

**Question Related to Norms & Assumptions For Piping & Structural Work:-**

1. Write the estimation for welding consumables for piping work (Groove& Fillet welding)?

Answer:-

**WELDING CONSUMABLE ESTIMATION FOR PIPING WORK WITH SINGLE V HAVING INCLUDED ANGLE OF 75 DEGREES**

WALL THICKNESS (MM)	GROOVE AREA (SQ.MM)	WELD METAL WEIGHT (kg/each dia)	ELECTRODE/FILLER WIRE CONSUMPTION (where root welding by E6010 -consumption of E6010 will be 30 gm/each dia)			
			SINGLE		COMBINATIONAL	
			GTAW	SMAW	GTAW	SMAW
4	23	15	20	26	0	0
5	33	21	28	37	10	11
6	46	29	38	51	19	25
7	59	38	50	67	19	41
8	75	48	63	84	19	59
9	91	58	77	102	19	78
10	110	70	92	123	19	98
11	130	83	110	146	19	120
12	151	97	128	171	19	145
13	174	111	147	195	19	170
14	198	127	168	224	19	190
15	224	143	189	252	19	226
16	252	161	213	293	19	259
17	281	180	238	317	19	291
18	311	199	263	350	19	323
19	343	220	290	387	19	362
20	377	241	318	424	19	398
21	412	264	348	465	19	439
22	449	287	379	505	19	479

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