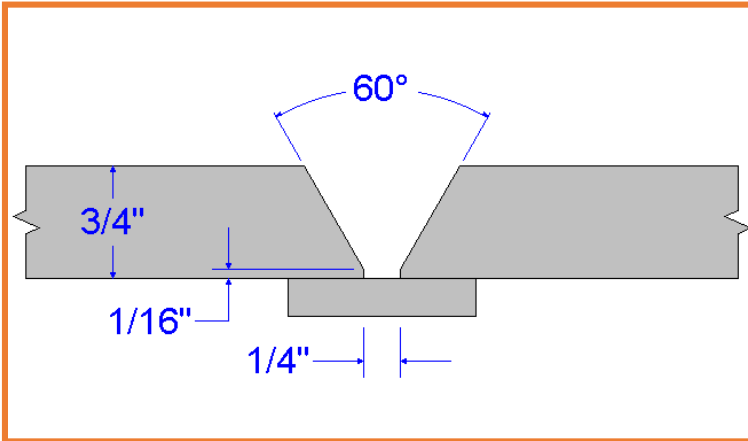


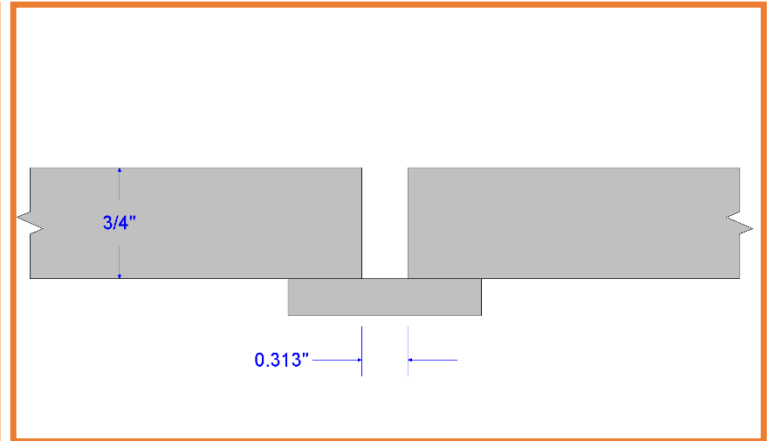
HEAVY WALL PLATE / BUTT JOINT

Joint Detail

Conventional

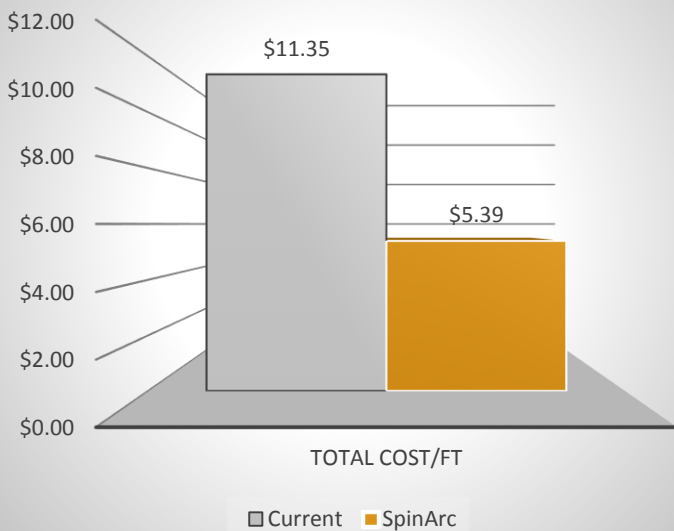


SpinArc[™]

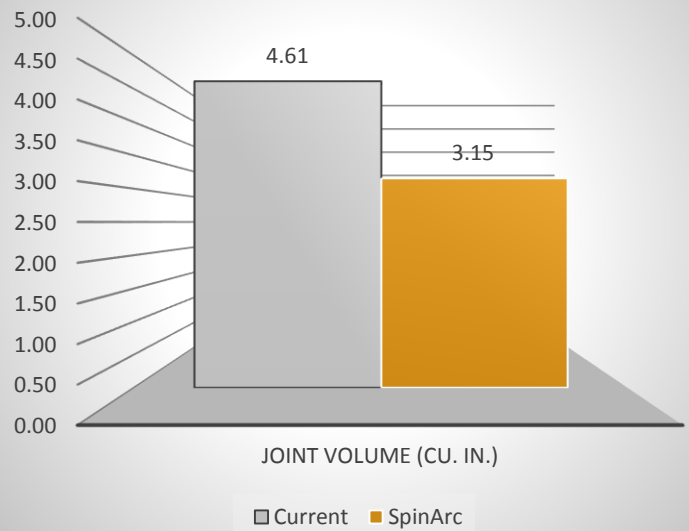


Productivity Gains From SpinArc[™]

Total Cost Per Foot of Weld



JOINT VOLUME



Based on 2000ft of welding a month and \$8,000 for SpinArc System

COMPARISONS (per month)					
FILLER REDUCTION	1158.32	(lbs.)	ARC TIME REDUCTION	163.00	(hr.)
ESTIMATED SAVINGS	\$19,493.22		PAYBACK PERIOD	0.4	(months)

PRODUCTIVITY INCREASES

CONVENTIONAL			SpinArc™		
WELD INFORMATION					
PROCESS	METAL CORE		PROCESS	METAL CORE	
WFS (in./min.)	400		WFS (in./min.)	600	
WIRE DIAMETER	0.045		WIRE DIAMETER	0.045	
FLOW RATE (CFH)	45		FLOW RATE (CFH)	45	
CONSUMABLE COSTS					
WIRE PRICE	(\$/lb.)	\$2.06	WIRE PRICE	(\$/lb.)	\$2.06
GAS PRICE	(\$/ft. ³)	\$0.11	GAS PRICE	(\$/ft. ³)	\$0.11
FLUX PRICE	(\$/lb.)	\$0.00	FLUX PRICE	(\$/lb.)	\$0.00
SUMMARY					
				% CHANGE	
JOINT AREA	0.46	(in. ²)	JOINT AREA	0.28	(in. ²)
JOINT VOLUME	5.52	(in. ³)	JOINT VOLUME	3.38	(in. ³)
FILLER REQUIRED	1.49	(lbs.)	FILLER REQUIRED	0.91	(lbs.)
DEPOSITION RATE	10.83	(lbs./hr.)	DEPOSITION RATE	16.24	(lbs./hr.)
ARC TIME	0.14	(hr.)	ARC TIME	0.06	(hr.)
GAS REQUIRED	6.19	(ft. ³)	GAS REQUIRED	2.52	(ft. ³)
FLUX REQUIRED	0.00	(lbs.)	FLUX REQUIRED	0.00	(lbs.)
WIRE COST	\$3.07	(\$)	WIRE COST	\$1.87	(\$)
GAS COST	\$0.68	(\$)	GAS COST	\$0.28	(\$)
FLUX COST	\$0.00	(\$)	FLUX COST	\$0.00	(\$)
TOTAL COST/FT	\$17.50	(\$)	TOTAL COST/FT	\$7.75	(\$)
COMPARISONS (per month)					
FILLER REDUCTION	1158.32	(lbs.)	ARC TIME REDUCTION	163.00	(hr.)
ESTIMATED SAVINGS	\$19,493.22		PAYBACK PERIOD	0.4	(months)

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	2000

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