

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 byinternationally 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):	<u>2.4</u> <u>mm</u>	Root Face Height (a):	<u>3.5</u> <u>mm</u>	Groove Angle (b):	<u>37.5</u> <u>deg</u>
Groove Angle (a):	<u>30</u> <u>deg</u>	Root Penetration (r):	<u>3.6</u> <u>mm</u>	Radius (r):	<u>1.5</u> <u>mm</u>
Cap Height (h):	<u>3.5</u> <u>mm</u>	Branch Thickness (tB):	<u>1.5</u> <u>mm</u>	Header Thick (tH):	<u>1.5</u> <u>mm</u>
Thickness (tA):	<u>2.27</u> <u>mm</u>				

Consumables:

Consumable Group:	<u>Stainless &amp; High Alloy Steel</u>	Consumable Spec:	<input checked="" type="checkbox"/> GTAW	<input type="checkbox"/> SMAW
Gas Consumption:	<u>0.32</u> <u>cu.m/200A.h</u>	Deposition Efficiency:	<u>20</u> <u>%</u>	<u>50</u> <u>%</u>
Operator Factor:	<u>20</u> <u>%</u>	Deposition Rate:	<u>0.36</u> <u>kg</u>	<u>0.26</u> <u>kg/hr</u>

Power Characteristics:

Cost per KWh:	<u>0</u> <u>GBP</u>	Welding Voltage:	<u>20</u> <u>V</u>
		Welding Current:	<u>200</u> <u>A</u>

Cost Input:

Consumable Cost Basis:	<u>Bulk</u>	Consumable Cost:	<u>0</u> <u>GBP/kg</u>
Flux Cost:	<u>0</u> <u>GBP/kg</u>	Labor Cost:	<u>0</u> <u>GBP/hr</u>
Gas Cost:	<u>0</u> <u>GBP/cu.m</u>	Trade Name: <u>THERMAGIT GE246L / FOX EASyMA</u>	

Estimated Expenditure

Welding Consumables to be purchased:	<u>0.35</u> <u>kg</u> / <u>20.45</u> <u>kg</u>	Cost for Consumables:	<u>6.5</u> <u>GBP</u>
Flux Required:	<u>Not Applicable</u>	Cost for Flux:	<u>Not Applicable</u>
Gas Consumption:	<u>5.2</u> <u>cu.m</u>	Cost for Gas:	<u>5</u> <u>GBP</u>
Power Consumption:	<u>20.2</u> <u>KWh</u>	Cost for Power:	<u>20</u> <u>GBP</u>
Arc Time:	<u>0.8</u> <u>hrs</u> / <u>8.2</u> <u>hrs</u>	Cost for Labor:	<u>130</u> <u>GBP</u>
Manhours (Time to weld):	<u>8</u> <u>hrs</u> / <u>42</u> <u>hrs</u>	Total Cost:	<u>204.5</u> <u>GBP</u>

Notes:

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

# Welding Estimate Guide

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*JATC Handbook* United States. Bureau of Apprenticeship and Training, 1962

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

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

**Manufacturing Planning and Estimating**

**Handbook** American Society of Tool and Manufacturing Engineers,1963

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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

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