

Job Traveler

Job Number: 231755-12



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:** *3TE3016Y**Product Code:** TEE**Description:** TE 30X16 .625 X .500-
WPHY70**Master Job No:**TAG: PUR-5020-2010483
LINE 20, EN-461PUR-5020-2010483
LINE 20, EN-462

ES-PF1.14

Total Qty Open: 2 EA**Qty Posted:** 0 EA**Qty To Make:** 2**Start Date:** 09/14/2023**Phone:** 2,257,569,868**Contact:** CLAIRE BLAY**Fax:**

Job Notes

BCLW
B10664
FROM ROUGH BLANKS
FORM AT PRESS

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 8 TRIM	Torch Cut Cut hole					09/14/2023	09/14/2023	2
20	FAB 2 PULL/JACK	Nozzle Pull Nozzle Pull or Jack					09/14/2023	09/14/2023	2



9/13

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Report Generated: 09/14/2023 8:51:06 AM

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30	FORGE 8 TRIM	Torch Cut Trim	11/06/2023 11/07/2023	2
				
40	FORGE 7 HEAT TREAT	Heat Treat Heat treat	08/27/2024 08/27/2024	2
				
50	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	08/27/2024 08/28/2024	2
				
60	PIPE 13 X RAY	Pipe X Ray X-ray	08/28/2024 08/28/2024	2
				
70	E1 MACHINING	E1 Extender Expander	08/28/2024 08/28/2024	2
				
80	M1 MACHINING	M1 Big Mill Machining	08/28/2024 08/29/2024	2
				
90	STAMP 1 STAMP	Stamping	08/29/2024 08/29/2024	2
				
100	INSPECT 1 INSPECTION	Inspection 1	08/29/2024 08/29/2024	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					Quantity: 2	
Needed	On Hand	Posted	Short	Unit	Description	Sub- Assy Vendor
2.00000	8.00000	2.00000	0.00000	EA	*2TE302-16XHY	YES
					TE2 30X2-16-XH-ROUGH-HY	
					Quantities from Bins/Lot Number:	
					BCLW/222045-02 (1.0)	
					BCLW (1.0)	

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCLW
30X16
.625X.500
WPHY70
231755-12

30" Run Diameter = 30.476"

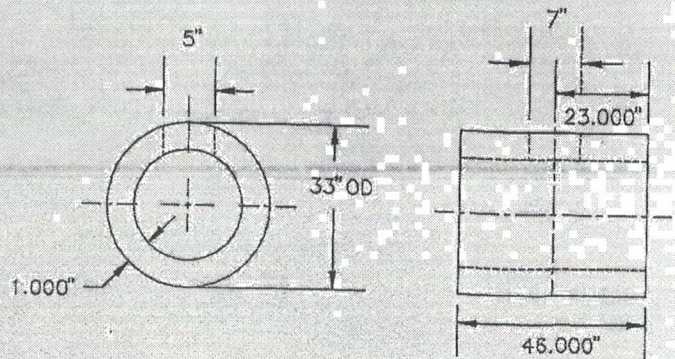
16" Outlet Diameter = 16.479"

Material Size 33" O.D. x 1.000" W

Length 46.000"

Hole size 5" x 7" Oval

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



Ovaling Data: Oval: HOT Oval width: 29-1/2" ± .1/4"

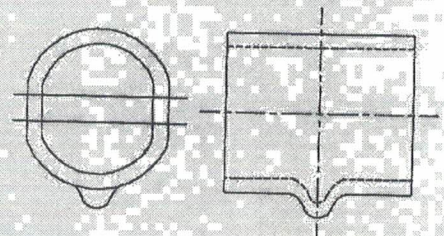
Preform Data:

Press: Machine 2000 Ton Set up#10138 Upper Die# 50037

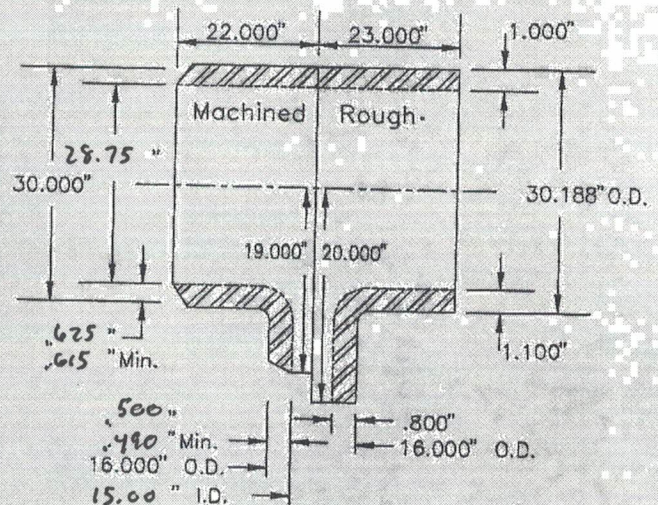
Lower Die# 50084

1st Oper: Heat to 1650°F
Quench in 20" of water
Close dies to 3" &
Pull 9" plug(3-1/2" rod)

2nd Oper: Re-heat to 1650°F
Quench in 18" of water
Close dies 1" &
Pull 11-3/4" plug(4" rod)



Final Oper: Re-heat to 1650°F
Do not quench
Close dies HOT &
Pull 14-3/4" plug(4" rod)



15.00 I.D. →

				DATE:	30" x 16" (.625 x .500)	DWG# 30-16-2A
				SCALE: NONE		
				DRAWN BY: J.DAVIDSON		
				CHECKED BY:		
REV	DESCRIPTION	BY	DATE		HIGH YIELD TEE MFG. DATA	

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number

231755-12

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

BORE RUN I.D. STRAIGHT TO: 28.000 + 1/4 -0 0.625
28.750
0.615

BORE OUTLET I.D. STRAIGHT TO: 14.500 + 1/8 -0 0.500
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 231755-12

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