APPENDIX D - Oxy-fuel Gas Welding and Cutting

When performing oxy-fuel gas welding and cutting the following rules will apply:

- Oxy-fuel gas welding and cutting equipment shall be listed by a nationally recognized testing laboratory.
- Oxygen cylinders and apparatus will be kept free from oil, grease, and other flammable or explosive substances and will not be handled with oily hands or gloves.
- Oxygen cylinders and apparatus will not be used interchangeably with any other gas.

Hoses

- Fuel gas hose and oxygen hose will be readily distinguishable from each other.
- Oxygen and fuel gas hoses will not be interchangeable; a single hose having more than one gas passage will not be used.
- Hose couplings of the type that can be unlocked or disconnected without a rotary motion are prohibited.
- Hose which has been subject to flashback or which shows severe wear or damage will be tested to twice the normal pressure to which it is subjected, and in no case less than (300 psi). Defective hose, or hose in doubtful condition, will not be used.
- When parallel runs of oxygen and fuel gas hose are taped together, not more than 4 inches out of every 12 inches will be covered by tape.
- Boxes used for the storage of gas hose will be ventilated.
- Hose connections will be clamped or otherwise securely fastened in a manner that will withstand, without leakage, twice the pressure to which they are normally subjected in service, but not less than 300 psi.

Torches

- Torches shall be inspected, at the beginning of each working shift, for leaking shutoff valves, hose couplings, and tip connections. Defective torches will not be used.
- Hoses will be purged individually before lighting the torch for the first time each day. Hoses will not be purged into confined spaces or near ignition sources.
- Clogged torch tip openings shall be cleaned with suitable cleaning wires, drills, or other devices designed for such purposes.
- Torches will be lighted by friction lighters or other approved devices, not by matches or from hot work.
- Torch valves will be closed and the gas supply shut off whenever work is suspended.
- The torch and hose will be removed from confined spaces whenever work is suspended.
- Oxy-fuel gas, and other fuel gas-oxygen, welding and cutting systems utilizing cylinder-hose-torch will have a reverse-flow check valve, in each hose, between the torch and the regulator (Reverse-flow check valves that are integral with the torch are acceptable.).