

# Job Traveler

Job Number: 231303-02



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

Dated: 07/12/202

Quote No: 19821

Customer: MRC GL257952

PO Num: C1522200548B0

Ship Via: ODFL COLLECT

Priority: 3 - STANDARD

Part Number: \*3CR128Y

Product Code: CONCENTRIC REDUCER

Description: CR 12X8 .375 X .322-  
WPHY52

Master Job No:

MS 18-2

Total Qty Open: 1 EA

Qty Posted: 0 EA

Qty To Make: 1

Start Date: 07/12/2023

Phone: 3,043,485,211

Contact: TONYA CHARNEY

Fax:

## Job Notes

BCCW  
B10724  
CUT (1) @ 9" FROM 54" PIECE  
QR CODE ATTACHED

## Routing

Routed By:

Quantity 1

| Step No | Work Cntr / Vendor  |             | Setup | Cycle | Total | Pieces   | --- Scheduled --- |            | Run      |
|---------|---------------------|-------------|-------|-------|-------|----------|-------------------|------------|----------|
| Dept    | Operation           | Description | Time  | Time  | Time  | Per Hour | Start             | End        | Quantity |
| 10      | SAW<br>SAW CUT PIPE | Saw #1      |       |       |       |          | 07/12/2023        | 07/12/2023 | 1        |



|    |                   |              |  |  |  |  |            |            |   |
|----|-------------------|--------------|--|--|--|--|------------|------------|---|
| 20 | FORGE 1<br>HAMMER | Small Hammer |  |  |  |  | 07/26/2023 | 07/26/2023 | 1 |
|----|-------------------|--------------|--|--|--|--|------------|------------|---|



|    |                       |            |  |  |  |  |            |            |   |
|----|-----------------------|------------|--|--|--|--|------------|------------|---|
| 30 | FORGE 7<br>HEAT TREAT | Heat Treat |  |  |  |  | 09/04/2023 | 09/04/2023 | 1 |
|----|-----------------------|------------|--|--|--|--|------------|------------|---|



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|                                                                                   |                                                                                    |                 |            |            |   |
|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------|-----------------|------------|------------|---|
| 40                                                                                | FORGE 5-6<br>FORGE BLAST                                                           | Forge Shotblast | 09/04/2023 | 09/04/2023 | 1 |
|   |   |                 |            |            |   |
| 50                                                                                | L6 & L8<br>MACHINING                                                               | L6 & L8         | 09/04/2023 | 09/05/2023 | 1 |
|   |   |                 |            |            |   |
| 60                                                                                | STAMP 1<br>STAMP                                                                   | Stamping        | 09/05/2023 | 09/05/2023 | 1 |
|   |   |                 |            |            |   |
| 70                                                                                | INSPECT 1<br>INSPECTION                                                            | Inspection 1    | 09/05/2023 | 09/05/2023 | 1 |
|   |   |                 |            |            |   |
| 80                                                                                | SHIPPING<br>SHIPPING                                                               | Shipping        | 09/05/2023 | 09/05/2023 | 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 |
| 9.00000                                                          | 128.00000 | 9.00000 | 0.00000 | IN   | 0PI12S8052  | NO SFI          |
| PI0 12-S80-Y52<br>Quantities from Bins/Lot Number:<br>BCCW (9.0) |           |         |         |      |             |                 |



BCCW 12X8 .375X.322 WPHY52 231303-02

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 B16.9 EXCEPT 12.75 "END @ BEVEL 0.375 NOMINAL

0.328 MINIMUM

8.625 "END @ BEVEL 0.322 NOMINAL

0.282 MINIMUM

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

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

8.625 in. (SMALL) END PRE-BORE I.D. TO 7.731 ± 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