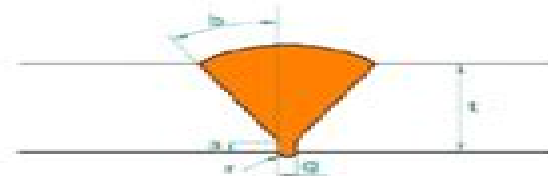


This module uses the method of calculating welding cost recommended by Welding Specialists. Values provided by form on certain inputs are taken from studies conducted by internationally acclaimed institutes.

Calculation No: 2045-WC-003
Joint Type: Groove
Joint Detail: V-Groove
Weld Process: GTAW (root/hoof) + 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: 0.32 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: THERMAJET 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: 1320 GBP
Total Cost: 2045 GBP

Notes:

Calculation By: Engineering Pulse

Dated: 07-Mar-14

Welding Estimate Guide

A Gutmann



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