

Job Traveler

Job Number: 231383-01



Due Date: 08/07/2023

Sold To: FERGUSON ENTERPRISES, INC.
FERGUSON ENTERPRISES, INC. #26
P.O. BOX 9406
HAMPTON, VA 23670-0406
United States

Ship To: FERGUSON ENTERPRISES, INC.
504 INDUSTRIAL BLVD
AUSTIN, TX 78745
United States

Order No: 231383**Dated:** 07/21/2023**Quote No:** 20308**Customer:** FERGUS131204**PO Num:** E456-13095**Ship Via:** SAIA COLLECT**Priority:** 1 - OVERTIME**Part Number:** *3HF4B**Product Code:** HOT TAP W/ FLANGE**Description:** HF 4X2-1/2 STD-WPB**Master Job No:**

W/150# RF WNF

Total Qty Open: 4 EA**Qty Posted:** 0 EA**Qty To Make:** 4**Start Date:** 07/31/2023**Phone:** 757-223-6800**Contact:** JAMES AWTREY**Fax:**

Job Notes

BCJA
B10706
CUT (4) @ 12.25" EACH FROM 83" PIECE

Routing

Routed By:**Quantity 4**

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled ---		Run Quantity
							Start	End	
10	SAW SAW CUT PIPE	Saw #1 Cut pipe					07/31/2023	07/31/2023	4
20	FAB 6 SPLIT/ASSEM2	Encircle Saddle Hole Split					08/01/2023	08/01/2023	4
30	FAB 9 FAB DRILL	ES Drill Drill Hole					08/01/2023	08/01/2023	4

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40	PIPE 2 SMALL ROLL	Small Roller Roll	08/01/2023 08/01/2023	4
				
50	FORGE 1 HAMMER	Small Hammer Form	08/03/2023 08/07/2023	4
				
60	M7 SM BULL MACHINING	M7 Small Bullard Machining	08/07/2023 08/07/2023	4
				
70	FAB 4 SPLIT/ASSEM2	Welding Station # 1 Trim/Assembly	08/07/2023 08/07/2023	4
				
80	G1 MACHINING	G1 Groove 1 Groove	08/07/2023 08/08/2023	4
				
90	FAB 11 BUTT WELD	Various-Misc Assembly/Bevel	08/08/2023 08/08/2023	4
				
100	FAB 4 TACK/ASSEM 1	Welding Station # 1 Tack Rings and Asembly 1	08/10/2023 08/14/2023	4
				
110	FORGE 7 HEAT TREAT	Heat Treat Heat treat	03/06/2024 03/07/2024	4
				
120	FAB 11 GOUGE RINGS	Various-Misc Gouge Rings	03/07/2024 03/07/2024	4
				

130	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	03/07/2024 03/07/2024	4
				
140	FAB 6 SPLIT/ASSEM2	Encircle Saddle Hole Split	03/07/2024 03/07/2024	4
				
150	PIPE 11 WELD PREP	Special Welds Fit-up	03/11/2024 03/11/2024	4
				
160	PIPE 11 WELD FLANGE	Special Welds Flange weld	03/11/2024 03/13/2024	4
				
170	FAB 7 CLEAN GRIND	Cleanup Grind Clean up grind	03/13/2024 03/13/2024	4
				
180	PIPE 13 X RAY	Pipe X Ray X Ray inspection of weld	03/13/2024 03/13/2024	4
				
190	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	03/13/2024 03/14/2024	4
				
200	STAMP 1 STAMP	Stamping Flange Protect	03/14/2024 03/14/2024	4
				
210	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast	03/14/2024 03/14/2024	4
				

220	STAMP 1 STAMP	Stamping Product Stamping	03/14/2024 03/14/2024	4
				
230	INSPECT 1 INSPECTION	Inspection 1 Inspection	03/14/2024 03/14/2024	4
				
240	SHIPPING SHIPPING	Shipping Shipping	03/14/2024 03/14/2024	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					Quantity: 4	
Needed	On Hand	Posted	Short	Unit	Description	Sub- Assy Vendor
50.00000	2,222.00000	50.00000	0.00000	IN	0PI8XHB	NO SFI
PI0 8-XH-WPB Quantities from Bins/Lot Number: BCJA (50.0)						

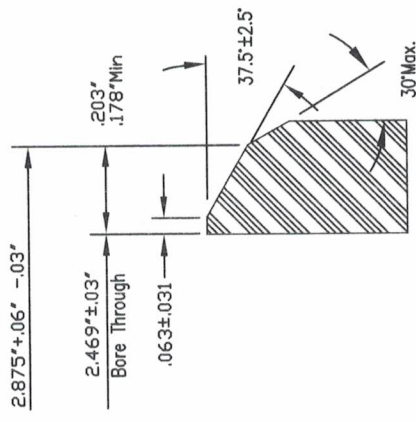
Marking Information:



