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#Markus Jensen



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Question Excerpt

1. A crack running along the centreline of a weld bead could be caused by:
A. Use of damp flux
B. Lack of preheat
C. Arc voltage too high
D. Weld bead too deep and very narrow
2. When welding this plate distortion can be minimised by:
A. Welding from both sides
B. Using U preparations rather than V types
C. Using stringers
D. Using back-step welding
3. EN ISO 5817 (Level C) specifies that the limit for the diameter (D) of a single pore in a weld is: 0.50.2t, but max. 4mm where t=material thickness. For which of the following situations is the pore acceptable?
A. t=20mm, measured pore diameter = 5mm
B. t=15mm, measured pore diameter = 4.5mm
C. t=10mm, measured pore diameter = 3mm
D. t=10mm, measured pore diameter = 1.5mm
4. Typical temperature used for normalising a C-Mn steel plate are:
A. 400-450°C
B. 1000-1100°C
C. 700-800°C
D. 880-920°C
5. The use of low carbon austenitic stainless steels and stabiliser stainless steels will minimise the risk of:
A. HAZ cracking
B. Weld decay
C. Weld metal cracking
D. Distortion
6. Transfer of material identification by hand stamping is sometimes not allowed for high integrity applications because it:
A. Is too slow
B. Can be a safety hazard
C. May damage the material
D. Causes problems with coating operations.
7. Which of the following is associated with SAW more often than it is with MMA welds?
A. Hydrogen cracking in the HAZ
B. Solidification cracking in the weld metal
C. Reheat cracking during PWHT
D. Lamellar tearing
8. A C-Mn steel is being welded by MMA and the electrode run-out lengths that have been used are much shorter than specified by the WPS. This deviation may give:
A. Increased risk of hydrogen cracking
B. Increased risk of solidification cracking
C. Lower values of HAZ toughness
D. Higher values of HAZ hardness

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