

Job Traveler

Job Number: 231180-36



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: *3TE4816Y

Product Code: TEE

Description: TE 48X16 1.00 X .500-
WPHY70

Master Job No:

MSSSP75-14

Total Qty Open: 6 EA

Qty Posted: 0 EA

Qty To Make: 6

Start Date: 07/20/2023

Phone: 225-570-8941 (Direct)

Contact: MASON COCKERHAM

Fax:

Job Notes

BCOO QR CODE
B10853
PIPE SHOP TRAVELER 233-2023, NO SCRAP, RECORD REMAINING DROP

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
0	PIPE 3 PLATE BURN	Burning Table Plate Burn					07/20/2023	07/20/2023	6
0	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					07/25/2023	07/25/2023	6
0	PIPE 4 BIG ROLL	Big Roller Roll on large roller					07/25/2023	07/25/2023	6



40	PIPE 7 STRING UP	Initial Weld String-up	07/25/2023 07/25/2023	6
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	07/25/2023 07/25/2023	6
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	07/25/2023 07/25/2023	6
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	07/26/2023 07/26/2023	6
				
80	PIPE 9 OD WELD	OD Weld OD Weld	07/31/2023 07/31/2023	6
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/10/2023 08/10/2023	6
				
100	FORGE 8 TRIM	Torch Cut Cut hole	08/31/2023 08/31/2023	6
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	08/31/2023 09/04/2023	6
				
120	FORGE 8 TRIM	Torch Cut Trim	09/14/2023 09/14/2023	6
				

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	09/14/2023	09/19/2023	6
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	09/25/2023	09/25/2023	6
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	09/25/2023	09/26/2023	6
					
160	E1 MACHINING	E1 Extender Expander	09/26/2023	09/26/2023	6
					
170	M1 MACHINING	M1 Big Mill Machining	09/26/2023	10/02/2023	6
					
180	STAMP 1 STAMP	Stamping	10/02/2023	10/02/2023	6
					
190	INSPECT 1 INSPECTION	Inspection 1	10/02/2023	10/02/2023	6
					
200	SHIPPING SHIPPING	Shipping	10/02/2023	10/02/2023	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	
<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>
31,230.00000	184,460.00000	31,230.00000	0.00000	LB	0PL15633	NO CLIFF STEEL
PL0 1.5-A633-E						
Quantities from Bins/Lot Number:						
BCOO-06 (10410.0)						
BCOO-07 (10410.0)						
BCOO-08 (10410.0)						

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCOO
48X16
1.0X.500
WPHY70
231180-36

RUN DIE DIAMETER = FREE PULLED 48 x 24" DIES
 OUTLET DIE DIA.

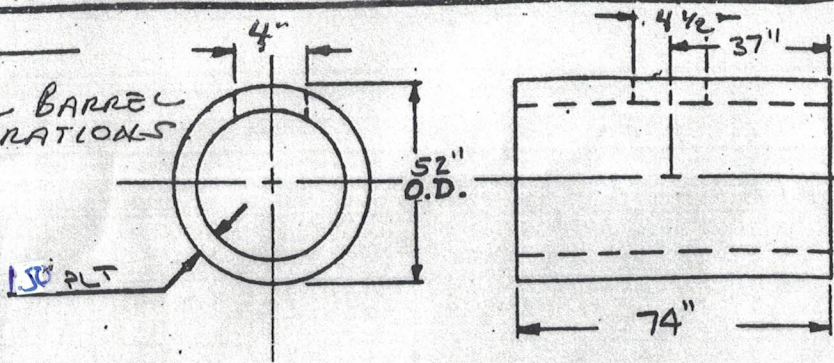
MATERIAL SIZE 52" OD x 1.5" PCT

LENGTH 74"
 NOTE: CUT OUTLET HOLE AFTER BARREL OPERATIONS

HOLE CUTTING DATA: 4 x 4 1/2"

HOLE SIZE: _____

GRIND 1/8" RADIUS ON HOLE EDGES I.D. AND O.D.



DVALING DATA:
 MACHINE 2000 TON PRESS

OVAL WIDTH 47" + 1/2" - 0"
 OVAL:- Hot

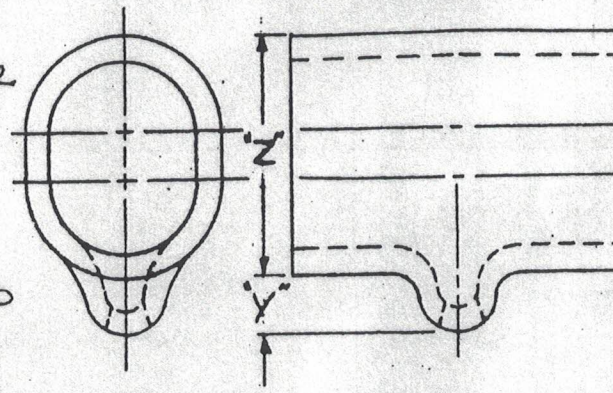
PREFORM DATA:

PRESS: MACHINE #2000T SET UP #None UPPER DIE #50303 LOWER DIE #50305 WITH 48" x 24" INSERT #50305-2

1ST FORM HEAT TO 1650°F.
 QUENCH IN 3 1/2 INCHES OF WATER
 BARREL DOWN HOT WITH
 HOT SIDE UP CLOSE DIES TO 4 1/2"

2ND FORM RE-HEAT TO 1650°F
 QUENCH BARRELED SIDE IN 29"
 INCHES OF WATER AND BARREL
 DOWN HOT WITH HOT SIDE UP
 CLOSE DIES TO 1"

3RD FORM RE-HEAT TO 1650°F.
 QUENCH OUTLET AREA ONLY
 BARREL DOWN HOT WITH HOT SIDE UP - CLOSE DIES

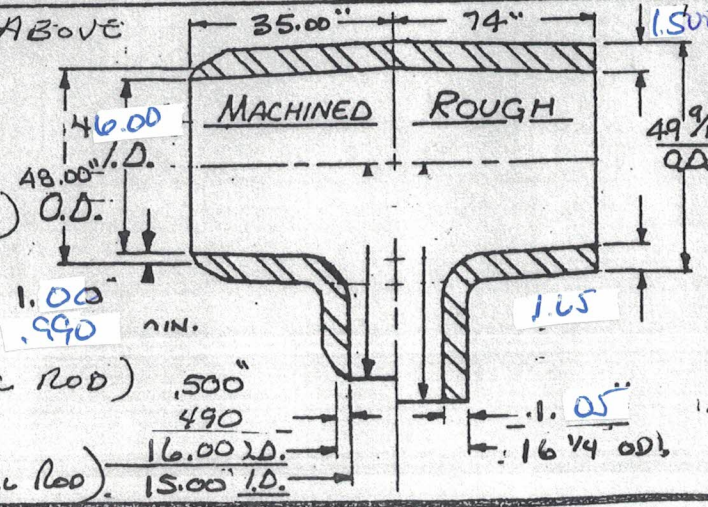


4TH OPERATION: CUT OUTLET HOLE PER ABOVE

5TH OPERATION HEAT TO 1650°F
 DO NOT QUENCH
 PULL 9" DIA. PLUG (4 PULL ROD)

6TH OPER. RE-HEAT TO 1650°F.
 DO NOT QUENCH
 PULL 11 1/2" DIA. PLUG (4 PULL ROD)

FINAL PLUG RE-HEAT TO 1650°F
 DO NOT QUENCH
 PULL 14 1/4" DIA. PLUG (4 PULL ROD)



DATE	11-30-98
SCALE	NONE
DRAWN	
CHECKED	
DESCRIPTION	BY DATE APP'D.

48" x 16 1.00 x .500 WT

TEE MFG. DATA

DWG. NO. 48 x 11 MOD.

Pipe Shop Traveler Tee Cyl.

233-2023

7/12/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	TRADE		SFI Order No	231180-36	Due Date	8/18/2023
Part	52.000	OD X	1.500 X	74.000	Ship Date	9/28/2023
Plate Size	1.500	X	158.651 X	74.000	NoPcs	6
Heat No.	R3384				Code	BCOO-06, 07, 08
Material	A633E		Test Material		Test No	

Cut 6 Plate(s) 1.500 X Thick X 158.651 Width X 74.000 Length 4994 Lbs.

Per Sketch #

From (3) Plate(s) 1.500 Thick X 132.000 Wide X 360.000 Long

Stamp Plates With Heat Code BCOO-06, 07, 08

Scarf to 158.651 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 52.000 " 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 231180-36

Stamp Each Cylinder in (2) Places With Heat Code BCOO-06, 07, 08

Fitting Description: (6) TE 48X16 Y70

Comments: NO SCRAP, RECORD REMAINING DROP

