

# 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 % CO<sub>2</sub>
2. CO<sub>2</sub>
3. **Pure Argon**
4. Argon + 5 % CO<sub>2</sub>

**(Explanation:** Pure Argon tends to produce a wider, shallower penetration profile, and in certain applications, it may result in poor penetration. The addition of CO<sub>2</sub> 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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