hazardous materials are employed in fluxes, coatings, covering, and filler metals used in welding and cutting or are released to the atmosphere during welding and cutting. Supervisors will ensure employee's under their control are familiar with the Material Safety Data Sheets (MSDS) applicable to the welding materials they are using.

2. VENTILATION FOR GENERAL WELDING AND CUTTING.

a. **General.** Mechanical ventilation shall be provided when welding or cutting is done on metals other than the following; Fluorine compounds, Zinc, Lead, Beryllium, Cadmium, Mercury, and stainless steels.
   1) In a space of less than 10,000 cubic feet per welder.
   2) In a room having a ceiling height of less than 16 feet
   3) In confined spaces or where the welding space contains partitions, balconies, or other structural barriers to the extent that they significantly obstruct cross ventilation**.**

b. **Minimum rate**. Such ventilation shall be at the minimum rate of 2,000 cubic feet per minute per welder, except where local exhaust hoods and booths provide an equivalent or better rate, or airline respirators approved

by the Mine Safety and Health Administration and the National Institute for Occupational Safety and Health, pursuant to the provisions of 30 CFR part 11, are provided. Natural ventilation is considered sufficient for welding or cutting operations where the following restrictions are not present.

1) In a space of less than 10,000 cubic feet per welder.
2) In a room having a ceiling height of less than 16 feet.
3) In confined spaces or where the welding space contains partitions, balconies, or other structural barriers to the extent that they significantly obstruct cross ventilation.

3. **LOCAL EXHAUST HOODS AND BOOTHS**. Mechanical local exhaust ventilation may be by means of either of the following:

a. **Hoods.** Freely movable hoods intended to be placed by the welder as near as practicable to the work being welded and provided with a rate of air-flow sufficient to maintain a velocity in the direction of the hood of 100 linear feet per minute in the zone of welding when the hood is at its most remote distance from the point of welding. The rates of ventilation required to accomplish this control velocity using a 3 inch wide flanged suction opening are shown in the following table:

Welding Zone	**Minimum air flow *(1) cubic feet/ minute**	**Duct diameter, inches *(2)**
4 to 6 inches from arc to torch	150	3
6 to 8 inches from arc to torch	275	3 ½
8 to 10 inches form arc to torch	425	4 ½
10 to 12 inches from arc to torch	600	5 ½

*(1) When brazing with cadmium bearing materials or when cutting on such materials increased rates of ventilation may be required.

*(2) Nearest half-inch duct diameter bases on 4,000 feet per minute velocity in pipe.

b. **Fixed enclosure**. A fixed enclosure with a top and not less than two sides which surround the welding or cutting operations and with a rate of airflow sufficient to maintain a velocity away from the welder of not less than 100 linear feet per minute.

4. **VENTILATION IN CONFINED SPACES**

a. **Air replacement**. All welding and cutting operation carried on in confined spaces shall be adequately ventilated to prevent the accumulation of toxic materials or possible oxygen deficiency. This applies not only to the welder but also to helpers and other personnel in the immediate vicinity. All replacement air shall be clean and respirable.

b. **Airline respirators**. In such circumstances where it is impossible to provide such ventilation, airline respirators or hose masks approved by the

Mine Safety and Health Administration and the National Institute for Occupational Safety and Health, shall be used.

c. **Self-contained units**. In areas immediately dangerous to life and health (IDLH), hose masks with blowers or self-contained breathing equipment shall be used. The breathing equipment shall be approved by the Mine Safety and Health Administration and the National Institute for Occupational Safety and Health.

d. **Outside helper**. Where Eagle Industrial Instrumentation welding operations are carried on in confined spaces and where welders and helpers are provided with hose masks, hose masks with blowers, or self-contained breathing equipment approved by the Mine Safety and Health Administration and the National Institute for Occupational Safety and Health, a worker shall be stationed on the outside of such confined spaces to insure the safety of those working within. This will be done in accordance with **EAGLE INDUSTRIAL INSTRUMENTATION**confined space standard practice instructions.

e. **Oxygen for ventilation**. Because of its flammable properties, **Oxygen shall never be used for ventilation.**

5. **FLUORINE COMPOUNDS**

a. **General**. In confined spaces, welding or cutting involving fluxes, covering, or other materials which contain fluorine compounds shall be done in accordance with the safety precautions and work practices delineated on the MSDS.

b. **Maximum allowable concentration**. The need for local exhaust ventilation or airline respirators for welding or cutting in other than confined spaces will depend upon the individual circumstances. However, experience has shown such protection to be desirable for fixed-location production welding and for all production welding on stainless steels.

6. **ZINC.**

a. **Confined spaces**. In confined spaces welding or cutting involving zinc-bearing base or filler metals or metals coated with zinc-bearing materials shall be done in accordance with the "Ventilation in confined space" section of this program

b. **Indoors**. Indoors, welding or cutting involving zinc-bearing base or filler metals coated with zinc-bearing materials shall be done in accordance with the "Local exhaust hoods and booths" section of this program.

7. **LEAD**

a. **Confined spaces**. In confined spaces, welding involving lead-base metals (erroneously called lead-burning) shall be done in accordance with the "Ventilation in confined space" section of this program.

b. **Indoors**. Indoors, welding involving lead-base metals shall be done in accordance with the "Local exhaust hoods and booths" section of this program.

c. **Local ventilation**. In confined spaces or indoors, welding or cutting involving metals containing lead, other than as an impurity, or involving metals coated with lead-bearing materials, including paint shall be done using local exhaust ventilation or airline respirators. Outdoors such operations shall be done using respiratory protective equipment approved by the Mine Safety and Health Administration and the National Institute for Occupational Safety and Health. In all cases, workers in the immediate vicinity of the cutting operation shall be protected as necessary by local exhaust ventilation or airline respirators.

8. **BERYLLIUM**. Welding or cutting indoors, outdoors, or in confined spaces involving beryllium-containing base or filler metals shall be done using local exhaust ventilation and airline respirators unless atmospheric tests under the most adverse conditions have established that the workers' exposure is within the acceptable concentrations defined by 29 CFR 1910.1000. In all cases, workers in the immediate vicinity of the welding or cutting operations shall be protected as necessary by local exhaust ventilation or airline respirator.

9. **CADMIUM**

a. **General**. Welding or cutting indoors or in confined spaces involving cadmium-bearing or cadmium-coated base metals shall be done using local exhaust ventilation or airline respirators unless atmospheric tests under the most adverse conditions have established that the workers' exposure is within the acceptable concentrations defined by 29 CFR 1910.1000. Outdoors such operation shall be done using respiratory protective equipment such as fume respirators approved by the Mine Safety and Health Administration and the National Institute for Occupational Safety and Health.

b. **Confined space**. Welding (brazing) involving cadmium-bearing filler metals shall be done using ventilation in accordance with the "Ventilation in confined space" and the "Local exhaust hoods and booths" section of this program.

10. **MERCURY**. Welding or cutting indoors or in a confined space involving metals coated with mercury-bearing materials including paint, shall be done using local exhaust ventilation or airline respirators unless atmospheric tests under the most adverse conditions have established that the workers' exposure is within the acceptable concentrations defined by 29 CFR 1910.1000. Outdoors such operations shall be done using respiratory protective equipment approved by the

Mine Safety and Health Administration and the National Institute for Occupational Safety and Health.

11. **CLEANING COMPOUNDS**

a. **Manufacturer's instructions**. In the use of cleaning materials, because of their possible toxicity or flammability, appropriate precautions such as manufacturers instructions shall be followed.

b. **Degreasing.** Degreasing and other cleaning operations involving chlorinated hydrocarbons shall be so located that no vapors from these operations will reach or be drawn into the atmosphere surrounding any welding operation. In addition, trichloroethylene and perchlorethylene should be kept out of atmospheres penetrated by the ultraviolet radiation of gas-shielded welding operations.

12. **CUTTING OF STAINLESS STEELS**. Oxygen cutting, using either a chemical flux or iron powder or gas-shielded arc cutting of stainless steel, shall be done using mechanical ventilation adequate to remove the fumes generated.

13. **FIRST-AID EQUIPMENT**. First-aid equipment shall be available at all times. All injuries shall be reported to your supervisor in accordance with **EAGLE INDUSTRIAL INSTRUMENTATION**policy as soon as possible for medical attention. First aid shall be rendered until medical attention can be provided.

F. INDUSTRIAL APPLICATIONS

1. **TRANSMISSION PIPELINE**

a. **General.** The requirements of the "Protection of personnel" and the "Health protection and ventilation" sections of this program shall be observed.

b. **Field shop operations**. Where field shop operations are involved for fabrication of fittings, river crossings, road crossings, and pumping and compressor stations the requirements of the "fire prevention and protection", "Protection of personnel" and the "Health protection and ventilation" sections of this program shall be observed.

c. **Electric shock**. When arc welding is performed in wet conditions, or under conditions of high humidity, special protection against electric shock shall be supplied.

d. **Pressure testing**. In pressure testing of pipelines, the workers and the public shall be protected against injury by the blowing out of closures or other pressure restraining devices. Also, protection shall be provided against expulsion of loose dirt that may have become trapped in the pipe.

e. **Construction standards**. The welded construction of transmission pipelines shall be conducted in accordance with the Standard for Welding Pipe Lines and Related Facilities, API Std. 1104--1968.

f. **Flammable substance lines**. The connection, by welding of branches to pipelines carrying flammable substances shall be performed in accordance with Welding or hot Tapping on Equipment Containing Flammables, API Std. PSD No. 2201—1963.

g. **X-ray inspection**. The use of X-rays and radioactive isotopes for the inspection of welded pipeline joints shall be carried out in conformance with the American National Standard Safety Standard for Non-Medical X-ray and Sealed Gamma-Ray Sources, ANSI Z54.1—1964

2. **MECHANICAL PIPING SYSTEMS**

a. **General.** The requirements of the "Fire prevention and protection", "Protection of personnel" and the "Health protection and ventilation" sections of this program shall be observed.

b. **X-ray inspection**. The use of X-rays and radioactive isotopes for the inspection of welded piping joints shall be in conformance with the American National Standard Safety Standard for Non-Medical X-ray and Sealed Gamma-Ray Sources, ANSI Z54.1—1963.

G. TRAINING

1. **Types of training**. Supervisors will determine whether training required for specific jobs will be conducted in a classroom or on-the-job. The degree of training provided shall be determined by the complexity of the welding, brazing, or cutting requirements of the individual job and the associated hazards.

a. **Initial training**. Prior to job assignment, **EAGLE INDUSTRIAL INSTRUMENTATION**shall provide training to supervisors, welders, cutters or any other related position to ensure that the hazards associated with all forms of burning, welding, brazing, and cutting operations including arc welding oxy/acetylene welding are understood by all employees related and that the knowledge and skills required for the safe application, usage, of work place equipment, are acquired by employees. The training shall include the following:

1) Each authorized or supervisory employee shall receive training in the recognition of applicable hazards involved with particular job. The methods and means necessary for safe work.

2) Each affected employee (welders and cutters) shall be instructed in the purpose and use of the confined space entry procedure (where needed).

3) All other employees whose work operations are or may be in an area where welding, brazing, or cutting is to be performed, shall be instructed about the procedure, and about the prohibitions relating to working in that area.

4) In addition, any personnel assigned must be trained and familiar with the operation and maintenance of equipment as per 1910.254

as well as procedure in AWS A6-1 involving the use of gas shielded or arc welding.

b. **Refresher training**. Scheduled refresher training will be conducted on an as needed basis.

1) Retraining shall be provided for all authorized and affected employees whenever there is a change in their job assignments, a change in welding equipment, equipment or processes that present a new hazards, when their work takes them into hazardous areas, or when there is a change in the confined space entry procedures (when used).

2) Additional retraining shall also be conducted whenever a periodic inspection reveals, or whenever **EAGLE INDUSTRIAL INSTRUMENTATION**has reason to believe, that there are deviations from or inadequacies in the employee's knowledge of known hazards, or use of equipment or procedures.

3) The retraining shall reestablish employee proficiency and introduce new equipment, or revised control methods and procedures, as necessary.

c. **Certification**. **EAGLE INDUSTRIAL INSTRUMENTATION**shall certify that all employee training has been accomplished and is being kept up to date. The certification shall contain a synopsis of the training conducted, each employee's name, job, and dates of training.

H. SELECTION AND USE OF WORK PRACTICES.

Supervisors shall develop and ensure use of standardized safety-related work practices to prevent injuries resulting from hot work accidents. The specific safety-related work practices shall be consistent with the nature and extent of the associated hot work hazards.

I. COMPRESSED GAS CYLINDERS

General requirements for safely handling compressed gas cylinders. The Interstate Commerce Commission defines a compressed gas as "that gas having a pressure in the container of 40 psia or greater at 70 degrees F, regardless of the pressure at 70 degrees F, having an absolute pressure exceeding l04 psi at l30 degrees F. In addition, it includes any liquid flammable material having a Reid vapor pressure exceeding 40 psia at l00 degrees F. A multitude of gases are available commercially, all having different properties and hazards associated with them. Their usage introduces hazards of flammability, explosion, chemical reaction, toxicity, and serious interference with manual fire-fighting efforts. The one common hazard shared by all compressed gases is pressure. There have been documented instances where a cylinder of gas has been damaged to such an extent that the instantaneous release of gas has rocketed the cylinder through a brick wall, propelling it several hundred feet away before coming to rest. Any and all workers in charge of oxygen and fuel gas supply, including piping systems must be trained and certified competent in the following:

a. **Safe Use of Compressed Gas Cylinders**

The following requirements must be observed when using, storing or handling compressed gas cylinders.

1) Know the cylinder contents; be sure identification labels are in place. Colors differ/also covers change.
2) Know the properties of the contents. MSDS's for the compressed gas being used, stored or handled should be reviewed with area personnel by the supervisor. The review should include information on physical data, fire and explosion data, reactivity, health hazards, special personal protection, and storage, spill and disposal procedures. MSDS's may be obtained from the supplier of the compressed gas, Safety Office, and/or purchasing.

b. **Responsibility and Procedures**

All operators of equipment should report any equipment defect or safety hazard and discontinue its use until it is safely repaired or replaced. If repairs are made they should be done by either the manufacturer or qualified person. The following are guidelines to follow in using and inspecting equipment.

1) Cylinder contents must be properly identified with appropriate label. Do not accept any cylinder that is not clearly labeled with its contents. Do not deface or remove any markings, labels, decals, tags, or stencil marks used for identification of content.
2) If a cylinder leaks and the leak cannot be remedied by simply tightening a valve gland or packing nut, close the valve and attach a tag stating that the cylinder was moved outdoors to a well ventilated location. If the gas is flammable or toxic, place an appropriate sign near the cylinder warning against these hazards and notify the Safety Observer or Supervisor. Notify the gas supplier and follow his instructions as to the immediate return of the cylinder.
3) Do not ship a leaking cylinder by a common or contract carrier whether charged or partially charged. Do not ship compressed gas cylinders that have been exposed to fire. Consult your supplier for advice under these circumstances.
4) Before returning empty cylinders, close the valve and see that cylinder valve protective caps and outlet caps or plugs, if used, are replaced. Mark or tag cylinder as "EMPTY".
5) Cylinders containing compressed gases should not be subjected to a temperature above l25 degrees F. A flame should never be permitted to come in contact with any part of a compressed gas cylinder.

6) Cylinders should not be subjected to artificially created low temperatures without the approval of the supplier. Many steels undergo decreased ductility at low temperatures.
7) Never attempt to repair or alter cylinders, valves or safety relief devices.
8) Never use cylinders as rollers or supports, or for any purpose other than to contain the material as received.
9) Keep the cylinder valve closed at all times, except when the cylinder is in active use.
10) Notify the owner of the cylinder if any condition has occurred which might permit any foreign substance to enter the cylinder or valve, giving details and cylinder serial number.
11) Do not place cylinders where they might become part of an electric circuit. When the cylinders are used in conjunction with electric welding, precautions must be taken against accidentally grounding compressed gas cylinders and allowing them to be burned by an electric arc.
12) Do not repaint cylinders.
13) When in doubt about the proper handling of a compressed gas cylinder or its contents consult the Safety Director of the manufacturer or supplier of the gas.

c. Moving Cylinders

1) Where removable caps are provided for valve protection, such caps should be kept on cylinders at all times except when cylinders are in use.
2) Do not lift cylinder by the cap.
3) Never drop cylinders nor permit them to strike against each other or against the surface violently.
4) Never handle a cylinder with a lifting magnet. Slings, ropes, or chains should not be used unless provisions have been made on the cylinder for appropriate lifting attachments, such as lugs. A crane may be use when a safe cradle or platform is provided to hold the cylinders.
5) Avoid dragging or sliding cylinders. Use a suitable hand truck, fork truck, roll platform, or similar device with the cylinder firmly secured for transporting and loading/unloading.

d. Storing Cylinders

1) Cylinder storage areas should be prominently posted with the names of the gases to be stored. Cylinders should be grouped by types of gas.
2) Oxygen cylinders in storage shall be separated from fuel, gas cylinders or combustible materials (especially oil or grease) by a minimum of 20 feet or by a noncombustible barrier at least 5 feet high having a fire resistance rating of at lease one-half hour.

3) Charged and empty cylinders should be stored separately with empty cylinders clearly marked.
4) Storage area shall be fire-resistant, dry and well ventilated.
5) Secure cylinders by chain or straps to a rigid support.
6) Inside storage of full containers shall not be located near exits, stairways, or in areas normally used or intended for the safe exit of people.

e. Using Cylinders

1) Secure to rigid support before using.
2) Use the regulator specified by the manufacturer for a special gas. Be sure the system pressure rating will handle regulator discharge pressure.
3) Insure that all connections are free of leaks. Never use a flame to detect flammable gas leaks, use leak detector or soapy water.
4) Do not use oil or grease on valves, reducers, regulators, or lines in an oxygen system.
5) Open cylinder valves slowly. Point the valve opening and/or the glass-covered gauge faced away from yourself or other persons. Close cylinder valves when stopping work, moving cylinders, or when cylinders are empty.
6) Never mix different gases in cylinder.
7) Acetylene cylinders should be used and stored in an upright position to avoid loss of acetone.