

Job Traveler

Job Number: 231293-01



Due Date: 08/01/2023

Sold To: TEAM, INC.
200 HERMANN DRIVE
ALVIN, TX 77511

Ship To: DIXIE MANUFACTURING
6330 DIXIE DRIVE
HOUSTON, TX 77087
United States

Order No: 231293

Dated: 07/11/2023

Quote No: 19911

Customer: TEAM,390502

PO Num: 1461-PO-041508-2

Ship Via: BRENDA.BROOKS@TEAMINC.CO

Priority: 1 - OVERTIME

Part Number: *3ESPT4Y

Product Code: ENCIRCLEMENT SADDLE

Description: ES 48X24-PT.4.WPHY65

Master Job No:

.750 RUN

NACE MR0175

MSSSSP-19

Total Qty Open: 1 EA

Qty Posted: 0 EA

Qty To Make: 1

Start Date: 07/19/2023
Contact: FRANZ WAGNER

Phone: 281-388-3427
Fax:

Job Notes

BCKW
B10582
PIPE SHOP TRAVELER 230-2023
CUT CYLINDER AND (1) PS 24 TOGETHER FROM SAME PLATE

DO NOT ADD SCRAP; ENOUGH PLATE IS ALLOCATED

DRAWING ATTACHED - 3" WIDE SIDE BARS *

QR CODE ATTACHED

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
 										

Job Number: 231293-01

30	PIPE 4 BIG ROLL	Big Roller Big roll	07/25/2023 07/25/2023	1
				
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	SAW SAW CUT PIPE	Saw #1 Cut Pipe	07/31/2023 07/31/2023	1
				
100	FAB 6 SPLIT/ASSEM2	Encircle Saddle Hole SPLIT/ASSEMBLY	07/31/2023 07/31/2023	1
				
110	FAB 7 CLEAN GRIND	Cleanup Grind Clean up grind	07/31/2023 07/31/2023	1
				

120	PIPE 2 SMALL ROLL	Small Roller Small rolling machine	07/31/2023 07/31/2023	1
				
130	FAB 4 SPLIT/ASSEM2	Welding Station # 1 Split pipe and assembly 2	07/31/2023 07/31/2023	1
				
140	FORGE 1 HAMMER	Small Hammer Fit Saddle	07/31/2023 07/31/2023	1
				
150	FAB 6 BURN HOLE	Encircle Saddle Hole Burn Hole	07/31/2023 07/31/2023	1
				
160	FAB 7 CLEAN GRIND	Cleanup Grind Cleanup Grind	07/31/2023 07/31/2023	1
				
170	FAB 11 FORGE BLAST	Various-Misc Blast	07/31/2023 07/31/2023	1
				
180	FAB 4 TACK/ASSEM 1	Welding Station # 1 Tack saddle to sleeve	07/31/2023 07/31/2023	1
				
190	PIPE 11 WELD PADS	Special Welds Weld Saddle	07/31/2023 08/01/2023	1
				
200	FAB 8 FAB GRIND	Fab Grind Grind	08/01/2023 08/01/2023	1
				



220

FORGE 7
HEAT TREAT

Heat Treat
Heat Treat

08/31/2023 08/31/2023

1



230

FAB 11
GOUGE RINGS

Various-Misc
Gouge Rings

08/31/2023 08/31/2023

1



240

FORGE 5-6
FORGE BLAST

Forge Shotblast
Blast

08/31/2023 08/31/2023

1



250

STAMP 1
STAMP

Stamping

08/31/2023 08/31/2023

1



260

INSPECT 1
INSPECTION

Inspection 1

08/31/2023 08/31/2023

1



270

SHIPPING
SHIPPING

Shipping

08/31/2023 08/31/2023

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

Sub-
Assy Vendor

NO SFI

----- Quantity -----

Needed

On Hand

Posted

Short

Unit

Description

2,530.00000
118,553.00000
2,530.00000
0.00000
LB
0PL75633

PL0 .75-A633-E

Quantities from Bins/Lot Number:

BCKW (2530.0)



BCKW
48X24
WPHY65
231293-01

Pipe Shop Traveler Welded R / T Cyl.

230-2023

7/11/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>TEAM</u>			SFI Order No	<u>231293-01</u>	Due Date	<u>7/19/2023</u>
Part	<u>49.813</u> ^{OD} X	<u>0.750</u> X	<u>55.000</u>			Ship Date	<u>8/1/2023</u>
Plate Size	<u>0.750</u> X	<u>154.136</u> X	<u>55.000</u>			NoPcs	<u>1</u>
Heat No.	<u>R0387</u>					Code	<u>BCKW</u>
Material	<u>A633E</u>	Test Material				Test No	

Cut 1 Plate(s) 0.750 X Thick X 154.136 Width X 55.000 Length 1803 Lbs.

Per Sketch # 6163

From (1) Plate(s) 0.750 Thick X 120.000 Wide X 156.000 Long

Stamp Plates With Heat Code BCKW

Scarf to 154.136 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 49.813 " 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

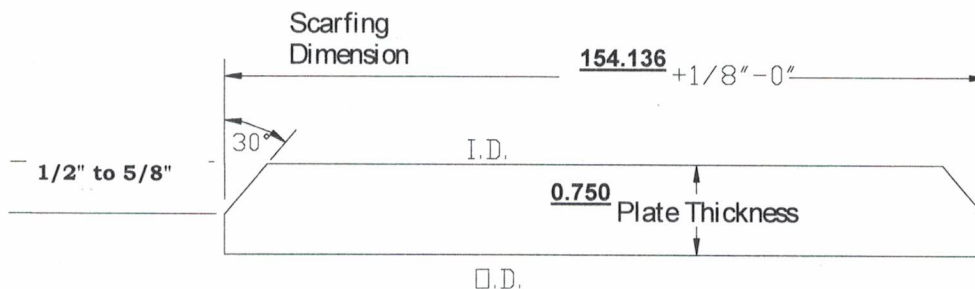
Torch Cut Into 0 Pcs @ 0 Inches

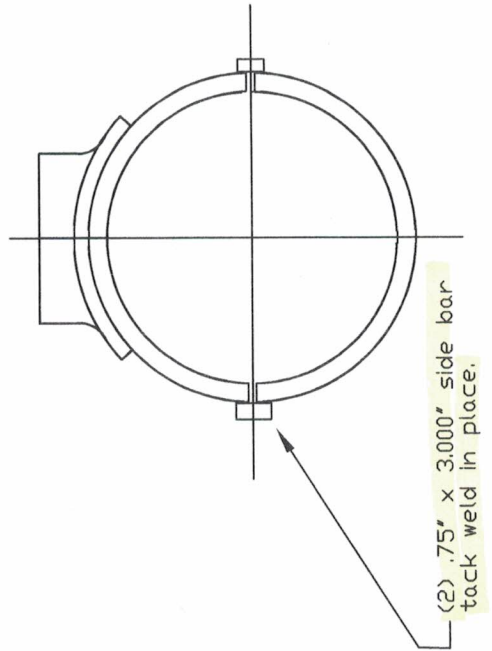
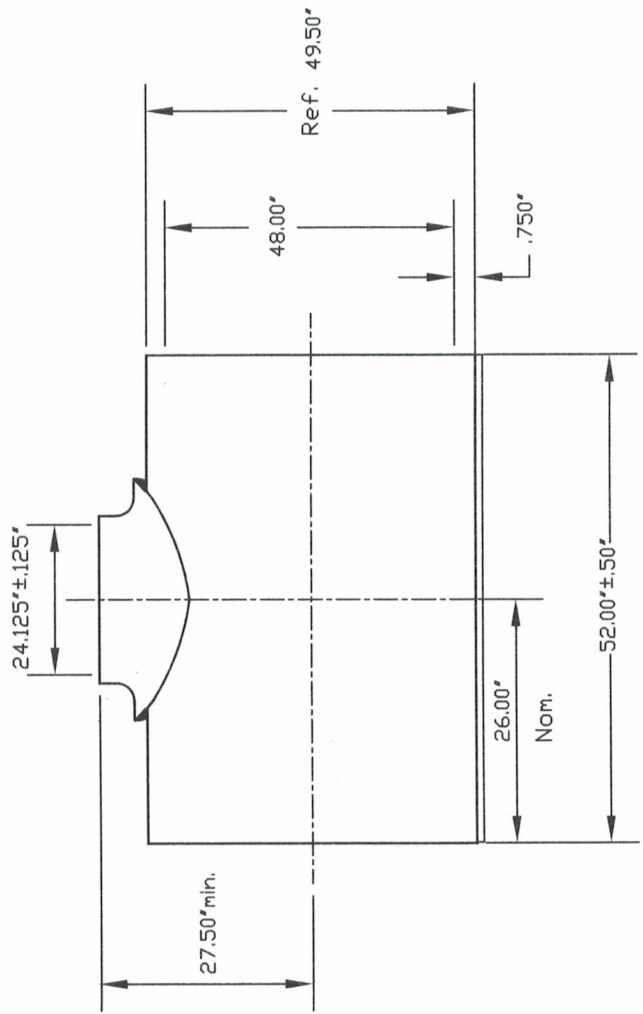
Paint Mark on Cylinder TEAM 231293-01

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

Fitting Description: (1)ES 48X24 Y65

Comments: CUT (1) PS24 FROM SAME PLATE WITH THIS CYLINDER





MAX HARDNESS: 22HRC/250HV
CHECK AT BASE, WELD, HAZ

Steel Forgings, Inc.			
Company: TEAM, INC.	PO# 1461-PO-041508-2		
Spec: MSS-SP75-19 & NACE MR0175	Qty: 1		
Description: ES Pt. 4	Date: 7/11/23		
48x24 - .750 run WPHY65	SFI #:231293		
Drawing#:	Drawn by:	Appr'd:	Scale:
Revision: 0	J. LOFDAHL		None

CUT TO LENGTH FROM PIECE _____ INCHES LONG

IF MADE FROM ROLL AND TACK, PUT IN FURNACE TO STRESS RELIEVE @ 1650°F FOR 1/2 HOUR

FORM BY HAMMER OR PRESS

FOR PART 3 AND 4 USE WELD PROCEDURE #FCAW-HY-141 REV.0

INSTALL STIFFENERS WITH MINIMAL WELDING

IF PART 1 OR 3, MACHINE GROOVE FOR BACKING STRIP, 0.75" STRIP WIDTH FOR <16" DIAMETER, 1" WIDTH FOR >= 16"

HEAT TREATMENT PER QCP 8.1 REV.1:

HEAT TREAT 1/2 HR @ 1650°F **WATER QUENCH** FURNACE LOAD # _____

TEMPER 3/4 HR @ 1300 °F - AIR COOL - FURNACE LOAD# _____

BLAST

FIT TO SIZED PIPE

FOR PART #1 AND #3 AND >24" DIAMETER, RECORD THE GREATEST GAP SIZE AND SIGN OFF

HARDNESS (BASE, WELD, HAZ) 250 MAX: B: _____ W: _____ HAZ: _____

TACK FITTING TOGETHER WITH MINIMAL WELDS

STAMP

INSPECT

GRIND