

Job Traveler

Job Number: 232086-01



Due Date: 01/22/2024

Sold To: MAVERICK INTERNATIONAL
P.O. BOX 1994
WINNIE, TX 77665
United States

Ship To: MAVERICK INTERNATIONAL
18291 ENGLIN RD
JERROD WRIGHT 409- 656-2320
Hamshire, TX 77622
United States

Order No: 232086**Dated:** 11/10/2023**Quote No:** 21852**Customer:** MAVERI255587**PO Num:** 4039430**Ship Via:** PPD & CHARGE**Priority:** 3 - STANDARD**Part Number:** *3TE3012Y**Product Code:** TEE**Description:** TE 30X12 .750 X .500-
WPHY70**Master Job No:**

MSSSP75-19

Total Qty Open: 10 EA**Qty Posted:** 0 EA**Qty To Make:** 10**Start Date:** 11/15/2023**Phone:** 409-833-7878**Contact:** JERRY NELSON JR.**Fax:**

Job Notes

(7)BCJI
B10849
PIPE SHOP TRAVELERS 375,376-2023; FULL PLATES ALLOCATED

(3)BCKV
B10579
PIPE SHOP TRAVELER 377-2023; RECORD NEW DROP SIZE

Routing

Routed By:**Quantity 10**

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					11/15/2023	11/15/2023	10
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					11/16/2023	11/20/2023	10



Job Number: 232086-01

Report Generated: 11/10/2023 11:23:04 AM

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30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	11/20/2023	11/20/2023	10
					
40	PIPE 7 STRING UP	Initial Weld String-up	11/20/2023	11/20/2023	10
					
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	11/21/2023	11/21/2023	10
					
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	11/21/2023	11/21/2023	10
					
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	11/22/2023	11/22/2023	10
					
80	PIPE 9 OD WELD	OD Weld OD Weld	11/22/2023	11/22/2023	10
					
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	11/22/2023	11/23/2023	10
					
100	FORGE 8 TRIM	Torch Cut Cut hole	11/29/2023	11/29/2023	10
					
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	11/29/2023	11/29/2023	10
					

120	FORGE 8 TRIM	Torch Cut Trim	11/29/2023 11/30/2023	10
				
130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	07/03/2024 07/08/2024	10
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	07/08/2024 07/09/2024	10
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	07/09/2024 07/10/2024	10
				
160	E1 MACHINING	E1 Extender Expander	07/10/2024 07/10/2024	10
				
170	M1 MACHINING	M1 Big Mill Machining	07/10/2024 07/18/2024	10
				
180	STAMP 1 STAMP	Stamping	07/18/2024 07/18/2024	10
				
190	INSPECT 1 INSPECTION	Inspection 1	07/18/2024 07/18/2024	10
				



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: 10	
Needed	On Hand	Posted	Short	Unit	Description
18,168.00000	769,064.00000	18,168.00000	0.00000	LB	0PL125633
					PL0 1.25-A633-E
					Quantities from Bins/Lot Number:
					BCKV-05 (5311.0)
					BCJI-12 (10848.0)
					BCJI (2009.0)

Sub-
Assy

NO

Vendor

CLIFF
STEEL

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCJI
30X12
.750X.500
WPHY70
232086-01

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCKV
30X12
.750X.500
WPHY70
232086-01

Pipe Shop Traveler Tee Cyl.

375-2023

11/10/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>MAVERICK</u>				SFI Order No	<u>232086-01</u>	Due Date	<u>12/1/2023</u>
Part	<u>33.000</u>	OD	X	<u>1.250</u>	X	<u>140.000</u>	Ship Date	<u>1/22/2024</u>
Plate Size	<u>1.250</u>		X	<u>99.746</u>	X	<u>140.000</u>	NoPcs	<u>2</u>
Heat No.	<u>R0172</u>						Code	<u>BCJI-12</u>
Material	<u>A633E</u>		Test Material				Test No	

Cut **2** Plate(s) **1.250** X Thick X **99.746** Width X **140.000** Length **4950** Lbs.

Per Sketch #

From (**1**) Plate(s) **1.250** Thick X **107.000** Wide X **286.000** Long

Stamp Plates With Heat Code **BCJI-12**

Scarf to **99.746** + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To **33.000** " 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

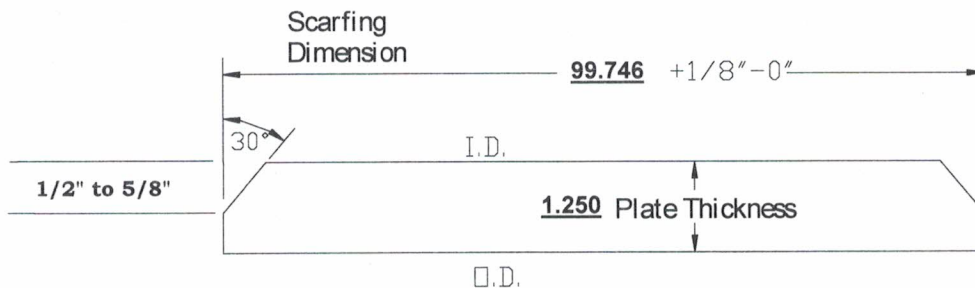
Torch Cut Into **6** Pcs @ **46** Inches

Paint Mark on Cylinder **MAVERICK** **232086-01**

Stamp Each Cylinder in (2) Places With Heat Code **BCJI-12**

Fitting Description: **(10)TE 30X12 Y70**

Comments: **FULL PLATE ALLOCATED**



Pipe Shop Traveler Tee Cyl.

376-2023

11/10/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	MAVERICK			SFI Order No	232086-01	Due Date	12/1/2023	
Part	33.000	OD	X	1.250	X	48.000	Ship Date	1/22/2024
Plate Size	1.250		X	99.746	X	48.000	NoPcs	1
Heat No.	R0172						Code	BCJI
Material	A633E			Test Material		Test No		

Cut 1 Plate(s) 1.250 X Thick X 99.746 Width X 48.000 Length 1697 Lbs.

Per Sketch # 5883

From (1) Plate(s) 1.250 Thick X 109.000 Wide X 52.000 Long

Stamp Plates With Heat Code BCJI

Scarf to 99.746 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 33.000 " 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

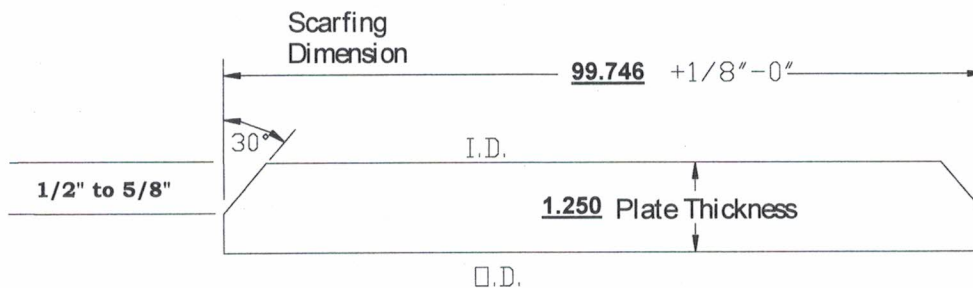
Torch Cut Into 1 Pcs @ 46 Inches

Paint Mark on Cylinder MAVERICK 232086-01

Stamp Each Cylinder in (2) Places With Heat Code BCJI

Fitting Description: (10)TE 30X12 Y70

Comments: FULL PLATE ALLOCATED



Pipe Shop Traveler Tee Cyl.

377-2023

11/10/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>MAVERICK</u>			SFI Order No	<u>232086-01</u>	Due Date	<u>12/1/2023</u>	
Part	<u>33.000</u>	OD	X	<u>1.250</u>	X	<u>140.000</u>	Ship Date	<u>1/22/2024</u>
Plate Size	<u>1.250</u>		X	<u>99.746</u>	X	<u>140.000</u>	NoPcs	<u>1</u>
Heat No.	<u>R1537</u>						Code	<u>BCKV-05</u>
Material	<u>A633E</u>		Test Material			Test No		

Cut **1** Plate(s) **1.250** X Thick X **99.746** Width X **140.000** Length **4950** Lbs.

Per Sketch #

From (**1**) Plate(s) **1.250** Thick X **107.000** Wide X **290.000** Long

Stamp Plates With Heat Code

BCKV-05

Scarf to **99.746** + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To **33.000** " 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 @ **46** Inches

Paint Mark on Cylinder **MAVERICK**

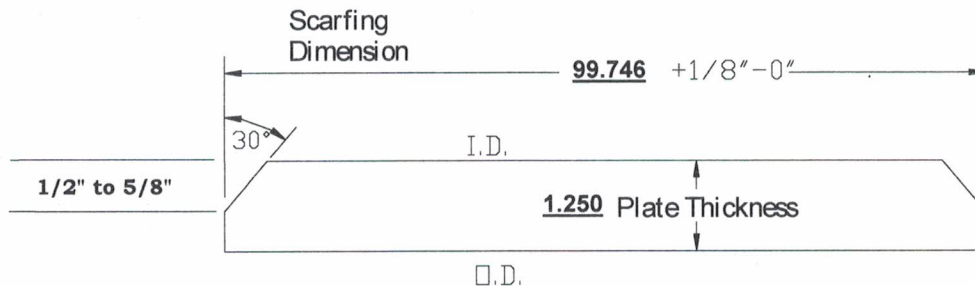
232086-01

Stamp Each Cylinder in (2) Places With Heat Code

BCKV-05

Fitting Description: **(10)TE 30X12 Y70**

Comments: **107X140 ALLOCATED; RECORD NEW DROP SIZE**

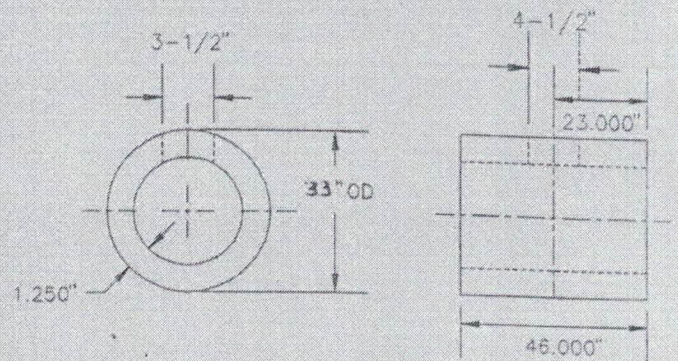


30" Run Diameter = 30.476"

12" Outlet Diameter = 13.125"

Material Size **33"** O.D. x 1.250" W
Length 46.000"

Hole size 3-1/2" x 4-1/2" Oval
Grind 1/8" radius on hole edges
I.D. & O.D.

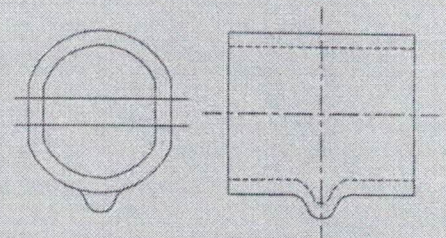


Ovaling Data: Oval: HOT Oval width: 29-1/2" ± .1/4"

Preform Data:

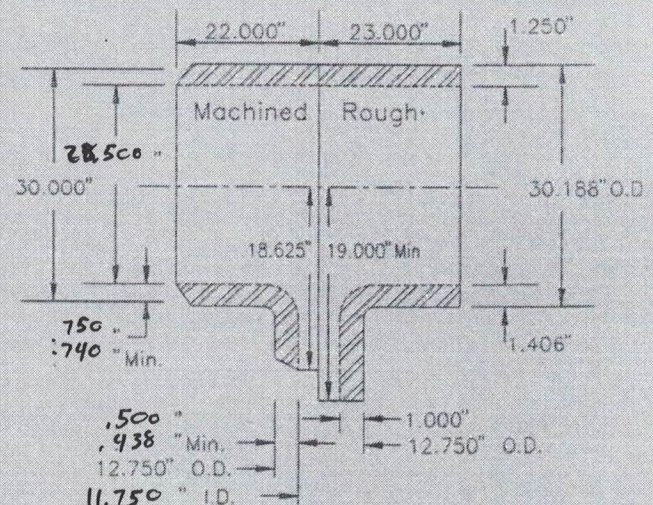
Press: Machine 2000 Ton Set up# 10138 Upper Die# 50037
Lower Die# 50086 (with 12" insert)

1st Oper: Heat to 1650°F
Quench in 23-1/2" of water
Close dies to 6" &
Pull 6" plug(3" rod)



2nd Oper: Re-heat to 1650°F
Quench in 21" of water
Close dies to 3-1/2" &
Pull 8-1/2" plug(3-1/2" rod)

3rd Oper: Re-heat to 1650°F
Quench in 18-1/2" of water
Close dies HOT to 1" &
Pull 11-1/2" plug(4" rod)



Final Oper: Re-heat to 1650°F
Do not quench
Close dies HOT &
Re-pull 11-1/2" plug(4" rod)

				DATE:	30" x 12" (.750 x .500)	DWG# 30-12-5A
				SCALE: NONE		
				DRAWN BY: J.DAVIDSON		
				CHECKED BY:		
REV	DESCRIPTION	BY	DATE		HIGH YIELD TEE MFG. DATA	

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# _____

SHOTBLAST TO NEAR WHITE FINISH

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

MACHINE PER MSS-SP75-19

BORE RUN I.D. STRAIGHT TO: 27.750 + 1/4 -0 28.500
0.750
0.740

BORE OUTLET I.D. STRAIGHT TO: 11.500 ± 1/16 11.750
0.500
0.438

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE