

Due Date: 09/12/2023



Sold To: COMCO PIPE AND SUPPLY COMPANY
5910 17th STREET NW
EDMONTON, AB T6P 1S5
Canada

Ship To: Comco Pipe & Supply Co.
4203-53rd Ave
Edmonton, AB T6B 3P4
Canada

Order No: 231501 Dated: 08/08/2023 Quote No: 20424

Customer: COMCO75352 PO Num: E1-1062118-1

Ship Via: RKIM@TQL.COM : REF Q#434746 Priority: 3 - STANDARD

Part Number: *3TE24Y Product Code: TEE

Description: TE 24 .500-WPHY65 Master Job No:

W/ BARS

CSA Z245.11

Total Qty Open: 1 EA Qty Posted: 0 EA Qty To Make: 1

Start Date: 11/08/2023 Phone:
Contact: BRIAN HODGE Fax:

Job Notes

BCKZ
B10707-2

Routing

Routed By:

Quantity 1

Step No	Work Cntr / Vendor		Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
dept	Operation	Description	Time	Time	Time	Per Hour	Start	End	Quantity
0	FORGE 7 HEAT TREAT	Heat Treat					11/08/2023	11/09/2023	1
 									
0	FORGE 5-6 FORGE BLAST	Forge Shotblast					11/09/2023	11/09/2023	1
 									
0	PIPE 13 X RAY	Pipe X Ray					11/09/2023	11/09/2023	1
 									

40	E1 MACHINING	E1 Extender	11/09/2023 11/09/2023	1
				
50	M7 SM BULL MACHINING	M7 Small Bullard Machining	11/09/2023 11/13/2023	1
				
60	PIPE 11 WELD BARS	Special Welds	12/12/2023 12/12/2023	1
				
70	FAB 8 GRINDING	Fab Grind Grinding Bars	12/12/2023 12/12/2023	1
				
80	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	12/12/2023 12/13/2023	1
				
90	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	12/13/2023 12/13/2023	1
				
100	STAMP 1 STAMP	Stamping	12/13/2023 12/13/2023	1
				
110	INSPECT 1 INSPECTION	Inspection 1	12/13/2023 12/13/2023	1
				



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: 1
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>	<u>Unit</u>	<u>Description</u>	<u>Sub- Assy</u> <u>Vendor</u>
1.00000	47.00000	1.00000	0.00000	EA	*2TE24XHY	YES

TE2 24X24-XH-XH-Y60
Quantities from Bins/Lot Number:
BCKZ/230294-03 (1.0)

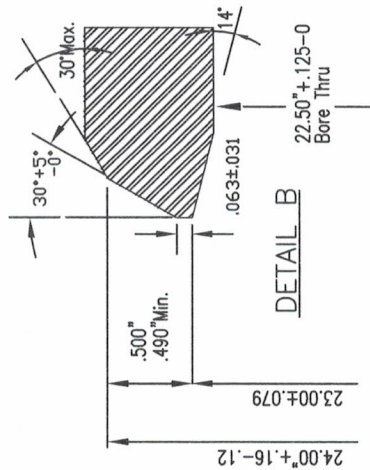
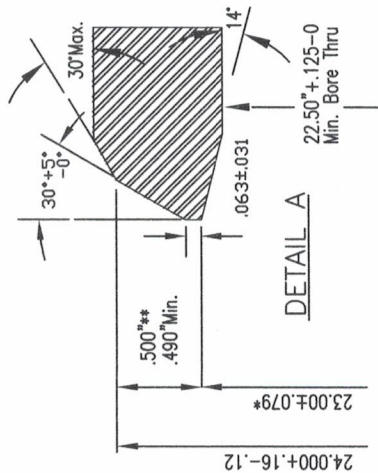
Marking Information:



FLEET-LINE

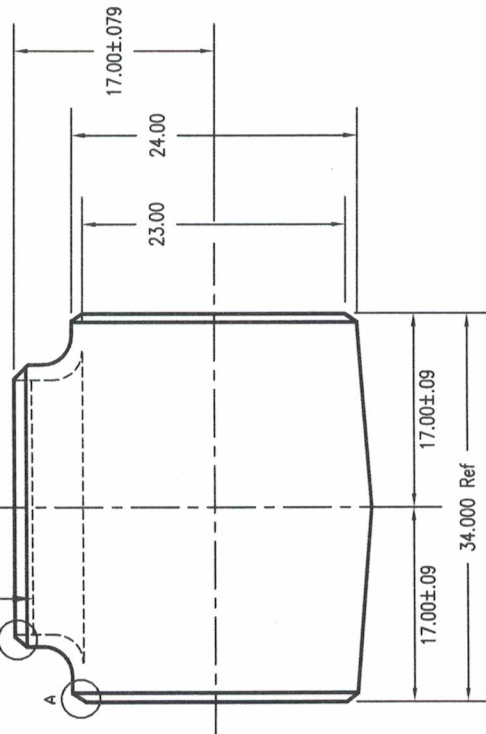
MADE IN USA
STEEL FORGINGS

Z245.11-22
GRADE 448
M45C
BCKZ
24X24
.500X.500



*As measured by circumferential measurement.
 .12" maximum out-of-round.

(4) 1/2" x 2" HEIGHT
 B scraper bars (A-516-70)

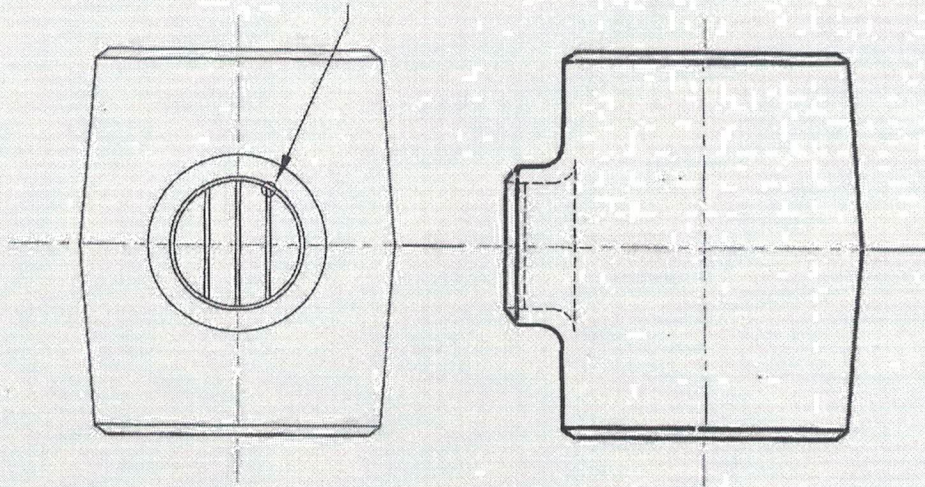


STEEL FORGINGS, INC.

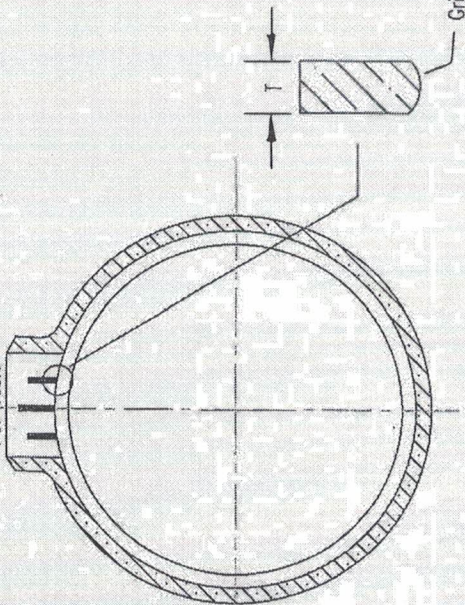
Company: COMCO	PO# -
Spec: Z245.11-22	Qty: 1
Description: TEE_W/BARS_24X24-.500X.500_WPHY65	Date: 8/2/23
Drawing#: 24X24	SFI #: 211475-01
Revision: 0	Appr'd: John Lofdahl
	Scale: None

Rev.	Date	By	Revision

Notes:
 Bottom of scraper bars to have corners broken smooth with no burrs or sharp edges.
 Bottom of scraper bars to be flush with inside radius of tee.
 Scraper bars to be made from carbon steel having a minimum yield of 36,000 PSI and are to be welded to the inside surface of tee outlet by means of a continuous full fusion weld along contact area. Scraper bars shall be beveled to fit inside contour of contact surface. Scraper bar welds to be wet magnetic particle examined.
 PWHT of tees will occur after bars installed. Stress Relieving temperature may be the same as tempering temperature if mechanical test results satisfy specification requirements.
 Weld to be a continuous weld completely around all sides of bar with 3/8" fillets.



Bars Equally Spaced Per Table



SCRAPER BAR DATA

Outlet Size	# of Bars	Plt Thk	Width
4	1	1/2	1-3/4
6	1	1/2	2
8	1	1/2	2-1/2
10	2	1/2	3
12	2	1/2	3
14	3	1/2	3
16	3	1/2	3
18	3	1/2	3
20	3	1/2	3
24	3	1/2	3
26	3	3/4	3
30	3	3/4	3
36	3	3/4	3
42	4	1	4
48	4	1	4

STEEL FORGINGS, INC.

SCRAPER BARS FOR STRAIGHT AND REDUCING BUTT WELDING TEES		Date: 5/9/03	Scale: None
Drawing# 122890	Drawn by: J. Lofdahl	App'd:	
Revision: 3			

Rev.	Date	By:	Revision
3	5/9/03	JL	Revised PWHT note
2	8/6/96	JD	Revised Sections A-A

FORM BY EXTRUSION PER CARD: _____

PRE CUT ENDS

IF ORDER SIZE IS LARGER THAN FURNACE LOAD, PRIOR TO HEAT TREAT SERIALIZE UNDER CUTTER STAMP

HEAT TREATMENT PER QCP 8.1 REV. 1: (WITH TEST MAT'L B-_____)
NORMALIZE 1650°F (1/2 HR) AIR COOL - WATER QUENCH FURNACE LOAD # 1-2023-1020 8/17
TEMPER @ 1300 °F (1 HR) - AIR COOL FURNACE LOAD # 2-2023-1079 8/17 DH DH

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

BORE RUN I.D. STRAIGHT THRU TO: 22.50 +1/8 - 0 23.00 : 500
BORE OUTLET STRAIGHT TO: 22.50 +1/8 - 0 : 490

MACHINE PER CSA Z245.11:22 ~~IF THRU BORE, ACTUAL ID:~~ _____

Maximum bevel thickness is .617 & .617 (SEC 10.7)

INSTALL 4 1/2 " THICK X 2 " WIDE SCRAPER BARS PER SFI DWG 122890
REV. 3 (ATTACHED) PER WPS SMAW-CS/HSLA-403 REV.0

PREHEAT TO AT LEAST 150°F AND KEEP INTERPASS AT LESS THAN 450°F

ME SCRAPER BARS PER SPEC. XL-MT-100 (LATEST REVISION), ACCEPTANCE CRITERIA
MORE STRINGENT OF E709 AND/OR CUSTOMER SPECIFICATION _____

HEAT TREAT PER QCP 8.1 REV. 1: STRESS RELIEVE 1 HR @ 1100F
FURNACE LOAD # _____

STAMP: REFER TO SEC. 15.2.1

FLEETLINE
Z245.11:22
GRADE 448
M45C
Heat Code BCK2
Size 24 x 24
WT .500 x .500

HARDNESS: (286 BHN MAX) BASE PC# _____ PC# _____ PC# _____
WELD PC# _____ PC# _____ PC# _____

PAINT

END PROTECT/PALLETIZE