



Due Date: 10/03/2023

Sold MRC GLOBAL (US), INC
To: ATTN: INVOICE AUDITING DEPT
P.O. BOX 513
CHARLESTON, WV 25322

Ship MRC GLOBAL (US), INC
To: 1100 LEBLANC ROAD
PORT ALLEN, LA 70767
United States

Order No: 231708

Customer: MRC GL257952

Ship Via: ODFL COLLECT

Part Number: *3HF10B

Description: HF 10X10 STD-WPL6

W/150# WNF

Dated: 09/06/2023

PO Num: C0712518805B0

Priority: 3 - STANDARD

Product Code: HOT TAP W/ FLANGE

Master Job No:

Quote No: 20885

Total Qty Open: 2 EA

Qty Posted: 0 EA

Qty To Make: 2

Start Date: 09/06/2023
Contact: KAYLA PICKERING

Phone: 225-378-9903
Fax:

Job Notes

ZAKD
B10892 - TESTING REQ'D
CUT (2) @ 26.25" EACH AND CUT 3X3 FOR TESTING

Routing

Routed By:							Quantity 2		
Step No	Work Cntr / Vendor		Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Description	Time	Time	Time	Per Hour	Start	End	Quantity
10	SAW SAW CUT PIPE	Saw #1 Cut pipe					09/06/2023	09/06/2023	2
 									
20	FAB 6 SPLIT/ASSEM2	Encircle Saddle Hole Split					09/06/2023	09/06/2023	2
 									
30	FAB 9 FAB DRILL	ES Drill Drill Hole					09/06/2023	09/06/2023	2
 									

40	PIPE 2 SMALL ROLL	Small Roller Roll	09/06/2023 09/06/2023	2
				
50	FORGE 1 HAMMER	Small Hammer Form	09/07/2023 09/07/2023	2
				
60	M7 SM BULL MACHINING	M7 Small Bullard Machining	09/07/2023 09/07/2023	2
				
70	FAB 4 SPLIT/ASSEM2	Welding Station # 1 Trim/Assembly	09/07/2023 09/07/2023	2
				
80	G1 MACHINING	G1 Groove 1 Groove	09/07/2023 09/07/2023	2
				
90	FAB 11 BUTT WELD	Various-Misc Assembly/Bevel	09/07/2023 09/11/2023	2
				
100	FAB 4 TACK/ASSEM 1	Welding Station # 1 Tack Rings and Asembly 1	09/11/2023 09/11/2023	2
				
110	FORGE 7 HEAT TREAT	Heat Treat Heat treat	06/24/2024 06/24/2024	2
				
120	FAB 11 GOUGE RINGS	Various-Misc Gouge Rings	06/24/2024 06/25/2024	2
				

130	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	06/25/2024 06/25/2024	2
				
140	FAB 6 SPLIT/ASSEM2	Encircle Saddle Hole Split	06/25/2024 06/25/2024	2
				
150	PIPE 11 WELD PREP	Special Welds Fit-up	06/25/2024 06/25/2024	2
				
160	PIPE 11 WELD FLANGE	Special Welds Flange weld	06/25/2024 06/26/2024	2
				
170	FAB 7 CLEAN GRIND	Cleanup Grind Clean up grind	06/26/2024 06/26/2024	2
				
180	PIPE 13 X RAY	Pipe X Ray X Ray inspection of weld	06/26/2024 06/26/2024	2
				
190	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	06/26/2024 06/26/2024	2
				
200	STAMP 1 STAMP	Stamping Flange Protect	06/26/2024 06/26/2024	2
				
210	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast	06/26/2024 06/26/2024	2
				



230

INSPECT 1
INSPECTION

Inspection 1
Inspection

06/26/2024 06/26/2024

2



240

SHIPPING
SHIPPING

Shipping
Shipping

06/26/2024 06/26/2024

2



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: 2	
Needed	On Hand	Posted	Short	Unit	Description
56.00000	686.00000	56.00000	0.00000	IN	0PI18S60B
PI0 18-S60-WPB					
Quantities from Bins/Lot Number:					
ZAKD (56.0)					

Sub-
Assy Vendor
NO SPACE CITY

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

ZAKD
10X10
STDXSTD
WPL6
231708-01

FORM BY HAMMER OR PRESS

DELIVER BOTH HALVES TO HAMMER FOR HOT FORMING

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- _____)

NORMALIZE 1/2 HR @ 1650°F AIR COOL FURNACE LOAD # _____

~~TEMPER~~ ~~_____~~ ~~HR @~~ ~~_____~~ ~~°F~~ ~~AIR COOL~~ ~~FURNACE LOAD#~~ _____

TORCH CUT AND GRIND SIDE BEVELS

MACHINE OUTLET PER B16.9

MACHINE GROOVE FOR BACKING STRIP, 0.75" STRIP WIDTH FOR <16" DIAMETER, 1" WIDTH FOR >= 16"

BORE OUTLET ID STRAIGHT THRU @ 10.020

FIT, TACK AND WELD 10 in. 150 # RFWN FLANGE WITH **HEAT CODE** _____

TO OUTLET OF 10 X 10 STD BUTT WELD HOT TAP

WELD IN 1G POSITION

USE PROCEDURE SMAW-CS-143 REV.2

WELD I.D. PASS USING 1/8in. DIA. 7018-H4R ELECTRODE. **HEAT NO.** _____

BACKGOUGE AND/OR GRIND O.D. WELD GROOVE TO SOUND METAL.

WELD O.D. PASSES USING 5/32in. DIA. 7018-H4R ELECTRODE. **HEAT NO.** _____

CONDITION GRIND 10 in. ROUNDAABOUT WELD FLUSH TO 1/16" MAX WELD HEIGHT.

100% RADIOGRAPH 10 in. ROUNDAABOUT WELD PER ASME SECTION VIII, DIV.1 PARAGRAPH UW-51 (**XL-RT-100 - LATEST REVISION**)

HEAT TREATMENT PER QCP 8.1 REV.1: **STRESS RELIEVE** 3/4 HR @ 1100 °F - AIR COOL - FURNACE LOAD # _____

PRODUCT STAMP BOTH HALVES AND PAINT

HARDNESS (IF QTY IS 2 OR MORE, CHECK 2 PCS) _____

NO WEEP HOLE?