

# **QA/QC WELDING INSPECTOR**

## **(INTERVIEW QUESTIONS & ANSWERS)**

1. Which element could affect the hardness of carbon steel material?

**CARBON**

2. How will you qualify welder for on-plot process piping?

**BY PERFORMANCE TEST (WOT) PER ASME-IX**

3. Write 4 common welding defects in SMAW process?

a) **POROSITY**

b) **SLAG**

c) **LOP**

d) **LOF**

e) **SPATTERS**

f) **ROOT CONCAVITY**

g) **UNDERCUT (ROOT & TOE)**

4. What are the causes of weld defect Porosity?

**Improper baking of Low Hydrogen electrode, inadequate shielding of welding area, improper cleaning of joint surface, inadequate preheating**

5. Why pre-heat is done on some pipes before start welding?

- i. **It slows the cooling rate in the weld metal and base metal, producing a more ductile metallurgical structure with greater resistance to cracking;**
- ii. **The slower cooling rate provides an opportunity for hydrogen that may be present to diffuse out harmlessly, reducing the potential for cracking;**
- iii. **It reduces the shrinkage stresses in the weld and adjacent base metal, which is especially important in highly restrained joints; and**
- iv. **It raises some steels above the temperature at which brittle fracture would occur in fabrication**

6. If welder qualifies on 2G and 5G positions, how many positions he can qualified?

**All positions**

7. Name the 2 types of flux used in SAW \_\_\_\_\_

**Neutral & basic**

8. Which welding process shall be used for all passes for butt welds in piping and set-in fittings less than 2 inch NPS?

**GTAW**

9. DMW means \_\_\_\_\_?

**Dissimilar Metal Weld, such as CS to SS**

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**Ian Pickup**



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