HPR400XD Operating Cost Example

PLASMA	OXYFUEL
Part is 3 foot square = 12 linear feet	Part is 3 foot square = 12 linear feet
Cut 575 feet in one hour ÷12 = 48 parts	Cut 85 feet in one hour ÷12 = 7 parts
Multiply by 8 hours/day = 384	Multiply by 8 hours/day = 56
Multiply by 5 days/week = 1,920	Multiply by 5 days/week = 280
Multiply by 52 weeks/year = **99,840** parts per year	Multiply by 52 weeks/year = **14,560** parts per year

More than 6x more plasma parts cut per year than oxyfuel

Assume part is a 3 foot square. We are just trying to get a sense of how many parts are cut.

Lower Operating Cost

Operating cost = **Cost of cutting** ÷ (**linear feet cut**)

	Plasma	Oxyfuel
Cost of cutting		
% electrode & nozzle for 1 hour	$16.77	$0.06
Power	$4.14	$0.00
Gas	$7.90	$6.20
Labor & OH	$30.00	$30.00
Cost of cutting per hour	**$58.81**	**$36.26**
Divide by linear feet cut		
Linear feet =	575	85
Operating cost per foot	**$0.10**	**$0.43**

$0.10 = 4 times LOWER Operating Costs than $0.43

$16.77 = 1/2.74 cost of electrode & consumable for HPR400XD. This is based on 493 20-second starts converted to arc hours (493 x 20 ÷ 60 ÷ 60 = 2.74 arc hours. 1 arc hour = 1/2.74)

Lower Operating Cost