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*Certification Scheme for Welding and Inspection Personnel*  
**3.1**



Question: 113

The dip transfer or short-circuiting mode of metal transfer used for MIG/MAG welding is characterized by:

- A. Giving deep penetration
- B. Being suitable for positional welding
- C. Giving low spatter
- D. Giving high deposition

Answer: B

Question: 114

Carbon equivalent values (CEV) are used to determine how to avoid the risk of:

- A. Hydrogen cracking
- B. Lamellar tearing
- C. Solidification cracking
- D. Weld decay

Answer: A

Question: 115

Exceeding the maximum interpass temperature specified for a C-Mn steel weld joint may give:

- A. Excessive porosity
- B. Burn through
- C. Lower toughness
- D. Higher strength

Answer: C

Question: 116

Welds made with very high heat input will show a reduction in:

- A. Tensile ductility
- B. Notch toughness
- C. Fatigue strength
- D. Creep resistance

Answer: B

Question: 117

Which of the following would be classed as the most serious type of defect?

- A. A buried linear slag inclusion
- B. Buried lack of inter-run fusion
- C. Surface breaking lack of sidewall fusion
- D. Surface porosity

Answer: C

Question: 118

A transverse tensile test from a Weld Procedure Approval Record (WPAR) test plate is used to measure:

- A. Tensile strength of the weld
- B. Tensile strength of the joint
- C. Stress/strain characteristics of the weld
- D. Stress/strain characteristics of the joint

Answer: B

Question: 119

For gammer radiography of a steel weld at 35mm thickness, the recommended isotope is:

- A. Thulium 170
- B. Ytterbium 169
- C. Iridium 192
- D. Cobalt 60

Answer: C

Question: 220

Which element has the greatest effect on the HAZ hardness of C-Mn steel?

- A. Molybdenum
- B. Chromium
- C. Titanium
- D. Carbon

Answer: D

Question: 221

With reference to the various grades of stainless steels which of the following statements is true?

- A. They are all non-magnetic
- B. They all require 100% Ar for GMAW
- C. They all have very high thermal conductivity
- D. Only certain grades can be used for service at very low temperatures

Answer: D

Question: 222

BS EN 288 and BS EN ISO 15614 are specifications for?

- A. Welder approval testing
- B. Welding equipment calibration

- C. Welding procedure approval
- D. Consumables for submerged arc welding

Answer: C

Question: 223

Repair welding of in-service plant and equipment may be more difficult than making repairs during initial fabrication because:

- A. The material may be contaminated
- B. Access to repair area may be difficult
- C. Positional welding may be needed
- D. All of the above

Answer: D

Question: 224

When MAG welding in dip transfer (a short-circuiting mode) spatter can be reduced by:

- A. Using inductance
- B. Using 100% CO<sub>2</sub>
- C. Using Ar +30% He
- D. Increasing the stick-out length

Answer: A



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