

Job Traveler

Job Number: 231735-04



Due Date: 10/02/2023

Sold SMP SUPPLY
To: 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: *3TE24Y Product Code: TEE
Description: TE 24 .812-WPHY65 Master Job No:
W/ BARS
TAG: LINE 11
M8120

Total Qty Open: 4 EA Qty Posted: 0 EA Qty To Make: 4

Start Date: 09/25/2023
Contact: ERIN TAYLOR

Phone: (713)840-9333
Fax: (713)840-9339

Job Notes

BCON
B10856 - TESTING REQ'D
PIPE SHOP TRAVELER 306-2023
181X79 ALLOCATED; RECORD NEW DROP SIZE

Routing

Routed By:

Quantity 4

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- Start End		Run Quantity
10	PIPE 3 PLATE BURN	Burning Table Plate Burn					09/25/2023	09/25/2023	4
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					09/26/2023	09/26/2023	4



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Report Generated: 09/11/2023 11:00:51 AM

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30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	09/26/2023 09/26/2023	4
				
40	PIPE 7 STRING UP	Initial Weld String-up	09/26/2023 09/26/2023	4
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	09/28/2023 09/28/2023	4
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	09/28/2023 09/28/2023	4
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	09/28/2023 09/28/2023	4
				
80	PIPE 9 OD WELD	OD Weld OD Weld	10/04/2023 10/04/2023	4
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	10/12/2023 10/12/2023	4
				
100	FORGE 8 TRIM	Torch Cut Cut hole	11/01/2023 11/01/2023	4
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	11/01/2023 11/01/2023	4
				

120	FORGE 8 TRIM	Torch Cut Trim	11/01/2023 11/02/2023	4
				
130	FORGE 7 HEAT TREAT	Heat Treat	07/29/2024 07/30/2024	4
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast	07/30/2024 07/30/2024	4
				
150	PIPE 13 X RAY	Pipe X Ray	07/30/2024 07/31/2024	4
				
160	E1 MACHINING	E1 Extender	07/31/2024 07/31/2024	4
				
170	M7 SM BULL MACHINING	M7 Small Bullard Machining	07/31/2024 08/05/2024	4
				
180	PIPE 11 WELD BARS	Special Welds Weld Bars	08/13/2024 08/15/2024	4
				
190	FAB 8 GRINDING	Fab Grind Grinding Bars	08/15/2024 08/15/2024	4
				
200	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	08/15/2024 08/15/2024	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	Sub-Assy Vendor
5,576.00000	14,696.00000	5,576.00000	0.00000	LB	0PL1375633	NO CLIFF STEEL
PL0 1.375-A633-E						
Quantities from Bins/Lot Number:						
BCON-01 (5576.0)						

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCON
24X24
.812X.812
WPHY65
231735-04

Pipe Shop Traveler Tee Cyl.

306-2023

9/11/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>SMP</u>	SFI Order No	<u>231735-04</u>	Due Date	<u>9/18/2023</u>
Part	<u>30.000</u> OD X <u>1.375</u> X <u>79.000</u>	Ship Date	<u>10/2/2023</u>	NoPcs	<u>2</u>
Plate Size	<u>1.375</u> X <u>89.928</u> X <u>79.000</u>	Code	<u>BCON</u>	Test No	
Heat No.	<u>R3384</u>	Test Material			
Material	<u>A633E</u>				

Cut 2 Plate(s) 1.375 X Thick X 89.928 Width X 79.000 Length 2770 Lbs.

Per Sketch # 6211

From (1) Plate(s) 1.375 Thick X 134.000 Wide X 181.000 Long

Stamp Plates With Heat Code BCON

Scarf to 89.928 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 30.000 " 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

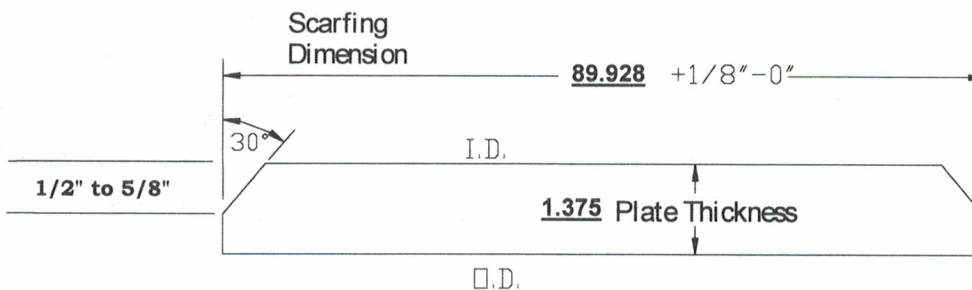
Torch Cut Into 4 Pcs @ 38.5 Inches

Paint Mark on Cylinder SMP 231735-04

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

Fitting Description: (4)TE 24 Y65

Comments: VERIFY LAYOUT TO SCARF ALONG 181" SIDE

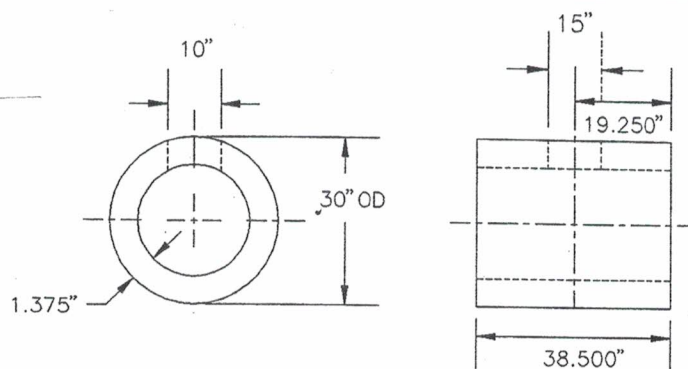


24" Run Diameter = 24.430"
 24" Outlet Diameter = 24.375"

Material Size 30" O.D. x 1.375" W
 Length 38.500"

Hole size 10" x 15"

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

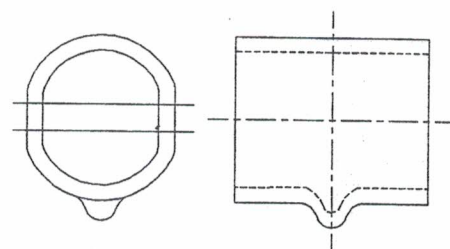


Ovaling Data: Oval: HOT Oval width: 23-1/2" ± .1/4"

Preform Data:

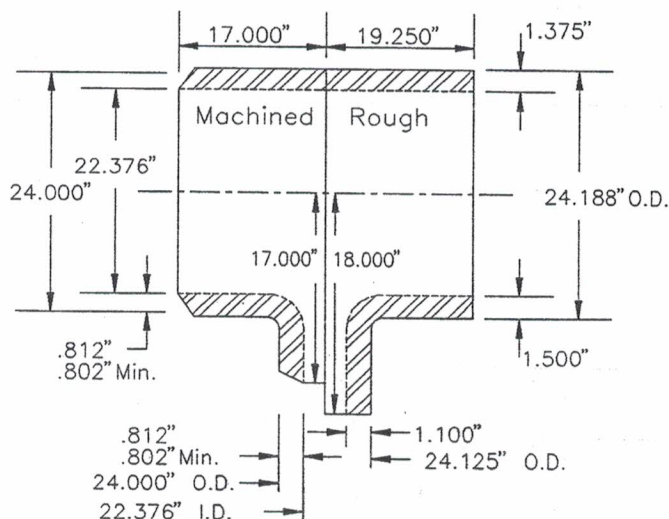
Press: Machine 2000 Ton Set up#10362 Upper Die# 50145
 Lower Die# 40312

1st Oper: Heat to 1650°F.
 Quench in 21" of water
 Close dies to 6" &
 Pull 17-3/8" plug (4" rod)



2nd Oper: Heat to 1650°F.
 Quench in 17" of water
 Close dies to 2" &
 Pull 20.00" plug (4" rod)

Final Oper: Re-heat to 1650°F
 Do not quench
 Close dies HOT &
 Pull 22-1/4" plug (4" rod)



DATE:

SCALE: NONE

DRAWN BY: J.DAVIDSON

CHECKED BY:

DWG#

24" x 24"
 (.812x.812)

24-24-6

HIGH YIELD
 TEE MFG. DATA

REV	DESCRIPTION	BY	DATE

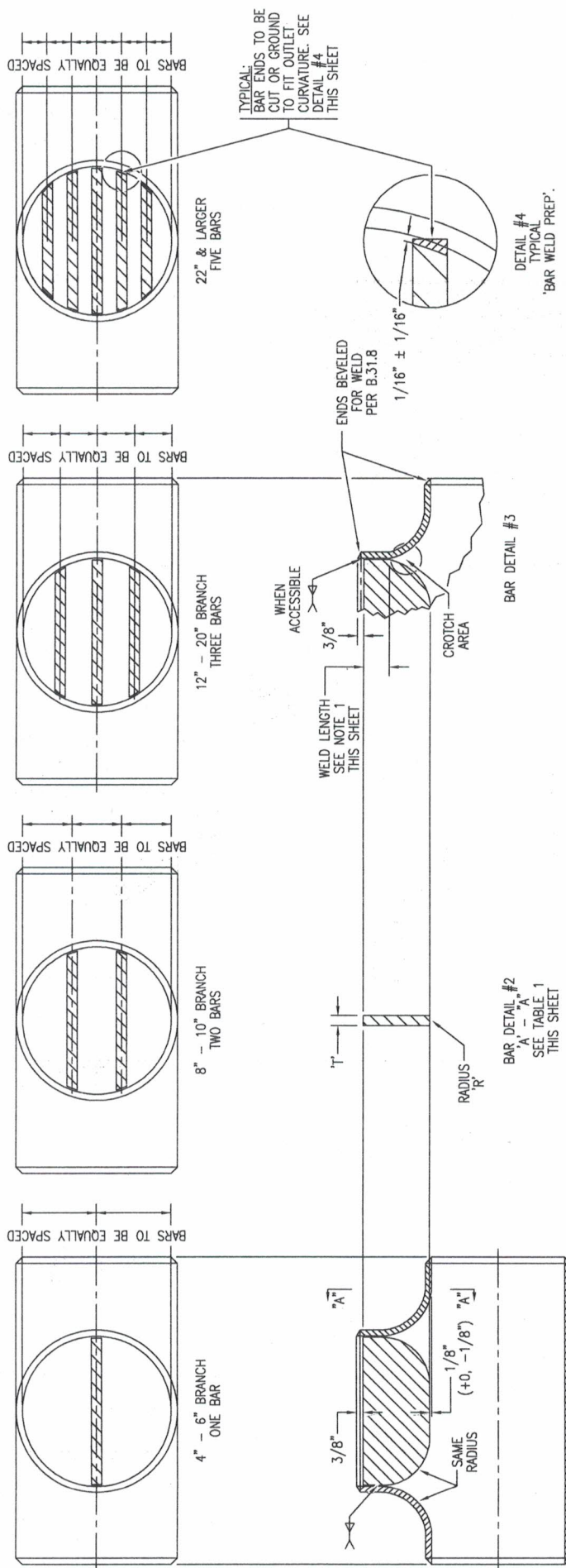


TABLE 1

NOMINAL BRANCH OUTLET SIZE	"T" DIMENSION	"R" RADIUS	FILLET WELD SIZE
4" - 10"	1/2" ± 1/16"	1/16"	3/8" LEGS
12" - 18"	1/2" ± 1/16"	1/16"	3/8" LEGS
20" - 24"	7/8" ± 1/16"	1/8"	5/8" LEGS
26" - 34"	7/8" ± 1/16"	1/8"	5/8" LEGS
36"	7/8" ± 1/16"	1/8"	5/8" LEGS
40" & LARGER	7/8" ± 1/16"	1/8"	5/8" LEGS

NOTES:

1. FILLET WELD ALL OF THE STRAIGHT LENGTH OF EACH BAR. AVOID WELDING IN THE CROTCH AREA. SEE BAR DETAIL #3 WELD LENGTH.
2. GUIDE BARS SHALL BE ASTM A36 OR ASTM A516.
3. GUIDE BARS ARE TO BE EQUALLY SPACED.
4. FILLET WELDS SHALL BE A MINIMUM OF TWO (2) PASSES MADE WITH E7018 ELECTRODES, FLUX CORE OR EQUIVALENT PREHEAT WELD AREA TO 200° F. MINIMUM.
5. WHEN PERFORMING SCRAPER BAR WELDS, COMPLETE THE WELD ON ONE END AND ALLOW TO COOL TO AMBIENT TEMPERATURE BEFORE WELDING THE OTHER END.
6. SCRAPER BAR WELDS SHALL BE NONDESTRUCTIVELY INSPECTED USING THE DYE PENETRANT METHOD PER ASTM E165 OR THE MAGNETIC PARTICLE METHOD PER ASTM E709.
7. THE FITTING SHALL BE DESIGNED IN ACCORDANCE WITH CFR TITLE 49 PART 192, MINIMUM FEDERAL SAFETY STANDARDS, AND GPTC GUIDE FOR GAS TRANSMISSION AND DISTRIBUTION PIPING SYSTEMS, LATEST EDITION.
8. THIS DRAWING SUPERSEDES ALL PREVIOUS KINDER MORGAN STANDARD GRATED TEE DETAIL DRAWINGS.

NO.	DATE	DESCRIPTION	BY	CHKD	APPR
0	10/11/05	APPROVED	MB	DM	JT
1	10/11/05	REVISED	MB	DM	JT
2	10/14/05	REVISED	MB	DM	JT

KINDER MORGAN

SCRAPER BAR DETAILS
FOR GRATED PIGGING TEE

DATE: 10/11/05
SCALE: N.T.S.
APPROVED BY: JT
TYP: P-0100-B220 SH. 1 OF 1

DESIGNED IN ACCORDANCE WITH TITLE 49-PART 192, MINIMUM FEDERAL SAFETY STANDARDS, AND GPTC GUIDE FOR GAS TRANSMISSION AND DISTRIBUTION PIPING SYSTEMS, LATEST EDITION.

DO NOT USE GRADE C MATERIAL

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# _____

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

FINISH MACHINE OUTLET PER MSS-SP75-2019 EXCEPT ID TOLERANCE ± 3/32

INSTALL 5 7/8 ± 1/16 in. THICK FULL HEIGHT SCRAPER BARS PER TYP-P-0100-B220 10/14/2015 (ATTACHED)

PER WPS FCAW-CS-HSLA-131 (LATEST REV.)

CLIP 1/2" OFF TOP CORNERS OF BAR(S)

PREHEAT TO AT LEAST 150°F AND KEEP INTERPASS AT LESS THAN 450°F

INSPECTOR TO SIGN OFF ON BARS AFTER THEY ARE FIT-UP _____

INSPECTOR TO SIGN OFF ON BARS AFTER THEY ARE GROUND _____

100% ME SCRAPER BAR WELDS PER SPEC. XL-MT-100 (LATEST REVISION), ACCEPTANCE CRITERIA MORE STRINGENT OF E709 AND/OR CUSTOMER SPECIFICATION _____

HEAT TREATMENT PER QCP 8.1 REV.1 **STRESS RELIEVE** 1 1/2 HR @ 1100 °F - AIR COOL - FURNACE LOAD # _____

SHOTBLAST TO NEAR WHITE FINISH

MACHINE RUN ENDS PER MSS-SP75-2019: **EXCEPT ID TOLERANCE** ± 3/32

0.812

BORE RUN I.D. STRAIGHT TO: 21.876 + 1/8 -0 22.376

0.802

0.812

BORE OUTLET I.D. STRAIGHT TO: 21.876 + 1/8 -0 22.376

0.802

OUT OF ROUNDESS 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%): 2 **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