



Pipefitter's Test

Rev. 2, 2-29-16

NOTE: Pipefitter's Blue Book & Foot & Inch Calculator Needed

Name: _____

Date: _____

SS# _____

Part One: "Terminology & References"

1) The term "Take Off" refers to _____?

- A) Not working a scheduled work day
- B) Pipe removed from strait runs to add fittings in system
- C) Items being removed from unit
- D) None of these

2) What is a Slip On Flange _____?

- A) A flange that fits to the O.D. of the pipe
- B) A flange that fits to the I.D. of the pipe
- C) A flange that fits on top of the pipe
- D) Not a flange at all

3) Certain Alloys need to be heated for welding this process is called _____?

- A) Heat mixing
- B) Heat excluding
- C) Stressing/Pre-Heating
- D) None of these

4) What does it mean to Hydro Test something _____?

- A) To clean something with potable water
- B) To pressure a pipe system up with water per required client Spec
- C) To run Hydraulic test fluid through a system
- D) None of these

5) T.O.L means _____?

- A) To Omit Linear Footage
- B) To Outline Length
- C) Thread-O-Let
- D) To Original Length

6) Do you have to 2-Hole a Lap Joint Flange _____?

- A) Yes

B) No

7) Can you Hydro through a Control Valve_____?

A) Yes

B) No

C) Sometimes, depending on Engineering Requirements

8) What is a Flow Orifice used for_____?

A) To control the flow of a solid material

B) To blind of a pipe

C) To regulate back pressure

D) To control the flow of liquid product in a pipe

9) Can you Hydro through a Gate Valve_____?

A) Yes

B) No

10) What is the take-off on a 6" Short Radius 90 degree Elbow_____?

A) 4"

B) 6"

C) 3 ½"

D) 2 ¼"

11) What is the takeoff on a 10" Long Radius 90-degree Elbow_____?

A) 8"

B) 6 ½"

C) 15"

D) 4 ½"

12) During a Shut Down, fitting a new pipe to an existing pipe is often called a _____?

A) Fitters choice

B) Cold tap

C) Up grade

D) Tie-in

13) How many bolts go in a 4" 150# flange_____?

A) 4

B) 6

C) 8

D) 12

14) What kind of Stick Rod is used to weld Standard Carbon Steel Pipe _____?

- A) 7018
- B) 8107
- C) 1817
- D) 2012

15) If new piping that you are installing needs to be re-routed, what do you do _____?

- A) Re-route the line without telling anyone
- B) Ask another Pipe Fitter
- C) Tell your immediate Supervisor
- D) Leave it like it is and don't finish it

16) What is the Take-Off on a 6" 45-degree elbow _____?

- A) 5 ½"
- B) 3 ¾"
- C) 2 ½"
- D) 6"

Part Two: "Fabrication"

Note: Use page 7 to answer questions 17 through 22. All fittings are Long Radius 6" Nominal Pipe Size.

17) What length would the pipe be cut for Dimension "A" _____?

- A) 8'-4"
- B) 7'-6"
- C) 8'-10"
- D) 8'-6"

18) Solve for Dimension "B" _____?

- A) 8"-5 13/16"
- B) 8"-8"
- C) 7"-4"
- D) None of the Above

19) What length is dimension "C" _____?

- A) 1'-2"
- B) 1'-10"
- C) 2'-4"
- D) 2"-6"

20) Dimension "B" is 6'-0", what is Dimension "A" _____?

- A) 6'-0"
- B) 5'-0"
- C) 4'-0"
- D) 4'-5"

21) A Pipe fitter is installing a new line in the Existing Pipe Rack. The Coordinates on the new line call for it to go 6'-2" to the East. What would the East Coordinate be for the new location of the piping?

- A) 516'-11 1/8"
- B) 516'-4"
- C) 412'-9 1/8"
- D) 212'-3"

22) Solve for Dimension "A" _____?

- A) 3'-8 7/16"
- B) 3'-6"
- C) 2'-10 1/2"
- D) 3'-2"