

Job Traveler

Job Number: 231180-40



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: *3TE3620Y

Product Code: TEE

Description: TE 36X20 .875 X .594-
WPHY65

Master Job No:

W/BARS

MSSSP75-14

Total Qty Open: 1 EA

Qty Posted: 0 EA

Qty To Make: 1

Start Date: 07/19/2023

Phone: 225-570-8941 (Direct)

Contact: MASON COCKERHAM

Fax:

Job Notes

BCNZ QR CODE
B10795
PIPE SHOP TRAVELER 229-2023, NO SCRAP, ALL ALLOCATED

Routing

Routed By:

Quantity 1

Step No	Work Cntr / Vendor	Description	Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation		Time	Time	Time	Per Hour	Start	End	Quantity
10	PIPE 3 PLATE BURN	Burning Table Plate Burn					07/19/2023	07/19/2023	1
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					07/25/2023	07/25/2023	1
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller					07/25/2023	07/25/2023	1

Job Number: 231180-40

Report Generated: 07/11/2023 8:13:53 AM

TD 3/11

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

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/06/2024 02/06/2024	1
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/06/2024 02/06/2024	1
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/06/2024 02/06/2024	1
				
160	E1 MACHINING	E1 Extender Expander	02/06/2024 02/06/2024	1
				
170	M1 MACHINING	M1 Big Mill Machining	02/06/2024 02/07/2024	1
				
180	PIPE 11	Special Welds Bars	02/19/2024 02/20/2024	1
				
190	FAB 8 GRINDING	Fab Grind Grinding Bars	02/20/2024 02/20/2024	1
				
200	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	02/28/2024 02/28/2024	1
				
210	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	02/28/2024 02/29/2024	1
				



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: 1	
Needed	On Hand	Posted	Short	Unit	Description	Sub-Assy Vendor
3,603.00000	100,253.00000	3,603.00000	0.00000	LB	0PL1375633	NO CLIFF STEEL
					PL0 1.375-A633-E	
					Quantities from Bins/Lot Number:	
					BCNZ-02 (3603.0)	

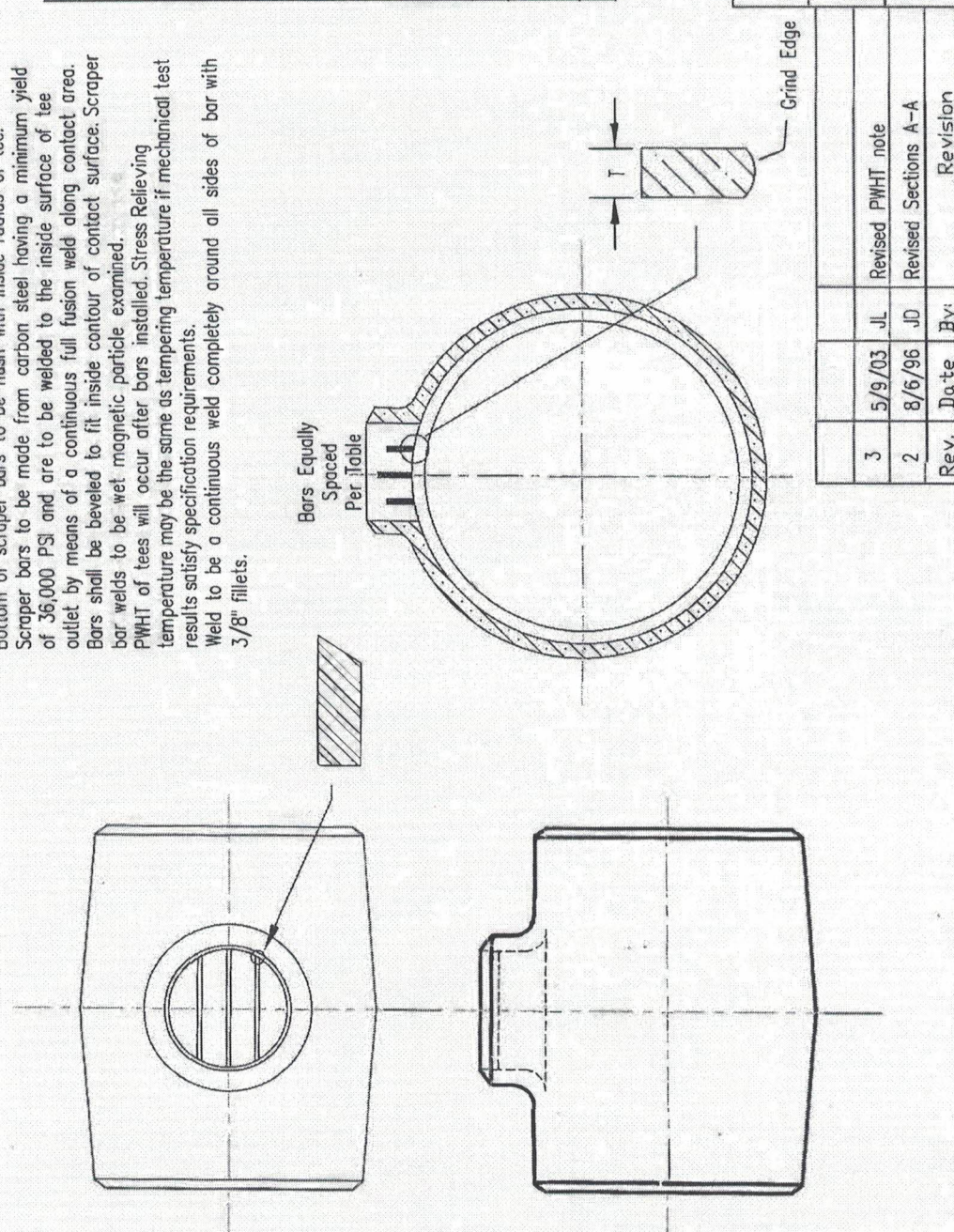


BCNZ
36X20
.875X.594
WPHY65
231180-40

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	Pit 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



STEEL FORGINGS, INC.

SCRAPER BARS FOR STRAIGHT AND REDUCING BUTT WELDING TEES		Date: 5/9/03	Scale: None
Drawing#: 122890	Drawn by: J. Lofdah	App'd:	
Revision: 3			

Pipe Shop Traveler Tee Cyl.

229-2023

7/11/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	TRADE	SFI Order No	231180-40	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	1
Heat No.	R2914			Code	BCNZ
Material	A633E	Test Material		Test No	

Cut 1 Plate(s) 1.375 X Thick X 127.628 Width X 55.000 Length 2737 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 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

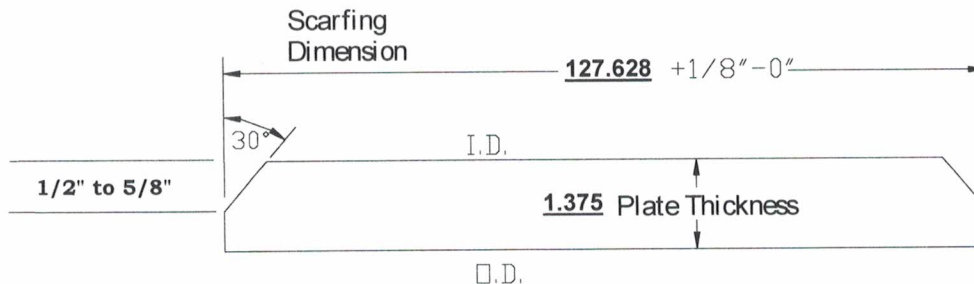
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder TRADE 231180-40

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

Fitting Description: (1) TE 36X20 Y65

Comments: RUN WITH 228-2023, NO SCRAP, ALL ALLOCATED



36" Run Diameter = 36.542"
 20" Outlet Diameter = 20.523"

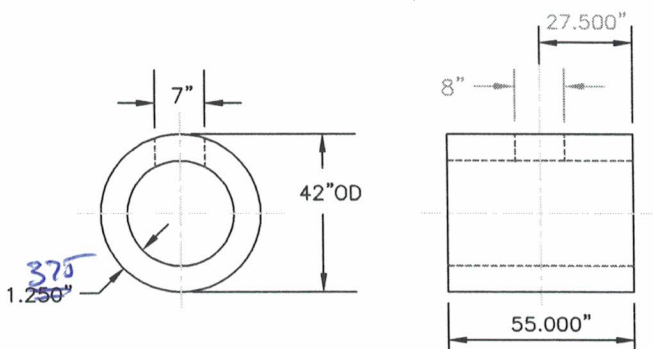
Material Size 42" O.D. x 1.250" W
 Length 55.000"

Ovaling Data:

Oval HOT to: 35-3/4" ± 1/4"

Hole size 7" x 8" oval

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



Preform Data:

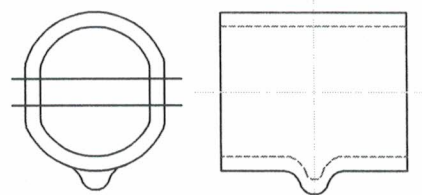
Press: Machine 2000 Ton Set up #10139 Upper Die # 50046
 Lower Die # 50082 with 36x20" Insert #50089

1st Oper: Heat to 1650°F.—Quench in 28 inches of water.

Close dies to 5-1/2" and
 Pull 10-1/4" diameter plug (4" rod).

2nd Oper: Re-heat to 1650°F.

Quench in 23-1/2 inches of water
 Close dies to 1-1/2" and
 Pull 14-3/4" diameter plug (4" rod).

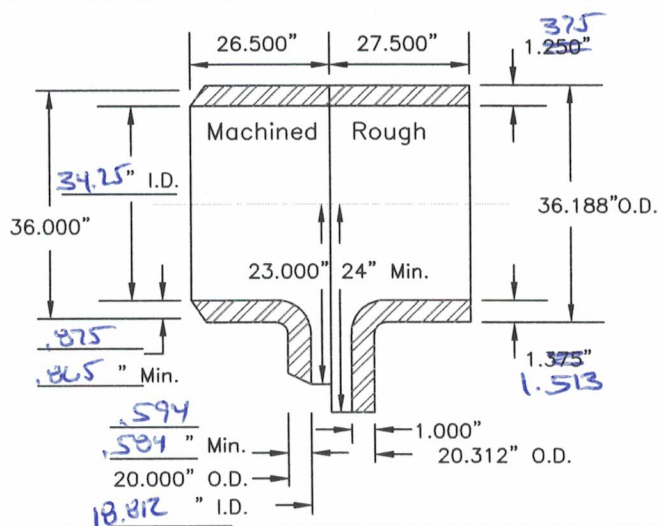


3th Oper: Re-heat to 1650°F.

Do not quench

Close dies hot and

Pull 18-1/4" plug (4" pull rod).



			DATE: 11-22-99
			SCALE: NONE
			DRAWN BY: J.D.
			CHECKED BY: Bull
REV	DESCRIPTION	BY	DATE

36" x 20"
 .875 x .594
 HIGH YIELD
 TEE MFG. DATA

DWG#
 36-20-3
 Use for bevel thicknesses:
 36" Run—.751" thru .833"
 20" Outlet—.812" and less.

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 1/2 " 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: 18.312 + 1/8 -0 18.812
0.594
0.584

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE