Job Traveler

Job Number: 231335-04

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:** 07/17/202 **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:**

TAG: PUR-5020-2009505 /
LINE 12

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
B10661-1
PIPE SHOP TRAVELER 239-2023
DO NOT ADD SCRAP

Routing

Routed By: **Quantity** 2

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	2
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	09/13/2023	09/13/2023	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	02/13/2024	2

140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/13/2024	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	STAMP 1 STAMP	Stamping	02/14/2024	02/14/2024	2

190	INSPECT 1 INSPECTION	Inspection 1	02/14/2024	02/14/2024	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

Quantity						Sub-Assy	Vendor
Needed	On Hand	Posted	Short	Unit	Description		
5,558.00000	851,534.00000	5,558.00000	0.00000	LB	0PL125633 PL0 1.25-A633-E Quantities from Bins/Lot Number: BCLV-11,12 (5558.0)	NO	CLEVELAND -CL

Marking Information:

FLEET-LINE®
MADE IN USA
STEEL FORGINGS

BCLV
36X36
.750X.750
WPHY70
231335-04
PUR-5020-2009505/12

Pipe Shop Traveler Tee Cyl.

239-2023
7/17/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

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

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

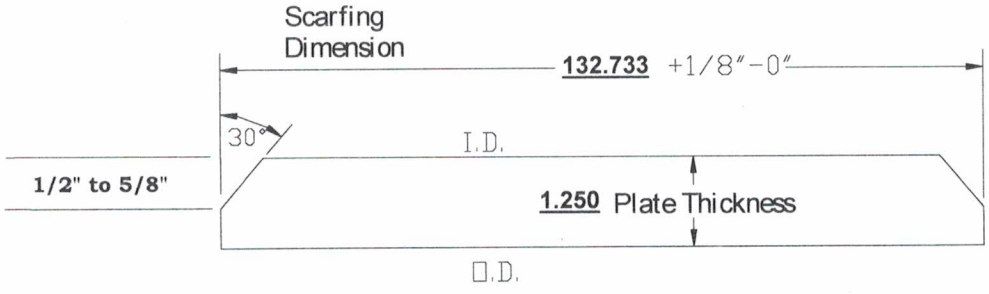
Torch Cut Into 0 Pcs @ 0 Inches

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

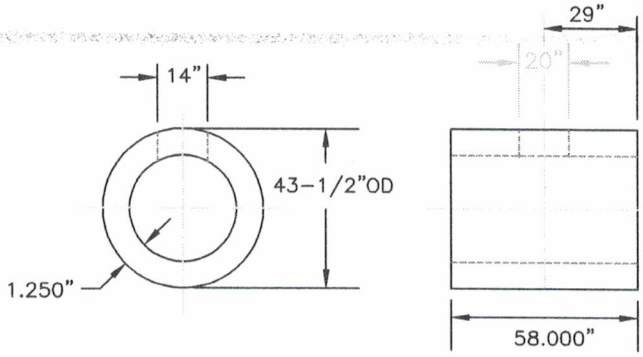
Comments:



36" Run Diameter = 36.542"
36" Outlet Diameter = 36.699"

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

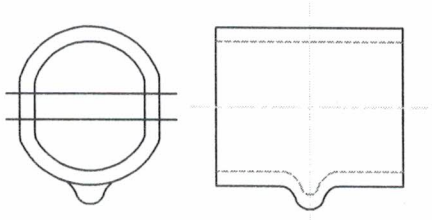
Hole size 14" x 20" Oval
Grind 1/8" radius on hole edges
I.D. & O.D.



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

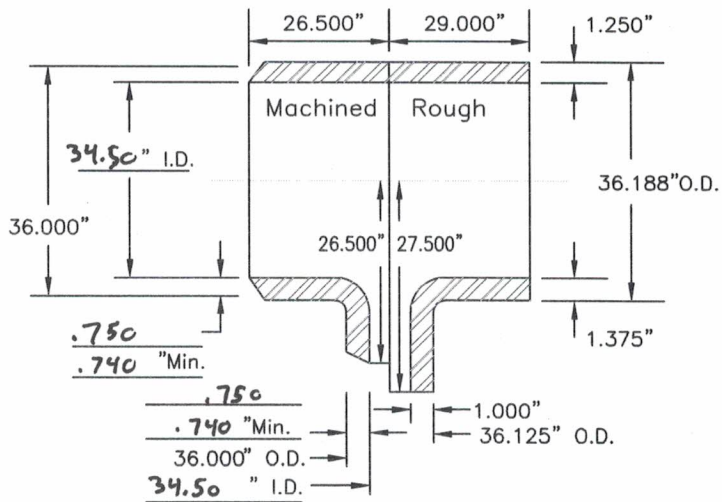
Preform Data:
Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50045

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	36" x 36" .750	DWG# 36–36– 4
				SCALE: NONE		
				DRAWN BY: J.D.		
				CHECKED BY: Bull		
					HIGH YIELD TEE MFG. DATA	(use for all bevel thicknesses from .751" thru. .833")
REV	DESCRIPTION	BY	DATE			

DOCUMENT PACKAGE

Fitting Description TEE 36 - .750 Y70

SFI Serial Number 231335 - 04

Spectra Serial Number PO PUR-5020-2009505 / 12 / 01, 02

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°+5°/ -0°? _____, _____, _____, _____, _____

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: 33.75 +1/4 -0

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 - 04

SPECTRA SERIAL NUMBER PO PUR-5020-2009505 /12/ 01, 02

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