

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 by internationally acclaimed institutes.

Calculation No: 2045-WC-003

Joint Type: Groove

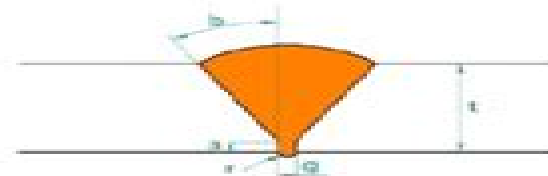
Joint Detail: V-Groove

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

Welding Method: Manual

Total Weld Length: 8.625 m

Joint Thickness: 12.7 mm



## Joint Dimensions

Root Gap (g): 2.4 mm Root Face Height (a): 1.5 mm Groove Angle (θ): 37.5 deg

Groove Angle (α):  deg Root Penetration (r): 1.6 mm Radius (r1):  mm

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

Thickness (ta):  mm

## Consumables

Consumable Group: Stainless & High Alloy Steel

Gas Consumption: 0.33 cu.m/100A.h

Operator Factor: 30 %

Consumable Spec: ER308L ER308L-17

Deposition Efficiency: 90 / 90 %

Deposition Rate: 0.36 / 1.25 kg/hr

## Power Characteristics

Cost per KWh: 1 GBP

Welding Voltage: 30 / 30 V

Welding Current: 200 / 340 A

## Cost Input

Consumable Cost Basis: Boiler

Flux Cost:  GBP/kg

Gas Cost: 1 GBP/cu.m

Consumable Cost:  /  GBP/kg

Labor Cost: 30 / 35 GBP/hr

Trade Name: THERMAST GE308L / FOX EA54MA

## Estimated Expenditure

Welding Consumables to be purchased: 0.33 kg / 30-44 kg

Flux Required: Not Applicable

Gas Consumption: 5.2 cu.m

Power Consumption: 26.2 kWh

Arc time: 0.8 hrs / 8.2 hrs

Manhours (Time to weld): 4 hrs / 43 hrs

Cost for Consumables: 64.5 GBP

Cost for Flux: Not Applicable

Cost for Gas: 5 GBP

Cost for Power: 26 GBP

Cost for Labor: 1370 GBP

Total Cost: 2045 GBP

## Notes:

Calculation By: Engineering Pulse

Dated: 07-Mar-14

# Welding Estimate Guide

**LL Leslie**

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the 'LL Leslie' text.

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**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 and systems As

the only book available on the subject it covers all operations from machining and sheet metal fabrication through wiring circuit board assembly electrical testing and packaging In addition it describes the fields of production schedule determination personnel facility planning ratios and concept estimating      Manufacturing Planning and Estimating Handbook American Society of Tool and Manufacturing Engineers,1963      Mechanical Estimating Guidebook for Building Construction John Gladstone,Kenneth King Humphreys,B. K. Lunde,1987      Means Estimating Handbook RSMMeans,2003-03-26 This comprehensive reference covers the full spectrum of technical data required to estimate construction costs The book includes information on sizing productivity equipment requirements code mandated specifications design standards and engineering factors      *Canadian Blacksmith Gas Welder and Automotive Repairman* ,1918      **Cost Estimating Manual for Pipelines and Marine Structures** John S. Page,1977-01-01 From the Book Preface This manual has been compiled to provide time frames labor crews and equipment spreads to assist the estimator in capsulizing an estimate for the installation of cross country pipelines marshland pipelines nearshore and surf zone pipelines submerged pipelines wharfs jetties dock facilities single point mooring terminals offshore drilling and production platforms and equipment and appurtenances installed thereon The time frames and labor and equipment spreads which appear throughout this manual are the result of many time and method studies conducted under varied conditions and at locations throughout the world these time frames and labor and equipment spreads reflect a complete unbiased view of all operations involved When one is engaged in compiling an estimate from any information furnished by others as is the case with this manual he should view it in an objective light giving due consideration to the nature of the project at hand and evaluating all items that may affect the productivity of labor and all other elements involved      *Brick foundations, arches, tile setting, estimating* Frank Duncan Graham,Thomas J. Emery,1924      *Building Age and National Builder* ,1929      **Catalog of Copyright Entries. Third Series** Library of Congress. Copyright Office,1962 Includes Part 1 Number 1 Books and Pamphlets Including Serials and Contributions to Periodicals January June      **Energy Research Abstracts** ,1986      Engineering Estimates, Costs, and Accounts ,1911      **American Machinist** ,1921      **Engineering Record, Building Record and Sanitary Engineer** ,1907      **Appleton's Popular Science Monthly** ,1948      **Engineering and Cement World** ,1925      *Engineering World* ,1925

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