

Question Answers on Welding for CSWIP 3.1 and AWS CWI

Q1) When considering the MIG/MAG welding process which of the following metal transfer modes would be the most suited to the welding of thick plates over 25mm, flat welding position?

1. Dip transfer
2. Pulse transfer
3. **Spray transfer**
4. Globular transfer

(Explanation: Spray transfer is often preferred for welding thick plates in the **flat** position due to its high deposition rates, good penetration, and overall efficiency. While pulsed transfer can also be effective, spray transfer is a common choice for thicker materials in **flat** welding positions.)

Q2) Poor penetration would be found in MIG/MAG welded steels when using:

1. Argon + 20 % CO₂
2. CO₂
3. **Pure Argon**
4. Argon + 5 % CO₂

(Explanation: Pure Argon tends to produce a wider, shallower penetration profile, and in certain applications, it may result in poor penetration. The addition of CO₂ helps improve the welding process by providing better arc stability and deeper penetration.)

Q3) In the TIG welding process, slope-in/slope-out capability is useful in order to:

1. **Avoid start porosity and crater pipes**
2. Reduce the risk of tungsten inclusions
3. Stabilise the arc
4. Allow more time for the filler metal to melt

(Explanation: In TIG welding, slope-in and slope-out capability, also known as "amperage ramping" or "current up/down slope," is useful to avoid start porosity and crater pipes. **Slope-in helps gradually increase the welding current** at the start of the weld to avoid porosity, and **slope-out gradually decreases the current** at the end to prevent the formation of crater pipes. This feature helps in achieving smoother and more controlled starts and stops in the welding process.)

Q4) Which defect is NOT normally associated with TIG?

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Sebastian Brünink



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