

Estimation for Laser Cladding of the Compressor Rotor

S. No.	ITEM	Machine hourly rate (Rs.)	Machining Hours	Machining Rate (Rs.)
1	Pre machining before laser cladding	750	1.5	1125
	Total Initial pre-machining cost			1125

Based on the two budgetary offers received from the probable vendors			
		L1 Quote (Rs.)	80% of Quoted value
2	Process qualification charges	50,000	40,000
3	Laser Cladding	1,18,000	94,400
	Post finish machining		
	Grinding		
	NDT after cladding		
Total Laser cladding cost including Pre machining, Laser cladding & Post machining as per the steps 1, 2 & 3 of the drawing 33320904013-00 (in Rs.)			135,525

Note: The Laser Cladding facility is not available in house. To evaluate the estimation for the same, budgetary offers were taken from probable vendors.