

**ERIE COUNTY TECHNICAL SCHOOL
PROPOSED AGENDA ITEM**

DATE: October 27, 2005

SUBJECT: Welding Equipment Lease

CATEGORY: Operations

INITIATED BY: Aldo Jackson

DESCRIPTION: Employment opportunities for welders in Erie County is projected to be very high (See Erie Regional Chamber survey). We are also working with three companies (Custom Engineering, McShane Welding and Riley Power) and two agencies (Workforce Investment Board and Industrial Resource Center) to provide a 160-hour welding training program. The training capacity in Erie County is virtually maximized. The projected job openings and the limited capacity necessitate the need for additional training space and equipment. This proposed lease of equipment will allow the Erie County Technical School and the Regional Career & Technical Center to open a welding laboratory in the Skill Center.

RECOMMENDATION: Motion to approve a lease with General Welding Supply for twelve power sources at a monthly rate of \$4,155.85 for 12 months (total expense of \$49870.08), contingent upon ECTS entering into a training contract.

3. Indicate the number of welders in each category you will need in the next year												
CNC Plasma Cutting	1	1										2
Air Carbon Arc Cutting	0											0
Oxy-fuel brazing and welding and cutting	2	2										4
Basic Plate and Sheet Metal Welding	45	1	12	1	10							69
Plasma, Oxy-Fuel, Alloy and Hardfacing Welding	0											0
Pipe Welding	1	2										3
Gas Tungsten Arc Welding (GTAW - TIG)	40	15	2	1	3	1	2	2	10			76
Gas Metal Arc Welding (GMAW-MIG)	10	2	4	6	2	10						34
Flux-Cored Arc Welding (FCAW)	45	2	15	20	10							92
Submerged Arc Welding (SAW)	0											0
Comprehensive Arc Welder	0											0
Certified Welding Inspector Training	0											0
Basic Motor Sports Welding	0											0
Advanced Motor Sports Welding	0											0
Maintenance Welding	0											0
Stick Welding	15	10										25
MIG Welding Horizontal	10	3	3									16
MIG Welding Vertical	3	10										13
MIG Welding Overhead	3											3
TIG Welding	45	1	1	10								57
TOTAL***												394

***Note: The total number is most likely the result of double counting by some of the companies. They need welders that will need to know how to do more than one type of welding

XMT® Series 304 CC/CV, 350 CC/CV, 350 VS and 456 CC/CV

See Literature No. DC/18.8

The multiprocess XMT family combines the advantages of inverter-based power with the built-in features and productivity of high-end MIG machines.



Wind Tunnel Technology™ protects electrical components and PC boards from contamination.

Fan-On-Demand™ cooling system operates only when needed, reducing noise, energy use and amount of contaminants pulled through machine.

Lift-Arc™ allows TIG starting without the use of high-frequency. Starts the arc without contaminating the weld with tungsten.

Adaptive Hot Start™ increases the output amperage at the start of a weld if necessary, eliminating electrode sticking.

Inverter arc control technology provides greater puddle control for superior 6010 Stick electrode performance.

Line voltage compensation keeps power constant even if power input varies by ±10%. XMT 350 models further expand line voltage compensation to an amazing +37% and -59% when operating on 460 VAC.

Process selector switch reduces the number of control setup combinations without reducing any features.

Large, dual digital meters are easy to view and presettable to ease setting weld output.

Pulsed MIG capabilities with optional Optima™ control reduces spatter and distortion, allows better out-of-position puddle control, and provides potential reduction of fume particle emission. *Not available on XMT 350 VS.*

Lightweight, aerospace-grade aluminum case offers protection with the benefit of reduced weight.

115 VAC auxiliary power provides 10 amps of circuit-breaker-protected power for water circulators, etc. *Standard on XMT 456, optional on XMT 304 and XMT 350 CC/CV. Not available on XMT 350 VS.*

Heavy Industrial

	XMT 304 CC/CV
	XMT 350 CC/CV
	XMT 350 VS
	XMT 456 CC/CV

Processes

- MIG (GMAW)
- Pulsed MIG (GMAW-P)*
- Stick (SMAW)
- TIG (GTAW)
- Pulsed TIG (GTAW-P)*
- Flux Cored (FCAW)
- Air Carbon Arc Cutting and Gouging (CAC-A) (304: 1/4 in carbons) (350: 5/16 in carbons) (456: 3/8 in carbons)

*With optional controls only — not available with XMT 350 VS model.

XMT 304 & 350 CC/CV MIGRunner™ Come Complete With

- XMT 304 or 350 CC/CV
- 22A wire feeder
- Roughneck® C-4015 MIG gun
- Consumables
- .035 and .045 in drive roll kit
- Regulator/flow gauge with gas hose
- Factory-installed running gear/cylinder rack

XMT 350 XR-Edge & XR-A Python® MIGRunner™, & XR-Edge PULSERunner Come Complete With

- XMT 350 CC/CV
- XR-Control
- Air-cooled XR-A Edge or Python gun
- Consumables
- Drive roll kit (XR-Edge only)
- Regulator/flow gauge with gas hose
- Factory-installed running gear/cylinder rack
- Optima™ Pulse control (PULSERunner only)

Python® is a registered trademark of MK Products, Inc.

