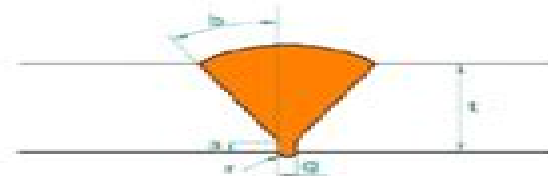


This module uses the method of calculating welding cost recommended by Welding Specialists. Values provided by form on certain inputs are taken from studies conducted by internationally acclaimed institutes.

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>0.32</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>340</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>2046</u> GBP

Notes:

\_\_\_\_\_

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\_\_\_\_\_

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

# Welding Estimate Guide

**Mark Steyvers**

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located 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

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 *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

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