

Job Traveler

Job Number: 232143-03

Due Date: 02/22/2024



Sold To: CTAP, LLC
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: *3TE3620Y

Product Code: TEE

Description: TE 36X20 .875 X .500-
WPHY65

Master Job No:

MSSSP75-19

Total Qty Open: 14 EA

Qty Posted: 0 EA

Qty To Make: 14

Start Date: 12/11/2023

Phone: 281-636-8149

Contact: RAY BRADY

Fax:

Job Notes

BCPU
B10962 - TESTING REQ'D
PIPE SHOP TRAVELER 398-2023
(2) FULL PLATES ALLOCATED, (1) CYL ON THIRD PLATE WILL BE CUT WITH PIPE SHOP TRAVELER 400-2023

Routing

Routed By:

Quantity 14

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					12/11/2023	12/11/2023	14



20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating				12/12/2023	12/12/2023	14
----	------------------------	---------------------------------	--	--	--	------------	------------	----



30	PIPE 4 BIG ROLL	Big Roller Roll on large roller				12/12/2023	12/12/2023	14
----	--------------------	------------------------------------	--	--	--	------------	------------	----



Job Number: 232143-03

Report Generated: 11/30/2023 1:31:47 PM

Page 1 of 5

40	PIPE 7 STRING UP	Initial Weld String-up	12/12/2023	12/12/2023	14
					
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	12/12/2023	12/12/2023	14
					
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	12/12/2023	12/12/2023	14
					
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	12/12/2023	12/12/2023	14
					
80	PIPE 9 OD WELD	OD Weld OD Weld	12/13/2023	12/13/2023	14
					
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	12/18/2023	12/19/2023	14
					
100	FORGE 8 TRIM	Torch Cut Cut hole	12/25/2023	12/25/2023	14
					
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	12/28/2023	12/28/2023	14
					
120	FORGE 8 TRIM	Torch Cut Trim	01/08/2024	01/10/2024	14
					

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	06/19/2024	06/25/2024	14
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	06/25/2024	06/26/2024	14
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	06/26/2024	06/27/2024	14
					
160	E1 MACHINING	E1 Extender Expander	06/27/2024	06/27/2024	14
					
170	M1 MACHINING	M1 Big Mill Machining	06/27/2024	07/10/2024	14
					
180	STAMP 1 STAMP	Stamping	07/10/2024	07/10/2024	14
					
190	INSPECT 1 INSPECTION	Inspection 1	07/10/2024	07/10/2024	14
					
200	SHIPPING SHIPPING	Shipping	07/10/2024	07/10/2024	14
					

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: 14		
Needed	On Hand	Posted	Short	Unit	Description	Sub-Assy Vendor
41,386.00000	78,381.00000	41,386.00000	0.00000	LB	0PL1375633	NO CLIFF STEEL
				PL0 1.375-A633-E		
				Quantities from Bins/Lot Number:		
				BCPU-02 (17810.0)		
				BCPU-03 (17810.0)		
				BCPU-04 (5766.0)		

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCPU
36X20
.875X.500
WPHY65
232143-03

Pipe Shop Traveler Tee Cyl.

398-2023

11/30/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	CTAP	SFI Order No	232143-03	Due Date	12/15/2023
Part	42.000 OD X 1.375 X 112.000			Ship Date	2/22/2024
Plate Size	1.375 X 127.628 X 112.000			NoPcs	7
Heat No.	R3938			Code	BCPU-02,03,04
Material	A633E	Test Material		Test No	

Cut 7 Plate(s) 1.375 X Thick X 127.628 Width X 112.000 Length 5574 Lbs.

Per Sketch #

From (3) Plate(s) 1.375 Thick X 132.000 Wide X 346.000 Long

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

Scarf to 127.628 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 42.000 " 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

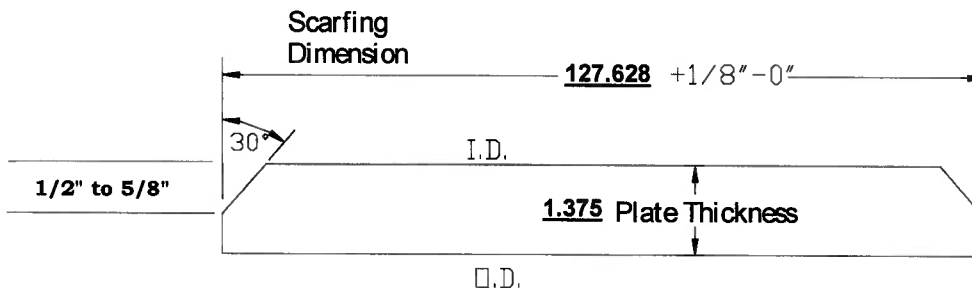
Torch Cut Into 2 Pcs @ 55 Inches

Paint Mark on Cylinder CTAP 232143-03

Stamp Each Cylinder in (2) Places With Heat Code BCPU-02,03,04

Fitting Description: (14)TE 36X20 Y65

Comments: LAST CYL WILL BE CUT W/ 400-2023



36" Run Diameter = 36.542"

20" Outlet Diameter = 20.523"

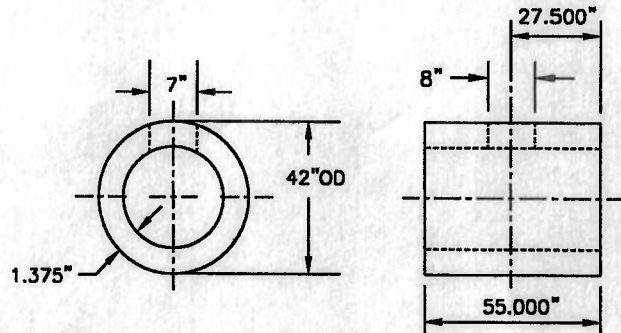
Material Size 42" O.D. x 1.375"W
Length 55.000"

Ovaling Data:

Oval HOT to: 35-3/4" ± 1/4"

Hole size 7"x 8" oval

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



Preform Data:

Press: Machine 2000 Ton Set up #10139 Upper Die# 50046
Lower Die# 50082 with 36x20" Insert #50089

1st Oper: Heat to 1650°F.—Quench in 28 inches of water.

Close dies to 5-1/2" and

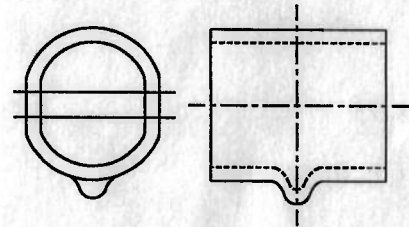
Pull 10-1/4" diameter plug (4" rod).

2nd Oper: Re-heat to 1650°F.

Quench in 23-1/2 inches of water

Close dies to 1-1/2" and

Pull 14-3/4" diameter plug (4" rod).

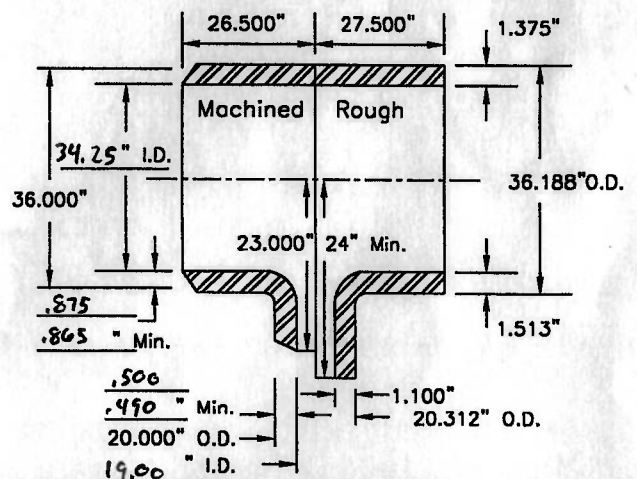


3th Oper: Re-heat to 1650°F.

Do not quench

Close dies hot and

Pull 18-1/4" plug (4" pull rod).



				DATE: 11-22-99	36" x 20" .875 x .500 HIGH YIELD TEE MFG. DATA	DWG#
				SCALE: NONE		36-20-4
				DRAWN BY: J.D.		
				CHECKED BY: Bull		
REV	DESCRIPTION	BY	DATE			Use for bevel thicknesses: 36" Run—.834" thru .916" 20" Outlet—.812" 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: 18.500 + 1/8 -0 19.000
0.500
0.490

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE