

Job Traveler

Job Number: 232143-05



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: *3TE3630Y

Product Code: TEE

Description: TE 36X30 .875 X .688-
WPHY65

Master Job No:

MSSSP75-19

Total Qty Open: 4 EA

Qty Posted: 0 EA

Qty To Make: 4

Start Date: 12/11/2023

Phone: 281-636-8149

Contact: RAY BRADY

Fax:

Job Notes

BCPU
B10962 - TESTING REQ'D
PIPE SHOP TRAVELER 400-2023
CUT WITH PIPE SHOP TRAVELER 398-2023
FULL PLATE ALLOCATED BETWEEN BOTH ORDERS

Routing

Routed By:

Quantity 4

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	4



20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating				12/12/2023	12/12/2023	4
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30	PIPE 4 BIG ROLL	Big Roller Roll on large roller				12/12/2023	12/12/2023	4
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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	12/19/2023 12/19/2023	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	01/01/2024 01/01/2024	4
				
120	FORGE 8 TRIM	Torch Cut Trim	01/10/2024 01/11/2024	4
				

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/13/2024	02/14/2024	4
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/14/2024	02/14/2024	4
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/14/2024	02/14/2024	4
					
160	E1 MACHINING	E1 Extender Expander	02/14/2024	02/15/2024	4
					
170	M1 MACHINING	M1 Big Mill Machining	02/15/2024	02/20/2024	4
					
180	STAMP 1 STAMP	Stamping	02/20/2024	02/20/2024	4
					
190	INSPECT 1 INSPECTION	Inspection 1	02/20/2024	02/20/2024	4
					
200	SHIPPING SHIPPING	Shipping	02/20/2024	02/20/2024	4
					

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

Materials List

Quantity: 4

----- Quantity -----				Unit	Description	Sub-	Vendor
Needed	On Hand	Posted	Short			Assy	
12,044.00000	49,039.00000	12,044.00000	0.00000	LB	0PL1375633	NO	CLIFF STEEL
					PL0 1.375-A633-E		
					Quantities from Bins/Lot Number:		
					BCPU-04 (12044.0)		

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCPU
36X30
.875X.688
WPHY65
232143-05

Pipe Shop Traveler Tee Cyl.

400-2023

11/30/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>CTAP</u>		SFI Order No	<u>232143-05</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>2</u>
Heat No.	<u>R3938</u>				Code	<u>BCPU-04</u>
Material	<u>A633E</u>	Test Material			Test No	

Cut 2 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-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

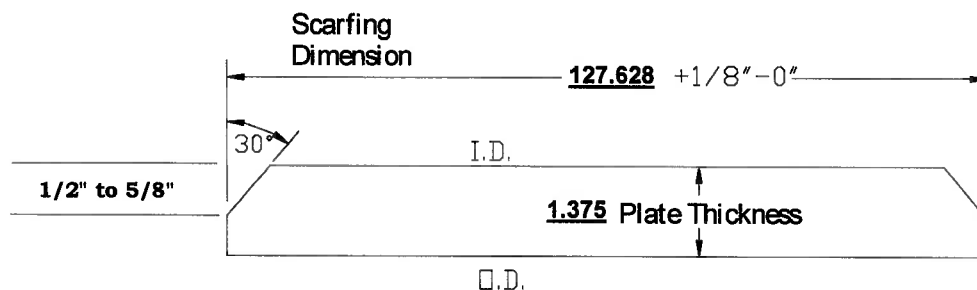
Torch Cut Into 2 Pcs @ 55 Inches

Paint Mark on Cylinder CTAP 232143-05

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

Fitting Description: (4)TE 36X30 Y65

Comments: CUT WITH 398-2023



36" Run Diameter = 36.542"

30" Outlet Diameter = 30.633"

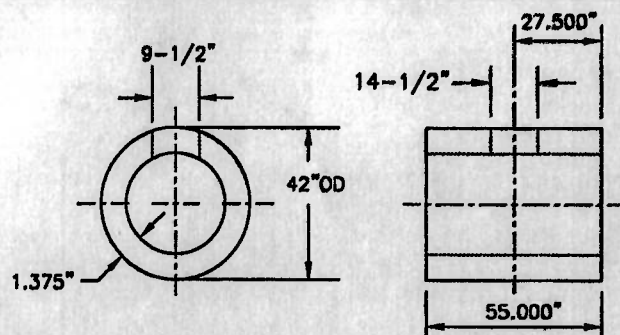
Material Size 42" O.D. x 1.375"W
Length 55.000"

Ovaling Data:

Oval: HOT to 35-3/4" ± 1/4"

Hole size 9-1/2" x 14-1/2" oval

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



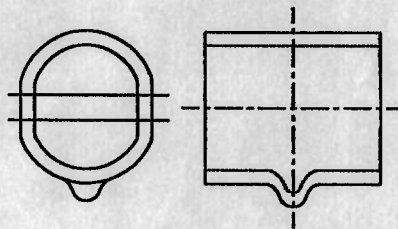
Preform Data:

Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50092

1st Oper: Heat to 1650°F.—Quench in 27 inches of water.

Close dies to 6" and

Pull 17-3/8" diameter plug (4" rod).



2nd Oper: Re-heat to 1650°F.

Quench in 23 inches of water

Close dies to 2" and

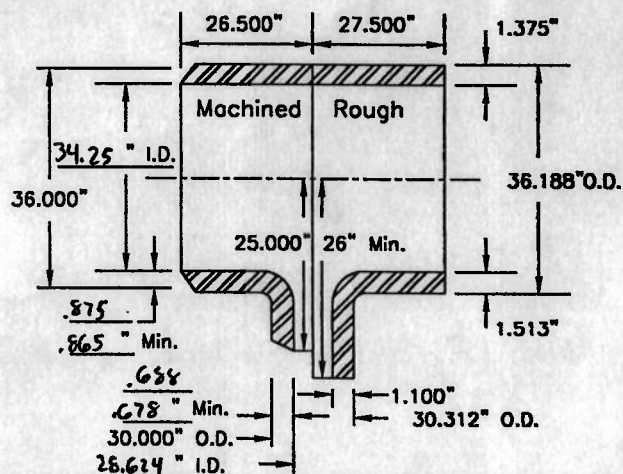
Pull 23-3/4" diameter plug (4" rod).

3th Oper: Re-heat to 1650°F.

Do not quench

Close dies hot and

Pull 28.280" plug (6" pull rod).



REV	DESCRIPTION	BY	DATE
			DATE: 11-29-99
			SCALE: NONE
			DRAWN BY: J.D.
			CHECKED BY: Bull

36" x 30"
.875 x .688
HIGH YIELD TEE MFG. DATA

DWG#
36-30-5
Use for bevel thicknesses: 36" Run—.834" thru .916". 30" 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: 27.874 + 1/4 -0 28.624
0.688
0.678

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE