

Job Traveler

Job Number: 232143-04

Due Date: 02/22/2024



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

Ship To: , CO
United States

Order No: 232143

Customer: CTAP

Ship Via: ABERNAL@CTAPLLC.COM

Part Number: *3TE3624Y

Description: TE 36X24 .875 X .625-WPHY65

MSSSP75-19

Dated: 11/29/202:

PO Num: 163469

Priority: 3 - STANDARD

Product Code: TEE

Master Job No:

Quote No: 21936

Total Qty Open: 2 EA

Qty Posted: 0 EA

Qty To Make: 2

Start Date: 12/11/2023

Contact: RAY BRADY

Phone: 281-636-8149

Fax:

Job Notes

BCPU
B10962 - TESTING REQ'D
PIPE SHOP TRAVELER 399-2023

Routing

Routed By:		Quantity 2						
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	Burning Table Plate Burn				12/11/2023	12/11/2023	2
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating				12/12/2023	12/12/2023	2
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller				12/12/2023	12/12/2023	2

40	PIPE 7 STRING UP	Initial Weld String-up	12/12/2023	12/12/2023	2
					
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	12/12/2023	12/12/2023	2
					
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	12/12/2023	12/12/2023	2
					
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	12/12/2023	12/12/2023	2
					
80	PIPE 9 OD WELD	OD Weld OD Weld	12/13/2023	12/13/2023	2
					
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	12/19/2023	12/19/2023	2
					
100	FORGE 8 TRIM	Torch Cut Cut hole	12/25/2023	12/25/2023	2
					
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	12/28/2023	01/01/2024	2
					
120	FORGE 8 TRIM	Torch Cut Trim	01/10/2024	01/10/2024	2
					

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/13/2024	02/13/2024	2
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/13/2024	02/13/2024	2
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/13/2024	02/13/2024	2
					
160	E1 MACHINING	E1 Extender Expander	02/13/2024	02/13/2024	2
					
170	M1 MACHINING	M1 Big Mill Machining	02/13/2024	02/15/2024	2
					
180	STAMP 1 STAMP	Stamping	02/15/2024	02/15/2024	2
					
190	INSPECT 1 INSPECTION	Inspection 1	02/15/2024	02/15/2024	2
					
200	SHIPPING SHIPPING	Shipping	02/15/2024	02/15/2024	2
					

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: 2

Quantity				Unit	Description	Sub- Assy	Vendor
Needed	On Hand	Posted	Short				
5,766.00000	42,761.00000	5,766.00000	0.00000	LB	0PL1375633	NO	CLIFF STEEL
					PL0 1.375-A633-E		
					Quantities from Bins/Lot Number:		
					BCPU-06 (5766.0)		

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCPU
36X24
.875X.625
WPHY65
232143-04

Pipe Shop Traveler Tee Cyl.

399-2023

11/30/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>CTAP</u>		SFI Order No	<u>232143-04</u>	Due Date	<u>12/15/2023</u>
Part	<u>42.000</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>127.628</u> X	<u>112.000</u>	NoPcs	<u>1</u>
Heat No.	<u>R3938</u>				Code	<u>BCPU-06</u>
Material	<u>A633E</u>	Test Material			Test No	

Cut 1 Plate(s) 1.375 X Thick X 127.628 Width X 112.000 Length 5574 Lbs.
Per Sketch #

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

Stamp Plates With Heat Code BCPU-05

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

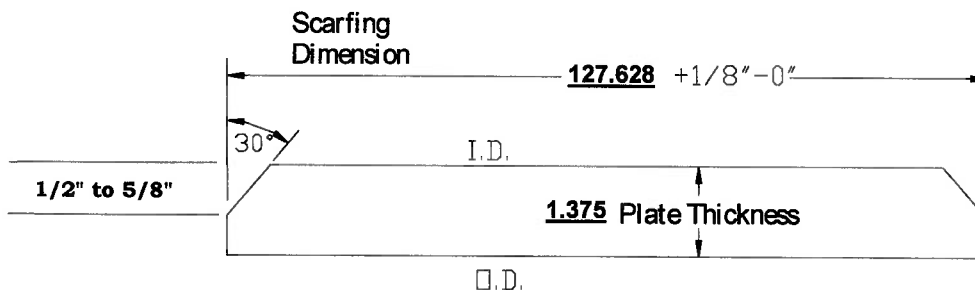
Torch Cut Into 2 Pcs @ 55 Inches

Paint Mark on Cylinder CTAP 232143-04

Stamp Each Cylinder in (2) Places With Heat Code BCPU-06

Fitting Description: (2)TE 36X24 Y65

Comments:



36" Run Diameter = 36.542"

24" Outlet Diameter = 24.567"

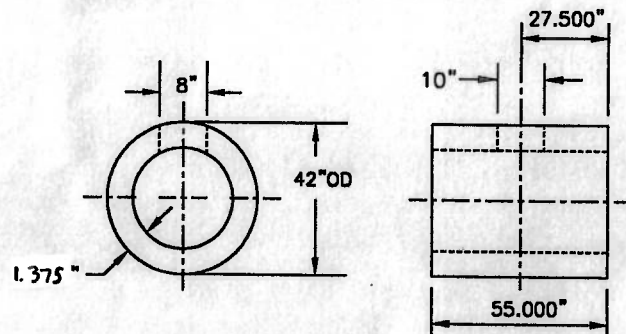
Material Size 42" O.D. x 1.375 W
Length 55.000"

Ovaling Data:

Oval HOT to: 35-3/4" ± 1/4"

Hole size 8"x 10" oval

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



Preform Data:

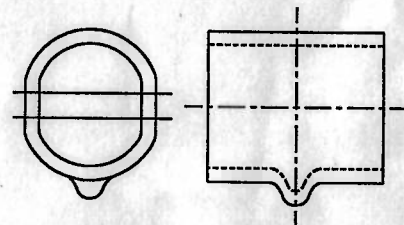
Press: Machine 2000 Ton Set up #10139 Upper Die# 50046
Lower Die# 50082 with 36x24" Insert #50082

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

Close dies to 5-1/2" and
Pull 12-1/2" diameter plug (4" rod).

2nd Oper: Re-heat to 1650°F.

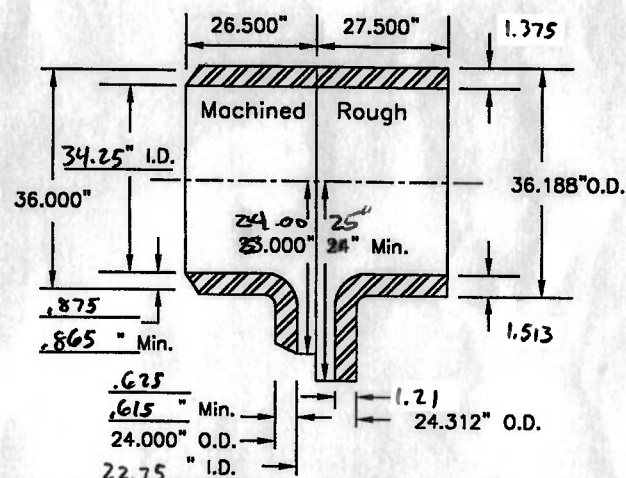
Quench in 23-1/2 inches of water
Close dies to 1-1/2" and
Pull 17-3/4" diameter plug (4" rod).



3th Oper: Re-heat to 1650°F.

Do not quench

Close dies hot and
Pull 21-7/8" plug (4" pull rod).



DATE: 11-22-99

SCALE: NONE

DRAWN BY: J.D.

CHECKED BY: Bull

36" x 24"

.875 x .625

HIGH YIELD
TEE MFG. DATA

DWG#

36-24-4

Use for bevel thicknesses:
36" Run—.834" thru. 1.000".
24" Outlet— 1.000" and less.

REV	DESCRIPTION	BY	DATE
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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: 22.250 + 1/8 -0 22.750
0.625
0.615

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE