

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

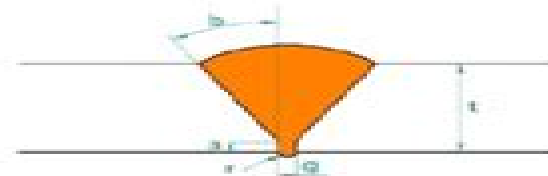
Joint Detail: V-Groove

Weld Process: GTAW (root/heat) + 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

**Siddappa N.Byraredy**



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 throughout this manual are the result of many time and method studies conducted under varied conditions and at locations  
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