

**Foundry Work**

Business Name:		ABN:	
Business Address:			
Contact Person:	Phone:	Email:	

**THIS RISK ASSESSMENT IS APPROVED BY THE PCBU ON THIS PROJECT**

Under the Work Health and Safety Regulation (WHS Regulation), a person conducting a business or undertaking (PCBU) is required to ensure that a RISK ASSESSMENT is prepared before the proposed work starts.

Full Name:		
Signature:	Title:	Date:

**CLIENT OR PRINCIPAL CONTRACTOR DETAILS**

Client:	SCOPE OF WORKS
Project Name:	
Project Address:	
Project Manager:	
Contact Phone:	
Date Risk Assessment supplied to Project Manager:	



RISK MATRIX									
LIKELIHOOD	INSIGNIFICANT	MINOR	MODERATE	MAJOR	CATASTROPHIC	SCORE	ACTION	HIERARCHY OF CONTROLS	
ALMOST CERTAIN	3 HIGH	3 HIGH	4 ACUTE	4 ACUTE	4 ACUTE			<b>Elimination</b> Remove the hazard.	
LIKELY	2 MODERATE	3 HIGH	3 HIGH	4 ACUTE	4 ACUTE	4A ACUTE	DO NOT PROCEED	<b>Substitution</b> Replace the hazard.	
POSSIBLE	1 LOW	2 MODERATE	3 HIGH	4 ACUTE	4 ACUTE	3H HIGH	Review before work starts.	Isolation Isolate People from the hazard	
UNLIKELY	1 LOW	1 LOW	2 MODERATE	3 HIGH	4 ACUTE	2M MODERATE	Ensure control measures in place.	<b>Engineering</b> Isolate the hazard	
RARE	1 LOW	1 LOW	2 MODERATE	3 HIGH	3 HIGH	1L LOW	Monitor and keep records.	Administrative Change PPE	

  

Risk Rating & Required Action:	
<b>4A</b>	Stop work. The risk is intolerable. Eliminate the hazard or redesign the activity before proceeding. A Safe Work Method Statement (SWMS) or higher-level authorisation is required.
<b>3H</b>	Review and approve additional controls before task starts. Senior supervisor sign-off needed.
<b>2M</b>	Ensure all nominated controls are in place and effective. Proceed with caution; monitor conditions.
<b>1L</b>	Proceed, following standard operating procedures. Monitor and keep records.

  

Consequence Scale:			
Consequence	People (injury/illness)	Project / Assets	Compliance / Reputation
<b>Catastrophic</b>	Fatality or permanent total disability	project shutdown	Significant regulator intervention; criminal prosecution
<b>Major</b>	Serious injury/illness (hospital > 5 days)	critical delay	Improvement notice; major media coverage
<b>Moderate</b>	Medical-treatment injury; lost-time > 1 day	moderate delay	Minor breach; adverse client comment
<b>Minor</b>	First-aid only, no lost time	negligible delay	Isolated non-conformance
<b>Insignificant</b>	No injury	no schedule impact	Deviation caught and corrected on site

  

**Notes on Hierarchy of Controls:**  
Remember to apply controls in the preferred order shown by the coloured pyramid:

1. **Eliminate**
2. **Substitute**
3. **Isolate**
4. **Engineering**
5. **Administrative**
6. **PPE**

Always document **why** a lower-order control is accepted if elimination or substitution is not reasonably practicable.

*aligned with Safe Work Australia's Managing the risk of fatigue at work (2023) and ISO 45001:2018 clauses 6–8.*

JOB STEP	POTENTIAL HAZARDS	IR	CONTROL MEASURES	RR
SPECIFIC WORK STEPS	HAZARDS THAT MAY ARISE	INITIAL RISK	SPECIFIC MEASURES TO BE PUT IN PLACE TO ELIMINATE OR CONTROL THE RISKS	RESIDUAL RISK
1. WHS Governance, Legal Compliance and PCBU Due Diligence	<ul style="list-style-type: none"> <li>Inadequate understanding and implementation of WHS Act 2011 and WHS Regulation requirements specific to high-risk foundry and smelting operations</li> <li>Lack of clear WHS governance structure, roles and accountabilities for senior management, supervisors and workers across furnace, casting, fettling and smelting areas</li> <li>Insufficient integration of WHS into business planning, budgeting and procurement decisions (e.g. selection of arc furnace transformers, smelting plant and casting systems driven only by production/cost)</li> <li>Failure to demonstrate officer due diligence (e.g. not acquiring WHS knowledge, not ensuring resources and processes to manage risks, not verifying that systems are implemented)</li> <li>Poor consultation, cooperation and coordination between PCBU (host employer, contractor, maintenance providers, equipment OEMs) working on arc furnace transformers, smelting plants and casting</li> <li>Inadequate WHS objectives, targets and key performance indicators for critical risks such as molten metal handling, lead exposure, arc flash, high voltage equipment and manual handling of moulds</li> <li>Absence of formal process to review and incorporate changes in Australian Standards and Codes of Practice relevant to foundry work (e.g. hazardous chemicals, welding, confined spaces, noise, electrical safety)</li> <li>Inadequate oversight of contractor WHS systems for furnace repairs, transformer work, refractory relining and forging equipment repairs</li> </ul>	High	<ul style="list-style-type: none"> <li>Establish a documented WHS management system aligned with WHS Act 2011, WHS Regulation and ISO 45001, with specific modules for foundry, furnace, casting, smelting and lead operations</li> <li>Define and document WHS roles, responsibilities and accountabilities for officers, managers, supervisors, health and safety representatives (HSRs), maintenance personnel and workers in all foundry areas</li> <li>Implement an officer due diligence framework, including regular WHS legal briefings, site safety walks, verification activities (e.g. audits, inspections, system reviews) and documented follow-up on actions</li> <li>Develop and maintain a WHS legal register identifying applicable Acts, Regulations, Codes of Practice and Australian Standards (e.g. high voltage installations, pressure equipment, hazardous chemicals, noise), and assign responsibility for keeping it current</li> <li>Integrate WHS risk management into strategic and operational planning, including capital approvals for arc furnaces, transformers, smelting plants, ventilation systems and casting equipment upgrades</li> <li>Set measurable WHS performance indicators for critical foundry risks (e.g. molten metal incidents, lead in blood results, near misses on furnace operations, noise-induced hearing loss indicators) and review at management meetings</li> <li>Establish formal consultation arrangements consistent with WHS Act 2011 (e.g. HSR structures, WHS committees, toolbox talks) covering all operational groups including furnace crews, shakeout and fettling teams, casting operators and maintenance staff</li> <li>Implement a contractor management procedure requiring prequalification, review of contractor WHS systems, safe work method statements for high-risk construction work, and coordination meetings before work on transformers, smelters or forging equipment</li> <li>Schedule periodic independent WHS audits of the foundry operations and management systems, with tracking and closure of corrective actions in a central system</li> <li>Ensure PCBU-to-PCBU consultation and documented interface agreements for shared plant, services (e.g. power supply to arc furnaces), and overlapping work areas in smelting and casting operations</li> </ul>	Medium

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2. Risk Management Framework for Foundry and Smelting Operations	<ul style="list-style-type: none"> <li>Inconsistent or informal risk assessment processes for molten metal handling, arc furnace transformer operations, smelting plants and casting lines</li> <li>Risk assessments focusing only on task steps rather than underlying system and management failures (e.g. poor layout, inadequate supervision, lack of engineering controls)</li> <li>Failure to identify and assess cumulative risks from multiple hazards such as heat stress, fumes, noise, manual handling and moving plant in the same area</li> <li>Inadequate consideration of foreseeable abnormal conditions (e.g. furnace run-outs, ladle failure, power loss to smelting plant, refractory failure, mould mis-runs, sand system blockages)</li> <li>No formal process for re-assessing risks when there are changes in equipment, processes or materials (e.g. new alloy, increased lead content) or work organisation (e.g. shift pattern changes)</li> <li>Risk controls chosen primarily on administrative measures and PPE, with limited use of engineering or substitution controls for furnace and casting operations</li> <li>Poor documentation and communication of risk assessments to affected workers, contractors and supervisors</li> </ul>	High	<ul style="list-style-type: none"> <li>Implement a documented risk management procedure consistent with WHS Regulation, requiring formal risk assessments for all critical foundry systems including arc furnace transformers, smelting plant operations, mould and sand systems, shakeout, fettling and lead casting</li> <li>Use structured risk assessment tools (e.g. bow-tie analysis, HAZOP, what-if analysis) for complex systems such as furnace power supply, smelting process controls and molten metal transfer systems</li> <li>Mandate multi-disciplinary participation in risk assessments, including operators, maintenance, engineers, HSE, WHS specialists and management to capture operational knowledge and system issues</li> <li>Ensure risk assessments explicitly consider abnormal and emergency scenarios (e.g. transformer oil leak and fire, furnace over-temperature, ladle failure, mould explosions, smelter off-gas system failure)</li> <li>Implement a management of change (MoC) process requiring risk assessment for any change to plant, processes, layout, materials (including lead alloys) or operating parameters in furnace, casting and smelting areas</li> <li>Adopt a hierarchy-of-controls decision process, with justification required where engineering or elimination/substitution measures are not implemented for high-risk hazards (e.g. molten metal splash, fumes, noise, lead exposure)</li> <li>Maintain a central, version-controlled repository of risk assessments accessible to all relevant personnel and linked to procedures, training plans and inspection regimes</li> <li>Schedule periodic review of risk assessments (e.g. annually or after incidents, near misses or major changes) and document outcomes and control improvements</li> <li>Integrate risk assessment outputs into maintenance plans, capital works programs and layout changes for foundry equipment and smelting plants</li> </ul>	Medium
3. Plant, Equipment and Engineering Controls for Furnaces and Casting Systems	<ul style="list-style-type: none"> <li>Inadequate plant design and guarding for arc furnaces, crucible furnaces, smelting plants, casting lines, shakeout equipment and fettling machinery</li> <li>Failure of molten metal containment systems (ladles, launders, crucibles, moulds) due to poor design, lack of</li> </ul>	High	<ul style="list-style-type: none"> <li>Specify and procure all furnaces, smelting plants, transformers, casting lines, shakeout and fettling equipment to meet relevant Australian Standards and WHS Regulation plant requirements, including documented design risk assessments from suppliers</li> <li>Design and maintain robust molten metal containment systems (e.g. ladle integrity monitoring, double refractory linings, containment pits, emergency run-out channels) with engineering verification and periodic integrity assessment</li> </ul>	Medium

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	<ul style="list-style-type: none"> <li>redundancy or unsuitable materials of construction</li> <li>Insufficient segregation and physical barriers between molten metal transfer paths and pedestrian or vehicle routes</li> <li>Deficient interlocks, emergency stop systems and control system design on furnace and casting equipment</li> <li>Poorly controlled energy sources (electrical, hydraulic, pneumatic, stored energy) associated with high-voltage transformers and furnace drives</li> <li>Inadequate ventilation, local exhaust and fume capture systems for smelting, lead casting and fettling operations</li> <li>Excessive noise and vibration from foundry equipment without engineered noise control</li> <li>Lack of integrated spill containment and fire suppression systems for transformer oil, fuel, molten metal run-outs and flammable materials</li> </ul>		<ul style="list-style-type: none"> <li>Implement physical separation of molten metal routes from pedestrian and vehicle pathways via barriers, dedicated overhead transfer routes, marked exclusion zones and interlocked gates</li> <li>Ensure all critical plant is fitted with appropriate guarding, interlocks, emergency stops and lockable isolation points, and that safety-related control systems are designed and verified to appropriate performance levels (e.g. functional safety standards)</li> <li>Develop engineering standards for foundry plant modifications, requiring design review, formal change control, and verification/validation before returning equipment to service</li> <li>Implement engineered ventilation and local exhaust systems for smelting, lead casting, shakeout and fettling areas, designed by competent engineers and routinely performance-tested (airflow, capture efficiency, filter performance)</li> <li>Install engineered noise controls (e.g. acoustic enclosures, silencers, damping treatments, quiet fans) on high-noise plant and validate effectiveness through scheduled noise surveys</li> <li>Provide secondary containment, bunding and fire suppression/ detection systems for arc furnace transformers, fuel systems and molten metal run-out areas, integrated with emergency shutdown protocols</li> <li>Standardise furnace and casting control interfaces with clear visual indicators, alarms and permissives to prevent unsafe operating states (e.g. tilt inhibit when personnel present in hazard zone)</li> <li>Maintain accurate and current plant schematics, one-line electrical diagrams, and process and instrumentation diagrams (P&amp;IDs) for furnace, smelting and casting systems to support safe operation and maintenance planning</li> </ul>	
4. Maintenance, Inspection and Testing of Foundry and Smelting Plant	<ul style="list-style-type: none"> <li>Unplanned failure of electrical furnace, transformer, smelting or casting equipment due to inadequate preventative maintenance</li> <li>Degradation of crucibles, ladles, refractories and moulding equipment leading to molten metal leaks</li> <li>Out-of-date or incomplete inspection and testing regimes for high-voltage transformers, lifting equipment, hoists and overhead cranes used for molten metal handling</li> <li>Maintenance work conducted without effective isolation, lock-out tag-out (LOTO) and verification of zero energy on furnace and smelting plant</li> <li>Reliance on reactive repairs to forging and foundry equipment instead of systematic condition monitoring</li> </ul>	High	<p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p>	Medium

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	<ul style="list-style-type: none"> <li>Poor quality control of replacement components (e.g. seals, refractories, hoses) not suited for high-temperature or corrosive foundry environments</li> <li>Insufficient maintenance of ventilation, extraction and filtration systems affecting control of fumes, dust and lead</li> </ul>		[REDACTED]	
5. Electrical Safety and Arc Furnace Transformer Management	<ul style="list-style-type: none"> <li>Exposure to high-voltage electrical energy during operation, inspection or maintenance of arc furnace transformers and associated switchgear</li> <li>Arc flash incidents due to inadequate design, labelling, protection settings or work practices around furnace transformers and smelting plant power distribution</li> <li>Transformer oil leakage leading to fire, environmental contamination or slip hazards</li> <li>Inadequate earthing, bonding and protection of furnace, smelting and casting equipment</li> <li>Uncontrolled energisation during commissioning, fault-finding or modifications to electrical systems feeding furnaces and foundry equipment</li> <li>Insufficient competence and authorisation of electrical and instrumentation personnel working on high-risk equipment</li> </ul>	High	[REDACTED]	Medium
6. Hazardous Substances, Fumes and Lead Exposure Management	<ul style="list-style-type: none"> <li>Exposure to metal fumes (including lead, manganese, chromium, nickel) and combustion products from smelting and furnace operations</li> </ul>	High	[REDACTED]	Medium

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	<ul style="list-style-type: none"> <li>• Lead exposure during lead casting tasks, handling of lead-bearing alloys, and cleaning of contaminated equipment and work areas</li> <li>• Respirable crystalline silica exposure from sand casting, shakeout, fettling and cleaning activities</li> <li>• Exposure to chemical binders, resins, fluxes, refractory materials and cleaning agents used in moulding, smelting and crucible maintenance</li> <li>• Inadequate storage, labelling and segregation of hazardous chemicals used in foundry and smelting processes</li> <li>• Insufficient health monitoring for workers exposed to lead, silica and other hazardous substances</li> </ul>		<p>[REDACTED]</p>	
7. Thermal, Molten Metal and Fire/Explosion Risk Management	<ul style="list-style-type: none"> <li>• Molten metal splash, spill out or explosion from furnaces, ladles, crucibles and moulds</li> <li>• Contact burns from hot surfaces, products, tooling, moulds and equipment in furnace and casting areas</li> <li>• Thermal stress and heat exhaustion for workers in proximity to smelting plants, arc furnaces and casting lines</li> <li>• Explosions caused by moisture in moulds, scrap, ladles or crucibles during pouring of molten metal</li> <li>• Fires involving combustible materials, transformer oil, refractories or accumulated dust in foundry and smelting areas</li> </ul>	High	<p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p>	Medium

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			[REDACTED]	
8. Work Organisation, Supervision and Competency Management	<ul style="list-style-type: none"> <li>Inadequate supervision of high-risk activities such as furnace operation, molten metal pouring, lead casting and shakeout/fettling</li> <li>Insufficient training and competency assessment for operators, maintenance staff and contractors on specialised foundry and smelting equipment</li> <li>Over-reliance on informal on-the-job training without standardised procedure or verification of understanding</li> <li>Fatigue and shift work impacts on decision-making, especially for night shifts and extended furnace operations</li> <li>Poor communication and handover between shifts, leading to unrecognised plant issues or process upsets</li> </ul>		[REDACTED]	Medium
9. Procedures, Permits and Safe Systems of Work	<ul style="list-style-type: none"> <li>Critical tasks in furnace operation, molten metal handling, crucible maintenance, sand casting and smelting conducted without clear, current and accessible procedures</li> <li>High-risk non-routine work (e.g. repair of forging equipment, furnace relining, confined space entry, hot work on or near process equipment) performed without formal permit systems</li> </ul>	High	[REDACTED]	Medium

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	<ul style="list-style-type: none"> <li>Workers bypassing or not following procedures due to complexity, lack of practicality or production pressures</li> <li>Inadequate controls on simultaneous operations (SIMOPS), such as maintenance near active furnaces or casting lines</li> </ul>		[REDACTED]	
10. Contractor and Supplier Management for Foundry and Furnace Activities	<ul style="list-style-type: none"> <li>Contractors performing high-risk work (e.g. furnace repairs, transformer maintenance, refractory relining, forging equipment repair) without adequate understanding of site-specific hazards and systems</li> <li>Inconsistent WHS performance and standards between contractors and principal PCBU</li> <li>Poor coordination of concurrent contractor and in-house activities in smelting, casting, shakeout and maintenance areas</li> <li>Suppliers providing equipment, refractories, chemicals or consumables that do not meet safety and performance requirements</li> </ul>	Medium	[REDACTED]	Low
11. Emergency Preparedness and Response for Foundry Operations	<ul style="list-style-type: none"> <li>Uncontrolled response to molten metal run-outs, furnace explosions, smelter upsets or transformer fires</li> <li>Delayed or ineffective response to serious injuries (burns, crush injuries, electrical shock) in casting, shakeout and fettling areas</li> <li>Inadequate planning for release of hazardous substances (fumes, gases,</li> </ul>	High	[REDACTED]	Medium

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	<p>lead contamination, dust) during emergencies</p> <ul style="list-style-type: none"> <li>• Confusion regarding roles, communication channels and decision-making during foundry emergencies</li> </ul>		<p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p>	
12. Monitoring, Reporting, Consultation and Continuous Improvement	<ul style="list-style-type: none"> <li>• Failure to detect deteriorating WHS performance or emerging risks in furnace, casting, smelting and other operations</li> <li>• Under-reporting of incidents, near misses and hazards, particularly related to molten metal, lead exposure and high-voltage equipment</li> <li>• Workers and HSRs not effectively consulted on changes to foundry plant, processes or controls</li> <li>• Lack of systematic review and improvement of WHS systems following incidents, audits or regulatory changes</li> </ul>	Medium	<p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p>	Low

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SAMPLE

**EMERGENCY RESPONSE – CALL 000 FOR EMERGENCIES**

Ensure to have an Emergency Management Plan in place as well as adequate numbers of trained first aid staff with easy access to fully stocked first aid kits, rescue equipment, material safety data sheets, adequate access to emergency communication equipment and fire-fighting equipment suitable for all classes of fire and ignition sources.

**LEGISLATIVE REFERENCES**

RELEVANT LEGISLATION AND CODES OF PRACTICE. DELETE THE LEGISLATIVE REFERENCES FOR ANY STATE THAT ARE NOT APPLICABLE

**Queensland & Australian Capital Territory**

Work Health and Safety Act 2011  
 Work Health and Safety Regulations 2011  
 Legislation QLD: <https://www.worksafe.qld.gov.au/laws-and-compliance/work-health-and-safety-laws>  
 Codes of Practice QLD: <https://www.worksafe.qld.gov.au/laws-and-compliance/codes-of-practice>  
 Legislation ACT: <https://www.worksafe.act.gov.au/laws-and-compliance/acts-and-regulations>  
 Codes of Practice ACT: <https://www.worksafe.act.gov.au/laws-and-compliance/codes-of-practice>

**Victoria**

Occupational Health and Safety Act 2004  
 Occupational Health and Safety Regulations 2017  
 Legislation VIC: <https://www.worksafe.vic.gov.au/occupational-health-and-safety-act-and-regulations>  
 Codes of Practice VIC: <https://www.worksafe.vic.gov.au/compliance-codes-and-codes-practice>

**New South Wales**

Work Health and Safety Act 2011  
 Work Health and Safety Regulations 2025  
 Legislation NSW: <https://www.safework.nsw.gov.au/legal-obligations/legislation>  
 Codes of Practice NSW: <https://www.safework.nsw.gov.au/resource-library/list-codes-of-practice>

**Western Australia**

Work Health and Safety Act 2020  
 Work Health and Safety Regulations 2022  
 Legislation Western Australia: <https://www.commerce.wa.gov.au/worksafe/legislation>  
 Codes of Practice WA: <https://www.commerce.wa.gov.au/worksafe/codes-practice>

**Northern Territory**

Work Health and Safety (National Uniform Legislation) Act 2011  
 Work Health and Safety (National Uniform Legislation) Regulation 2011  
 Legislation NT: <https://worksafe.nt.gov.au/laws-and-compliance/workplace-safety-laws>  
 Codes of Practice NT: <https://worksafe.nt.gov.au/laws-and-compliance/codes-of-practice>

**Safe Work Australia Links**

Law and Regulation (All States): <https://www.safeworkaustralia.gov.au/law-and-regulation>  
 Model Codes of Practice: <https://www.safeworkaustralia.gov.au/resources-publications/model-codes-of-practice>

**South Australia**

Work Health and Safety Act 2012 (SA)  
 Work Health and Safety Regulations 2012 (SA)  
 Legislation for SA: <https://www.safework.sa.gov.au/resources/legislation>  
 Codes of Practice for SA: <https://www.safework.sa.gov.au/workplaces/codes-of-practice#COPs>

**Model Codes of Practice**

- Managing noise and preventing hearing loss at work
- Confined spaces
- Labelling of workplace hazardous chemicals
- Managing risks of hazardous chemicals in the workplace
- Welding processes
- First aid in the workplace
- Managing the risk of falls at workplaces
- Hazardous manual tasks
- Managing the risk of falls in housing construction
- Managing electrical risks in the workplace
- Demolition work
- Excavation work
- Work health and safety consultation, cooperation and coordination
- Managing the work environment and facilities
- How to manage work health and safety risks
- Managing risks of plant in the workplace
- Construction work

**Tasmania**

Work Health and Safety Act 2012  
 Work Health and Safety (Transitional and Consequential Provisions) Act 2012  
 Work Health and Safety Regulations 2012  
 Work Health and Safety (Transitional) Regulations 2012  
 Legislation for TAS: <https://worksafe.tas.gov.au/topics/laws-and-compliance/acts-and-regulations>  
 Codes of Practice for TAS: <https://worksafe.tas.gov.au/topics/laws-and-compliance/codes-of-practice>

Details of permits, licenses or access required by regulatory bodies (add or delete as required):

- Permits from local council
- Authorisation to commence work
- Any required documents.