

This module uses the method of calculating welding cost recommended by Welding Specialists. Values provided by form on certain inputs are taken from studies conducted byinternationally acclaimed institutes.

Calculation File: 2024-WEC-002

Joint Type: Groove

Joint Detail: V-Groove

Weld Process: GTAW (root/heat) + SMAW (fill/cap)

Welding Method: Manual

Total Weld Length: 8.62m mm

Joint Thickness: 2.27 mm

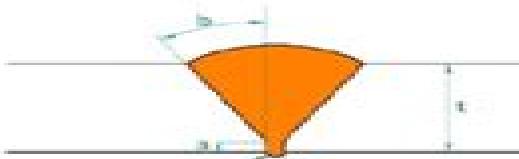
Joint Dimensions:

Root Gap (g): 2.4 mm Root Face Height (a): 3.5 mm Groove Angle (b): 37.5 deg

Groove Angle (a): 35 deg Root Penetration (v): 3.6 mm Radius (r): 10 mm

Cap Height (h): 3.5 mm Branch Thickness (tB): 1.5 mm Header Thick (th): 1.5 mm

Thickness (ta): 1.5 mm



Consumables:

Consumable Group: Stainless & High Alloy Steel Consumable Spec: ER316L ER316L-17

Gas Consumption: 0.32 cu.m/200A.h Deposition Efficiency: 90 % 90 %

Operator Factor: 20 % Deposition Rate: 0.36 / 0.36 kg/hr

Power Characteristics:

Cost per KWh: 0 GBP Welding Voltage: 20 / 20 V

Welding Current: 2000 / 2000 A

Cost Input:

Consumable Cost Basis: Both Consumable Cost: 0 GBP/kg

Flux Cost: 0 GBP/kg Labor Cost: 20 / 20 GBP/hr

Gas Cost: 0 GBP/m Trade Name: THERMAGIT GE316L / FOX EA 50/MA

Estimated Expenditure

Welding Consumables to be purchased:	<u>0.35</u> kg / <u>20.45</u> kg	Cost for Consumables:	<u>6.45</u> GBP
Flux Required:	<u>Not Applicable</u>	Cost for Flux:	<u>Not Applicable</u>
Gas Consumption:	<u>5.2 cu.m</u>	Cost for Gas:	<u>5</u> GBP
Power Consumption:	<u>20.2 kWh</u>	Cost for Power:	<u>2.02</u> GBP
Arc Time:	<u>0.8 hrs / 8.2 hrs</u>	Cost for Labour:	<u>160</u> GBP
Manhours (Time to weld):	<u>8 hrs / 40 hrs</u>	Total Cost:	<u>204.6</u> GBP

Notes:

Calculation By: Engineering Pulse Dated: 07-Mar-24

Welding Estimate Guide

Albert A Gayle

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JATC Handbook United States. Bureau of Apprenticeship and Training, 1962

Handbook of Electronics Industry Cost Estimating Data Theodore Taylor, 1985-09-11 A unique collection of time standards manufacturing methods and overall rules of thumb used for cost estimating electronic equipment

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