

Job Traveler

Job Number: 231335-02



Due Date: 09/11/2023

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: 231335**Dated:** 07/17/2023**Quote No:** 19994**Customer:** EDGEN119955**PO Num:** RMS-299132**Ship Via:** TIFFANY.BAKER@EDGENMURR**Priority:** 3 - STANDARD**Part Number:** *3TE3610Y**Product Code:** TEE**Description:** TE 36X10 .750 X .365-
WPHY70**Master Job No:**TAG: PUR-5020-2009505 /
LINE 10

ES-PF1.14

Total Qty Open: 6 EA**Qty Posted:** 0 EA**Qty To Make:** 6**Start Date:** 07/25/2023**Phone:** 2,257,569,868**Contact:** CLAIRE BLAY**Fax:**

Job Notes

BCOR
B10864 - TESTING REQ'D
PIPE SHOP TRAVELER 238-2023
DO NOT ADD SCRAP

Routing

Routed By:**Quantity 6**

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- Start End		Run Quantity
10	PIPE 3 PLATE BURN	Burning Table Plate Burn					07/25/2023	07/25/2023	6
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					07/31/2023	07/31/2023	6



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30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	07/31/2023 07/31/2023	6
				
40	PIPE 7 STRING UP	Initial Weld String-up	07/31/2023 07/31/2023	6
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	07/31/2023 07/31/2023	6
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	07/31/2023 07/31/2023	6
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	08/01/2023 08/01/2023	6
				
80	PIPE 9 OD WELD	OD Weld OD Weld	08/03/2023 08/03/2023	6
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/10/2023 08/10/2023	6
				
100	FORGE 8 TRIM	Torch Cut Cut hole	09/12/2023 09/12/2023	6
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	09/12/2023 09/13/2023	6
				

120	FORGE 8 TRIM	Torch Cut Trim	09/14/2023 09/18/2023	6
				
130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/08/2024 02/12/2024	6
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/12/2024 02/12/2024	6
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/12/2024 02/13/2024	6
				
160	E1 MACHINING	E1 Extender Expander	02/13/2024 02/13/2024	6
				
170	M1 MACHINING	M1 Big Mill Machining	02/13/2024 02/19/2024	6
				
180	STAMP 1 STAMP	Stamping	02/19/2024 02/19/2024	6
				
190	INSPECT 1 INSPECTION	Inspection 1	02/19/2024 02/19/2024	6
				



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: 6		
Needed	On Hand	Posted	Short	Unit	Description	Sub- Assy Vendor
15,945.00000	861,921.00000	15,945.00000	0.00000	LB	0PL125633	NO CLIFF STEEL
PL0 1.25-A633-E						
Quantities from Bins/Lot Number:						
BCOR-02 (15945.0)						

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCOR
36X10
.750X.365
WPHY70
231335-02
PUR-5020-2009505/10

Pipe Shop Traveler Tee Cyl.

238-2023

7/17/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>EDGEN</u>	SFI Order No	<u>231335-02</u>	Due Date	<u>8/11/2023</u>
Part	<u>39.000</u> OD X <u>1.250</u> X <u>112.000</u>			Ship Date	<u>9/11/2023</u>
Plate Size	<u>1.250</u> X <u>118.595</u> X <u>112.000</u>			NoPcs	<u>3</u>
Heat No.	<u>R3380</u>			Code	<u>BCOR-02</u>
Material	<u>A633E</u>	Test Material		Test No	

Cut 3 Plate(s) 1.250 X Thick X 118.595 Width X 112.000 Length 4709 Lbs.

Per Sketch #

From (1) Plate(s) 1.250 Thick X 130.000 Wide X 346.000 Long

Stamp Plates With Heat Code

BCOR-02

Scarf to 118.595 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 39.000 " 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 2 Pcs @ 55 Inches

Paint Mark on Cylinder

EDGEN

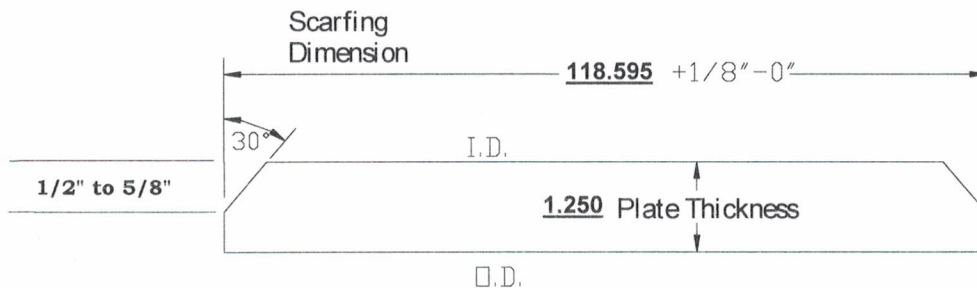
231335-02

Stamp Each Cylinder in (2) Places With Heat Code

BCOR-02

Fitting Description: (6)TE 36X10 Y70

Comments:



36" Run Diameter = 36.542"

10" Outlet Diameter = Free pull in 36 x 18 dies

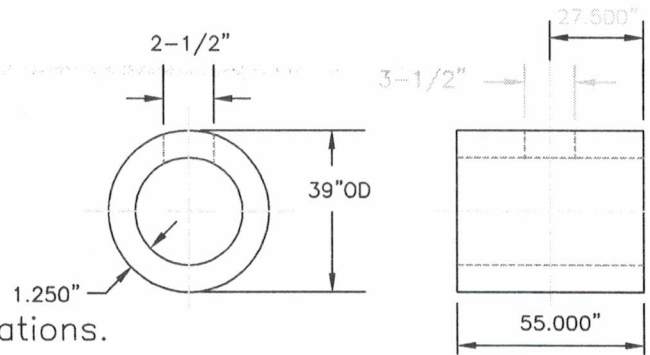
Material Size 39" O.D. x 1.250"W

Length 55.000"

Hole size 3"x4" oval

Grind $1/8"$ radius on hole edges

I.D. & O.D.



SHOP NOTE: Cut hole after barreling operations.

Ovaling Data: Oval: HOT Oval width: $35-3/4" \pm 1/4"$

Preform Data:

Press: Machine 2000 Ton Set up#10139 Upper Die# 50046

Lower Die# 50082 with 36x18" Insert #50090

1st Oper: Heat to 1650°F.—Quench in 23-1/2" of water.

Barrel down HOT with HOT side up.

Close dies to 3"

2nd Oper: Re-heat to 1650°F.

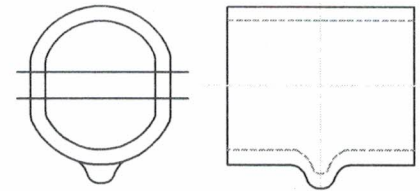
Quench barreled side in 21-1/2" of water & barrel down HOT with HOT side up. Close dies to 1".

3rd Oper: Re-heat to 1650°F.

Quench to cool outlet area only

Barrel down HOT with HOT side up.

Close dies

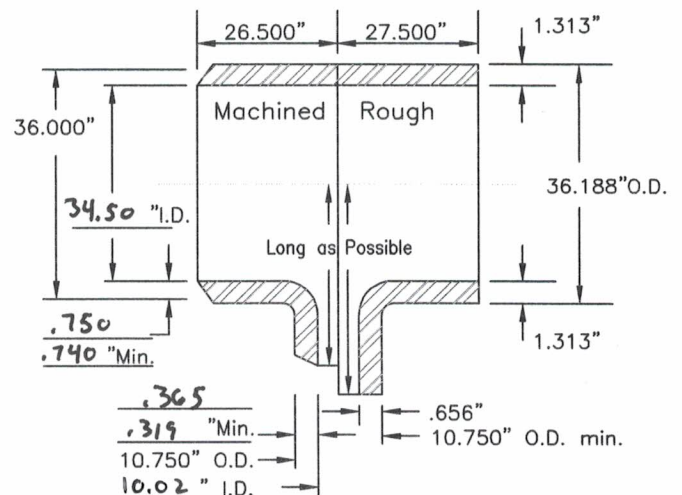


4th Oper: Drill outlet hole per above

5th Oper: Locally heat outlet area with torches & Free pull 4-1/2" plug(2-1/2" rod)

6th Oper: Locally heat outlet area with torches & Free pull 6-3/4" plug(3" rod)

Final Oper: Locally heat outlet area with torches & Free pull 9-1/2" plug(3-1/2" rod)



				DATE: 11-17-99	36 x 10" <u>.750 x .365</u> HIGH YIELD TEE MFG. DATA	DWG# 36-10-4 Use for bevel thicknesses: Run—.751" thru .833". Outlet—.593" and less.
				SCALE: NONE		
				DRAWN BY: J.D.		
				CHECKED BY: Bull		
1	revised hole from 2.5x3.5 to 3x4	jl	10/25/92			
REV	DESCRIPTION	BY	DATE			

DOCUMENT PACKAGE

Fitting Description TEE 36x10 .750 x.365 Y70

SFI Serial Number 231335 - 02

Spectra Serial Number PO Pur - 5020-2009505 / 10 / 01 - 06

ME inspection report

MTR's

Reader Sheet for Radiography

Inspection sheet with actual dimensions

Heat Treat charts

Furnace Uniformity & Quarterly Recorder Calibration records

DIMENSIONAL INSPECTION SHEET FOR TEE

Does stamping match traveler? _____' _____' _____' _____' _____'

What is actual run bevel thickness? _____' _____' _____' _____' _____'

What is actual outlet bevel thickness? _____' _____' _____' _____' _____'

What is the length of the tee? _____' _____' _____' _____' _____'

What is actual ID of run at bevel?
(Check two places) _____' _____' _____' _____' _____'

What is actual ID of outlet?
(Check two places) _____' _____' _____' _____' _____'

What is M dimension? _____' _____' _____' _____' _____'

Is outlet centered?

Are all three bevels $30^{\circ}+5^{\circ}/-0^{\circ}$? _____' _____' _____' _____' _____'

SFI serial number stamped on it? _____' _____' _____' _____' _____'

Spectra serial number stamped on it? _____' _____' _____' _____' _____'

Have all areas needing cosmetic grinding been marked? _____' _____' _____' _____' _____'

Grind weld seam inside and outside flush
for minimum 2" from ends.

FORM BY EXTRUSION PER CARD _____

PRE CUT ENDS

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 SEAMS PER SPEC. XL-RT-100 (LATEST REVISION)

SHOTBLAST TO NEAR WHITE METAL FINISH

DO NOT MACHINE UNTIL TESTING COMPLETE.

BORE RUN I.D. STRAIGHT THRU TO: 33.75 +1/4 -0 34.50 ^{.750} _{.740}

BORE OUTLET STRAIGHT TO: 9.77 ± 1/16 10.02 ^{.365} _{.319}

MACHINE PER MSS-SP-75-19: EXCEPT 14 DEG. MIN. 18 DEG. MAX INTERNAL TAPER IF ~~THRU BORE~~, ACTUAL ID. _____

MAGNETIC PARTICLE EXAMINE BEVELED ENDS OF OUTLET PER SPEC. XL-MT-100 (LATEST REVISION) AND PARA. 7A5 & 7A10 OF SPEC. PF1.13. (5/28/18) AND ALL WELD BEVELS ALONG WITH INSIDE AND OUTSIDE OF OUTLET CROTCH IF IT IS Y60 AND GREATER AND ACCESSIBLE. ATTACH REPORTS

STAMP PER MSS-SP-75-19 ON O.D. A MINIMUM OF 2" FROM BEVEL & WELD SEAM * QR CODE *

SFI SERIAL NUMBER 231335 - 02

SPECTRA SERIAL NUMBER PO PUR-5020-2009505 / 10 / 01, 06

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

CUSTOMER INSPECTION MAY BE REQUIRED

MPS & ITP FOR PF1.9 REV. 0 IS APPROVED 3/1/12 PER REX LITTRELL, SPECTRA ENERGY

Base and weld charpies minimum 20/15 ft-lbs

CE can equal .45 or less

ME bevels

Base hardness

QT only Y52 and up