

Job Traveler

Job Number: 231340-02



Due Date: 09/11/2023

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

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

Order No: 231340 Dated: 07/17/2023 Quote No: 20132
Customer: SMP SUPPLY PO Num: 88781
Ship Via: MSCHWARTZ@SMP-SUPPLY.CC Priority: 3 - STANDARD
Part Number: *3TE208Y Product Code: TEE
Description: TE 20X8 .375 X .322-
WPHY70
W/ BARS
-20F CVN
MSSSP75-14

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

Start Date: 08/01/2023

Phone: (713)840-9333

Contact: MICHELLE SCHWARTZ

Fax: (713)840-9339

Job Notes

BCKZ
B10707-1
CUT (2) @ 32" 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					08/01/2023	08/01/2023	2
20	FORGE 8 TRIM	Torch Cut Cut hole					08/02/2023	08/02/2023	2



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Report Generated: 07/17/2023 11:32:10 AM

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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	02/01/2024 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	02/07/2024 02/08/2024	2
				
110	FAB 8 GRINDING	Fab Grind Grinding Bars	02/08/2024 02/08/2024	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
					Sub-
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>	<u>Unit</u>	<u>Description</u>
					<u>Assy</u> <u>Vendor</u>

Marking Information:



FLEET-LINE[®]

MADE IN USA
STEEL FORGINGS

BCKZ
20X8
.375X.322
WPHY70
231340-02

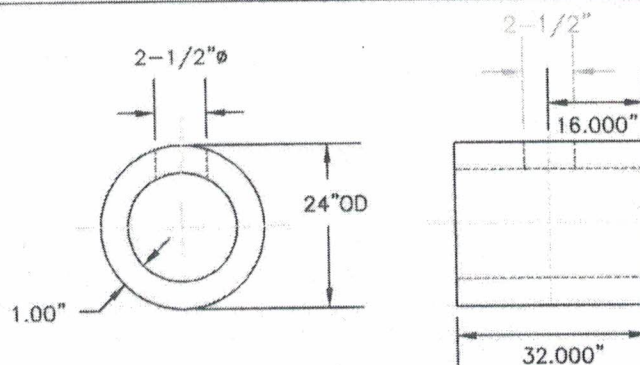
20" Run Diameter = 20.456"

8" Outlet Diameter = 8.766"

Material Size 24" O.D. x 1.00"W
Length 32.000"

Hole size 2-1/2"

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

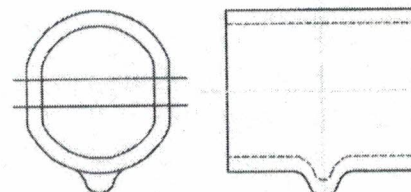


Valing Data: Oval: HOT Oval width: 19-3/4" ± 1/8"

Preform Data:

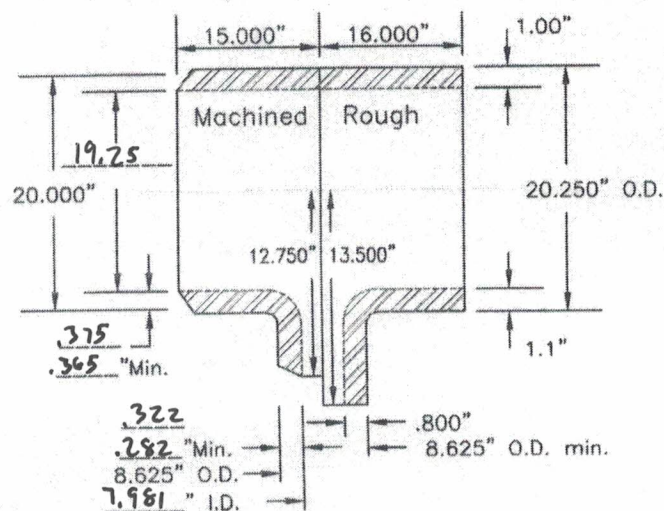
Press: Machine 2000 Ton Set up# None shown Upper Die# 42206
Lower Die# 40378

1st Form: Heat to 1650°F.
Quench in 17" of water
Close to 3-3/4" &
Pull 4" plug (2" rod)



2nd Form: Re-heat to 1650°F.
Quench in 14" of water
Close dies to 3/4" &
Pull 6.00" plug (3" plug)

Final Form: Re-heat to 1650°F.
Do not quench
Close dies HOT &
Pull 7-1/4" plug (3" rod)

