

Job Traveler

Job Number: 231768-05



Due Date: 12/21/2023

Sold SAGEBRUSH PIPELINE SUPPLY CO.
To: 8101 STATE HWY. 66
TULSA, OK 74131
United States

Ship SAGEBRUSH PIPELINE EQUIPMENT
To: 7640 W. 81ST STREET
TULSA, OK 74131
United States

Order No: 231768

Dated: 09/14/202

Quote No: 18391

Customer: SAGEBR357502

PO Num: 70044

Ship Via: KASEY.WAGNON@SAGEBRUSH

Priority: 3 - STANDARD

Part Number: *3ER4236Y

Product Code: ECCENTRIC REDUCER

Description: ER 42X36 1.00 X .875-
WPHY70

Master Job No:

THRU BORE

PRE-BORE OK
SEE ATTACHED DWG

MIN ID 33.223"

M8120

Total Qty Open: 5 EA

Qty Posted: 0 EA

Qty To Make: 5

Start Date: 10/25/2023

Phone: 918-551-5672

Contact: LES VANDEVER

Fax:

Job Notes

(3)BCNN
B10760
PIPE SHOP TRAVELER 326-2023

(2)BCLS
B10642
PIPE SHOP TRAVELER 327-2023; FULL PLATE ALLOCATED
DRAWING ATTACHED

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
10	PIPE 3 PLATE BURN	Burning Table Plate Burn					10/25/2023	10/25/2023	5
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					10/25/2023	10/25/2023	5



Job Number: 231768-05

Report Generated: 10/06/2023 1:14:02 PM

Page 1 of 5

30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	10/25/2023	10/25/2023	5
					
40	PIPE 7 STRING UP	Initial Weld String-up	10/26/2023	10/26/2023	5
					
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	10/26/2023	10/26/2023	5
					
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	10/26/2023	10/26/2023	5
					
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	10/26/2023	10/26/2023	5
					
80	PIPE 9 OD WELD	OD Weld OD Weld	11/01/2023	11/01/2023	5
					
90	PIPE 4 BIG ROLL	Big Roller Re-roll on large roller	11/01/2023	11/01/2023	5
					
100	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	11/06/2023	11/06/2023	5
					
110	FORGE 4 HAMMER	Large Hammer Hammer	11/08/2023	11/14/2023	5
					

120	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	08/05/2024	08/06/2024	5
					
130	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	08/06/2024	08/06/2024	5
					
140	PIPE 13 X RAY	Pipe X Ray X-ray weld	08/06/2024	08/07/2024	5
					
150	E1 MACHINING	E1 Extender Expander	08/07/2024	08/07/2024	5
					
160	M1 MACHINING	M1 Big Mill Machining	08/07/2024	08/12/2024	5
					
170	STAMP 1 STAMP	Stamping Stamping	08/12/2024	08/12/2024	5
					
180	INSPECT 1 INSPECTION	Inspection 1 Inspection	08/12/2024	08/12/2024	5
					
190	SHIPPING SHIPPING	Shipping Shipping	08/12/2024	08/12/2024	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
6,984.00000	772,907.00000	6,984.00000	0.00000	LB	0PL125633	NO SFI
				PL0 1.25-A633-E		
				Quantities from Bins/Lot Number:		
				BCNN-DROPS (3825.0)		
				BCLS-DROPS (3159.0)		

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCNN
42X36
1.00X.875
WPHY70
231768-05

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCLS
42X36
1.00X.875
WPHY70
231768-05

Pipe Shop Traveler Reducer Cyl.

326-2023

9/27/2023

☐ Pipe Shop Copy

☐ Pipe Shop Original

Customer	<u>SAGEBRUSH</u>			SFI Order No	<u>231768-05</u>	Due Date	<u>10/27/2023</u>	
Part	<u>42.000</u>	OD	X	<u>1.250</u>	X	<u>83.000</u>	Ship Date	<u>12/21/2023</u>
Plate Size	<u>1.250</u>		X	<u>128.020</u>	X	<u>83.000</u>	NoPcs	<u>1</u>
Heat No.	<u>R2886</u>					Code	<u>BCNN</u>	
Material	<u>A633E</u>			Test Material		Test No		

Cut 1 Plate(s) 1.250 X Thick X 128.020 Width X 83.000 Length 3767 Lbs.

Per Sketch # 6115

From (1) Plate(s) 1.250 Thick X 130.000 Wide X 105.000 Long

Stamp Plates With Heat Code

BCNN

Scarf to 128.020 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 42.000 " O.D.

Tack Weld Using 5/32 " Dia. E9018M Electrodes Per Procedure # SMAW-HSLA-132-REV. 1

Use Weld Procedure SAW-HSLA-101-REV. 11

Weld I.D. Using 3/16 " Dia. LINCOLN LA-85 Wire and LINCOLN 888 Flux.

Backgouge to Sound Metal and Condition Grind O.D. Weld Groove

Weld O.D. Using 3/16 " Dia. LINCOLN LA-85 Wire and LINCOLN 888 Flux.

Hot Reroll to Roundup

Torch Cut Into 3 Pcs @ 27 Inches

Paint Mark on Cylinder SAGEBRUSH

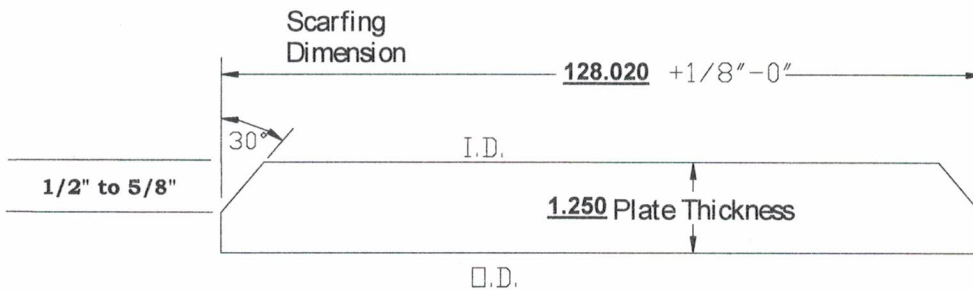
231768-05

Stamp Each Cylinder in (2) Places With Heat Code

BCNN

Fitting Description: (5)ER 42X36 Y70

Comments: RECORD NEW DROP SIZE



Pipe Shop Traveler Reducer Cyl.

327-2023

10/6/2023

☐ Pipe Shop Copy

☐ Pipe Shop Original

Customer	<u>SAGEBRUSH</u>			SFI Order No	<u>231768-05</u>	Due Date	<u>10/27/2023</u>	
Part	<u>42.000</u>	OD	X	<u>1.250</u>	X	<u>57.000</u>	Ship Date	<u>12/21/2023</u>
Plate Size	<u>1.250</u>		X	<u>128.020</u>	X	<u>57.000</u>	NoPcs	<u>1</u>
Heat No.	<u>R1852</u>					Code	<u>BCLS</u>	
Material	<u>A633E</u>			Test Material		Test No		

Cut 1 Plate(s) 1.250 X Thick X 128.020 Width X 57.000 Length 2587 Lbs.

Per Sketch # 6015

From (1) Plate(s) 1.250 Thick X 133.000 Wide X 67.000 Long

Stamp Plates With Heat Code

BCLS

Scarf to 128.020 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 42.000 " O.D.

Tack Weld Using 5/32 " Dia. E9018M Electrodes Per Procedure # SMAW-HSLA-132-REV. 1

Use Weld Procedure SAW-HSLA-101-REV. 11

Weld I.D. Using 3/16 " Dia. LINCOLN LA-85 Wire and LINCOLN 888 Flux.

Backgouge to Sound Metal and Condition Grind O.D. Weld Groove

Weld O.D. Using 3/16 " Dia. LINCOLN LA-85 Wire and LINCOLN 888 Flux.

Hot Reroll to Roundup

Torch Cut Into 2 Pcs @ 27 Inches

Paint Mark on Cylinder SAGEBRUSH

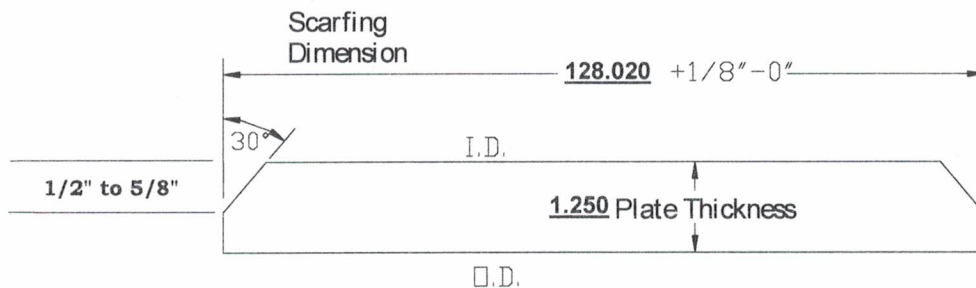
231768-05

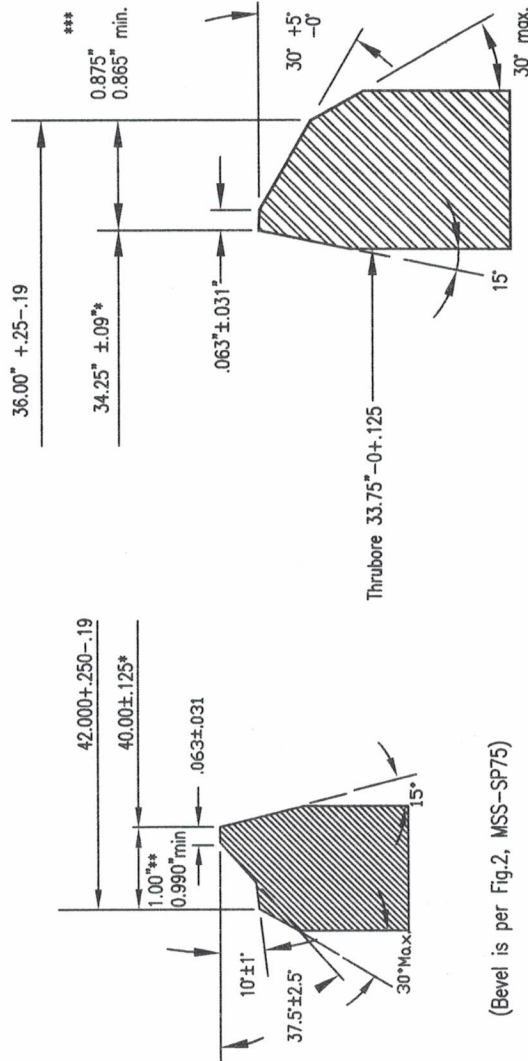
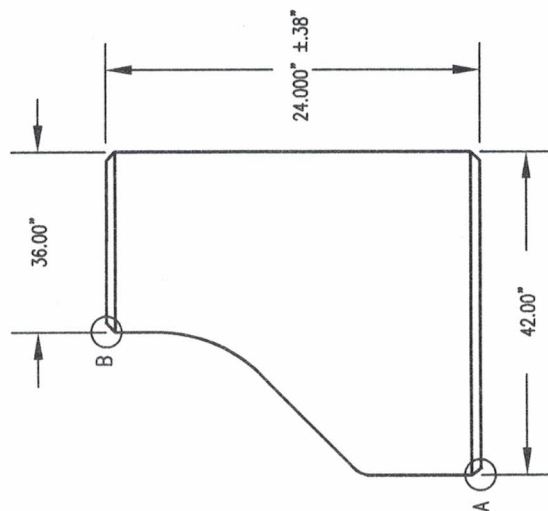
Stamp Each Cylinder in (2) Places With Heat Code

BCLS

Fitting Description: (5)ER 42X36 Y70

Comments: FULL PLATE ALLOCATED.





(Bevel is per Fig.2, MSS-SP75)

Detail A

Detail B

APPROVED

JWH

09/26/23

STEEL FORGINGS, INC.

*As measured by circumferential measurement.
 0.125" maximum out-of-round.
 ** A minimum wall of 0.935" is allowed in isolated non-continuous reductions in the 42" end.
 *** A minimum wall of 0.818" is allowed in isolated non-continuous reductions in the 36" end.

Company: SAGEBRUSH
 Spec.: M8120

PO# 70044
 Qty: 5

Description: 42"x36"-1.00"x.875"
 Eccentric Reducer - WPHY70

Date: 9/15/23
 SFI #: 231768-05

Drawing#: ER42x36
 Revision: 0

Drawn by:
 J. LOFDAHL

Appr'd:
 Scale: None

Rev.	Date	By	Revision

DO NOT USE GRADE C MATERIAL

FORM BY HAMMER

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# _____

100% RADIOGRAPH WELD SEAM PER SPEC. XL-RT-100 (LATEST REVISION) _____

SHOTBLAST TO NEAR WHITE FINISH

MACHINE PER MSS-SP75-19 EXCEPT ID TOLERANCE: ± 3/32

36 in. (SMALL) END-STRAIGHT BORE I.D. TO 33.75 +1/8 -0 **COMPOUND BEVEL BIG END**
(FACE, TAPER BORE, AND BEVEL)

OUT OF ROUNDNESS 1/8" MAX

MIN. WALL AT BEVEL NO LESS THAN .010" UNDER NOMINAL

STAMP PER MSS-SP75-19

CUSTOMER INSPECTION REQUIRED

(1 EACH HEAT)

RANDOM HARDNESS TEST (30%): 2 PCS (BASE, WELD, HAZ); 240 BHN MAX

PC	B _____	W _____	H _____	B _____	W _____	H _____
	B _____	W _____	H _____	B _____	W _____	H _____

PAINT MARK ON ID (6" FROM ONE END) _____

COAT OD SURFACES ONLY AFTER INSPECTION

PACKAGING - PROVIDE SUITABLE END PROTECTION, 16" AND LARGER REQUIRES END PROTECTION AND 1 PC PER PALLET

BASE CHARPY 50% SHEAR MIN.

WELD CHARPY 20/15 MIN.

VANADIUM .025% MIN.

PE OR ME BEVELS IF STATED ON PO

RANDOM B,W,H HARDNESS

CE .45 MAX; STAMP CE IF >.42

M8110 - 55K TENSILE MAX

S:\PUBLIC\TAVELER\Kinder Morgan M8120\KM TRAVELERS.XLSX