Practice quiz: AWS CWI - Part C Code Application and Endorsement (API 1104)

10 questions. The answer key is on page 2.

Name _____ Date _____

1. **A question asks what extra controls apply to welding on a pipeline that is carrying product. Where do you look?**
   A. The section on repair and removal of defects
   B. The scope at the front of the book
   C. The annex on in-service welding
   D. The acceptance standards for NDT

2. **Which API 1104 section tells you whether an imperfection found on a radiograph is acceptable?**
   A. Acceptance standards for NDT
   B. Procedures for NDT
   C. Inspection and testing of production welds
   D. Qualification of welders

3. **Electrodes for a spread have been rained on and their coating is damp. What does the standard expect?**
   A. Use them on the cap pass only
   B. Dry them on the warm pipe and then use them
   C. Use them if the preheat is raised a little
   D. Set them aside and do not use them

4. **Pipe ends arrive on the right-of-way with a damaged bevel. What should be done before welding the joint?**
   A. Weld it as is and fill the damage with extra passes
   B. Repair or re-prepare the bevel to the procedure's joint design
   C. Weld it as is and radiograph it twice
   D. Rotate the pipe so the damage sits at the bottom of the joint

5. **A defect has been ground out of a girth weld for repair. What should be confirmed before rewelding starts?**
   A. That a different welder will make the repair
   B. That the defect has been fully removed
   C. That the radiograph of the defect has been filed
   D. That the line has been pressure tested

6. **Under which procedure must repair welds on a girth weld be made?**
   A. Any procedure the repair welder has used before
   B. The production procedure, with the welding current raised a little
   C. No written procedure, if the repair is short
   D. A repair procedure qualified as the standard requires

7. **A repair was made to a defect first found by ultrasonic testing. Which reinspection of the repaired area is the minimum?**
   A. Ultrasonic testing, the method that found it
   B. Visual inspection only, once the cap is ground
   C. Penetrant testing of the cap surface
   D. No testing, if the repair welder is qualified

8. **Why is welding on a pipeline in service riskier than welding new pipe?**
   A. Pipe in service is always thicker than new pipe
   B. Filler metal cannot be added to a line in service
   C. Burn-through risk, and fast cooling from the flowing product
   D. Radiography cannot be used once a line is pressurized

9. **Where does API 1104 put the procedure and operator rules for mechanized welding with filler metal additions?**
   A. In the manual welder qualification section only
   B. In the acceptance standards for NDT
   C. Nowhere, since mechanized welding is outside the standard
   D. In their own section, apart from the manual rules

10. **On what basis are pipe and fitting materials mainly grouped when a welding procedure is qualified?**
    A. Pipe outside diameter, whatever the grade
    B. Specified minimum yield strength
    C. Nominal wall thickness, whatever the grade
    D. The type of external coating applied

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Answer key

AWS CWI - Part C Code Application and Endorsement (API 1104). One line of why for each answer.

1. **C** Welding on a line that is carrying product has its own annex, which covers how procedures and welders are qualified for it.
2. **A** Acceptance standards for NDT set the limits for each imperfection.
3. **D** Damp or damaged filler metal is not used for production welding.
4. **B** Joint design is part of the procedure, so pipe ends must match it before welding starts.
5. **B** Rewelding over part of a defect leaves it in the weld, so removal is confirmed first.
6. **D** Repairs are welded to a qualified repair procedure.
7. **A** A repaired area is reinspected at least by the method that found the defect, because that method can see that kind of defect.
8. **C** On a line carrying product, the arc can burn through the wall, and the flowing product cools the weld fast enough to raise the risk of hydrogen cracking.
9. **D** Mechanized welding with filler metal additions has its own section with its own procedure and operator rules.
10. **B** Base materials are grouped mainly by specified minimum yield strength, since strength drives the procedure's needs.

Full explanations

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