

Job Traveler

Job Number: 231180-35



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:** 06/20/2023**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: 2 EA**Qty Posted:** 0 EA**Qty To Make:** 2**Start Date:** 07/18/2023**Phone:** 225-570-8941 (Direct)**Contact:** MASON COCKERHAM**Fax:**

Job Notes

BCOO QR CODE
B10853
PIPE SHOP TRAVELER 232-2023, NO SCRAP, JUST RECORD DROP

Routing

Routed By:**Quantity 2**

Step No	Work Cntr / Vendor	Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Time	Time	Time	Per Hour	Start	End	Quantity
10	PIPE 3 PLATE BURN					07/18/2023	07/18/2023	2
20	PIPE 6 FURNACE HEAT					07/25/2023	07/25/2023	2
30	PIPE 4 BIG ROLL					07/25/2023	07/25/2023	2

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Report Generated: 07/12/2023 10:18:03 AM

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40	PIPE 7 STRING UP	Initial Weld String-up	07/25/2023 07/25/2023	2
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	07/25/2023 07/25/2023	2
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	07/25/2023 07/25/2023	2
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	07/26/2023 07/26/2023	2
				
80	PIPE 9 OD WELD	OD Weld OD Weld	07/31/2023 07/31/2023	2
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/07/2023 08/07/2023	2
				
100	FORGE 8 TRIM	Torch Cut Cut hole	08/28/2023 08/29/2023	2
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	08/29/2023 08/29/2023	2
				
120	FORGE 8 TRIM	Torch Cut Trim	09/13/2023 09/14/2023	2
				

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	01/29/2024	01/29/2024	2
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	01/29/2024	01/30/2024	2
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	01/30/2024	01/30/2024	2
					
160	E1 MACHINING	E1 Extender Expander	01/30/2024	01/30/2024	2
					
170	M1 MACHINING	M1 Big Mill Machining	01/30/2024	01/31/2024	2
					
180	STAMP 1 STAMP	Stamping	01/31/2024	01/31/2024	2
					
190	INSPECT 1 INSPECTION	Inspection 1	01/31/2024	01/31/2024	2
					
200	SHIPPING SHIPPING	Shipping	01/31/2024	01/31/2024	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>	<u>Unit</u>	<u>Description</u>	<u>Sub- Assy</u>	<u>Vendor</u>	
7,974.00000	152,004.00000	7,974.00000	0.00000	LB	0PL15633	NO	AMERIC529	
					PL0 1.5-A633-E			2
					Quantities from Bins/Lot Number:			
					BCOB-01 (7974.0)			
					BCOB-01			
					BCOB-05			



BCOO
42X12
1.0X.375
WPHY65
231180-35

Pipe Shop Traveler Tee Cyl.

232-2023

7/12/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>TRADE</u>	SFI Order No	<u>231180-35</u>	Due Date	<u>8/18/2023</u>
Part	<u>46.000</u> OD X <u>1.500</u> X <u>64.000</u>			Ship Date	<u>9/28/2023</u>
Plate Size	<u>1.500</u> X <u>139.801</u> X <u>64.000</u>			NoPcs	<u>2</u>
Heat No.	<u>R3384</u>			Code	<u>BCOO-05</u>
Material	<u>A633E</u>	Test Material		Test No	

Cut 2 Plate(s) 1.500 X Thick X 139.801 Width X 64.000 Length 3806 Lbs.
Per Sketch #

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

Stamp Plates With Heat Code BCOO-05

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

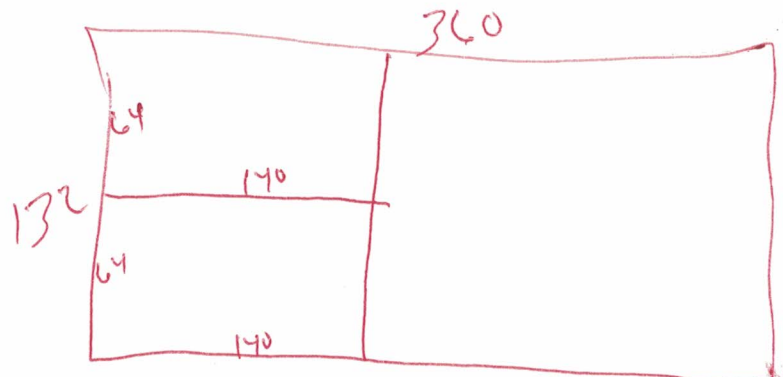
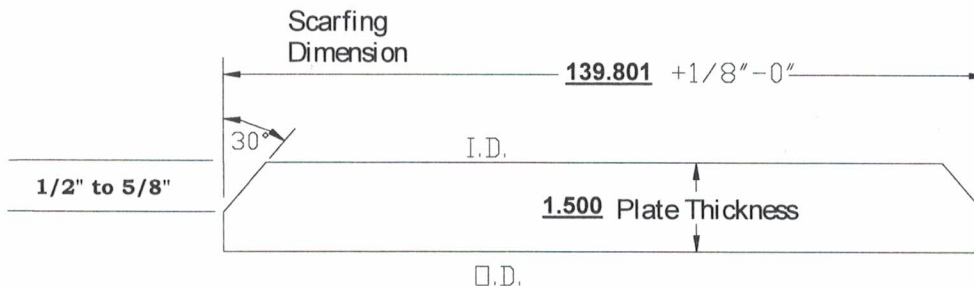
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder TRADE 231180-35

Stamp Each Cylinder in (2) Places With Heat Code BCOO-05

Fitting Description: (2) TE 42X12 Y65

Comments: NO SCRAP, RECORD THE REMAINING DROP ONLY



42" Run Diameter = 42.785"

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

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

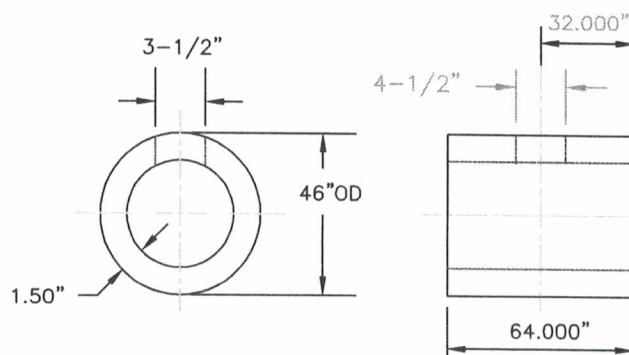
Length 64.000"

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:

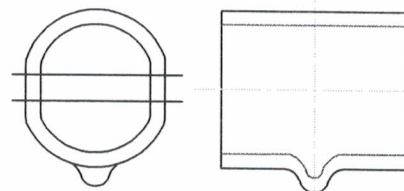
Press: Machine 2000 Ton Set up#10391 Upper Die# 50048

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

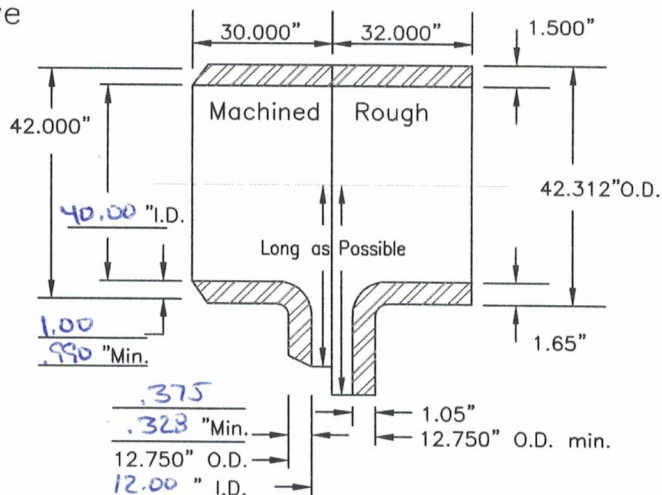


4th Oper: Torch cut outlet hole per above

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

42 x 12"

1.0 x .375

HIGH YIELD
TEE MFG. DATA

DWG#

42-12-3

Use for bevel thicknesses:

REV	DESCRIPTION	BY	DATE
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