Job Traveler

Job Number: 231347-04

Due Date: 09/12/2023

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

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

Order No: 231347 **Dated:** 07/18/202 **Quote No:** 19835

Customer: FLOW-Z134580 **PO Num:** 9299274

Ship Via: **Priority:** 3 - STANDARD

Part Number: *3TE3610Y **Product Code:** TEE

Description: TE 36X10 .625 X .365-WPHY60
MSSSP75-19 **Master Job No:**

Total Qty Open: 4 EA **Qty Posted:** 0 EA **Qty To Make:** 4

Start Date: 07/26/2023 **Phone:**

Contact: JUAN MALAVE **Fax:**

Job Notes

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

Routing

Routed By: **Quantity** 4

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					07/26/2023	07/26/2023	4
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					08/01/2023	08/01/2023	4
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller					08/01/2023	08/01/2023	4

40	PIPE 7 STRING UP	Initial Weld String-up	08/01/2023	08/01/2023	4
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	08/01/2023	08/01/2023	4
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	08/01/2023	08/01/2023	4
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	08/02/2023	08/02/2023	4
80	PIPE 9 OD WELD	OD Weld OD Weld	08/07/2023	08/07/2023	4
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/15/2023	08/15/2023	4
100	FORGE 8 TRIM	Torch Cut Cut hole	09/19/2023	09/19/2023	4
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	09/19/2023	09/20/2023	4
120	FORGE 8 TRIM	Torch Cut Trim	09/20/2023	09/20/2023	4

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/15/2024	02/19/2024	4
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/19/2024	02/19/2024	4
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/19/2024	02/19/2024	4
160	E1 MACHINING	E1 Extender Expander	02/19/2024	02/19/2024	4
170	M1 MACHINING	M1 Big Mill Machining	02/19/2024	02/21/2024	4
180	STAMP 1 STAMP	Stamping	02/21/2024	02/21/2024	4
190	INSPECT 1 INSPECTION	Inspection 1	02/21/2024	02/21/2024	4
200	SHIPPING SHIPPING	Shipping	02/21/2024	02/21/2024	4

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: 4

Quantity						Sub-	
Needed	On Hand	Posted	Short	Unit	Description	Assy	Vendor
7,692.00000	496,356.00000	7,692.00000	0.00000	LB	0PL1633	NO	SFI

PL0 1-A633-E
Quantities from Bins/Lot Number:
BCKX-16 (7692.0)

Marking Information:

FLEET-LINE®
MADE IN USA
STEEL FORGINGS

BCKX
36X10
.625X.365
WPHY60
231347-04

Pipe Shop Traveler Tee Cyl.

243 -2023
7/18/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	FLOWZONE	SFI Order No	231347-04	Due Date	8/12/2023
Part	39.000 OD X 1.000 X 112.000			Ship Date	9/12/2023
Plate Size	1.000 X 119.381 X 112.000			NoPcs	2
Heat No.	R0464			Code	BCKX-16
Material	A633E Test Material			Test No	

Cut 2 Plate(s) 1.000 X Thick X 119.381 Width X 112.000 Length 3792 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

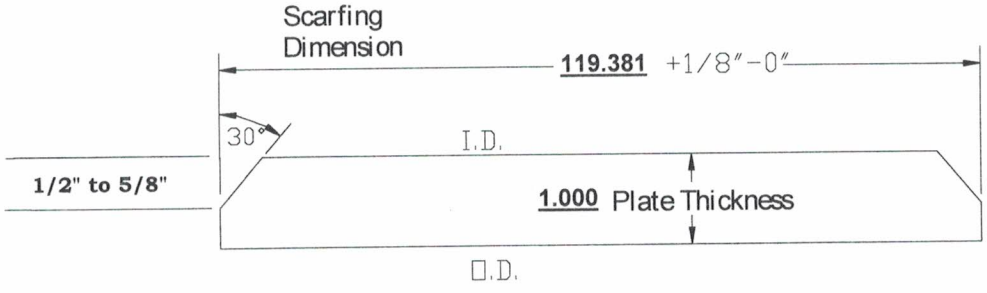
Torch Cut Into 2 Pcs @ 55 Inches

Paint Mark on Cylinder FLOWZONE 231347-04

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

Fitting Description: (4)TE 36X10 Y60

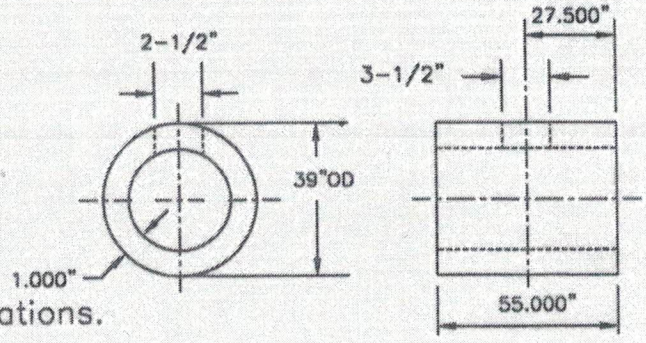
Comments: WATCH LAYOUT CLOSELY!!! CUT W/ 242-2023



36" Run Diameter = 36.542"
10" Outlet Diameter = Free pull in 36 x 18 dies

Material Size 39" O.D. x 1.000"W
Length 55.000"

Hole size 2-1/2"x3-1/2 oval
Grind 1/8" radius on hole edges I.D. & O.D.



SHOP NOTE: Cut hole after barreling operations.

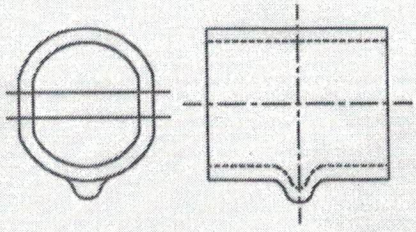
Ovaling Data: Oval: HOT Oval width: 35-3/4"±1/4"

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

1st Oper: Heat to 1650°F.-Quench in 23-1/2" of water.
Barrel down HOT with HOT side up.
Close dies to 3"

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: Re-heat to 1650°F.
Quench to cool outlet area only
Barrel down HOT with HOT side up.
Close dies

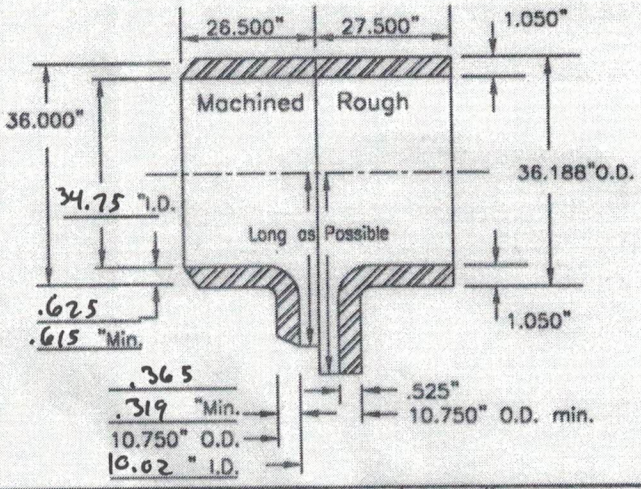


4th Oper: Drill outlet hole per above

5th Oper: Locally heat outlet area with torches & Free pull 4-1/2" plug(2-1/2" rod)

6th Oper: Locally heat outlet area with torches & Free pull 6-3/4" plug(3" rod)

Final Oper: Locally heat outlet area with torches & Free pull 9-5/8" plug(3-1/2" rod)



REV	DESCRIPTION	BY	DATE

DATE: 11-17-99
SCALE: NONE
DRAWN BY: J.D.
CHECKED BY: Bull

36 x 10"
.625 x .365

HIGH YIELD
TEE MFG. DATA

DWG#
36-10-2

Use for bevel thicknesses:
Run-.439" thru .666".
Outlet-.500" and less.

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: 9.770 ± 1/16 (10.020 / 0.365 / 0.319)

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE