

Job Traveler

Job Number: 231755-13



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: *3TE2416Y

Product Code: TEE

Description: TE 24X16 .562 X .500-
WPHY65

Master Job No:

TAG: PUR-5020-2010483
LINE 21, EN-481

PUR-5020-2010483
LINE 21, EN-482

PUR-5020-2010483
LINE 21, EN-483

PUR-5020-2010483
LINE 21, EN-484

PUR-5020-2010483
LINE 21, EN-485

ES-PF1.14

Total Qty Open: 5 EA

Qty Posted: 0 EA

Qty To Make: 5

Start Date: 09/26/2023

Phone: 2,257,569,868

Contact: CLAIRE BLAY

Fax:

Job Notes

BCLW
B10664
CUT (5) @ 36" EACH FROM (2) 110" CYLINDERS

9/18

Job Number: 231755-13

Report Generated: 09/14/2023 8:51:07 AM

Routing

Routed By:

Quantity 5

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- Start End		Run Quantity
5	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut					09/26/2023	09/27/2023	5
 									
10	FORGE 8 TRIM	Torch Cut Cut hole					10/09/2023	10/09/2023	5
 									
20	FORGE 12 FORM/PRESS	2000 Ton Press Forming					10/09/2023	10/09/2023	5
 									
30	FORGE 8 TRIM	Torch Cut Trim					11/07/2023	11/07/2023	5
 									
40	FORGE 7 HEAT TREAT	Heat Treat					08/27/2024	08/28/2024	5
 									
50	FORGE 5-6 FORGE BLAST	Forge Shotblast					08/28/2024	08/29/2024	5
 									
60	PIPE 13 X RAY	Pipe X Ray					08/29/2024	08/29/2024	5
 									
70	E1 MACHINING	E1 Extender					08/29/2024	09/02/2024	5
 									

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90

STAMP 1
STAMP

Stamping

09/04/2024 09/04/2024

5



100

INSPECT 1
INSPECTION

Inspection 1

09/04/2024 09/04/2024

5



110

SHIPPING
SHIPPING

Shipping

09/04/2024 09/04/2024

5



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: 5	
Needed	On Hand	Posted	Short	Unit	Description	Sub- Assy Vendor
184.00000	587.00000	184.00000	0.00000	EA	0PI27152	NO SFI
PI0 27-1-Y52						
Quantities from Bins/Lot Number:						
BCLW/230055-02 (110.0)						
BCLW/230055-02 (74.0)						

Marking Information:



FLEET-LINE
MADE IN USA
STEEL FORGINGS

BCLW
24X16
.562X.500
WPHY65
231755-13

16" Outlet Diameter = 16.375"

Hole size $5\frac{1}{2} \times 6\frac{1}{2}$
~~8" x 7"~~

Technical drawing of a cylindrical part showing front and side views with dimensions:

- Front View (Left):** A circle with an outer diameter of 27" OD and a wall thickness of 1.000". The center is marked with a crosshair. A dimension of $5\frac{1}{2}$ " is shown from the center to the left edge of a feature.
- Side View (Right):** A rectangle with a total width of 36.000" and a height of 18.000". The center is marked with a crosshair. A dimension of $6\frac{1}{2}$ " is shown from the center to the top edge of a feature.

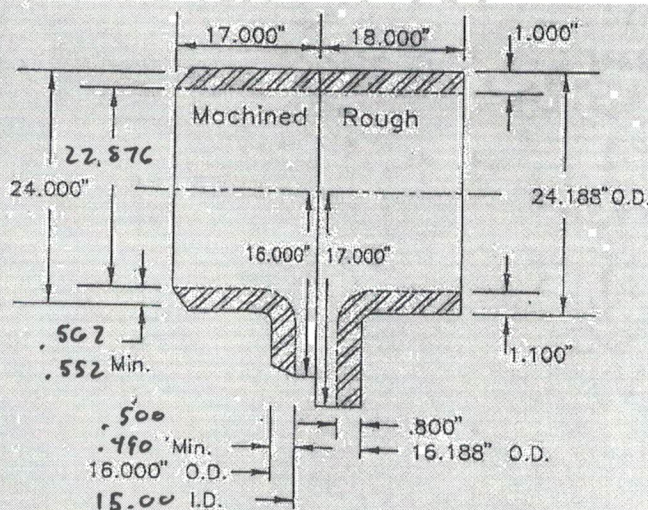
Preform Data:

Press: Machine 2000 Ton Set up#10362 Upper Die# 50145
Lower Die# 40308

1st Oper: Heat to 1650°F.—Quench in ^{17"}~~16"~~
of water. Close dies HOT to ~~2-1/2"~~ 3"
Pull ~~10-1/16"~~ dia. plug (~~X~~ rod)
_{9.00"} _{3 1/2"}

2nd Oper: Re-heat to 1650°F.
Quench in 15" of water
Close dies HOT to 1" &
Pull 12" ~~plug~~ plug (4")

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



				DATE: 12/19/96	24" x 16" (.562' x .500)	DWG# 24-16-2A
				SCALE: NONE		
				DRAWN BY: J.DAVIDSON		
				CHECKED BY: EAS		
REV	DESCRIPTION	BY	DATE	HIGH YIELD TEE MFG. DATA		

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number _____

231755-13

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: 22.376 + 1/8 -0 22.876
0.562
0.552

BORE OUTLET I.D. STRAIGHT TO: 14.500 + 1/8 -0 15.000
0.500
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 231755-13

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