Job Traveler

Job Number: 231756-06

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: 231756 **Dated:** 09/12/202 **Quote No:** 20723

Customer: EDGEN119955 **PO Num:** RMS-300903

Ship Via: TIFFANY.BAKER@EDGENMURR **Priority:** 3 - STANDARD

Part Number: *3TE36Y **Product Code:** TEE

Description: TE 36 .750-WPHY70 **Master Job No:**

TAG: PUR-5020-2010480
LINE 14, AR-341

PUR-5020-2010480
LINE 14, AR-342

PUR-5020-2010480
LINE 14, AR-343

ES-PF1.14

Total Qty Open: 3 EA **Qty Posted:** 0 EA **Qty To Make:** 3

Start Date: 09/27/2023 **Phone:** 2,257,569,868

Contact: CLAIRE BLAY **Fax:**

Job Notes

BCMR
B10747-1 - TESTING REQ'D
USE (3) CYLINDERS @ 58" EACH
CYLINDERS IN PROCESS ON 231659-01

Routing

Routed By:

Quantity 3

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					09/27/2023	09/28/2023	3

20	FORGE 8 TRIM	Torch Cut Cut hole	10/09/2023	10/09/2023	3
30	FORGE 12 FORM/PRESS	2000 Ton Press Forming	10/09/2023	10/10/2023	3
40	FORGE 8 TRIM	Torch Cut Trim	11/07/2023	11/07/2023	3
50	FORGE 7 HEAT TREAT	Heat Treat Heat treat	09/05/2024	09/05/2024	3
60	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	09/05/2024	09/05/2024	3
70	PIPE 13 X RAY	Pipe X Ray X-ray	09/05/2024	09/09/2024	3
80	E1 MACHINING	E1 Extender Expander	09/09/2024	09/09/2024	3
90	M1 MACHINING	M1 Big Mill Machining	09/09/2024	09/10/2024	3
150	STAMP 1 STAMP	Stamping	09/10/2024	09/10/2024	3

Job Number: 231756-06

Report Generated: 09/14/2023 9:13:12 AM

160	INSPECT 1 INSPECTION	Inspection 1	09/10/2024	09/10/2024	3
170	SHIPPING SHIPPING	Shipping	09/10/2024	09/10/2024	3

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: 3

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

Marking Information:

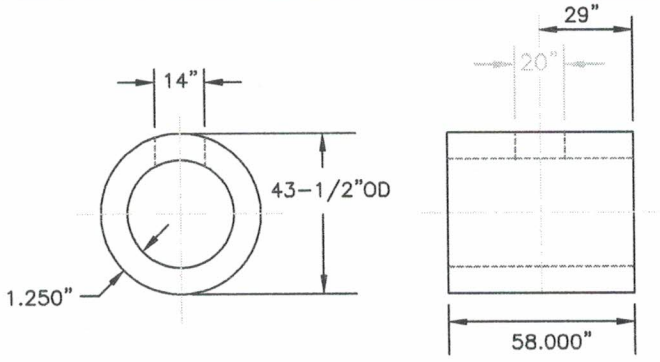
FLEET-LINE®
MADE IN USA
STEEL FORGINGS

BCMR
36X36
.750X.750
WPHY70
231756-06

36" Run Diameter = 36.542"
36" Outlet Diameter = 36.699"

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

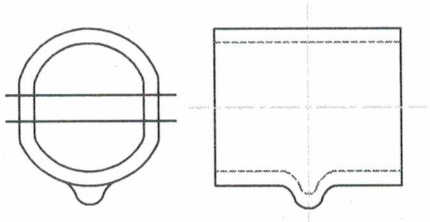
Hole size 14" x 20" Oval
Grind 1/8" radius on hole edges
I.D. & O.D.



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

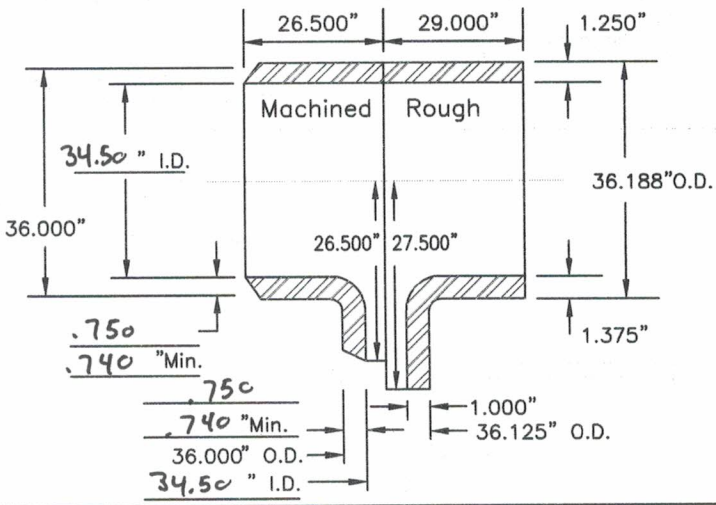
1st Oper: Heat to 1650°F
Quench in 30" of water
Close dies HOT to 7–1/2"
Pull 23.210" plug (6"rod)



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 34.250" plug (6" rod)

LET JOHN KNOW IF WE HAVE THIS PLUG. IT MAY BE THAT WE ONLY HAVE 34⅛.
JL



REV	DESCRIPTION	BY	DATE

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")

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number 231756-06

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°+5°/ -0°? _____, _____, _____, _____, _____

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)

BORE OUTLET I.D. STRAIGHT TO: 33.750 + 1/4 -0 (0.750 / 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 231756-06

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 LITTRELL, 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