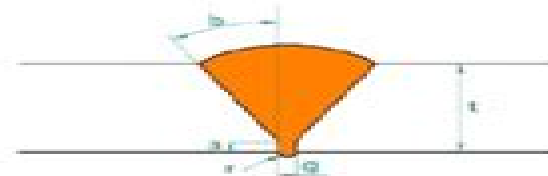


This module uses the method of calculating welding cost recommended by Welding Specialists. Values provided by form on certain inputs are taken from studies conducted by internationally acclaimed institutes.

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:				[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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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 Manufacturing

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Industrial Construction Estimating Manual Kenneth Storm, 2020-05-27 Industrial Construction Estimating Manual focuses on industrial process plants and enables the contractor subcontractor and engineer to use methods models procedures formats and technical data for developing industrial process plant construction estimates The manual begins with an introduction devoted to labor data collection verification of data coding productivity measurement the unit quantity model and computer aided cost estimating It goes on to provide information on construction materials database systems work estimating computer aided estimating detailed labor estimates bid assurance and detailed applications to construction Practical examples based on historical data collected from past installations are also included as well as a detailed glossary Excel and mathematical formulas metric standard conversions area and volume formulas and boiler man hour tables Industrial Construction Estimating Manual aids contractors subcontractors and engineers with a balance detailed estimating method using the unit quantity model and is an excellent resource for those involved in engineering technology and construction estimating Provides a detailed estimating method using the unit quantity model to prepare construction estimates Delivers information on construction materials databases labor estimates computer aided estimating bid assurance and applications to construction Utilizes historical data from a database of previous similar work calculates material cost and labor by category and produces both summary and detailed man hour and cost estimates

Pipeline Rules of Thumb Handbook E.W. McAllister, 2015-08-03 Now in its sixth edition Pipeline Rules of Thumb Handbook has been and continues to be the standard resource for any professional in the pipeline industry A practical and convenient reference it provides quick solutions to the everyday pipeline problems that the pipeline engineer contractor or designer faces Pipeline Rules of Thumb Handbook assembles hundreds of shortcuts for pipeline construction design and engineering Workable how to methods handy formulas correlations and curves all come together in this one convenient volume Save valuable time and effort using the thousands of illustrations photographs tables calculations and formulas available in an easy to use format Updated and

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Hulls Stanley Theodore Rolfe,David M. Rhea,Bogdan O. Kuzmanovic,1974 The Report provides comprehensive toughness criteria for welded ship hulls that can be used for steels of all strength levels Because of the fact that stress concentrations are always present in large complex welded structures and therefore high stresses as well as discontinuities or flaws will be present in welded ship hulls primary emphasis in the proposed fracture control guidelines is placed on the use of steels with moderate levels of notch toughness and on the use of properly designed crack arresters In general concepts of fracture mechanics are used to develop the material toughness level that is required for fail safe operation of welded ship hulls

Canadian Blacksmith Gas Welder and Automotive Repairman ,1918 PPI Construction Depth Reference Manual for the Civil PE Exam eText - 1 Year Thomas Korman,2016-11-30 Construction Depth Reference Manual prepares you for the construction depth section of the NCEES Civil PE exam All depth topics are covered and exam adopted codes and standards are frequently referenced You will learn how to apply concepts by reviewing the 40 example problems and you can check your solving approaches by reviewing each problem s step by step solution Access to supportive information is just as important as knowledge and problem solving efficiency The Construction Depth Reference Manual s thorough index easily directs you to the codes and concepts you will need during the exam Cross references to the 163 equations 38 tables 93 figures 5 appendices and relevant codes will point you to additional support material when you need it Topics Covered Construction Operations and Methods Earthwork Construction and Layout Estimating Quantity and Cost Material Quality Control and Production Scheduling Temporary Structures Worker Health and Safety Production Economics Anoop Desai,Aashi Mital,2018-08-06 This book serves a unique purpose within the world of engineering It covers the economics of modern manufacturing and focuses on examining the techniques and methods from a cost perspective It can be used by both students and professionals alike The book is useful to students in industrial engineering and mechanical engineering programs as a primary textbook for engineering economy production costing and related courses It can also be used by MBA students specializing in production management and finance Specific topics of coverage include the computation of direct and indirect cost for manufacturing operations including a variety of overhead operations in such an environment Costing of manufacturing methods such as casting forging turning milling and welding is addressed along with inventory analysis The

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

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