

Job Traveler

Job Number: 241342-01



Due Date: 07/19/2024

Sold MRC GLOBAL (US), INC
To: ATTN: INVOICE AUDITING DEPT
P.O. BOX 513
CHARLESTON, WV 25322

Ship ATMOS ENERGY C/O PUMPCO
To: 14703 CR 1227
CODY PORTER 325-201-5481
180.48246_LINE S2(PHASE 3)
Flint, TX 75757
United States

Order No: 241342

Dated: 06/26/202

Quote No: 25350

Customer: MRC GL257952

PO Num: C0134075529D0

Ship Via: FERNANDO.GARCIA@MRCGLO

Priority: 1 - OVERTIME

Part Number: *3TE3616Y

Product Code: TEE

Description: TE 36X16 .750 X .375-
WPHY65

Master Job No:

MSSSP75-19

Total Qty Open: 14 EA

Qty Posted: 0 EA

Qty To Make: 14

Start Date: 07/15/2024

Phone: 3,043,485,211

Contact: FERNANDO GARCIA

Fax:

Job Notes

(3)BCPS B10948
(5)BCRR B11000
FROM BLANKS

(6)BCRI
B10985
CUT (6) @ 55" EACH FROM (3) @ 112" - CYLINDERS IN PROCESS ON 240920-07

Routing

Routed By:							Quantity 14		
Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- StartEnd		Run Quantity
10	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut					07/15/2024	07/15/2024	14
 									
20	FORGE 8 TRIM	Torch Cut Cut hole					07/25/2024	07/25/2024	14
 									

30	FORGE 12 FORM/PRESS	2000 Ton Press Forming	10/30/2024 10/30/2024	14
				
40	FORGE 8 TRIM	Torch Cut Trim	11/07/2024 11/12/2024	14
				
50	FORGE 7 HEAT TREAT	Heat Treat Heat treat	01/29/2025 02/04/2025	14
				
60	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/04/2025 02/05/2025	14
				
70	PIPE 13 X RAY	Pipe X Ray X-ray	02/05/2025 02/06/2025	14
				
80	E1 MACHINING	E1 Extender Expander	02/06/2025 02/06/2025	14
				
90	M1 MACHINING	M1 Big Mill Machining	02/06/2025 02/19/2025	14
				
100	STAMP 1 STAMP	Stamping	02/19/2025 02/19/2025	14
				
110	INSPECT 1 INSPECTION	Inspection 1	02/19/2025 02/19/2025	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
8.00000	8.00000	8.00000	0.00000	EA	*2TE3616XHY	YES

TE2 36X16-XH-XH-Y60
Quantities from Bins/Lot Number:
BCPS (3.0)
BCRR (5.0)

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCPS
36X16
.750X.375
WPHY65
241342-01

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCRR
36X16
.750X.375
WPHY65
241342-01

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCRI
36X16
.750X.375
WPHY65
241342-01

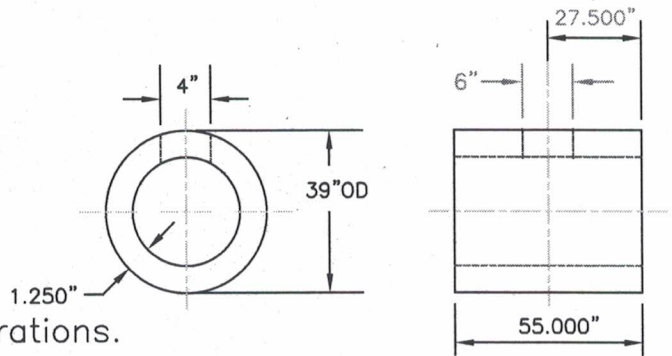
36" Run Diameter = 36.542"

16" Outlet Diameter = Free pull in 36 x 18 dies

Material Size 39" O.D. x 1.250"W
Length 55.000"

Hole size 3.50" hole

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



SHOP NOTE: Cut hole after barreling operations.

Ovaling Data: Oval: HOT Oval width: $35-3/4" \pm 1/4"$

Preform Data:

Press: Machine 2000 Ton Set up#10139 Upper Die# 50046
Lower Die# 50082 with 36x18" Insert #50090

1st Oper: Heat to 1650°F. — Quench in 23-1/2" of water.

Barrel down HOT with HOT side up. Close dies to 3"

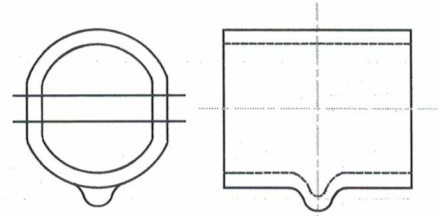
2nd Oper: Re-heat to 1650°F.

Quench barreled side in 21-1/2" of water & barrel
down HOT with HOT side up. Close dies to 1".

3rd Oper: Cut outlet hole per above.

4th Oper: Heat to 1650°F. — Do not quench. Do not close dies
and pull 6-3/4" plug.

5th Oper: Heat to 1650°F. — Do not quench. Do not close
dies pull 8-3/4" dia. plug (3" pull rod)



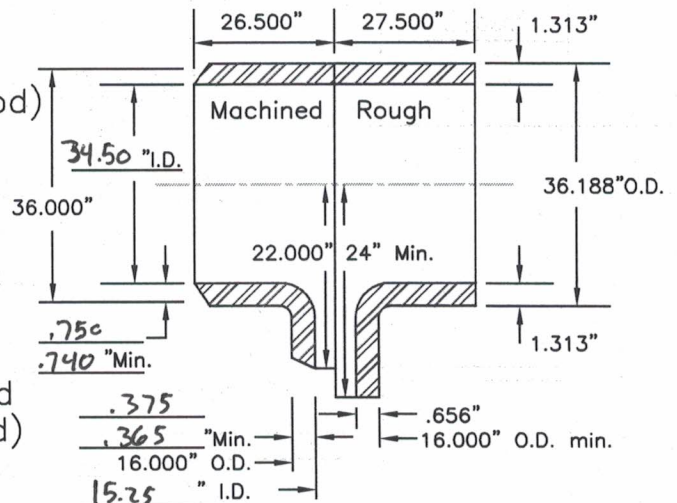
6th Oper: Heat to 1650°F.—Do not quench
Do not close dies and
Pull 10-3/4" dia. plug (3.5" pull rod)

7th Oper: Re-heat to 1650°F.—Do not
quench—Do not close dies and
Pull 12-3/4" dia. plug (4" pull rod)

Final Oper: Re-heat to 1650°F.

Do not quench—Close dies hot and
Pull 14.750" dia. plug (4" pull rod)

SHOP NOTE: Outlet may require end sizing.



				DATE: 11-19-99
				SCALE: NONE
				DRAWN BY: J.D.
2	added extra pins for manual pull	JL	10/11/16	CHECKED BY: Bull
1	changed outlet height	JL	9/9/15	
REV	DESCRIPTION	BY	DATE	

36" x 16"
.750 x .375
HIGH YIELD
TEE MFG. DATA

DWG#
36-16-5
Use for bevel thicknesses: 36: Run— .751" thru .833" 16" Outlet— .593" 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 1/4 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: 33.750 + 1/4 -0 34.500
0.750
0.740

BORE OUTLET I.D. STRAIGHT TO: 14.750 + 1/8 -0 15.250
0.375
0.365

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE