

Job Traveler

Job Number: 231755-03



Due Date: 11/08/2023

Sold To: EDGEN MURRAY CORPORATION
18444 HIGHLAND ROAD
P.O. BOX 84160
BATON ROUGE, LA 70884-4160
United States

Ship To: , LA
United States

Order No: 231755

Dated: 09/12/2023

Quote No: 20723

Customer: EDGEN119955

PO Num: RMS-300904

Ship Via: TIFFANY.BAKER@EDGENMURR

Priority: 3 - STANDARD

Part Number: *3CR3620Y

Product Code: CONCENTRIC REDUCER

Description: CR 36X20 .750 X .500-
WPHY70

Master Job No:

TAG: : PUR-5020-2010483
LINE 9, EN-331PUR-5020-2010483
LINE 9, EN-332PUR-5020-2010483
LINE 9, EN-333

ES-PF1.14

Total Qty Open: 3 EA

Qty Posted: 0 EA

Qty To Make: 3

Start Date: 09/26/2023

Phone: 2,257,569,868

Contact: CLAIRE BLAY

Fax:

Job Notes

BCLT
B10646-1 - TESTING REQ'D
CUT (3) @ 25.75" EACH FROM 80" CYLINDER
CYLINDERS IN PROCESS ON 231758-01

Routing

Routed By:

Quantity 3

Step No	Work Cntr / Vendor	Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Time	Time	Time	Per Hour	Start	End	Quantity
10	FORGE 10					09/26/2023	09/26/2023	3
	CYLINDER CUT							



8/10

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20	FORGE 4 HAMMER	Large Hammer Hammer	11/01/2023 11/06/2023	3
				
30	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	08/20/2024 08/20/2024	3
				
40	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	08/20/2024 08/21/2024	3
				
50	PIPE 13 X RAY	Pipe X Ray X-ray weld	08/21/2024 08/21/2024	3
				
60	E1 MACHINING	E1 Extender Expander	08/21/2024 08/21/2024	3
				
70	M1 MACHINING	M1 Big Mill Machining	08/21/2024 08/22/2024	3
				
80	STAMP 1 STAMP	Stamping Stamping	08/22/2024 08/22/2024	3
				
90	INSPECT 1 INSPECTION	Inspection 1 Inspection	08/22/2024 08/22/2024	3
				



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: 3

----- Quantity -----						
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>	<u>Unit</u>	<u>Description</u>	
						<u>Sub- Assy</u> <u>Vendor</u>

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCLT
36X20
.750X.500
WPHY70
231755-03

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number _____ 231755-03 _____

Spectra Serial Number PO _____ SEE FRONT SHEET _____

ME inspection report

MTR's

Reader Sheet for Radiography

Inspection sheet with actual dimensions

Heat Treat charts

Furnace Uniformity & Quarterly Recorder Calibration records

DIMENSIONAL INSPECTION SHEET FOR TEE

Does stamping match traveler? _____' _____' _____' _____' _____'

What is actual run bevel thickness? _____' _____' _____' _____' _____'

What is actual outlet bevel thickness? _____' _____' _____' _____' _____'

What is the length of the tee? _____' _____' _____' _____' _____'

What is actual ID of run at bevel?
(Check two places) _____' _____' _____' _____' _____'

What is actual ID of outlet?
(Check two places) _____' _____' _____' _____' _____'

What is M dimension? _____' _____' _____' _____' _____'

Is outlet centered? _____' _____' _____' _____' _____'

Are all three bevels $30^{\circ}+5^{\circ}/-0^{\circ}$? _____' _____' _____' _____' _____'

SFI serial number stamped on it? _____' _____' _____' _____' _____'

Spectra serial number stamped on it? _____' _____' _____' _____' _____'

Have all areas needing cosmetic grinding been marked? _____' _____' _____' _____' _____'

Grind weld seam inside and outside flush
for minimum 2" from ends.

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 1/2 HR @ 1650°F **WATER QUENCH** FURNACE LOAD # _____

TEMPER 1 HR @ 1200 °F - AIR COOL - FURNACE LOAD# _____

IF QUENCH AND TEMPERED, RECORD THE FOLLOWING

TIME FROM FURNACE TO QUENCH TANK _____

TEMPERATURE OF QUENCH TANK _____

SHOTBLAST TO NEAR WHITE FINISH

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

DO NOT MACHINE UNTIL TESTING COMPLETE

MACHINE PER MSS-SP75-19 EXCEPT 14° MIN., 18° MAX INTERNAL TAPER

20 in. (SMALL) END-STRAIGHT BORE I.D. TO 18.500 ± 1/16
(FACE, TAPER BORE, AND BEVEL)

~~ME ALL WELD BEVELS PER SPEC. XL-MT-100 (LATEST REVISION) AND PF1.1 PARA 7A10 (5/28/18) ATTACH REPORTS~~

STAMP PER MSS-SP75-19 ON O.D. A MINIMUM OF 2" FROM BEVEL & WELD SEAM

SFI SERIAL NUMBER 231755-03

SPECTRA SERIAL NUMBER PO SEE FRONT SHEET

HARDNESS TEST EACH PIECE (235 BHN MAX): _____

PAINT EXTERIOR ONLY - AFTER INSPECTION

PAINT RED FLOURESCENT STRIPE DOWN LENGTH OF FITTING IF CE> .42 CE= _____

END PROTECT/PALLETIZE

CUSTOMER INSPECTION MAY BE REQUIRED

MPS & ITP FOR PF1.9 REV. 0 IS APPROVED 3/1/12 PER REX LITTRELL, SPECTRA ENERGY

Base and weld charpies min 20/15

CE .45 or less

ME bevels

Base hardness

QT can only be used for Y52 and up

S:\PUBLIC\TRAVELER\Spectra PF1.14\PF1.14 Travelers.XLSX