

SSOW 03: HOT WORKS/WELDING

Issue Number: 06

Date of Issue: 31/01/2026

Based on: RA08

PURPOSE

To ensure all hot works and welding activities are carried out safely and in a controlled manner, preventing fire, explosion, burns, electric shock, exposure to fumes, and harm to personnel or property. This SSOW sets out the safe working practices, equipment standards, and competency requirements needed to manage the significant risks associated with hot works.

PPE REQUIREMENTS

For this activity, the following PPE must be worn



High-vis Vest / Jacket (BS EN 471)



Safety Boots (EN ISO 20345:2011) (S3)



Safety Gloves (EN 12477/407)



Safety Glasses (EN 116:2001) or Safety Goggles (EN 169)



Welding Overalls (EN ISO 11611)



Welding Visor (EN 166)

TRAINING REQUIREMENTS

- Hot Works Training / Permit-to-Work Awareness
- Welding and Cutting Equipment Competency Training
- Fire Safety & Use of Fire Extinguishers
- Manual Handling Awareness
- COSHH Awareness for Welding Fumes and Gases

EQUIPMENT REQUIREMENTS

- Welding Plant (MIG/TIG/Arc) with appropriate leads and earth clamps
- Gas Cylinders with fitted flashback arrestors
- Fire Extinguishers & Fire Blanket
- Welding Screens / Barriers
- Extraction or Local Exhaust Ventilation (LEV) where available
- Hand Tools (grinders, clamps, brushes) inspected and serviceable

SAFE SYSTEM OF WORK

- Avoid hot works where possible by using cold cutting methods.
- Only trained competent persons are permitted to carry out hot work.
- Full PPE must be worn at all times during hot work activities.
- Remove all combustible materials from the work area prior to hot works.
- All gas cylinders to be fitted with flash back arrestors and used in accordance with RA no. 03.
- Inspect all hoses, cylinders, tanks, valves, tools and burning equipment daily prior to use. If any defects are identified STOP and quarantine the item of equipment, report this to your line manager.
- Appropriate Fire-fighting equipment to be in close proximity and serviceable.
- Protect at risk items with fire retardant material where possible or necessary.
- Flame retardant PPE to be worn where appropriate.
- Fire watch to be maintained for at least 1 hour after hot works cease.
- Prior to commencing ensure that the work area is segregated using physical barriers and signage where possible.
- When welding ensure that others are not exposed to UV flash using welding screens available.
- Hot works must be carried out in well-ventilated areas. Use extraction systems where possible.
- DO NOT make adjustments while welding.

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- All welding equipment must be isolated from power sources before being cleaned, adjusted, maintained or repaired. Un-plug when not in use.
- Never leave hot works equipment including welding powered on unattended.
- When using welding equipment, ensure that the machine is correctly set up for current, voltage, wire feed and shielding gas flow rate.
- Ensure the mig welder work cable (earth) makes firm contact to provide good electrical contact.
- Ensure the work piece has been prepared to be free of any paint, oxides or other surface finishes ensuring good electrical contact.

IDENTIFIED RISKS

The SSOW above has been compiled after identifying the following risks from this activity

- Fire or explosion resulting in major injuries, burns or fatalities to personnel and/or damage to plant/vehicles and buildings.
- Asphyxiation from gases.
- Cuts, lacerations, burns.
- Electric shock, flying sparks
- UV radiation
- Toxic fumes

FOR MORE INFORMATION, PLEASE REFER TO RISK ASSESSMENT RA08

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