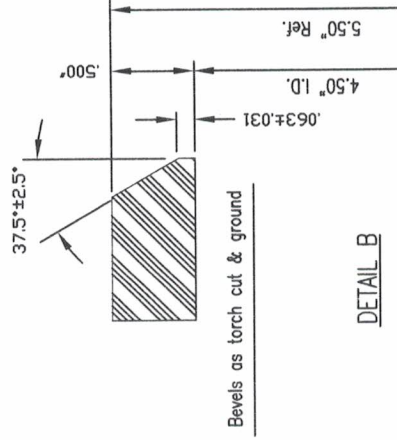
FLEET-LINE

MADE IN USA
STEEL FORGINGS

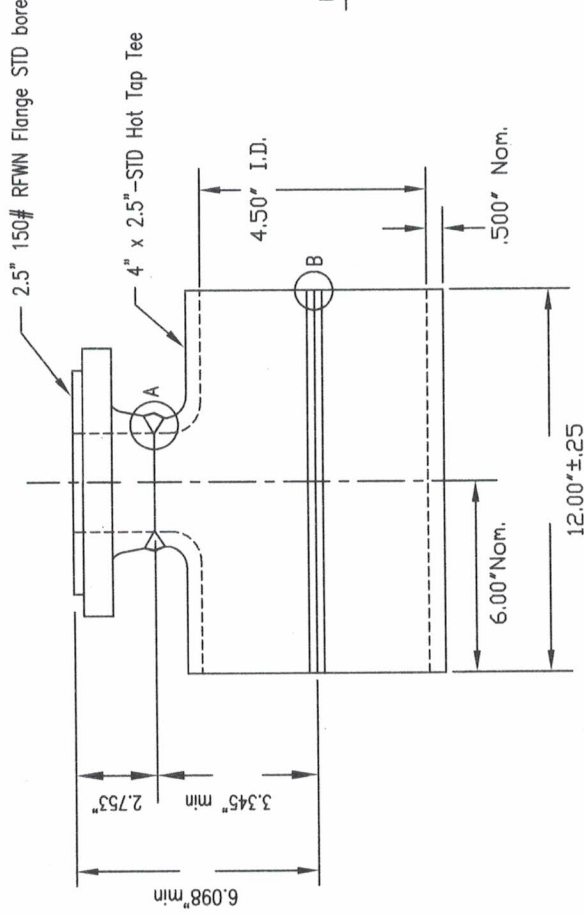
BCJA
4X2.5
STDSTD
WPB
231383-01



DETAIL A



DETAIL B



STEEL FORGINGS, INC.

GROOVE AND BACKING STRIP INCLUDED BUT NOT SHOWN

*Radial gap tolerance between run and fitting is 1% of run diameter.

Company: FERGUSON
Spec.: A234 WPB

PO#--
Qty: 4

Date: 7/20/23
SFI #: -

Description: 4X2.5-STD HOT TAP
TEE with 2.5\" 150# RFWN FLANGE.

Drawing#: 0
Revision: 0

Drawn by:
J. LOFDAHL

Appr'd:
Scale:
None

Rev.	Date	By:	Revision

FORM BY HAMMER OR PRESS

DELIVER BOTH HALVES TO HAMMER FOR HOT FORMING

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#~~ _____

TORCH CUT AND GRIND SIDE BEVELS

MACHINE OUTLET PER B16.9

MACHINE GROOVE FOR BACKING STRIP, 0.75" STRIP WIDTH FOR <16" DIAMETER, 1" WIDTH FOR >= 16"

BORE OUTLET ID STRAIGHT THRU @ 2.469

FIT, TACK AND WELD 2.5 in. 150 # RFWN FLANGE WITH **HEAT CODE** _____

TO OUTLET OF 4 X 2.5 STD BUTT WELD HOT TAP

WELD IN 1G POSITION

USE PROCEDURE SMAW-CS-143 REV.2

WELD I.D. PASS USING 1/8in. DIA. 7018-H4R ELECTRODE. **HEAT NO.** _____

BACKGOUGE AND/OR GRIND O.D. WELD GROOVE TO SOUND METAL.

WELD O.D. PASSES USING 5/32in. DIA. 7018-H4R ELECTRODE. **HEAT NO.** _____

CONDITION GRIND 2.5 in. ROUNDAABOUT WELD FLUSH TO 1/16" MAX WELD HEIGHT.

100% RADIOGRAPH 2.5 in. ROUNDAABOUT WELD PER ASME SECTION VIII, DIV.1 PARAGRAPH UW-51 (**XL-RT-100 - LATEST REVISION**)

HEAT TREATMENT PER QCP 8.1 REV.1: **STRESS RELIEVE** 3/4 HR @ 1100 °F - AIR COOL - FURNACE LOAD # _____

PRODUCT STAMP BOTH HALVES AND PAINT

HARDNESS (IF QTY IS 2 OR MORE, CHECK 2 PCS) _____

NO WEEP HOLE?