Innershield is a common trade name used when referring to the Self-Shielded Flux Cored Arc Welding process.

True False

4F refers to an overhead fillet weld.

- a. true
- b. false

Gas-shielded, flux-cored wire welding can be used on all mild and low alloy steels.

- a. true
- b. false

The selection of FCAW-Shielded (Dual Shield) welding process is an excellent choice for fieldwork.

- a. true
- b. false

Wire feeding problems are often traced back to worn contact tubes, dirty liners, worn drive rolls, improper drive roll pressure or any combination of these.

- a. true
- b. false

With Self -Shielded FCAW, the shielding gas is provided by the:

a. flux inside the filler

b. gas supplied through the nozzle

- c. both A and B are correct
- d. no shielding is required

The main limitation of FCAW is that it is confined

a. to flat and horizontal welding

b. to plate or rolled pipe only

c. to ferrous metals and nickel based alloys

d. all of the above

The flux in a FCAW electrode is designed to

a. remove impurities on the metal

- b. protect the weld from the atmosphere
- c. cleanses impurities from the base metal

d. all of these

Where does the wire electrode pick up the welding current in FCAW?

- a. drive rollers
- b. the plasma
- c. contact tip
- d. conduit

FCAW Module

The welding gun conduit liner

- a. must be new if the wire is changed
- **b.** size must be compatible with the wire size
- c. must be straight
- d. must be made from nylon for steel wire

Flux Cored Metal Arc Welding with the E71T-1 electrode uses

- a. DCEP
- b. DCEN
- c. AC
- d. ACRP

The 1 in the AWS designation E71T-3 means

- a. flat position
- b. horizontal position
- c. vertical and overhead
- d. all position
- e. there is no such AWS designation

In shielded Flux Cored Arc Welding, the shielding is accomplished by the:

- a. shielding gas from the gun.
- b. electrode flux.
- c. inert gas provided by the rare gas deoxidizers in the core wire.
- d. both a and b

Which of the following gasses *is not* used as a shielding gas for Shielded FCAW?

- a. **argon**
- b. carbon dioxide
- c. argon and carbon dioxide mixtures
- d. both b & c
- e. none of the above

In FCAW, the distance from the end of the contact tube to the arc is:

- a. arc length
- b. stick out
- c. a and b above
- d. b and c above

The welding process that always uses a tubular electrode is:

- a. SMAW
- b. GMAW
- c. FCAW
- d. SAW

What current or polarity should be used with gas shielded flux core welding?

- a. AC
- **b. DCEP**
- c. DCEN
- d. All of these

The gas-shielded, flux cored weld pool is protected by ------ as well as gas shielding.

- a. nozzle
- b. slag
- c. core elements
- d. magnetic field

An example of a flux-cored filler electrode that is used with external shielding gas is

a. E71T-1

- b. E71T-8
- c. E71T-11
- d. None of the above

A primary cause of porosity is _____.

- a. Moisture
- b. Drafts
- c. Oil
- d. All of the above

A gas flow rate that is too high causes _____.

- a. Undue waste
- b. Turbulence which in turn can cause porosity
- c. All of the above
- d. High flow rates give the best coverage

What mode of metal transfer occurs in FCAW-shielded?

- a. Spray
- b. Short Circuit
- c. Globular
- d. None of the above

Flux-cored welding increases welding speeds and _____ rates.

a. Deposition

- b. Defect
- c. Velocity
- d. None of the above

Adjusting drive roll pressure is important to _____.

- a. Prevent wire slippage
- b. Prevent crushing the wire
- c. Prevent drag on the motor
- d. All of the above

What is the common cause for porosity with FCAW-Self Shielded?

- a. Surface contamination
- b. Excessive voltage
- c. Moisture
- d. All of the above