



# Oregon

John Kitzhaber MD, Governor

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November 12, 2014

[Text of changes](#)

## Oregon OSHA – Adopted Changes to Oxygen-fuel Gas Standards in General Industry and Construction

Oregon OSHA has adopted OAR 437-002-2253, the Oxygen-Fuel Gas Welding and Cutting Standard for General Industry employers and Construction employers when welding, cutting, brazing, soldering, and flame coating is performed using a combination of oxygen and a fuel-gas. This rulemaking combines the existing Division 2 and Division 3 Oxygen-Fuel Gas Welding and Cutting rules. Twelve related Division 2 rules and a single Division 3 rule were either amended or repealed in the creation of OAR 437-002-2253.

OAR 437-002-2253 makes one rule applicable to all disciplines involved in the processes of welding, cutting, brazing, soldering, and thermal coating when using a combination of oxygen and a fuel-gas except for Agriculture, Maritime and Forest Activities. Additionally, it adds a Scope to the rule.

It provides definitions for key words and terms relevant to processes covered by the rule. It creates a user friendly format by taking separate rules that had multiple requirements and consolidating them into a single rule with easy to understand sections, sections that can be used as a template for training.

The rule establishes a requirement for the training of employees to be performed by a competent person prior to allowing them to work independently.

Additionally, the rule prohibits the use of passenger vehicle trunks for transportation of cylinders and establishes requirements to perform leak tests prior to each placement of a cylinder into an enclosed vehicle.

It establishes requirements to perform drop tests on cylinders and associated equipment and explains how to perform a drop test for those instances when it is required.

Cylinders in storage and transportation must not be exposed to temperatures of 125°F or greater.

The rule permits employers to follow manufacturer's recommendations when installing reverse flow check valves (back flow) and flashback arrestors (flashback preventers).

Finally, it updates language in the rule to reflect contemporary American Society of Mechanical Engineers (ASME) requirements, Association for Rubber Product Manufacturers (ARPM) requirements, Compressed Gas Association (CGA) requirements, and National Fire Protection Association (NFPA) requirements.

This is Oregon OSHA Administrative Order 6-2014, **adopted October 28, 2014, and effective May 1, 2015.**

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Note: In compliance with the Americans with Disabilities Act (ADA), this publication is available in alternative formats by calling 503-378-3272.

Secretary of State  
Certificate and Order for Filing  
**PERMANENT ADMINISTRATIVE RULES**

I certify that the attached copies\* are true, full and correct copies of the PERMANENT Rule(s) adopted on October 28, 2014 by the  
Date prior to or same as filing date

Department of Consumer & Business Services/Oregon Occupational Safety & Health Division 437  
Agency and Division Administrative Rules Chapter Number

Sue Joye 350 Winter Street NE, Salem OR 97301-3882 503-947-7449  
Rules Coordinator Address Telephone

to become effective May 1, 2015 as Oregon OSHA Administrative Order 6-2014.  
Date upon filing or later

Rulemaking Notice was published in the April 2014 *Oregon Bulletin*.\*\*  
Month and Year

### **RULE CAPTION**

Adopt Oxygen-fuel gas standards in general industry and construction.  
Not more than 15 words that reasonably identifies the subject matter of the agency's intended action.

### **RULEMAKING ACTION**

**ADOPT:** OAR 437-002-2101, 437-002-2253.  
**AMEND:** OAR 437-002-0100, 437-002-0280, 437-002-2102, 437-003-0001.  
**REPEAL:** OAR 437-002-0290, 437-002-0291, 437-002-0292, 437-002-0293, 437-002-0294,  
437-002-0295, 437-002-0296.

**ORS** 654.025(2), 656.726(4)  
Stat. Auth.

**ORS** 654.001 through 654.295  
Stats. Implemented

### **RULE SUMMARY**

Oregon OSHA has adopted OAR 437-002-2253, the Oxygen-Fuel Gas Welding and Cutting Standard for general industry employers and construction employers when welding, cutting, brazing, soldering, and flame coating is performed using a combination of oxygen and a fuel-gas. This rulemaking combines the existing Division 2 and Division 3 Oxygen-Fuel Gas Welding and Cutting rules, making one rule applicable to general industry and construction. Agriculture, Maritime and Forest Activities are not included. For the purpose of rule consistency, Oregon OSHA amended OAR 437-002-2102 Acetylene and repealed 1910.101 Compressed Gases (General Requirements). Oregon OSHA adopted a new rule, OAR 437-002-2101 Compressed Gases (General Requirements) to replace the repealed 1910.101 Compressed Gases (General Requirements).

Twelve related Division 2 rules and a single Division 3 rule were amended, adopted, or repealed in the creation of OAR 437-002-2253.

OAR 437-002-2253 involved in the processes of welding, cutting, brazing, soldering, and thermal coating when using a combination of oxygen and a fuel-gas. It provides definitions for key words and terms relevant to processes covered by the rule. It creates a user friendly format by taking separate rules that had multiple requirements and consolidating them into a single rule with easy to understand sections, sections that can be used as a template for training.

The rule establishes a requirement for the training of employees to be performed by a competent person prior to allowing them to work independently.

Additionally, the rule prohibits the use of passenger vehicle trunks for transportation of cylinders and establishes requirements to perform leak tests prior to each placement of a cylinder into an enclosed vehicle.

It establishes requirements to perform drop tests on cylinders and associated equipment and explains how to perform a drop test for those instances when it is required.

Cylinders in storage must not be exposed to temperatures of 125°F or greater.

Noncombustible barriers used to separate cylinders in storage were addressed. New barrier installations, horizontal and/or vertical measurements, must include an 18-inch protective buffer. Modifications to existing barriers can not degrade the overall barrier's fire resistance rating.

The rule permits employers to follow manufacturer's recommendations when installing reverse flow check valves (back flow) and flashback arrestors (flashback preventers).

Finally, it updates language in the rule to reflect contemporary American Society of Mechanical Engineers (ASME) requirements, Association for Rubber Product Manufacturers (ARPM) requirements, Compressed Gas Association (CGA) requirements, and National Fire Protection Association (NFPA) requirements.

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/s/Michael D. Wood  
Authorized Signer

Michael D. Wood  
Printed name

10/28/2014  
Date

\*With this original, file one photocopy of certificate, one paper copy of rules listed in Rulemaking Actions, and electronic copy of rules.

\*\*The *Oregon Bulletin* is published on the 1st of each month and updates rules found in the OAR Compilation. For publication in Bulletin, rule and notice filings must be submitted by 5:00 pm on the 15th day of the preceding month unless this deadline falls on a weekend or legal holiday, when filings are accepted until 5:00 pm on the preceding workday.  
ARC 930-2005