

Job Traveler

NEEDS TESTING

Job Number: 252448-02

Due Date: 03/13/2026



Sold MAVERICK INTERNATIONAL
To: P.O. BOX 1994
WINNIE, TX 77665
United States

Ship MAVERICK INTERNATIONAL
To: 10959 EAST HAMSHIRE ROAD
HAMSHIRE, TX 77622
United States

Order No: 252448	Dated: 10/22/202	Quote No: 35034
Customer: MAVERI255587		PO Num: 4058748
Ship Via: EMAIL BUBBA		Priority: 50
Part Number: *3TE3012Y		Product Code: TEE
Description: TE 30X12 1.00X.750 WPHY70		Master Job No:
SQUARE CUT		
-50F CVN		
MSSSP75-25		
Total Qty Open: 8 EA	Qty Posted: 0 EA	Qty To Make: 8
Start Date: 12/29/2025		Phone: 409-833-7878
Contact: BUBBA NELSON		Fax:

Job Notes

BCSR
B11160-1

***TEMPER AT 1100

USE QTY (1) AT 46 INCHES FROM PIPE SHOP TRAVELER 295-2025
USE QTY (1) AT 46 INCHES FROM PIPE SHOP TRAVELER 296-2025
USE QTY (1) AT 46 INCHES FROM PIPE SHOP TRAVELER 297-2025
USE QTY (1) AT 46 INCHES FROM PIPE SHOP TRAVELER 298-2025

BCOZ
B10878-1 TESTING REQ'ED

***TEMPER AT 1100

USE QTY (1) AT 46 INCHES FROM PIPE SHOP TRAVELER 299-2025
USE QTY (1) AT 46 INCHES FROM PIPE SHOP TRAVELER 301-2025

BCTP
B11304-1 TESTING REQ'ED

***TEMPER AT 1100

USE QTY (2) AT 46 INCHES FROM PIPE SHOP TRAVELER 300-2025

Routing

Routed By:

Quantity 8

Step No	Work Cntr / Vendor	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled ---	Run Quantity
Dept	Operation						Start	End
	Job Number: 252448-02							

10	PIPE 3 PLATE BURN	Burning Table Plate Burn	12/22/2025 12/22/2025	8
				
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating	12/24/2025 12/24/2025	8
				
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	12/24/2025 12/24/2025	8
				
40	PIPE 7 STRING UP	Initial Weld String-up	12/29/2025 12/29/2025	8
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	01/01/2026 01/01/2026	8
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	01/05/2026 01/05/2026	8
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	01/07/2026 01/07/2026	8
				
80	PIPE 9 OD WELD	OD Weld OD Weld	01/12/2026 01/12/2026	8
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	01/22/2026 01/26/2026	8
				

Job Number: 252448-02

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100	FORGE 8 TRIM	Torch Cut Cut hole	03/09/2026 03/10/2026	8
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	03/10/2026 03/10/2026	8
				
120	FORGE 8 TRIM	Torch Cut Trim	03/11/2026 03/12/2026	8
				
130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	12/14/2026 12/16/2026	8
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	12/16/2026 12/17/2026	8
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	12/17/2026 12/17/2026	8
				
160	E1 MACHINING	E1 Extender Expander	12/17/2026 12/21/2026	8
				
170	M1 MACHINING	M1 Big Mill Machining	12/21/2026 12/24/2026	8
				
180	STAMP 1 STAMP	Stamping	12/24/2026 12/24/2026	8
				

Job Number: 252448-02

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180 STAMP 1 Stamping 12/08/2026 12/08/2026 8
 STAMP



190 INSPECT 1 Inspection 1 12/08/2026 12/08/2026 8
 INSPECTION



200 SHIPPING Shipping 12/08/2026 12/08/2026 8
 SHIPPING



Time per Piece (HR): 0.000 0.000 0.000 0.000
 Total Time for Job (HR): 0.000 0.000 0.000

Materials List

Quantity				Unit	Description	Sub-Assy	Vendor
Needed	On Hand	Posted	Short				
28,944.00000	261,640.00000	25,570.00000	3,374.00000	LB	0PL15633	NO	SFI

PL0 1.5-A633-E
 Quantities from Bins/Lot Number:
 BCSR-01 (9611.0)
 BCSR-02 (5150.0)
 BCOZ-10 (4168.0)
 BCOZ-DROPS (3156.0)
 BCTP-03 (3485.0)

Pipe Shop Traveler Tee Cyl.

295-2025

12/16/2025

Pipe Shop Copy

Pipe Shop Original

Customer	MAVERICK		SFI Order No	252488-02	Due Date	2/13/2026
Part	34.000 OD X	1.500 X	46.000		Ship Date	3/13/2026
Plate Size	1.500 X	102.102 X	46.000		NoPcs	1
Heat No.	R4420				Code	BCSR
Material	A633E		Test Material		Test No	

Cut 1 Plate(s) 1.500 X Thick X 102.102 Width X 46.000 Length 1998 Lbs.

Per Sketch # 6363

From (Ø) Plate(s) 1.500 Thick X 61.000 Wide X 158.000 Long

Stamp Plates With Heat Code

BCSR

Scarf to 102.102 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 34.000 " O.D.

Tack Weld Using 3/16 " 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 1 Pcs @ 46 Inches

Paint Mark on Cylinder

MAVERICK

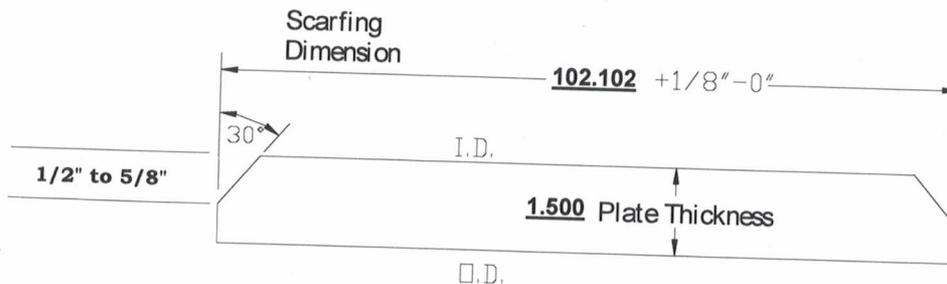
252488-02

Stamp Each Cylinder in (2) Places With Heat Code

BCSR

Fitting Description: (1) TE 30X12

Comments:



Pipe Shop Traveler Tee Cyl.

296-2025

12/16/2025

Pipe Shop Copy

Pipe Shop Original

Customer	MAVERICK			SFI Order No	252448-02	Due Date	2/13/2026
Part	34.000 od X	1.500 X	46.000			Ship Date	3/13/2026
Plate Size	1.500 X	102.102 X	46.000			NoPcs	1
Heat No.	A633E					Code	BCSR
Material	R4420	Test Material				Test No	

Cut 1 Plate(s) 1.500 X Thick X 102.102 Width X 46.000 Length 1998 Lbs.

Per Sketch # 6364

From (1) Plate(s) 1.500 Thick X 61.000 Wide X 160.000 Long

Stamp Plates With Heat Code

BCSR

Scarf to 102.102 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 34.000 " O.D.

Tack Weld Using 3/16 " 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 1 Pcs @ 46 Inches

Paint Mark on Cylinder

MAVERICK

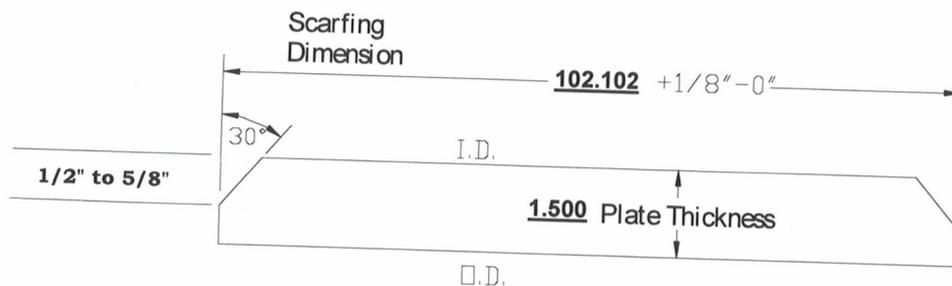
252448-02

Stamp Each Cylinder in (2) Places With Heat Code

BCSR

Fitting Description: (1) TEX3012

Comments:



Pipe Shop Traveler Tee Cyl.

297-2025

12/16/2025

Pipe Shop Copy

Pipe Shop Original

Customer	MAVERICK			SFI Order No	252448-02	Due Date	2/13/2026
Part	34.000 OD X	1.500 X	46.000			Ship Date	3/13/2026
Plate Size	1.500 X	102.102 X	46.000			NoPcs	1
Heat No.	R4420					Code	BCSR
Material	A633E Test Material					Test No	

Cut 1 Plate(s) 1.500 X Thick X 102.102 Width X 46.000 Length 1998 Lbs.

Per Sketch # 6407

From (1) Plate(s) 1.500 Thick X 55.000 Wide X 155.000 Long

Stamp Plates With Heat Code BCSR

Scarf to 102.102 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 34.000 " O.D.

Tack Weld Using 3/16 " 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 1 Pcs @ 46 Inches

Paint Mark on Cylinder MAVERICK

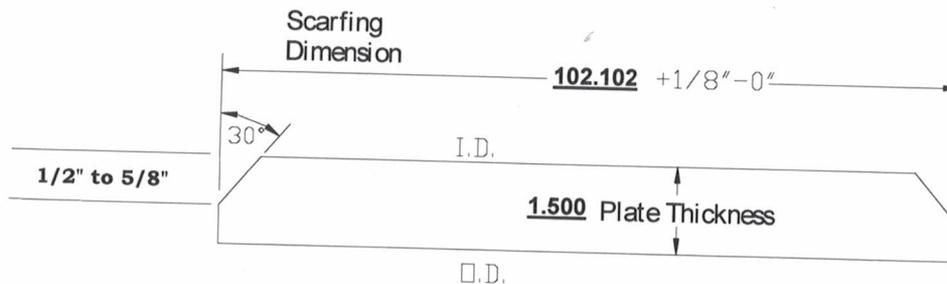
252448-02

Stamp Each Cylinder in (2) Places With Heat Code

BCSR

Fitting Description: (1) TE 30X12

Comments:



Pipe Shop Traveler Tee Cyl.

298-2025

12/16/2025

Pipe Shop Copy
 Pipe Shop Original

Customer	MAVERICK			SFI Order No	252448-02	Due Date	2/13/2026
Part	34.000 OD X	1.500 X	46.000			Ship Date	3/13/2026
Plate Size	1.500 X	102.102 X	46.000			NoPcs	1
Heat No.	R4420					Code	BCSR
Material	A633E	Test Material				Test No	

Cut 1 Plate(s) 1.500 X Thick X 102.102 Width X 46.000 Length 1998 Lbs.

Per Sketch # 6409

From (1) Plate(s) 1.500 Thick X 55.000 Wide X 123.000 Long

Stamp Plates With Heat Code **BCSR**

Scarf to 102.102 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 34.000 " O.D.

Tack Weld Using 3/16 " 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 1 Pcs @ 46 Inches

Paint Mark on Cylinder **MAVERICK**

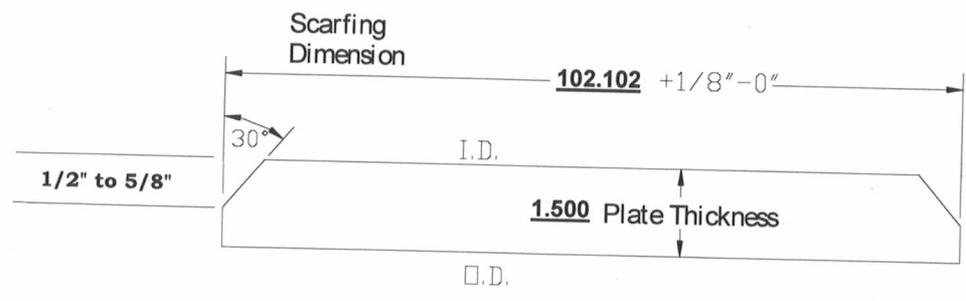
252448-02

Stamp Each Cylinder in (2) Places With Heat Code

BCSR

Fitting Description: **(1) TE30X12**

Comments:



Pipe Shop Traveler Tee Cyl.

299-2025

12/16/2025

Pipe Shop Copy

Pipe Shop Original

Customer	MAVERICK			SFI Order No	252448-02	Due Date	2/13/2026
Part	34.000 OD X	1.500 X	46.000			Ship Date	3/13/2026
Plate Size	1.500 X	102.102 X	46.000			NoPcs	1
Heat No.	R3504					Code	BCOZ
Material	A633E	Test Material				Test No	

Cut 1 Plate(s) 1.500 X Thick X 102.102 Width X 46.000 Length 1998 Lbs.
 Per Sketch # 6353

From (1) Plate(s) 1.500 Thick X 54.000 Wide X 170.000 Long

Stamp Plates With Heat Code BCOZ

Scarf to 102.102 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 34.000 " O.D.

