

Job Traveler

Due Date: 09/12/2023

Job Number: 231347-03



Sold FLOW-ZONE, LLC
To: 3504 DWAYNE ROAD
ROSHARON, TX 77583

Ship FLOW-ZONE - ROSHARON
To: 3504 DWAYNE RD
Rosharon, TX 77583
United States

Order No: 231347

Customer: FLOW-Z134580

Ship Via:

Part Number: *3TE3616Y

Description: TE 36X16 .625 X .500-WPHY60

MSSSP75-19

Dated: 07/18/2023

PO Num: 9299274

Priority: 3 - STANDARD

Product Code: TEE

Master Job No:

Quote No: 19835

Qty To Make: 1

Total Qty Open: 1 EA

Qty Posted: 0 EA

Start Date: 07/26/2023
Contact: JUAN MALAVE

Phone:
Fax:

Job Notes

BCKX
B10584
PIPE SHOP TRAVELER 242-2023
CUT WITH 243-2023 - **WATCH LAYOUT CAREFULLY BEFORE CUTTING**
DO NOT ADD SCRAP
QR CODE

Routing

Routed By:		Quantity 1							
Step No	Work Cntr / Vendor	Description	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					07/26/2023	07/26/2023	1
 									
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					08/01/2023	08/01/2023	1
 									
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller					08/01/2023	08/01/2023	1
 									

Job Number: 231347-03

40	PIPE 7 STRING UP	Initial Weld String-up	08/01/2023 08/01/2023	1
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	08/01/2023 08/01/2023	1
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	08/01/2023 08/01/2023	1
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	08/02/2023 08/02/2023	1
				
80	PIPE 9 OD WELD	OD Weld OD Weld	08/07/2023 08/07/2023	1
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/15/2023 08/15/2023	1
				
100	FORGE 8 TRIM	Torch Cut Cut hole	09/18/2023 09/18/2023	1
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	09/18/2023 09/18/2023	1
				
120	FORGE 8 TRIM	Torch Cut Trim	09/19/2023 09/19/2023	1
				

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/15/2024	02/15/2024	1
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/15/2024	02/15/2024	1
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/15/2024	02/15/2024	1
					
160	E1 MACHINING	E1 Extender Expander	02/15/2024	02/15/2024	1
					
170	M1 MACHINING	M1 Big Mill Machining	02/15/2024	02/19/2024	1
					
180	STAMP 1 STAMP	Stamping	02/19/2024	02/19/2024	1
					
190	INSPECT 1 INSPECTION	Inspection 1	02/19/2024	02/19/2024	1
					
200	SHIPPING SHIPPING	Shipping	02/19/2024	02/19/2024	1
					
Time per Piece (HR):			0.00	0.00	0.00
Total Time for Job (HR):			0.00	0.00	0.00

Materials List

Quantity: 1

Quantity				Unit	Description	Sub-	Vendor
Needed	On Hand	Posted	Short			Assy	
1,906.00000	490,570.00000	1,906.00000	0.00000	LB	0PL1633	NO	SFI
					PL0 1-A633-E		
					Quantities from Bins/Lot Number:		
					BCKX-16 (1906.0)		

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCKX
36X16
.625X.500
WPHY60
231347-03

Pipe Shop Traveler Tee Cyl.

242-2023

7/18/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>FLOWZONE</u>			SFI Order No	<u>231347-03</u>	Due Date	<u>8/12/2023</u>
Part	<u>39.000</u>	OD X	<u>1.000</u> X	<u>55.000</u>		Ship Date	<u>9/12/2023</u>
Plate Size	<u>1.000</u>	X	<u>119.381</u> X	<u>55.000</u>		NoPcs	<u>1</u>
Heat No.	<u>R0464</u>					Code	<u>BCKX-16</u>
Material	<u>A633E</u>		Test Material			Test No	

Cut 1 Plate(s) 1.000 X Thick X 119.381 Width X 55.000 Length 1862 Lbs.

Per Sketch #

From (1) Plate(s) 1.000 Thick X 120.000 Wide X 360.000 Long

Stamp Plates With Heat Code BCKX-16

Scarf to 119.381 + 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

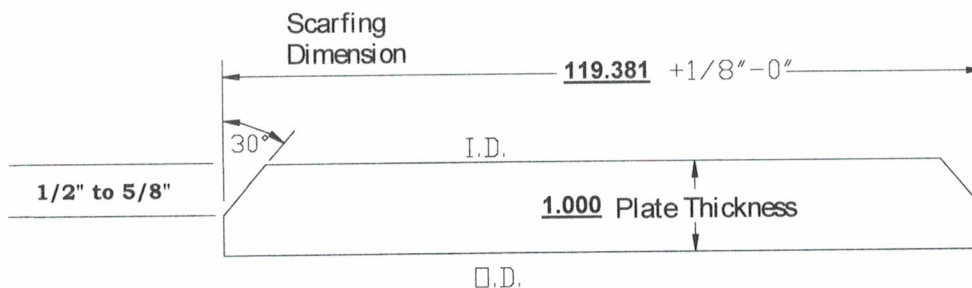
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder FLOWZONE 231347-03

Stamp Each Cylinder in (2) Places With Heat Code BCKX-16

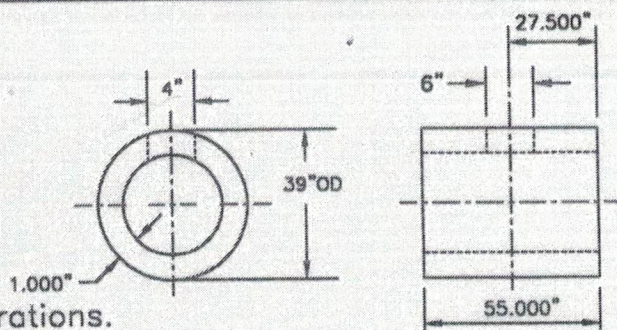
Fitting Description: (1) TE 36X16 Y60

Comments: WATCH LAYOUT CLOSELY!!! CUT W/ 243-2023



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

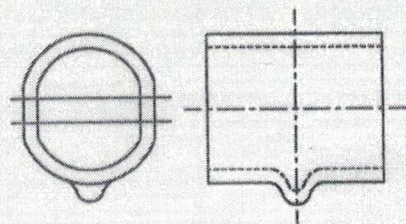
Hole size 4"x 6" oval
Grind $1/8"$ radius on hole edges
I.D. & O.D.



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

Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50082 with 36x18" Insert #50090

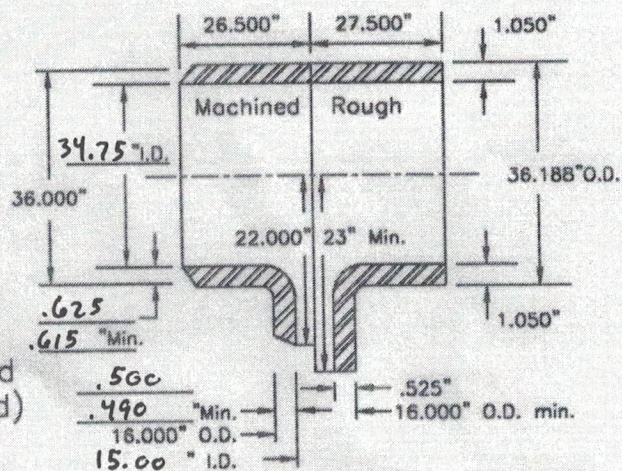
2nd Oper: Re-heat to 1650°F.
Quench barreled side in 21-1/2" of
water & barrel down HOT with HOT side
up. Close dies to 1".



3rd Oper: Cut outlet hole per above

5th Oper: Re-heat to 1650°F.—Do not
quench—Do not close dies and
Pull 10-1 1/2" dia. plug(4" pull rod)

Final Oper: Re-heat to 1650°F.
Do not quench—Close dies hot and
Pull 14.750" dia. plug (4" pull rod)



SHOP NOTE: Outlet may require end sizing.

				DATE: 11-19-99	36" x 16" <u>.625 x .500</u> HIGH YIELD TEE MFG. DATA	DWG# 36-16-2 Use for bevel thicknesses: 36: Run- .439" thru. .666" 16" Outlet- .500" and less.
				SCALE: NONE		
				DRAWN BY: J.D.		
				CHECKED BY: Bull		
REV	DESCRIPTION	BY	DATE			

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 @ 1200 °F - AIR COOL - FURNACE LOAD# _____

SHOTBLAST TO NEAR WHITE FINISH

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

MACHINE PER MSS-SP75-14

BORE RUN I.D. STRAIGHT TO: 34.000 + 1/4 -0 34.750
0.625
0.615

BORE OUTLET I.D. STRAIGHT TO: 14.500 + 1/8 -0 15.000
0.500
0.490

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE