

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

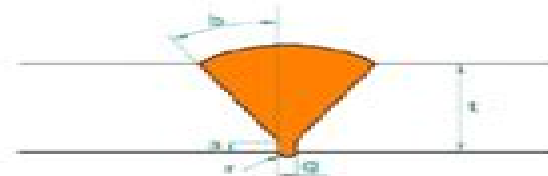
Joint Detail: V-Groove

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

Consumable Spec: ER308L (GTAW) / E308L-17 (SMAW)

Gas Consumption: 0.33 cu.m/100A.h Deposition Efficiency: 90 / 90 %

Operator Factor: 30 % Deposition Rate: 0.36 / 1.25 kg/hr

Power Characteristics:

Cost per kWh: 1 GBP Welding Voltage: 30 / 30 V

Cost Input: Welding Current: 200 / 340 A

Consumable Cost Basis: Boiler Consumable Cost: / GBP/kg

Flux Cost: GBP/kg Labor Cost: 30 / 35 GBP/hr

Gas Cost: 1 GBP/cu.m Trade Name: THERMAJET GE308L / FOX EA54MA

Estimated Expenditure

Welding Consumables to be purchased:	0.33 kg / 30-44 kg	Cost for Consumables	64.5 GBP
Flux Required:	Not Applicable	Cost for Flux	Not Applicable
Gas Consumption:	5.2 cu.m	Cost for Gas	5 GBP
Power Consumption:	26.2 kWh	Cost for Power	26 GBP
Arc time:	0.8 hrs / 8.2 hrs	Cost for Labor	1370 GBP
Manhours (Time to weld):	4 hrs / 43 hrs	Total Cost	2045 GBP

Notes:

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

Welding Estimate Guide

Michael Rajnik

A red circular graphic with a gradient, appearing as a stylized arrow or a light effect, positioned to the right of the author's name.

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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 mooring 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

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

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Industrial Construction Estimating Manual Kenneth Storm, 2020-05-27

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Manufacturing Planning and Estimating Handbook American Society of Tool and Manufacturing Engineers,1963

JATC Handbook United States. Bureau of Apprenticeship and Training,1962 Recognition of Occupational Health Hazards 510: Course manual ,1982 Heating, Ventilating, and Air-conditioning Systems Estimating Manual A. M. Khashab,1984 Good No Highlights No Markup all pages are intact Slight Shelfwear may have the corners slightly dented may have slight color changes slightly damaged spine *Catalog of Copyright Entries. Third Series* Library of Congress. Copyright Office,1964 Includes Part 1 Number 1 Books and Pamphlets Including Serials and Contributions to Periodicals January June Energy Research Abstracts ,1986 **Brick foundations, arches, tile setting, estimating** Frank Duncan Graham,Thomas J. Emery,1924 **Cumulative Index to NASA Tech Briefs** , NASA Tech Briefs ,1981

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