

YELLOW CARD

Inspection instruction for gas equipment during welding and cutting

This instruction shows how the company can fulfil the regulations of the Swedish Work Environment Authority and the Swedish Civil Contingencies Agency regarding the inspection of gas equipment used for welding and cutting.

Action	Daily inspection ¹	Self-inspection ² (Leak test ³ at least every six months)	Inspection during change of component
Component			
Gas cylinder	Properly secured?	–	Is the cylinder screw-thread intact?
Regulator	Correct pressure? Damaged?	Connections	Test the connections for leakage.
Backfire protection ⁴	In place?	Connections	–
Hose connections	Tightened?	Connections	Test the connections for leakage.
Hoses	Cracking or other defects?	Cracking or other defects?	Is the hose labelled EN 559, EN 3821 ⁵ ?
Check valves ⁶	In place?	Including function check.	Test the connections for leakage.
Blowpipe's welding and cutting capacity	Defects?	Connections and valves	Check gaskets. Test the connections for leakage.

See explanations on the back for footnotes 1, 2, 3, 4, 5, and 6.

The central supply system for gas shall be tested for leakage at least once a year. The inspection is carried out as self-inspection as per directions in *Utförning av försörjningssystem för gas* (Design of supply systems for gas) from the Swedish Welding Commission. **Attach this instruction to the equipment!**

1. The person using the equipment performs a **daily inspection**.
2. Continuous oversight is required according to the Swedish Work Environment Authority's regulations on the use of pressure retaining devices, AFS 2002:1. Continuous oversight is conducted as **self-inspection** by the company itself, by specially appointed and trained staff. Records of inspections are to be entered in a journal. Journal sheets and instructions for self-inspection are found at **www.svets.se/kontrollinstruktion**.

3. The entire system is preferably **tested for leakage** in one go (use a leak detector spray or soap water). Check that the valves on the blowpipe handle are closed. Open the cylinder valve and pressurise the system. Close the cylinder valve and check after about five minutes that the pressure has not dropped on the high pressure manometer.

4. **Backfire protection** is to be in place on regulators/line terminals for acetylene according to the Swedish Civil Contingencies Agency's regulations on portable containers for flammable gas, SÄIFS 1998:7. The backfire protection's lock and protection functions are to be tested every 24 months according to SÄIFS 1998:7. This should be performed by a workshop approved by the supplier.

5. EN 3821 only applies to twin hoses.

6. According to the Swedish Work Environment Authority's regulations on fuse welding and thermal cutting, AFS 1992:9, **clack valves** must be in place.

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KOMMISSIONEN**

The yellow card has been prepared by the Swedish Welding Commission's AG42e (Work group for safety during acetylene and oxygen installations) and can be ordered from the Welding Commission.

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