

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