

Job Traveler

Job Number: 240019-02



Due Date: 02/13/2024

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

Ship Via: FFA

Part Number: *3ER3024Y

Description: ER 30X24 1.00 X .969-WPHY65

THRUBORE

-20F CVN

M-1 - * TAKING
EXCEPTION TO GRAIN
SIZE *

PO Num: STL-303651

Priority: 3 - STANDARD

Product Code: ECCENTRIC REDUCER

Master Job No:

Total Qty Open: 4 EA

Qty Posted: 0 EA

Qty To Make: 4

Start Date: 01/08/2024

Contact: NICK POLIZZI

Phone: 314-524-0001

Fax:

Job Notes

BCOZ
B10878
PIPE SHOP TRAVELER 4-2024; CUT WITH 5-2024
END CAPS REQ'D

Routing

Routed By:

Quantity 4

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- StartEnd		Run Quantity
10	PIPE 3 PLATE BURN	Burning Table Plate Burn					01/08/2024	01/08/2024	4
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					01/08/2024	01/08/2024	4

30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	01/08/2024 01/08/2024	4
				
40	PIPE 7 STRING UP	Initial Weld String-up	01/08/2024 01/08/2024	4
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	01/08/2024 01/08/2024	4
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	01/08/2024 01/08/2024	4
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	01/08/2024 01/08/2024	4
				
80	PIPE 9 OD WELD	OD Weld OD Weld	01/08/2024 01/08/2024	4
				
90	PIPE 4 BIG ROLL	Big Roller Re-roll on large roller	01/08/2024 01/08/2024	4
				
100	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	01/23/2024 01/23/2024	4
				
110	FORGE 4 HAMMER	Large Hammer Hammer	01/24/2024 01/29/2024	4
				

120	FORGE 7 HEAT TREAT	Heat Treat Heat Treat	10/14/2024	10/15/2024	4
					
130	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	10/15/2024	10/15/2024	4
					
140	PIPE 13 X RAY	Pipe X Ray X-ray weld	10/15/2024	10/16/2024	4
					
150	E1 MACHINING	E1 Extender Expander	10/16/2024	10/16/2024	4
					
160	M1 MACHINING	M1 Big Mill Machining	10/16/2024	10/21/2024	4
					
170	STAMP 1 STAMP	Stamping Stamping	10/21/2024	10/21/2024	4
					
180	INSPECT 1 INSPECTION	Inspection 1 Inspection	10/21/2024	10/21/2024	4
					
190	SHIPPING SHIPPING	Shipping Shipping	10/21/2024	10/21/2024	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				Quantity: 4			
Needed	On Hand	Posted	Short	Unit	Description	Sub- Assy	Vendor
4,114.00000	275,530.00000	4,114.00000	0.00000	LB	0PL15633	NO	CLIFF STEEL
					PL0 1.5-A633-E		
					Quantities from Bins/Lot Number:		
					BCOZ-DROPS (4114.0)		
1.00000	1.00000	1.00000	0.00000	EA	3EC24	YES	D&D SYSTEMS
					END CAP PROTECTOR 24"		
					Quantities from Bins/Lot Number:		
					YARD (1.0)		
4.00000	53.00000	4.00000	0.00000	EA	3EC30	YES	M&P FLANGE
					END CAP PROTECTOR 30"		
					Quantities from Bins/Lot Number:		
					YARD (3.0)		
					YARD (1.0)		

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCOZ
30X24
1.00X.969
WPHY65
240019-02

Pipe Shop Traveler Reducer Cyl.

4-2024

1/5/2024

☐

Pipe Shop Copy

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Pipe Shop Original

Customer	<u>EDGEN</u>			SFI Order No	<u>240019-02</u>	Due Date	<u>2/19/2024</u>	
Part	<u>30.000</u>	OD	X	<u>1.500</u>	X	<u>108.000</u>	Ship Date	<u>2/13/2024</u>
Plate Size	<u>1.500</u>		X	<u>89.536</u>	X	<u>108.000</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 89.536 Width X 108.000 Length 4114 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 89.536 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 30.000 " 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 4 Pcs @ 26.5 Inches

Paint Mark on Cylinder EDGEN

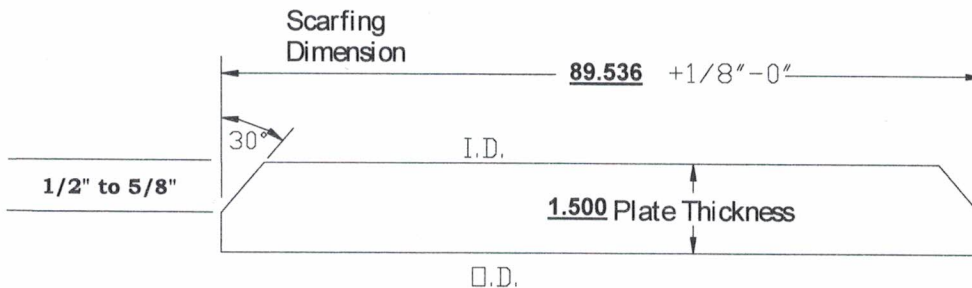
240019-02

Stamp Each Cylinder in (2) Places With Heat Code

BCOZ

Fitting Description: (4)ER 30X24 Y65

Comments: CUT WITH 5-2024



FORM BY HAMMER

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 IF THRU-BORE, ACTUAL ID: _____

24 in. (SMALL) END-STRAIGHT BORE I.D. TO 22.062 ± .09

(FACE, THRU BORE, AND BEVEL)

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE