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### Question: 32

What is the minimum holding time of SA-106 Grade B, 1 inch thick material?

- A. 2.4 hours
- B. 2 hours
- C. 1 hour
- D. not specified

**Answer: C**

### Question: 33

What is the working pressure of a 150 lb. flange, SA 350 Gr.LF6 CL 1, used at 400°F?

- A. 230 psig
- B. 200 psig
- C. 170 psig
- D. 140 psig

**Answer: B**

### Question: 34

What is the minimum class flange that can be used if the material is SA 351 Gr.C F8C, temperature 950°F and working pressure is 1930 psig

- A. 800
- B. 900
- C. 1500
- D. This material can not be used at this temperature

**Answer: C**

### Question: 35

The preheat zone shall extend beyond each edge of a pipe weld

- A. 1"
- B. 2"
- C. 2T
- D. 3T

**Answer: A**

### Question: 36

What is the root face limitation as listed on the attached WPS and PQR

- A. 3/32"
- B. 1/8"

- C. No limit
- D. Not designated

**Answer: D**

**Question: 37**

If the supporting PQR is used, are the P-noâs correct on the attached WPS?

- A. Yes
- B. No
- C. Could be if properly preheated
- D. Not enough information

**Answer: B**

**Question: 38**

Is the thickness range on the WPS supported by the PQR?

- A. Yes
- B. No
- C. Re qualification is required by API 570
- D. Re qualification is required by ASME Section V

**Answer: B**

**Question: 39**

Is the attached PQR properly qualified?

- A. No, because RT is not allowed during PQR qualification
- B. No, because there are not enough tensile tests
- C. No, because peening is allowed by ASME B31.3
- D. Yes

**Answer: B**

**Question: 40**

What should have been the correct number and type of guide bends on the PQR?

- A. 6 side bends
- B. 2 face and 2 root bends
- C. 1 side, 1 face and 1 root bend
- D. No side bends required

**Answer: D**

**Question: 41**

According to API 570, a(n) is a person who assists the inspector by performing specific NDE testing.

- A. NDE technician
- B. Inspector assistant
- C. Level II inspector
- D. Examiner

**Answer: D**

**Question: 42**

More than one contractor, manufacturer or installer may simultaneously qualify a welder. In such case, each participating organization shall be represented by during the test.

- A. A certified welding inspector
- B. A responsible employee
- C. The welder's supervisor
- D. A welding engineer

**Answer: B**

**Question: 43**

Which of the following best describes API 574?

- A. code
- B. Standard
- C. specification
- D. Recommended practice

**Answer: D**

**Question: 44**

The potential for personnel exposure is deemed to be significant in which fluid service?

- A. Category M fluid service
- B. High pressure fluid service
- C. Normal fluid service
- D. Category B fluid service

**Answer: A**

**Question: 45**

When an injection point circuit for the purpose of inspection is designated, the recommended up stream limit of the injection point circuit shall be the greater of ?

- A. minimum 12 inches
- B. maximum 12 inches
- C. three pipe diameters
- D. both A and C

**Answer: D**

**Question: 46**

can cause flame detectors used to indicate a furnace or boiler fire to give false indications on control panels.

- A. Welding or related repairs on piping
- B. Piping alterations in the shop
- C. Ultrasonic inspection
- D. Radiographic inspection

**Answer: D**

**Question: 47**

After application of a non destructive evaluation technique, any resulting evidence is commonly referred to as

- A. A crack
- B. porosity
- C. a leak
- D. an indication

**Answer: D**

**Question: 48**

API 570 applies to piping systems for process fluids such as:

- A. Firewater
- B. Plumbing, sanitary sewers and storm sewers
- C. Raw, intermediate, and finished products.
- D. Piping systems on trucks, ships and barges

**Answer: C**

**Question: 49**

Which of the following applies to socket welds in piping systems?

- A. Should be avoided
- B. Should be used in all welded piping
- C. Should be welded using SAW only
- D. Should be avoided where crevice corrosion may occur

**Answer: D**

**Question: 50**

Each piece of magnetizing equipment shall be calibrated

- A. at the beginning of each shift
- B. at least once a year or whenever the equipment has been subject to major electrical repair

- C. whenever the technician feels like it
- D. at least once every 90 days

**Answer: B**

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