







# EHS Guidance Notes



## GN # 11b – Gas Welding & Cutting

Environment, Health and Safety  
Ports, Customs & Free Zone Corporation

		
<p style="text-align: center;"><b>LOCATION OF WORK &amp; TROLLEY</b></p> <ul style="list-style-type: none"> <li>▪ Keep the flammable storage away from the gas welding &amp; cutting operation.</li> <li>▪ Keep &amp; store the gas cylinders away from the source of heat.</li> <li>▪ Always keep the gas cylinders vertical in a trolley &amp; tied with chain.</li> <li>▪ Do not lift gas trolley with crane.</li> </ul>	<p style="text-align: center;"><b>HOT WORK PERMIT</b></p> <ul style="list-style-type: none"> <li>▪ Obtain Hot work Permit from the area supervisor.</li> <li>▪ Cordon off the area &amp; display the permit where welding &amp; cutting work is carried out.</li> <li>▪ Operations shall be shielded by non-combustible or flameproof screens to protect people working in the close vicinity.</li> <li>▪ Flammable containers shall be drained, washed, dried thoroughly &amp; purged with inert gas.</li> </ul>	<p style="text-align: center;"><b>FLASH BACK ARRESTOR, HOSE PIPES &amp; PRESSURE GAUGES</b></p> <ul style="list-style-type: none"> <li>▪ Ensure that Flash back arrestors are provided on both the cylinders.</li> <li>▪ Provide <b>RED</b> colour hose pipe for Acetylene cylinder &amp; <b>GREEN</b> for Oxygen cylinder.</li> <li>▪ Hose pipes must be connected with proper clamps.</li> <li>▪ Maintain pressure gauges in working condition.</li> <li>▪ Torch should be kept free from molten metal slag.</li> </ul>
		
<p style="text-align: center;"><b>FIRE FIGHTING EQUIPMENT &amp; USE OF PPE</b></p> <ul style="list-style-type: none"> <li>▪ Provide appropriate fire fighting equipment as prescribed by the Civil Defense.</li> <li>▪ Workers shall be protected by suitable eye, face, hand, body, foot &amp; respiratory protective equipment.</li> </ul>	<p style="text-align: center;"><b>STORING GAS CYLINDERS</b></p> <ul style="list-style-type: none"> <li>▪ Provide adequate mechanical fume extraction &amp; / or forced ventilation whenever work is not carried out in the open air.</li> <li>▪ Gas cylinders shall be stored in a well ventilated shed made up of non flammable material.</li> <li>▪ Keep the valve caps in place.</li> </ul>	<p style="text-align: center;"><b>TRAINING &amp; FIRE WATCH</b></p> <ul style="list-style-type: none"> <li>▪ Contactors shall instruct workers in the safe means of arc welding and cutting.</li> <li>▪ Provide fire watch for at least an hour after completion of welding or cutting work.</li> </ul>