Job Traveler

Job Number: 231180-39

Due Date: 10/05/2023

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: *3TE3630Y **Product Code:** TEE

Description: TE 36X30 .875 X .750-WPHY65
W/BARS
MSSSP75-14

Master Job No:

Total Qty Open: 3 EA **Qty Posted:** 0 EA **Qty To Make:** 3

Start Date: 07/20/2023 **Phone:** 225-570-8941 (Direct)

Contact: MASON COCKERHAM **Fax:**

Job Notes

BCON
B10856
PIPE SHOP TRAVELER 231-2023
NO SCRAP, ONLY RECORD LARGE DROP REMAINING

Routing

Routed By:

Quantity 3

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					07/20/2023	07/20/2023	3
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					07/25/2023	07/25/2023	3

30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	07/25/2023	07/25/2023	3
40	PIPE 7 STRING UP	Initial Weld String-up	07/25/2023	07/25/2023	3
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	07/25/2023	07/25/2023	3
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	07/25/2023	07/25/2023	3
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	07/26/2023	07/26/2023	3
80	PIPE 9 OD WELD	OD Weld OD Weld	07/31/2023	07/31/2023	3
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/10/2023	08/10/2023	3
100	FORGE 8 TRIM	Torch Cut Cut hole	08/31/2023	08/31/2023	3
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	08/31/2023	08/31/2023	3

120	FORGE 8 TRIM	Torch Cut Trim	09/13/2023	09/13/2023	3

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	03/05/2024	03/06/2024	3

140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	03/06/2024	03/06/2024	3

150	PIPE 13 X RAY	Pipe X Ray X-ray	03/06/2024	03/06/2024	3

160	E1 MACHINING	E1 Extender Expander	03/06/2024	03/06/2024	3

170	M1 MACHINING	M1 Big Mill Machining	03/06/2024	03/11/2024	3

180	PIPE 11	Special Welds Bars	03/11/2024	03/14/2024	3

190	FAB 8 GRINDING	Fab Grind Grinding Bars	03/14/2024	03/14/2024	3

200	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	03/14/2024	03/18/2024	3

210	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	03/18/2024	03/18/2024	3
220	PIPE 13 X RAY	Pipe X Ray ME inspection of weld	03/18/2024	03/18/2024	3
230	STAMP 1 STAMP	Stamping	03/18/2024	03/18/2024	3
240	INSPECT 1 INSPECTION	Inspection 1	03/18/2024	03/18/2024	3
250	SHIPPING SHIPPING	Shipping	03/18/2024	03/18/2024	3

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: 3

Quantity						Sub-Assy	Vendor
Needed	On Hand	Posted	Short	Unit	Description		
8,750.00000	96,650.00000	8,750.00000	0.00000	LB	0PL1375633 PL0 1.375-A633-E Quantities from Bins/Lot Number: BCON-01 (8750.0)	NO	CLIFF STEEL

BCON
36X30
.875X.750
WPHY65
231180-39

Pipe Shop Traveler Tee Cyl.

231 -2023
7/12/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	TRADE	SFI Order No	231180-39	Due Date	8/31/2023
Part	42.000 OD X 1.375 X 55.000			Ship Date	10/5/2023
Plate Size	1.375 X 127.628 X 55.000			NoPcs	3
Heat No.	R3384			Code	BCON-01
Material	A633E	Test Material	cut(6)6X12for(3)12X12	Test No	10854,5,6

Cut 3 Plate(s) 1.375 X Thick X 127.628 Width X 55.000 Length 2737 Lbs.

Per Sketch #

From (1) Plate(s) 1.375 Thick X 132.000 Wide X 360.000 Long

Stamp Plates With Heat Code BCON-01

Scarf to 127.628 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 42.000 " 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

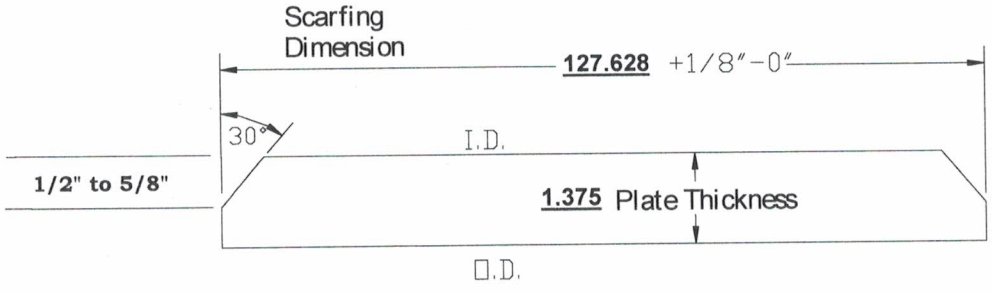
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder TRADE 231180-39

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

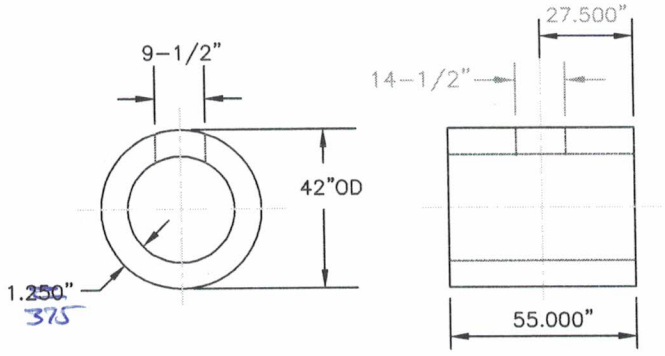
Fitting Description: (3) TE 36X30Y65WB

Comments: NO SCRAP, ONLY RECORD REMAINING DROP



36" Run Diameter = 36.542"
30" Outlet Diameter= 30.633"

Material Size 42" O.D. x 1.~~250~~ 375"W
Length 55.000"

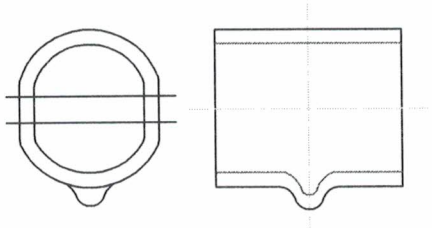


Ovaling Data:
Oval: HOT to 35-3/4"±1/4"

Hole size 9-1/2"x 14-1/2" oval
Grind 1/8" radius on hole edges
I.D. & O.D.

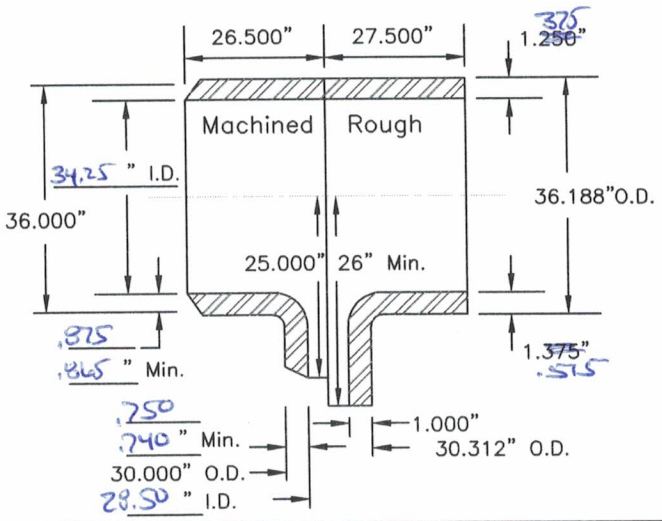
Preform Data:
Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50092

1st Oper: Heat to 1650°F.-Quench in 27 inches of water.
Close dies to 6" and
Pull 17-3/8" diameter plug (4" rod).



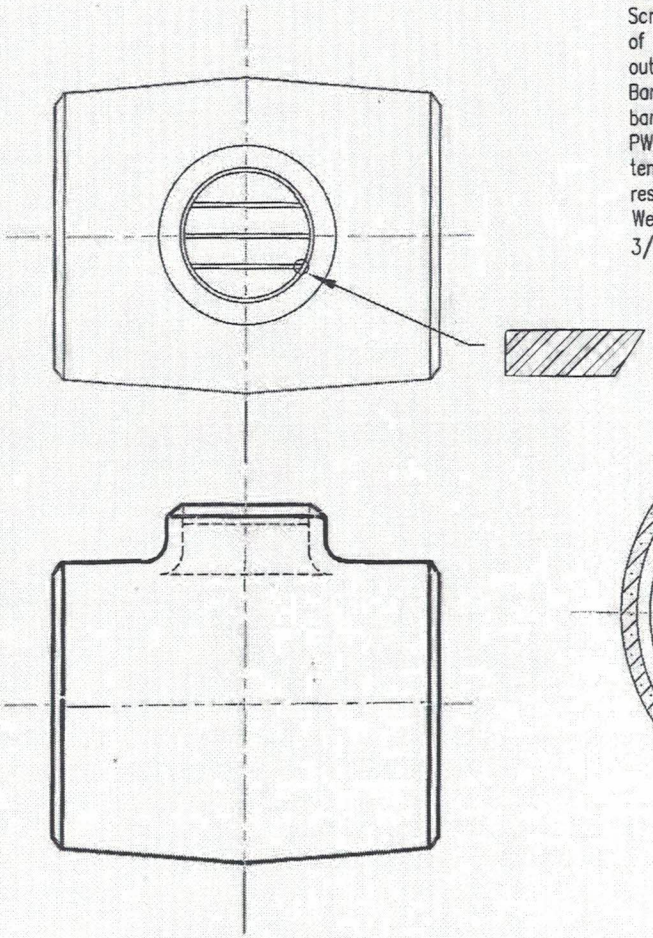
2nd Oper: Re-heat to 1650°F.
Quench in 23 inches of water
Close dies to 2" and
Pull 23-3/4" diameter plug (4" rod).

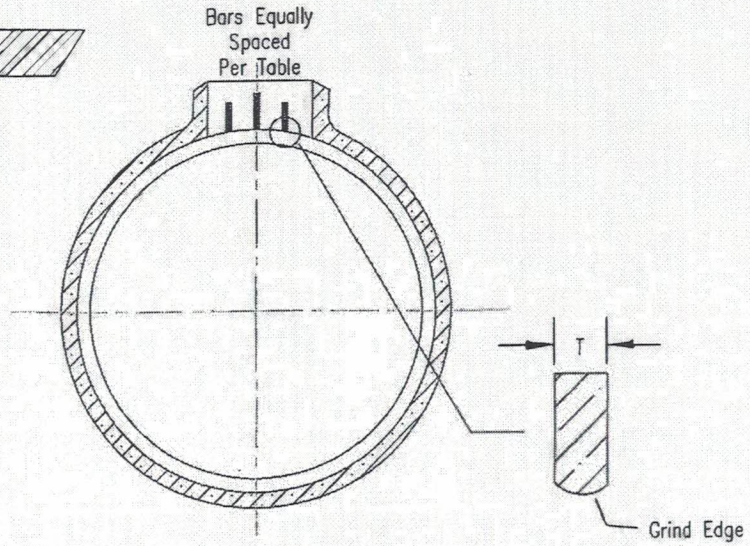
3th Oper: Re-heat to 1650°F.
Do not quench
Close dies hot and
Pull 28.280" plug (6" pull rod).



				DATE: 11-29-99	36" x 30" .875x.750	DWG# 36-30-3
				SCALE: NONE		
				DRAWN BY: J.D.		
				CHECKED BY: Bull		
					HIGH YIELD TEE MFG. DATA	Use for bevel thicknesses: 36" Run-.751" thru. .833". 30" Outlet-.750" and less.
REV	DESCRIPTION	BY	DATE			

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	Plt 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: 33.500 + 1/4 -0 — 34.250 (0.875 / 0.865)

BORE OUTLET I.D. STRAIGHT TO: 27.750 + 1/4 -0 — 28.500 (0.750 / 0.740)

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE