

### 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 <sup>3</sup>
correction factor:	- %
filler metal:	-
welding position:	-

#### physical seam parameters

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

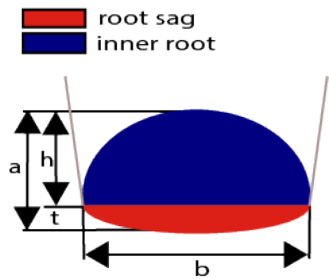
#### welding time

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

#### seam root

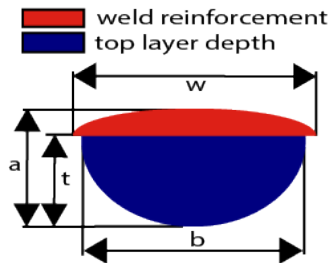
root width:	- mm
root height:	- mm

root sag: - mm



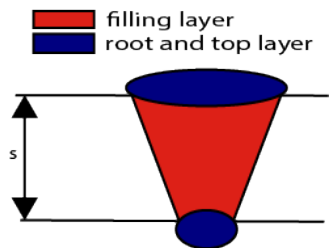
**Top layer(s)**

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: cm<sup>3</sup>  
 Width of the crosscut position: mm  
 Volume of the crosscut layer: cm<sup>3</sup>

**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
<b>inert gas</b>	
gas consumption:	- l / min
expenses:	- €
<b>welding powder</b>	
powder consumption:	- kg / h
powder consumption / kg:	- kg / (kg SG)
expenses:	- €
expenses:	- € / kg
<b>forming gas</b>	
Forming gas consumption:	- l / min
expenses:	- €
<b>bath protection</b>	
Length of bath protection:	- m
Consumption / kg:	- m / kg SG
expenses:	- €
expenses:	- € / kg
<b>other expenses</b>	
expenses:	- €