

Job Traveler

Job Number: 231229-01



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: 231229

Dated: 06/27/2023

Quote No: 19106

Customer: EDGEN119955

PO Num: RMS-298619

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		Cylinder Cut Cylinder Cut			07/13/2023	07/13/2023	1
20	FORGE 4 HAMMER		Large Hammer Hammer			07/17/2023	07/17/2023	1
30	FORGE 7 HEAT TREAT		Heat Treat Heat Treat			09/05/2023	09/05/2023	1

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Report Generated: 07/12/2023 10:56:12 AM

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50

PIPE 13
X RAY

Pipe X Ray
X-ray weld

09/05/2023 09/06/2023

1



60

E1
MACHINING

E1 Extender
Expander

09/06/2023 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: 1	
-----Quantity-----					Sub-	
Needed	On Hand	Posted	Short	Unit	Assy	Vendor
27.00000	87.00000	27.00000	0.00000	EA	NO	SFI
					PI0 36-1.25-Y52	
					Quantities from Bins/Lot Number:	
					BCKU (27.0)	

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCKU
36X16
.750X.375
WPHY70
231229-01
PUR-5020-2009252/3

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-5020-2009252 / 3 / _____

SFI SERIAL NUMBER 231229 - 01 _____

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