

Job Traveler

Job Number: 231605-01



Due Date: 09/13/2023

Sold To: EDGEN MURRAY CORPORATION
18444 HIGHLAND ROAD
P.O. BOX 84160
BATON ROUGE, LA 70884-4160
United States

Ship To: EDGEN MURRAY CORPORATION
, LA 70884-4160
United States

Order No: 231605 Dated: 08/22/2023 Quote No: 20664

Customer: EDGEN119955 PO Num: RMS-300217

Ship Via: TIFFANY.BAKER@EDGENMURR. Priority: 3 - STANDARD

Part Number: *3ES12PT1Y Product Code: ENCIRCLEMENT SADDLE

Description: ES 12X8-PT.1-WPHY52 Master Job No:

.375 MW RUN

30" OAL

PER DWG SP-4401

ES-PF8.1

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

Start Date: 08/29/2023 Phone: 2,257,569,868
Contact: CLAIRE BLAY Fax:

Job Notes

BCDD
B10212
CUT (1) @ 30.25" FROM 60" PIECE
DETAILED PRINT ATTACHED

Routing

Routed By:

Quantity 1

Step No	Work Cntr / Vendor	Description	Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation		Time	Time	Time	Per Hour	Start	End	Quantity
0	SAW	Saw #1					08/29/2023	08/29/2023	1
	SAW CUT PIPE								



30	FAB 8 CLEAN GRIND	Fab Grind Clean up grind	08/29/2023 08/29/2023	1
				
35	FAB 9 FAB DRILL	ES Drill Fab Drill	08/29/2023 08/29/2023	1
				
40	FORGE 1 HAMMER	Small Hammer Hammer	09/06/2023 09/06/2023	1
				
60	SAW SAW-SADDLE	Saw #1 Saw Trim Saddle	09/06/2023 09/06/2023	1
				
70	FAB 7 HAMMER	Cleanup Grind Wrap	09/13/2023 09/13/2023	1
				
80	FAB 4 SPLIT/ASSEM2	Welding Station # 1 Split pipe and assembly 2	09/13/2023 09/13/2023	1
				
90	FAB 7 CLEAN GRIND	Cleanup Grind Clean up grind	09/13/2023 09/13/2023	1
				
100	G1 MACHINING	G1 Groove 1 Machining	09/13/2023 09/13/2023	1
				
110	FAB 4 TACK/ASSEM 1	Welding Station # 1 Tack Rings and Asembly 1	09/13/2023 09/13/2023	1
				

120	FORGE 7 HEAT TREAT	Heat Treat	12/14/2023	12/14/2023	1
					
130	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	12/18/2023	12/18/2023	1
					
140	STAMP 1 STAMP	Stamping	12/18/2023	12/18/2023	1
					
150	INSPECT 1 INSPECTION	Inspection 1	12/18/2023	12/18/2023	1
					
160	SHIPPING SHIPPING	Shipping Shipping	12/18/2023	12/18/2023	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	
Needed	On Hand	Posted	Short	Unit	Description	Sub- Assy Vendor
31.00000	360.00000	31.00000	0.00000	EA	OPI2056352RT	NO SFI

P10 20-.563-Y52RT
 Quantities from Bins/Lot Number:
 BCDD/230116-01 (31.0)

Marking Information:

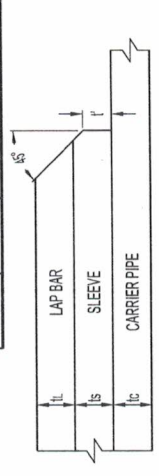
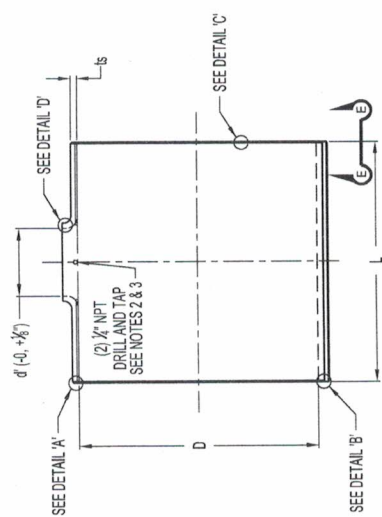
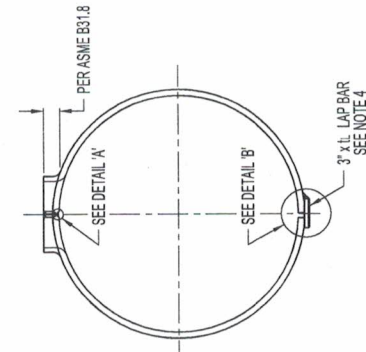
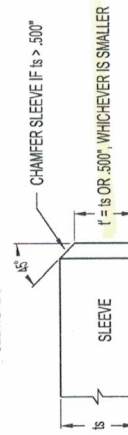
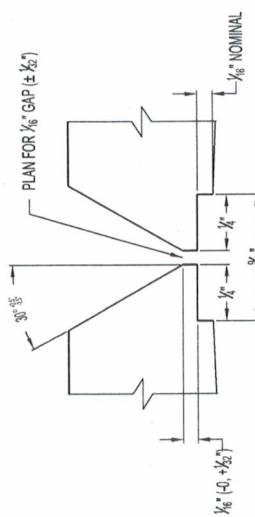
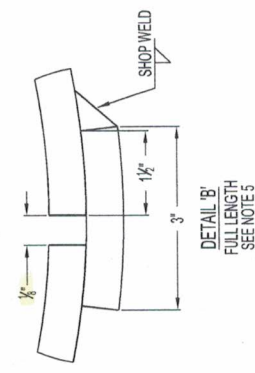


FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCDD
12X8
WPHY52
PUR-5020-2010139
LINE 1
231605-01

BRANCH SIZE d	CUTTER DIAMETER	SLEEVE OUTLET I.D. d'	MIN. CARRIER DIA. D	MIN. SLEEVE LENGTH L
4.500"	2 1/16"	4.625"	6.625"	12"
6.625"	3 1/16"	6.750"	8.625"	16"
8.625"	5 1/16"	8.750"	12.750"	20"
10.750"	7 1/16"	10.875"	16.000"	24"
12.750"	9 1/16"	12.875"	20.000"	28"
14.000"	11 1/16"	14.125"	24.000"	32"
16.000"	12 1/8"	16.125"	26.000"	36"
18.000"	14 1/16"	18.125"	30.000"	40"
20.000"	15 1/8"	20.125"	30.000"	44"
22.000"	17"	22.125"	36.000"	48"
24.000"	19"	24.125"	36.000"	52"
26.000"	21"	26.125"	42.000"	56"
30.000"	25"	30.125"	48.000"	64"



LEGEND:

- ts = SLEEVE THICKNESS (ts = tl)
- tl = LAP BAR THICKNESS (tl = ts)
- t' = ts OR 0.500", WHICHEVER IS SMALLER.
- D = CARRIER O.D./SLEEVE I.D.
- d' = SLEEVE BRANCH OUTLET I.D. (BRANCH O.D. + 1/8")
- L = SLEEVE LENGTH (MIN.) = 2 x NOMINAL BRANCH DIAMETER + 4"
- Y = SLEEVE & LAP BAR YIELD STRENGTH
- PT = DIE PENETRANT INSPECTION
- MT = MAG PARTICLE INSPECTION
- Yc = CARRIER PIPE SMYS
- tc = CARRIER PIPE THICKNESS
- d = BRANCH O.D.
- tb = SLEEVE BRANCH OUTLET THICKNESS TO BE SPECIFIED BY MFR.
- L_{ts} = (L-0)/2 (2 REQUIRED)

- NOTES:
1. REINFORCEMENT SHALL MEET OR EXCEED THE LATEST EDITION OF COMPANY SPECIFICATION ES-PF8 AND ASME B31.8.
 2. WEEP HOLES (1/2" DRILL & TAP) LOCATED 180° APART IN CENTER OF RADIUS.
 3. THREADED PLASTIC PLUGS SHALL BE SUPPLIED FOR EACH WEEP HOLE.
 4. BAR MATERIAL TO BE SAME AS SLEEVE MATERIAL (THICKNESS & GRADE)
 5. CHAMFER END OF LAP BAR AT 45° AND WELD CONTINUOUS TO ONE HALF OF SLEEVE. LAP BAR CURVED OR BENT TO MATCH SLEEVE CURVATURE.
 6. PERFORM PT OR MT INSPECTION ON ALL BEVELS AND ALL FILLET WELDS.
 7. CHAMFER SLEEVE PER DETAIL 'C'
 8. BUTT WELDING IS PROHIBITED.
 9. MAXIMUM CARBON EQUIVALENT OF SLEEVE AND LAP BAR IS 0.45%.
 10. MAXIMUM CARBON CONTENT OF SLEEVE AND LAP BAR IS 0.32%.
 11. BACKING STRIPS SHALL BE 1/2" WIDE BY 1/2" THICK MILD STEEL (AISC 1018 OR EQUAL).
 12. GROOVE FOR BACKING STRIP REQUIRED IN AREA CONTACTING CARRIER PIPE, BUT NOT IN EXTRUDED BRANCH AREA.

IC # SP4401.dgn	OPTION 1 - SPLIT TEE BRANCH REINFORCEMENT		DESIGN MANAGER	TLK	8-22-18	STANDARDS	
						DWG. SP-4401	REV. 3

DIMENSIONAL INSPECTION SHEET FOR ENCIRCLEMENT SADDLE

Is fitting in halves for shipment? _____, _____, _____, _____, _____

Does stamping match traveler? _____, _____, _____, _____, _____

What is actual ID of encirclement? _____, _____, _____, _____, _____

What is the length of the encirclement? _____, _____, _____, _____, _____

What is actual ID of outlet? _____, _____, _____, _____, _____

If minimum wall is specified, what is the minimum wall? _____, _____, _____, _____, _____

Is one complete side of side bar welded? _____, _____, _____, _____, _____

Are there two 1/4" holes drilled opposite one another for zerk fittings? _____, _____, _____, _____, _____

Does fitting have SPECTRA S/N stamped on it? _____, _____, _____, _____, _____

CUT TO LENGTH FROM PIECE 60 INCHES LONG

IF CUT FROM ROLL & TACK, PUT IT FURNACE @1650F FOR ½ HOUR TO STRESS RELIEVE

FORM BY HAMMER OR PRESS

INSTALL STIFFENERS WITH MINIMAL WELDING

HEAT TREATMENT PER QCP 8.1 REV. 1:

NORMALIZE (1/2 HR) @ 1650°F AIR COOL - ~~WATER QUENCH~~ **FURNACE LOAD #** _____
TEMPER (_____ HR) @ _____ °F AIR COOL **FURNACE LOAD #** _____

If bevel present, offset measurement between the two abutted horizontal bevel lands of the fitting shall not exceed maximum of 1/16 inch, and root opening measurement between the two abutted horizontal bevel lands of the fitting shall not exceed a maximum of 3/32 inch and a minimum of 1/32 inch

Inside diameter of fitting at both ends, when abutted together, shall be within 0 to 3/16 inch of the matching pipe nominal outside diameter.

Mismatch between the lengths of the two halves of the fitting when abutted shall be squared within a maximum of 1/8 inch.

FIT TO SIZED PIPE

1/8 INCH GAP BETWEEN HALVES

FOR PART #1 AND #3 AND >24" DIA. RECORD THE GREATEST GAP SIZE AND SIGN OFF.

DO NOT TACK FITTING TOGETHER FOR SHIPMENT

ME BEVELS PER SPEC. XL-MT-100 (LATEST REVISION) AND on run and outlet, and fillet welds, ATTACH REPORTS

Taper to: .500 **PER DETAIL "C"**
ON PRINT

Side bars to have taper that matches sleeve per attached print

Encirclements supplied with lap bars shall be supplied with one side of each lap bar welded to one of the halves prior to delivery and wrap the weld around the end of the bar. **Weld size fillet to match material thickness.** When two bars are required, they shall be installed such that they will be on opposite sides of the final installed orientation to accommodate final welding in the field.

Encirclements shall be supplied with two ¼" weep holes drilled and tapped opposite each other in the extruded area for installation of (1) grease zerk. **Paint with plastic plugs in fitting and ship this way, put grease zerks in bag.**

STAMP

INSPECT

HARDNESS: _____

PAINT OD AFTER INSPECTION

~~PAINT RED FLUORESCENT STRIPE ON FITTING IF CE IS .43 OR GREATER. CE= _____~~

PREPARE FOR SHIPPING

S:\PUBLIC\TRAVELER\Spectra PF8.1\PF8.1ENSA.docx