

# Fuel Safety Bulletin

## 99-04

**Issued:** Oct. 19, 1999

**Rev:** February 9, 2009

**Subject:** Hoses used on propane/oxygen or natural gas/oxygen torches used for welding, cutting and allied processes.

In the past few months, we have had a number of concerns expressed regarding the above noted hoses. Although there has been a large swing toward the use of propane or natural gas for these torches, the suppliers and even the end users continue to treat the systems as if they were still using acetylene. The differences in the gases make this bulletin a necessity.

In the future, the following directives must be followed when dealing with propane/oxygen or natural gas/oxygen torches;

1. All torches used on permanently installed pattern cutting tables (non-portable torches), must use certified Type 1 or Type 2 hose assemblies.
2. All portable torches shall use either certified Type 1 hoses or Grade T hose assemblies constructed to RMA standards, as supplied by various welding suppliers. This allowance of non-certified hoses has come about as the result of considerable research into hose standards and practices in other jurisdictions and in the welding industry. We are also aware of the fact that certified Type 1 hoses do not have the abrasion and heat resistance qualities required by this industry. CSA Standard W117.2-94 (Safety in Welding, Cutting, and Allied Processes) states that only Grade T hose is acceptable for this service. The Acetylene service hoses (Grades R and RM typically) will deteriorate rapidly in propane or natural gas service and must never be used.
3. The field repair of any hose is prohibited. As these are tested hose assemblies, all applicable standards prohibit this practice.
4. Please note that all other restrictions of the CSA B149.1-05 Code apply in spite of this hose deviation. Back check valves required by Code Clause 6.8.5, the 100 foot hose length restriction of Clause 6.20.3(d) and all other applicable Code Clauses still apply.

Should there be any questions regarding these issues, please contact me at our Halifax office. Our phone number here is 424-5721 or 1-800-559-3473. Our Fax number is 902-424-3239.

Sincerely

Dale C. Stewart  
Chief Inspector - Fuel Safety