

Job Traveler

Job Number: 232143-01



Due Date: 02/22/2024

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

Ship
To: , CO
United States

Order No: 232143

Customer: CTAP

Ship Via: ABERNAL@CTAPLLC.COM

Part Number: *3TE36Y

Description: TE 36 .875-WPHY65

Dated: 11/29/2023

PO Num: 163469

Priority: 3 - STANDARD

Product Code: TEE

Master Job No:

Quote No: 21936

Total Qty Open: 4 EA

Qty Posted: 0 EA

Qty To Make: 4

Start Date: 12/11/2023

Contact: RAY BRADY

Phone: 281-636-8149

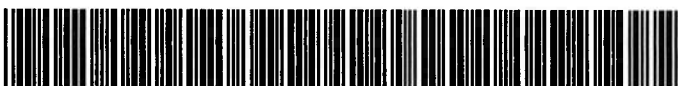
Fax:

Job Notes

BCPU
B10962 - TESTING REQ'D
PIPE SHOP TRAVELER 396-2023 - 132X267 SECTION ALLOCATED

Routing

Routed By:									Quantity 4
Step No	Work Cntr / Vendor		Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Description	Time	Time	Time	Per Hour	Start	End	Quantity
10	PIPE 3 PLATE BURN	Burning Table Plate Burn					12/11/2023	12/11/2023	4
 									
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					12/12/2023	12/12/2023	4
 									
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller					12/12/2023	12/12/2023	4
 									

40	PIPE 7 STRING UP	Initial Weld String-up	12/12/2023	12/12/2023	4
					
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	12/12/2023	12/12/2023	4
					
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	12/12/2023	12/12/2023	4
					
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	12/12/2023	12/12/2023	4
					
80	PIPE 9 OD WELD	OD Weld OD Weld	12/13/2023	12/13/2023	4
					
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	12/18/2023	12/18/2023	4
					
100	FORGE 8 TRIM	Torch Cut Cut hole	12/25/2023	12/25/2023	4
					
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	12/28/2023	12/28/2023	4
					
120	FORGE 8 TRIM	Torch Cut Trim	01/03/2024	01/03/2024	4
					

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/12/2024	02/13/2024	4
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/13/2024	02/13/2024	4
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/13/2024	02/13/2024	4
					
160	E1 MACHINING	E1 Extender Expander	02/13/2024	02/13/2024	4
					
170	M1 MACHINING	M1 Big Mill Machining	02/13/2024	02/15/2024	4
					
180	STAMP 1 STAMP	Stamping	02/15/2024	02/15/2024	4
					
190	INSPECT 1 INSPECTION	Inspection 1	02/15/2024	02/15/2024	4
					
200	SHIPPING SHIPPING	Shipping	02/15/2024	02/15/2024	4
					

Time per Piece (HR):	0.00	0.00	0.00	0.00
Total Time for Job (HR):	0.00	0.00	0.00	

<u>Sub- Assy</u>	<u>Vendor</u>
NO	CLIFF STEEL

Quantity			
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>
13,744.00000	50,739.00000	13,744.00000	0.00000

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCPU
36X36
.875X.875
WPHY65
232143-01

Pipe Shop Traveler Tee Cyl.

396-2023

11/30/2023

☐ Pipe Shop Copy

☐ Pipe Shop Original

Customer	<u>CTAP</u>			SFI Order No	<u>232143-01</u>	Due Date	<u>12/15/2023</u>
Part	<u>43.500</u>	OD	X	<u>1.375</u>	X	<u>58.000</u>	Ship Date
Plate Size	<u>1.375</u>		X	<u>132.340</u>	X	<u>58.000</u>	NoPcs
Heat No.	<u>R3938</u>						Code
Material	<u>A633E</u>			Test Material	<u>CUT (4) 6X12 FOR (2) 12X12</u>	Test No	<u>10962</u>

Cut 4 Plate(s) 1.375 X Thick X 132.340 Width X 58.000 Length 2993 Lbs.
Per Sketch #

From (1) Plate(s) 1.375 Thick X 132.000 Wide X 346.000 Long

Stamp Plates With Heat Code BCPU-04

Scarf to 132.340 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 43.500 " 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

