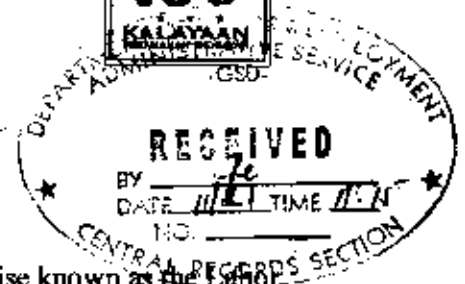




Republic of the Philippines  
**DEPARTMENT OF LABOR AND EMPLOYMENT**  
Intramuros, Manila



**DEPARTMENT ORDER NO. 74-05**  
**Series of 2005**



Pursuant to Article 162 of Presidential Decree No. 442, otherwise known as the Labor Code of the Philippines, as amended, Rule 1162.02 of Rule 1160 on Boiler of the Occupational Safety and Health Standards is hereby amended as follows:

***1162.02 : Inspection and Test of Boilers:***

- 1. The Regional Office concerned through its authorized technical safety inspectors shall conduct inspection, both internally and externally on all boiler parts and appliances on the following phases of work:***

***A. Power Utility Boiler***

- 1. During construction or fabrication, the boiler shall be hydrostatically tested at 1.5 times the design pressure after completion of work;***
- 2. Before being placed into service after completion of installation the boiler shall be hydrostatically tested at 1.5 times the design pressure;***
- 3. Before being placed into service after completion of reconstruction or repair the boiler shall be hydrostatically tested at 1.2 times the maximum allowable working pressure;***
- 4. The test shall be conducted at a minimum water temperature of not less than 21 °C (70 °F) and a maximum temperature not to exceed 71 °C (160 °F); and***
- 5. The conduct of inspection shall coincide with the scheduled plant shutdown for purposes of overhauling/preventive maintenance. Such inspection shall be conducted at an interval not exceeding eighteen (18) months. It shall be the duty of the power plant owner/operator to inform the Regional Office 30 days prior to the scheduled shutdown. Likewise, the Regional Office concerned shall serve Notice of Inspection five (5) days prior to the scheduled plant shutdown. In case of failure of owner/operator to notify DOLE prior to the regular shutdown, the permit to operate shall be suspended.***

***The owner/operator shall have the boiler drained, cooled, opened-up and thoroughly cleaned for the conduct of internal and external***

*inspection on all boiler parts and appliances. If the boiler has not been properly prepared for the inspection or the owner/operator fails to comply with the stated requirements, the technical safety inspector shall decline to make the inspection. Hydrostatic pump shall always be made ready just in case the boiler is to be subjected to a hydrostatic test on conditions specified in 1162:02 (2) A of this Rule.*

*In lieu of hydrostatic test, any of the following non-destructive testing, which is/are applicable shall be conducted and performed periodically but not exceeding 18 months on the boiler head, shell and tubes, by DOLE-Accredited Non-Destructive Testing (NDT) organization:*

- a. radiographic;*
- b. ultrasonic;*
- c. thickness gauging;*
- d. magnetic particle;*
- e. liquid penetrant;*
- f. and/or other equivalent non-destructive test*

#### **B. Industrial Boiler**

- 1. During construction or fabrication, the boiler shall be hydrostatically tested at 1.5 times the design pressure after completion of work;*
- 2. Before being placed into service after completion of installation, the boiler shall be hydrostatically tested at 1.5 times the design pressure;*
- 3. Before being placed into service after completion of reconstruction or repair, the boiler shall be hydrostatically tested at 1.5 times the maximum allowable working pressure;*
- 4. The test shall be conducted at a minimum water temperature of not less than 21 °C (70 °F) and a maximum temperature not to exceed 71 °C (160 °F); and*
- 5. Under proper control and to reach the required test pressure gradually, in no case shall this test pressure be exceeded by more than six percent (6%);*
- 6. During hydrostatic test, the safety valves shall be removed and the valve disc held down by means of testing clamps and not by screwing down the compression screw upon the spring; and*

7. *The Regional Office concerned shall serve the Notice of Inspection for the annual inspection of boiler to the owner/operator thirty (30) days before the expiration of the permit to operate the boiler and at the exact date of scheduled inspection, the owner/operator shall have the boiler drained, cooled, opened-up and thoroughly cleaned for the conduct of internal and external inspection on all boiler parts and appliances. If the boiler has not been properly prepared for the inspection or the owner/operator fails to comply with the stated requirements, the technical safety inspector shall decline to make the inspection. Hydrostatic pump shall always be made ready for the conduct of hydrostatic test.*

2. *The conduct of hydrostatic test on boilers that have been tested as new shall be performed as follows:*

A. *Power Utility Boiler*

*The conduct of hydrostatic test shall be done every five (5) years for power utility boilers unless the existence of the following conditions are noticed during the inspection:*

1. *Deposit and scales on drums, tubes and other pressure parts*
2. *Boiler cracks, broken stays, pitting, corrosion, erosion, scale and thin places in the drum*
3. *Wastage of tube ends*

B. *Industrial Boiler*


*The conduct of hydrostatic test for industrial boiler shall be done at an interval frequency of not more than 12 months.*

3. *Hydrostatic test and non-destructive test shall be conducted in the presence of the technical safety inspector.*
4. *Boilers found unsafe by inspecting authority shall not be allowed to operate and no permit shall be issued until the boiler defect/s is/are corrected and their fittings are in good condition to ensure safe operation. The validity of permit to operate for power utility boiler shall be eighteen (18) months and twelve (12) months or one (1) year for industrial boiler or other boiler from the date of inspection.*

All policy issuances, rules and regulations or part/s thereof inconsistent with any provision of this Order is hereby repealed, modified, superseded or amended accordingly.

The above-mentioned amendments shall take effect fifteen (15) days after announcement of their adoption in two (2) newspapers of general circulation.

Manila, Philippines, on 18th day of November 2005.



PATRICIA A. STO. TOMAS

Secretary



Dept. of Labor & Employment  
Office of the Secretary



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