Tack Weld Using 3/16 " 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 1 Pcs @ 46 Inches

Paint Mark on Cylinder MAVERICK

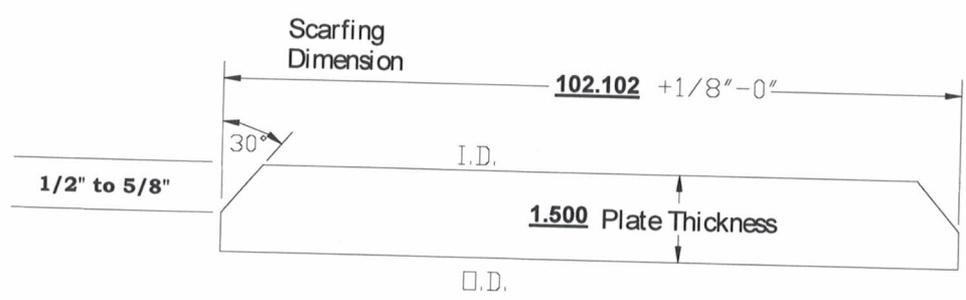
252448-02

Stamp Each Cylinder in (2) Places With Heat Code

BCOZ

Fitting Description: (1) TE30X12

Comments:



Pipe Shop Traveler Tee Cyl.

300-2025

12/29/2025

Pipe Shop Copy

Pipe Shop Original

Customer	MAVERICK			SFI Order No	252448-02	Due Date	2/13/2026
Part	34.000 OD X	1.500 X	94.000			Ship Date	3/13/2026
Plate Size	1.500 X	102.102 X	94.000			NoPcs	1
Heat No.	R5273					Code	BCTP
Material	A633E	Test Material				Test No	

Cut 1 Plate(s) 1.500 X Thick X 102.102 Width X 94.000 Length 4083 Lbs.

Per Sketch # 6531

From (1) Plate(s) 1.500 Thick X 129.000 Wide X 125.000 Long

Stamp Plates With Heat Code BCTP

Scarf to 102.102 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 34.000 " O.D.

Tack Weld Using 3/16 " 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

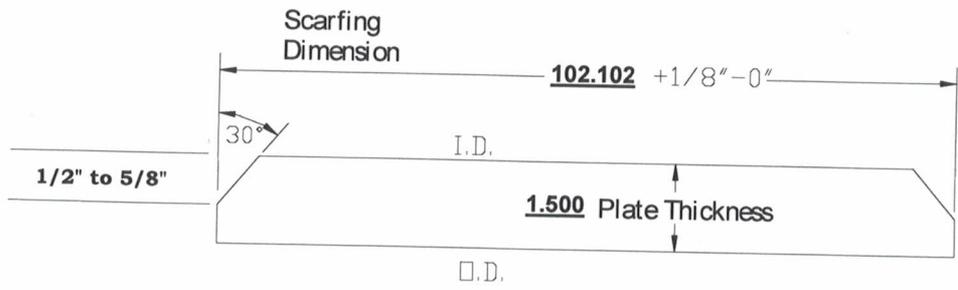
Torch Cut Into 2 Pcs @ 46 Inches

Paint Mark on Cylinder MAVERICK 252448-02

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

Fitting Description: (2) TE 30X12

Comments:



Pipe Shop Traveler Tee Cyl.

301-2025

12/16/2025

Pipe Shop Copy
 Pipe Shop Original

Customer	MAVERICK			SFI Order No	252448-02	Due Date	2/13/2026
Part	34.000 OD	X	1.500 X	46.000		Ship Date	3/13/2026
Plate Size	1.500	X	102.102 X	46.000		NoPcs	1
Heat No.	R5981					Code	BCOZ
Material	A633E			Test Material		Test No	

Cut 1 Plate(s) 1.500 X Thick X 102.102 Width X 46.000 Length 1998 Lbs.

Per Sketch # 6354

From (1) Plate(s) 1.500 Thick X 49.000 Wide X 164.000 Long

Stamp Plates With Heat Code BCOZ

Scarf to 102.102 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 34.000 " O.D.

Tack Weld Using 3/16 " 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

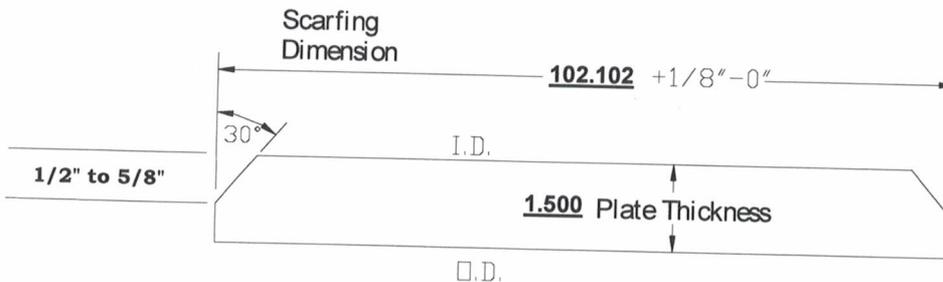
Torch Cut Into 1 Pcs @ 46 Inches

Paint Mark on Cylinder MAVERICK 252448-02

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

Fitting Description: (1) TE 30X12

Comments:

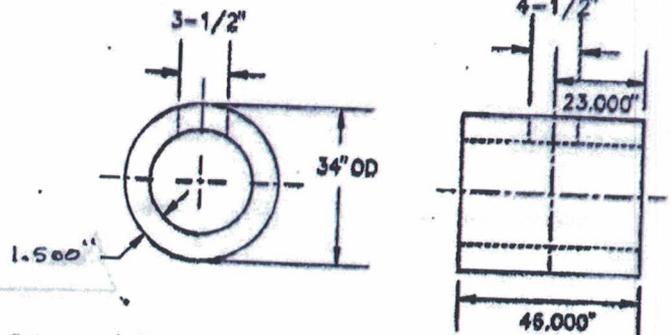


30" Run Diameter = 30.476"
 12" Outlet Diameter = 13.125"

OVERSIZE 34" CYLINDER

Material Size 34" O.D. x 1.500" PLT.
 Length 46.000"

Hole size 3-1/2" x 4-1/2" Oval
 Grind 1/8" radius on hole edges
 I.D. & O.D.



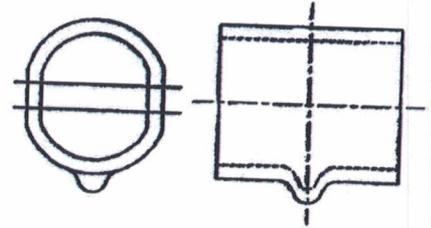
Ovaling Data: Oval: HOT Oval width: 29-1/2" ± .1/4"

Preform Data:

Press: Machine 2000 Ton Set up #10138 Upper Die # 50037
 Lower Die # 50086 (with 12" insert)

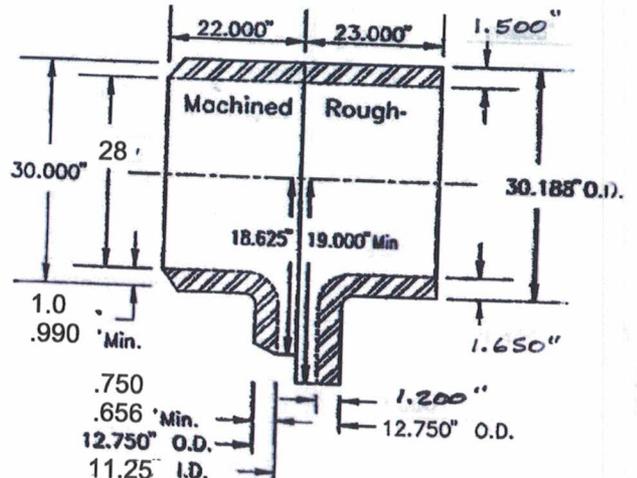
1st Oper: Heat to 1650°F
 Quench in 23-1/2" of water
 Close dies to 6" &
 Pull 6" plug(3" rod)

2nd Oper: Re-heat to 1650°F
 Quench in 21" of water
 Close dies to 3-1/2" &
 Pull 8-1/2" plug(3-1/2" rod)



3rd Oper: Re-heat to 1650°F
 Quench in 18-1/2" of water
 Close dies HOT to 1" &
 Pull 10 11/16" plug(4" rod)

Final Oper: Re-heat to 1650°F
 Do not quench
 Close dies HOT &
 Re-pull 10 11/16" plug(4" rod)



			DATE: 4-25-97	30" x 12" (1.0 X .750)	DWG# 30-12-5 MODIFIED
			SCALE: NONE		
			DRAWN BY: J.DAVIDSON		
			CHECKED BY: E&B		
REV	DESCRIPTION	BY	DATE	HIGH YIELD TEE MFG. DATA	

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCSR
30X12
1.0X.750
WPHY70
252448-02

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCTP
30X12
1.0X.750
WPHY70
252448-02

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCOZ
30X12
1.0X.750
WPHY70
252448-02

FORM BY EXTRUSION PER CARD: _____

HOLE LOCATION MUST BE VERIFIED AND SIGNED OFF _____

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: 11.000 ± 1/16 11.250
0.750
0.656

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE