



Due Date: 09/21/2023

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: *3TE4212Y

Product Code: TEE

Description: TE 42X12 1.00 X .375-WPHY65

Master Job No:

MSSSP75-14

Total Qty Open: 8 EA

Qty Posted: 0 EA

Qty To Make: 8

Start Date: 07/19/2023 Phone: 225-570-8941 (Direct)
Contact: MASON COCKERHAM Fax:

Job Notes

BCOO QR CODE
B10853
PIPE SHOP TRAVELER 225-2023
RECORD ONLY THE LARGE DROP, NO SCRAP

Routing

Routed By:

Step No	Work Cntr / Vendor		Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
dept	Operation	Description	Time	Time	Time	Per Hour	Start	End	Quantity
0	PIPE 3 PLATE BURN	Burning Table Plate Burn					07/19/2023	07/19/2023	8
 									
0	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					07/24/2023	07/24/2023	8
 									
0	PIPE 4 BIG ROLL	Big Roller Roll on large roller					07/24/2023	07/24/2023	8
 									

40	PIPE 7 STRING UP	Initial Weld String-up	07/24/2023 07/24/2023	8
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	07/24/2023 07/24/2023	8
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	07/25/2023 07/25/2023	8
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	07/25/2023 07/25/2023	8
				
80	PIPE 9 OD WELD	OD Weld OD Weld	07/27/2023 07/27/2023	8
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/03/2023 08/03/2023	8
				
100	FORGE 8 TRIM	Torch Cut Cut hole	08/31/2023 09/04/2023	8
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	09/04/2023 09/04/2023	8
				
120	FORGE 8 TRIM	Torch Cut Trim	09/11/2023 09/12/2023	8
				

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/14/2024	02/19/2024	8
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/19/2024	02/20/2024	8
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/20/2024	02/20/2024	8
					
160	E1 MACHINING	E1 Extender Expander	02/20/2024	02/20/2024	8
					
170	M1 MACHINING	M1 Big Mill Machining	02/20/2024	02/27/2024	8
					
180	STAMP 1 STAMP	Stamping	02/27/2024	02/27/2024	8
					
190	INSPECT 1 INSPECTION	Inspection 1	02/27/2024	02/27/2024	8
					
200	SHIPPING SHIPPING	Shipping	02/27/2024	02/27/2024	8
					

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: 8

<u>Quantity</u>				<u>Unit</u>	<u>Description</u>	<u>Sub-</u>	<u>Vendor</u>
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>			<u>Assy</u>	
32,569.00000	163,684.00000	32,569.00000	0.00000	LB	0PL15633	NO	CLIFF STEEL
					PL0 1.5-A633-E		
					Quantities from Bins/Lot Number:		
					BCOO-03 (16284.0)		
					BCOO-04 (16285.0)		



BCOO
42X12
1.0X.375
WPHY65
231180-29

Pipe Shop Traveler Tee Cyl.

225-2023

7/10/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	TRADE				SFI Order No	231180-29	Due Date	8/23/2023
Part	46.000	OD	X	1.500	X	64.000	Ship Date	9/21/2023
Plate Size	1.500		X	139.801	X	64.000	NoPcs	8
Heat No.	R3384						Code	BCOO-03, 04
Material	A633E		Test Material				Test No	

Cut 8 Plate(s) 1.500 X Thick X 139.801 Width X 64.000 Length 3806 Lbs.

Per Sketch #

From (2) Plate(s) 1.500 Thick X 132.000 Wide X 360.000 Long

Stamp Plates With Heat Code BCOO-03, 04

Scarf to 139.801 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 46.000 " 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

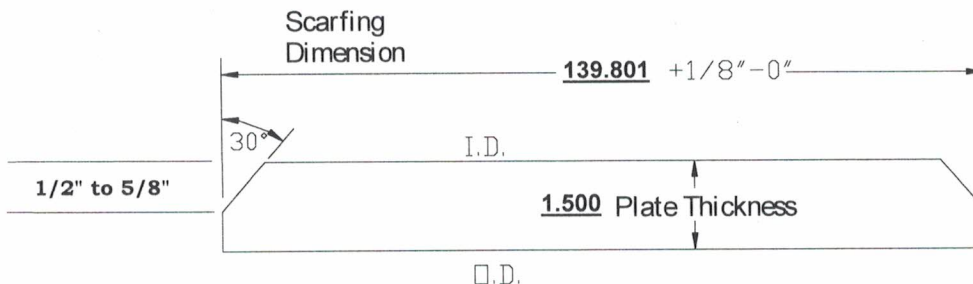
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder TRADE 231180-29

