

40	PIPE 7 STRING UP	Initial Weld String up	09/14/2023 09/14/2023	14
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID weld	09/14/2023 09/14/2023	14
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	09/14/2023 09/14/2023	14
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	09/14/2023 09/14/2023	14
				
80	PIPE 9 OD WELD	OD Weld OD weld	09/18/2023 09/18/2023	14
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	09/20/2023 09/21/2023	14
				
100	FORGE 8 TRIM	Torch Cut Cut hole	10/12/2023 10/12/2023	14
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	10/12/2023 10/12/2023	14
				
120	FORGE 8 TRIM	Torch Cut Trim	10/12/2023 10/16/2023	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			
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>
9,582.00000	49,615.00000	9,582.00000	0.00000

<u>Unit</u>	<u>Description</u>
LB	0PL1375633

PL0 1.375-A633-E
Quantities from Bins/Lot Number:
BCON-06 (9582.0)

<u>Sub- Assy</u>	<u>Vendor</u>
NO	CLIFF STEEL

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCON
16X10
.844X.594
WPHY65
231673-01

Pipe Shop Traveler Tee Cyl.

289-2023

8/31/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>MAVERICK</u>				SFI Order No	<u>231673-01</u>	Due Date	<u>9/22/2023</u>
Part	<u>20.000</u>	OD	X	<u>1.375</u>	X	<u>54.000</u>	Ship Date	<u>11/17/2023</u>
Plate Size	<u>1.375</u>		X	<u>58.512</u>	X	<u>54.000</u>	NoPcs	<u>7</u>
Heat No.	<u>R3384</u>						Code	<u>BCON-06</u>
Material	<u>A633E</u>		Test Material				Test No	

Cut 7 Plate(s) 1.375 X Thick X 58.512 Width X 54.000 Length 1232 Lbs.
Per Sketch #

From (1) Plate(s) 1.375 Thick X 132.000 Wide X 360.000 Long

Stamp Plates With Heat Code BCON-06

Scarf to 58.512 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 20.000 " 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

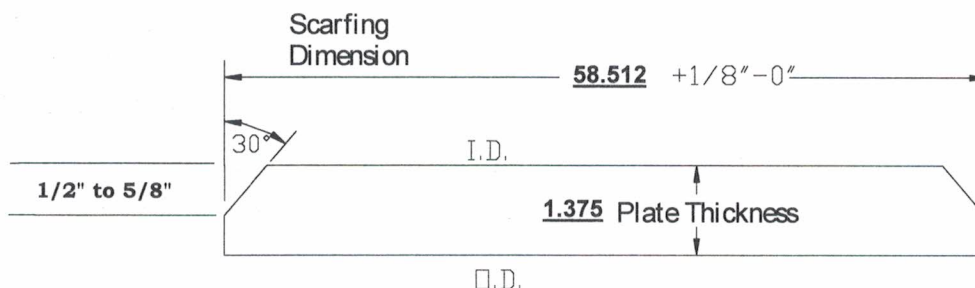
Torch Cut Into 2 Pcs @ 26 Inches

Paint Mark on Cylinder MAVERICK 231673-01

Stamp Each Cylinder in (2) Places With Heat Code BCON-06

Fitting Description: (14)TE 16X10 Y65

Comments: SCARF ALONG 132" EDGE



16" Run Diameter = 16.400"

10" Outlet Diameter = 10.984"

Material Size 20" O.D. x 1.375"
Length 26.000"

Hole Cutting Data:

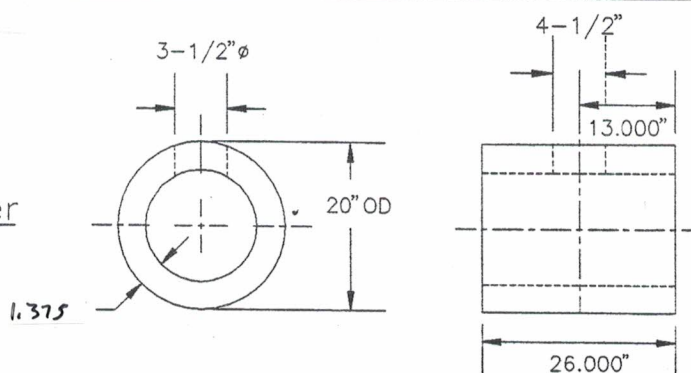
Hole size 3-1/2" to 4-1/2" Diameter

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

Ovaling Data:

Oval: HOT

Oval width 15-7/8" ± 1/8"

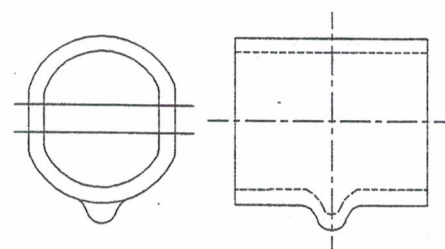


Preform Data:

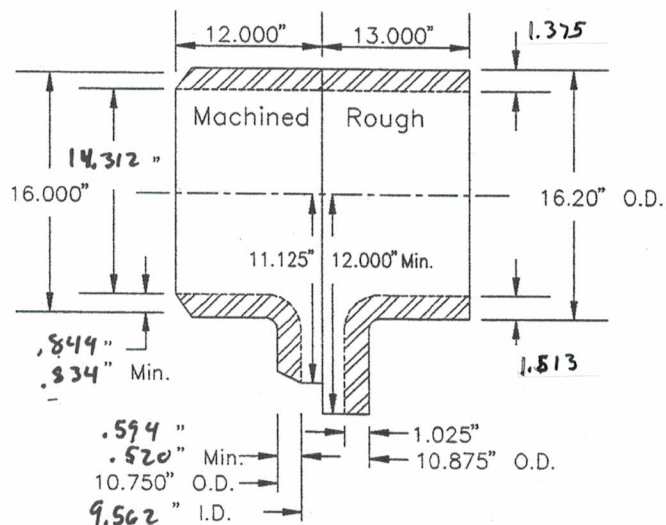
Press: Machine 2000 Ton Set up#10363 Upper Die# 50147
Lower Die# 40366

1st Form: Heat to 1650°F.
Quench in 14" of water
Close dies to 3-1/2" and
Pull 6" plug(3" rod)

2nd Form: Re-heat to 1650°F.
Quench in 11" of water
Close dies to 1" and
Pull 7-13/16" plug(3" rod)



Final Form: Re-heat to 1650°F
Do not quench
Close dies HOT and pull
8-7/8" plug(3-1/2" rod)



				DATE:	16" x 10" (.844 x .544) WTF	DWG#
				SCALE: NONE		16-10-4A
				DRAWN BY: J.DAVIDSON		
				CHECKED BY:		
REV	DESCRIPTION	BY	DATE	TEE MFG. DATA		

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: 13.812 + 1/8 -0 14.312
0.844
0.834

BORE OUTLET I.D. STRAIGHT TO: 9.312 ± 1/16 9.562
0.594
0.520

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE