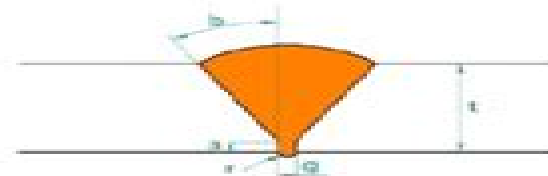


This module uses the method of calculating welding cost recommended by Welding Specialists. Values provided by form on certain inputs are taken from studies conducted by internationally acclaimed institutes.

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): 3.4 mm Root Face Height (a): 3.5 mm Groove Angle (θ): 37.5 deg  
Groove Angle (α):    deg Root Penetration (r): 3.4 mm Radius (R):    mm  
Cap Height (h): 3.5 mm Branch Thickness (tb):    mm Header Thick (th):    mm  
Thickness (ta):    mm

Consumables:				[ GTAW ]		[ SMAW ]	
Consumable Group:	<u>Stainless &amp; High Alloy Steel</u>	Consumable Spec:	<u>ER308L</u>	<u>E308L-17</u>			
Gas Consumption:	<u>0.33</u> cu.m/100A.h	Deposition Efficiency:	<u>90</u> / <u>90</u> %				
Operator Factor:	<u>30</u> %	Deposition Rate:	<u>0.36</u> / <u>1.25</u> kg/hr				
Power Characteristics:		Welding Voltage:		<u>30</u> / <u>30</u> V			
Cost per kWh:	<u>1</u> GBP	Welding Current:		<u>200</u> / <u>340</u> A			
Cost Input:		Consumable Cost:		<u>  </u> / <u>  </u> GBP/kg			
Flux Cost:	<u>  </u> GBP/kg	Labor Cost:		<u>30</u> / <u>35</u> GBP/hr			
Gas Cost:	<u>1</u> GBP/cu.m	Trade Name: THERMAST GE308L / FOX EA54MA					

#### Estimated Expenditure

Welding Consumables to be purchased:	<u>0.33 kg / 30-44 kg</u>	Cost for Consumables	<u>64.5</u> GBP
Flux Required:	<u>Not Applicable</u>	Cost for Flux	<u>Not Applicable</u>
Gas Consumption:	<u>5.2</u> cu.m	Cost for Gas	<u>5</u> GBP
Power Consumption:	<u>26.2</u> kWh	Cost for Power	<u>26</u> GBP
Arc time:	<u>0.8</u> hrs / <u>8.2</u> hrs	Cost for Labor	<u>1370</u> GBP
Manhours (Time to weld):	<u>4</u> hrs / <u>43</u> hrs	Total Cost	<u>2045</u> GBP

Notes:

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\_\_\_\_\_

Calculation By: Engineering Pulse Dated: 07-Mar-14

# Welding Estimate Guide

**Katrin Zwirgmaier**

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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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

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