



Torch Safety Program

1. Employees will be properly and thoroughly trained before attempting to do any work with or on any Cutting Torch or Propane Torch.
2. Before igniting the flame of a torch: open the oxygen valve on the torch. Wait until all air has been discharged from the oxygen hose and torch. Close the valve. Open the fuel gas valve on the torch handle. Wait until all air has been discharged from the fuel gas hose and torch then light the fuel gas and open the oxygen valve on the torch handle. Adjust the oxygen to produce the required flame for the job.
3. Light torches with friction lighters or other suitable lighters and not matches. Point the tip away from people.
4. Never put down a torch until the gases have been completely shut off.
5. Never open or turn the pressure adjusting screws on the regulators all the way out. Always adjust flames at torch valves, not with regulator adjusting screws.
6. ALWAYS use fuel gases at safe pressures. Many gauges permit higher, unsafe pressures. If you find a gauge that permits unsafe pressures, take it out of service immediately.
7. Oxygen is not a fuel and will not burn, but contact with it can cause combustible materials such as oil and grease to burn rapidly at room temperature. Therefore, keep oxygen away from grease or oil on surfaces such as gloves, clothes, cylinders, valves, couplings, regulators, and hoses. Do not use oxygen instead of compressed air in pneumatic tools, in oil preheating burners, to start internal combustion, to blow out pipelines, to dust clothing or work, or to create pressure for ventilation.
8. Oxygen and fuel gas hoses must be different in color (green for oxygen and red for fuel gas) or otherwise identified.
9. Inspect hoses and connections every day for leaks. Look for holes, cracks, and loose cylinder fittings or track connectors. To check for leaks: close the oxygen and fuel gas torch valves, then turn the regulator pressure adjusting screws clockwise to give normal working pressure on oxygen valves and about ten PSIG on fuel gas valves. Use non-fat soapy water or

- approved leak test solution to test for leaks. At the same time, check regulators for creeping.
10. If a torch backfires frequently, inspect it and clean the tip. If it continues to backfire or you find other problems, remove it from service immediately. Take it to a qualified technician for repair.
 11. Do not use steel wire or similar materials to clean tip orifices.
 12. "Flashback" occurs when a flame burns back inside a torch, tip, hose, or regulator and can cause a fire or explosion if it reaches the cylinder. Flashbacks usually make high-pitched squealing or hissing sounds. Flashback arrestors at torch handles and check valves at gas sources help prevent flashbacks. In case of flashback: *Close the oxygen valve at once. *Close the fuel valve. *Let the torch cool off. *Have the torch repaired or replaced.
 13. Wear PERSONAL PROTECTIVE EQUIPMENT as required to include tinted eye protection, gloves, etc.
 14. Never store flammable or combustible materials in any area designated as a "Hot Work Area".
 15. Always ensure that there is adequate exhaust ventilation before starting any hot work with torches.
 16. Check the immediate area where you are about to ignite a torch to ensure that there are no open containers of flammable liquids. Inspect the work area next to yours as the employee working in that area may have inadvertently left a container of used flammable liquid nearby. I.E. Used transmission fluid, motor oil, etc.