

Job Traveler

Job Number: 231288-02



Due Date: 08/25/2023

Sold MRC GLOBAL (US), INC
To: ATTN: INVOICE AUDITING DEPT
P.O. BOX 513
CHARLESTON, WV 25322

Ship MRC GLOBAL (US), INC
To: 2911 S GREAT SW PARKWAY
SUITE 100
GRAND PRAIRE, TX 75052
United States

Order No: 231288

Dated: 07/11/2023

Quote No: 19567

Customer: MRC GL257952

PO Num: C0132189834B0

Ship Via: ODFL COLLECT

Priority: 3 - STANDARD

Part Number: *3TE24Y

Product Code: TEE

Description: TE 24 .625-WPHY65

Master Job No:

W/ BARS

MSSSP75-14

Total Qty Open: 2 EA

Qty Posted: 0 EA

Qty To Make: 2

Start Date: 02/29/2024

Phone: 3,043,485,211

Contact: JOSE BARRERA

Fax:

Job Notes

BCJF
B10426
QR CODE ATTACHED

QTY (1); OTHER TEE w/ SEPARATE TRAVELER

Routing

Routed By:

Quantity 2

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- Start End		Run Quantity
10	FORGE 7 HEAT TREAT	Heat Treat					02/29/2024	02/29/2024	2
20	FORGE 5-6 FORGE BLAST	Forge Shotblast					02/29/2024	02/29/2024	2
30	PIPE 13 X RAY	Pipe X Ray					02/29/2024	02/29/2024	2

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Report Generated: 07/11/2023 9:03:25 AM

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40	E1 MACHINING	E1 Extender	02/29/2024 03/04/2024	2
				
50	M7 SM BULL MACHINING	M7 Small Bullard Machining	03/04/2024 03/05/2024	2
				
60	PIPE 11 WELD BARS	Special Welds	03/05/2024 03/06/2024	2
				
70	FAB 8 GRINDING	Fab Grind Grinding Bars	03/06/2024 03/06/2024	2
				
80	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	03/06/2024 03/06/2024	2
				
90	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	03/06/2024 03/06/2024	2
				
100	STAMP 1 STAMP	Stamping	03/06/2024 03/06/2024	2
				
110	INSPECT 1 INSPECTION	Inspection 1	03/06/2024 03/06/2024	2
				



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: 2	
<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>
2.00000	38.00000	2.00000	0.00000	EA	*2TE24XHY	YES
TE2 24X24-XH-XH-Y60						
Quantities from Bins/Lot Number:						
BCJF/221382-03 (2.0)						



BCJF
24X24
.625X.625
WPHY65
231288-02

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

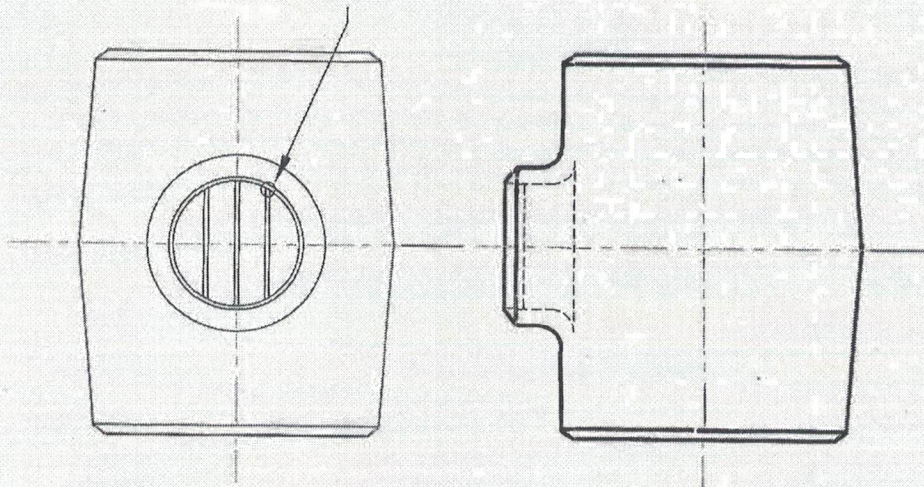
outlet by means of a continuous full fusion weld along contact area.

Bars shall be beveled to fit inside contour of contact surface. Scraper bar welds to be wet magnetic particle examined.

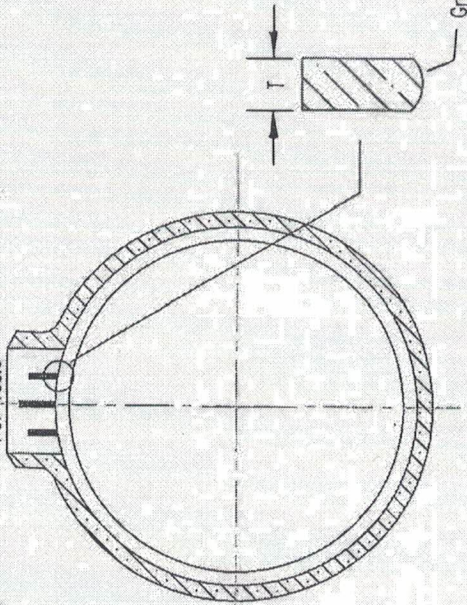
PWHT of tees will occur after bars installed. Stress Relieving

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.



Bars Equally Spaced Per Table



Grind Edge

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

STEEL FORGINGS, INC.

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

Rev.	Date	By	Revision
3	5/9/03	JL	Revised PWHT note
2	8/6/96	JD	Revised Sections A-A

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 1/2 HR @ 1650°F WATER QUENCH FURNACE LOAD # 7-1-2023 - 932

TEMPER 1 HR @ 1200 °F - AIR COOL - FURNACE LOAD# 2-2023 - 997

MT 7-28-23

100% RADIOGRAPH WELD SEAM PER SPEC. XL-RT-100 (LATEST REVISION) 8-14-23 SLW

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 8-15-23 SLW

HEAT TREATMENT PER QCP 8.1 REV.1: STRESS RELIEVE 1 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: 22.250 + 1/8 -0 22.750
0.625
0.615

BORE OUTLET I.D. STRAIGHT TO: 22.250 + 1/8 -0 22.750
0.625
0.615

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE