

Job Traveler

Job Number: 231595-01



Due Date: 10/11/2023

Sold SMP SUPPLY
To: PO BOX 1675
MONT BELVIEU, TX 77523

Ship SMP SUPPLY
To: 11356 Interstate 10
Baytown, TX 77523
United States

Order No: 231595

Dated: 08/21/2023

Quote No: 20646

Customer: SMP SUPPLY

PO Num: 90706

Ship Via: DHOLLOWAY@SMP-SUPPLY.CO

Priority: 3 - STANDARD

Part Number: *3TE3624Y

Product Code: TEE

Description: TE 36X24 .875 X .687-
WPHY70

Master Job No:

MSSSP75-19

Total Qty Open: 14 EA

Qty Posted: 0 EA

Qty To Make: 14

Start Date: 08/31/2023

Phone: (713)840-9333

Contact: MONICA PRICE

Fax: (713)840-9339

Job Notes

BCON
B10855
PIPE SHOP TRAVELERS 278,279-2023
FULL PLATES ALLOCATED

Routing

Routed By:

Quantity 14

Step No	Work Cntr / Vendor		Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Description	Time	Time	Time	Per Hour	Start	End	Quantity
10	PIPE 3 PLATE BURN	Burning Table Plate Burn					08/31/2023	08/31/2023	14
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					08/31/2023	08/31/2023	14
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller					08/31/2023	08/31/2023	14

Job Number: 231595-01

Report Generated: 08/21/2023 1:56:07 PM

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40	PIPE 7 STRING UP	Initial Weld String-up	08/31/2023 08/31/2023	14
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	08/31/2023 08/31/2023	14
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	08/31/2023 08/31/2023	14
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	09/04/2023 09/04/2023	14
				
80	PIPE 9 OD WELD	OD Weld OD Weld	09/04/2023 09/04/2023	14
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	09/07/2023 09/07/2023	14
				
100	FORGE 8 TRIM	Torch Cut Cut hole	09/28/2023 09/28/2023	14
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	09/28/2023 10/02/2023	14
				
120	FORGE 8 TRIM	Torch Cut Trim	10/02/2023 10/03/2023	14
				

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	06/26/2024	07/02/2024	14
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	07/02/2024	07/04/2024	14
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	07/04/2024	07/04/2024	14
					
160	E1 MACHINING	E1 Extender Expander	07/04/2024	07/08/2024	14
					
170	M1 MACHINING	M1 Big Mill Machining	07/08/2024	07/17/2024	14
					
180	STAMP 1 STAMP	Stamping	07/17/2024	07/17/2024	14
					
190	INSPECT 1 INSPECTION	Inspection 1	07/17/2024	07/17/2024	14
					
200	SHIPPING SHIPPING	Shipping	07/17/2024	07/17/2024	14
					

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: 14

Quantity				Unit	Description	Sub-	Vendor
Needed	On Hand	Posted	Short			Assy	
43,957.00000	92,337.00000	43,957.00000	0.00000	LB	0PL1375633	NO	CLIFF STEEL
					PL0 1.375-A633-E		
					Quantities from Bins/Lot Number:		
					BCON-03 (18530.0)		
					BCON-04 (18530.0)		
					BCON-02 (6897.0)		

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCON
36X24
.875X.687
WPHY70
231595-01

Pipe Shop Traveler Tee Cyl.

278-2023

8/21/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>SMP</u>	SFI Order No	<u>231595-01</u>	Due Date	<u>9/11/2023</u>
Part	<u>42.000</u> OD X <u>1.375</u> X <u>112.000</u>	Ship Date	<u>10/11/2023</u>	NoPcs	<u>6</u>
Plate Size	<u>1.375</u> X <u>127.628</u> X <u>112.000</u>	Code	<u>BCON-03,04</u>	Test No	
Heat No.	<u>R3384</u>				
Material	<u>A633E</u>	Test Material			

Cut 6 Plate(s) 1.375 X Thick X 127.628 Width X 112.000 Length 5574 Lbs.

Per Sketch #

From (2) Plate(s) 1.375 Thick X 132.000 Wide X 360.000 Long

Stamp Plates With Heat Code BCON-03,04

Scarf to 127.628 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 42.000 " 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

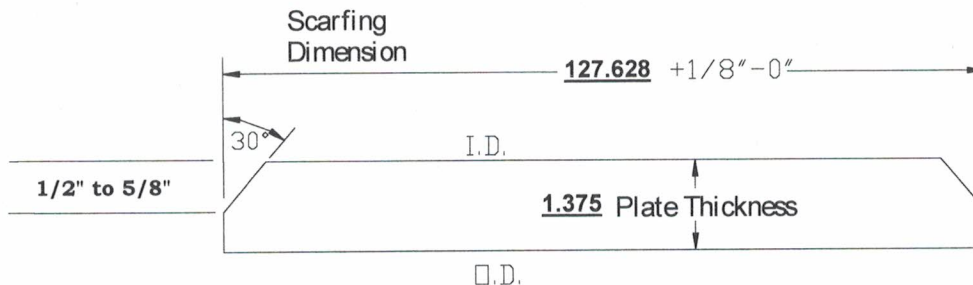
Torch Cut Into 12 Pcs @ 55 Inches

Paint Mark on Cylinder SMP 231595-01

Stamp Each Cylinder in (2) Places With Heat Code BCON-03,04

Fitting Description: (14)TE 36X24 Y70

Comments:



Pipe Shop Traveler Tee Cyl.

279-2023

8/21/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>SMP</u>	SFI Order No	<u>231595-01</u>	Due Date	<u>9/11/2023</u>
Part	<u>42.000</u> OD X <u>1.375</u> X <u>112.000</u>	Ship Date	<u>10/11/2023</u>	NoPcs	<u>1</u>
Plate Size	<u>1.375</u> X <u>127.628</u> X <u>112.000</u>	Code	<u>BCON</u>	Test No	
Heat No.	<u>R3384</u>				
Material	<u>A633E</u>	Test Material			

Cut 1 Plate(s) 1.375 X Thick X 127.628 Width X 112.000 Length 5574 Lbs.

Per Sketch # 6212

From (1) Plate(s) 1.375 Thick X 132.000 Wide X 133.000 Long

Stamp Plates With Heat Code BCON

Scarf to 127.628 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 42.000 " 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

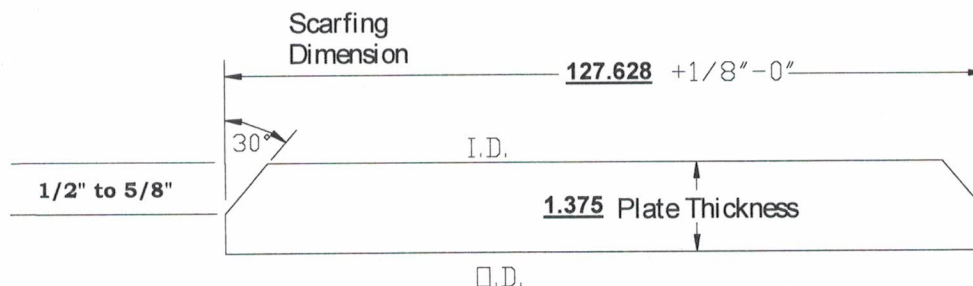
Torch Cut Into 2 Pcs @ 55 Inches

Paint Mark on Cylinder SMP 231595-01

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

Fitting Description: (14)TE 36X24 Y70

Comments:



36" Run Diameter = 36.542"

24" Outlet Diameter= 24.567"

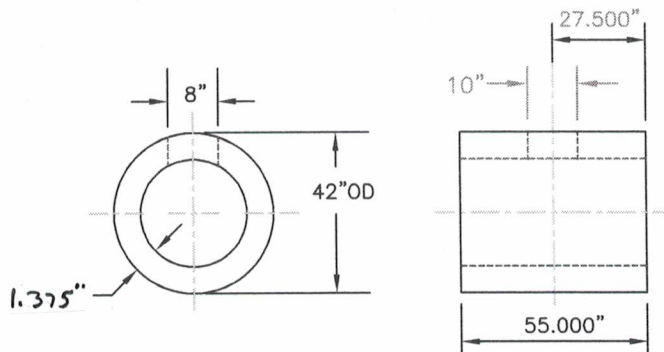
Material Size 42" O.D. x 1.375" W
Length 55.000"

Ovaling Data:

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

Hole size 8"x 10" oval

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



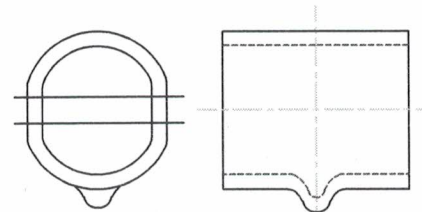
Preform Data:

Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50082 with 36x24" Insert #50082

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

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

Pull $12-1/2"$ 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

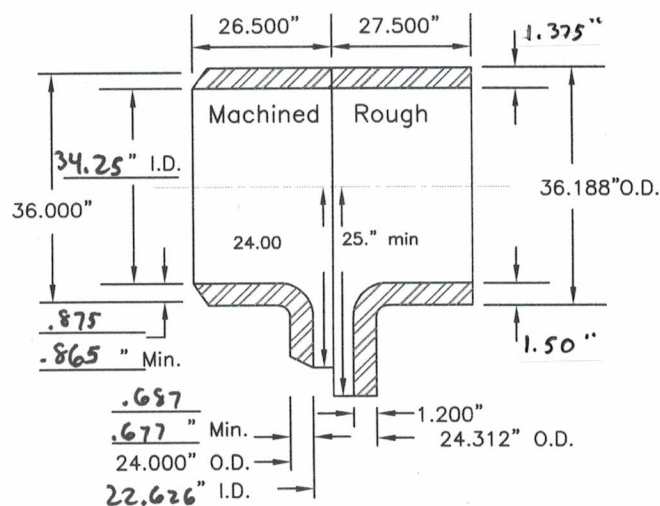
Pull $17-3/4"$ diameter plug (4" rod).

3th Oper: Re-heat to 1650°F.

Do not quench

Close dies hot and

Pull $22-1/4"$ plug (4" pull rod).



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

DATE: 11-22-99	DWG#
SCALE: NONE	
DRAWN BY: J.D.	
CHECKED BY: Bull	
36" x 24"	36-24-4
.875 x .687	
HIGH YIELD	Use for bevel thicknesses:
TEE MFG. DATA	36" Run—.834" thru. 1.000".
	24" Outlet— 1.000" 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 3/4 HR @ 1650°F **WATER QUENCH** FURNACE LOAD # _____

TEMPER 1 1/2 HR @ 1100 °F - AIR COOL - FURNACE LOAD# _____

SHOTBLAST TO NEAR WHITE FINISH

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

MACHINE PER MSS-SP75-19

BORE RUN I.D. STRAIGHT TO: 33.500 + 1/4 -0 34.250
0.875
0.865

BORE OUTLET I.D. STRAIGHT TO: 22.126 + 1/8 -0 22.626
0.687
0.677

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE