



Learning Event



MAINTAINING PROCESS EQUIPMENT

HAZARD
Chemical
(flammable)

**Loss of
Containment**

CONSEQUENCES

Actual: No harm to persons
Potential: This could have caused a fatality

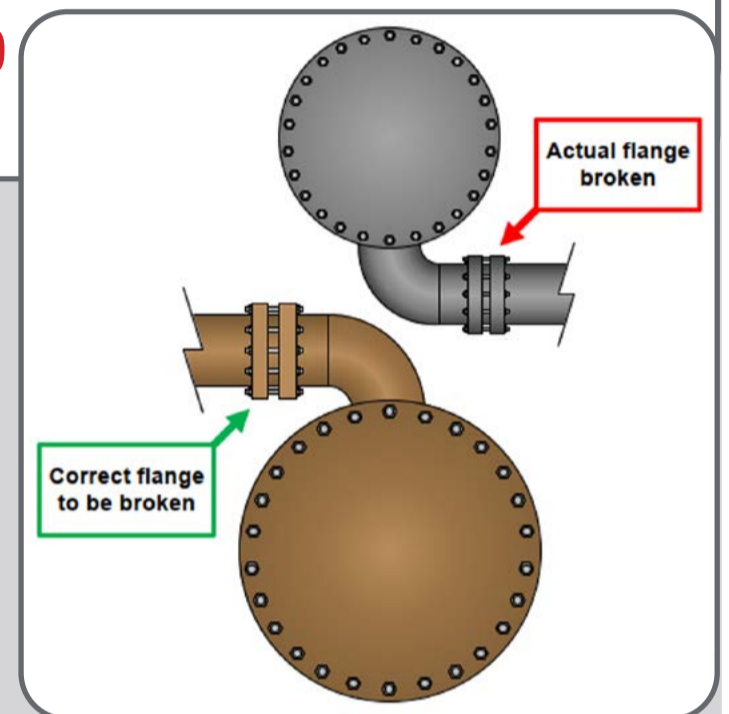
WHAT ARE YOU DOING TO PREVENT INCIDENTS CAUSED BY UNINTENTIONALLY WORKING ON LIVE EQUIPMENT?

What Happened?

A maintenance worker was instructed to reduce bolt a flange join on a heat exchanger shell. This was in the work scope and documented in the work permit.

The worker set up their work area and then commenced work on the wrong heat exchanger shell, which was live.

An operator noticed that work was proceeding on the wrong exchanger shell and instructed the worker to stop.



Why did it Happen?

The worker was unsure about the job scope but did not stop to confirm they were working on the correct flange.

What did they Learn?

- Prior to commencing work read your work permit.
- Confirm that the work permit matches the equipment you will be working on.
- Confirm you have the correct authorisation before commencing work on equipment.
- Ensure equipment is isolated and safe to work on before commencing work.
- If you are unsure of your work scope, use your STOP WORK AUTHORITY.

Process Safety Fundamentals

- ✓ We discuss process safety hazards before starting a task.
- ✓ We use operating and maintenance procedures, even if we are familiar with the task.
- ✓ We pause before key steps and check readiness to progress.
- ✓ We use isolation plans for the specific task, based on up-to-date information.
- ✓ We raise isolation concerns before the task starts and challenge when isolation plans cannot be executed.
- ✓ We check for residual pressure or process material before breaking containment.
- ✓ We use up-to-date documentation (e.g., P&IDs) that accurately reflect installed systems and equipment.
- ✓ We physically confirm the system is ready for the intended activity (e.g., valve positions, line up of relief devices, etc.).
- ✓ We discuss the work plan and what signals would tell us it is proceeding as expected.
- ✓ We pause and ask questions when signals and conditions are not as expected.
- ✓ We stop and alert supervision if the activity is not proceeding as expected.



Ask yourself or your Crew:

- If you are unsure of your work scope, do you pause and ask questions to confirm your understanding before commencing the work?
- Do you always obtain the required authorisations before commencing work? When issued with a permit to work, do you always read the permit requirements to confirm your understanding?
- When working with pressurised equipment, do you always “walk the line” to ensure isolations are in place and verified? Do you check for residual pressure before breaking containment?

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Safety 2023 Campaign



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