

U.S. Army Corps of Engineers Safety Inspection Checklist Gas Welding/Cutting/Heating Operations

Date of Inspection

| | |
|------------------------------|---------------------|
| Location (Plant or Facility) | Contract Number |
| Contractor Name | Project Name |
| Inspector Name (Print) | Inspector Signature |

This checklist serves as a guide only, it does not replace or eliminate the need to comply with the requirements set forth in Engineering Manual 385-1-1, Safety and Health Requirements Manual, dated 15 September 2008. The references included in this checklist correspond to the applicable sections of EM 385-1-1.

| Item Description | REF | Yes | No | N/A | Remarks (Any NO or N/A item) |
|--|---------------------|-----|----|-----|------------------------------|
| 1. Does the welding unit have a compatible fire extinguisher in the immediate vicinity? | 10.C.01 | | | | |
| 2. When welding operations are near combustible materials, has a Hot Permit been issued? | 10C.02 10.C.03.c | | | | |
| 3. Is a qualified fire watch assigned to guard against fire after welding and instructed in fire fighting equipment? | 10.C.04 09.J.03 | | | | |
| 4. Is adequate ventilation or correct respirators provided for the welder and helper? | 10.B.03-7 | | | | |
| 5. Is cutting over combustible flooring protected? | 10.C.05 | | | | |
| 6. If the floor is wet or damp are personnel protected from potential shock hazards? | 10.C.05 | | | | |
| 7. Are noncombustible barriers installed below welding or burning operations in a shaft or raise? | 10.C.07 | | | | |
| 8. Are fire resistant guards installed if welding near combustible walls, partitions, ceilings, or roofs? | 10.C.08 | | | | |
| 9. Have welding or cutting drums, tanks, or containers that have contained hazardous materials been cleaned first? | 10.C.11 | | | | |
| 10. Is hot tapping, cutting, welding or cutting on a flammable gas or liquid pipeline done IAW API standards? | 10.C.12 | | | | |
| 11. Is cutting, welding or heating near a sprinkler head protected before commencing operations? | 10.C.13 | | | | |
| 12. Are oxygen cylinders and regulators kept free from oil, grease, and other flammable or explosive substances? | 10.D.02 | | | | |
| 13. Are oxygen cylinders and apparatus not used interchangeably with any other gas? | 10.D.02 | | | | |
| 14. Are fuel and oxygen gas hoses distinguishable from each other and not interchangeable? | 10.D.03 | | | | |

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| 15. Are hose couplings the type that can be locked or disconnected without rotary motions are prohibited? | 10.D.03.c | | | | |
| 16. Are hoses with flashback evidence or severe wear or damage not be used? | 10.D.03.d | | | | |
| 17. Are oxygen and fuel gas hoses running parallel only taped 4" out of 12" with tape? | 10.D.03.e | | | | |
| 18. Is the storage of hoses and regulators ventilated? | 10.D.03.f | | | | |
| 19. Are hose connections clamped or otherwise secured to withstand without leakage twice the pressure subjected to and NLT 300 psi? | 10.D.03.g | | | | |
| 20. Are torches, shutoff valves, hose couplings, and tip connections inspected before each use for leaks and defective ones removed? | 10.D.04.a | | | | |
| 21. Are all hoses purged individually before lighting a torch for the first time and after shutting down for the day? | 10.D.04.b | | | | |
| 22. Are torch tips checked with cleaning wires designed for cleaning to ensure they are clean? | 10.D.04.c | | | | |
| 23. Are lighting of cutting torches or welding gas torches only done by friction or approved devices? | 10.D.04.d | | | | |
| 24. When the use of torch/welding gas equipment is suspended, is the gas/fuel supply shut off and removed from confined space? | 10.D.05 10.D.06 | | | | |
| 25. Are the oxygen and fuel gas lines using cylinder, regulator, hose, torch each protected with a reverse flow check valve and flash arrestor on each hose at regulator or at the torch? | 10.D.07 | | | | |
| 26. Are acetylene regulators adjusted to not permit a discharge greater than 15 PSI or 103.4 kPa on the gauge? | 10.D.09 | | | | |
| 27. Are fuel and gas compressed cylinders stored in well ventilated locations, stored in separated groups and labeled with caps on them when not in use and placarded? | 20.D.03 20.D.07 | | | | |
| 28. Are fuel gas cylinders and oxidizing gasses separated by at least 20 feet or a fire resistive partition having at least a 1 hour rating? | 20.D.03.d | | | | |
| 29. Are fuel gas cylinders not opened more than 1.5 turns and oxygen cylinders opened all the way? | 20.D.11 | | | | |
| 30. Are leaking cylinders isolated outdoors and at least 100 feet from personnel and allowed to escape slowly and marked defective after the gas has escaped? | 20.D.15 | | | | |

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| 31. Are oxygen and fuel gas pressure regulators, including gauges, in proper working order while in use and a valve wrench or wheel in operating position when in use to shut them off? | 20.D.11 20.D.19 | | | | |

Other Remarks