

Job Traveler

Job Number: 231756-10



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: 09/12/2023

Quote No: 20723

Customer: EDGEN119955

PO Num: RMS-300903

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-5020-2010480
LINE 18, AR-391PUR-5020-2010480
LINE 18, AR-392PUR-5020-2010480
LINE 18, AR-393

ES-PF1.14

Total Qty Open: 3 EA

Qty Posted: 0 EA

Qty To Make: 3

Start Date: 09/28/2023

Phone: 2,257,569,868

Contact: CLAIRE BLAY

Fax:

Job Notes

BCOR
B10864
CUT (3) @ 55" EACH FROM (2) 112" CYLINDERS

Routing

Routed By:

Quantity 3

Step No	Work Cntr / Vendor		Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Description	Time	Time	Time	Per Hour	Start	End	Quantity
10	FORGE 10	Cylinder Cut					09/28/2023	09/28/2023	3
	CYLINDER CUT	Cylinder Cut							



Job Number: 231756-10

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

Page 1 of 4

9/13

20	FORGE 8 TRIM	Torch Cut Cut hole	11/08/2023 11/08/2023	3
				
30	FORGE 12 FORM/PRESS	2000 Ton Press Forming	11/08/2023 11/09/2023	3
				
40	FORGE 8 TRIM	Torch Cut Trim	11/09/2023 11/09/2023	3
				
50	FORGE 7 HEAT TREAT	Heat Treat Heat treat	09/10/2024 09/11/2024	3
				
60	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	09/11/2024 09/11/2024	3
				
70	PIPE 13 X RAY	Pipe X Ray X-ray	09/11/2024 09/11/2024	3
				
80	E1 MACHINING	E1 Extender Expander	09/11/2024 09/11/2024	3
				
90	M1 MACHINING	M1 Big Mill Machining	09/11/2024 09/16/2024	3
				
150	STAMP 1 STAMP	Stamping	09/16/2024 09/16/2024	3
				

160

INSPECT 1
INSPECTION

Inspection 1

09/16/2024 09/16/2024

3



170

SHIPPING
SHIPPING

Shipping

09/16/2024 09/16/2024

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

<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>
168.00000	449.00000	168.00000	0.00000	EA	0PI3912552	NO	SFI

PIO 39-1.25-Y52

Quantities from Bins/Lot Number:

BCOR (56.0)

BCOR (112.0)

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCOR
36X16
.750X.500
WPHY70
231756-10

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

Hole size 3.50" hole

Technical drawing of a thick-walled cylinder cross-section. The outer diameter is labeled 39"OD. The inner diameter is labeled 4". The wall thickness is labeled 1.250".

Technical drawing of a rectangular plate. The overall width is 55.000". The overall height is 27.500". There are two vertical holes, each with a diameter of 6.12". The distance between the centerlines of the two holes is 27.500". The distance from the left edge to the centerline of the first hole is 13.750". The distance from the centerline of the second hole to the right edge is 13.750".

SHOP NOTE: Cut hole after barreling operations.

Ovaling Data: Oval: HOT Oval width: $35-3/4" \pm 1/4"$

Preform Data:

Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50082 with 36x18" Insert #50090

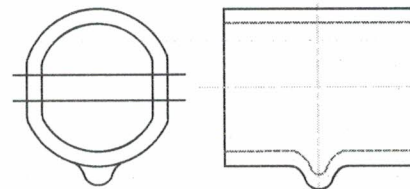
1st Oper: Heat to 1650°F. - Quench in 23-1/2" of water.
Barrel down HOT with HOT side up. Close dies to 3"

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. — Don not quench. Do not close dies pull 8-3/4" dia. plug (3" pull rod)

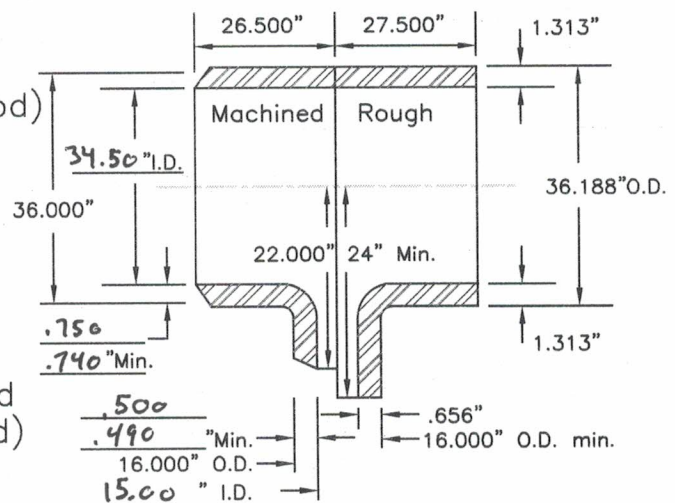


6th Oper: Heat to 1650°F.—Do not quench
Do not close dies and
Pull 10-3/4" dia. plug (3.5" pull rod)

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 _____ 231756-10 _____

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 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

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

SFI SERIAL NUMBER 231756-10

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