Job Traveler

Job Number: 231180-27

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 **Dated:** 06/20/202 **Quote No:**

Customer: TRADE400390 **PO Num:** 232013A202

Ship Via: MASON.COCKERHAM@TRADEC **Priority:** 3 - STANDARD

Part Number: *3TE4236Y **Product Code:** TEE

Description: TE 42X36 1.00 X .875-WPHY65
W/BARS
MSSSP75-14

Master Job No:

Total Qty Open: 6 EA **Qty Posted:** 0 EA **Qty To Make:** 6

Start Date: 07/12/2023 **Phone:** 225-570-8941 (Direct)

Contact: MASON COCKERHAM **Fax:**

Job Notes

(4) BCOJ B10838 (2)BCLF B10611 2 DIFFERENT QR CODES
PIPE SHOP TRAVELERS 226, 227-2023

Routing

Routed By: **Quantity** 6

Step No / Dept	Work Cntr / Vendor / Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- Start	End	Run Quantity
10	PIPE 3 PLATE BURN	Burning Table Plate Burn					07/12/2023	07/13/2023	6
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					07/17/2023	07/17/2023	6
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller					07/18/2023	07/18/2023	6

40	PIPE 7 STRING UP	Initial Weld String-up	07/19/2023	07/19/2023	6
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	07/20/2023	07/20/2023	6
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	07/20/2023	07/20/2023	6
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	07/24/2023	07/24/2023	6
80	PIPE 9 OD WELD	OD Weld OD Weld	07/26/2023	07/26/2023	6
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/03/2023	08/03/2023	6
100	FORGE 8 TRIM	Torch Cut Cut hole	08/30/2023	08/30/2023	6
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	08/30/2023	08/30/2023	6
120	FORGE 8 TRIM	Torch Cut Trim	09/12/2023	09/13/2023	6

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/19/2024	02/20/2024	6
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/20/2024	02/21/2024	6
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/21/2024	02/21/2024	6
160	E1 MACHINING	E1 Extender Expander	02/21/2024	02/21/2024	6
170	M1 MACHINING	M1 Big Mill Machining	02/21/2024	02/27/2024	6
180	PIPE 11	Special Welds Bars	02/27/2024	03/07/2024	6
190	FAB 8 GRINDING	Fab Grind Grinding Bars	03/07/2024	03/11/2024	6
200	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	03/11/2024	03/12/2024	6
210	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	03/12/2024	03/13/2024	6

220	PIPE 13 X RAY	Pipe X Ray ME inspection of weld	03/13/2024	03/13/2024	6
230	STAMP 1 STAMP	Stamping	03/13/2024	03/13/2024	6
240	INSPECT 1 INSPECTION	Inspection 1	03/13/2024	03/13/2024	6
250	SHIPPING SHIPPING	Shipping	03/13/2024	03/13/2024	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: 6

Quantity							
Needed	**On Hand**	**Posted**	**Short**	**Unit**	**Description**	**Sub-Assy**	**Vendor**
19,541.00000	131,115.00000	19,541.00000	0.00000	LB	0PL15633 PL0 1.5-A633-E Quantities from Bins/Lot Number: BCLF-04 (8311.0) BCOJ-01 (11230.0)	NO	CLEVELAND -CL

BCLF
42X36
1.0X.875
WPHY65
231180-27

BCOJ
42X36
1.0X.875
WPHY65
231180-27

Pipe Shop Traveler Tee Cyl.

226-2023
7/10/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	TRADE	SFI Order No	231180-27	Due Date	8/11/2023
Part	48.000 OD X 1.500 X 64.000			Ship Date	9/8/2023
Plate Size	1.500 X 146.084 X 64.000			NoPcs	4
Heat No.	R2915			Code	BCOJ-01
Material	A633E	Test Material	CUT (2)6X12 FOR 12X12	Test No	10838

Cut 4 Plate(s) 1.500 X Thick X 146.084 Width X 64.000 Length 3977 Lbs.

Per Sketch #

From (1) Plate(s) 1.500 Thick X 132.000 Wide X 360.000 Long

Stamp Plates With Heat Code BCOJ-01

Scarf to 146.084 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 48.000 " 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 0 Pcs @ 0 Inches

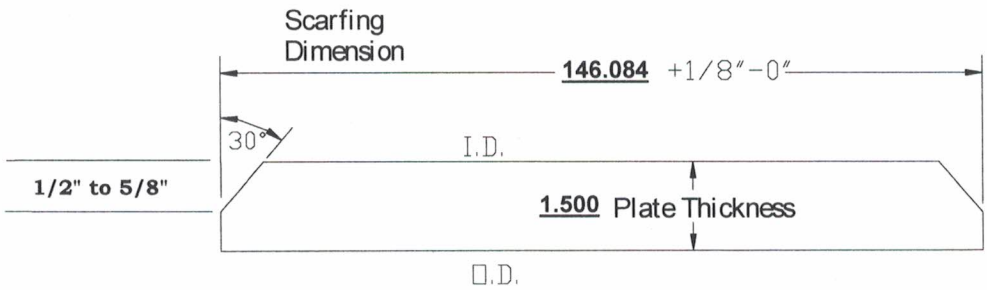
Paint Mark on Cylinder TRADE 231180-27

Stamp Each Cylinder in (2) Places With Heat Code BCOJ-01

Fitting Description: (4) TE 42X36 Y65WB

Comments: NO SCRAP, ONLY RECORD THE REMAINING DROP

11230



Pipe Shop Traveler Tee Cyl.

227-2023
7/10/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	TRADE	SFI Order No	231180-27	Due Date	8/16/2023
Part	48.000 OD X 1.500 X 64.000			Ship Date	9/8/2023
Plate Size	1.500 X 146.084 X 64.000			NoPcs	2
Heat No.	R1537			Code	BCLF
Material	A633E	Test Material		Test No	

Cut 2 Plate(s) 1.500 X Thick X 146.084 Width X 64.000 Length 3977 Lbs.

Per Sketch # 6144

From (1) Plate(s) 1.500 Thick X 132.000 Wide X 221.000 Long

Stamp Plates With Heat Code BCLF

8341

Scarf to 146.084 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 48.000 " 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

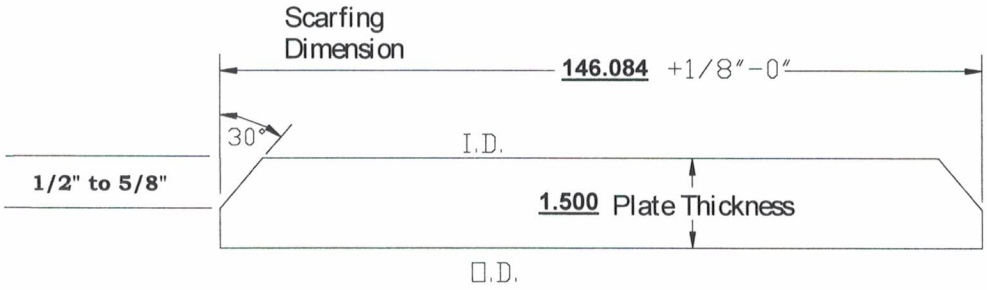
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder TRADE 231180-27

Stamp Each Cylinder in (2) Places With Heat Code BCLF

Fitting Description: (2) TEE 42X36 Y65 WB

Comments: NO SCRAP, RECORD ONLY THE REVISED DROP SIZE

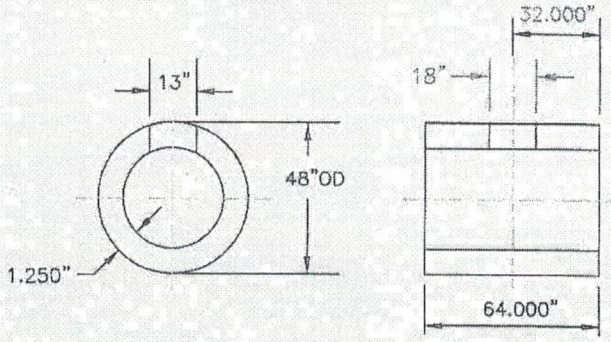


42" Run Diameter = 42.785"
36" OUTLET DIAMETER = 36.876

Material Size 48" O.D. x 1.500 "W
Length 64.000"

Ovaling Data: Oval HOT to: 42"±1/4"

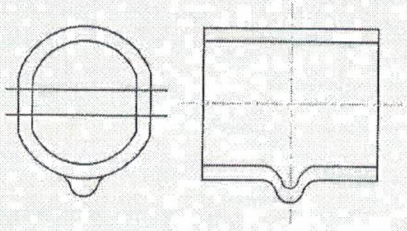
Hole size —torch cut 13"x18" oval
Grind 1/8" radius on hole edges
I.D. & O.D.



Preform Data:
Press: Machine 2000 Ton Set up#10140 Upper Die# 50048
Lower Die# 50095

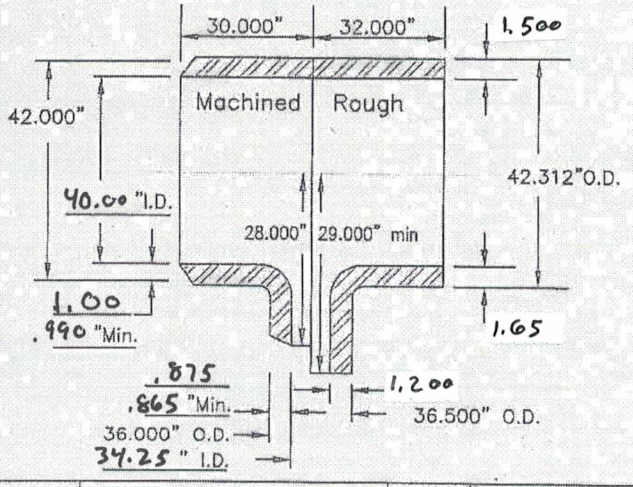
1st Oper: Heat to 1650°F.
Quench in 31 inches of water.
Close dies to 5–1/2" and
Pull 20.000" dia. plug (4" pull rod).

2nd Oper: Re–heat to 1650°F.
Quench in 27 inches of water
Close dies to 1–1/2" and
Pull 25.150" plug (4" pull rod).



3rd Oper: Re–heat to 1650°F.
Do not quench
Close dies hot and
Pull 31.593" dia. plug
(6" pull rod)

Final Operation: Free pull in 42" straight
bottom die# 50042
Re–heat to 1650°F.
Do not quench
Free pull 33.800"dia. plug
(6" pull rod)



SHOP NOTE: Outlet will require end sizing.

REV	DESCRIPTION	BY	DATE

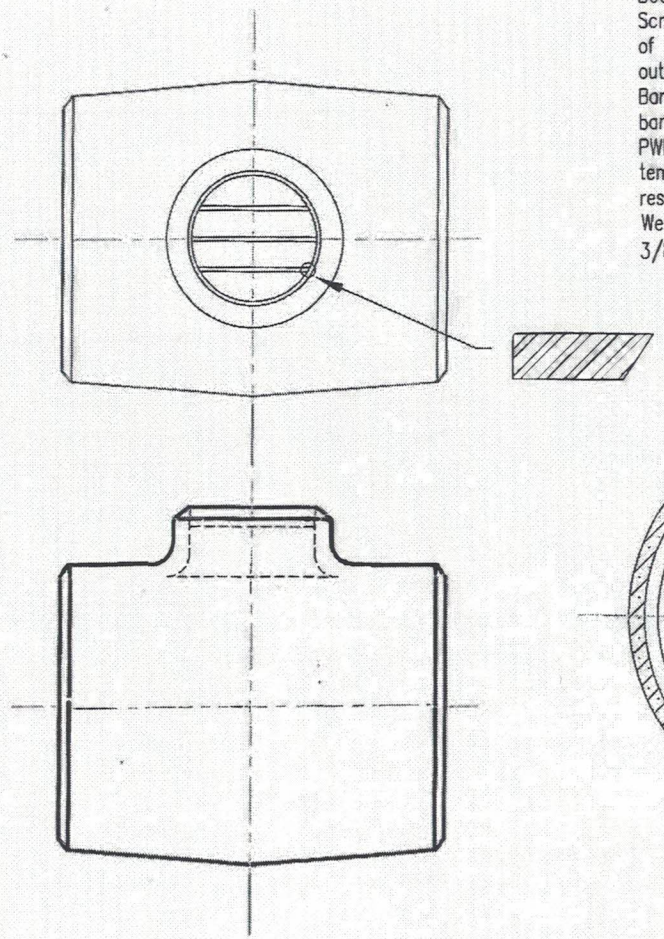
DATE: 12–10–99
SCALE: NONE
DRAWN BY: J.D.
CHECKED BY: Bull

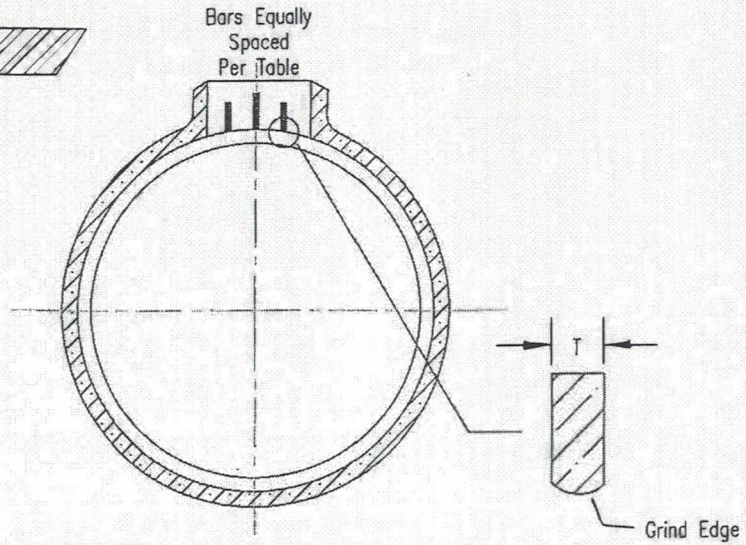
42 x 36"
1.00 x .875
HIGH YIELD
TEE MFG. DATA

DWG#
42–36–2

Use for bevel thicknesses:
Run- .867" thru .8331.
Outlet- .750" max.

Notes:
Bottom of scraper bars to have corners broken smooth with no burrs or sharp edges.
Bottom of scraper bars to be flush with inside radius of tee.
Scraper bars to be made from carbon steel having a minimum yield of 36,000 PSI and are to be welded to the inside surface of tee outlet by means of a continuous full fusion weld along contact area. Bars shall be beveled to fit inside contour of contact surface. Scraper bar welds to be wet magnetic particle examined.
PWHT of tees will occur after bars installed. Stress Relieving temperature may be the same as tempering temperature if mechanical test results satisfy specification requirements.
Weld to be a continuous weld completely around all sides of bar with 3/8" fillets.





SCRAPER BAR DATA

Outlet Size	# of Bars	Pit Thk	Width
4	1	1/2	1-3/4
6	1	1/2	2
8	1	1/2	2-1/2
10	2	1/2	3
12	2	1/2	3
14	3	1/2	3
16	3	1/2	3
18	3	1/2	3
20	3	1/2	3
24	3	1/2	3
26	3	3/4	3
30	3	3/4	3
36	3	3/4	3
42	4	1	4
48	4	1	4

Rev.	Date	By:	Revision
3	5/9/03	JL	Revised PWHT note
2	8/6/96	JD	Revised Sections A-A

STEEL FORGINGS, INC.

SCRAPER BARS FOR STRAIGHT AND REDUCING BUTT WELDING TEES

Date: 5/9/03

Drawing#: 122890
Revision: 3

Drawn by: J. Lofdahl

Appr'd:

Scale: None

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 1/2** HR @ **1100** °F - AIR COOL - FURNACE LOAD# _____

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

INSTALL 3 3/4 " THICK X 3 " WIDE SCRAPER BARS PER SFI DWG 122890 REV.3 (ATTACHED) PER WPS FCAW-CS/HSLA-131 R.0
PER WPS FCAW-CS-HSLA-131 (LATEST REV.)

INSPECTOR TO SIGN OFF ON BARS AFTER THEY ARE FIT-UP _____

INSPECTOR TO SIGN OFF ON BARS AFTER THEY ARE GROUND _____

MAG PARTICLE EXAMINE SCRAPER BAR WELDS PER SPEC. XL-MT-100 (LATEST REVISION), ACCEPTANCE CRITERIA MORE STRINGENT OF E709 AND/OR CUSTOMER SPECIFICATION _____

HEAT TREATMENT PER QCP 8.1 REV.1: **STRESS RELIEVE** **1 1/2** HR @ **1100** °F - AIR COOL - FURNACE LOAD # _____

SHOTBLAST TO NEAR WHITE FINISH

MACHINE AFTER STRESS RELIEVE

MACHINE PER MSS-SP75-14

BORE RUN I.D. STRAIGHT TO: 39.250 + 1/4 -0 40.000 (1.000 / 0.990)

BORE OUTLET I.D. STRAIGHT TO: 33.500 + 1/4 -0 34.250 (0.875 / 0.865)

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE