

Job Traveler

Job Number: 231335-03



Due Date: 09/11/2023

Sold EDGEN MURRAY CORPORATION
To: 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: *3TE36Y

Product Code: TEE

Description: TE 36 .750-WPHY70

Master Job No:

THRU BORE

MIN ID 34.5"

W/ BARS

TAG: PIGGABLE

PUR-5020-2009505 /
LINE 11

ES-PF1.14

Total Qty Open: 2 EA

Qty Posted: 0 EA

Qty To Make: 2

Start Date: 07/25/2023

Phone: 2,257,569,868

Contact: CLAIRE BLAY

Fax:

Job Notes

BCLV
B10662-1 - TESTING REQ'D
PIPE SHOP TRAVELER 239-2023
DO NOT ADD SCRAP

Routing

Routed By:

Quantity 2

Step No	Work Cntr / Vendor	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			07/25/2023	07/25/2023	2



Job Number: 231335-03

Report Generated: 07/17/2023 4:19:37 PM

Page 1 of 5

20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating	07/31/2023 07/31/2023	2
				
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	07/31/2023 07/31/2023	2
				
40	PIPE 7 STRING UP	Initial Weld String-up	07/31/2023 07/31/2023	2
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	08/01/2023 08/01/2023	2
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	08/01/2023 08/01/2023	2
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	08/01/2023 08/01/2023	2
				
80	PIPE 9 OD WELD	OD Weld OD Weld	08/03/2023 08/03/2023	2
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/10/2023 08/10/2023	2
				
100	FORGE 8 TRIM	Torch Cut Cut hole	09/12/2023 09/12/2023	2
				

110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	09/12/2023 09/12/2023	2
				
120	FORGE 8 TRIM	Torch Cut Trim	09/18/2023 09/18/2023	2
				
130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/12/2024 02/12/2024	2
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/12/2024 02/13/2024	2
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/13/2024 02/13/2024	2
				
160	E1 MACHINING	E1 Extender Expander	02/13/2024 02/13/2024	2
				
170	M1 MACHINING	M1 Big Mill Machining	02/13/2024 02/14/2024	2
				
180	PIPE 11	Special Welds Bars	02/14/2024 02/19/2024	2
				
190	FAB 8 GRINDING	Fab Grind Grinding Bars	02/19/2024 02/20/2024	2
				

200	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	02/20/2024	02/20/2024	2
					
210	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	02/20/2024	02/20/2024	2
					
220	PIPE 13 X RAY	Pipe X Ray ME inspection of weld	02/20/2024	02/20/2024	2
					
230	STAMP 1 STAMP	Stamping	02/20/2024	02/20/2024	2
					
240	INSPECT 1 INSPECTION	Inspection 1	02/20/2024	02/20/2024	2
					
250	SHIPPING SHIPPING	Shipping	02/20/2024	02/20/2024	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:	2
					Sub- Assy	Vendor
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>	<u>Unit</u>	<u>Description</u>	
5,558.00000	851,534.00000	5,558.00000	0.00000	LB	0PL125633	NO CLEVELAND -CL
					PL0 1.25-A633-E	
					Quantities from Bins/Lot Number:	
					BCLV-11,12 (5558.0)	

Marking Information:



FLEET-LINE[®]

MADE IN USA
STEEL FORGINGS

BCLV
36X36
.750X.750
WPHY70
231335-03
PUR-5020-2009505/11
PIGGABLE

Pipe Shop Traveler Tee Cyl.

239-2023

7/17/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>EDGEN</u>		SFI Order No	<u>231335-03,04</u>	Due Date	<u>8/11/2023</u>
Part	<u>43.500</u>	OD X	<u>1.250</u> X	<u>58.000</u>	Ship Date	<u>9/11/2023</u>
Plate Size	<u>1.250</u>	X	<u>132.733</u> X	<u>58.000</u>	NoPcs	<u>4</u>
Heat No.	<u>R1978</u>				Code	<u>BCLV-11</u>
Material	<u>A633E</u>	Test Material	<u>CUT (2) 6X12 FOR 12X12</u>		Test No	<u>10662-1</u>

Cut 4 Plate(s) 1.250 X Thick X 132.733 Width X 58.000 Length 2729 Lbs.

Per Sketch #

From (1) Plate(s) 1.250 Thick X 134.000 Wide X 296.000 Long

Stamp Plates With Heat Code BCLV-11

Scarf to 132.733 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 43.500 " 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

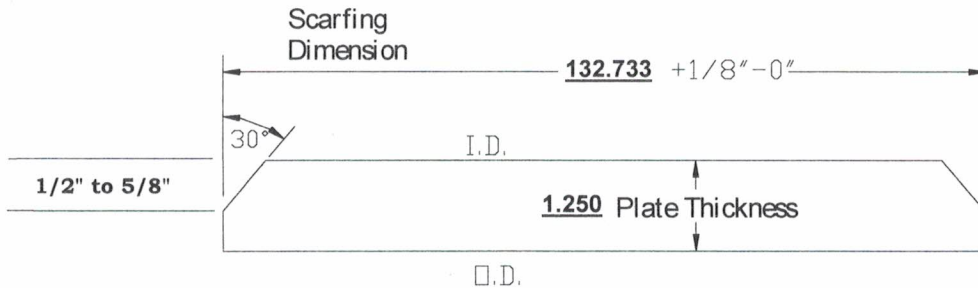
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder EDGEN 231335-03,04

Stamp Each Cylinder in (2) Places With Heat Code BCLV-11

Fitting Description: (4)TE 36 Y70

Comments:



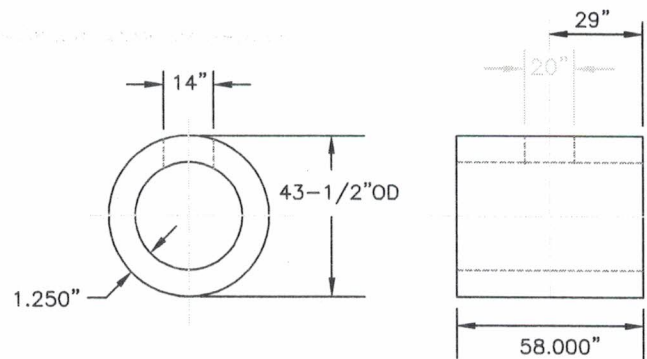
36" Run Diameter = 36.542"

36" Outlet Diameter = 36.699"

Material Size 43-1/2" O.D. x 1.250"W
Length 58.000"

Hole size 14" x 20" Oval

Grind 1/8" radius on hole edges
I.D. & O.D.

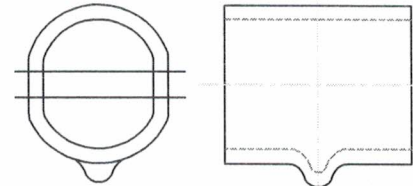


Ovaling Data: Oval: HOT Oval width: 35-3/4" ± .1/4"

Preform Data:

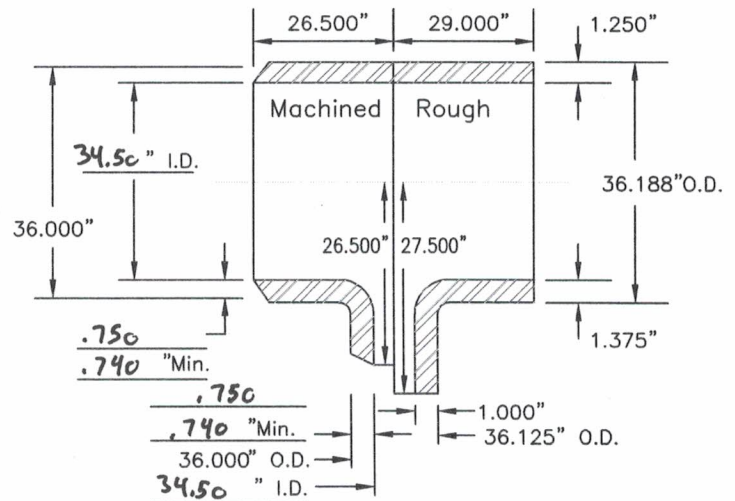
Press: Machine 2000 Ton Set up #10139 Upper Die# 50046
Lower Die# 50045

1st Oper: Heat to 1650°F
Quench in 30" of water
Close dies HOT to 7-1/2"
Pull 23.210" plug (6" rod)



2nd Oper: Re-heat to 1650°F
Quench in 25-1/2" of water
Close dies to 3" &
Pull 29.140" plug (6" rod)

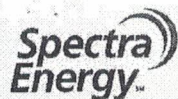
Final Oper: Re-heat to 1650°F
Do not quench
Countersink plug,
Close dies HOT &
Pull 34 1/4" plug (6" rod)



				DATE: 11-12-99
				SCALE: NONE
				DRAWN BY: J.D.
				CHECKED BY: Bull
REV	DESCRIPTION	BY	DATE	

36" x 36"
.750
HIGH YIELD
TEE MFG. DATA

DWG#
36-36-4
(use for all bevel thicknesses
from .751" thru .833")



Spec. Number: **ES-PF6.4**

Prev. Issue Date: **02/13/2004**

Section **I** of **II**

Material/Equipment Specification

Revision Date: **09/21/2011**

Page **6** of **7**

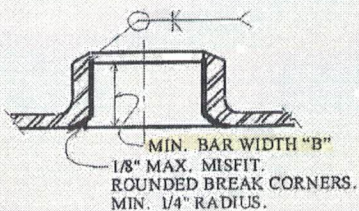
Title: **SCRAPER BARS**

11 FIGURES

Spectra Energy Transmission SD-F-1 STANDARD DRAWING - SCRAPER BAR TEES

		BRANCH DIAMETER																		
RUN DIA.	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	42	48	
4	1/4																			
6	1/4	1/4																		
8	1/4	1/4	1/4								THICKNESS OF BARS (INCHES)									
10	1/4	1/4	1/4	1/4																
12	1/2	1/2	1/2	1/2	1/2															
14		1/2	1/2	1/2	1/2	1/2														
16		1/2	1/2	1/2	1/2	1/2	1/2													
18		1/2	1/2	1/2	1/2	1/2	1/2	1/2												
20			1/2	1/2	1/2	1/2	1/2	1/2	1/2											
22			1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2										
24			1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	3/4									
26				1/2	1/2	1/2	1/2	1/2	1/2	1/2	3/4	3/4								
28				1/2	1/2	1/2	1/2	1/2	1/2	1/2	3/4	3/4	3/4							
30				1/2	1/2	1/2	1/2	1/2	1/2	1/2	3/4	3/4	3/4	3/4						
32					3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4					
34					3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4				
36					3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4			
42						3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4		
48						3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	1	
NO. OF BARS	1		2			3				4				5				6		

ASTM A36 FLAT BAR



Min. Weld Thickness

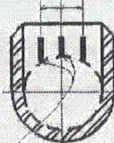
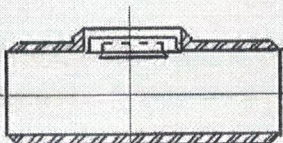
1/4" bar: 1/4" 1/2" bar: 3/8"

3/4" bar: 1/2"

1" bar: 1/2"

BARS EQUALLY SPACED

RANGE OF OUTLET SIZE	"B"
4"	1 1/2"
6"	2"
8" THROUGH 12"	2 1/2"
14" THROUGH 20"	2 3/4"
22" THROUGH 48"	3 3/8"



BOTTOM EDGE OF BARS SHALL NOT PROTRUDE INSIDE THE RUN DIAMETER.
BREAK CORNERS: 1/4" MIN. RADIUS.

SCRAPER BARS TO BE APPROX. .125" ABOVE RUN

DOCUMENT PACKAGE

Fitting Description TEE 36 -.750 Y70 w/bars

SFI Serial Number 231335 - 03

Spectra S/N PO PUR-5020-2009505 / 11 / 01, 02

Purchaser's Purchase Order

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 S/N stamped on it? _____' _____' _____' _____' _____'

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

Grind weld seam flush for 2" from ends
on both ID and OD

How many bars are there? _____

Are they equidistant (+/-1/4")? _____

What is the thickness of the bars? _____

What is the width of the bar if specified? _____

Have the bars been swept in the run? _____

What is the clearance between the run and the bars? _____

If a fillet or weld size is specified, what is the actual weld size? _____

If there is a minimum dimension from the top of the bevel or the bevel line on the outside of the outlet to the top of the bar, what is the actual? _____

If there is a minimum weld length specified, what is the actual length? _____

Have the sharp edges all been broken? _____

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