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| ***G:\6100_Performance_HR\6555 - Organisational Safety and Wellbeing\2. HSW - Systems and Strategy Team\Rebadging OSW Documents (Kristyn)\ITD logos\Updated 2018\Welding_word_banner_SOP.jpg*****OXY – FUEL GAS WELDING**🗹**Circular Saw** |
| ***Students must complete the checklist below with a tick in every box before operating this welding equipment*** |
| **Has your teacher given you instruction on the safe use and operation of this equipment?** | **🗆** |
|  |
| **Has your teacher given permission for you to use this equipment?** | **🗆** |
|  | Are you wearing approved welding goggles?. | **🗆** |
| Foot Protection circle | Are you wearing protective footwear with substantial uppers?. | **🗆** |
| Hand Protection circle | Are you wearing oil-free leather gloves?  | **🗆** |
| **Hair Protection circle** | If you have long or loose hair, is it tied back and contained? | **🗆** |
| Apron | Are you wearing close-fitting protective clothing or overalls? | **🗆** |
| Prohibition circle | Have you removed all your exposed rings and jeweller? | **🗆** |
| **Have you read the important information section on the reverse?** | **🗆** |
|  **PRE-OPERATIONAL SAFETY CHECKS** |  |
| 1. Are there any slip/trip hazards present in workspaces and walkways?
2. Is the area clean and free of grease, oil and other flammable material?
3. Are gas hoses in good condition and unable to create a tripping hazard?
4. Have you made a visual inspection of all equipment for damage?
5. Is the area well ventilated and is the fume extraction unit on?
 | **🗆** |
| **🗆** |
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Oxy – fuel gas welding

Paste pages 1 & 2 back to back – cut out this section – laminate and trim to size

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| ***G:\6100_Performance_HR\6555 - Organisational Safety and Wellbeing\2. HSW - Systems and Strategy Team\Rebadging OSW Documents (Kristyn)\ITD logos\Updated 2018\Welding_word_banner_SOP.jpg*****OXY – FUEL GAS WELDING****Circular Saw** |
| **Important information – read before use** |
| **PRESSURE SETTING** |
| **DO NOT use faulty equipment – report this immediately to your teacher.** |
| 1. Check the oxygen and acetylene/fuel regulator adjusting knobs are loose.
2. Check that both blowpipe valves are closed.
3. Slowly open the cylinder valves on each cylinder for half a turn only.
4. Screw in the regulator adjusting knobs slowly until the delivery pressure gauges register 70kPa.
5. Purge and check for constant oxygen gas flow.
* Open the oxygen blowpipe for two seconds valve and check the delivery gauge.
* If necessary, re-adjust the oxygen regulator to achieve a 70kPa pressure.
* Close the oxygen blowpipe valve.
1. Purge and check for constant acetylene/fuel gas flow.
* Open the acetylene/fuel blowpipe valve for two seconds and check the delivery gauge.
* If necessary, re-adjust the acetylene regulator to achieve a 70kPa pressure.
* Check the acetylene blowpipe valve.
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| LIGHTING UP 1. Open the acetylene/fuel blowpipe valve slightly and light the blowpipe with a flint lighter.
2. Continue to slowly open the acetylene/fuel valve until the flame no longer produces soot.
3. Slowly open the oxygen blowpipe valve until a neutral flame is produced.

**SHUTTING OFF BLOWPIPE**1. Close the acetylene/fuel blowpipe valve first.
2. Then close the oxygen blowpipe valve.

**CLOSING DOWN** 1. Close down both cylinder valves.
2. Open oxygen blowpipe valve to allow the gas to drain out.
3. When oxygen gauges read zero, unscrew regulator-adjusting knob.
4. Close oxygen blowpipe valve.
5. Turn off acetylene/fuel cylinder valve.
6. Open acetylene/fuel blowpipe valve and release gas.
7. When acetylene/fuel gauges read zero, release regulator adjusting knob.
8. Close acetylene/fuel blowpipe valve.
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| **HOUSEKEEPING** |
| 1. Hang up welding blowpipe and hoses.
2. Turn off fume extraction.
3. Leave the work area in a safe, clean and tidy condition.
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| **POTENTIAL HAZARDS** |
| ◼ Flying sparks ◼ Fumes ◼ Flashbacks ◼ Fumes and vapours ◼ IR radiation burns to eyes and skin ◼ Fire ◼ Explosion by gas leakage |
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| **FORBIDDEN** |
|  ◼ Lighting the blowpipe with matches or lighters.  ◼ Using oil, greases or other hydrocarbons near or around Oxy/Acetylene gasses. ◼ Using oxygen as a substitute for compressed air.  |

 **Date of last review:**  \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ **Signature:** \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_