*Duty cycle rating below achieved with 6 gauge input power cord (8 gauge cord supplied with unit).

Model	Stock Number	Input Power	Amperage/Voltage Range	Rated Output	Amps Input at Rated Load Output, 60 Hz	Max. Open-Circuit Voltage	Dimensions	Net Weight
XMT 304 CC/CV (w/Dinse)	#903 471) 208-230/460 V #903 471-01-1) 208-230/460 V w/Aux. Pwr. #903 473) 460/575 V #907 061) 208/230/460 V MIGRunner	Three-Phase	CC Mode: 5–400 A CV Mode: 10–35 V	300 A at 32 VDC, 60% Duty Cycle	33.7 30.5 17 18.9 15.2 12.2 11.6	90 VDC	H: 17 in (432 mm) W: 12½ in (318 mm) D: 24 in (610 mm)	79.5 lb (36.1 kg)
		Single-Phase		225 A at 29 VDC, 60% Duty Cycle	52.4 47.4 — 24.5 — 11.3 7.6			
XMT 350 CC/CV (w/Dinse)	#907 161) 208–575 V #907 161-01-1) 208–575 V w/Aux. Pwr. #907 233) 208–575 V MIGRunner #907 234) 208–575 V XR-Edge MIGRunner #951 033) 208–575 V XR-Edge PULSERunner #907 235) 208–575 V Python® MIGRunner	Three-Phase	CC Mode: 5–425 A CV Mode: 10–38 V	350 A at 34 VDC, 60% Duty Cycle	40.4 36.1 20.6 17.8 14.1 14.2 13.6	75 VDC	H: 17 in (432 mm) W: 12½ in (318 mm) D: 24 in (610 mm)	80 lb (36.3 kg)
		Single-Phase		300 A at 32 VDC, 60% Duty Cycle*	60.8 54.6 29.7 25.4 19.9 11.7 11.2			
XMT 350 VS (w/Tweco®)	#907 224) 208–575 V (CC/CV inverter ideal for construction — no remote control)	Three-Phase	CC Mode: 5–425 A CV Mode: 10–38 V	350 A at 34 VDC, 60% Duty Cycle	40.4 36.1 20.6 17.8 14.1 14.2 13.6	75 VDC	H: 17 in (432 mm) W: 12½ in (318 mm) D: 24 in (610 mm)	80 lb (36.3 kg)
		Single-Phase		300 A at 32 VDC, 60% Duty Cycle*	60.8 54.6 29.7 25.4 19.9 11.7 11.2			
XMT 456 CC/CV (w/Stud ½")	#907 010) 230/460 V #907 011) 575 V	Three-Phase	CC Mode: 5–600 A CV Mode: 10–38 V	450 A at 38 VDC, 100% Duty Cycle; 565 A at 43 VDC, 60% Duty Cycle	— 50.8 31 27.8 24.4 21.2 19.2	95 VDC	H: 17 in (431 mm) W: 14½ in (368 mm) D: 26 in (660 mm)	118 lb (53.5 kg)

Call 1-800-4-A-MILLER for more information.

XMT 304 CC/CV Additional Features

Auto-Link® circuit automatically links the power source to primary voltage being applied (230/460 or 460/575 VAC, single- or three-phase).

Ultra-tough, polycarbonate-blended cover for control panel protects front controls from damage.

XMT 350 Additional Features

Available in two styles — CC/CV and VS.

VS model is capable of both CV and CC operation and has a simple four-position front panel *without remote control receptacle. Ideal for construction.*

AUTOLINK® Power Management Technology Allows for any input voltage hook-up (208–575 V) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable input power.

XMT 456 CC/CV Additional Features

Unique case design helps protect internal components from dirt and dust. To connect input power cord and/or set unit up for correct input power, remove the easy-to-handle panel (1/3 case). The remaining two-thirds of the case never needs to be removed!

Optional XMT 304 and 350 CC/CV Packages

Factory-complete welding packages are capable of housing two gas cylinders, optional water cooler, all in the most floor-space efficient, and maneuverable cart offered.



XMT 304 MIGRunner™ (#907 061 shown)
XMT 350 MIGRunner™ (#907 233)



XMT 350 XR-Edge MIGRunner™ (#907 234 shown)
XMT 350 XR-A Python® MIGRunner™ (#907 235)
XMT 350 XR-Edge PULSERunner™ (#951 033)

Note: Cart is for use with XMT 304/350 models only.

International-style weld disconnects provide high-quality weld cable connections. (Two connectors supplied with each unit.)

Reduced OCV operation — an internal dip switch enables reduced open-circuit voltage Stick welding capability. OCV is typically below 15 volts.

