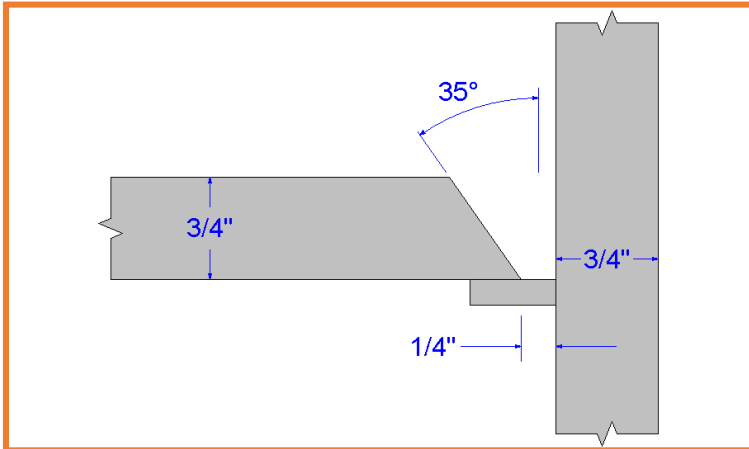
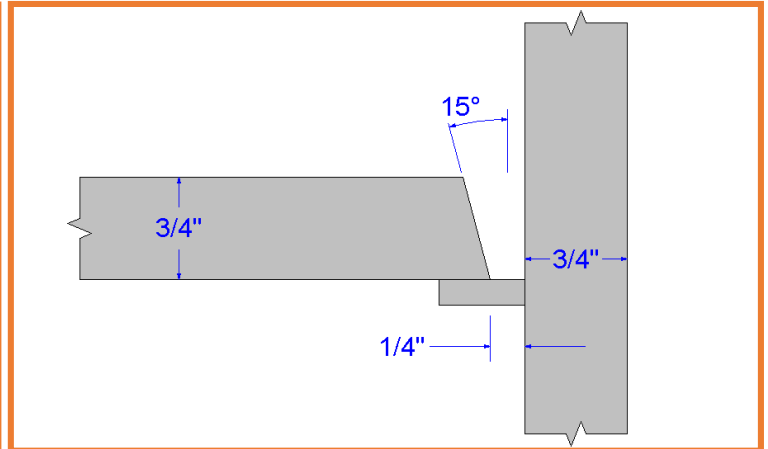


Joint Detail

Conventional

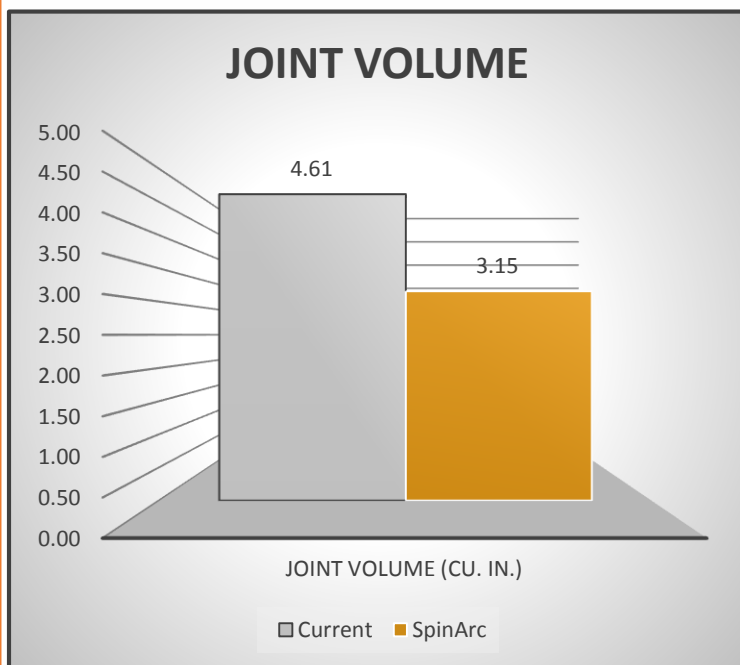


SpinArc[™]

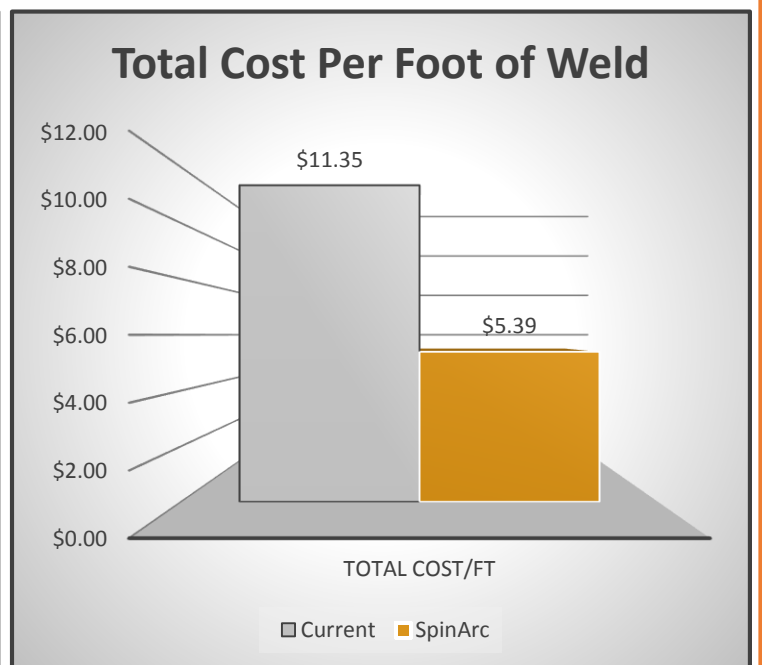


Productivity Gains From SpinArc[™]

JOINT VOLUME



Total Cost Per Foot of Weld



Based on 1500ft of weld a month and \$8,000 SpinArc System

COMPARISONS (per month)

FILLER REDUCTION	608.19	(lbs.)	ARC TIME REDUCTION	78.84	(hr.)
ESTIMATED SAVINGS	\$8,943.60		PAYBACK PERIOD	0.9	(months)

PRODUCTIVITY INCREASES

CONVENTIONAL			SpinArc™		
WELD INFORMATION					
PROCESS	GMAW		PROCESS	GMAW	
WFS (in./min.)	500		WFS (in./min.)	575	
WIRE DIAMETER	0.045		WIRE DIAMETER	0.052	
FLOW RATE (CFH)	45		FLOW RATE (CFH)	45	
CONSUMABLE COSTS					
WIRE PRICE	(\$/lb.)	\$1.10	WIRE PRICE	(\$/lb.)	\$1.10
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	0.38	(in. ²)	JOINT AREA	0.26	(in. ²) 31.6% ✓
JOINT VOLUME	4.61	(in. ³)	JOINT VOLUME	3.15	(in. ³) 31.6% ✓
FILLER REQUIRED	1.28	(lbs.)	FILLER REQUIRED	0.88	(lbs.) 31.6% ✓
DEPOSITION RATE	13.53	(lbs./hr.)	DEPOSITION RATE	20.78	(lbs./hr.) 34.9% ✓
ARC TIME	0.09	(hr.)	ARC TIME	0.04	(hr.) 55.5% ✓
GAS REQUIRED	4.26	(ft. ³)	GAS REQUIRED	1.90	(ft. ³) 55.5% ✓
FLUX REQUIRED	0.00	(lbs.)	FLUX REQUIRED	0.00	(lbs.)
WIRE COST	\$1.41	(\$)	WIRE COST	\$0.96	(\$) 31.6% ✓
GAS COST	\$0.47	(\$)	GAS COST	\$0.21	(\$) 55.5% ✓
FLUX COST	\$0.00	(\$)	FLUX COST	\$0.00	(\$)
TOTAL COST/FT	\$11.35	(\$)	TOTAL COST/FT	\$5.39	(\$) 52.5% ✓
COMPARISONS (per month)					
FILLER REDUCTION	608.19	(lbs.)	ARC TIME REDUCTION	78.84	(hr.)
ESTIMATED SAVINGS	\$8,943.60		PAYBACK PERIOD	0.9	(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	1500

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