



OPERATIONAL CONTROL PROCEDURE

Doc. No.: HSEOCP:04

Rev. No.: 00

Rev. Date: 10/01/2018

OCP No. : 04

SAFE WELDING AND GAS CUTTING OPERATION

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Purpose	To ensure that all activities related to welding and gas cutting are safe.	Scope	ISG
Responsibility	Concerned Head/ SOX		
Performance criteria	No. of incidents / accidents on such cases		
Cross reference	ISO : 14001, OHSAS : 18001		

PPEs and Precautions

	Insulated rubber gloves		Eye protection as identified in SDS must be worn at all times		A welding mask is required for this process
	Respiratory protection as identified must be worn		All cylinders must have protective devices and be secured vertically		Mandatory requirements are specified and must be followed. Report any near misses/accidents.

Procedures and Controls

S. No.	Activity	Responsibility
1.	Use trolleys and cradles of adequate strength, as far as possible, while moving the cylinders.	Supervisor
2.	Always keep LPG and other liquefiable gas cylinders in upright position and ensure that they are not knocked over	Operator
3.	Check that the valves of the gas cylinders are lightly shut when not in use.	Operator
4.	Do not release gas from the cylinder unless pressure regulator is fitted to its valve.	Operator
5.	Use gas hoses specially designed for the purpose with standard colour code.	Operator
6.	Use proper clamps for hose connections, Check leakage from hose connections before starting work. Never use steel wires for clamping.	Operator
7.	Take care that there are no kinks in the hoses and the hoses are laid such that nobody steps on the hoses and these do not get damaged due to activities in progress in the vicinity.	Operator
8.	Use flame flash back arrestors to avoid back firing in flammable gas cylinders.	Supervisor
9.	Open the valve of oxygen gas first and then flammable gas for lighting the torch.	Operator
10.	Use friction gas lighters only for lighting the torch. Never use matches or smouldering manila ropes or rags for lighting the torch.	Operator
11.	Protect the gas cylinders and hoses from welding sparks or gas cutting sparks falling on them.	Operator
12.	Ensure that the valve key is easily accessible to close the valve immediately in case of emergency.	Operator
13.	Never crimp the hose for temporary shutting of gas. Always shut the supply through pressure regulators.	Operator
14.	Check the hoses daily for any visible damage. Discard the hoses in which gas had backfired.	Supervisor



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15.	Remove the leaking cylinder of flammable gas immediately to an open space where it is least dangerous to life and property. Intimate the supplier of the cylinder.	Supervisor
16.	Ensure use of aprons, gloves and other PPE as appropriate.	Supervisor

Site Safety department to identify all possible Welding & Gas Cutting Hazard Areas and ensure control as per this OCP.

In addition, relevant records pertaining to actions taken to be prepared and kept.

Records:

Record Title	Record No.	Location	Responsibility	Retention Period

Verification, Corrective and Preventive Action:

HOD / Site In-charge shall ensure effective implementation of the above procedure. In case of any deviation, shall take suitable corrective and preventive action.

Revision History

Revision Date	Revision No.	Old Text	New Text	Reason	Revised by (with sign)