

conticast

HORIZONTAL CONTINUOUS CASTER OPERATING COSTS

FIGURES BASED ON PRODUCTION OF FORGING AND MACHINING BRASS CDA37700 (Cu58Pb2Zn40) IN 100mm DIA. SOLID BAR.
WORKING BASIS - 5 DAY / 24 HOUR WORKING WEEK, 46 DAYS PER YEAR - COSTS IN \$ U.S. DOLLARS

COMPARISON EXAMPLE: COMBINED MELTING & HOLDING WITH PRODUCTION RATE OF 200kg PER HOUR
ANNUAL PRODUCTION - 1000 METRIC TONNES

	REF700-900 OIL	REF700-900 GAS	REF700-900 NAT. GAS	REF700-900 ELECTRIC
FUEL	120kWH \$2.95	120kWH \$3.40	120kWH \$2.26	75kWH \$8.25
NITROGEN	\$0.11	\$0.11	\$0.11	\$0.53
DIES	\$1.88	\$1.88	\$1.88	\$1.88
CRUCIBLE	\$0.98	\$0.49	\$0.49	\$1.45
GRAPHITE HEATERS	NIL	NIL	NIL	\$1.09
TOTAL COST PER 1000kg	\$29.60	\$29.40	\$23.70	\$66.00
ANNUAL SAVING OVER ELECTRIC	\$36,400.00	\$36,600.00	\$42,300.00	

BASED ON COSTS AS FOLLOWS :-
ELECTRICITY - \$0.11 / kWH
NATURAL GAS - \$0.019 / kWH
PROPANE - \$0.37 / LITRE (1 LITRE = 13.07 kWH)
OIL - \$0.30 / LITRE (1 LITRE = 12.22 kWH)
NITROGEN - \$0.53 . CUBIC METRE