



30. how much root face size allowed?  $\rightarrow$  0.6 to 1.6mm (or) As per WPS.

31. what is string bead and what is weave bead?  $\rightarrow$  No side to side motion. (stringer)

32. how much weave bead allowed?  $\rightarrow$  3 Side to side motion (laterally)

33. why we are using P no?  $\rightarrow$  Electrode thickness of electrode (or) As per WPS.

34. what is F no?  $\rightarrow$  Base metal groups

35. what is A no?  $\rightarrow$  Filler metal grouping

36. how we approve the WPS?  $\rightarrow$  Electrode chemical composition. The weld must satisfy chemical, mechanical, physical properties

37. what is the parameters required to prepare a WPS?  $\rightarrow$   $\phi$  of pipe, welding position, average no. of runs.

38. In 8 mm thickness pipe what is the reinforcement allowed?

39. How much size undercut is allowed in piping?  $\rightarrow$  0.8mm

40. What is SAES, SAEP, SAMSS?  $\rightarrow$  Saudi Aramco Engineering Standards, Saudi Aramco Engineering Procedures, Saudi Aramco material system specifications

41. What Aramco standard for Welding of piping?  $\rightarrow$  SAES - W - 011

42. What is on-plot piping, off-plot piping?

43. A pipe made of which specifications?  $\rightarrow$  API, SL (or) ASTM.

44. why using PWHT?  $\rightarrow$  To relieve internal stresses

45. Which hardness method is acceptable in procedure qualification?  $\rightarrow$  Vickers (P/QC) Brinell's hardness test

46. what are the mechanical tests for qualifying a PQR?  $\rightarrow$  Tensile, Bend, Charpy

47. how we qualify a welder?  $\rightarrow$  Test on a radiography

48. why we are using pre heating?  $\rightarrow$  To remove H<sub>2</sub>O, moisture, reduce the cooling rate

49. when and where we check the interpass temperature?  $\rightarrow$  immediately after completion of run (position) than 25mm from the W

50. what is the responsibility of a welding Inspector?  $\rightarrow$  To ensure code compliance, workmanship control, documentation control

51. what is the tools required for a welding Inspector?  $\rightarrow$  HT, low gauge, torch.

52. what is the common defects can find in RT and UT?  $\rightarrow$  Cracks, porosity

53. How to select MPI or DPT?  $\rightarrow$  DPT is for exclusively surface defects, MPI is for surface

54. How much % of RT required in piping?  $\rightarrow$  100% (or) 100%

55. How we will pre heat?  $\rightarrow$  fire flame, Electrical coil

56. How much area required pre heating?  $\rightarrow$  75mm min from both sides of joint

57. After Visual inspection what is our responsibility?  $\rightarrow$  Record the defects and compare with EN code. observed per run

58. If a joint root incomplete fusion what you will do?  $\rightarrow$  cut & rework.

59. if any Arc strike on base metal what you will do?  $\rightarrow$  Grind and check with D-S for any surface cracks.

60. If any forged fittings cut and re beveled what you will do?  $\rightarrow$  to be MPI

red on P.D.R. for quality up

APROVES TOOLS + etc Bend 70% MPI 100% 50HT 100% 100%

Defect on the metal ferric content