

# Weld cost-calculation on produced parts per piece

			Solid wire	Metal Cored wire
<b>FIXED DATA</b>				
Wire-price	/Kg		0	2,8
Sales-price of the welded piece	/piece		10	10
Cost-price welding robot-cell	/hour		85	85
Labour cost manual welder	/hour		30	30
2 shifts, 5d/week, 47w/year	h/y		3760	3760

<b>MEASURED DATA</b>				
Arc time	sec		56	32
Cycle time	sec		64	40
Defects per 100 pieces	%		15	1
Produced pieces per hour	# pieces/hour		42,6	68,2

<b>CALCULATED DATA</b>				
Wire-price per welded piece	/Piece		0	0,0224
Produced pieces per year	# pieces/year		160176	256282
Production cost per year	/year	Robot & Labour cost	432400	432400
	/year	Welding wire cost	0	50534,4
	/year	Gas cost	2242	2460
	/year	Add.to repair	65196	4854
	/year	Total	499839	490249
<b>Savings/year</b>	<b>/year</b>			<b>9590</b>
<b>Cost-Price per piece*</b>	<b>/piece</b>		<b>3,12</b>	<b>1,91</b>

\*Raw material and individual parts cost is equal to both and not included

The table shows that even by giving away the solid wire free of charge, the production-cost per piece has decreased with more than 38%. Due to good starting characteristics, even with big mismatches, the number of manual repairs has gone down dramatically.

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