

Job Traveler

Job Number: 231347-05



Due Date: 09/12/2023

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

Dated: 07/18/2023

Quote No: 19835

Customer: FLOW-Z134580

PO Num: 9299274

Ship Via:

Priority: 3 - STANDARD

Part Number: *3TE36Y

Product Code: TEE

Description: TE 36 .625-WPHY60

Master Job No:

MSSSP75-19

Total Qty Open: 1 EA

Qty Posted: 0 EA

Qty To Make: 1

Start Date: 07/26/2023

Phone:

Contact: JUAN MALAVE

Fax:

Job Notes

BCKX
B10584
PIPE SHOP TRAVELER 244-2023
FULL PLATE ALLOCATED; DO NOT ADD SCRAP
QR CODE

Routing

Routed By:

Quantity 1

Step No	Work Cntr / Vendor	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

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Report Generated: 07/18/2023 10:16:00 AM

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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	09/19/2023 09/19/2023	1
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	09/20/2023 09/20/2023	1
				
120	FORGE 8 TRIM	Torch Cut Trim	09/20/2023 09/20/2023	1
				

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/19/2024	02/19/2024	1
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/19/2024	02/19/2024	1
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/19/2024	02/19/2024	1
					
160	E1 MACHINING	E1 Extender Expander	02/19/2024	02/19/2024	1
					
170	M1 MACHINING	M1 Big Mill Machining	02/19/2024	02/20/2024	1
					
180	STAMP 1 STAMP	Stamping	02/20/2024	02/20/2024	1
					
190	INSPECT 1 INSPECTION	Inspection 1	02/20/2024	02/20/2024	1
					
200	SHIPPING SHIPPING	Shipping	02/20/2024	02/20/2024	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	
3,061.00000	491,725.00000	3,061.00000	0.00000	LB	0PL1633	NO	SFI
					PL0 1-A633-E		
					Quantities from Bins/Lot Number:		
					BCKX-11 DROP (3061.0)		

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCKX
36X36
.625X.625
WPHY60
231347-05

Pipe Shop Traveler Tee Cyl.

244-2023

7/18/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	FLOWZONE	SFI Order No	231347-05	Due Date	8/12/2023
Part	43.500 OD X 1.000 X 58.000	Ship Date	9/12/2023	NoPcs	1
Plate Size	1.000 X 133.518 X 58.000	Code	BCKX	Test No	
Heat No.	R0464				
Material	A633E	Test Material			

Cut 1 Plate(s) 1.000 X Thick X 133.518 Width X 58.000 Length 2196 Lbs.

Per Sketch # 6114

From (1) Plate(s) 1.000 Thick X 142.000 Wide X 76.000 Long

Stamp Plates With Heat Code BCKX

Scarf to 133.518 + 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

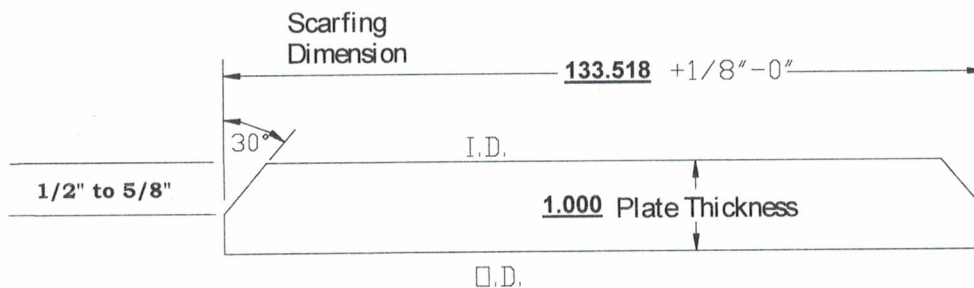
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder FLOWZONE 231347-05

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

Fitting Description: (1)TE 36 Y60

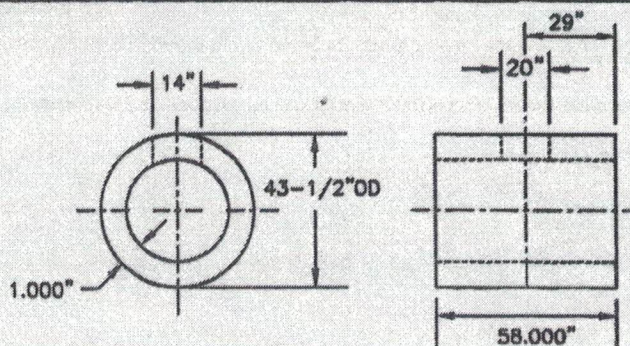
Comments:



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

Material Size 43-1/2" O.D. x 1.000"W
 Length 58.000"

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



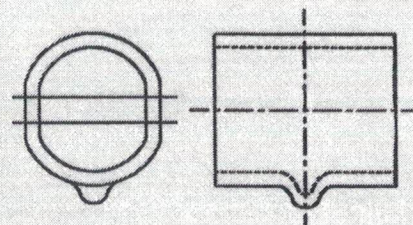
Ovaling Data: Oval: HOT Oval width: 35-3/4" ± 1/4"

Preform Data:

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

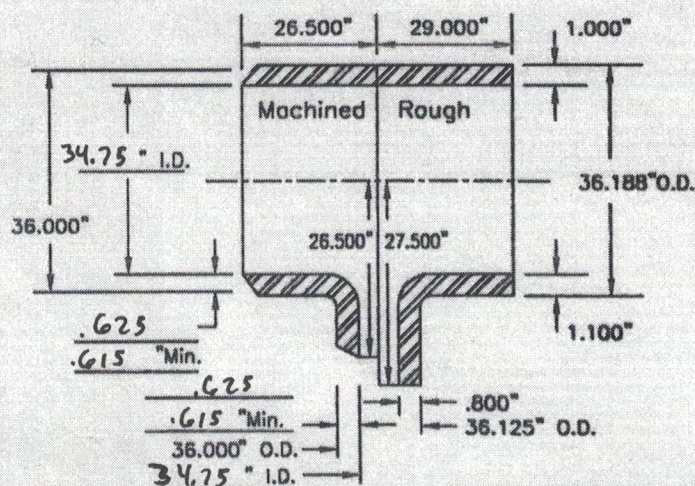
1st Oper: Heat to 1650°F
 Quench in 30" of water
 Close dies HOT to 7-1/2"
 Pull 23.210" plug (6" rod)

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
 Close dies HOT &
 Pull 34.500" plug (6" rod)

SHOP NOTE: MAY REQUIRE END SIZING



				DATE: 11-12-99	36" x 36" <u>.625 x .625</u> HIGH YIELD TEE MFG. DATA	DWG#
				SCALE: NONE		36-36-2 (use for all bevel thicknesses from .439" thru .666")
				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: 34.000 + 1/4 -0 34.750
0.625
0.615

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE