

Sold To: EDGEN MURRAY CORPORATION
18444 HIGHLAND ROAD
P.O. BOX 84160
BATON ROUGE, LA 70884-4160
United States

Ship To: PIPELINE EQUIPMENT
8403 SOUTH 89TH WEST AVENUE
Tulsa, OK 74131
United States

Order No: 240019

Dated: 01/04/2024

Quote No: 21880

Customer: EDGEN119955

PO Num: STL-303651

Ship Via: FFA

Priority: 3 - STANDARD

Part Number: *3TE308Y

Product Code: TEE

Description: TE 30X8 1.00 X .322-WPHY65

Master Job No:

-20F CVN

M-1 - * TAKING
EXCEPTION TO GRAIN
SIZE *

Total Qty Open: 8 EA

Qty Posted: 0 EA

Qty To Make: 8

Start Date: 01/08/2024

Phone: 314-524-0001

Contact: NICK POLIZZI

Fax:

Job Notes

BCOZ
B10878
PIPE SHOP TRAVELERS 5-2024, 6-2024
END CAPS REQ'D

Routing

Routed By:

Quantity 8

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					01/08/2024	01/08/2024	8
 									
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					01/08/2024	01/08/2024	8
 									

30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	01/08/2024 01/08/2024	8
				
40	PIPE 7 STRING UP	Initial Weld String-up	01/08/2024 01/08/2024	8
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	01/08/2024 01/08/2024	8
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	01/08/2024 01/08/2024	8
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	01/08/2024 01/08/2024	8
				
80	PIPE 9 OD WELD	OD Weld OD Weld	01/08/2024 01/08/2024	8
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	01/22/2024 01/23/2024	8
				
100	FORGE 8 TRIM	Torch Cut Cut hole	02/15/2024 02/15/2024	8
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	02/15/2024 02/15/2024	8
				

120	FORGE 8 TRIM	Torch Cut Trim	02/15/2024 02/19/2024	8
				
130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	10/15/2024 10/17/2024	8
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	10/17/2024 10/21/2024	8
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	10/21/2024 10/21/2024	8
				
160	E1 MACHINING	E1 Extender Expander	10/21/2024 10/21/2024	8
				
170	M1 MACHINING	M1 Big Mill Machining	10/21/2024 10/28/2024	8
				
180	STAMP 1 STAMP	Stamping	10/28/2024 10/28/2024	8
				
190	INSPECT 1 INSPECTION	Inspection 1	10/28/2024 10/28/2024	8
				



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: 8			
Needed	On Hand	Posted	Short	Unit	Description	Sub- Assy	Vendor
16,508.00000	287,924.00000	16,508.00000	0.00000	LB	0PL15633	NO	CLIFF STEEL
					PL0 1.5-A633-E Quantities from Bins/Lot Number: BCOZ-DROPS (4632.0) BCOZ-04 (11876.0)		
16.00000	65.00000	16.00000	0.00000	EA	3EC30	YES	M&P FLANGE
					END CAP PROTECTOR 30" Quantities from Bins/Lot Number: YARD (16.0)		
8.00000	43.00000	8.00000	0.00000	EA	3EC8	YES	D&D SYSTEMS
					END CAP PROTECTOR 8" Quantities from Bins/Lot Number: YARD (8.0)		

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCOZ
30X8
1.00X.322
WPHY65
240019-01

Pipe Shop Traveler Tee Cyl.

5-2024

1/5/2024

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>EDGEN</u>		SFI Order No	<u>240019-01</u>	Due Date	<u>1/19/2024</u>
Part	<u>33.000</u> OD	X	<u>1.500</u> X	<u>94.000</u>	Ship Date	<u>2/13/2024</u>
Plate Size	<u>1.500</u>	X	<u>98.960</u> X	<u>94.000</u>	NoPcs	<u>1</u>
Heat No.	<u>R3504</u>				Code	<u>BCOZ</u>
Material	<u>A633E</u>	Test Material			Test No	

Cut 1 Plate(s) 1.500 X Thick X 98.960 Width X 94.000 Length 3957 Lbs.

Per Sketch # 6251

From (1) Plate(s) 1.500 Thick X 133.000 Wide X 218.000 Long

Stamp Plates With Heat Code BCOZ

Scarf to 98.960 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 33.000 " 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

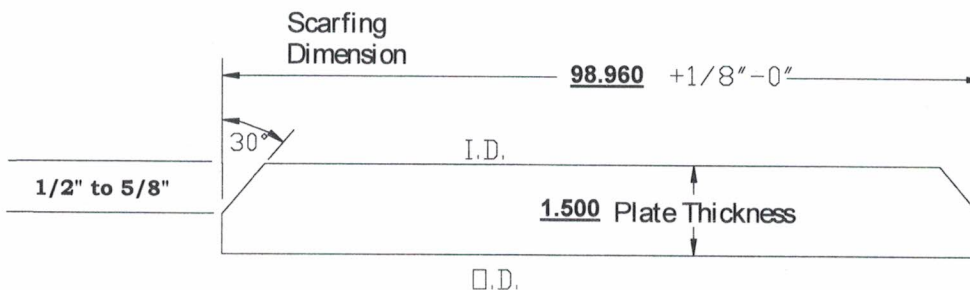
Torch Cut Into 2 Pcs @ 46 Inches

Paint Mark on Cylinder EDGEN 240019-01

Stamp Each Cylinder in (2) Places With Heat Code BCOZ

Fitting Description: (8)TE 30X8 Y65

Comments: CUT WITH 4-2024; 99X110 ALLOCATED TO ACCOUNT FOR END OF PLT.



Pipe Shop Traveler Tee Cyl.

6-2024

1/5/2024

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>EDGEN</u>				SFI Order No	<u>240019-01</u>	Due Date	<u>1/19/2024</u>
Part	<u>33.000</u>	OD	X	<u>1.500</u>	X	<u>94.000</u>	Ship Date	<u>2/13/2024</u>
Plate Size	<u>1.500</u>		X	<u>98.960</u>	X	<u>94.000</u>	NoPcs	<u>3</u>
Heat No.	<u>R3504</u>						Code	<u>BCOZ-04</u>
Material	<u>A633E</u>		Test Material				Test No	

Cut 3 Plate(s) 1.500 X Thick X 98.960 Width X 94.000 Length 3957 Lbs.
Per Sketch #

From (1) Plate(s) 1.500 Thick X 132.000 Wide X 360.000 Long

Stamp Plates With Heat Code BCOZ-04

Scarf to 98.960 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 33.000 " 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

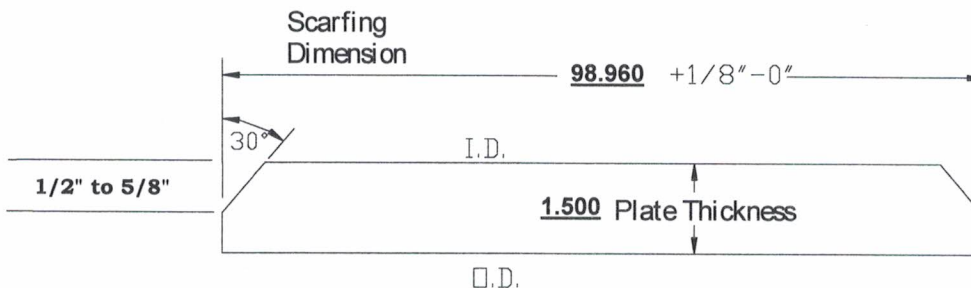
Torch Cut Into 6 Pcs @ 46 Inches

Paint Mark on Cylinder EDGEN 240019-01

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

Fitting Description: (8)TE 30X8 Y65

Comments:



30" Run Diameter = 30.476"

" Outlet Diameter = Free pull in 30 x 16 dies

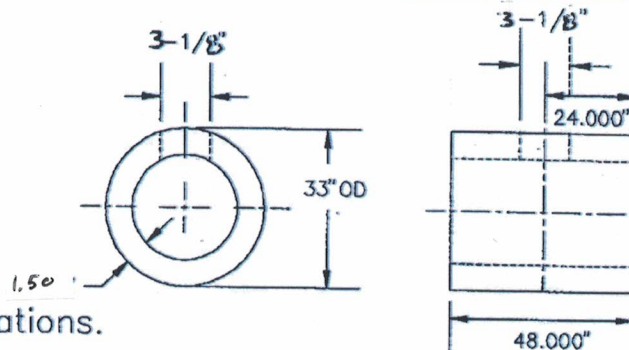
Material Size 33" O.D. x 1.50"W

Length 46.000"

Hole size 3-1/8" Diameter

Grind 1/8" radius on hole edges

I.D. & O.D.



SHOP NOTE: Cut hole after barreling operations.

Ovaling Data: Oval: HOT Oval width: 29-1/2" ± .1/4"

Preform Data:

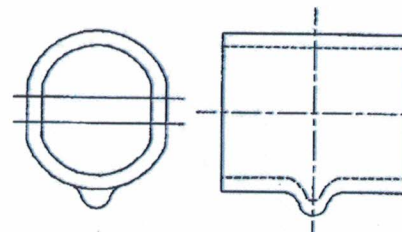
Press: Machine 2000 Ton Set up#10138 Upper Die# 50037

Lower Die# 50086

SHOP NOTE: May take two heats for each barreling operation (1 & 2).

1st Oper: Heat to 1650°F.—Quench in 26-1/2" of water. Barrel down HOT with HOT side up. Close dies to 6-1/4"

2nd Oper: Re-heat to 1650°F.
Quench barreled side in 20-1/2" of water & barrel down HOT with HOT side up. Close dies.

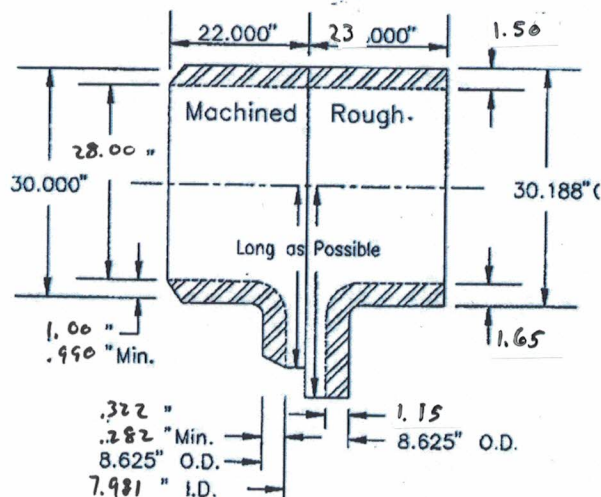


3rd Oper: Cut outlet hole per above

4th Oper: Locally heat outlet area with torches & Free pull 3-3/4" plug(1-3/4" rod) in 30 x 16 dies

5th Oper: Locally heat outlet area with torches & Free pull 5-9/16" plug(2-1/2" rod)

Final Oper: Locally heat outlet area with torches & Free pull 7-7/16" plug(3" rod)



				DATE: 10/25/12	30" x 8" (1.00 x .322)	DWG# 30-8-3A
				SCALE: NONE		
				DRAWN BY: J.DAVIDSON		
				CHECKED BY: JL		
1	REVISED HOLE FROM 2 1/2 TO 3 1/8	JL	10/25/12		HIGH YIELD TEE MFG. DATA	
REV	DESCRIPTION	BY	DATE			

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: 27.250 + 1/4 -0 28.000
1.000
0.990

BORE OUTLET I.D. STRAIGHT TO: 7.731 ± 1/16 7.981
0.322
0.282

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE