

Job Traveler

Job Number: 231735-01



Due Date: 10/02/2023

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

Ship To: , TX
United States

Order No: 231735

Dated: 09/11/2023

Quote No: 20933

Customer: SMP SUPPLY

PO Num: 91716

Ship Via: MLANE@SMP-SUPPLY.COM

Priority: 1 - OVERTIME

Part Number: *3ER3624Y

Product Code: ECCENTRIC REDUCER

Description: ER 36X24 1.188 X .812-WPHY70

Master Job No:

TAG: LINE 6

M8120

Total Qty Open: 1 EA

Qty Posted: 0 EA

Qty To Make: 1

Start Date: 09/11/2023

Phone: (713)840-9333

Contact: ERIN TAYLOR

Fax: (713)840-9339

Job Notes

BCON
B10855 - TESTING REQ'D
PIPE SHOP TRAVELER 303-2023
FULL PLATE ALLOCATED

Routing

Routed By:

Quantity 1

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	Burning Table					09/11/2023	09/11/2023	1
	PLATE BURN	Plate Burn							
20	PIPE 6	Pipe Furnace					09/12/2023	09/12/2023	1
	FURNACE HEAT	Furnace heating							

30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	09/12/2023 09/12/2023	1
				
40	PIPE 7 STRING UP	Initial Weld String-up	09/12/2023 09/12/2023	1
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	09/13/2023 09/13/2023	1
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	09/13/2023 09/13/2023	1
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	09/14/2023 09/14/2023	1
				
80	PIPE 9 OD WELD	OD Weld OD Weld	09/18/2023 09/18/2023	1
				
90	PIPE 4 BIG ROLL	Big Roller Re-roll on large roller	09/18/2023 09/18/2023	1
				
100	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	09/18/2023 09/18/2023	1
				
110	FORGE 4 HAMMER	Large Hammer Hammer	09/25/2023 09/25/2023	1
				

120	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	07/22/2024	07/22/2024	1
					
130	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	07/22/2024	07/22/2024	1
					
140	PIPE 13 X RAY	Pipe X Ray X-ray weld	07/22/2024	07/23/2024	1
					
150	E1 MACHINING	E1 Extender Expander	07/23/2024	07/23/2024	1
					
160	M1 MACHINING	M1 Big Mill Machining	07/23/2024	07/23/2024	1
					
170	STAMP 1 STAMP	Stamping Stamping	07/23/2024	07/23/2024	1
					
180	INSPECT 1 INSPECTION	Inspection 1 Inspection	07/23/2024	07/23/2024	1
					
190	SHIPPING SHIPPING	Shipping Shipping	07/23/2024	07/23/2024	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: 1

<u>Quantity</u>				<u>Unit</u>	<u>Description</u>	<u>Sub-</u>	<u>Vendor</u>
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>			<u>Assy</u>	
1,390.00000	10,510.00000	1,390.00000	0.00000	LB	0PL1375633	NO	CLIFF STEEL
					PL0 1.375-A633-E		
					Quantities from Bins/Lot Number:		
					BCON-01 (1390.0)		

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCON
36X24
1.188X.812
WPHY70
231735-01

Pipe Shop Traveler Reducer Cyl.

303-2023

9/11/2023

☐ Pipe Shop Copy☐ Pipe Shop Original

Customer	<u>SMP</u>	SFI Order No	<u>231735-01</u>	Due Date	<u>9/18/2023</u>
Part	<u>36.000</u> OD X <u>1.375</u> X <u>27.000</u>	Ship Date	<u>10/2/2023</u>	NoPcs	<u>1</u>
Plate Size	<u>1.375</u> X <u>108.778</u> X <u>27.000</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 108.778 Width X 27.000 Length 1145 Lbs.Per Sketch # 6218From (1) Plate(s) 1.375 Thick X 132.000 Wide X 27.000 Long

Stamp Plates With Heat Code

BCONScarf to 108.778 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 36.000 " O.D.Tack Weld Using 5/32 " Dia. E9018M Electrodes Per Procedure # SMAW-HSLA-132-REV. 1Use Weld Procedure SAW-HSLA-101-REV. 11Weld 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

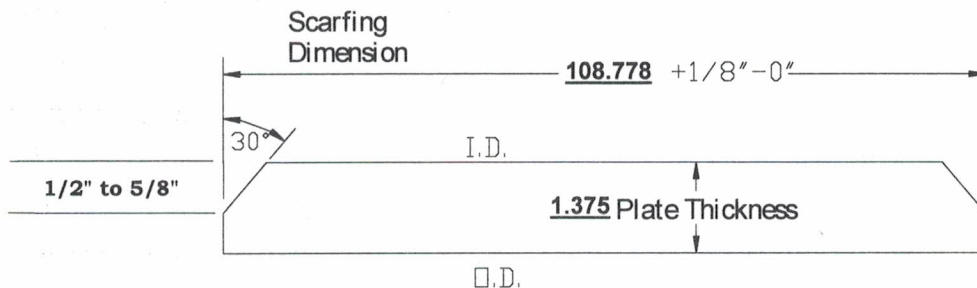
Weld O.D. Using 3/16 " Dia. LINCOLN LA-85 Wire and LINCOLN 888 Flux.

Hot Reroll to Roundup

Torch Cut Into Pcs @ Inches

Paint Mark on Cylinder SMP231735-01

Stamp Each Cylinder in (2) Places With Heat Code

BCONFitting Description: (1)ER 36X24 Y70Comments: FULL PLATE ALLOCATED

DO NOT USE GRADE C MATERIAL

FORM BY HAMMER

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# _____

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

SHOTBLAST TO NEAR WHITE FINISH

MACHINE PER MSS-SP75-19 EXCEPT ID TOLERANCE: ± 3/32

24 in. (SMALL) END-STRAIGHT BORE I.D. TO 21.876 ± 1/16

(FACE, TAPER BORE, AND BEVEL)

OUT OF ROUNDNESS 1/8" MAX

MIN. WALL AT BEVEL NO LESS THAN .010" UNDER NOMINAL

STAMP PER MSS-SP75-19

CUSTOMER INSPECTION REQUIRED

RANDOM HARDNESS TEST (30%): 1 **PCS (BASE, WELD, HAZ); 240 BHN MAX**

PC	B _____	W _____	H _____	B _____	W _____	H _____
	B _____	W _____	H _____	B _____	W _____	H _____

PAINT MARK ON ID (6" FROM ONE END) _____

COAT OD SURFACES ONLY AFTER INSPECTION

PACKAGING - PROVIDE SUITABLE END PROTECTION, 16" AND LARGER REQUIRES END PROTECTION AND 1 PC PER PALLET

BASE CHARPY 50% SHEAR MIN.

WELD CHARPY 20/15 MIN.

VANADIUM .025% MIN.

PE OR ME BEVELS IF STATED ON PO

RANDOM B,W,H HARDNESS

CE .45 MAX; STAMP CE IF >.42

M8110 - 55K TENSILE MAX

S:\PUBLIC\TAVELER\Kinder Morgan M8120\KM TRAVELERS.XLSX