

# Job Traveler

Job Number: 231180-33



Due Date: 09/28/2023

**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 .875 X .375-  
WPHY70  
MSSSP75-14

**Total Qty Open:** 2 EA      **Qty Posted:** 0 EA      **Qty To Make:** 2

**Start Date:** 07/19/2023

**Phone:** 225-570-8941 (Direct)

**Contact:** MASON COCKERHAM

**Fax:**

## Job Notes

BCNZ  
B10794  
PIPE SHOP TRAVELER 228-2023, NO SCRAP, ALLOCATED

QR CODE

## Routing

**Routed By:**

**Quantity 2**

| Step No                                                                                                                                                                | Work Cntr / Vendor     | Setup                              | Cycle       | Total       | Pieces          | --- Scheduled --- |            | Run             |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|------------------------------------|-------------|-------------|-----------------|-------------------|------------|-----------------|
| <u>Dept</u>                                                                                                                                                            | <u>Operation</u>       | <u>Time</u>                        | <u>Time</u> | <u>Time</u> | <u>Per Hour</u> | <u>Start</u>      | <u>End</u> | <u>Quantity</u> |
| 10                                                                                                                                                                     | PIPE 3<br>PLATE BURN   | Burning Table<br>Plate Burn        |             |             |                 | 07/19/2023        | 07/19/2023 | 2               |
|   |                        |                                    |             |             |                 |                   |            |                 |
| 20                                                                                                                                                                     | PIPE 6<br>FURNACE HEAT | Pipe Furnace<br>Furnace heating    |             |             |                 | 07/25/2023        | 07/25/2023 | 2               |
|   |                        |                                    |             |             |                 |                   |            |                 |
| 30                                                                                                                                                                     | PIPE 4<br>BIG ROLL     | Big Roller<br>Roll on large roller |             |             |                 | 07/25/2023        | 07/25/2023 | 2               |
|   |                        |                                    |             |             |                 |                   |            |                 |

Job Number: 231180-33

Report Generated: 07/11/2023 8:13:39 AM

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|                                                                                    |                                                                                     |                                |                       |   |
|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|--------------------------------|-----------------------|---|
| 40                                                                                 | PIPE 7<br>STRING UP                                                                 | Initial Weld<br>String-up      | 07/25/2023 07/25/2023 | 2 |
|     |    |                                |                       |   |
| 50                                                                                 | PIPE 8<br>ID WELD # 1                                                               | ID Weld # 1<br>ID Weld         | 07/25/2023 07/25/2023 | 2 |
|    |    |                                |                       |   |
| 60                                                                                 | PIPE 12<br>PIPE GOUGE                                                               | Pipe Gouge<br>Pipe gouge       | 07/25/2023 07/25/2023 | 2 |
|    |    |                                |                       |   |
| 70                                                                                 | PIPE 5<br>WELD PREP                                                                 | Grind After Gouge<br>Weld prep | 07/26/2023 07/26/2023 | 2 |
|    |    |                                |                       |   |
| 80                                                                                 | PIPE 9<br>OD WELD                                                                   | OD Weld<br>OD Weld             | 07/31/2023 07/31/2023 | 2 |
|   |   |                                |                       |   |
| 90                                                                                 | FORGE 10<br>CYLINDER CUT                                                            | Cylinder Cut<br>Cylinder Cut   | 08/10/2023 08/10/2023 | 2 |
|  |  |                                |                       |   |
| 100                                                                                | FORGE 8<br>TRIM                                                                     | Torch Cut<br>Cut hole          | 09/12/2023 09/12/2023 | 2 |
|  |  |                                |                       |   |
| 110                                                                                | FORGE 12<br>FORM/PRESS                                                              | 2000 Ton Press<br>Forming      | 09/12/2023 09/12/2023 | 2 |
|  |  |                                |                       |   |
| 120                                                                                | FORGE 8<br>TRIM                                                                     | Torch Cut<br>Trim              | 09/13/2023 09/13/2023 | 2 |
|  |  |                                |                       |   |

|                                                                                    |                                                                                     |                               |            |            |   |
|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------|------------|------------|---|
| 130                                                                                | FORGE 7<br>HEAT TREAT                                                               | Heat Treat<br>Heat treat      | 02/28/2024 | 02/28/2024 | 2 |
|     |    |                               |            |            |   |
| 140                                                                                | FORGE 5-6<br>FORGE BLAST                                                            | Forge Shotblast<br>Shot blast | 02/28/2024 | 02/28/2024 | 2 |
|    |    |                               |            |            |   |
| 150                                                                                | PIPE 13<br>X RAY                                                                    | Pipe X Ray<br>X-ray           | 02/28/2024 | 02/29/2024 | 2 |
|    |    |                               |            |            |   |
| 160                                                                                | E1<br>MACHINING                                                                     | E1 Extender<br>Expander       | 02/29/2024 | 02/29/2024 | 2 |
|    |    |                               |            |            |   |
| 170                                                                                | M1<br>MACHINING                                                                     | M1 Big Mill<br>Machining      | 02/29/2024 | 03/04/2024 | 2 |
|   |   |                               |            |            |   |
| 180                                                                                | STAMP 1<br>STAMP                                                                    | Stamping                      | 03/04/2024 | 03/04/2024 | 2 |
|  |  |                               |            |            |   |
| 190                                                                                | INSPECT 1<br>INSPECTION                                                             | Inspection 1                  | 03/04/2024 | 03/04/2024 | 2 |
|  |  |                               |            |            |   |
| 200                                                                                | SHIPPING<br>SHIPPING                                                                | Shipping                      | 03/04/2024 | 03/04/2024 | 2 |
|  |  |                               |            |            |   |

|                          |      |      |      |      |
|--------------------------|------|------|------|------|
| 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: 2

| Quantity      |                |               |              |
|---------------|----------------|---------------|--------------|
| <u>Needed</u> | <u>On Hand</u> | <u>Posted</u> | <u>Short</u> |
| 7,613.00000   | 104,263.00000  | 7,613.00000   | 0.00000      |

| <u>Unit</u> | <u>Description</u> |
|-------------|--------------------|
| LB          | 0PL1375633         |

PL0 1.375-A633-E  
Quantities from Bins/Lot Number:  
BCNZ-02 (7613.0)

| <u>Sub-<br/>Assy</u> | <u>Vendor</u>  |
|----------------------|----------------|
| NO                   | CLIFF<br>STEEL |



BCNZ  
42X12  
.875X.375  
WPHY70  
231180-33

# Pipe Shop Traveler Tee Cyl.

228-2023

7/11/2023

☐ Pipe Shop Copy  
☐ Pipe Shop Original

|            |                                                 |               |                  |          |                  |
|------------|-------------------------------------------------|---------------|------------------|----------|------------------|
| Customer   | <u>TRADE</u>                                    | SFI Order No  | <u>231180-33</u> | Due Date | <u>8/18/2023</u> |
| Part       | <u>46.000</u> OD X <u>1.375</u> X <u>64.000</u> | Ship Date     | <u>9/28/2023</u> | NoPcs    | <u>2</u>         |
| Plate Size | <u>1.375</u> X <u>140.194</u> X <u>64.000</u>   | Code          | <u>BCNZ</u>      | Test No  |                  |
| Heat No.   | <u>R2914</u>                                    |               |                  |          |                  |
| Material   | <u>A633E</u>                                    | Test Material |                  |          |                  |

Cut 2 Plate(s) 1.375 X Thick X 140.194 Width X 64.000 Length 3499 Lbs.

Per Sketch # 6173

From ( 1 ) Plate(s) 1.375 Thick X 132.000 Wide X 216.000 Long

Stamp Plates With Heat Code BCNZ

Scarf to 140.194 + 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

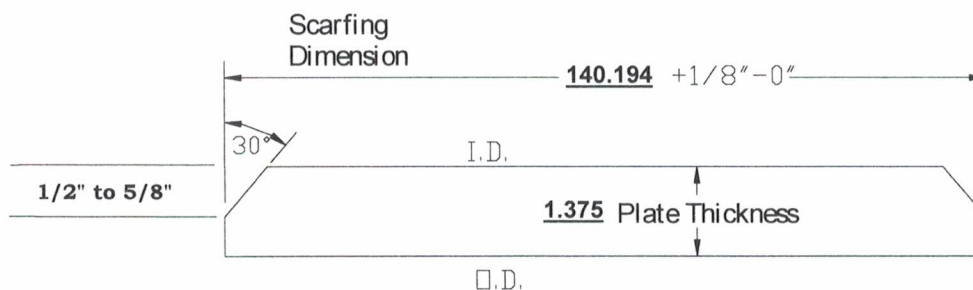
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder TRADE 231180-33

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

Fitting Description: (2) TE 42X12 Y70

Comments: CUT WITH 229-2023, NO SCRAP, ALL ALLOCATED



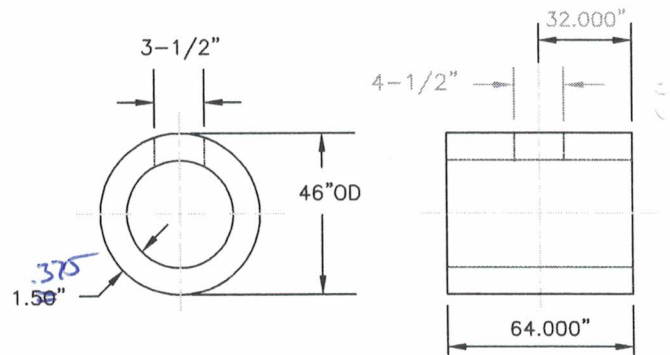
42" Run Diameter = 42.785"

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.

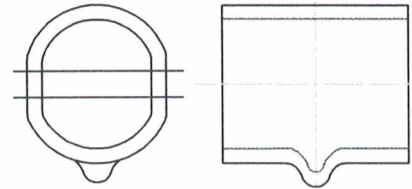
Preform Data:

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

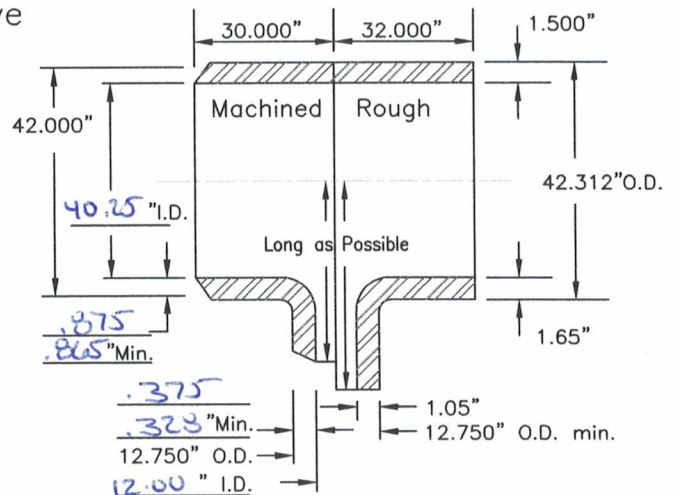


4th Oper: Torch cut outlet hole per above

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    | 42 x 12"<br><u>375 x 375</u><br>HIGH YIELD<br>TEE MFG. DATA | DWG#<br><br>42-12-3<br><br>Use for bevel thicknesses: |
|     |             |    |      | SCALE: NONE      |                                                             |                                                       |
|     |             |    |      | DRAWN BY: J.D.   |                                                             |                                                       |
|     |             |    |      | CHECKED BY: Bull |                                                             |                                                       |
| REV | DESCRIPTION | BY | DATE |                  |                                                             |                                                       |

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

0.875

BORE RUN I.D. STRAIGHT TO: 39.500 + 1/4 -0 40.250

0.865

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