

Job Traveler

Job Number: 232089-01



Due Date: 01/12/2024

Sold CTAP, LLC
To: 2585 TRAILRIDGE DR EAST
LAFAYETTE, CO 80026

Ship To: , CO
United States

Order No: 232089

Dated: 11/13/2023

Quote No: 21341

Customer: CTAP

PO Num: 163087

Ship Via: MDUTA@CTAPLLC.COM

Priority: 3 - STANDARD

Part Number: *3CP24XHY

Product Code: CAP

Description: CP 24 .562-WPHY52

Master Job No:

✖ W/ LIFTING LUG PER SP- 4210

DWG ATTACHED

✖

ES-PF1.14

Total Qty Open: 6 EA

Qty Posted: 0 EA

Qty To Make: 6

Start Date: 11/16/2023

Phone: 303-661-9475

Contact: MIKE COPESEY

Fax:

Job Notes

BCLH
B10613
FROM LOT 231515-02 IN PROCESS. **DO NOT HEAT TREAT WITH STOCK ORDER.**
TAKE CAPS TO FAB SHOP AFTER FORMING.
LIFTING LUGS TO BE INSTALLED BY FAB SHOP BEFORE HEAT TREATING

Routing

Routed By:

		Quantity 6							
Step No	Work Cntr / Vendor		Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Description	Time	Time	Time	Per Hour	Start	End	Quantity
10	FAB 4	Welding Station # 1					11/16/2023	11/20/2023	6
	TACK/ASSEM 1	Weld Lifting Lugs							
20	FORGE 7	Heat Treat					01/11/2024	01/15/2024	6
	HEAT TREAT	Heat treat							



40

M3
MACHINING

M3 Mill
Machining

01/15/2024 01/15/2024

6



50

STAMP 1
STAMP

Stamping

01/15/2024 01/15/2024

6



60

INSPECT 1
INSPECTION

Inspection 1

01/15/2024 01/15/2024

6



70

SHIPPING
SHIPPING

Shipping

01/15/2024 01/15/2024

6



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: 6	
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>	<u>Unit</u>	<u>Description</u>	<u>Sub- Assy</u> <u>Vendor</u>

Marking Information:



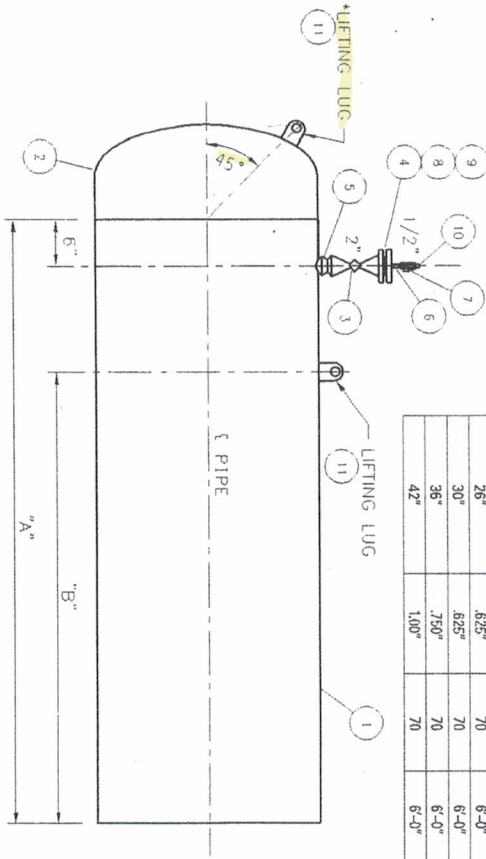
FLEET-LINE

MADE IN USA
STEEL FORGINGS

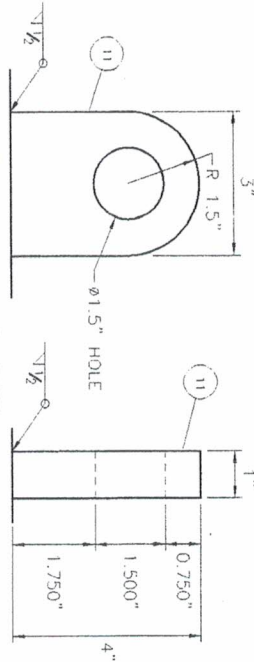
BCLH
24 - .562
WPHY52
PUR-1520-2001648
232089-01

ISOLATION CAP DIMENSION SCHEDULE

CAP SIZE	W.T.	YIELD (KSI)	DM. "A"	DM. "B"
10"	.500"	42	4'-0"	2'-4 1/2"
12"	.500"	52	4'-0"	2'-4 1/2"
16"	.500"	60	4'-0"	2'-6"
20"	.500"	65	5'-0"	3'-0"
22"	.562"	65	5'-0"	3'-2"
24"	.562"	70	5'-0"	3'-4"
26"	.625"	70	6'-0"	3'-6"
30"	.625"	70	6'-0"	3'-8"
36"	.750"	70	6'-0"	3'-9"
42"	1.00"	70	6'-0"	3'-10"



ISOLATION CAP FABRICATION DETAIL



LIFTING LUG DETAIL

*CAP MOUNTED LIFTING LUG TO BE USED ON DIAMETERS 20" AND LARGER.
16" AND SMALLER WILL UTILIZE A SINGLE PIPE MOUNTED LIFTING LUG.

BILL OF MATERIAL

ITEM #	QTY	SIZE	DESCRIPTION
1	1	XX	PIPE API 5L, PS2, BARE, SAWL, SMLS /HRW (SEE ISOLATION CAP SCHEDULE FOR W.T. AND YIELD)
2	1	XX	CAP PIPE, BW, CS, ASME B16.9, ES-PT2.2 OR ES-PT1.8 (SEE ISOLATION CAP SCHEDULE FOR W.T. AND YIELD)
3	1	2"	VALVE, PLUG, ANSI 600, WEAFF, BTM 0.218" W.T., OR, B
4	1	2"	FLANGE, BLIND, ANSI 600, RF, CS, A105, ASME/ANSI B16.5, C. D. & T. 1/2" N.P.T.
5	1	2"	WELDLET, X.S., SCH. 80, F.S., X"-X"
6	1	1/2"	NIPPLE, 1/2" x 3" LG., T.B.E., SCH. 80, C.S., A106, GR. B, A723
7	1	1/2"	VALVE, BALL, 3000# W.P., FNPT, C.S., 316SS, BALL & STEM, STD. THM, W/VITON SEATS, MSS SP-94
8	1	2"	GASKET, SPIRAL WOUND, 1/2" THK., STYLE FLEXITALL, COI, ANSI 600, INNER MATERIAL: 304SS, FILLER MATERIAL: FLEXIBLE GRAPHITE, OUTER MATERIAL: C.S. WITH INNER BACKING RING
9	8	1/2" x 4 3/4"	BOLT, STUDS, ALLOY STEEL, CONT. THREADS, ASTM-A193, GRADE B-7, TEFION COATED, CW, 2 FOR 2" ANSI 600 FLANGE (8 BOLTS PER SET)
10	1	1/2"	BOLT, PLUG, SOLID HEX HEAD, 3000# F.S., SCRD., ASME B16.11
11	XX	1/2"	LIFTING LUG, 1" THK, STEEL, ASTM A36, SEE DETAIL BELOW FOR QUANTITY AND DIMENSIONING

GENERAL NOTES:

1. ALL WELD AREAS SHALL BE PREHEATED TO A MINIMUM OF 250° F. PRIOR TO WELDING.
2. FABRICATION SHALL BE SANDBLASTED TO A "COMMERCIAL BLAST" IN ACCORDANCE WITH NACE STANDARD TM-01-70. THE MATERIAL SHALL BE PRIMED WITH VALSPAR 13-R-50 AND PAINTED WITH VALSPAR 19-Y-12 MEDIUM YELLOW. MINIMUM WET FILM THICKNESS: 3 - 3.5 MILS.
3. FABRICATIONS SHALL ALSO BE PAINT STENCILED AND TAGGED PER THE QUALITY CONTROL INSPECTOR.
4. ALL WELDS SHALL BE IDENTIFIED ON A WELDERS' MAP. THE MANUFACTURER'S NAME AND THE HEAT NUMBER SHALL BE IDENTIFIED ON ALL X-GRADE MATERIAL.
5. STENCILING WELDS WITH A WELDERS IDENTIFICATION STAMP SHALL NOT BE PERMITTED.
6. ALL WELDING SHALL BE IN ACCORDANCE WITH ASME BOILER AND PRESSURE VESSEL CODE SEC VIII, DIV 1, LATEST DOT APPROVED EDITION OR PER API-1104, LATEST DOT APPROVED EDITION.
7. ALL WELDS SHALL BE RADIOGRAPHED AND INTERPRETED IN ACCORDANCE WITH API 1104, LATEST DOT APPROVED EDITION. WELDS THAT CANNOT PRODUCE LEGIBLE RADIOGRAPHS SHALL BE TESTED BY THE DYE PENETRATE OR MAGNETIC PARTICLE INSPECTION METHODS.
8. ALL WELDMENTS SHALL HAVE A 100% PENETRATION WELD.
9. LONGITUDINAL SEAM ON PIPE SHALL BE LOCATED AT THE 4 O'CLOCK POSITION. (NOTE 2" BLEEDER @ 12 O'CLOCK)
10. FABRICATOR SHALL PROVIDE "SPECTRA ENERGY" WITH COPIES OF THE WELDING PROCEDURE (WPS) AND QUALIFICATION RECORDS (PQR) FOR ALL WELDS FOR APPROVAL PRIOR TO FABRICATION.
11. SPECTRA ENERGY SHALL BE NOTIFIED 72 HOURS PRIOR TO ANY FABRICATION.
12. ISOLATION CAPS SHALL BE STORED AND SHIPPED WITH THE BLIND FLANGES BOLTED TO THE RFFE VALVES AND HEX-HEAD PLUGS THREADED INTO THE THREADED VALVES.
13. HYDROSTATIC TESTING: 8 HOURS @ 2220 PSIG (+25, -0 PSI) MINIMUM. PROVIDE HYDROSTATIC TEST CHARTS.
14. ALL MATERIAL MUST MEET A 1480 PSIG/ANSI 600 DESIGN RATING WITH A 0.5 DESIGN FACTOR.
15. ALL PURCHASED MATERIAL MUST MEET COMPANY SPECS AND BE ON THE APPROVED MANUFACTURERS LIST.
16. ALL WELDS ON LUG TO PIPE NEED TO BE AT LEAST 3" CONTINUOUS LENGTH TO PROVIDE SUFFICIENT HEAT INPUT TO ACHIEVE ACCEPTABLE METALLURGICAL HARDNESS LEVELS.

ISOLATION CAP

DESIGN MANAGER	RWG	10-4	STANDARDS
INITIALS	DATE	DWC.	SP-4210
			REV. 4

DOCUMENT PACKAGE

Fitting Description (G) CAP 24- .562 Y52

SFI Serial Number 232089 - C1

Spectra S/N PO PUR-1520-2001648 / /

ME inspection report

MTR's

Inspection sheet with actual dimensions

Heat Treat charts

Furnace Uniformity & Quarterly Recorder Calibration records

DIMENSIONAL INSPECTION SHEET FOR CAP

Does stamping match traveler? _____

What is actual bevel thickness? _____

What is the height of the cap? _____

What is actual ID of cap at bevel?
(check two places) _____

Is bevel $30^{\circ}+5^{\circ}/-0^{\circ}$? _____

SFI S/N stamped on it? _____

Spectra S/N stamped on it? _____

Have all areas needing cosmetic
grinding been marked? _____

FORM BY PRESS

IF ORDER SIZE IS LARGER THAN FURNACE LOAD, SERIALIZE UNDER CUTTER STAMP PRIOR TO HEAT TREAT
HEAT TREATMENT PER QCP 8.1 REV. 1

NORMALIZE (1/2 HR) @ 1650°F AIR COOL - ~~WATER QUENCH~~ FURNACE LOAD # _____
~~TEMPER (_____ HR) @ _____ °F AIR COOL FURNACE LOAD # _____~~
Use furnace #1 or 2 only

IF ~~QUENCH AND TEMPERED~~ RECORD THE FOLLOWING
TIME FROM FURNACE TO QUENCH TANK _____
TEMPERATURE OF QUENCH TANK _____

SHOTBLAST TO NEAR WHITE METAL FINISH

DO NOT MACHINE UNTIL TESTING COMPLETE.

MACHINE PER MSS-SP-75-19: EXCEPT 14 DEG. MIN. 18 DEG. MAX INTERNAL TAPER

STAMP PER MSS-SP-75-19 ON O.D. A MINIMUM OF 2" FROM BEVEL

SPECTRA S/N POUR-1520-2001648 / _____ / 01,02,... 06

SFI SERIAL NUMBER 232089 - 01

HARDNESS TEST (235 MAX BHN) EACH PIECE: _____

PAINT EXTERIOR ONLY AFTER INSPECTION

~~PAINT RED FLUORESCENT STRIPE DOWN LENGTH OF FITTING (CE= _____)~~

PAINT MARK: _____

END PROTECT/PALLETIZE

CUSTOMER INSPECTION MAY BE REQUIRED

PF1.9 REV. 0 MPS & ITP APPROVED PER REX LITRELL, SPECTRA ENERGY 3/1/12

Charpy minimum 20/15 ft-lbs

CE can equal .45 or less

Base hardness

QT only Y52 and up