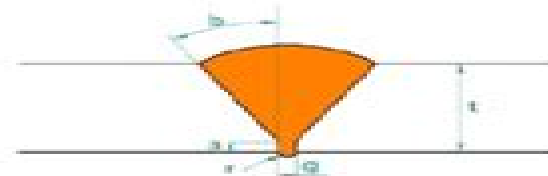


This module uses the method of calculating welding cost recommended by Welding Specialists. Values provided by form on certain inputs are taken from studies conducted by internationally acclaimed institutes.

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 (R):        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: 1320 GBP  
Total Cost: 2045 GBP

**Notes:**

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\_\_\_\_\_

Calculation By: Engineering Pulse

Dated: 07-Mar-14

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Apprenticeship and Training**

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