

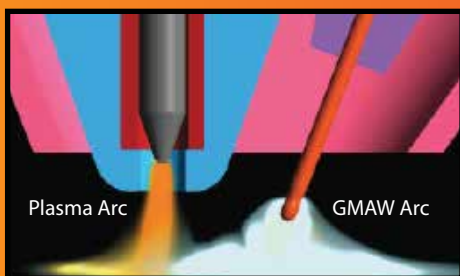


Cost Saving



SuperMIG[®]

Hybrid Welding
Plasma & GMAW



Principle of work:

Plasma arc melting base material creating a keyhole, GMAW arc following and providing the filler metal and creating full penetration.

Return of investment (ROI) calculation

Butt Welding Carbon Steel 10mm	Welding Technology			
	Submerged Arc	Plasma	MIG	SuperMIG®
Activity and cost				
Length of each parts (meter)	8	8	8	8
Number of parts	1000	1000	1000	1000
Beveling/Machining required? (Yes/No)	Yes	Yes	Yes	No
Additional cost of preparation per part	10€	14€	10€	0€
Number of passes per weld	2	3	2	1
Total combined welding length per part (meters)	16	24	16	8
Welding speed (m/min)	0.60	0.25	0.45	0.70
Total welding time per part (minutes)	27	96	36	11.5
Labor cost/part (average manpower cost €/h 40)	17.78 €	64.00 €	23.70 €	5.93 €
Cost of material, wire, gas, flux (per part)	6.67 €	9.60 €	4.47 €	2.07 €
Heat Input (KJ/cm)	17	24	13	10
Additional cost of straightening post welding	8.00 €	10.00 €	2.00 €	0.00 €
Total cost per part	42.45 €	97.60 €	40.44 €	10.00 €
Total Cost - 1000 parts	42,444 €	97,600 €	40,444 €	10,000 €
Saving by using SuperMIG	-32,444.00 €	-87,600.00 €	-30,444.00 €	-

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