

1 **Department of Labor and Industry**

2 **Adopted Permanent Rules Relating to Boiler Operators**

3 **5225.1110 BOILER OPERATION STANDARDS; ALL PLANTS.**

4 Subpart 1. **Safe boiler operation.** All boilers, unless specifically exempted by
5 Minnesota Statutes, section 183.56, must be operated, maintained, and attended by an
6 operating engineer in a prudent and attentive manner to avoid endangering human life
7 and property. At a minimum, all operating boilers must be checked by an operating
8 engineer in compliance with this chapter. Specific minimum attendance requirements
9 for hobby boilers are given in part 5225.1140 and specific minimum attendance
10 requirements for high pressure plants are given in part 5225.1180.

11 In determining whether a boiler is operated, maintained, and attended in a prudent
12 and attentive manner, the division and the chief engineer or operating engineer shall
13 consider the recommendations of the American Society of Mechanical Engineers Boiler
14 and Pressure Vessel Code, Section VI, for low pressure and Section VII, for high
15 pressure along with the following additional factors:

- 16 A. the size or capacity of the boiler plant;
- 17 B. the condition of boilers and appurtenances;
- 18 C. the frequency of boiler checks and past maintenance history;
- 19 D. the extent of public occupancy of the building containing the boiler plant;
- 20 E. the operating service conditions, including weather;
- 21 F. compliance with other statutes and rules of this division; and
- 22 G. any other factor which would adversely affect the safety of the boiler.

23 A logbook must be maintained in the boiler room by the chief engineer or an
24 operating engineer designated by the chief engineer. The log shall document when the
25 boiler checks were made, who made the boiler checks, and what specific checks of

1 equipment were made. This log shall be made available to the boiler inspector during
2 inspections and at other times upon request of the boiler inspector.

3 Subp. 2. **Unsafe boiler plant.** If the chief engineer or operating engineer has found
4 the boiler to be in an unsafe condition, the engineer shall notify the owner or employer
5 and the chief boiler inspector as soon as possible. If the unsafe boiler is not immediately
6 taken out of service, the chief engineer or operating engineer shall ensure that the boiler
7 is continuously monitored by an operating engineer, 24 hours per day, until the division
8 has either sealed the object, verified that the unsafe condition has been corrected, or
9 determined that continuous monitoring is no longer required.

10 **5225.1140 ATTENDANCE OF HOBBY BOILERS.**

11 Subpart 1. [See repealer.]

12 Subp. 2. [See repealer.]

13 Subp. 3. **Hobby boiler.** A hobby boiler may not be left unattended when in operation
14 and members of the public are present. For purposes of this part, a traction engine may
15 be considered as not being in operation when all of the following conditions exist:

16 A. the water level is at least one-third of the water gage glass;

17 B. the header or dome valve is in a closed position;

18 C. the draft doors are closed;

19 D. the fire is banked or extinguished; and

20 E. the boiler pressure is at least 20 pounds per square inch below the safety valve
21 relieving pressure.

22 **5225.1180 ATTENDANCE AT HIGH PRESSURE PLANT.**

23 Subpart 1. **Attendance; plant of 0 to 30 horsepower.** At a minimum, a high pressure
24 boiler plant of 0 to 30 horsepower, when in operation, must be checked daily by an
25 operating engineer.

1 **Subp. 2. Attendance; plant of 31 to 200 horsepower.**

2 A. A high pressure boiler plant of 31 to 200 horsepower may be left in operation
3 unattended by an operating engineer for no more than two consecutive hours when the
4 premises are occupied by employees or the public, except as permitted by item B.

5 B. A high pressure boiler plant of 31 to 200 horsepower is exempt from the high
6 pressure attendance requirements of item A, but must be checked at least daily, under
7 the following conditions:

8 (1) the boiler is equipped with dual pressure controls and dual low water fuel
9 cutouts and the boiler does not exceed 15 pounds per square inch operating pressure at
10 any time during the operating engineer's absence;

11 (2) the boiler is equipped with fail-safe type safety controls or valves regulating
12 pressure, temperature, water level, and control supply lines. Fuel control and safety
13 devices must meet at least the minimum requirements for automatically fired boilers in
14 Sections I and IV of the American Society of Mechanical Engineers Boiler and Pressure
15 Vessel Code;

16 (3) the valves and controls must be manually switched over by the operating
17 engineer, the dates and time must be entered in the boiler room log, and the entry must
18 be signed by the operating engineer;

19 (4) the building in which the boiler is located is not occupied by the public or
20 employees except for custodial, maintenance, or security personnel; and

21 (5) the boiler is for supplying steam directly to a low pressure header with
22 header safety valves set at or below 15 pounds per square inch and is of adequate
23 capacity to prevent a pressure rise above 15 pounds per square inch in the system. The
24 shutoff valve between the high and low pressure systems must be electrically
25 interlocked with the low pressure control system so that the crossover valve is in the
26 open position while operating on low pressure.

1 Subp. 3. **Attendance; plant over 200 horsepower.**

2 A. A high pressure boiler plant of more than 200 horsepower, when in operation,
3 requires constant attendance, except as otherwise provided in item B.

4 B. The shift engineer in a high pressure boiler plant of over 200 horsepower may
5 leave the boiler room for up to 30 minutes if all boilers are equipped with dual pressure
6 controls and dual low water fuel cutouts, one of which must be the manual reset type.
7 The shift engineer must stay within 500 feet of the boiler room at all times during the
8 shift.

9 Subp. 4. **Limitations.** The absences described in subparts 2, item A, and 3, item B,
10 may not approach nearly continuous absence from the plant.

11 **5225.2700 REPAIRS BY INSPECTORS PROHIBITED.**

12 Boiler inspectors shall not make any of the repairs they order to boilers.

13 **5225.3100 INSURED COVERAGE REPORT.**

14 Every insurance company insuring a boiler or pressure vessel must notify the
15 division in writing within 30 days of the effective date of coverage (including binders).
16 It must also mail a duplicate of the notification to the assured, who shall, until receipt of
17 exemption certificate, display the notice in a conspicuous place near the boiler or
18 pressure vessel. The person, firm, or corporation operating the insured boiler or
19 pressure vessel shall procure and display an exemption certificate as provided in part
20 5225.3150 within a period of 90 days from the date of coverage, and keep it displayed in
21 a conspicuous place near the boiler or pressure vessel.

22 If the certificate is not displayed within 90 days from date of coverage the boiler
23 inspector from the division shall make the usual and customary inspection of the boiler
24 or pressure vessel and charge the statutory fee.

25 **REPEALER.** Minnesota Rules, part 5225.1140, subparts 1 and 2, are repealed.