



Due Date: 08/23/2023

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

Ship MRC GLOBAL (US), INC
To: 3110 FRENCHMENS ROAD
TOLEDO, OH 43607
United States

Order No: 231303

Customer: MRC GL257952

Ship Via: ODFL COLLECT

Part Number: *3CR2412Y

Description: CR 24X12 .375 X .375-WPHY52

MS 18-2

Dated: 07/12/2023

PO Num: C1522200548B0

Priority: 3 - STANDARD

Product Code: CONCENTRIC REDUCER

Master Job No:

Quote No: 19821

Total Qty Open: 1 EA

Qty Posted: 0 EA

Qty To Make: 1

Start Date: 07/13/2023
Contact: TONYA CHARNEY

Phone: 3,043,485,211
Fax:

Job Notes

AXJH
B10857 - TESTING REQ'D
CUT (1) @ 22" FROM 124" PIECE AND CUT 3X15 FOR TESTING
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	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut					07/13/2023	07/13/2023	1
 									
20	FORGE 4 HAMMER	Large Hammer Hammer					07/13/2023	07/13/2023	1
 									
30	FORGE 7 HEAT TREAT	Heat Treat Heat Treat					07/13/2023	07/13/2023	1
 									

40	FORGE 5-6 FORGE BLAST	Forge Shotblast Forge Blast	07/13/2023	07/13/2023	1
					
50	PIPE 13 X RAY	Pipe X Ray X-Ray	07/13/2023	07/13/2023	1
					
60	E1 MACHINING	E1 Extender Expander	07/13/2023	07/13/2023	1
					
70	M9 MACHINING	M9 Medium Bullard Machining	07/13/2023	08/03/2023	1
					
80	STAMP 1 STAMP	Stamping	08/03/2023	08/03/2023	1
					
90	INSPECT 1 INSPECTION	Inspection 1	08/03/2023	08/03/2023	1
					
100	SHIPPING SHIPPING	Shipping	08/03/2023	08/03/2023	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
25.00000	200.00000	25.00000	0.00000	IN	0PI24XH52	NO SFI

PI0 24-XH-Y52
Quantities from Bins/Lot Number:
AXJH (25.0)

Job Number: 231303-01

Report Generated: 07/12/2023 9:19:29 AM



AXJH 24X12 .375X.375 WPHY52 CE .45 231303-0

FORM BY HAMMER

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- _____)

NORMALIZE 1/2 HR @ 1650°F AIR COOL FURNACE LOAD # _____

TEMPER _____ HR @ _____ °F AIR COOL FURNACE LOAD # _____

QUENCH WATER MUST BE BELOW 100°F

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

MACHINE PER MSS-SP-75-19 EXCEPT 24 "END @ BEVEL 0.375 NOMINAL

0.365 MINIMUM

12.75 "END @ BEVEL 0.375 NOMINAL

0.328 MINIMUM

0.351 MINIMUM WALL ALLOWED IN ISOLATED NON-CONTINUOUS REDUCTION OF BODY (LARGE END)

0.328 MINIMUM WALL ALLOWED IN ISOLATED NON-CONTINUOUS REDUCTION OF BODY (SMALL END)

12.75 in. (SMALL) END PRE-BORE I.D. TO 11.75 ± 1/32

(FACE, TAPER BORE, AND BEVEL)

I.D. TAPER BORING: 14° MIN - 20° MAX.

I.D. TOLERANCE AT BEVEL: +3/32" -1/32"

WET MAG PARTICLE EXAMINE END BEVELS PER PARA. 2.11 OF MS 18-2 SPEC. DTD. 3/07 AND

PER SPEC. XL-MT-100 (LATEST REVISION) _____

STAMP AS CLOSE TO BEVEL AS PRACTICAL (CIRCUMFERENTIALLY): PER MSS-SP-75-2019

HARDNESS TEST: _____ **~~PIECES ONLY IF Q&T (BASE, WELD, HAZ); 241 BHN MAX~~**

PC# _____

SHOTBLAST I.D. AND O.D. TO NEAR WHITE FINISH

PAINT WITH RUST INHIBITING PAINT

END PROTECT USING 1/2" PLYWOOD/PALLETIZE

LONGER FURNACE HOLDING TIMES

S:\PUBLIC\TAVELER\MICHCON MS-18\MS-18 TRAVELERS.XLSX