

Job Traveler

Job Number: 231826-01

Due Date: 11/29/2023



Sold To: MRC GLOBAL (US), INC
ATTN: INVOICE AUDITING DEPT
P.O. BOX 513
CHARLESTON, WV 25322

Ship To: ATMOS ENERGY
WILL ADVISE SHIP TO ADDRESS
SPEC PROJ GRAND PRAIRIE
180.49854 - MLV
Corsicana, TX 75110
United States

Order No: 231826

Dated: 09/25/2023

Quote No: 20980

Customer: MRC GL257952

PO Num: C0132627155D0

Ship Via: FERNANDO.GARCIA@MRCGLOE

Priority: 3 - STANDARD

Part Number: *3TE3616Y

Product Code: TEE

Description: TE 36X16 .750 X .375-
WPHY65

Master Job No:

W/ BARS

MSSSP75-14

Total Qty Open: 16 EA

Qty Posted: 0 EA

Qty To Make: 16

Start Date: 09/25/2023

Phone: 3,043,485,211

Contact: FERNANDO GARCIA

Fax:

Job Notes

BCOR
B10865
PIPE SHOP TRAVELER 319-2023
CUT (16) PCS 55" FROM (8)112" LONG PCS

Routing

Routed By:

Quantity 16

Step No	Work Cntr / Vendor	Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Time	Time	Time	Per Hour	Start	End	Quantity
10	PIPE 3 PLATE BURN					09/25/2023	09/25/2023	16
	Burning Table Plate Burn							



20	PIPE 6 FURNACE HEAT					09/25/2023	09/26/2023	16
	Pipe Furnace Furnace heating							



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JD 9/26

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30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	09/26/2023 09/26/2023	16
				
40	PIPE 7 STRING UP	Initial Weld String-up	09/26/2023 09/26/2023	16
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	09/26/2023 09/26/2023	16
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	09/26/2023 09/26/2023	16
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	09/26/2023 09/26/2023	16
				
80	PIPE 9 OD WELD	OD Weld OD Weld	09/27/2023 09/27/2023	16
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	10/02/2023 10/03/2023	16
				
100	FORGE 8 TRIM	Torch Cut Cut hole	10/05/2023 10/09/2023	16
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	10/09/2023 10/09/2023	16
				

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120	FORGE 8 TRIM	Torch Cut Trim	10/10/2023 10/12/2023	16
				
130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	09/04/2024 09/10/2024	16
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	09/10/2024 09/12/2024	16
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	09/12/2024 09/12/2024	16
				
160	E1 MACHINING	E1 Extender Expander	09/12/2024 09/16/2024	16
				
170	M1 MACHINING	M1 Big Mill Machining	09/16/2024 09/26/2024	16
				
180	PIPE 11	Special Welds Bars	09/26/2024 10/24/2024	16
				
190	FAB 8 GRINDING	Fab Grind Grinding Bars	10/24/2024 10/30/2024	16
				
200	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	10/30/2024 11/04/2024	16
				

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210	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	11/04/2024 11/05/2024	16
				
220	PIPE 13 X RAY	Pipe X Ray ME inspection of weld	11/05/2024 11/06/2024	16
				
230	STAMP 1 STAMP	Stamping	11/06/2024 11/06/2024	16
				
240	INSPECT 1 INSPECTION	Inspection 1	11/06/2024 11/06/2024	16
				
250	SHIPPING SHIPPING	Shipping	11/06/2024 11/06/2024	16
				

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: 16	
Needed	On Hand	Posted	Short	Unit	Description
42,465.00000	831,317.00000	42,465.00000	0.00000	LB	0PL125633
PL0 1.25-A633-E Quantities from Bins/Lot Number: BCOR-08 (15945.0) BCOR-09 (10575.0) BCOR-07 (15945.0)					
				Sub- Assy	Vendor
				NO	CLIFF STEEL

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCOR
36X16
.750X.375
WPHY65
231826-01

Pipe Shop Traveler Tee Cyl.

319-2023

9/25/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>MRC</u>	SFI Order No	<u>231826-01</u>	Due Date	<u>10/20/2023</u>
Part	<u>39.000</u> OD X <u>1.250</u> X <u>112.000</u>	Ship Date	<u>11/29/2023</u>	NoPcs	<u>8</u>
Plate Size	<u>1.250</u> X <u>118.595</u> X <u>112.000</u>	Code	<u>BCOR-07, 08, 09</u>	Test No	<u>10865</u>
Heat No.	<u>R3380</u>				
Material	<u>A633E</u>	Test Material	<u>CUT (2)6X12 FOR 12X12</u>		

Cut 8 Plate(s) 1.250 X Thick X 118.595 Width X 112.000 Length 4709 Lbs.

Per Sketch #

From (3) Plate(s) 1.250 Thick X 132.000 Wide X 346.000 Long

Stamp Plates With Heat Code BCOR-07, 08, 09

Scarf to 118.595 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 39.000 " 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

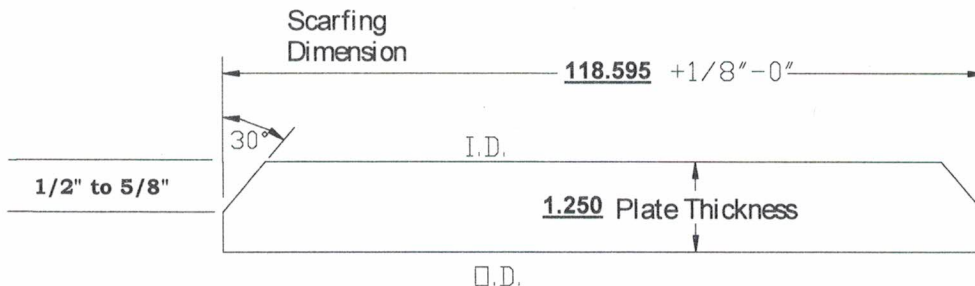
Torch Cut Into 2 Pcs @ 55 Inches

Paint Mark on Cylinder MRC 231826-01

Stamp Each Cylinder in (2) Places With Heat Code BCOR-07, 08, 09

Fitting Description: (16) TEE 36X16

Comments:



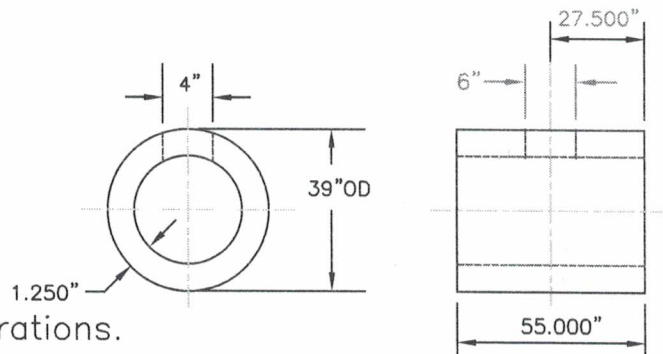
36" Run Diameter = 36.542"

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

Material Size 39" O.D. x 1.250"W
Length 55.000"

Hole size 3.50" hole

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



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"

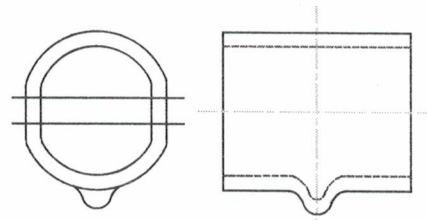
2nd Oper: Re-heat to 1650°F.

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

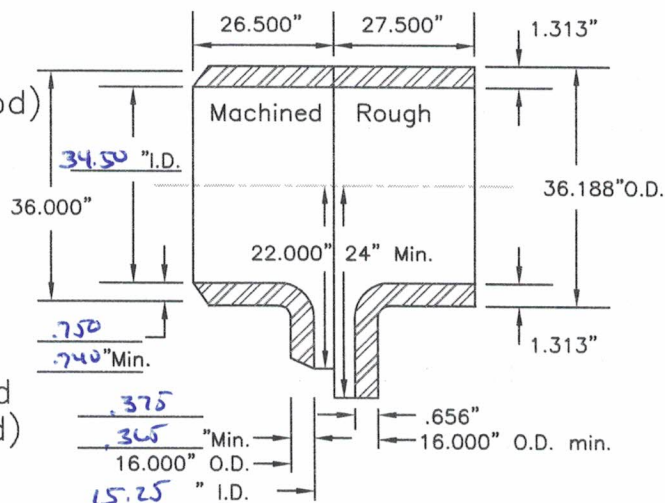


6th Oper: Heat to 1650°F.—Do not quench
Do not close dies and
Pull 10-3/4" dia. plug (3.5" pull rod)

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.



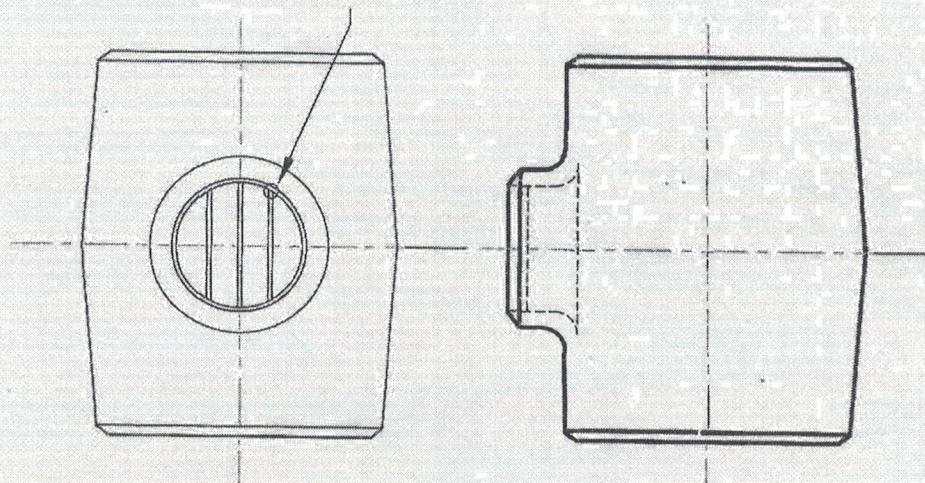
				DATE: 11-19-99
				SCALE: NONE
				DRAWN BY: J.D.
2	added extra pins for manual pull	JL	10/11/16	CHECKED BY: Bull
1	changed outlet height	JL	9/9/15	
REV	DESCRIPTION	BY	DATE	

36" x 16"
.750 x .375
HIGH YIELD
TEE MFG. DATA

DWG#
36-16-5
Use for bevel thicknesses:
36: Run— .751" thru .833"
16" Outlet— .593" and less.

Notes:

Bottom of scraper bars to have corners broken smooth with no burrs or sharp edges.
 Bottom of scraper bars to be flush with inside radius of tee.
 Scraper bars to be made from carbon steel having a minimum yield of 36,000 PSI and are to be welded to the inside surface of tee outlet by means of a continuous full fusion weld along contact area.
 Bars shall be beveled to fit inside contour of contact surface. Scraper bar welds to be wet magnetic particle examined.
 PWHT of tees will occur after bars installed. Stress Relieving temperature may be the same as tempering temperature if mechanical test results satisfy specification requirements.
 Weld to be a continuous weld completely around all sides of bar with 3/8" fillets.



SCRAPER BAR DATA

Outlet Size	# of Bars	Pit Thk	Width
4	1	1/2	1-3/4
6	1	1/2	2
8	1	1/2	2-1/2
10	2	1/2	3
12	2	1/2	3
14	3	1/2	3
16	3	1/2	3
18	3	1/2	3
20	3	1/2	3
24	3	1/2	3
26	3	3/4	3
30	3	3/4	3
36	3	3/4	3
42	4	1	4
48	4	1	4

STEEL FORGINGS, INC.

SCRAPER BARS FOR STRAIGHT AND REDUCING BUTT WELDING TEES		Date: 5/9/03	Scale: None
Drawing#: 122890	Drawn by: J. Lofdahl	Appr'd:	
Revision: 3			

Rev.	Date	By	Revision
3	5/9/03	JL	Revised PWHT note
2	8/6/96	JD	Revised Sections A-A

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# _____

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

INSTALL 3 1/2 " THICK X 3 " WIDE SCRAPER BARS PER SFI DWG 122890 REV.3 (ATTACHED) PER WPS FCAW-CS/HSLA-131 R.0
PER WPS FCAW-CS-HSLA-131 (LATEST REV.)

INSPECTOR TO SIGN OFF ON BARS AFTER THEY ARE FIT-UP _____

INSPECTOR TO SIGN OFF ON BARS AFTER THEY ARE GROUND _____

**MAG PARTICLE EXAMINE SCRAPER BAR WELDS PER SPEC. XL-MT-100 (LATEST REVISION), ACCEPTANCE CRITERIA
MORE STRINGENT OF E709 AND/OR CUSTOMER SPECIFICATION** _____

HEAT TREATMENT PER QCP 8.1 REV.1: **STRESS RELIEVE** 1 1/4 HR @ 1100 °F - AIR COOL - FURNACE LOAD # _____

SHOTBLAST TO NEAR WHITE FINISH

MACHINE AFTER STRESS RELIEVE

MACHINE PER MSS-SP75-14

BORE RUN I.D. STRAIGHT TO: 33.750 + 1/4 -0 34.500
0.750
0.740

BORE OUTLET I.D. STRAIGHT TO: 14.750 + 1/8 -0 15.250
0.375
0.365

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE