



Due Date: 09/08/2023

Sold To: TRADE CONSTRUCTION COMPANY, L.
17043 JOOR ROAD, SUITE A
ZACHARY, LA 70791
United States

Ship To: TRADE CONSTRUCTION COMPANY, L.
, LA 70791
United States

Order No: 231180

Customer: TRADE400390

Ship Via: MASON.COCKERHAM@TRADEC

Part Number: *3TE3612Y

Description: TE 36X12 .750 X .375-
WPHY70

MSSSP75-14

Dated: 06/20/2023

PO Num: 232013A202

Priority: 3 - STANDARD

Product Code: TEE

Master Job No:

Quote No:

Total Qty Open: 6 EA

Qty Posted: 0 EA

Qty To Make: 6

Start Date: 07/24/2023

Contact: MASON COCKERHAM

Phone: 225-570-8941 (Direct)

Fax:

Job Notes

BCNM
B10801
PIPE SHOP TRAVELER 218-2023, ALL ALLOCATED, NO SCRAP

Routing

Routed By:

Quantity 6

Step No	Work Cntr / Vendor		Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Description	Time	Time	Time	Per Hour	Start	End	Quantity
10	PIPE 3 PLATE BURN	Burning Table Plate Burn					07/24/2023	07/24/2023	6
									
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					07/27/2023	07/27/2023	6
									
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller					07/27/2023	07/27/2023	6
									

40	PIPE 7 STRING UP	Initial Weld String-up	07/27/2023 07/27/2023	6
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	07/31/2023 07/31/2023	6
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	07/31/2023 07/31/2023	6
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	08/01/2023 08/01/2023	6
				
80	PIPE 9 OD WELD	OD Weld OD Weld	08/03/2023 08/03/2023	6
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/08/2023 08/08/2023	6
				
100	FORGE 8 TRIM	Torch Cut Cut hole	08/29/2023 08/29/2023	6
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	08/29/2023 08/30/2023	6
				
120	FORGE 8 TRIM	Torch Cut Trim	08/30/2023 08/31/2023	6
				



140

FORGE 5-6
FORGE BLAST

Forge Shotblast
Shot blast

01/11/2024 01/11/2024

6



150

PIPE 13
X RAY

Pipe X Ray
X-ray

01/11/2024 01/15/2024

6



160

E1
MACHINING

E1 Extender
Expander

01/15/2024 01/15/2024

6



170

M1
MACHINING

M1 Big Mill
Machining

01/15/2024 01/18/2024

6



180

STAMP 1
STAMP

Stamping

01/18/2024 01/18/2024

6



190

INSPECT 1
INSPECTION

Inspection 1

01/18/2024 01/18/2024

6



200

SHIPPING
SHIPPING

Shipping

01/18/2024 01/18/2024

6



Time per Piece (HR):	0.00	0.00	0.00	0.00
Total Time for Job (HR):	0.00	0.00	0.00	

Materials List

Quantity				Quantity: 6		
Needed	On Hand	Posted	Short	Unit	Description	Sub-Assy Vendor
15,945.00000	894,144.00000	15,945.00000	0.00000	LB	0PL125633	NO CLIFF STEEL
				PL0 1.25-A633-E		
				Quantities from Bins/Lot Number:		
				BCNM-08 (15945.0)		

Pipe Shop Traveler Tee Cyl.

218-2023

7/14/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	TRADE	SFI Order No	231180-20	Due Date	7/28/2023
Part	39.000 OD X 1.250 X 112.000			Ship Date	9/8/2023
Plate Size	1.250 X 118.595 X 112.000			NoPcs	3
Heat No.	R2914			Code	BCNM-08
Material	A633E	Test Material		Test No	

Cut 3 Plate(s) 1.250 X Thick X 118.595 Width X 112.000 Length 4709 Lbs.
Per Sketch #

From (1) Plate(s) 1.250 Thick X 130.000 Wide X 346.000 Long

Stamp Plates With Heat Code BCNM-08

Scarf to 118.595 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 39.000 " O.D.

Tack Weld Using 5/32 " Dia. E9018M Electrodes Per Procedure # SMAW-HSLA-132-REV. 1

Use Weld Procedure SAW-HSLA-101-REV. 11

Weld I.D. Using 3/16 " Dia. LINCOLN LA-85 Wire and LINCOLN 888 Flux.

Backgouge to Sound Metal and Condition Grind O.D. Weld Groove

Weld O.D. Using 3/16 " Dia. LINCOLN LA-85 Wire and LINCOLN 888 Flux.

Hot Reroll to Roundup

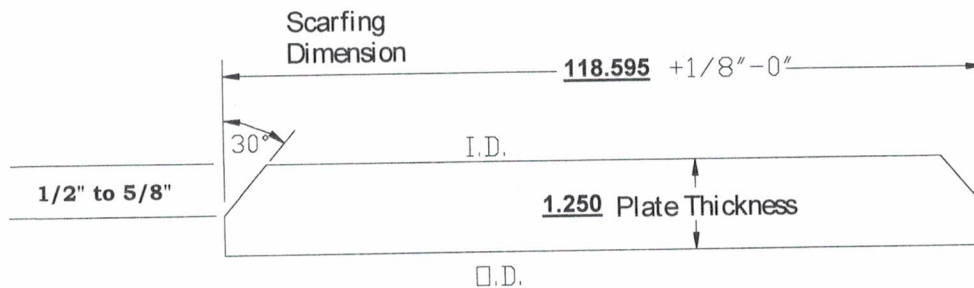
Torch Cut Into 2 Pcs @ 112 Inches

Paint Mark on Cylinder TRADE 231180-20

Stamp Each Cylinder in (2) Places With Heat Code BCNM-08

Fitting Description: (6)TE 36X12 Y70

Comments:

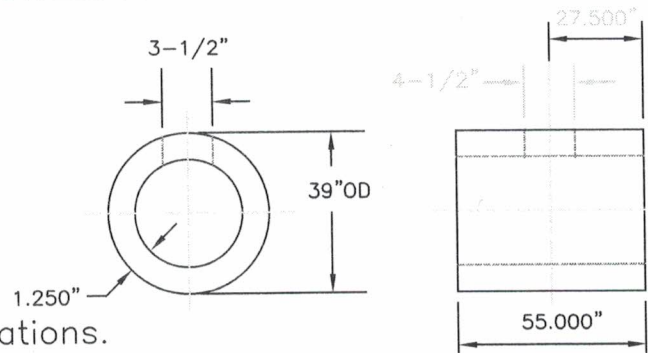


36" Run Diameter = 36.542"

12" Outlet Diameter = Free pull in 36 x 18 dies

Material Size 39" O.D. x 1.250"W
Length 55.000"

Hole size 3-1/2"x4-1/2" oval
Grind 1/8" radius on hole edges
I.D. & O.D.



SHOP NOTE: Cut hole after barreling operations.

Ovaling Data: Oval: HOT Oval width: 35-3/4"±1/4"

Preform Data:

Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50082 with 36x18" Insert #50090

1st Oper: Heat to 1650°F.—Quench in 23-1/2" of water.

Barrel down HOT with HOT side up. Close dies to 3";

2nd Oper: Re-heat to 1650°F. Quench barreled side in 21-1/2" of water &
barrel down HOT with HOT side up. Close dies.

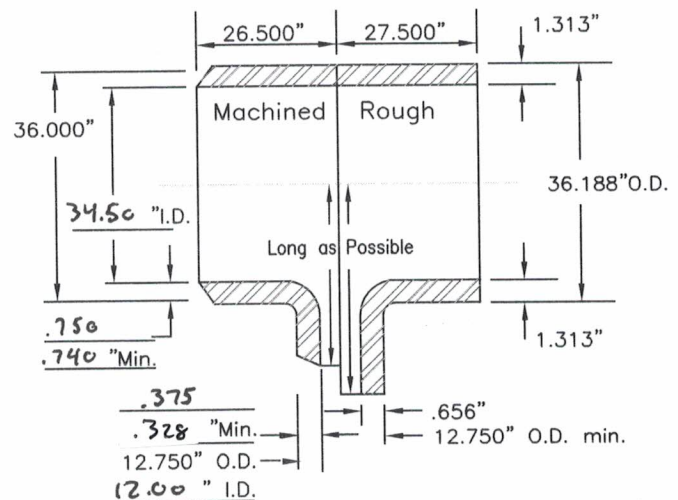
3rd Oper: Cut outlet hole per above

4th Oper: Locally heat outlet area with
torches & Free pull 6.750"
plug(3" rod)

5th Oper: Locally heat outlet area with
torches & Free pull 8-3/4"
plug(3-1/2" rod)

6th Oper: Locally heat outlet area with
torches & Free pull 10-3/4"
plug(3-1/2" rod)

7th Oper: Locally heat outlet area with
torches & Free pull 11-3/4"
plug(3-1/2" rod)



SHOP NOTE: OUTLET MAY REQUIRE END SIZING

REV	DESCRIPTION	BY	DATE
1	changed pin sequence	jl	7/7/16

DATE: 11-18-99

SCALE: NONE

DRAWN BY: J.D.

CHECKED BY: Bull

36 x 12"

.750 x .375

HIGH YIELD
TEE MFG. DATA

DWG#

36-12-4

Use for bevel thicknesses:
Run—.751" thru .833".
Outlet—.593" and less.

FORM BY EXTRUSION PER CARD: _____

PRE CUT ENDS

IF ORDER SIZE IS LARGER THAN FURNACE LOAD, SERIALIZE UNDER CUTTER STAMP PRIOR TO HEAT TREAT

HEAT TREATMENT PER QCP 8.1 REV.1: (WITH TEST MAT'L B- _____)

HEAT TREAT 3/4 HR @ 1650°F **WATER QUENCH** FURNACE LOAD # _____

TEMPER 1 1/4 HR @ 1100 °F - AIR COOL - FURNACE LOAD# _____

SHOTBLAST TO NEAR WHITE FINISH

100% RADIOGRAPH WELD SEAM PER SPEC. XL-RT-100 (LATEST REVISION) _____

MACHINE PER MSS-SP75-14

BORE RUN I.D. STRAIGHT TO: 33.750 + 1/4 -0 34.500
0.750
0.740

BORE OUTLET I.D. STRAIGHT TO: 11.750 ± 1/16 12.000
0.375
0.328

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE