

# **Instrumentation Interview Questions And Answers Guide.**



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# Instrumentation Job Interview Preparation Guide.

### Question # 1

Explain How D.P. transmitter can be applied to open tank?

#### Answer:-

In open tank the lower pressure side is vented to the atmosphere. All pressure is applied to the high pressure side. This vessel pressure is measured through high pressure side.

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### Question # 2

What is the use of valve positioner?

#### Answer:-

Valve positioner can be used for following reasons:

- Quick action
- Valve hysteresis
- Viscous liquids
- Split range.
- Line pressure changes on valve
- Bench set not standard
- Reverse valve operations

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### Question # 3

Name different types of bourdon tubes?

#### Answer:-

Types of bourdon tubes:

1. C type
2. Spiral
3. Helix

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### Question # 4

Explain What is the working principle of the magnetic meter?

#### Answer:-

An electric potential is developed when a conductor is moved across the magnetic field. In most electrical machinery the conductor is a wire. The principle is equally applicable to a moving, electrically conductive liquid. The primary device of commercial magnetic meters consist of straight cylindrical electrically insulated tube with a pair of electrodes nearly flush with the tube walls and located at opposite end of a tube diameter. This device is limited to electrically conducting liquids. The magnetic meter is particularly suited to measurement of slurries and dirty fluids.

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### Question # 5

Why use -24vlt in vibration?

#### Answer:-

normally in electronics and instrumentation cct the pnp transistr is used thats y the o/p is 24vlt bt in vibartion he npn transistr is used thats y v use -24vlt

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### Question # 6

How to write the program for single push button by using Ladder diagram?

#### Answer:-



1. Create a Push button
2. Connect a Counter series to PB
3. Create a compare button
4. Initialize 1 at one end
5. Counter output in another
6. Connect the Coil which has to be energized
7. Initialize 2 at one end
8. Counter output in another
9. Connect the Coil which has to be reenergized.

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### **Question # 7**

What is remote mount with MTA option? (In case of Dual Sensor Vortex Flowmeter, rosemount has written in its Catalog drawings)?

#### **Answer:-**

Remote mount with MTA means MTA connector for mounting remote connection. MTA is the Connector used for connection. Generally we called it MTA Connector. There are many types of MTA connector such as MTA 100connectors, Mta 156 connectors etc...

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### **Question # 8**

Why 4-20 mA signal is preferred over a 0-10V signal?

#### **Answer:-**

Generally in a transistor some amount of voltage is required for turning it on. This voltage is the cut in voltage. Up to this voltage there exists a nonlinearity in its characteristics. Beyond this cut in voltage the char. of transistor is linear. This nonlinear region lays between 0-4ma, beyond 4ma it linear. This is why 4-20 ma range is used.

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### **Question # 9**

Can we use a control valve without positioner?

#### **Answer:-**

Control valve can not be without positioner. The purpose of the positioner is to control the control valve stroke so as to keep the valve in desired position. The positioner receives signal from the controller, and send the boosted signal to the actuator to reach the desired position as and when the valve reaches the desired position the positioner cuts the boosted signal to the actuator and keeps the position.

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### **Question # 10**

What is Instrumentation Measurement?

#### **Answer:-**

Instrumentation can be used to measure certain field parameters (physical values):

These measured values include:

- \* pressure, either differential or static
- \* flow
- \* temperature - Temperature\_measurement
- \* level - Level Measurement
- \* density
- \* viscosity
- \* radiation
- \* current
- \* voltage
- \* inductance
- \* capacitance
- \* frequency
- \* resistivity
- \* conductivity
- \* chemical composition
- \* chemical properties
- \* various physical properties

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### **Question # 11**

What is Instrumentation Control?

#### **Answer:-**

In addition to measuring field parameters, instrumentation is also responsible for providing the ability to modify some field parameters.

Some examples include:

Device Field Parameter(s)  
Valve Flow, Pressure  
Relay Voltage, Current  
Solenoid Physical Location, Level  
Circuit breaker Voltage, Current

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## Instrumentation Interview Questions And Answers

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### **Question # 12**

What is Instrumentation Instrumentation engineering?

#### **Answer:-**

Instrumentation engineering is the engineering specialization focused on the principle and operation of measuring instruments which are used in design and configuration of automated systems in electrical, pneumatic domains etc. They typically work for industries with automated processes, such as chemical or manufacturing plants, with the goal of improving system productivity, reliability, safety, optimization and stability.

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### **Question # 13**

What is Instrumentation technologists and mechanics?

#### **Answer:-**

Instrumentation technologists, technicians and mechanics specialize in troubleshooting and repairing instruments and instrumentation systems. This trade is so intertwined with electricians, pipefitters, power engineers, and engineering companies, that one can find him/herself in extremely diverse working situations. An over-arching term, "Instrument Fitter" is often used to describe people in this field, regardless of any specialization. oo nga.

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### **Question # 14**

Difference between DCS and PLC including data processing and architecture.

#### **Answer:-**

If we have more I/o's in digital signals than analogue signals normally we choose DCS....and vice versa.

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### **Question # 15**

How to calibrate rpm sensor?

#### **Answer:-**

Rpm means rotating per minute... We can only checking the rotating by usen of talkometer and reflecting sticke(stripes)

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### **Question # 16**

What is commissioning and pre-commissioning in instrumentation?

#### **Answer:-**

Pre-commissioning and commissioning activities before a plant or facilities handed over for normal operation it should be inspected checked clean flushed verified and tested, in short pre-commissioning is the testing of non energized system and commissioning is the testing of energized system

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### **Question # 17**

What is a instrumentation?

#### **Answer:-**

Instrumentation is the variety of measuring instruments to monitoring & control a process.

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### **Question # 18**

What is the basic role of instrument technician in maintenance turbine system?

#### **Answer:-**

Gas Turbine Having varies instrumentation measurement system to monitor and control the turbine. Temperature monitoring protection for bearing, Cooling air, TIT,TAT. Speed Monitoring protection and control, varies flow and pressure measurement, Pulsation monitoring, vibration monitoring and protection. VIGV Hydraulic valves control, turbine gas valves, blow off valves, varies type of on/off and solenoid valves. As a maintenance technician, He is capable to install and commission above instrumentation system in turbine. To explain more details, More specific questions to be added. Let me prepare and add more questions.

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### **Question # 19**

Tell me the working of an enraf level gauge?

#### **Answer:-**

Enraf level gauge is based on the ser powered null balance technique. A displacer serves as continuous level sensing element. A two phase ser motor controlled by a capacitive balance system winds unwinds the the measuring wire until the tension in the weight springs is in balance with the weight of the displaced part immersed in the liquid. The sensing system in balance measures the two capacitance formed by the moving central sensing rod provided by the two capacitor plates and the si plates.

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### **Question # 20**

What are primary elements of measuring pressure? Which type of pressure can be measured by these elements?

#### **Answer:-**

Primary elements of measuring pressure are:



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- a. Bourdon Tube
- b. Diaphragm
- c. Capsule
- d. Bellows
- e. Pressure springs

These elements are known as elastic deformation pressure elements.

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### **Question # 21**

How to choose differential range?

**Answer:-**

The most common range for differential range for liquid measurement is 0-100. This range is high enough to minimize the errors caused by unequal heads in the seal chambers. It is also dependent on the differences in the temperature of the load lines. The 100 range permits an increased in capacity up to 400. While decrease down up to 20 by merely changing the range tubes or range adjustments.

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### **Question # 22**

Why are we using airlock relay?

**Answer:-**

For pneumatic Control valve : air Lock Relay holds the Air in locked condition when the supply Air pressure falls below the set value.

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### **Question # 23**

What is the modbus?

**Answer:-**

MODBUS is a commonly used industrial communications protocol. It allows the exchange of data between PLCs and computers. It was originally designed for Modicon (Schneider Electric) PLCs but has become widely used by many PLC manufacturers and industrial networks.

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### **Question # 24**

What is the slandering of tray installation for oil and gas?

**Answer:-**

NEMA VE2 is followed in installation of Cable tray

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### **Question # 25**

What is constant voltage unit?

**Answer:-**

The constant voltage circuit consists of a rectifier, CR and a filter capacitor. It is followed by two stages of zener regulation. Abridge configuration is provided to lamp line voltage zener regulation. Regulation 1 and regulation 2 provides relatively provide constant current. Resistors form a bridge that may remoment line voltage effects.

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### **Question # 26**

Why thermo wells are used? What materials are used in thermo wells?

**Answer:-**

In numerous applications, it is neither desirable nor practical to expose a temperature sensor directly to a material. Wells are therefore used to protect against damage corrosion, arosion, aborsion and high pressure processes. A thermo well is also useful in protecting a sensor from physical damage during handling and normal operations.

Materials used in thermo wells: Stainless steel, Inconel, Monel, Alloy Steel, Hastelloy

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### **Question # 27**

What is Bernoulli's theorem. State its application?

**Answer:-**

Bernoulli's theorem states that the 'total energy of a liquid flowing from one point to another remains constant'. It is applicable for non-compressible liquids. For different types of liquid flow Bernoulli's equation changes. There is direct proportion between speed of fluid and its dynamic pressure and its kinetic energy. It can be used in various real life situations like measuring pressure on aircraft wing and calibrating the airspeed indicator. It can also be used to low pressure in the venturi tubes present in carburetor.

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### **Question # 28**

What is zener diode? What is voltage regulator?

**Answer:-**



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The breakdown region of a p-n diode can be made very sharp and almost vertical diodes with almost vertical breakdown region are known as zener diodes. A zener diode operating in the breakdown region is equivalent to a battery. Because of this current through zener diode can change but the voltage remains constant. It is this constant voltage that has made the zener diode an important device in voltage regulation.

Voltage regulator: The output remains constant despite changes in the input voltage due to zener effect.

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### Question # 29

What is force balance principle? State some of its' advantages?

**Answer:-**

Force balance principle: A controller which generates an output signal by opposing torque. The input force is applied on the input bellows which moves the beam. This crackles nozzle back pressure. The nozzle back pressure is sensed by the balancing bellows which brings the beam to balance. The baffle movement is very less about 0.002 for full scale output.

Advantages:

- Moving parts are fewer.
- Baffle movement is negligible
- Frictional losses are less

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### Question # 30

How to test a transistor with a multimeter?

**Answer:-**

- Emitter +ve of meter and base -ve output =Low resistance
- Emitter -ve of meter and base +ve output =High resistance
- Collector +ve and base -ve output =Low
- Collector -ve and base +ve output =Low

Emitter: Collector = High resistance

PNP: Opposite Results

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### Question # 31

What is ratio control system?

**Answer:-**

A ratio control system is characterized by the fact that variations in the secondary variable don't reflect back on the primary variable. A ratio control system is the system where secondary flow is held in some proportion to a primary uncontrollable flow.

If we assume that the output of a primary transmitter is A, and the output of the secondary transmitter is B, and that the multiplication factor of the ratio relay is K, then for equilibrium conditions which means set valve is equal to measured valve, we find the following relation:

$KA-B=0$  or  $B/A = K$  where 'K' is the ratio setting off the relay.

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### Question # 32

Speed sensor input output?

**Answer:-**

Input : 24v DC

Output : 5-18v pulse which frequency is proportional to turbine rotor speed (number of teeth in 360 deg varies with different turbine). Speed sensor having sensor, amplifier and controller. Sensor works based on eddy current principle.

$F = (\text{\#teeth} * \text{RPM}) / 60$

Example (120 teeth and 3000 RPM)

$F = 6000 \text{ HZ}$

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### Question # 33

What different between rtf and thermocouples?

and how to identify in rtd and thermocouple?

please tell me answer and send images?

**Answer:-**

RTD you can measure resistance Thermocouple you can measure millivolts.

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### Question # 34

Do you know How D.P. transmitter can be applied to close tank?

**Answer:-**

In closed tank, bottom of the tank is connected to the high pressure side of the transmitter. Top of tank is connected to the lower pressure side of the transmitter. In this way vessel pressure can be measured.

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### Question # 35

Do you know the working of an electronic level transducer?



### **Answer:-**

The variation in level of buoyancy resulting from a change in liquid level varies the net weight of the displacer increasing or decreasing the load on the torque arm. This change is directly proportional to change in level and specific gravity of the liquid. The resulting torque tube movement varies the angular motion of the rotor in RVDT providing a rotor change proportional to the rotor displacement, which is converted and amplified to a D.C. current.

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### **Question # 36**

List of Instrumentation Engineering Job Interview Questions!

### **Answer:-**

1. How can leveltrol be installed in steam drum for measuring the level of steam drum?
2. What is ultrasonic flowmeter?
3. Differentiate between ultrasonic flowmeter and radar type flow meter.
4. What is the use of temprature compensation?
5. What is modbus?
6. How signals can be taken through modbus?
7. How earthing can be checked?
8. How many ohms are required for proper earthing?
9. Explain signal isolator.
10. Which wiring connection is preferred in motor for industrial use?
11. What do you mean by trim?
12. How DP Transmitter can be calibrated for crude application in floating roof tank?
13. What is the principle of capacitance type level transmitter?
14. How process line mpm calculation is done?
15. Explain PLC Level and its type?
16. What is procedure on mmwc in to tph?
17. How an rtd work, and what volts/current goes to a RTD to measure the resistance?
18. What is consistency transmitter and describe its working?
19. How to calculate MMWC values into tonnes?
20. How can I make calculation to Install level transmitter (DP) for open tank and close tank?
21. What is difference between DO and DI?
22. What is loop1 and loop2 in MTS LT?
23. How to calibration a control valve?
24. What is dry leg calibration and where is it used?
25. How flow can be measured with dp?
26. Why MMWC unit is used?
27. How HART protocol can be connected with control valves?
28. What is the meaning of slope in PH transmitter?
29. What is Difference between PLC and CNC?
30. If we have 450 mm height boiler drum level, so what is span & zero value for a dpt transmitter?
31. How can level transmitter in closed tank application be used?
32. Why ac supply load cell is used? Can we use the dc supply load cell?
33. What are advantages and disadvantage of the ac supply load cell?
34. What is coriolis principle for mass flow meter?
35. What are the automatic controller MODES?
36. What is Cryogenic?
37. What happen if we install my pressure transmitter below the elevation of pipe in natural gas service?
38. What are the reliability data, like failure rate etc, for bently Nevada systems & vibration probes?
39. What is the meaning of wet leg & where is it used?
40. What are the key components of control loop?
41. Working principle of lvd?
42. What is difference between differential pressure & delta pressure?
43. How to trim the pressure transmitter?
44. What are different types of cable?
45. What is the use of control cable?
46. Which type of diaphragm use in costic line, DM water line, natural gas line, oil line?
47. What are different types of valves?
48. What is the hydra step level sensor output value (measuring level of steam drum)?
49. What is mean by live zero and dead zero?
50. When a magnet is heated?
51. Why the degree of valve plugs and valve seat is slightly different I control valve trim design?
52. What is modbus, profibus, fieldbus?
53. What is the use of gauge?
54. How to calibrate differential pressure switch?

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### **Question # 37**

Do you know How do you identify an orifice in the pipeline?

### **Answer:-**

An orifice tab is welded on the orifice plate which extends out of the line giving an indication of the orifice plate.

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### **Question # 38**

Explain How can a D.P. transmitter be calibrated?

### **Answer:-**

D.P. transmitter can be calibrated using following steps:



1. Adjust zero of Xmtrs.
2. Perform static pressure test: Give equal pressure on both sides of transmitter. Zero should not shift either side. If the zero shifts then carry out static alignment.
3. Perform vacuum test: Apply equal vacuum to both the sides. Zero should not shift.
4. Calibration procedure: Give 20 psi air supply to the transmitter and vent L.P. side to atmosphere. Connect output of the instrument to the standard test gauge. Adjust zero. Apply required pressure to the high pressure side and adjust the span. Adjust zero gain if necessary.

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### **Question # 39**

What is the use of single seated valve?

**Answer:-**

The single seated valve is used on smaller sizes where an absolute shut off is required. The use of single seated valve is limited by pressure drop across the valve in the closed or almost closed position.

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### **Question # 40**

What are different types of control valves?

**Answer:-**

The commonly used control valves can be defined as follows:

a. Depending on Action:

Depending on action there are two types of control valves 1. Air to close 2. Air to open

b. Depending on body:

Depending on body there are 4 types of control valves

1. Globe valves single or double seated

2. Angle valves

3. Butterfly valves

4. Three way valves

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### **Question # 41**

What is intrinsically safe system?

**Answer:-**

Intrinsic safety is a technique for designing electrical equipment for safe use in locations made hazardous by the presence of flammable gas or vapours in the air. Intrinsically safe circuit is one in which any spark or thermal effect produced either normally or under specified fault conditions is incapable of causing ignition of a specified gas or vapour in air mixture at the most ignited concentration.

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### **Question # 42**

What is motion balance principle?

**Answer:-**

A controller which generates an output signal by motion of its parts. The increase in the baffle is to move towards the nozzle. The nozzle back pressure will increase. This increase in the back pressure acting on the balancing bellows, will expand the bellows. The nozzle is moved upward due to this. The nozzle will move until motion almost equals the input baffle motion.

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### **Question # 43**

What do you mean by Pt 100?

**Answer:-**

Pt100 is a type of Resistance temperature detector (RTD). It is made by platinum. It means 100 ohms, resistance at 0 degree C.

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### **Question # 44**

What is the function of vortex flow meter and working principle?

**Answer:-**

principle - Kármán

working: bluff body is placed in pipeline. There is no flow pressure sensor getting zero. When flow in the pipe line bluff body generates vortices if flow increases vortices are increased these vortices are sensed by pressure sensors and fed to transmitter generate output.

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### **Question # 45**

What is the principle of mass flow meter..?

**Answer:-**

Mass flow meter works on the principle of "Coriolis effect"

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### **Question # 46**





## Instrumentation Interview Questions And Answers

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How to use -24vdc in turbine vibration measurement?

**Answer:-**

You are probably referring to a proximity probe, and specifically a probe manufactured by Bently Nevada (now GE Power). Actually the negative DC voltage is bias power that the sensor requires in order to return a voltage (also negative) corresponding to the actual gap between the sensor tip and the target. The gap between the sensor and target must be set prior to using the probe at a distance relative to the probe sensitivity, this gap varies depending on what type of probe is being used. The output DC voltage from the signal conditioner used by the probe can be checked to set the gap. At the far end of the sensitivity range, the output voltage may be close to -24 VDC. As this gap decreases the voltage becomes more positive and at a nearly closed gap it is almost 0 VDC.

There is no good reason for this supply voltage or output voltage to be negative, as other types of proximity probes use positive bias voltage. I suspect that the Bently company used a minus bias voltage for product protection. They have been selling their hardware for 50 years, so it's impossible to switch now.

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### **Question # 47**

Can you explain the burnout feature?

**Answer:-**

Burnout provides the warnsug feature of driving indicator at the end of scale, if the input circuit is open. A burnout resistor is provided which develops a voltage drop between the measuring circuit and amplifier. The polarity of the signal determines the direction of the servo drive upon an open circuit in the input.

Upscale burnout: R value 10 M

Downscale burnout: R value 22 M

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### **Question # 48**

Do you know How is automatic reference junction compensation carried out in temperature recorders?

**Answer:-**

In automatic reference junction compensation, variable nickel resistor is used. As the temperature changes, so does its resistance. This reference junction compensator is located, so that it will be at the temperature of the reference junction. The reference junction is at the poset where the dissimilar wire of the thermocouple is rejoined. This joint is invariably at the terminal strip of the instrument.

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### **Question # 49**

Explain What are de-saturators?

**Answer:-**

When, in some processes, e.g. batch processes, long transient responses are expected during which a sustained deviation is present the controller integral action continuously drives the output to a minimum or maximum value. This phenomenon is called 'integral saturation of the control unit'. When this condition is met, then this unit is de-saturated.

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### **Question # 50**

What is the working of Rota meter?

**Answer:-**

Variable area meters are special form of head meters. Where in the area of flow restrictor is varied. So as to hold the differential pressure constant. The rota meter consists of a vertical tapered tube through which the metered fluid flows in upward direction. As the flow varies the 'float' rises or falls to vary the area of the passages that the differential across it balances the gravitational force on the 'float'. The differential pressure is maintained constant. The position of the 'float' is the measure of the rate of flow.

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### **Question # 51**

Tell me the mechanism behind the turbine meter?

**Answer:-**

Turbine meters consist of straight flow tube within which a turbine or fan is free to rotate about its axis which is fixed along the centre line of the tube. Mostly, a magnetic pick up system senses the rotation of the rotor through the tube walls. The turbine meter is a flow rate device, since the rotor speed is directly proportional to the flow rate. The output is usually in the form of electric pulses from the magnetic pick up with a frequency proportional to the flow rate.

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### **Question # 52**

How can you identify between 2 wire pt100 and thermocouple without using multimeter?

**Answer:-**

By checking the terminal block, thermocouples should have a polarity sig or indication

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### **Question # 53**

Explain What are different types of orifice plates? State their uses?

**Answer:-**

Different orifice plates are:

1. Concentric



## Instrumentation Interview Questions And Answers

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2. Segmental

3. Eccentric

- Concentric: These plates are used for ideal liquid as well as gases and steam service. Concentric holes are present in these plates, that's why it is known as concentric orifice.

- Segmental: This plate has hole in the form of segment of the circle. This plate is used for colloidal and sherry flow measurement.

- Eccentric: This plate has the eccentric holes. This plate is used in viscous and sherry flow measurement.

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### **Question # 54**

Explain Why is the orifice tab provided?

**Answer:-**

Following reasons justify for providing orifice tab:

1. Indication of orifice plate in a line
2. The orifice diameter is marked on it.
3. The material of the orifice plate.
4. The tag number of the orifice plate.
5. To mark the inlet of an orifice.

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### **Question # 55**

Tell me How is flow measured in square root?

**Answer:-**

Flow varies directly as the square root of pressure. Thus,  $F=K$  of square root of applied pressure. Since this flow varies as the square root of differential pressure. The pressure pen does not directly indicate flow. Thus flow can be determined by taking the square root of the pen. Assume the pen reads 50% of the chart. So, flow can be calculated using the pen measure in the chart.

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### **Question # 56**

Name different parts of a pressure gauge? Explain the use of hair spring in the pressure gauge?

**Answer:-**

Pressure gauge includes following components:

- a. 'C' type bourdon tube.
- b. Connecting link
- c. Sector gear
- d. Pinion Gear
- e. Hair spring
- f. Pointer
- g. Dial

Use of hair spring: Hair spring is responsible for controlling torque. It is also used to eliminate any play into linkages.

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### **Question # 57**

What is the use of double seated valve?

**Answer:-**

In double seated valves the upward and downward forces on the plug due to reduction of fluid pressure are nearly equalized. It is generally used on bigger size valves and high pressure systems. Actuator forces required are less.

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### **Question # 58**

What is furnace draft control?

**Answer:-**

Balanced draft boilers are generally used negative furnace pressure. When both forced draft and induced draft are used together, at some point in the system the pressure will be same as that of atmosphere. Therefore the furnace pressure must be negative to prevent hot gas leakage. Excessive vacuum in the furnace however produces heat losses through air infiltration. The most desirable condition is that the one have a very slight negative pressure of the top of furnace.

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### **Question # 59**

What is solenoid valve? Where it is used?

**Answer:-**

A solenoid is electrically operated valve. It consists of solenoid coil in which magnetic plunger moves. This plunger is connected to the plug and tends to open or close the valve. There are two types of solenoid valves:

1. Normally Open
2. Normally closed

Use: It is used for safety purpose in different electric work

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