

Mobile Oxy-Fuel Procedures

Light Up Procedure

Check	<ul style="list-style-type: none"> Local fire procedures are followed Fire extinguishers are available Appropriate PPE is in use.
Visual Check	<ul style="list-style-type: none"> Before use visual checks are completed.
Purge	<p>Purge oxygen & fuel hoses in turn whilst setting working pressure.</p> <ul style="list-style-type: none"> Purge oxygen & fuel assembly in turn. Open cylinder valve to a maximum 1.5 turns Open torch valve Open regulator & adjust to set for initial working pressure. Purge each hose & gas assembly checking for gas flow from torch. Close torch valves.
Leak Check	<ul style="list-style-type: none"> All Joints

Ensure torch valves are closed before proceeding

Purge Torch	<ul style="list-style-type: none"> Open oxygen torch valve, purge 3-5 seconds, then close the valve. Open fuel torch valve, purge 3-5 seconds, then close the valve.
Lighting the system	<ul style="list-style-type: none"> Open fuel gas torch valve Ignite the fuel gas with the correct spark lighter. For acetylene increase fuel gas valve to reduce smoke if necessary.
	<ul style="list-style-type: none"> Slowly open the oxygen torch valve until a clear sharply defined flame is achieved.

Shut Down Procedure

The fuel gas is normally switched off first - consult the Equipment Supplier's handbook as there may be variations	
Extinguish the working Flame at the torch	<ul style="list-style-type: none"> Fuel gas off Oxygen off
Close Cylinder Valve	<ul style="list-style-type: none"> Turn the cylinder valve keys clockwise until closed.
Vent System (No Gas)	<ul style="list-style-type: none"> Open torch valves in turn. Vent the gas from each of the hoses Check gauges are reading zero.
Close Torch Valves	<ul style="list-style-type: none"> Close all torch valves.
Close Regulator	<ul style="list-style-type: none"> Close regulator pressure adjustment screw.

Check Three Stops

Three Stops Employed	<ol style="list-style-type: none"> Torch Valves Closed Cylinder Closed Regulator Closed
Safely Store Equipment	<ul style="list-style-type: none"> Preferably do not stow hoses around the cylinders Remove the cylinders from any confined space.

Emergency Procedure

TURN OFF only if safe to do so	<ol style="list-style-type: none"> Oxygen torch valve first Fuel gas torch valve Cylinder valves
Immediately put down the torch, preferably in water, as the oxygen may use the torch components as a fuel causing the torch to melt.	
Check acetylene cylinder (if used)	<ul style="list-style-type: none"> If the cylinder appears to generate its own heat, or has been involved in a fire, evacuate the area & call the Fire Services.
Check equipment for damage	<ul style="list-style-type: none"> Replace damaged hose & any damaged equipment.
Restart	<ul style="list-style-type: none"> Ensure visual before use checks & light up procedures are repeated.



Global Welding Supplies
 13 Patiki Road, Avondale, Auckland, 1026
 www.gws.co.nz | +64 9 828 9888
 sales@gwsnz.co.nz