Stamp Each Cylinder in (2) Places With Heat Code BCOO-03, 04

Fitting Description: (8) TEE 42X12 Y65

Comments: RECORD ONLY THE LARGE DROP, NO SCRAP



42" Run Diameter = 42.785"

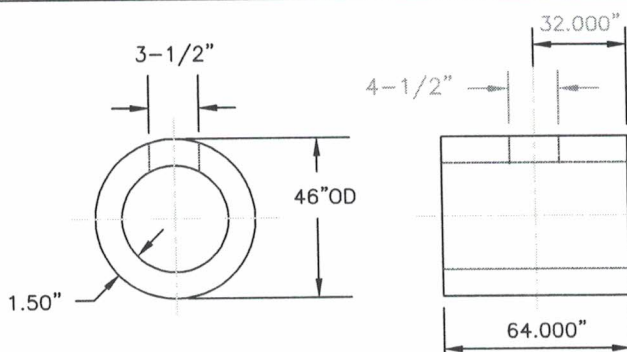
12" Outlet Diameter = Free pull in 42 x 24 dies..

Material Size 46" O.D. x 1.50"W
Length 64.000"

Ovaling Data: Oval HOT to: 42"±1/4"

Hole size -torch cut 3-1/2x4-1/2 oval

Grind 1/8" radius on hole edges
I.D. & O.D.



SHOP NOTE: torch cut hole after barreling operations.

Preform Data:

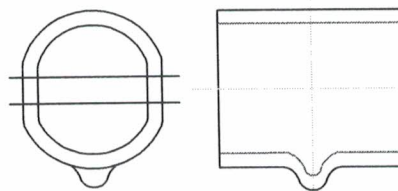
Press: Machine 2000 Ton Set up#10391 Upper Die# 50048

Lower Die# 50151 with 42x24" Insert #41622-1

1st Oper: Heat to 1650°F.—Quench in 26" of water.
Barrel down HOT with HOT side up.
Close dies to 3"

2nd Oper: Re-heat to 1650°F.
Quench barreled side in 24" of water & barrel down HOT with HOT side up. Close dies to 1".

3rd Oper: Re-heat to 1650°F.
Quench to cool outlet area only
Barrel down HOT with HOT side up.
Close dies

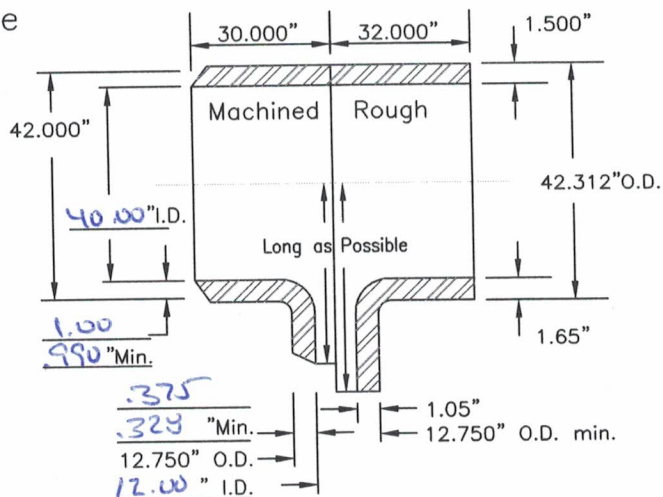


4th Oper: Torch cut outlet hole per above

5th Oper: Locally heat outlet area with torches & Free pull 6.000" plug (3" rod) in 42 x 24 dies

6th Oper: Locally heat outlet area with torches & Free pull 8-1/2" plug (3-1/2" rod)

Final Oper: Locally heat outlet area with torches & Free pull 11-3/8" plug (4" rod)



				DATE: 12-1-99
				SCALE: NONE
				DRAWN BY: J.D.
				CHECKED BY: Bull
REV	DESCRIPTION	BY	DATE	

42 x 12"
1.00 x .375
HIGH YIELD
TEE MFG. DATA

DWG#

42-12-3

Use for bevel thicknesses:

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# _____

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: 39.250 + 1/4 -0 40.000
1.000
0.990
0.375
BORE OUTLET I.D. STRAIGHT TO: 11.750 ± 1/16 12.000
0.328

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE