



### Welding and Soldering

#### Gas Welding

- Store and transport compressed gas cylinders in the upright position with the valve protective caps on. Secure cylinders in portable service upright with a chain.
- Never weld in areas with limited or restricted air supply (confined space) without prior approval from the Department of Safety and Environmental Affairs.
- Do not store or place cylinders where they will be exposed to heat, flame, impact, electric arcs or circuits, high temperature process equipment or sparks.
- Use regulators and pressure gauges only with gases for which they are designed and intended. Do not attempt to repair or alter cylinders, valves, or attachments.
- Place a “Defective” tag on any fuel gas cylinder in which leaks occur and immediately remove it from service and store outdoors.
- If gas cylinders are close to welding or cutting operations, place a fire resistant shield between the cylinders and these operations.
- Place an “Empty” tag on all empty cylinders and store them separately from full ones.
- Before removing a regulator from a cylinder valve, close the cylinder valve and release the gas from the regulator.
- Wear proper eye and/or face protection when welding.
- Inspect torches in use at the beginning of each working shift for leaking shutoff valves, hose couplings, and tip connections.
- Use friction lighters or other approved devices to light torches. Never use matches or hot work to light torches.
- Shut gas cylinders off when operations are suspended for any substantial period of time, such as during lunch or overnight. Upon completion of welding operations, warn other workers of the location of hot metal.
- Cut or weld only in areas that are or have been made fire safe.
- Where practicable, relocate all combustibles at least 35 feet from the work site. Where relocation is impracticable, combustibles should be protected with flame-proofed covers or otherwise shielded with suitable guards or curtains.
- Maintain suitable fire extinguishing equipment ready for use while welding and cutting are being performed.
- Make sure fire watchers are employed whenever welding or cutting is performed in locations where other than a minor fire might develop.



### Arc Welding and Cutting

1. Protect workers or other persons adjacent to the welding areas from the rays by erecting noncombustible or flameproof screens or shields, or have them wear appropriate safety goggles.
2. Make sure arc welding and cutting cables are insulated, flexible and capable of handling the maximum current required by the operations, taking into account the duty cycles.
3. Make sure ground connections are mechanically and electrically adequate to carry the current.
4. When electrode holders are left unattended, remove electrodes and place holders to prevent employee injury.
5. Keep the power supply switch in the off position when arc welders or cutters leave or stop work or when machines are moved.
6. When arc welding is performed in wet or high humidity conditions, use additional protection, such as rubber pads or boots, against electric shock.
7. If you are exposed to UV radiation, make sure your skin is covered completely to prevent ultraviolet burns and damage. Be sure your helmets and hand shields do not have leaks, openings or highly reflective surfaces.

### Soldering

1. Perform soldering activities only if you are trained and authorized to do so.
2. Always wear personal protective equipment, including safety glasses, when soldering.
3. Always solder in well-ventilated areas.
4. Minimize soldering fumes by using the lowest acceptable wattage and holding the electrode perpendicular and as close to the work surface and possible.
5. Position yourself while welding or cutting so that your head is not in the fumes.
6. Remove all nearby flammable or combustible materials before striking an arc or lighting a flame.
7. Keep welding areas free of equipment and machines that could cause trips or falls.

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