

Job Traveler

Job Number: 231755-11



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: *3TE3616Y

Product Code: TEE

Description: TE 36X16 .750 X .500-
WPHY70

Master Job No:

TAG: PUR-5020-2010483
LINE 19, EN-431

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

BCOR
B10864
CUT (1) @ 55" FROM 112" 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 8 TRIM	Torch Cut Cut hole					10/04/2023	10/04/2023	1
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Report Generated: 09/14/2023 8:51:05 AM

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30	FORGE 12 FORM/PRESS	2000 Ton Press Forming	10/04/2023 10/04/2023	1
				
40	FORGE 8 TRIM	Torch Cut Trim	10/09/2023 10/09/2023	1
				
50	FORGE 7 HEAT TREAT	Heat Treat Heat treat	08/27/2024 08/27/2024	1
				
60	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	08/27/2024 08/27/2024	1
				
70	PIPE 13 X RAY	Pipe X Ray X-ray	08/27/2024 08/27/2024	1
				
80	E1 MACHINING	E1 Extender Expander	08/27/2024 08/27/2024	1
				
90	M1 MACHINING	M1 Big Mill Machining	08/27/2024 08/28/2024	1
				
150	STAMP 1 STAMP	Stamping	08/28/2024 08/28/2024	1
				
160	INSPECT 1 INSPECTION	Inspection 1	08/28/2024 08/28/2024	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 -----						Quantity: 1
<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>
56.00000	505.00000	56.00000	0.00000	EA	0PI3912552	NO SFI

PI0 39-1.25-Y52
Quantities from Bins/Lot Number:
BCOR (56.0)

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCOR
36X16
.750X.500
WPHY70
231755-11

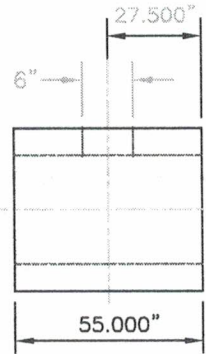
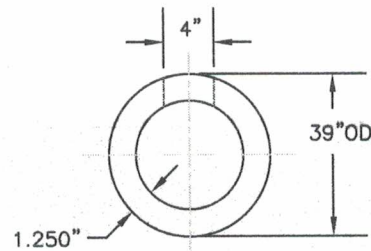
36" Run Diameter = 36.542"

16" Outlet Diameter = Free pull in 36 x 18 dies

Material Size 39" O.D. x 1.250"W
Length 55.000"

Hole size 3.50" hole

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



SHOP NOTE: Cut hole after barreling operations.

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# 50082 with 36x18" Insert #50090

1st Oper: Heat to 1650°F. — Quench in 23-1/2" of water.

Barrel down HOT with HOT side up. Close dies to 3"

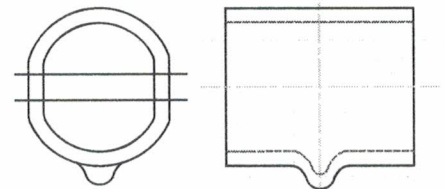
2nd Oper: Re-heat to 1650°F.

Quench barreled side in 21-1/2" of water & barrel
down HOT with HOT side up. Close dies to 1".

3rd Oper: Cut outlet hole per above.

4th Oper: Heat to 1650°F. — Do not quench. Do not close dies
and pull 6-3/4" plug.

5th Oper: Heat to 1650°F. — Do not quench. Do not close
dies pull 8-3/4" dia. plug (3" pull rod)

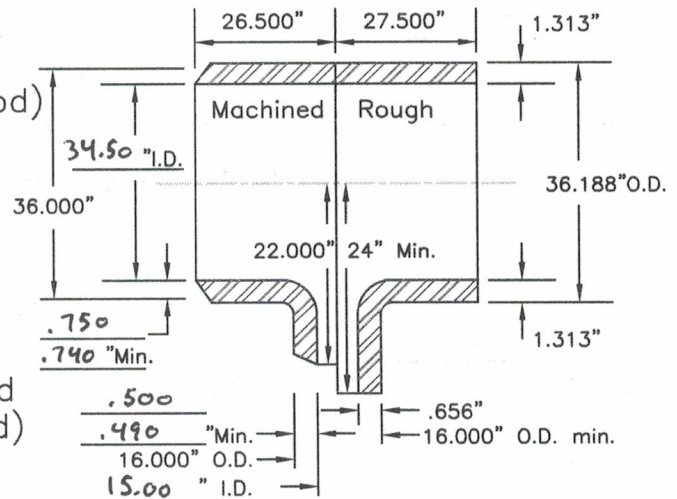


6th Oper: Heat to 1650°F.—Do not quench
Do not close dies and
Pull 10-3/4" dia. plug (3.5" pull rod)

7th Oper: Re-heat to 1650°F.—Do not
quench—Do not close dies and
Pull 12-3/4" dia. plug (4" pull rod)

Final Oper: Re-heat to 1650°F.
Do not quench—Close dies hot and
Pull 14.750" dia. plug (4" pull rod)

SHOP NOTE: Outlet may require end sizing.



				DATE: 11-19-99
				SCALE: NONE
				DRAWN BY: J.D.
2	added extra pins for manual pull	JL	10/11/16	CHECKED BY: Bull
1	changed outlet height	JL	9/9/15	
REV	DESCRIPTION	BY	DATE	

36" x 16"
.750 x .500
HIGH YIELD
TEE MFG. DATA

DWG#
36-16-5
Use for bevel thicknesses:
36: Run—.751" thru .833"
16" Outlet—.593" and less.

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number 231755-11

Spectra Serial Number PO PUR-5020-2010483/19/EN-431

~~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: 14.500 + 1/8 -0 15.000
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 231755-11

SPECTRA SERIAL NUMBER PO PUR-5020-2010483/19/EN-431

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