Auto Remote Sense enables unit to automatically use remote control if connected to remote control receptacle (CC/CV models only).

Optional gas solenoid for TIG welding.

Primary voltage display shows what primary voltage the power source is set for without removing the side panels. Saves time and assures you that the power source has been correctly set for available input voltage.

Optional remote on/off provides ability to turn power source on or off when it is located away from your work.

Most Popular Accessories for non-VS Models

- SuitCase™ 8RC/12RC Wire Feeder #194 938/#194 940 (pg 56)
- Spoolmatic® 30A Spool Gun/WC-24 #130 831/#137 549 (pg 58)
- XR™-Control Wire Feeder #181 538 (pg 59)
- 22A Wire Feeder #193 066 (pg 60)
- Optima™ MIG Pulse Control #043 389 (pg 77)
- PC-300 Pulsed TIG Control #042 297 (pg 80)
- RCC-14 Remote Control #151 086 (pg 80)
- RCCS-14 Remote Control #043 688 (pg 80)
- RFCS-14 Remote Control #043 554 (pg 80)
- RFCS-14 HD Remote Control #194 744 (pg 80)
- RHC-14 Remote Control #129 340 (pg 80)
- RMLS-14 Remote Control #129 337 (pg 80)
- Current Sensor (XMT 456 only) #194 807 (Field)

Most Popular Accessories for VS Model

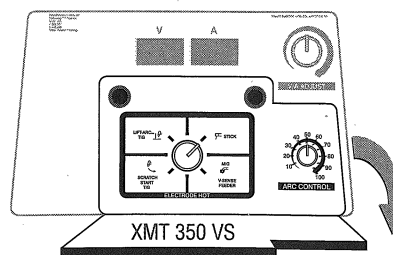
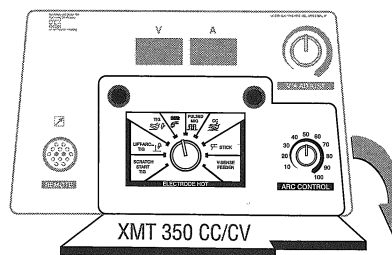
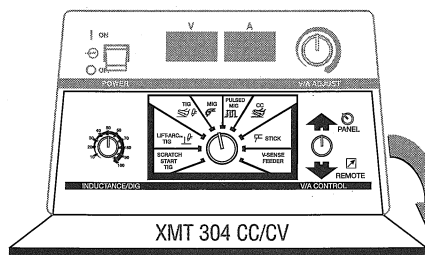
- SuitCase™ 8VS/X-TREME™ 12VS #194 890/#195 500 (pg 55)
- Spoolmatic® 30A Spool Gun/WC-115A (with contactor) #130 831/#137 546-01-1 (pg 58)

Most Popular Accessories for all Models

- XMT® Rack (pg 40)
- Cylinder Cart #042 537 (pg 72)
- MIGRunner™ Cart (XMT 304/350 only) #195 445 (pg 73)
- MIGRunner™ XL Cart #195 246 (pg 73)
- (shown with XMT 456, wire feeder and coolant system — sold separately)
- Universal Cart and Cylinder Rack (XMT 304/350 only) #042 934 (pg 73)
- Coolmate™ Coolant System (pg 74)
- Protective Cover (XMT 304/350 only) #195 478 (pg 80)

See your Miller distributor for other popular Miller options and accessories.

Drop-Down Panels Easy-to-use controls are “under the covers” of the XMT 304 CC/CV, XMT 350 CC/CV and XMT 350 VS.



GENERAL

Welding Supply
Erie

DISTRIBUTORS OF
Industrial Gases, Welding and Industrial Supplies

1313 CHESTNUT STREET • ERIE, PA 16501
PHONE (814) 453-5637 • FAX (814) 456-5914

October 21, 2005

Erie County Technical School

Attn: Aldo Jackson, P.H.D.

Dear Sir,

Thank you for the opportunity to be involved in the start-up of a much needed welder training program for the Northwestern PA area. We are pleased to quote the following Miller equipment.

- 10 ea. Miller 304XMT packages consisting of XMT 304 power supply, feeder, drive roll kit, 15 ft. mig gun, 12 ft. tig torch, regulator/flowmeter, all innerconnecting cables, ground cable with clamp and electrode holder with cable.
- 2 ea. Miller 456XMT packages for mig and fluxcore with same as above.

We, also, will offer you 3,000 lbs. of Hobart solid and fluxcore mild steel wire to be mixed as you might need it at - **No charge.**

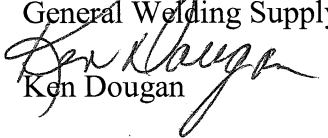
Gases for 40 hours of training - **No charge**

Your cost - \$4,155.84 for 12 months.

At the end of that time we will donate this equipment to the school.

If you have any questions concerning the above or if I can be of any further help, please do not hesitate to contact me.

KD/ct

Very truly yours,
General Welding Supply

Ken Dougan