

Job Traveler

Job Number: 231360-02



Due Date: 08/16/2023

Sold To: DELAWARE G&P LLC
1722 ROUTH ST., SUITE 1300
DALLAS, TX 75201
United States

Ship To: DELAWARE G&P LLC - Macy J Compressor Station
390-4 Longhorn Road
Malaga, NM 88263
United States

Order No: 231360

Dated: 07/19/202:

Quote No: 20154

Customer: DELAWARE G&P

PO Num: PO630 - 6300002963

Ship Via: AARON.THOMPSON@ENLINK.CC

Priority: 1 - OVERTIME

Part Number: *3TE3620B

Product Code: TEE

Description: TE 36X20 .375 X .375-
WPB

Master Job No:

Total Qty Open: 4 EA

Qty Posted: 0 EA

Qty To Make: 4

Start Date: 08/01/2023

Phone:

Contact: AARON THOMPSON

Fax:

Job Notes

BCOT
B10870 - TESTING REQ'D
PIPE SHOP TRAVELER 246-2023
DO NOT ADD SCRAP

Routing

Routed By:

Quantity 4

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			08/01/2023	08/01/2023	4
20	PIPE 6 FURNACE HEAT		Pipe Furnace Furnace heating			08/03/2023	08/03/2023	4
30	PIPE 4 BIG ROLL		Big Roller Roll on large roller			08/03/2023	08/03/2023	4

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Report Generated: 07/21/2023 2:18:10 PM

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40	PIPE 7 STRING UP	Initial Weld String-up	08/03/2023 08/03/2023	4
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	08/03/2023 08/03/2023	4
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	08/03/2023 08/03/2023	4
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	08/07/2023 08/07/2023	4
				
80	PIPE 9 OD WELD	OD Weld OD Weld	08/09/2023 08/09/2023	4
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/21/2023 08/21/2023	4
				
100	FORGE 8 TRIM	Torch Cut Cut hole	09/20/2023 09/20/2023	4
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	09/20/2023 09/20/2023	4
				
120	FORGE 8 TRIM	Torch Cut Trim	09/20/2023 09/21/2023	4
				

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	03/12/2024	03/13/2024	4
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	03/13/2024	03/13/2024	4
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	03/13/2024	03/13/2024	4
					
160	E1 MACHINING	E1 Extender Expander	03/13/2024	03/14/2024	4
					
170	M1 MACHINING	M1 Big Mill Machining	03/14/2024	03/19/2024	4
					
180	STAMP 1 STAMP	Stamping	03/19/2024	03/19/2024	4
					
190	INSPECT 1 INSPECTION	Inspection 1	03/19/2024	03/19/2024	4
					
200	SHIPPING SHIPPING	Shipping	03/19/2024	03/19/2024	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			
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>
8,848.00000	41,558.00000	8,848.00000	0.00000

<u>Unit</u>	<u>Description</u>
LB	0PL1516

PL0 1-A516-70
Quantities from Bins/Lot Number:
BCOT-01 (8848.0)

<u>Sub- Assy</u>	<u>Vendor</u>
NO	AMERIC529
	2

Marking Information:



FLEET-LINE[®]

MADE IN USA
STEEL FORGINGS

BCOT
36X20
.375X.375
WPB-W
231360-02

Pipe Shop Traveler Tee Cyl.

246-2023

7/21/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	DELAWARE G&P		SFI Order No	231360-01	Due Date	7/26/2023
Part	42.000	OD X	1.000 X	112.000	Ship Date	8/9/2023
Plate Size	1.000	X	128.806 X	112.000	NoPcs	2
Heat No.	3600235				Code	BCOT-01
Material	A516	Test Material CUT 1X11			Test No	10870

Cut 2 Plate(s) 1.000 X Thick X 128.806 Width X 112.000 Length 4091 Lbs.

Per Sketch #

From (1) Plate(s) 1.000 Thick X 120.000 Wide X 480.000 Long

Stamp Plates With Heat Code BCOT-01

Scarf to 128.806 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 42.000 " O.D.

Tack Weld Using 5/32 " Dia. E7018M LH-75 Electrodes Per Procedure # SMAW-CS-142 REV. 2

Use Weld Procedure SAW-CS-120 REV. 6

Weld I.D. Using 5/32 " Dia. LINCOLN L-50 Wire and LINCOLN 865 Flux.

Backgouge to Sound Metal and Condition Grind O.D. Weld Groove

Weld O.D. Using 5/32 " Dia. LINCOLN L-50 Wire and LINCOLN 865 Flux.

Hot Reroll to Roundup

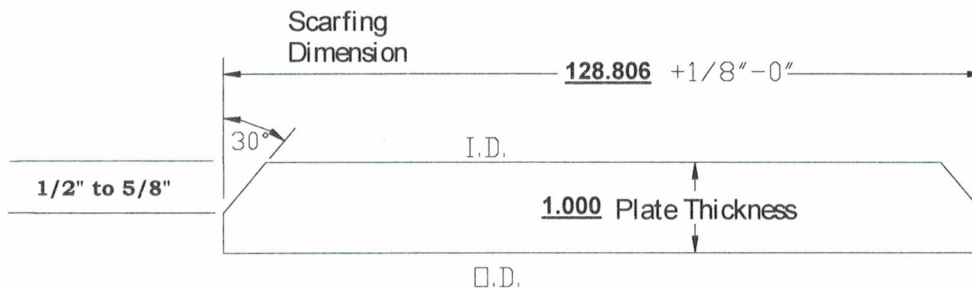
Torch Cut Into 2 Pcs @ 55 Inches

Paint Mark on Cylinder DELAWARE G&P 231360-01

Stamp Each Cylinder in (2) Places With Heat Code BCOT-01

Fitting Description: (4)TE 36X20 WPB

Comments:



36" Run Diameter = 36.542"

20" Outlet Diameter = 20.523"

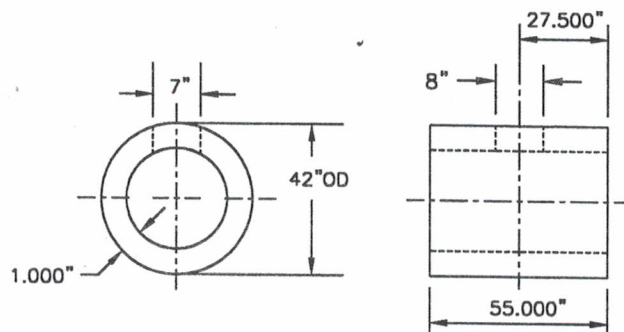
Material Size 42" O.D. x 1.000"W
Length 55.000"

Ovaling Data:

Oval HOT to: $35-3/4" \pm 1/4"$

Hole size 7"x 8" oval

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



Preform Data:

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

Lower Die# 50082 with 36x20" Insert #50089

1st Oper: Heat to 1650°F.—Quench in 28 inches of water.

Close dies to $5-1/2"$ and

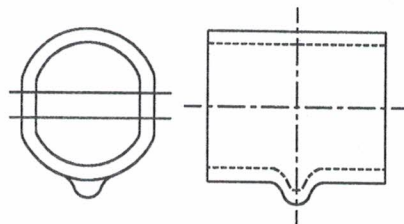
Pull $10-1/4"$ diameter plug (4" rod).

2nd Oper: Re-heat to 1650°F.

Quench in $23-1/2$ inches of water

Close dies to $1-1/2"$ and

Pull $14-3/4"$ diameter plug (4" rod).

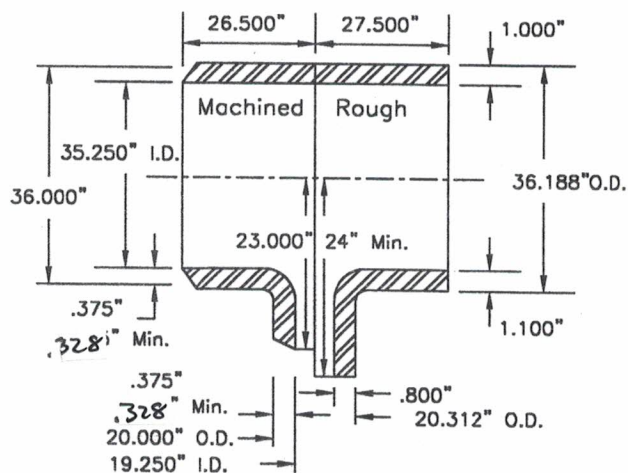


3th Oper: Re-heat to 1650°F.

Do not quench

Close dies hot and

Pull $18-7/8"$ plug (4" pull rod).



				DATE: 11-22-99
				SCALE: NONE
				DRAWN BY: J.D.
				CHECKED BY: Bull
REV	DESCRIPTION	BY	DATE	

	DWG#
36" x 20"	
.375"x.375"	
HIGH YIELD	
TEE MFG. DATA	
36-20-1 (STD)	

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- _____)

NORMALIZE 1/2 HR @ 1650°F AIR COOL FURNACE LOAD # _____

TEMPER _____ HR @ _____ °F AIR COOL FURNACE LOAD# _____

SHOTBLAST TO NEAR WHITE FINISH

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

MACHINE PER B16.9

BORE RUN I.D. STRAIGHT TO: 34.500 + 1/4 -0 35.250
0.375
0.328

BORE OUTLET I.D. STRAIGHT TO: 18.750 + 1/8 -0 19.250
0.375
0.328

CONDITION GRIND

STAMP PER A-234 WPBW

HARDNESS TEST AT LEAST 2 PIECES IF QUANTITY IS 2 OR MORE - 197BHN MAX _____

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE