

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): 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-x7

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: Both 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:	<u>0.35</u> <u>kg</u> / <u>20.45</u> <u>kg</u>	Cost for Consumables:	<u>6.45</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>26.2</u> <u>kWh</u>	Cost for Power:	<u>3.9</u> <u>GBP</u>
Arc Time:	<u>0.8</u> <u>hrs</u> / <u>0.2</u> <u>hrs</u>	Cost for Labor:	<u>13.20</u> <u>GBP</u>
Manhours (Time to weld):	<u>0.8</u> <u>hrs</u> / <u>0.2</u> <u>hrs</u>	Total Cost:	<u>204.6</u> <u>GBP</u>

Notes:

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

# Welding Estimate Guide

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