

Job Traveler

Job Number: 231755-04



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:** *3CR2420Y**Product Code:** CONCENTRIC REDUCER**Description:** CR 24X20 .562 X .500-
WPHY65**Master Job No:**TAG: PUR-5020-2010483
LINE 10, EN-335

ES-PF1.14

Total Qty Open: 1 EA**Qty Posted:** 0 EA**Qty To Make:** 1**Start Date:** 09/26/2023**Phone:** 2,257,569,868**Contact:** CLAIRE BLAY**Fax:**

Job Notes

BCLD
B10608-1
CUT (1) @ 21.125" FROM 120" CYLINDER

Routing

Routed By:

Quantity 1

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- Start End		Run Quantity
10	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut					09/26/2023	09/26/2023	1



20	FORGE 4 HAMMER	Large Hammer Hammer					10/09/2023	10/09/2023	1
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30	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	08/20/2024	08/20/2024	1
					
40	FORGE 5-6 FORGE BLAST	Forge Shotblast Forge Blast	08/21/2024	08/21/2024	1
					
50	PIPE 13 X RAY	Pipe X Ray X-Ray	08/21/2024	08/21/2024	1
					
60	E1 MACHINING	E1 Extender Expander	08/21/2024	08/21/2024	1
					
70	M9 MACHINING	M9 Medium Bullard Machining	12/24/2024	01/14/2025	1
					
80	STAMP 1 STAMP	Stamping	01/14/2025	01/14/2025	1
					
90	INSPECT 1 INSPECTION	Inspection 1	01/14/2025	01/14/2025	1
					
100	SHIPPING SHIPPING	Shipping	01/14/2025	01/14/2025	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

Quantity			
Needed	On Hand	Posted	Short
22.00000	293.00000	22.00000	0.00000

Unit Description
EA 0PI247552-W

Sub-
Assy Vendor
NO SFI

PI0 24-.75-Y52 W
Quantities from Bins/Lot Number:
BCLD (22.0)

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCLD
24X20
.562X.500
WPHY65
231755-04

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number 231755-04

Spectra Serial Number PO PUR-5020-2010483/10/EN-335

~~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 3/4 HR @ 1300 °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 231755-04

SPECTRA SERIAL NUMBER PO PUR-5020-2010483/10/EN-335

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 LITRELL, 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\TAVELER\Spectra PF1.14\PF1.14 Travelers.XLSX