Job Traveler

Job Number: 231756-11

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: *3TE3016Y **Product Code:** TEE

Description: TE 30X16 .625 X .500-WPHY70

TAG: PUR-5020-2010480
LINE 19, AR-421

ES-PF1.14

Master Job No:

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

Start Date: 10/09/2023 **Phone:** 2,257,569,868

Contact: CLAIRE BLAY **Fax:**

Job Notes

BCLW
B10664
FROM ROUGH BLANKS
FORM AT PRESS

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 8 TRIM	Torch Cut Cut hole					10/09/2023	10/09/2023	1
20	FAB 2 PULL/JACK	Nozzle Pull Nozzle Pull or Jack					10/09/2023	10/09/2023	1

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

120	SHIPPING SHIPPING	Shipping		09/12/2024 09/12/2024	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**
1.00000	6.00000	1.00000	0.00000	EA	*2TE302-16XHY	YES	
					TE2 30X2-16-XH-ROUGH-HY Quantities from Bins/Lot Number: BCLW (1.0)		

Marking Information:

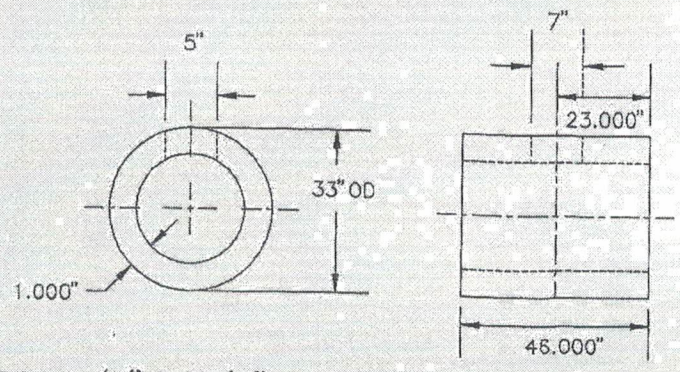
FLEET-LINE®
MADE IN USA
STEEL FORGINGS

BCLW
30X16
.625X.500
WPHY70
231756-11

30" Run Diameter = 30.476"
16" Outlet Diameter = 16.479"

Material Size 33" O.D. x 1.000"W
Length 46.000"

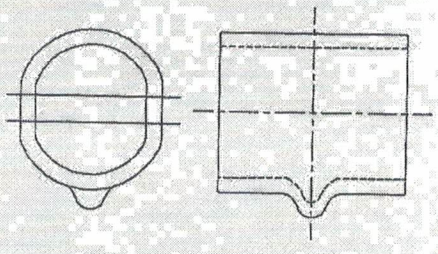
Hole size 5" x 7" Oval
Grind 1/8" radius on hole edges
I.D. & O.D.



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

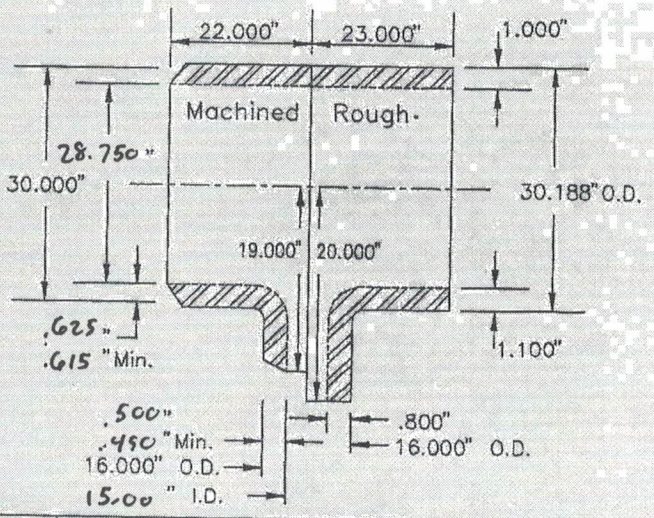
Preform Data:
Press: Machine 2000 Ton Set up#10138 Upper Die# 50037
Lower Die# 50084

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)



REV	DESCRIPTION	BY	DATE

DATE:
SCALE: NONE
DRAWN BY: J.DAVIDSON
CHECKED BY:

30" x 16"
(.625 x .500)

HIGH YIELD
TEE MFG. DATA

DWG#
30-16-2A

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number 231756-11

Spectra Serial Number PO PUR-5020-2010480/19/AR421

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 **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 231756-11

SPECTRA SERIAL NUMBER PO PUR-5020-2010480/19/AR421

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