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| <i>HEALTH AND SAFETY MANUAL</i> |  |
| Title: Acetylene | |
| Approved by: Greg Savoy | Rev. 1/1/08 |

1 Purpose/Scope:

To assure all the Company employees that are handling acetylene are adequately trained in the inherent hazards of the cylinders and their contents, as well as proper handling, storage, and use.

This program is applicable to all the Company employees that are engaged in any phase of operations dealing with acetylene.

2 Definitions/Responsibilities:

2.1 Responsibilities:

2.1.1 Supervisors:

- Supervisors shall verify that employees under their supervision receive the proper training in regards to “best work practices” concerning acetylene and other compressed gas cylinders.

2.1.1 Employees:

- Each employee shall determine that the acetylene cylinders under their control are in a safe working condition, stored properly and handled properly.

3 Requirements:

3.1 General:

3.1.1 Acetylene safety precautions shall be strictly observed and enforced.

- Store acetylene cylinders in an upright position (valves facing upwards). Do not lie on sides, drop, or handle roughly. If for some reason an acetylene cylinder was placed in a horizontal position, it shall be placed in an upright position for two (2) hours before use.
- They must be securely fastened to prevent shifting or falling.
- Store acetylene cylinders in a well-protected, well ventilated, dry place away from any heating devices or combustible materials.
- Acetylene cylinders shall be kept at least 20 feet from oxygen cylinders or separated by a noncombustible barrier at least 5 feet high with a fire rating of at least one-half hour.
- All valves shall remain closed on empty cylinders.

- Use acetylene from a cylinder only through a pressure-reducing regulator. Do not use acetylene at pressures greater than 15 psi.
- Open the acetylene valve slowly, ¼ to ½ turn. This will permit an adequate flow of gas. Never open the valve more than 1 ½ turns of the spindle.
- Only use hoses, regulators, and valves that are recommended for acetylene services.
- Pure copper or copper alloys containing 67 to 99 percent copper shall not be used in piping or fittings for handling acetylene except for torch tips.
- Never make any attempt to transfer acetylene from one cylinder to another.
- Turn the acetylene cylinder so that the outlet will point away from the oxygen cylinder.
- Do not stand in front of the valve when opening it.
- Keep sparks, flames, and heat away from acetylene cylinders.
- Test for leaks with soapy water-not with an open flame.
- Should an acetylene cylinder catch fire, use a wet blanket to extinguish the fire.
- If this fails, spray a stream of water onto the cylinder to keep it cool.

4 REFERENCES:

29 CFR 1910.102, Acetylene.

5 Exhibits:

None.