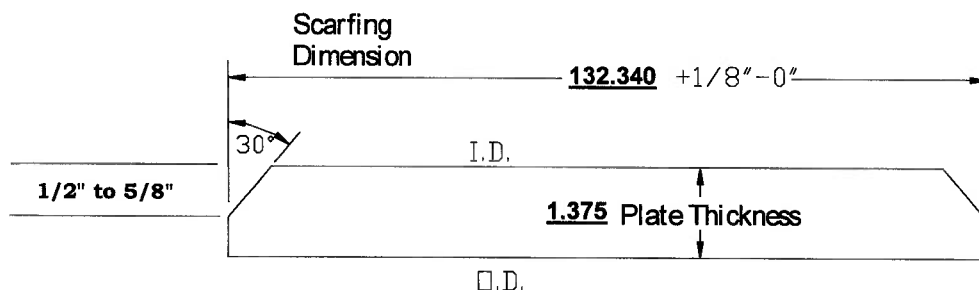
Torch Cut Into 0 Pcs @ 0 Inches

Paint Mark on Cylinder CTAP 232143-01

Stamp Each Cylinder in (2) Places With Heat Code BCPU-05

Fitting Description: (4)TE 36 Y65

Comments: 132X267 ALLOCATED



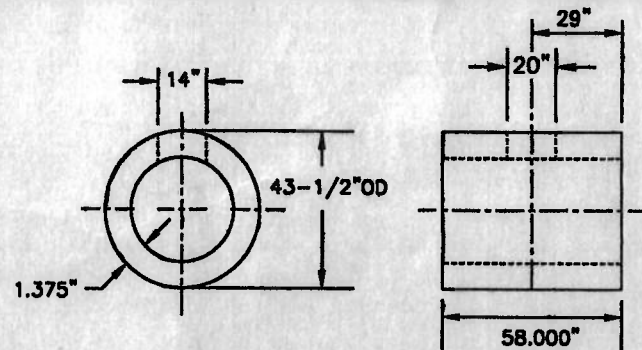
36" Run Diameter = 36.542"

36" Outlet Diameter = 36.699"

Material Size 43-1/2" O.D. x 1.375"W
Length 58.000"

Hole size 14" x 20" Oval

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



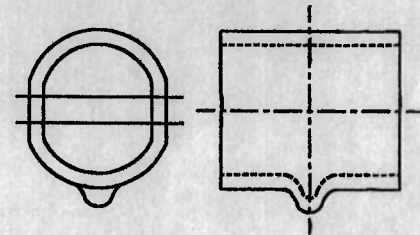
Ovaling Data: Oval: HOT Oval width: 35-3/4" ± 1/4"

Preform Data:

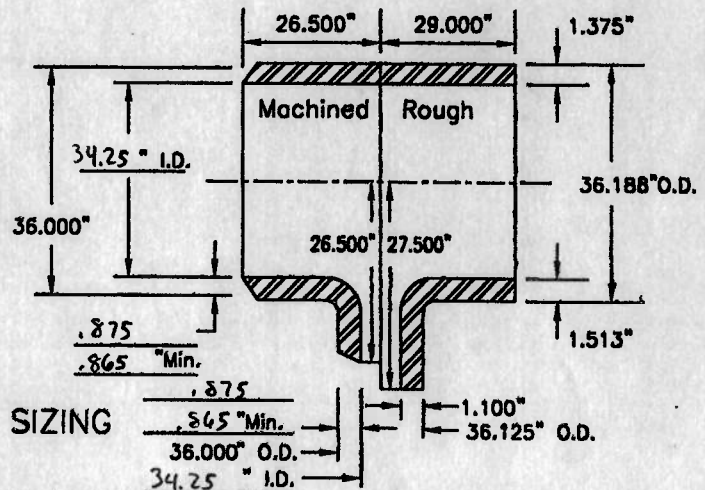
Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50045

1st Oper: Heat to 1650°F
Quench in 30" of water
Close dies HOT to 7-1/2"
Pull 23.210" plug (6" rod)

2nd Oper: Re-heat to 1650°F
Quench in 25" of water
Close dies to 3" &
Pull 29.140" plug (6" rod)



Final Oper: Re-heat to 1650°F
Do not quench
Countersink plug,
Close dies HOT &
Pull 33.800" plug (6" rod)



SHOP NOTE: OUTLET WILL REQUIRE END SIZING

REV	DESCRIPTION	BY	DATE
			DATE: 11-12-99
			SCALE: NONE
			DRAWN BY: J.D.
			CHECKED BY: Bull

36" x 36"
.875 x .875
HIGH YIELD
TEE MFG. DATA

DWG#
36-36-5
(use for all bevel thicknesses
from .834" thru .916")

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 1/2 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: 33.500 + 1/4 -0 34.250
0.875
0.865

BORE OUTLET I.D. STRAIGHT TO: 33.500 + 1/4 -0 34.250
0.875
0.865

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE