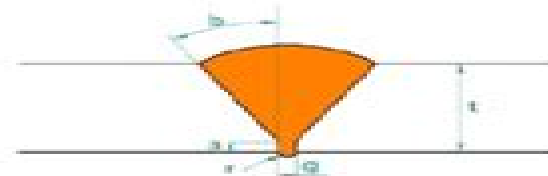


This module uses the method of calculating welding cost recommended by Welding Specialists. Values provided by form on certain inputs are taken from studies conducted by internationally acclaimed institutes.

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:				[GTAW]		[SMAW]	
Consumable Group:	<u>Stainless S 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>140</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:

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

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