

Example 7.1. Determine the melting efficiency in the case of arc welding of steel with a potential of 22 V and current of 230 A. The cross-sectional area of the joint is 25 mm² and the travel speed is 6 mm/s. Heat required to melt steel may be taken as 10 J/mm² and the heat transfer efficiency as 86 percent :

Solution. Given : $V = 22$ volts, $I = 230$ amp. ; Area of cross-section of the joints, $a = 25$ mm²
Travel speed, $v = 6$ mm/s ; Heat required to melt the steel = 10 J/mm² ; Heat transfer efficiency, $\eta = 86\%$.

Melting efficiency :

$$\text{Net heat supplied} = VI \times \eta = 22 \times 230 \times 0.86 = 4351.6 \text{ W}$$

$$\begin{aligned} \text{Heat required for melting} &= \text{Volume of base metal melted} \times \text{heat required to melt the steel} \\ &= (a \times v) \times 10 \text{ J/s} \\ &= 25 \times 6 \times 10 = 1500 \text{ J/S or W.} \end{aligned}$$

$$\begin{aligned} \text{Melting efficiency} &= \frac{\text{Heat required for melting}}{\text{Net heat supplied}} \\ &= \frac{1500}{4351.6} = 0.3447 \text{ or } 34.47\% \text{ (Ans.)} \end{aligned}$$

Example 7.2. It is required to weld a low carbon steel plate by the manual metal arc welding process using a linear V-I characteristic D.C. power source. The following data are available:

Open circuit voltage of power source = 62 V

Short circuit current = 130 A

Arc length ; $L = 4$ mm

Transverse speed of welding = 15 cm/min

Voltage is given as, $V = 20 + 1.5 L$ (L being arc length in mm)

Efficiency of heat input = 84 percent.

Calculate the heat input to the workpiece.

Solution. Given $V_{oc} = 62$ V, $I_{sc} = 130$ A ; $L = 4$ mm, $v = 15$ cm/min ;
 $V = 20 + 1.5 L$, $\eta = 84\%$

Heat input to the workpiece :

Volt-amp. characteristics of source is given as :

$$\frac{V}{62} + \frac{I}{130} = 1 \quad \dots(i)$$

Here, $V = 20 + 1.5 \times 4 = 26$ volts

Substituting the value of V in eqn. (i), we get

$$\frac{26}{62} + \frac{I}{130} = 1$$

or,

$$I = 130 \left(1 - \frac{26}{62} \right) = 75.5 \text{ A}$$

$$\begin{aligned} \text{Now, Power consumed} &= VI \\ &= 26 \times 75.5 = 1963 \text{ W} \end{aligned}$$

$$\begin{aligned} \therefore \text{Heat input into the workpiece} &= 1963 \times \eta = 1963 \times 0.84 = 1648.9 \text{ W (Ans.)} \end{aligned}$$

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1. Understanding the eBook Practical Problems In Mathematics For Manufacturing
 - The Rise of Digital Reading Practical Problems In Mathematics For Manufacturing
 - Advantages of eBooks Over Traditional Books
2. Identifying Practical Problems In Mathematics For Manufacturing
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Practical Problems In Mathematics For Manufacturing
 - User-Friendly Interface
4. Exploring eBook Recommendations from Practical Problems In Mathematics For Manufacturing
 - Personalized Recommendations
 - Practical Problems In Mathematics For Manufacturing User Reviews and Ratings
 - Practical Problems In Mathematics For Manufacturing and Bestseller Lists
5. Accessing Practical Problems In Mathematics For Manufacturing Free and Paid eBooks
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 - Practical Problems In Mathematics For Manufacturing eBook Subscription Services
 - Practical Problems In Mathematics For Manufacturing Budget-Friendly Options
6. Navigating Practical Problems In Mathematics For Manufacturing eBook Formats

- ePub, PDF, MOBI, and More
- Practical Problems In Mathematics For Manufacturing Compatibility with Devices
- Practical Problems In Mathematics For Manufacturing Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Practical Problems In Mathematics For Manufacturing
 - Highlighting and Note-Taking Practical Problems In Mathematics For Manufacturing
 - Interactive Elements Practical Problems In Mathematics For Manufacturing
- 8. Staying Engaged with Practical Problems In Mathematics For Manufacturing
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Practical Problems In Mathematics For Manufacturing
- 9. Balancing eBooks and Physical Books Practical Problems In Mathematics For Manufacturing
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Practical Problems In Mathematics For Manufacturing
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Practical Problems In Mathematics For Manufacturing
 - Setting Reading Goals Practical Problems In Mathematics For Manufacturing
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Practical Problems In Mathematics For Manufacturing
 - Fact-Checking eBook Content of Practical Problems In Mathematics For Manufacturing
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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