

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 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): 30 deg Root Penetration (r): 3.6 mm Radius (r): 3.6 mm

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

Thickness (ta): 3.5 mm

Consumables:

Consumable Group: Stainless & High Alloy Steel Consumable Spec: ER316L ER316L-37

Gas Consumption: 0.32 cu.m/200A.h Deposition Efficiency: 20 % 50 %

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

Power Characteristics:

Cost per KWh: 0.15 GBP Welding Voltage: 20 V 30 V

Welding Current: 2000 A 3000 A

Cost Input:

Consumable Cost Basis: Bulk Consumable Cost: 0.00 GBP/kg

Flux Cost: 0.00 GBP/kg Labor Cost: 30 GBP 35 GBP/hr

Gas Cost: 0.00 GBP/cu.m Trade Name: THERMAGIT GE316L / FOX EASyMA

Estimated Expenditure

Welding Consumables to be purchased: 0.35 kg / 20.44 kg

Cost for Consumables: 6.45 GBP

Flux Required: Not Applicable

Cost for Flux: Not Applicable

Gas Consumption: 5.2 cu.m

Cost for Gas: 5 GBP

Power Consumption: 20.2 kWh

Cost for Power: 3.0 GBP

Arc Time: 0.8 hrs / 8.2 hrs

Cost for Labour: 1320 GBP

Manhours (Time to weld): 4 hrs / 48 hrs

Total Cost: 2045 GBP

Notes:

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

Welding Estimate Guide

Siddappa N.Byrareddy

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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

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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

RSMeans,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

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