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## Risk Element

- Fire caused by flame from welding torch;
- Danger to personnel falling into pipe ducts or from scaffolding.

## Precautions to Eliminate/Reduce Risk

- All gas bottles are to be correctly secured;
- Flash back arrestors must be fitted to brazing equipment;
- A suitable fire extinguisher must be to hand;
- Two checks, one after 30 minute interval at the end of the operation. All hot works to stop 1 hour prior to end of shift, with a thorough inspection carried out before leaving site for any smouldering materials;
- All scaffolding must be erected by a competent person, and have safety rails and kick boards fitted & a current inspection tag;
- All scaffolding to be held firmly in position and scaffolding towers are to be fitted with out-riggers;
- All work areas to be cordoned off with suitable safety barriers;
- Low pressure Nitrogen should be passed through sections of pipework while brazing operations are carried out to prevent scale formed by Oxidisation;
- All Nitrogen bottles must be fitted with a pressure reducing regulator and gauge;
- Brazing to be carried out in accordance with COSHH Assessment information;
- Wear correct personal protective equipment;
- Safety harnesses should be worn, where appropriate, when working at high level.

## Safe Working Method

- All works to be carried out as per client's specification or best practice (where applicable);
- Ensure sufficient clearance is allowed for expansion and contraction of pipework during operation of the system;
- Remove all debris from pipe ducts before commencing work;
- All pipe supports are to be firmly fixed, following the manufacturer's instructions and recommendations;
- All fittings and pipes are to have brazed connections, unless mechanical joints have been specified;
- Low pressure Nitrogen must be passed through sections of pipework while brazing operations are carried out to prevent scale formed by Oxidisation.