

	SAF-0002	004	CES
	Welding LNG Powered Vehicles		

Although LNG presents less inherent dangers than other common fuels, standard precautions must be taken when welding LNG powered vehicles. Each site should have existing safety rules and regulations pertaining to welding LNG powered vehicles. The following guidelines should serve as additional direction to already existing safety rules and regulations.

1. Refer to shop instructions for guidance regarding the welding LNG powered vehicles.
2. Test area with a portable flammable gas detector. If possible, continue testing area while welding.
3. Shut off fuel at tanks and run engine until engine stops due loss of fuel.
4. Refer to NexGen Fueling Purge Procedure VT-004 if welding fuel tanks or lines or areas near fuel tanks and lines.
5. Vent fuel tanks to at least minimum engine pressure to prevent an unexpected venting of LNG from occurring.
6. Disconnect all engine, transmission, brake, or body electronics that could be damaged by welding current.
7. Cover tank and related plumbing, including piping to engine, with protective blankets prior to welding to prevent welding sparks or residue from falling on LNG equipment.

Warning:
Always purge any fuel tanks and associated plumbing prior to welding to prevent an uncontrolled venting of flammable gas from occurring.

Warning:
Consult NexGen Fueling prior to welding LNG tanks. Welding could damage tank vacuum insulation and/or void warranty.

Note:
Refer to the 1999 Edition of the NFPA 51B Standard for Fire Prevention During Welding, Cutting, and Other Hot Work for additional safety information.

Only trained and experienced welders should be allowed to weld LNG Gas systems. All station and system safety documents must be reviewed and adhered to when performing this procedure.