

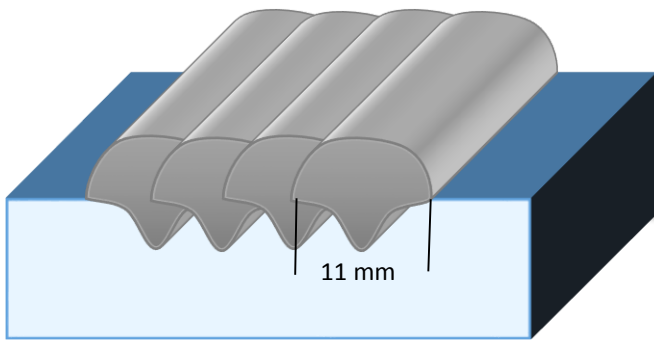
# WELDREVO<sup>®</sup>LUTION

VERTICAL DOWN 625 OVERLAY / WATERWALL OVERLAY

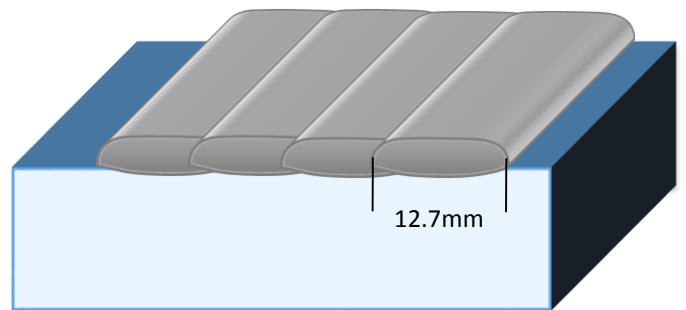
## Welded Components

Conventional Pulse

SpinArc<sup>™</sup>



16 IPM Travel Speed, .035" Wire size



26 IPM Travel Speed, .035" Wire Size

## Productivity Gains From SpinArc<sup>™</sup>

Deposition Rate: 11.88 lbs./hr.

Welding Time Cut in Half: 16 ipm conventional,

vs 26 ipm with spin arc

115% Bead Width over Standard Pulse

5,029 cm<sup>2</sup>/hr. of coverage area vs

2,682 cm<sup>2</sup>/hr. with conventional

### COMPARISONS (per month)

FILLER REDUCTION	301.29	(lbs.)	ARC TIME REDUCTION	115.89	(hr.)
ESTIMATED SAVINGS	\$21,201.72		PAYBACK PERIOD	0.4	(months)

*PRODUCTIVITY INCREASES*

CONVENTIONAL			SpinArc™		
WELD INFORMATION					
PROCESS	GMAW		PROCESS	GMAW	
WFS (in./min.)	450		WFS (in./min.)	675	
WIRE DIAMETER	0.035		WIRE DIAMETER	0.035	
FLOW RATE (CFH)	45		FLOW RATE (CFH)	45	
CONSUMABLE COSTS					
WIRE PRICE	(\$/lb.)	\$30.00	WIRE PRICE	(\$/lb.)	\$30.00
GAS PRICE	(\$/ft. <sup>3</sup> )	\$0.11	GAS PRICE	(\$/ft. <sup>3</sup> )	\$0.11
FLUX PRICE	(\$/lb.)	\$0.00	FLUX PRICE	(\$/lb.)	\$0.00
SUMMARY					
					% CHANGE
FILLER REQUIRED	0.18	(lbs.)	FILLER REQUIRED	0.15	(lbs.) 14.0% ✓
DEPOSITION RATE	7.92	(lbs./hr.)	DEPOSITION RATE	11.88	(lbs./hr.) 33.3% ✓
ARC TIME	0.02	(hr.)	ARC TIME	0.01	(hr.) 42.7% ✓
GAS REQUIRED	1.02	(ft. <sup>3</sup> )	GAS REQUIRED	0.58	(ft. <sup>3</sup> ) 42.7% ✓
WIRE COST	\$5.38	(\$)	WIRE COST	\$4.63	(\$) 14.0% ✓
GAS COST	\$0.11	(\$)	GAS COST	\$0.06	(\$) 42.7% ✓
TOTAL COST/FT	\$7.76	(\$)	TOTAL COST/FT	\$5.99	(\$) 22.8% ✓
COMPARISONS (per month)					
FILLER REDUCTION	301.29	(lbs.)	ARC TIME REDUCTION	115.89	(hr.)
<b>ESTIMATED SAVINGS</b>	<b>\$21,201.72</b>		<b>PAYBACK PERIOD</b>	<b>0.4</b>	<b>(months)</b>

GLOBAL VARIABLES	
COST OF SpinArc™ SYSTEM	\$8,000
LABOR AND OVERHEAD	\$50.00
LBS. FLUX PER LB. FILLER	1.50
FT OF WELD PER MONTH	1000

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