

Job Traveler

Job Number: 231228-01



Due Date: 08/16/2023

Sold To: EDGEN MURRAY CORPORATION
18444 HIGHLAND ROAD
P.O. BOX 84160
BATON ROUGE, LA 70884-4160
United States

Ship To: , LA
United States

Order No: 231228

Dated: 06/27/202:

Quote No: 19106

Customer: EDGEN119955

PO Num: RMS-298627

Ship Via: CLAIRE.BLAY@EDGENMURRAY.

Priority: 3 - STANDARD

Part Number: *3CR3616Y

Product Code: CONCENTRIC REDUCER

Description: CR 36X16 .750 X .375-
WPHY70

Master Job No:

ES-PF1.14

Total Qty Open: 1 EA

Qty Posted: 0 EA

Qty To Make: 1

Start Date: 07/13/2023

Phone: 2,257,569,868

Contact: CLAIRE BLAY

Fax:

Job Notes

BCKU
B10576-1
CUT (1) @ 26.5" FROM 114" PIECE
QR CODE ATTACHED

Routing

Routed By:

Quantity 1

Step No	Work Cntr / Vendor	Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Time	Time	Time	Per Hour	Start	End	Quantity
10	FORGE 10 CYLINDER CUT					07/13/2023	07/13/2023	1
20	FORGE 4 HAMMER					07/13/2023	07/17/2023	1
30	FORGE 7 HEAT TREAT					09/05/2023	09/05/2023	1

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40	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	09/05/2023	09/05/2023	1
					
50	PIPE 13 X RAY	Pipe X Ray X-ray weld	09/05/2023	09/05/2023	1
					
60	E1 MACHINING	E1 Extender Expander	09/05/2023	09/06/2023	1
					
70	M1 MACHINING	M1 Big Mill Machining	09/06/2023	09/06/2023	1
					
80	STAMP 1 STAMP	Stamping Stamping	09/06/2023	09/06/2023	1
					
90	INSPECT 1 INSPECTION	Inspection 1 Inspection	09/06/2023	09/06/2023	1
					
100	SHIPPING SHIPPING	Shipping Shipping	09/06/2023	09/06/2023	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
27.00000	87.00000	27.00000	0.00000	EA	0PI3612552	NO SFI
PI0 36-1.25-Y52 Quantities from Bins/Lot Number: BCKU (27.0)						

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Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCKU
36X16
.750X.375
WPHY70
231228-01
PUR-5020-2009254/5

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number _____ - _____

SPECTRA S/N PO _____ / _____ / _____

Purchaser's Purchase Order

MTR's

Reader Sheet for Radiography

Inspection sheet with actual dimensions

Heat Treat charts

Furnace Uniformity & Quarterly Recorder Calibration records

DIMENSIONAL INSPECTION SHEET FOR REDUCER

Does stamping match traveler? _____' _____' _____' _____' _____'

Actual large end bevel thickness? _____' _____' _____' _____' _____'

Actual small end bevel thickness? _____' _____' _____' _____' _____'

What is the length of the reducer? _____' _____' _____' _____' _____'

What is actual ID of small end at bevel? _____' _____' _____' _____' _____'
(CHECK TWO PLACES)

What is actual ID of large end at bevel? _____' _____' _____' _____' _____'
(CHECK TWO PLACES)

Are both bevels $30^{\circ}+5^{\circ}/-0^{\circ}$? _____' _____' _____' _____' _____'

Are both ends on plane? _____' _____' _____' _____' _____'

SFI S/N stamped on it? _____' _____' _____' _____' _____'

SPECTRA S/N stamped on it? _____' _____' _____' _____' _____'

Have all areas needing cosmetic grinding
been marked? _____' _____' _____' _____' _____'

grind weld seam flush on both ID and OD
for 2" minimum from ends.

FORM BY HAMMER

IF ORDER SIZE IS LARGER THAN FURNACE LOAD, PRIOR TO HEAT TREAT SERIALIZE UNDER CUTTER STAMP

HEAT TREATMENT PER QCP 8.1 REV. 1

NORMALIZE (3/4 HR) @ 1650°F ~~AIR COOL~~ - WATER QUENCH FURNACE LOAD # _____
TEMPER (1 1/4 HR) @ 1100 °F AIR COOL FURNACE LOAD # _____
Use furnace #1 or 2 only

IF QUENCH AND TEMPERED, RECORD THE FOLLOWING
TIME FROM FURNACE TO QUENCH TANK _____
TEMPERATURE OF QUENCH TANK _____

100% RADIOGRAPH WELD SEAM PER SPEC. XL-RT-100 (LATEST REVISION)

SHOTBLAST TO NEAR WHITE METAL FINISH

DO NOT MACHINE UNTIL TESTING COMPLETE.

MACHINE PER MSS-SP-75-14: EXCEPT 14 DEG. MIN. 18 DEG. MAX INTERNAL TAPER

16 (SMALL) END-STRAIGHT BORE I.D. TO 14.75 ± 1/16
(FACE, TAPER BORE, AND BEVEL)

ME ALL WELD BEVELS PER SPEC. XL-MT-100 (LATEST REVISION) AND PF1.13 PARA. 7A10 (5/28/18)
ATTACH REPORTS

STAMP PER MSS-SP-75-14 ON O.D. A MINIMUM OF 2" FROM BEVEL IF THRU-BORE, ACTUAL ID: _____

SPECTRA S/N PO PUR-5020-2009254 / 5 / _____

SFI SERIAL NUMBER 231228 - C1

HARDNESS TEST (235 MAX BHN) EACH PIECE: _____

PAINT EXTERIOR ONLY AFTER INSPECTION

~~PAINT RED FLUORESCENT STRIPE DOWN LENGTH OF FITTING (CE=_____)~~

PAINT MARK: _____

END PROTECT/PALLETIZE

PF1.9 MPS & ITP REV. 0 IS APPROVED BY REX LITRELL, SPECTRA ENERGY, 3/1/12

Base and weld charpies minimum 20/15 ft-lbs
CE can equal .45 or less
ME bevels
Base hardness
QT only Y52 and up