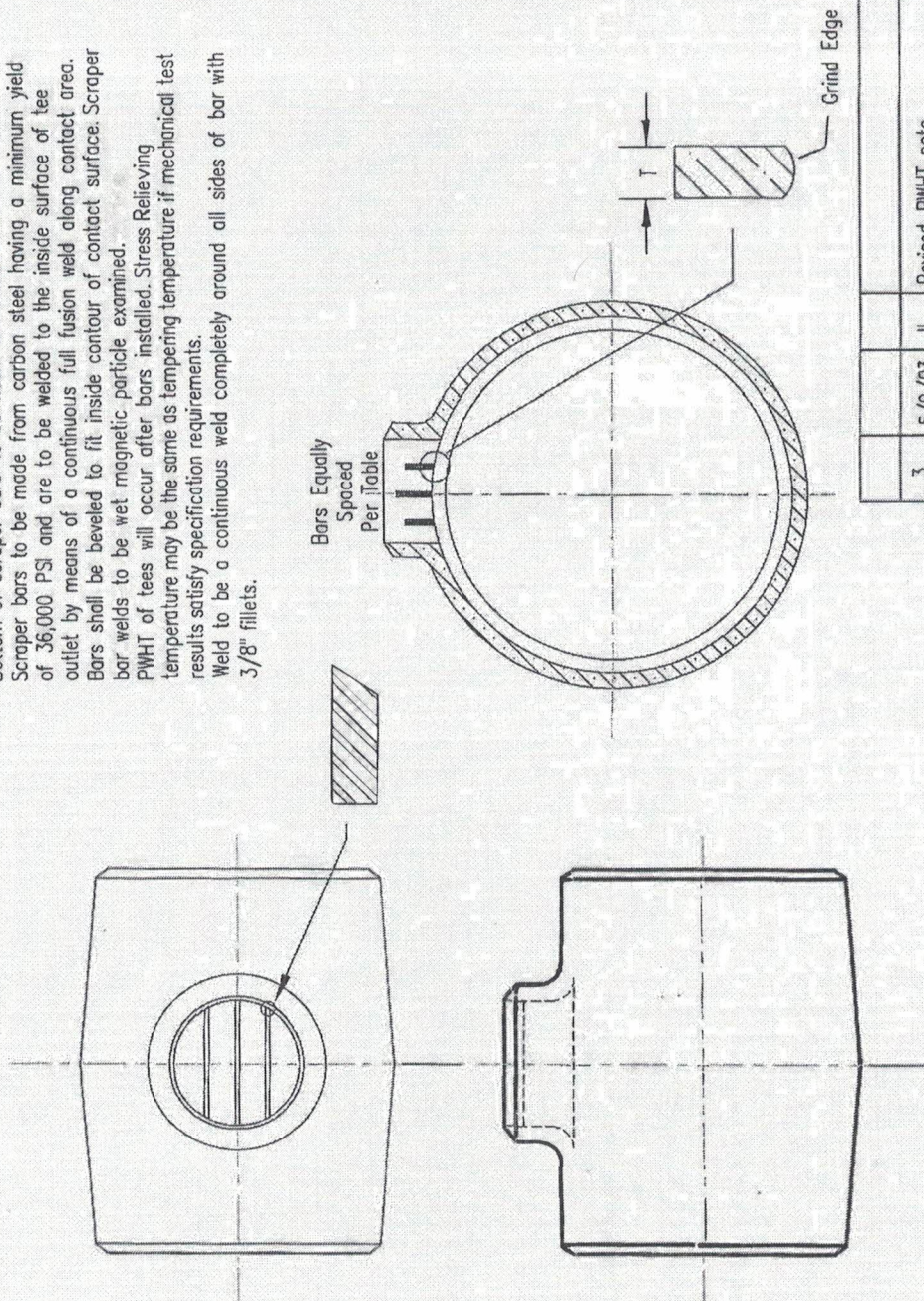


			DATE: 3/2/10	20"x 8" .375 x .322 HIGH YIELD TFF MFG DATA	DWG#
			SCALE: NONE		20-8-6
			DRAWN BY: J.DAVIDSON		
			CHECKED BY: JL		
DESCRIPTION	BY	DATE			

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. Scraper 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	Pit 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



STEEL FORGINGS, INC.

SCRAPER BARS FOR
 STRAIGHT AND REDUCING
 BUTT WELDING TEES

Date: 5/9/03

Drawing#: 122890
 Revision: 3

Drawn by:
 J. Lofdahl

Scale:
 None

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

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 1 1/2 " THICK X 2.5 " 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: 18.750 + 1/8 -0 19.250
0.375
0.365

BORE OUTLET I.D. STRAIGHT TO: 7.731 ± 1/16 7.981
0.322
0.282

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE