



**PURPOSE/APPLICATION**

**PPE**

- Hearing protection
- Safety Glasses
- Welders Mask
- Face Shield
- Gloves

**TRAINING**

- Orientation
- Competency
- Training

**TOOLS/EQUIPMENT**

- Side Boom
- Welding Trucks
- Seam Turners
- Calipers
- Slings
- Grinders
- Tiger Torch
- Propane Tanks

#	Job Steps	Hazards	Control Measures
1	Buff Pipe Ends	<ul style="list-style-type: none"> <li>▪ Flying Debris</li> <li>▪ Pinch Potential</li> <li>▪ Rotational hazards</li> <li>▪ Awkward body positioning</li> </ul>	<ul style="list-style-type: none"> <li>▪ Ensure double eye protection is being utilized while grinding, buffing, chipping, etc.</li> <li>▪ Ensure all required PPE is being utilized</li> <li>▪ Stay out of the line of fire</li> </ul>
2	Pre-heat pipe with tiger torch to specified temperature	<ul style="list-style-type: none"> <li>▪ Fire and Explosion</li> <li>▪ Burns</li> </ul>	<ul style="list-style-type: none"> <li>▪ Fire extinguisher present</li> <li>▪ Ensure appropriate hand protection is being worn</li> </ul>
3	Install calipers onto pipe, lift pipe with Side Boom and insert pipe end into clamps	<ul style="list-style-type: none"> <li>▪ Pinch Points</li> <li>▪ Mechanical failure</li> <li>▪ Crush potential</li> <li>▪ Suspended loads</li> <li>▪ Rigging failure</li> </ul>	<ul style="list-style-type: none"> <li>▪ Pre-inspect <b>ALL</b> equipment prior to use and take any damaged equipment out of service</li> <li>▪ Never work under a suspended load</li> </ul>



**SAFE JOB PROCEDURE**

**SJP-31**

**April 18, 2018**

**PIPELINE WELDING**

#	Job Steps	Hazards	Control Measures
4	Weld pipe together at joint ends	<ul style="list-style-type: none"><li>Arc Flash</li><li>Flying debris</li><li>Sparks</li><li>Stored energy</li></ul>	<ul style="list-style-type: none"><li>Ensure welding masks are being utilized</li><li>Use double eye protection</li><li>Ensure tack welds on pipe cover at least 50% before removing clamps</li></ul>
5	Set welded pipe onto Pipeline Cones or skids	<ul style="list-style-type: none"><li>Uneven ground conditions</li><li>Pinch Points</li><li>Damaged skids or cones</li><li>Miscommunication</li></ul>	<ul style="list-style-type: none"><li>Ensure Pipeline Cones or skids are sitting on level ground</li><li>Stay out of the line of fire</li><li>Ensure Cones or skids are in good condition, and replace all damaged ones</li><li>Use a spotter when necessary to give signals to operator</li></ul>

**Additional Precautions:**



**REFERENCE/REGULATIONS**

- Alberta OH&S Code
  - Part 2 Hazard Assessment, Elimination, And Controls
  - Part 7 Emergency Preparedness and Response
  - Part 10 Fire and Explosion Hazards – Section 171 - 174
  - Part 18 Personal Protective Equipment
- British Columbia OH&S Regulation
  - Part 4 Emergency Preparedness and Response – Section 4.13-4.16,
  - Part 8 Personal Protective Clothing and Equipment
- Saskatchewan OH&S Regulations
  - Part 7 Personal Protective Equipment
  - Part 13 Hoists, Cranes and Lifting Devices
  - Part 22 Controlled Products
  - Part 25 Fire and Explosion Hazards
- All Applicable CPES Codes, Rules, Policies and Procedures

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Developed by:	1. Jay Pilon	2. _____	Date:	Apr 21/2010
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Revised by:	1. Ryan Obleman	2. _____	Date:	Apr 18/2018
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