

Job Traveler

Job Number: 231755-10



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: *3TE3620Y Product Code: TEE
Description: TE 36X20 .750 X .500-
WPHY70
TAG: PUR-5020-2010483
LINE 18, EN-421
PUR-5020-2010483
LINE 18, EN-422
ES-PF1.14

Total Qty Open: 2 EA Qty Posted: 0 EA Qty To Make: 2

Start Date: 09/26/2023

Phone: 2,257,569,868

Contact: CLAIRE BLAY

Fax:

Job Notes

BCPB
B10883 - TESTING REQ'D
CUT (2) @ 55" EACH FROM 112" CYLINDER
CYLINDERS IN PROCESS ON 231758-02

Routing

Routed By:

Quantity 2

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	2
20	FORGE 8 TRIM	Torch Cut Cut hole					10/04/2023	10/04/2023	2



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Report Generated: 09/14/2023 8:51:05 AM

Page 1 of 4

30	FORGE 12 FORM/PRESS	2000 Ton Press Forming	10/04/2023 10/04/2023	2
				
40	FORGE 8 TRIM	Torch Cut Trim	10/05/2023 10/09/2023	2
				
50	FORGE 7 HEAT TREAT	Heat Treat Heat treat	08/26/2024 08/27/2024	2
				
60	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	08/27/2024 08/27/2024	2
				
70	PIPE 13 X RAY	Pipe X Ray X-ray	08/27/2024 08/27/2024	2
				
80	E1 MACHINING	E1 Extender Expander	08/27/2024 08/27/2024	2
				
90	M1 MACHINING	M1 Big Mill Machining	08/27/2024 08/28/2024	2
				
150	STAMP 1 STAMP	Stamping	08/28/2024 08/28/2024	2
				
160	INSPECT 1 INSPECTION	Inspection 1	08/28/2024 08/28/2024	2
				



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: 2

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

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCPB
36X20
.750X.500
WPHY70
231755-10

36" Run Diameter = 36.542"

20" Outlet Diameter = 20.523"

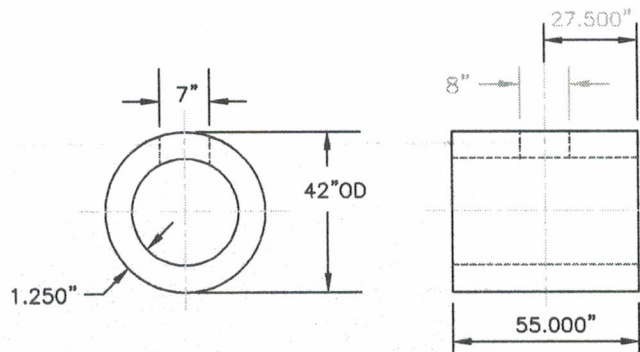
Material Size 42" O.D. x 1.250"W
Length 55.000"

Ovaling Data:

Oval HOT to: 35-3/4" ± 1/4"

Hole size 7"x 8" oval

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



Preform Data:

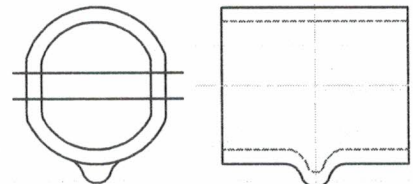
Press: Machine 2000 Ton Set up #10139 Upper Die # 50046
Lower Die # 50082 with 36x20" Insert #50089

1st Oper: Heat to 1650°F.—Quench in 28 inches of water.

Close dies to 5-1/2" and
Pull 10-1/4" diameter plug (4" rod).

2nd Oper: Re-heat to 1650°F.

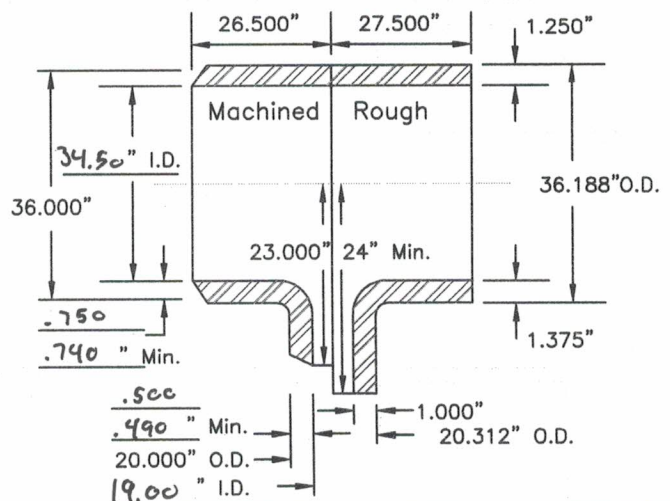
Quench in 23-1/2 inches of water
Close dies to 1-1/2" and
Pull 14-3/4" diameter plug (4" rod).



3th Oper: Re-heat to 1650°F.

Do not quench

Close dies hot and
Pull 18-1/4" plug (4" pull rod).



				DATE: 11-22-99
				SCALE: NONE
				DRAWN BY: J.D.
				CHECKED BY: Bull
REV	DESCRIPTION	BY	DATE	

36" x 20"
750 x 500
HIGH YIELD
TEE MFG. DATA

DWG#

36-20-3

Use for bevel thicknesses:
36" Run—.751" thru .833"
20" Outlet—.812" and less.

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number _____ 231755-10 _____

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
0.500

BORE OUTLET I.D. STRAIGHT TO: 18.500 + 1/8 -0 19.000
0.490

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 231755-10

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

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