

Sold To: SPACE CITY DISTRIBUTION
2205 Kansas Ave
Dickinson, TX 77539
United States

Ship To: SPACE CITY DISTRIBUTION
2328 W BELFORT AVE
HOUSTON, TX 77054
United States

Order No: 231618

Dated: 08/23/2023

Quote No: 19574

Customer: SPACE CITY

PO Num: P-230602-3-2

Ship Via: SFI SET UP TRUCK PP&A

Priority: 3 - STANDARD

Part Number: *3TE4830Y

Product Code: TEE

Description: TE 48X30 1.00 X 750-WPHY70

Master Job No:

-20 CVN

MSSSP75-19

Total Qty Open: 4 EA

Qty Posted: 0 EA

Qty To Make: 4

Start Date: 09/05/2023

Phone:

Contact: RONNIE RUZICKA

Fax:

Job Notes

BCOZ
B10878 - TESTING REQ'D
PIPE SHOP TRAVELER 281-2023
DO NOT ADD SCRAP; RECORD REMAINING DROP SIZE

Routing

Routed By:

Quantity 4

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					09/05/2023	09/05/2023	4
 									
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					09/05/2023	09/05/2023	4
 									

30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	09/05/2023 09/05/2023	4
				
40	PIPE 7 STRING UP	Initial Weld String-up	09/05/2023 09/05/2023	4
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	09/05/2023 09/05/2023	4
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	09/06/2023 09/06/2023	4
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	09/06/2023 09/06/2023	4
				
80	PIPE 9 OD WELD	OD Weld OD Weld	09/07/2023 09/07/2023	4
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	09/12/2023 09/12/2023	4
				
100	FORGE 8 TRIM	Torch Cut Cut hole	10/03/2023 10/03/2023	4
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	10/03/2023 10/03/2023	4
				

120	FORGE 8 TRIM	Torch Cut Trim	10/04/2023 10/04/2023	4
				
130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	07/03/2024 07/03/2024	4
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	07/03/2024 07/04/2024	4
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	07/04/2024 07/04/2024	4
				
160	E1 MACHINING	E1 Extender Expander	07/04/2024 07/04/2024	4
				
170	M1 MACHINING	M1 Big Mill Machining	07/04/2024 07/09/2024	4
				
180	STAMP 1 STAMP	Stamping	07/09/2024 07/09/2024	4
				
190	INSPECT 1 INSPECTION	Inspection 1	07/09/2024 07/09/2024	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
20,146.00000	365,522.00000	20,146.00000	0.00000	LB	0PL15633
					PL0 1.5-A633-E
					Quantities from Bins/Lot Number:
					BCOZ-01 (10073.0)
					BCOZ-02 (10073.0)

Sub-
Assy

Vendor

NO

CLIFF
STEEL

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCOZ
48X30
1.00X.750
WPHY70
231618-05

Pipe Shop Traveler Tee Cyl.

281-2023

8/23/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	SPACE CITY		SFI Order No	231618-05	Due Date	9/13/2023
Part	52.000	OD X	1.500 X	74.000	Ship Date	11/9/2023
Plate Size	1.500	X	158.651 X	74.000	NoPcs	4
Heat No.	R3504				Code	BCOZ-01,02
Material	A633E	Test Material	CUT (2) 6X12 FOR 12X12		Test No	10878

Cut 4 Plate(s) 1.500 X Thick X 158.651 Width X 74.000 Length 4994 Lbs.

Per Sketch #

From (2) Plate(s) 1.500 Thick X 132.000 Wide X 360.000 Long

Stamp Plates With Heat Code BCOZ-01,02

Scarf to 158.651 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 52.000 " 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

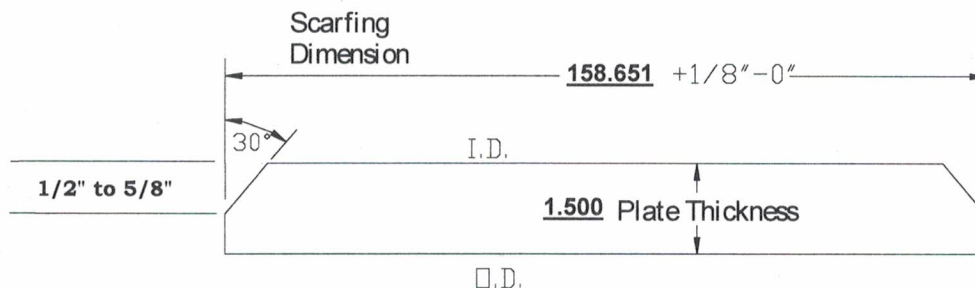
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder SPACE CITY 231618-05

