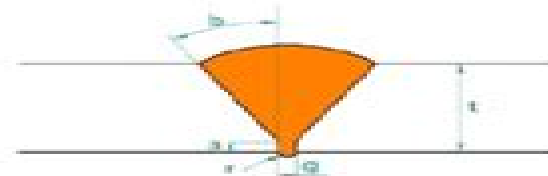


This module uses the method of calculating welding cost recommended by Welding Specialists. Values provided by form on certain inputs are taken from studies conducted by internationally acclaimed institutes.

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 (r1): 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: THERMAJET 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: 1370 GBP
Total Cost: 2045 GBP

Notes:

Calculation By: Engineering Pulse

Dated: 07-Mar-14

Welding Estimate Guide

**American Society of Tool and
Manufacturing Engineers**

A red circular graphic with a gradient, appearing as a partial circle or a thick arc, located to the right of the text in the light blue bar.

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Estimating and Costing for the Metal Manufacturing Industries Robert Creese, M. Adithan, 1992-08-25 This practical reference text provides a thorough overview of cost estimating as applied to various manufacturing industries with special emphasis on metal manufacturing concerns. It presents examples and study problems illustrating potential applications and the techniques involved in estimating costs. Containing both US and metric units for easy conversion of world wide manufacturing data. **Estimating and Costing for the Metal Manufacturing Industries** outlines professional societies and publications dealing with cost estimating and cost analysis details the four basic metalworking processes machining casting forming and joining reveals five techniques for capital cost estimating including the new AACE International's Recommended Practice 16R 90 and the new knowledge and experience method discusses the effect of scrap rates and operation costs upon unit costs offers four formula methods for conceptual cost estimating and examines material design cost relationships describes cost indexes cost capacity factors multiple improvement curves and facility cost estimation techniques offers a generalized metal cutting economics model for comparison with traditional economic models and more. **Estimating and Costing for the Metal Manufacturing Industries** serves as an on the job single source reference for cost manufacturing and industrial engineers and as a text for upper level undergraduate graduate and postgraduate students in cost estimating engineering economics and production operations courses. A Solutions manual to the end of chapter problems is available free of charge to instructors only. Requests for the manual must be made on official school stationery. **PDCA Cost and Estimating Guide Volume I**, 2004 Practices and Procedures is the how to manual for estimating painting and related work. Quality takeoff procedures and estimating methods are thoroughly described and discussed. All elements of proper job pricing are described including the evaluation of labor material additional job costs overhead and profit. Working blueprints and sample estimates are a part of the manual. Job costing methods and their relationship to estimating is included.

JATC Handbook United States. Bureau of Apprenticeship and Training, 1962 *Pipeline Rules of Thumb Handbook* E.W. McAllister, 2015-06-02 This classic reference has built a reputation as the go to book to solve even the most vexing pipeline problems. Now in its seventh edition *Pipeline Rules of Thumb Handbook* continues to set the standard by which all others are judged. The 7th edition features over 30% new and updated sections reflecting the exponential changes in the codes construction and equipment since the sixth edition. The seventh edition includes recommended drill sizes for self tapping screws new ASTM standard reinforcing bars calculations for calculating grounding resistance national Electrical Code tables Corliss meters pump seals progressive cavity pumps and accumulators for lubricating systems Shortcuts for pipeline construction design and engineering Calculations methods and handy formulas Turnkey solutions to the most vexing pipeline problems. **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 Cost Estimating Manual for Pipelines and Marine Structures John S. Page,1977-01-01 From the Book Preface This manual has been compiled to provide time frames labor crews and equipment spreads to assist the estimator in capsulizing an estimate for the installation of cross country pipelines marshland pipelines nearshore and surf zone pipelines submerged pipelines wharfs jetties dock facilities single point morring terminals offshore drilling and production platforms and equipment and appurtenances installed thereon The time frames and labor and equipment spreads which appear throughout this manual are the result of many time and method studies conducted under varied conditions and at locations throughout the world these time frames and labor and equipment spreads reflect a complete unbiased view of all operations involved When one is engaged in compiling an estimate from any information furnished by others as is the case with this manual he should view it in an objective light giving due consideration to the nature of the project at hand and evaluating all items that may affect the productivity of labor and all other elements involved

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

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Building Structural Design Handbook Richard White,Charles G. Salmon,1987-05-08 This book provides insight into the design analysis and construction of a variety of building types

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The 2004 Guide to the Evaluation of Educational Experiences in the Armed Services American Council on Education,American Council on Education Staff,2004 For more than a hald century the Guide to the Evaluation of Education Experiences in the Armed Services has been the standard reference work for recognizing learning acquired in military life Since 1942 ACE and has worked cooperatively with the US Department of Defense the Armed

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