

Oil and Gas Industry **Safety Alert 004**

On 08-11-08 at 3: 45 p.m. a welder was attempting to cut a riser on the east tank in the containment at the AC 19-10 SWD when the top of the tank blew off. A Hot Work Permit had been initiated by a contract foreman earlier to do some work on the tank. The immediate area was checked for LEL along with the riser on the tank prior to cutting the riser with a torch. A fire watch had been established and the area was being monitored during the cut on the riser. Once the welder had cut approx ¾ of the circumference of the pipe, an explosion was heard and the top of the tank came off. The tank lid piping was still connected to the tank thus limiting the tank lid from becoming a projectile and damaging the surrounding equipment. The tank had not been isolated from the west tank in the facility and that tank in the facility was still operating at the time of the incident. Neither contractor nor employees had LOTO'd the tank on location that was being worked on. There were no injuries reported and damage was limited to the east tank and piping connected to the tank. The west tank and piping was not damaged in the incident.



Facts and Findings

- No LOTO and isolation of equipment was performed prior to doing Hot Work on the tank.
- XTO Safety Handbook Hot Work procedures identifying the correct protocol for isolation and LOTO prior to Hot Work were not followed.
- The riser was not removed and moved to a safe area to do Hot Work.
- The Hot Work Permit was incomplete.

Recommendations:

- Ensure a thorough walk through prior to job initiation with Representative and Contract Inspector along with contract personnel to identify all isolation necessary and install LOTO on all equipment that is pertinent to the job.
- Follow and implement Hot Work standard as stated in the Safety Handbook to ensure all measures have been taken to prevent incidents.