

Job Traveler

Job Number: 232143-02



Due Date: 02/22/2024

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

Ship
To: , CO
United States

Order No: 232143

Dated: 11/29/2023

Quote No: 21936

Customer: CTAP

PO Num: 163469

Ship Via: ABERNAL@CTAPLLC.COM

Priority: 3 - STANDARD

Part Number: *3TE3616Y

Product Code: TEE

Description: TE 36X16 .875 X .375-
WPHY65

Master Job No:

MSSSP75-19

Total Qty Open: 18 EA

Qty Posted: 0 EA

Qty To Make: 18

Start Date: 12/11/2023

Phone: 281-636-8149

Contact: RAY BRADY

Fax:

Job Notes

BCPY
B10968 - TESTING REQ'D
PIPE SHOP TRAVELER 397-2023 - FULL PLATES ALLOCATED

Routing

Routed By:

Quantity 18

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	18
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					12/12/2023	12/12/2023	18
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller					12/12/2023	12/12/2023	18

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Report Generated: 11/30/2023 1:31:36 PM

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40	PIPE 7 STRING UP	Initial Weld String-up	12/12/2023	12/12/2023	18
					
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	12/12/2023	12/12/2023	18
					
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	12/12/2023	12/12/2023	18
					
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	12/12/2023	12/12/2023	18
					
80	PIPE 9 OD WELD	OD Weld OD Weld	12/13/2023	12/13/2023	18
					
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	12/18/2023	12/18/2023	18
					
100	FORGE 8 TRIM	Torch Cut Cut hole	12/25/2023	12/25/2023	18
					
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	12/28/2023	12/28/2023	18
					
120	FORGE 8 TRIM	Torch Cut Trim	01/03/2024	01/08/2024	18
					

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	06/12/2024 06/19/2024	18
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	06/19/2024 06/20/2024	18
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	06/20/2024 06/24/2024	18
				
160	E1 MACHINING	E1 Extender Expander	06/24/2024 06/25/2024	18
				
170	M1 MACHINING	M1 Big Mill Machining	06/25/2024 07/09/2024	18
				
180	STAMP 1 STAMP	Stamping	07/09/2024 07/09/2024	18
				
190	INSPECT 1 INSPECTION	Inspection 1	07/09/2024 07/09/2024	18
				
200	SHIPPING SHIPPING	Shipping	07/09/2024 07/09/2024	18
				

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:	18
Needed	On Hand	Posted	Short	Unit	Description	Sub- Assy	Vendor
54,750.00000	91,745.00000	54,750.00000	0.00000	LB	0PL1375633	NO	CLIFF STEEL
					PL0 1.375-A633-E		
					Quantities from Bins/Lot Number:		
					BCPY-01 (18250.0)		
					BCPY-02 (18250.0)		
					BCPY-03 (18250.0)		

Marking Information:



FLEET-LINE
MADE IN USA
STEEL FORGINGS

BCPY
36X16
.875X.375
WPHY65
232143-02

Pipe Shop Traveler Tee Cyl.

397-2023

11/30/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>CTAP</u>		SFI Order No	<u>232143-02</u>	Due Date	<u>12/15/2023</u>
Part	<u>39.000</u>	OD X	<u>1.375</u> X	<u>112.000</u>	Ship Date	<u>2/22/2024</u>
Plate Size	<u>1.375</u>	X	<u>118.203</u> X	<u>112.000</u>	NoPcs	<u>9</u>
Heat No.	<u>R4017</u>				Code	<u>BCPY-01,02,03</u>
Material	<u>A633E</u>	Test Material	<u>CUT (4) 6X12 FOR (2) 12X12</u>		Test No	<u>10968</u>

Cut 9 Plate(s) 1.375 X Thick X 118.203 Width X 112.000 Length 5162 Lbs.

Per Sketch #

From (3) Plate(s) 1.375 Thick X 130.000 Wide X 360.000 Long

Stamp Plates With Heat Code BCPY-01,02,03

Scarf to 118.203 + 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

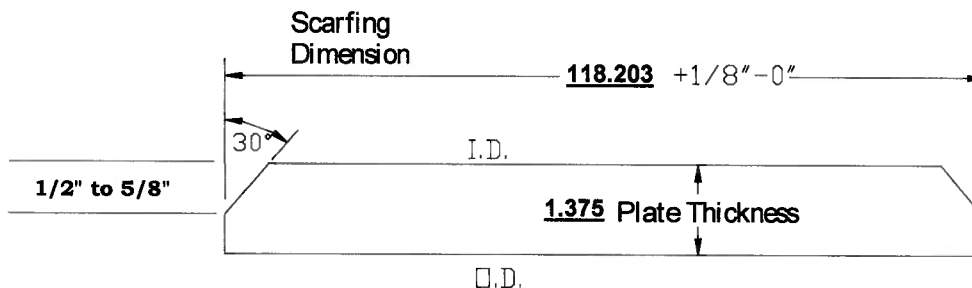
Torch Cut Into 2 Pcs @ 55 Inches

Paint Mark on Cylinder CTAP 232143-02

Stamp Each Cylinder in (2) Places With Heat Code BCPY-01,02,03

Fitting Description: (18)TE 36X16 Y65

Comments: FULL PLATES ALLOCATED



36" Run Diameter = 36.542"

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

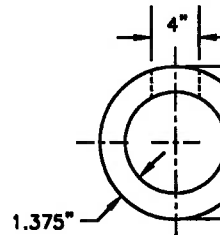
Material Size 39" O.D. x 1.375"W

Length 55.000"

Hole size 4"x 6" oval

Grind 1/8" radius on hole edges

I.D. & O.D.



Do Not Attempt to
Make .844 on the
Nozzle under NO
Circumstances 688 at
the most,
2-3-2020 RAM

SHOP NOTE: Cut hole after barreling operations.

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# 50082 with 36x18" Insert #50090

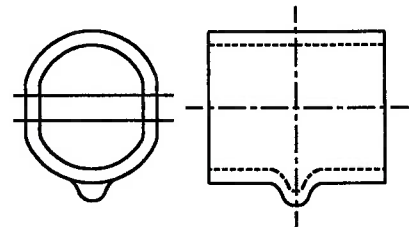
1st Oper: Heat to 1650°F.—Quench in 23-1/2" of water.

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 7-1/4" dia. plug (3" pull rod)

5th Oper: Re-heat to 1650°F.—Do not

quench—Do not close dies and

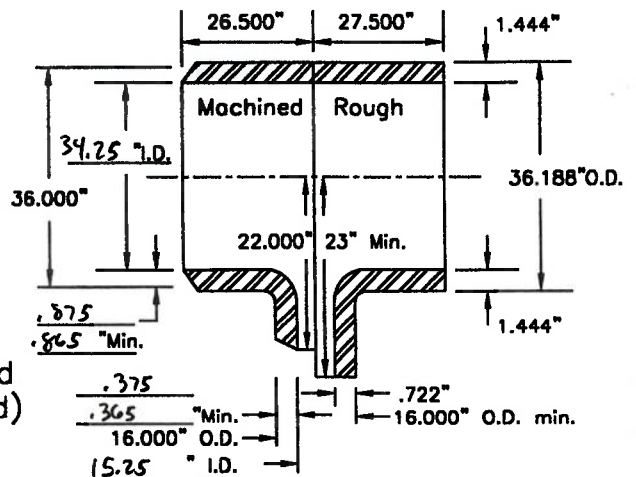
Pull 10-1/2" dia. plug (4" pull rod)

Final Oper: Re-heat to 1650°F.

Do not quench—Close dies hot and

Pull 14.375" dia. plug (4" pull rod)

SHOP NOTE: Outlet may require end sizing.



				DATE: 11-19-99
				SCALE: NONE
				DRAWN BY: J.D.
				CHECKED BY: Bull
REV	DESCRIPTION	BY	DATE	

36" x 16"	DWG#
.875 x .375	36-16-6
HIGH YIELD	Use for bevel thicknesses:
TEE MFG. DATA	36: Run— .834" thru .917"
	16" Outlet— .656" and less.

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: 14.750 + 1/8 -0 15.250
0.375
0.365

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE