



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: *3TE36Y

Product Code: TEE

Description: TE 36 .750-WPHY70

Master Job No:

TAG: PUR-5020-2010483
LINE 15, EN-391

PUR-5020-2010483
LINE 15, EN-392

PUR-5020-2010483
LINE 15, EN-393

PUR-5020-2010483
LINE 15, EN-394

ES-PF1.14

Total Qty Open: 4 EA

Qty Posted: 0 EA

Qty To Make: 4

Start Date: 09/26/2023

Phone: 2,257,569,868

Contact: CLAIRE BLAY

Fax:

Job Notes

BCMR
B10747-1 - TESTING REQ'D
USE (4) CYLINDERS @ 58" EACH
CYLINDERS IN PROCESS ON 231659-01

Routing

Routed By:

Quantity 4

Step No	Work Cntr / Vendor	Setup	Cycle	Total	Pieces	--- Scheduled ---	Run	
Dept	Operation	Time	Time	Time	Per Hour	Start	End	Quantity
10	FORGE 10 CYLINDER CUT		Cylinder Cut Cylinder Cut			09/26/2023	09/26/2023	4

*9/18*

Job Number: 231755-07

Report Generated: 09/14/2023 8:51:04 AM

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20	FORGE 8 TRIM	Torch Cut Cut hole	10/03/2023 10/04/2023	4
				
30	FORGE 12 FORM/PRESS	2000 Ton Press Forming	10/04/2023 10/04/2023	4
				
40	FORGE 8 TRIM	Torch Cut Trim	10/04/2023 10/05/2023	4
				
50	FORGE 7 HEAT TREAT	Heat Treat Heat treat	08/22/2024 08/26/2024	4
				
60	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	08/26/2024 08/26/2024	4
				
70	PIPE 13 X RAY	Pipe X Ray X-ray	08/26/2024 08/26/2024	4
				
80	E1 MACHINING	E1 Extender Expander	08/26/2024 08/27/2024	4
				
90	M1 MACHINING	M1 Big Mill Machining	08/27/2024 08/29/2024	4
				
150	STAMP 1 STAMP	Stamping	08/29/2024 08/29/2024	4
				

4



170

SHIPPING
SHIPPING

Shipping

08/29/2024 08/29/2024

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:	4
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Quantity						Sub-	
Needed	On Hand	Posted	Short	Unit	Description	Assy	Vendor

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCMR
36X36
.750X.750
WPHY70
231755-07

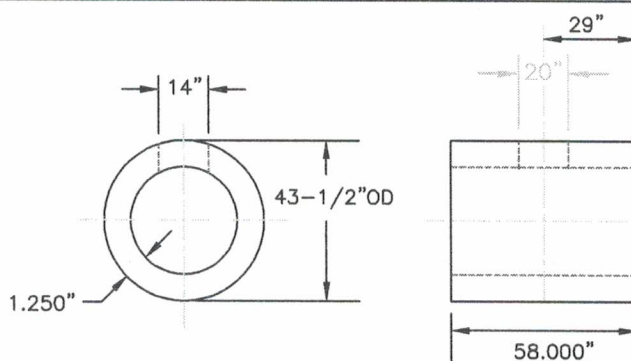
36" Run Diameter = 36.542"

36" Outlet Diameter = 36.699"

Material Size 43-1/2" O.D. x 1.250"W
Length 58.000"

Hole size 14" x 20" Oval

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



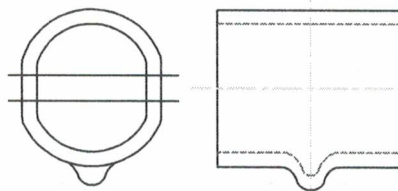
Ovaling Data: Oval: HOT Oval width: 35-3/4" ±.1/4"

Preform Data:

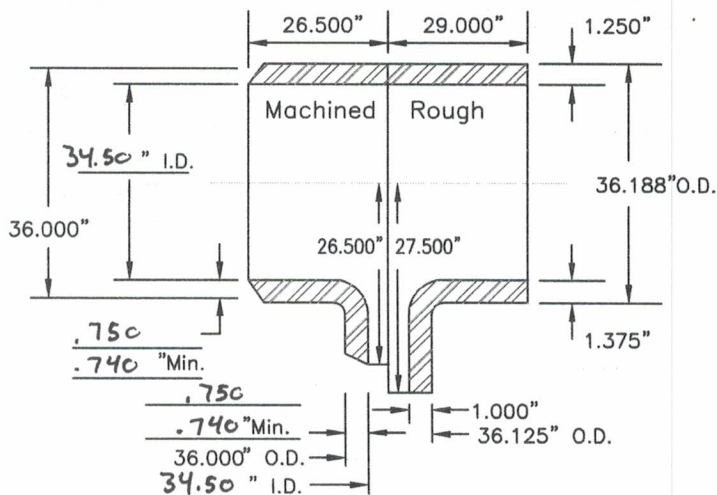
Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50045

1st Oper: Heat to 1650°F
Quench in 30" of water
Close dies HOT to 7-1/2"
Pull 23.210" plug (6" rod)

2nd Oper: Re-heat to 1650°F
Quench in 25-1/2" of water
Close dies to 3" &
Pull 29.140" plug (6" rod)



Final Oper: Re-heat to 1650°F
Do not quench
Countersink plug,
Close dies HOT &
Pull 34.25" plug (6" rod)



DATE: 11-12-99

SCALE: NONE

DRAWN BY: J.D.

CHECKED BY: Bull

36" x 36"

.750 x .750

HIGH YIELD
TEE MFG. DATA

DWG#

36-36-4

(use for all bevel thicknesses
from .751" thru .833")

REV DESCRIPTION BY DATE

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number 231755-07

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 3/4 HR @ 1650°F **WATER QUENCH** FURNACE LOAD # _____

TEMPER 1 1/4 HR @ 1100 °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

BORE RUN I.D. STRAIGHT TO: 33.750 + 1/4 -0 0.750
34.500

0.740
0.750

BORE OUTLET I.D. STRAIGHT TO: 33.750 + 1/4 -0 34.500
0.740

MAGNETIC PARTICLE EXAMINE BEVELED ENDS OF OUTLET PER SPEC. XL-MT-100 (LATEST REVISION) AND PARA. 7A5 & 7A10 OF SPEC. PF1.13. (5/28/18) AND ALL WELD BEVELS ALONG WITH INSIDE AND OUTSIDE OF OUTLET CROTCH IF IT IS Y60 AND GREATER AND ACCESSIBLE. ATTACH REPORTS

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

SFI SERIAL NUMBER 231755-07

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 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