Job Traveler

Job Number: 231756-08

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: *3TE3624Y **Product Code:** TEE

Description: TE 36X24 .750 X .562-WPHY70

TAG: : PUR-5020-2010480
LINE 16, AR-371

ES-PF1.14

Master Job No:

Total Qty Open: 1 EA **Qty Posted:** 0 EA **Qty To Make:** 1

Start Date: 09/28/2023 **Phone:** 2,257,569,868

Contact: CLAIRE BLAY **Fax:**

Job Notes

BCOR
B10864
CUT (1) @ 55" FROM 112" CYLINDER - REMAINING CYLINDER WILL GO TO STOCK
CYLINDERS IN PROCESS ON 231758-02

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					09/28/2023	09/28/2023	1
20	FORGE 8 TRIM	Torch Cut Cut hole					10/09/2023	10/09/2023	1

30	FORGE 12 FORM/PRESS	2000 Ton Press Forming	10/09/2023	10/09/2023	1
40	FORGE 8 TRIM	Torch Cut Trim	11/08/2023	11/08/2023	1
50	FORGE 7 HEAT TREAT	Heat Treat Heat treat	09/09/2024	09/10/2024	1
60	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	09/10/2024	09/10/2024	1
70	PIPE 13 X RAY	Pipe X Ray X-ray	09/10/2024	09/10/2024	1
80	E1 MACHINING	E1 Extender Expander	09/10/2024	09/10/2024	1
90	M1 MACHINING	M1 Big Mill Machining	09/10/2024	09/11/2024	1
150	STAMP 1 STAMP	Stamping	09/11/2024	09/11/2024	1
160	INSPECT 1 INSPECTION	Inspection 1	09/11/2024	09/11/2024	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: 1

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

Marking Information:

FLEET-LINE®
MADE IN USA
STEEL FORGINGS

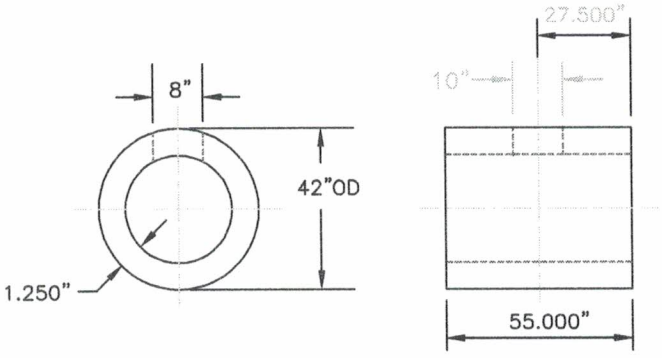
BCOR
36X24
.750X.562
WPHY70
231756-08

36" Run Diameter = 36.542"
24" Outlet Diameter= 24.567"

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

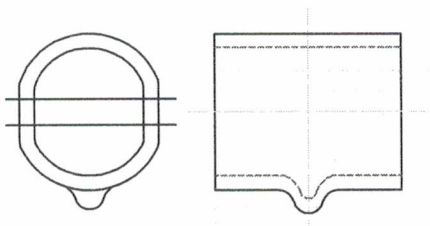
Ovaling Data:
Oval HOT to: 35–3/4"±1/4"

Hole size 8"x 10" oval
Grind 1/8" radius on hole edges
I.D. & O.D.



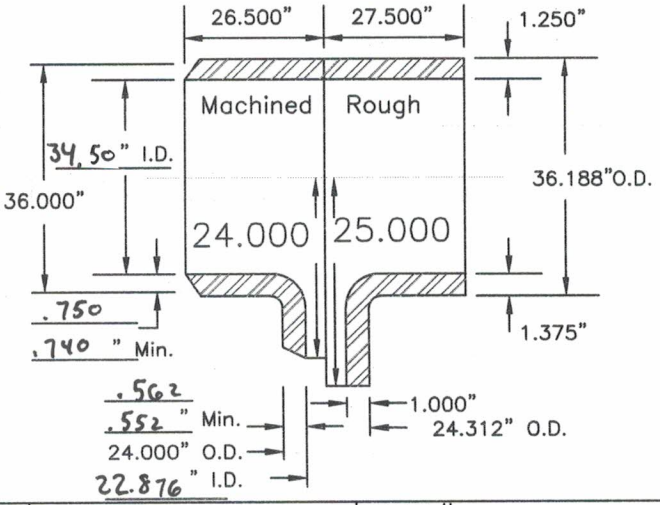
Preform Data:
Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50082 with 36x24" Insert #50082

1st Oper: Heat to 1650°F.–Quench in 28 inches of water.
Close dies to 5–1/2" and
Pull 12–1/2" 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 17–3/4" diameter plug (4" rod).

3th Oper: Re–heat to 1650°F.
Do not quench
Close dies hot and
Pull 22–1/4" plug (4" pull rod).



				DATE: 11–22–99	36" x 24" .750 x .562 HIGH YIELD TEE MFG. DATA	DWG# 36–24–3
				SCALE: NONE		
				DRAWN BY: J.D.		
				CHECKED BY: Bull		
REV	DESCRIPTION	BY	DATE			

Use for bevel thicknesses:
36" Run– .751" thru. .833".
24" Outlet– .750" and less.

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number 231756-08

Spectra Serial Number PO PUR-5020-2010480/16/AR-371

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

0.750

BORE RUN I.D. STRAIGHT TO: 33.750 + 1/4 -0 34.500

0.740

0.562

BORE OUTLET I.D. STRAIGHT TO: 22.376 + 1/8 -0 22.876

0.552

)N)

D

STAMP PER MSS-SP75-19 ON O.D. A MINIMUM OF 2" FROM BEVEL & WELD SEAM

SFI SERIAL NUMBER 231756-08

SPECTRA SERIAL NUMBER PO PUR-5020-2010480/16/AR-371

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