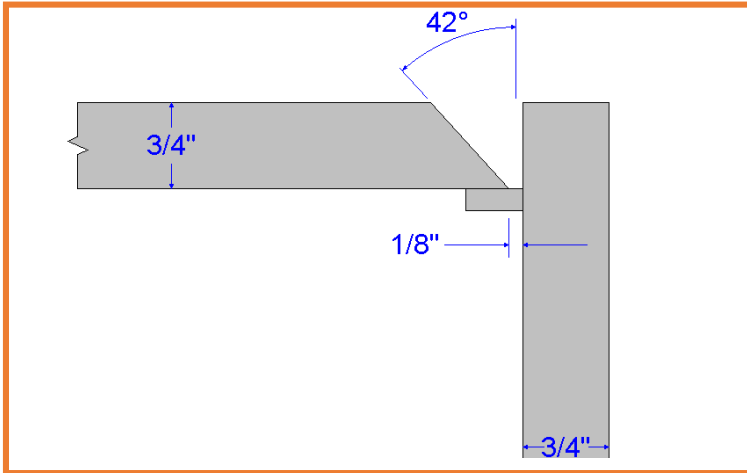


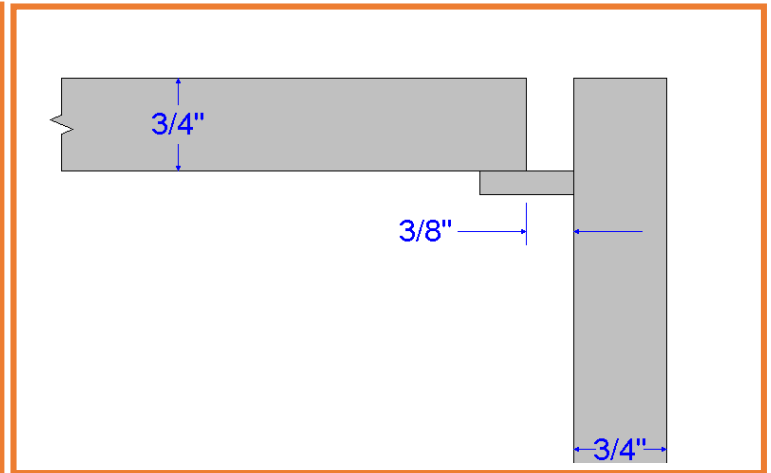
HEAVY WALL PLATE – CORNER WELD

Joint Detail

Conventional

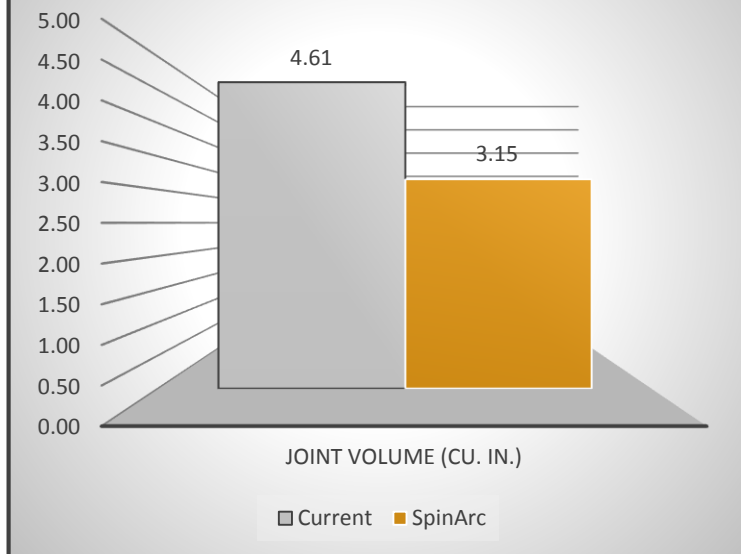


SpinArc™

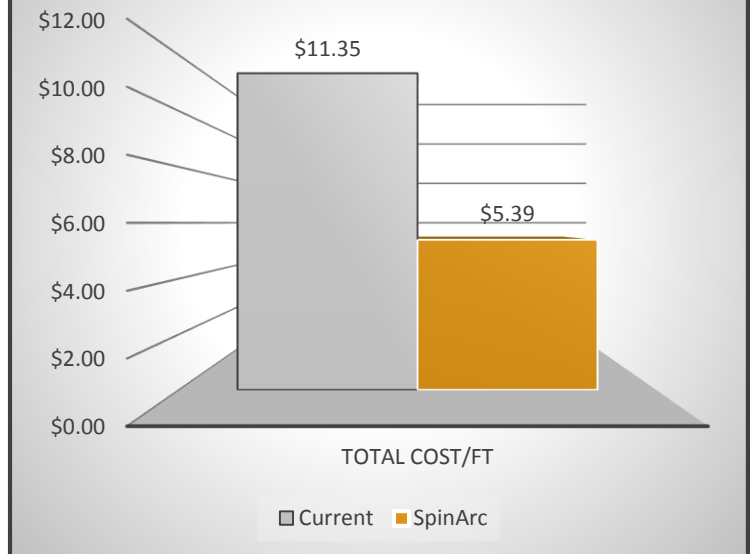


Productivity Gains From SpinArc™

JOINT VOLUME



Total Cost Per Foot of Weld



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

COMPARISONS (per month)					
FILLER REDUCTION	425.07	(lbs.)	ARC TIME REDUCTION	95.27	(hr.)
ESTIMATED SAVINGS	\$10,873.83		PAYBACK PERIOD	0.7	(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	0.35	(in. ²)	JOINT AREA	0.28	(in. ²)
JOINT VOLUME	4.16	(in. ³)	JOINT VOLUME	3.38	(in. ³)
FILLER REQUIRED	1.12	(lbs.)	FILLER REQUIRED	0.91	(lbs.)
DEPOSITION RATE	10.83	(lbs./hr.)	DEPOSITION RATE	16.24	(lbs./hr.)
ARC TIME	0.10	(hr.)	ARC TIME	0.06	(hr.)
GAS REQUIRED	4.66	(ft. ³)	GAS REQUIRED	2.52	(ft. ³)
FLUX REQUIRED	0.00	(lbs.)	FLUX REQUIRED	0.00	(lbs.)
WIRE COST	\$2.31	(\$)	WIRE COST	\$1.87	(\$)
GAS COST	\$0.51	(\$)	GAS COST	\$0.28	(\$)
FLUX COST	\$0.00	(\$)	FLUX COST	\$0.00	(\$)
TOTAL COST/FT	\$13.19	(\$)	TOTAL COST/FT	\$7.75	(\$)
COMPARISONS (per month)					
FILLER REDUCTION	425.07	(lbs.)	ARC TIME REDUCTION	95.27	(hr.)
ESTIMATED SAVINGS	\$10,873.83		PAYBACK PERIOD	0.7	(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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