Job Traveler

Job Number: 231340-01

Due Date: 09/11/2023

Sold To: SMP SUPPLY
PO BOX 1675
MONT BELVIEU, TX 77523

Ship To: PCW
379054 E 1130 RD
Okemah, OK 74859
United States

Order No: 231340 **Dated:** 07/17/202 **Quote No:** 20132

Customer: SMP SUPPLY **PO Num:** 88781

Ship Via: MSCHWARTZ@SMP-SUPPLY.CC **Priority:** 3 - STANDARD

Part Number: *3TE20Y **Product Code:** TEE

Description: TE 20 .412-WPHY70 **Master Job No:**

W/ BARS

-20F CVN

MSSSP75-14

Total Qty Open: 2 EA **Qty Posted:** 0 EA **Qty To Make:** 2

Start Date: 07/31/2023 **Phone:** (713)840-9333

Contact: MICHELLE SCHWARTZ **Fax:** (713)840-9339

Job Notes

BCKZ
B10707-1
CUT (2) @ 32.5" EACH FROM 132" CYLINDER
CYLINDERS IN PROCESS ON 231341-01

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	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut					07/31/2023	07/31/2023	2
20	FORGE 8 TRIM	Torch Cut Cut hole					08/01/2023	08/01/2023	2

30	FORGE 12 FORM/PRESS	2000 Ton Press Forming	08/02/2023	08/02/2023	2
40	FORGE 8 TRIM	Torch Cut Trim	09/12/2023	09/12/2023	2
50	FORGE 7 HEAT TREAT	Heat Treat	01/31/2024	02/01/2024	2
60	FORGE 5-6 FORGE BLAST	Forge Shotblast	02/01/2024	02/01/2024	2
70	PIPE 13 X RAY	Pipe X Ray	02/01/2024	02/01/2024	2
80	E1 MACHINING	E1 Extender	02/01/2024	02/01/2024	2
90	M7 SM BULL MACHINING	M7 Small Bullard Machining	02/01/2024	02/05/2024	2
100	PIPE 11 WELD BARS	Special Welds Weld Bars	02/06/2024	02/07/2024	2
110	FAB 8 GRINDING	Fab Grind Grinding Bars	02/07/2024	02/07/2024	2

120	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	02/08/2024	02/08/2024	2
130	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	02/08/2024	02/08/2024	2
140	PIPE 13 X RAY	Pipe X Ray X Ray inspection of weld	02/08/2024	02/08/2024	2
150	STAMP 1 STAMP	Stamping	02/08/2024	02/08/2024	2
160	INSPECT 1 INSPECTION	Inspection 1	02/08/2024	02/08/2024	2
170	SHIPPING SHIPPING	Shipping	02/08/2024	02/08/2024	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-	
Needed	On Hand	Posted	Short	Unit	Description	Assy	Vendor

Marking Information:

FLEET-LINE®
MADE IN USA
STEEL FORGINGS

BCKZ
20X20
.412X.412
WPHY70
231340-01

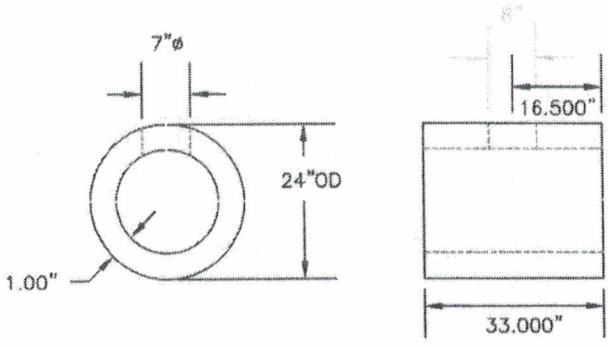
20" Run Diameter = 20.456"
20" Outlet Diameter = 20.375"

Material Size 24" O.D. x 1.00"W
Length 32.500

Hole size 7" x 8" Oval

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

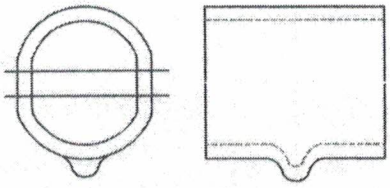
SHOP NOTE: Final plug should be 18-5/8". May have to end size (expand) outlet after precut prior to heat treat.



Ovaling Data: Oval: HOT Oval width: 19-3/4"±.1/8"

Use spacer between upper die & platten

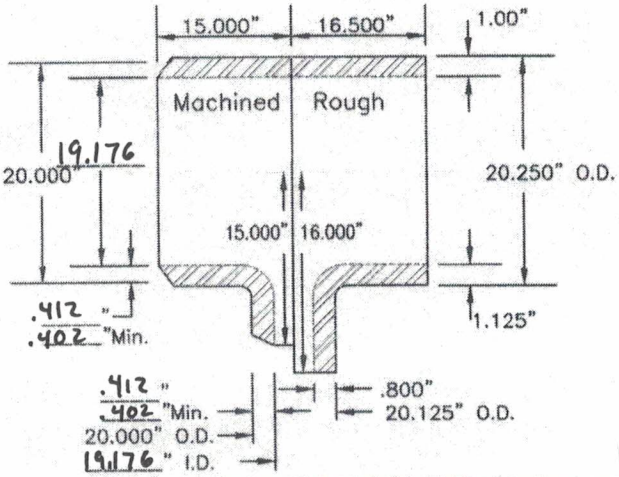
Preform Data:
Press: Machine 2000 Ton Set up#None shown Upper Die# 42206
Lower Die# 40835



1st Form: Heat to 1650°F.
Quench in 17" of water
Close to 4" &
Pull 10-1/2" plug (4" rod)

2nd Form: Re-heat to 1650°F.
Quench in 17" of water
Close dies to 2" &
Pull 13-3/4" plug (4" rod)

Final Form: Re-heat to 1650°F.
Do not quench
Close dies HOT & pull
18-1/2" plug (4" rod)

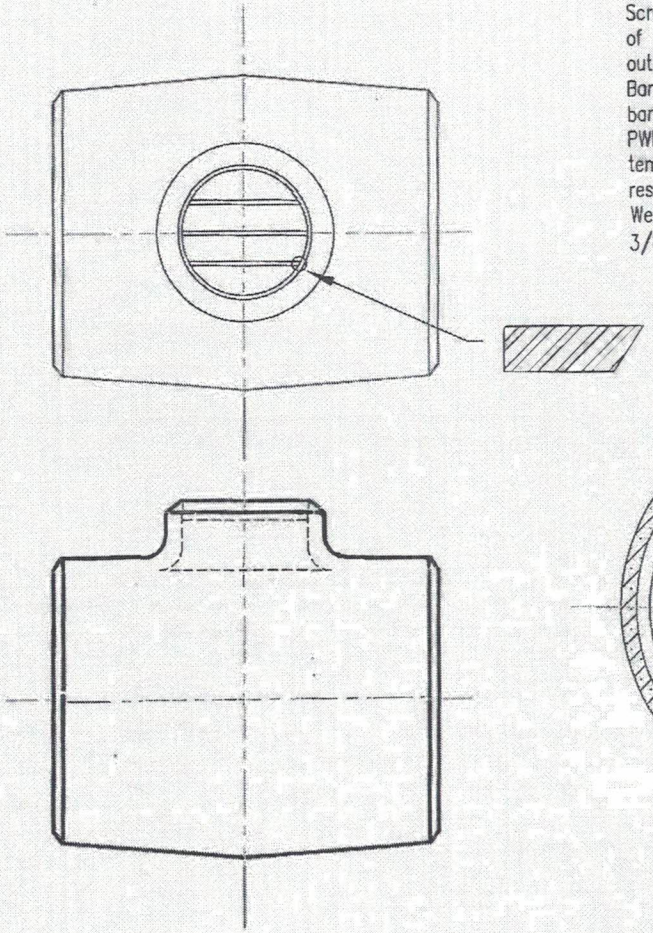


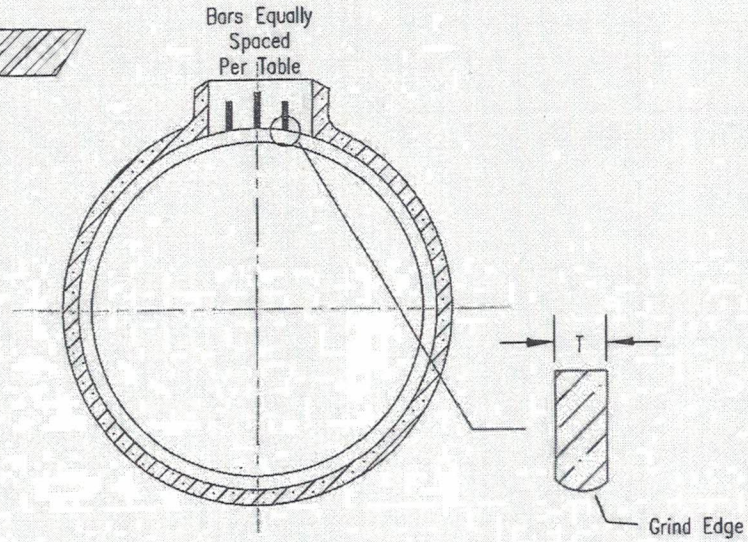
REV	DESCRIPTION	BY	DATE
			DATE: 4/12/10
			SCALE: NONE
			DRAWN BY: J.DAVIDSON
			CHECKED BY: JL

20"x 20"
(.412 x .412)
HIGH YIELD
TEE MFG. DATA

DWG#
20-20-4

Notes:
Bottom of scraper bars to have corners broken smooth with no burrs or sharp edges.
Bottom of scraper bars to be flush with inside radius of tee.
Scraper bars to be made from carbon steel having a minimum yield of 36,000 PSI and are to be welded to the inside surface of tee outlet by means of a continuous full fusion weld along contact area. Bars shall be beveled to fit inside contour of contact surface. Scraper bar welds to be wet magnetic particle examined.
PWHT of tees will occur after bars installed. Stress Relieving temperature may be the same as tempering temperature if mechanical test results satisfy specification requirements.
Weld to be a continuous weld completely around all sides of bar with 3/8" fillets.





SCRAPER BAR DATA

Outlet Size	# of Bars	Plt Thk	Width
4	1	1/2	1-3/4
6	1	1/2	2
8	1	1/2	2-1/2
10	2	1/2	3
12	2	1/2	3
14	3	1/2	3
16	3	1/2	3
18	3	1/2	3
20	3	1/2	3
24	3	1/2	3
26	3	3/4	3
30	3	3/4	3
36	3	3/4	3
42	4	1	4
48	4	1	4

Rev.	Date	By:	Revision
3	5/9/03	JL	Revised PWHT note
2	8/6/96	JD	Revised Sections A-A

STEEL FORGINGS, INC.

SCRAPER BARS FOR STRAIGHT AND REDUCING BUTT WELDING TEES

Date: 5/9/03

Drawing#: 122890
Revision: 3

Drawn by: J. Lofdahl

Appr'd:

Scale: None

FORM BY EXTRUSION PER CARD: _____

PRE CUT ENDS

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- _____)

HEAT TREAT **1/2** HR @ 1650°F **WATER QUENCH** FURNACE LOAD # _____

TEMPER **1** HR @ **1300** °F - AIR COOL - FURNACE LOAD# _____

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

INSTALL 3 1/2 " THICK X 3 " WIDE SCRAPER BARS PER SFI DWG 122890 REV.3 (ATTACHED) PER WPS FCAW-CS/HSLA-131 R.0 PER WPS FCAW-CS-HSLA-131 (LATEST REV.)

INSPECTOR TO SIGN OFF ON BARS AFTER THEY ARE FIT-UP _____

INSPECTOR TO SIGN OFF ON BARS AFTER THEY ARE GROUND _____

MAG PARTICLE EXAMINE SCRAPER BAR WELDS PER SPEC. XL-MT-100 (LATEST REVISION), ACCEPTANCE CRITERIA MORE STRINGENT OF E709 AND/OR CUSTOMER SPECIFICATION _____

HEAT TREATMENT PER QCP 8.1 REV.1: **STRESS RELIEVE** **1** HR @ **1100** °F - AIR COOL - FURNACE LOAD # _____

SHOTBLAST TO NEAR WHITE FINISH

MACHINE AFTER STRESS RELIEVE

MACHINE PER MSS-SP75-14

BORE RUN I.D. STRAIGHT TO: 18.676 + 1/8 -0 19.176 (0.412 / 0.402)

BORE OUTLET I.D. STRAIGHT TO: 18.676 + 1/8 -0 19.176 (0.412 / 0.402)

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE