

joint form

parameter

weld parameters

Seam length (l):	- m
Burn-in (e):	- mm
Material:	steel
Type of filler metal:	stick electrode
welding process:	
density:	- g / cm ³
correction factor:	- %
filler metal:	-
welding position:	-

physical seam parameters

Seam volume (total):	- cm ³
seam weight:	- kg
cap layer volume:	- cm ³
Volume 1:	- cm ³

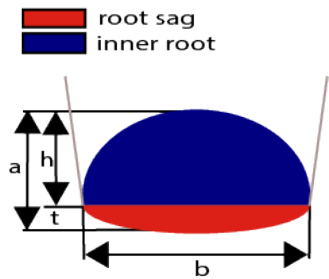
welding time

deposition rate:	- kg/h
Sum of auxiliary times:	- min
melting time:	- min
production time:	- min

seam root

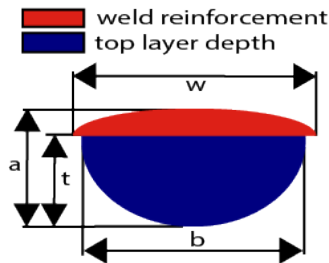
root width:	- mm
root height:	- mm

root sag: - mm



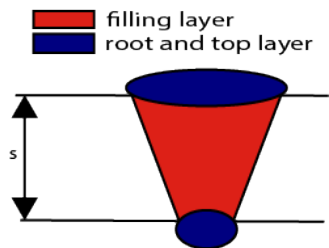
Top layer(s)

top layer width (b1): - mm
top layer depth (t1): - mm



Filling level(s) - total

Share of Hotpass in filling layers (b1): %
Do you want to divide the filling layers? (t1): no



crosscut length (lk): m
weld penetration crosscut (ek): mm
Width of the crosscut layer (b): mm
Depth of crosscut (t): mm
notch depth (h): mm
superelevation volume: cm³
Width of the crosscut position: mm
Volume of the crosscut layer: cm³

outcomes

Root layer(s): - kg
Top layer(s): - mm
Filling level(s) - total: - kg
cap position: - mm
... Hotpass: - mm
filler bead: - mm

Wages and additional costs

duty cycle: - %
contribution performance: - %
Number of employees: -
wage costs: - € / h
Price filler metal: - € - % discount
Price forming gas: - € / kg - % discount
Price Bath protection: - € / kg - % discount
Price inert gas: - € / kg - % discount
Welding powder price: - € / kg - % discount
additional costs: -

welding costs

Costs / kg SG::	- €
Total costs / kg::	- €
Weld metal costs::	- €
Total costs Pro rata::	- €
additional costs::	- € / kg
inert gas	
gas consumption:	- l / min
expenses:	- €
welding powder	
powder consumption:	- kg / h
powder consumption / kg:	- kg / (kg SG)
expenses:	- €
expenses:	- € / kg
forming gas	
Forming gas consumption:	- l / min
expenses:	- €
bath protection	
Length of bath protection:	- m
Consumption / kg:	- m / kg SG
expenses:	- €
expenses:	- € / kg
other expenses	
expenses:	- €