



GAS WELDING AND CUTTING EQUIPMENT

SAFETY INSTRUCTIONS

1. The area used for welding and cutting operations must be well ventilated and clear of flammable material
2. The operator must use goggles, gloves and other protective clothing to safeguard himself against sparks and flames. Respiratory protection should be used where necessary.
3. Cylinders must be properly secured in an upright position.
4. Regulators must be correct for the gas and the pressure range required. They should be examined for leaks and any form of damage, particularly to gauges before use.
5. Flashback Arrestors should be fitted to the outlet of the regulator.
6. Cylinder outlets must be free from dirt (a little gas should be 'shifted' through the valves before attaching the regulators) and regulator bullnosed nipples, seatings and threads must be free from damage.
7. Hoses should be in good condition and free from cuts and abrasions. New hoses must be blown through to remove any dirt or dust before fitting nut and hose nipple to 'regulator end' and HCV or Flashback Arrestor 'blowpipe end' of hose.
8. All hose connections must be free from dirt, in good condition and properly tightened.
9. Oil and grease must never be used with oxygen regulators or other equipment connected with oxygen supplies.
10. The regulator P.A. (pressure adjusting) screw must be in the unscrewed (zero pressure) position before opening the cylinder valve.
11. Blowpipe valves must be in the closed position before opening cylinder valves.
12. The cylinder valves must be opened slowly to prevent a pressure surge and an approved cylinder key must be used. The key should be left on the cylinder.
13. The regulators must be correctly adjusted to give the manufacturer's recommended pressures for the cutting or welding nozzles being used and the work to be done. Setting should be carried out in the flow condition.
14. The hoses must be purged individually, away from naked light, before lighting the blowpipe.
15. The blowpipe should be examined to ensure that it has no leaks before being lit.
16. To light the blowpipe, ignite fuel gas first and then open oxygen valve until a neutral flame is obtained.
17. To extinguish blowpipe, close fuel valve first and then the oxygen valve. If a sustained backfire is experienced close oxygen valve first.
18. The oxygen and fuel gas cylinder valves should be closed firmly.
19. Pressure in the hoses should be released by opening and then closing each blowpipe valve in turn.
20. The regulator P.A. screws should be unscrewed into the zero pressure position.