Stamp Each Cylinder in (2) Places With Heat Code BCOZ-01,02

Fitting Description: (4)TE 48X30 Y70

Comments: NO SCRAP, RECORD REMAINING DROP



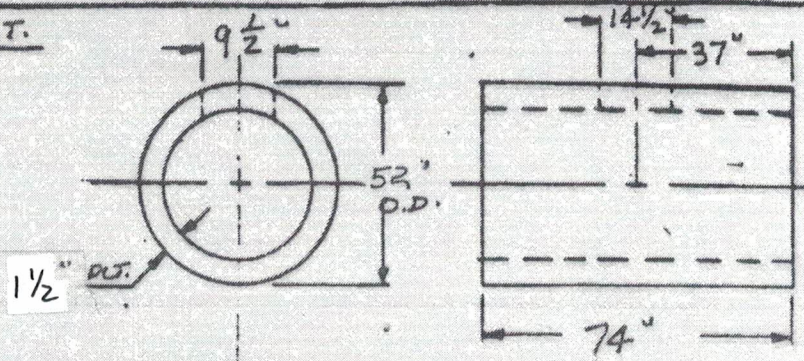
TO RUN DIA = 47.00"
30" OUTLET DIA = 30.810"

MATERIAL SIZE 52" O.D. x 1,500" PLT.
LENGTH 74"

HOLE CUTTING DATA:

HOLE SIZE 9 1/2" x 14 1/2" OVAL

GRIND 1/8" RADIUS ON
HOLE EDGES I.D. & O.D.



DVALING DATA:

MACHINE 2000 TON PRESS

OVAL : HOT

OVAL WIDTH 48 1/4" ± 1/4"

REFORM DATA:

PRESS : MACHINE #2000T SET UP NONE 48" UPPER DIE #50303 LOWER DIE 50305
48" INSERTABLE #
48x30" INSERT #50305-1

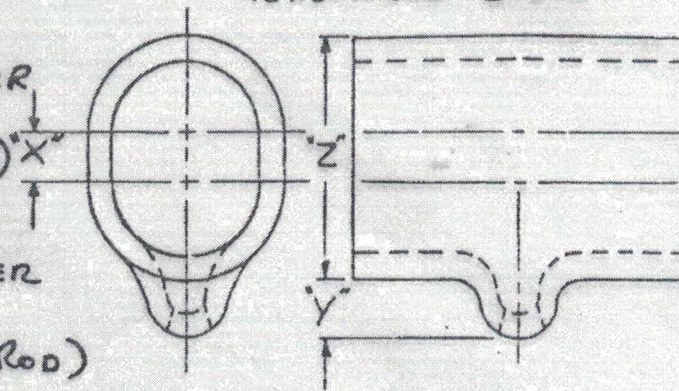
1ST FORM HEAT TO 1650°F.

QUENCH IN 30 1/2 INCHES OF WATER
CLOSE DIES TO 4" AND
PULL 18 1/2" DIA. PLUG (4 "PULL ROD)

2ND FORM

RE-HEAT TO 1650°F.

QUENCH IN 28 1/2 INCHES OF WATER
CLOSE DIES TO 2" AND
PULL 23 1/8" DIA. PLUG (4 "PULL ROD)



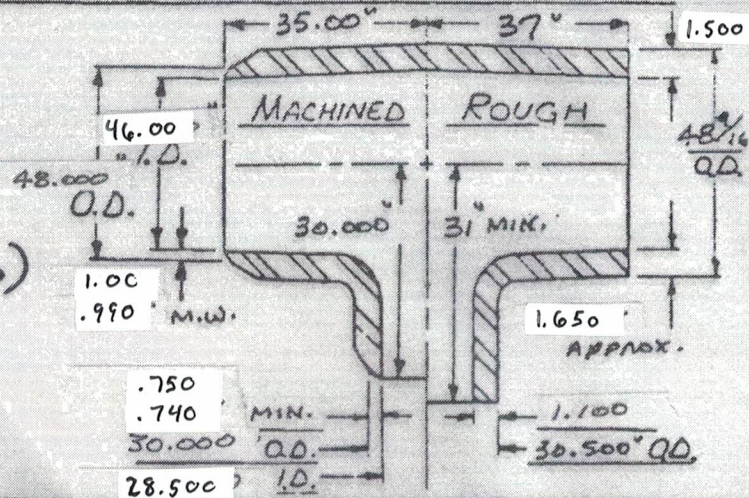
FINAL FORM:

RE-HEAT TO 1650°F.

DO NOT QUENCH

CLOSE DIES HOT AND

PULL 28.280" DIA. PLUG (6 "PULL ROD)



DATE 9-25-89

SCALE NONE

DRAWN 800

CHECKED

48" x 1.00" w. x 30" x .750" w.

X-65 REDUCING

TEE MFG. DATA

DWG.
NO.

48-4

DESCRIPTION

BY

DATE

APPR'D.

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: 45.250 + 1/4 -0 46.000
1.000
0.990

BORE OUTLET I.D. STRAIGHT TO: 27.750 + 1/4 -0 28.500
0.750
0.740

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE