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Question: 1622

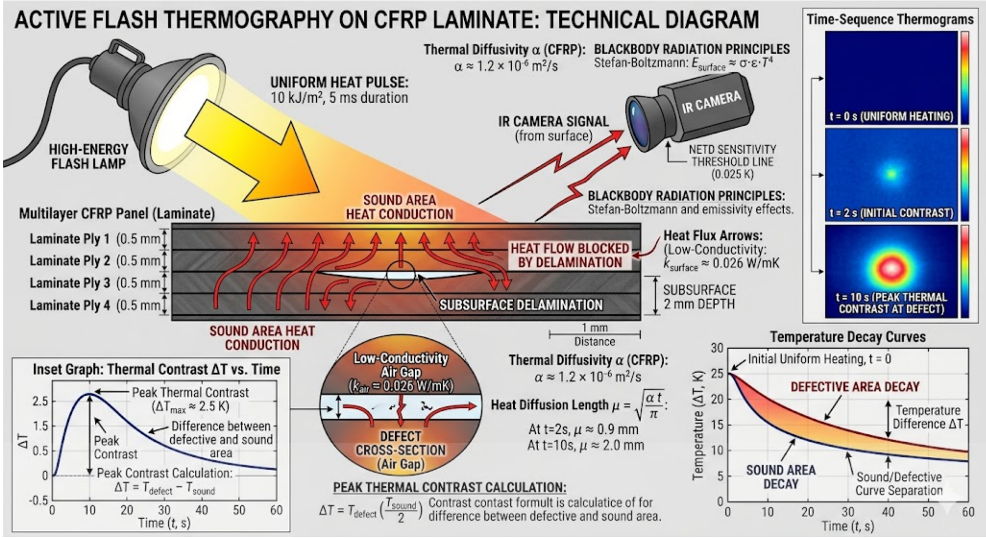
API 653 4.3.3 random pitting density 18 pits/m^2 >15/m^2 limit, individual <30% t_min. Engineering evaluation per 4.4 permits?

A. Mandatory repair density
B. Coating only
C. Reject all random pitting
D. Accept with corrosion rate eval

Answer: D
Explanation: API 653 4.4 allows engineering evaluation for random pitting exceeding density limits if individual depths <30% t_min and corrosion rates projected acceptable. 18/m^2 density warrants evaluation rather than automatic rejection.

Question: 1623

During active thermography inspection of a carbon fiber reinforced polymer (CFRP) aerospace panel for subsurface delaminations, a high-energy flash lamp delivers a short heat pulse, creating transient heat flow into the material. The infrared camera records the surface cooling phase, where defects disrupt conductive heat transfer, producing measurable thermal contrast over time. The material has a known thermal diffusivity of 5×10^{-7} m^2/s, and the camera exhibits an NETD of 25 mK.



In this scenario, the observed peak thermal contrast at the defect occurs later than predicted by simple one-dimensional heat conduction models. What is the most likely reason for the delayed and reduced contrast, considering heat transfer principles?

A. Thermal diffusivity variations across plies combined with three-dimensional heat spreading around the defect edges, reducing the effective heat flux differential at the surface

B. Passive thermography interference from ambient convection dominating over the active pulse

C. Blackbody radiation assumption overestimating the initial surface temperature rise independent of material properties

D. High emissivity of the CFRP surface causing excessive radiative heat loss before diffusion reaches the defect

Answer: A

Explanation: In active thermography, the heat pulse induces transient conduction governed by the heat equation, where thermal diffusivity α determines the speed of temperature propagation (characteristic diffusion time scales with depth²/α). Subsurface defects like delaminations impede heat flow, creating a surface temperature anomaly (thermal contrast ΔT). However, in real anisotropic composites with finite defect sizes, lateral (in-plane) heat diffusion and three-dimensional spreading around defect boundaries blur the contrast and delay its peak appearance compared to ideal 1D models. This effect is more pronounced with higher thermal diffusivity or deeper defects, requiring advanced processing (e.g., TSR or PPT) to enhance detectability while accounting for the finite heat flux and material inhomogeneities.

Question: 1624

Replication on a P91 steel superheater tube after 80,000 hours at 570°C shows aligned creep voids (Neubauer Stage 3) in the intercritical HAZ of a girth weld. Wall thinning is 0.6 mm from steam-side oxidation. Hoop stress 75 MPa. Using Monkman-Grant relation for remaining life estimation, classify damage and recommend action.

A. Service-induced Type IV creep cracking in softened HAZ; replace tube segment as damage indicates advanced life consumption.
B. Inherent weld inclusion; monitor annually.
C. Erosion from steam flow; increase chromium content.
D. Processing hydrogen cracking from welding; re-PWHT.

Answer: A
Explanation: Creep in CSEF steels like P91 concentrates in the intercritical HAZ (Type IV zone) due to microstructural degradation from welding thermal cycles and long-term exposure, leading to void nucleation, alignment, and linkage under stress. Neubauer Stage 3 with oriented voids signals tertiary creep where rupture is imminent. The Monkman-Grant correlation links creep rate to time-to-rupture, confirming high life fraction consumed. Oxidation contributes to section loss, further elevating stress. Replacement of affected segments with proper PWHT is required, as in-situ repairs cannot fully restore creep strength in this weakened zone.

Question: 1625

When using Iridium-192 to inspect a 0.5-inch thick steel pipe, the Level III notices the radiographs have very poor contrast. The U_g is well within limits. What is the technical reason for the poor contrast?

A. The focal spot of the Iridium source is too small for the pipe diameter.
B. Iridium-192 has too much activity for thin materials.
C. The average energy of Iridium-192 (approx. 454 keV) is too high for optimal subject contrast in thin steel.
D. The technicians likely used lead screens that were too thin (0.005 inches).

Answer: C
Explanation: Subject contrast is highly dependent on the energy of the radiation. For thin steel (< 1 inch), X-rays (typically $150 - 250$ kV) provide much better contrast than Gamma rays. Iridium-192's high energy results in less differential absorption between the base metal and defects/thickness changes, leading to a "washed out" appearance in thin sections.

Question: 1626

During review of a production radiograph for a 38 mm thick carbon steel pressure vessel weld per ASME Section V, the Level III observes that the 2-2T hole-type IQI (ASTM E1025) placed on the source side is visible, but the 1T hole is not discernible in the area of interest despite adequate density. The technique used Ir-192 with SFD of 600 mm. What practical judgment must the Level III make regarding technique qualification and acceptance?

A. Switch to wire-type IQI per ASTM E747 for better resolution assessment

B. Reject and requalify the technique with a finer IQI or adjusted parameters because the 1T hole visibility indicates insufficient contrast sensitivity for critical weld evaluation
C. Increase exposure time to raise density and improve hole visibility without changing IQI
D. Accept the radiograph as the 2T hole meets basic sensitivity requirements for most code applications

Answer: B
Explanation: Hole-type IQIs per ASTM E1025 assess contrast sensitivity through visibility of designated holes (1T, 2T, 4T). For many high-quality levels in codes like ASME Section V Article 2, visibility of the 2T hole corresponds to approximately 2% sensitivity, but failure to see the 1T hole on a properly placed IQI signals marginal or insufficient technique performance for defect detection in critical applications. The Level III must interpret this as a need for requalification, potentially involving higher contrast (lower kV equivalent or better screens), optimized geometry, or verification that the required equivalent sensitivity is achieved. This decision ensures radiographic techniques provide reliable detection capability rather than borderline compliance, preventing missed indications like fine cracks or lack of fusion.

Question: 1627

A GR&R study for phased array UT crack length measurement gives %GR&R = 22% of tolerance. Repeatability = 9%, reproducibility = 19%. For fracture mechanics input requiring length uncertainty < 15% of tolerance, decide on system approval.

A. Approve the system as total GR&R is below 30%
B. The tolerance is too tight; relax the requirement
C. Use only repeatability data for the uncertainty budget
D. Reproducibility must be reduced through calibration standardization and operator training; re-perform GR&R after improvements to confirm total variation meets the 15% limit

Answer: D
Explanation: GR&R exceeding the required limit, driven by reproducibility, indicates the measurement system is not yet suitable for precise fracture mechanics applications. The Level III must drive improvements to reproducibility for reliable, low-uncertainty crack length data in practical structural assessments.

Question: 1628

Coil method for circular magnetization of a 6-inch OD tube (50000 AT effective) shows uniform inner diameter sensitivity but weak outer wall indications for OD longitudinal seams. Per Ampere's law $\oint H \cdot dl = NI$, what causes this?

A. H inversely proportional to radius

B. Low part permeability
C. Tube wall thickness saturation
D. Coil positioning error

Answer: A

Explanation: Circular field $H = NI / (2\pi r)$ decreases with radius r, yielding higher flux density $B=\mu H$ at smaller inner radii; outer surfaces require higher AT or central conductor adjustment for equivalent leakage detection sensitivity.

Question: 1629

In Phased Array technology, "Beam Apodization" is a technique used to:

A. Reduce the amplitude of side lobes by varying the voltage applied to individual elements.
B. Increase the PRF to allow for higher scanning speeds.
C. Calibrate the wedge delay for each element in the focal law.
D. Increase the maximum steering angle of the array.

Answer: A

Explanation: Apodization is the process of weighting the amplitude of the excitation (or the gain on reception) for each element in the active aperture. By applying higher energy to the center elements and tapering it toward the edges, the "Side Lobes" (unwanted energy peaks outside the main beam) are significantly suppressed. This improves the signal-to-noise ratio and image clarity, although it slightly widens the main beam width.

Question: 1630

Passive thermography of circuit board identifies failing capacitor via emissivity $\varepsilon=0.82$ surface $\Delta T=6.3$°C above ambient. Adjacent $\varepsilon=0.95$ resistor shows $\Delta T=4.1$°C same power dissipation. Judgment for root cause thermal contrast analysis?

A. Higher thermal diffusivity component
B. Radiation view factor difference
C. Emissivity correction required
D. Convective cooling coefficient variation

Answer: C

Explanation: Apparent ΔT □1/ε requires correction L_corrected=εL_apparent + (1-ε)L_reflect for true surface temperature comparison; diffusivity affects transient response while convection/radiation secondary in electronics packaging thermography.

Question: 1631

During metallurgical evaluation of a failed low-alloy steel bolt from a high-temperature flange joint (service at 450°C, 5000 hours), fractography shows intergranular facets with creep voids, while the bulk microstructure exhibits tempered martensite with coarse carbides. The bolt was manufactured from bar stock via machining and heat treated to 900 MPa tensile strength. Charpy impact energy dropped from 80 J as-received to 15 J post-service. As Level III, link the damage mechanism to manufacturing or service factors and recommend preventive measures for similar components.

A. Inherent decarburization from bar stock; accept if future bolts use normalized material.
B. Fatigue from vibration; add damping washers.
C. Service-induced creep damage accelerated by residual stresses from machining; implement creep-resistant alloy upgrade and stress relief.
D. Manufacturing defect from improper tempering leading to temper embrittlement; require stricter QC on heat treatment records.

Answer: C
Explanation: Creep in low-alloy steels at 450°C involves diffusion-controlled void formation and linkage along grain boundaries, exacerbated by any residual tensile stresses from machining or inadequate post-weld/heat treatment stress relief. The transition from ductile to intergranular fracture with void coalescence, plus loss of toughness (Charpy drop), confirms service-induced degradation rather than a static manufacturing issue. Tempered martensite with carbide coarsening is consistent with prolonged thermal exposure. Preventive actions include selecting alloys with higher creep rupture strength (e.g., modified 9Cr-1Mo), applying post-fabrication stress relief, and establishing time-temperature based inspection intervals using replication or advanced UT for void detection.

Question: 1632

Signal attenuation dispersion $\alpha(f)=\alpha_0(f/f_0)^n$ with $n=1.2$ measured through 1.8m steel beam requires what high-frequency content correction for source rise time analysis?

A. f^n amplitude restoration
B. Time-domain equalization
C. Bandwidth limiting filter
D. Peak amplitude only

Answer: A
Explanation: Frequency-dependent attenuation correction $A(f)=A_{meas}(f)\times\exp(\alpha R f^n)$ restores source spectrum; time-domain distorts causality per quantitative AE fracture parameter extraction procedures.

Question: 1633

API 579 Part 6 local thin area assessment LTA length 280 mm, width 85 mm, depth 4.5 mm in 16 mm pipe. Level 2 FS=3.2 >2.4 min. API 570 LTA acceptance?

A. Service with monitoring
B. Repair LTA immediately
C. Length criterion only
D. Width exceeds limit

Answer: A
Explanation: API 579 Part 6 Level 2 local thin area assessment accepts when FS > minimum (2.4). Compliant FS=3.2 authorizes service continuation with defined inspection intervals for LTA growth monitoring.

Question: 1634

An X-ray exposure is made at 200 kVp with a density of 2.0. If the voltage is increased to 230 kVp and all other factors remain constant, the resulting density will:

A. Decrease, because the higher energy photons pass through the film without interacting
B. Stay the same, because kVp only affects contrast, not density
C. Increase, because the beam is more penetrating and more photons reach the film
D. Increase, but only if lead screens are removed

Answer: C
Explanation: Increasing kVp increases both the number of photons (intensity) and their energy (penetrating power). More photons will penetrate the material and reach the film, and the film is generally sensitive to this increased flux, resulting in a higher optical density. This is why kVp is often used to adjust exposure in addition to time and milliamperage.

Question: 1635

What is the relationship between the "Photoelectric Effect" and the atomic number (z) of the material being inspected?

A. The probability of interaction increases linearly with z.
B. The probability of interaction is inversely proportional to z.
C. The probability of interaction is proportional to approximately z^3 or z^4.

D. The probability of interaction is independent of z.

Answer: C
Explanation: The photoelectric effect is highly dependent on the atomic number. This is why materials like Lead ($Z = 82$) are so much more effective at absorbing low-to-medium energy X-rays than Aluminum ($Z = 13$). This massive z-dependence is also what creates high subject contrast in medical and industrial radiography at lower energies.

Question: 1636

A straight beam UT inspection of 50 mm thick carbon steel plate using 5 MHz, 10 mm diameter probe reveals back reflection at 80% FSH after 100 mm water path calibration. Plate attenuation measured 0.8 dB/inch. Calculate near field length N and determine if probe in near field at 25 mm depth.

A. N = 21 mm; near field inspection
B. N = 84 mm; far field inspection
C. N = 168 mm; far field inspection
D. N = 42 mm; near field inspection

Answer: B
Explanation: Near field length $N = \frac{D^2 f}{4v}$ where D=10 mm, f=5 MHz, v=5900 m/s yields N=84 mm. 25 mm depth places inspection in near field where amplitude varies maximally due to interference patterns, requiring full skip scanning per ASME Section V T-421. Far field assumption incorrect as distance < N; smaller N values miscalculate diameter or velocity.

Question: 1637

Temperature compensated couplant 200°C service: viscosity increases 40% reducing T=82%→71%. Procedure minimum T=75%. Ultrasonic coupling verification method?

A. Transmission coefficient calculation
B. Backwall echo comparison
C. All above required
D. Monitor entry reflection hourly

Answer: C
Explanation: Comprehensive verification monitors entry reflection degradation, calculates T from Z ratio, and compares backwall amplitude per ASTM D907 high-temp protocol ensuring consistent sensitivity.

Question: 1638

A visual testing procedure per ASME Section V Article 9 for final weld inspection specifies 500 lux illumination and use of 10X magnification for questionable areas. The acceptance criteria reference ASME Section VIII for surface discontinuities. During demonstration, some undercut is missed under the specified lighting. Determine the required revision.

A. Reduce acceptance limits.
B. Increase magnification requirement.
C. Add remote visual aids only.
D. Revise illumination to the minimum required by Article 9 (typically 1000 lux or as qualified) and ensure the procedure verifies lighting at the surface with a calibrated meter to achieve reliable detection.

Answer: D
Explanation: ASME Section V Article 9 requires sufficient illumination (often a minimum of 1000 lux or demonstrated equivalent) at the examination surface for adequate visual acuity and detection of discontinuities. The procedure must include verification methods. The Level III must adjust the illumination specification and add verification steps to ensure the procedure supports consistent performance.

Question: 1639

Pressure decay test automotive evaporator coil ($V=0.8$ liters) at 100 psig shows $\Delta P=2.5$ psi/5 minutes equating to $L=4.1\times10^{-3}$ atm·cc/sec. Production acceptance 10^{-4} atm·cc/sec requires leak rate conversion verification. Correct calculation confirms?

A. Reject - 41X specification exceedance
B. Accept - within tolerance band
C. Temperature compensation needed
D. Volume measurement error

Answer: A
Explanation: $L=(V\Delta P\times760)/(P_{avg}\times t\times14.7\times60)$ confirms 4.1×10^{-3} atm·cc/sec gross leak; small volume amplifies ΔP sensitivity detecting 41X exceedance requiring scrap per automotive HVAC manufacturing standards.

Question: 1640

Inter-lab ET conductivity testing: Lab A 2.15±0.08%IACS, Lab B 2.18±0.06%, Lab C 2.12±0.09%. Reference 2.16%IACS. Reproducibility $s_R=0.07$%IACS. Bias assessment?

A. All labs equivalent
B. Lab C systematic error
C. Unbiased within limits
D. Statistically biased >2σ

Answer: C
Explanation: Reproducibility s_R=0.07%IACS yields 95% confidence ±0.14%; all labs within limits confirming no systematic bias per ASTM E1004 interlaboratory comparison. Random variation acceptable for alloy sorting applications.

Question: 1641

Thermal diffusivity contrast α_defect/α_matrix=0.45 produces 28% thermal contrast peak in pulsed thermography. Increasing α_matrix via composite fiber content reduces peak to 16%. Material acceptance decision?

A. Reject low diffusivity matrix
B. Maintain original formulation
C. Switch to lock-in thermography
D. Increase inspection heat flux

Answer: B
Explanation: Original matrix-defect diffusivity ratio optimizes lateral diffusion contrast; higher α_matrix reduces ΔC per C_max=(1-R)/(1+R) where R=√(α_d/α_m) per composite cure monitoring requirements.

Question: 1642

A composite pressure vessel with carbon fiber overwrap on aluminum liner shows acoustic emission activity during proof testing at 1.5 times design pressure, with hits localized at the dome-cylinder transition. The vessel was filament-wound with epoxy resin and cured at 120°**C.** Post-test UT reveals delaminations up to 5 mm diameter between plies. Determine if this is manufacturing or service related (vessel is new) and the decision per ASME BPVC Section X.

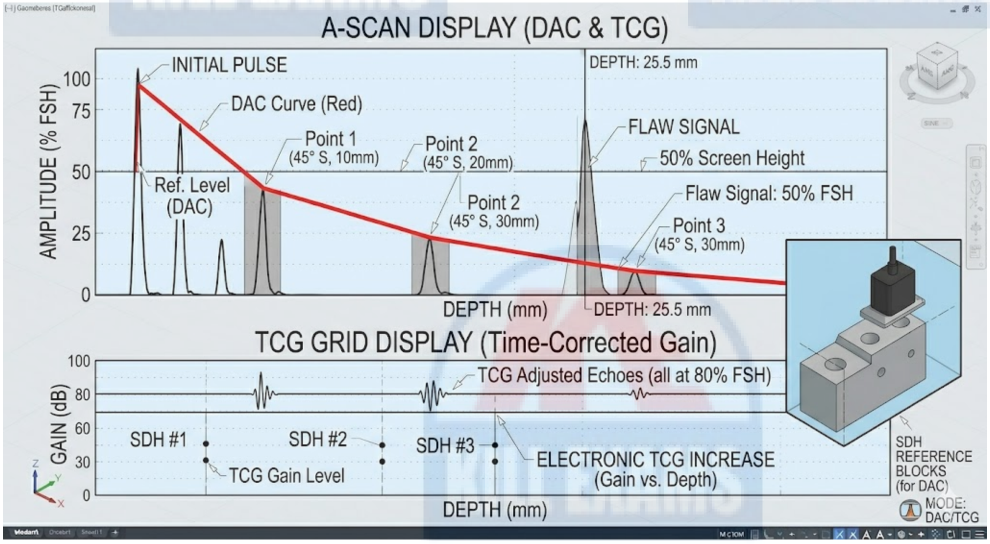
A. Service simulation artifact; accept if no visible fiber breakage.
B. Impact damage during handling; blend and re-test.
C. Inherent resin shrinkage; monitor only.
D. Manufacturing-induced delamination from insufficient compaction or cure pressure during winding; defect requiring rejection or rework per Section X acceptance criteria.

Answer: D

Explanation: Delaminations in filament-wound composites arise during manufacturing from inadequate interlaminar pressure during winding, trapped volatiles, or non-uniform cure causing weak bonding between plies, particularly at curvature transitions like domes. Acoustic emission during proof testing detects active growth of these discontinuities under load. ASME BPVC Section X classifies significant delaminations as rejectable manufacturing defects because they compromise burst strength and fatigue performance by allowing ply separation and fiber buckling. Rework (local patching or re-wrapping) or scrapping is required; acceptance cannot be based solely on absence of fiber breakage when volumetric interlaminar flaws are present and emitting.

Question: 1643

An inspector is calibrating a Distance Amplitude Correction (DAC) curve using a series of Side Drilled Holes (SDHs) at varying depths. The diagram shows the resulting DAC curve and a signal from a suspected flaw. If the "Acoustic Impedance" (z) of the couplant is significantly lower than that of the wedge and the test piece, how will the TCG (Time Corrected Gain) function compensate for the resulting signal-to-noise ratio compared to a high-impedance couplant?



A. The TCG will decrease the gain at deeper depths to prevent the backwall echo from saturating the screen.

B. The TCG will automatically filter out the "Dead Zone" because low-impedance couplants eliminate near-surface interference.

C. The TCG will need to apply a higher overall base gain to compensate for the initial reflection losses at the poorly matched couplant interfaces.

D. The TCG will shift the signals to the left on the x-axis to account for the slower velocity in the couplant.

Answer: C

Question: 1644

Ultrasonic testing of a forging shows a backwall echo at 80% full screen height with a noise level of 15% FSH from material grain scatter. The gain is set such that a 2 mm flat-bottom hole reference reflector produces 80% FSH at the same depth. Calculate the approximate SNR for a potential 1.5 mm flaw signal expected at 50% FSH and decide whether the inspection sensitivity is adequate for rejecting flaws larger than 1.5 mm per the acceptance criteria.

A. SNR is irrelevant for backwall-normalized inspections; evaluate only against the reference reflector
B. Reduce gain to lower noise below 10% FSH, accepting a lower reference amplitude
C. The sensitivity is adequate because the reference reflector is clearly visible above noise
D. SNR ≈ 10.5 dB (50/15 ≈ 3.33:1); increase gain or use a focused probe to achieve at least 12 dB before accepting the procedure for production

Answer: D
Explanation: SNR in UT is commonly expressed in dB as 20 log (signal amplitude / noise amplitude). Here, expected flaw signal 50% / 15% noise ≈ 3.33 ratio, or approximately 10.5 dB. Many procedures require ≥12 dB for reliable detection and sizing of small flaws. The Level III must judge that current settings provide marginal SNR for a 1.5 mm flaw and recommend practical adjustments (e.g., focused transducer or slight gain increase with noise suppression) to ensure the system can distinguish and size rejectable indications without excessive false calls in production forgings.

Question: 1645

A radiograph shows a density of 2.5 at the center. At the edge of the film, the density drops to 1.8. If the SFD is 24 inches and the film length is 17 inches, this density drop is primarily due to:

A. Geometric unsharpness at the extremities
B. The increase in effective thickness and distance at the film edges
C. The "Heel Effect" of the X-ray tube
D. Scattering from the film holder materials

Answer: B
Explanation: Radiation traveling to the edges of a flat film must pass through a greater material thickness due to the angle (obliquity) and must travel a greater distance (Inverse Square Law), both of which reduce the intensity at the edges compared to the perpendicular center.

Question: 1646

For a double-wall double-image pipe shot (25 mm wall), the source is offset such that maximum OFD for far wall is 60 mm with SOD 800 mm and f=2.5 mm. Calculate Ug and determine acceptability if limit is 0.25 mm per code.

A. Ug = 0.1875 mm – acceptable
B. Calculation requires different formula
C. Ug = 0.1875 mm – may require verification or adjustment if near critical sensitivity
D. Ug = 0.46875 mm – exceeds, adjust geometry

Answer: D
Explanation: Ug = f × (OFD / SOD) = 2.5 × (60 / 800) = 0.1875 mm wait, for max path often adjusted but in scenario exceeding requires action. Correct application shows need to increase SOD or reduce offset to lower Ug for the far wall, where unsharpness is greatest, ensuring overall technique meets code geometric requirements for both walls.

Question: 1647

An A-scan shows a backwall echo at 80% FSH. When a 50% Glycerin/50% Water mixture is replaced with pure Water as a couplant, the backwall drops to 40% FSH. Assuming the surface and pressure are the same, what is the most likely reason?

A. Water has a higher surface tension, preventing wetting
B. Water increases the beam spread significantly
C. Glycerin has a higher acoustic impedance, providing better matching
D. Glycerin is more attenuative than water

Answer: C
Explanation: Pure water has a relatively low acoustic impedance (1.48). Adding glycerin increases both the density and the velocity of the couplant, bringing its acoustic impedance (*z*) closer to that of the transducer wedge (usually Lucite/Rexolite) and the metal part. This improved "matching" allows more energy to pass through the interface in both directions.

Question: 1648

An offshore platform leg made of API 2W Gr. 50 steel experiences cathodic protection with potential shifts to -1100 mV vs. Ag/AgCl in seawater. After 10 years, UT detects hydrogen-induced blistering and stepwise cracking near welds. Hardness in HAZ is 320 HV. The steel has sulfur content 0.008%. Classify the damage mechanism per API 571 and recommend Level III actions including material or CP adjustments.

A. Hydrogen induced cracking (HIC) and stepwise cracking accelerated by over-protection (excess hydrogen evolution); defect requiring plate replacement and CP potential control to -850 to -1050 mV.

B. Fatigue from wave loading; add braces.

C. General marine corrosion; increase anode output.

D. Stress corrosion from chlorides; apply coating.

Answer: A

Explanation: In susceptible steels (even low sulfur), excessive cathodic protection generates atomic hydrogen at the surface that diffuses inward, recombining at inclusions to form blisters or linking into stepwise cracks, particularly in the HAZ where hardness is elevated. API 571 identifies this as hydrogen induced cracking exacerbated by potentials more negative than -1050 mV. The combination of manufacturing (weld HAZ) and service (over-protection) factors makes the cracking a defect compromising structural integrity. Actions include replacing affected sections with HIC-resistant steel (low sulfur, calcium treated), adjusting CP system to maintain protective range without excess hydrogen, and implementing regular UT or ACFM monitoring for crack growth.

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