

Job Traveler

Job Number: 231756-12



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: *3TE2416Y

Product Code: TEE

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

Master Job No:

TAG: PUR-5020-2010480
LINE 20, AR-441

PUR-5020-2010480
LINE 20, AR-442

PUR-5020-2010480
LINE 20, AR-443

PUR-5020-2010480
LINE 20, AR-444

PUR-5020-2010480
LINE 20, AR-445

ES-PF1.14

Total Qty Open: 5 EA

Qty Posted: 0 EA

Qty To Make: 5

Start Date: 09/28/2023

Phone: 2,257,569,868

Contact: CLAIRE BLAY

Fax:

Job Notes

BCLW
B10664
CUT (3) @ 36" EACH FROM 110" CYLINDER
USE (2) ADDITIONAL CYLINDERS AT 36" EACH

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					09/28/2023	09/28/2023	5
 									
10	FORGE 8 TRIM	Torch Cut Cut hole					11/08/2023	11/09/2023	5
 									
20	FORGE 12 FORM/PRESS	2000 Ton Press Forming					11/09/2023	11/09/2023	5
 									
30	FORGE 8 TRIM	Torch Cut Trim					11/09/2023	11/09/2023	5
 									
40	FORGE 7 HEAT TREAT	Heat Treat					09/11/2024	09/12/2024	5
 									
50	FORGE 5-6 FORGE BLAST	Forge Shotblast					09/12/2024	09/12/2024	5
 									
60	PIPE 13 X RAY	Pipe X Ray					09/12/2024	09/16/2024	5
 									
70	E1 MACHINING	E1 Extender					09/16/2024	09/16/2024	5
 									

Job Number: 231756-12

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



90

STAMP 1
STAMP

Stamping

09/18/2024 09/18/2024

5



100

INSPECT 1
INSPECTION

Inspection 1

09/18/2024 09/18/2024

5



110

SHIPPING
SHIPPING

Shipping

09/18/2024 09/18/2024

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
183.00000	403.00000	183.00000	0.00000	EA	0PI27152	NO	SFI
PI0 27-1-Y52							
Quantities from Bins/Lot Number:							
BCLW/222046-01 (37.0)							
BCLW/230055-02 (36.0)							
BCLW/230055-02 (110.0)							

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

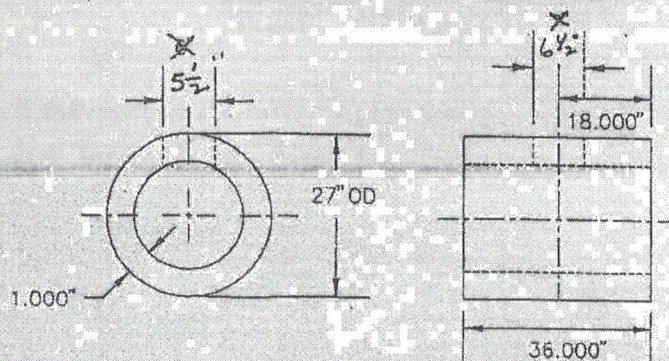
BCLW
24X16
.562X.500
WPHY65
231756-12

24" Run Diameter = 24.430"
 16" Outlet Diameter = 16.375"

Material Size 27" O.D. x 1.000" W
 Length 36.000"

Hole size $5\frac{1}{2} \times 6\frac{1}{2}$
 8×8

Grind $1/8$ " radius on hole edges
 I.D. & O.D.

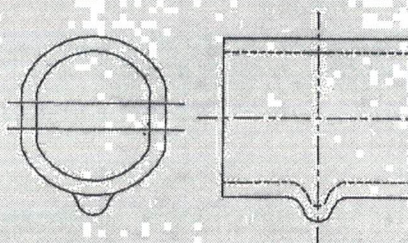


Ovaling Data: Oval: HOT Oval width: $23-3/4 \pm .1/4$ "

Preform Data:

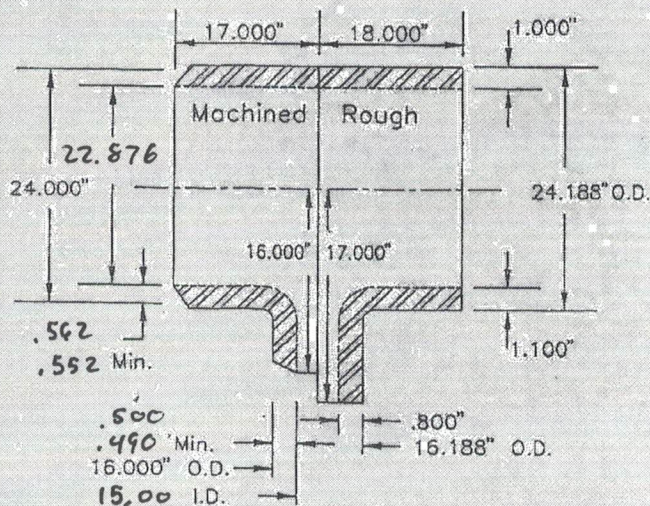
Press: Machine 2000 Ton Set up#10362 Upper Die# 50145
 Lower Die# 40308

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



2nd Oper: Re-heat to 1650°F.
 Quench in 15 " of water
 Close dies HOT to 1" &
 Pull $12-3/4$ " 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") HIGH YIELD TEE MFG. DATA	DWG#
				SCALE: NONE		24-16-2A
				DRAWN BY: J.DAVIDSON		
				CHECKED BY: EAS		
REV	DESCRIPTION	BY	DATE			

DOCUMENT PACKAGE

Fitting Description _____

SFI Serial Number _____

231756-12

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 231756-12

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