

Job Traveler

Job Number: 252495-02



Due Date: 02/13/2026

Sold SMP SUPPLY
To: PO BOX 1675
MONT BELVIEU, TX 77523

Ship SMP SUPPLY
To: 8626 UNITY DRIVE
Baytown, TX 77523
United States

Order No: 252495	Dated: 10/28/202	Quote No:
Customer: SMP SUPPLY		PO Num: 134735-1
Ship Via: AMOSIER@SMP-SUPPLY.COM		Priority: 3 - STANDARD
Part Number: *3TE4220Y		Product Code: TEE
Description: TE 42X20 .888 X .500- WPHY70		Master Job No:
MSSSP75-19		
Total Qty Open: 25 EA	Qty Posted: 0 EA	Qty To Make: 25

Start Date: 11/06/2025

Contact: CHRIS ACKER

Phone: (713)840-9333

Fax: (713)840-9339

Job Notes

BCVB 1-4
B11467
USE QTY (4) CYLINDERS FROM PIPE SHOP TRAVLER 244-2025

TEMPERING TEMP AT 1100

BCWJ 5-8
B11633 TESTING REQ'ED
USE QTY (4) CYLINDERS FROM PIPE SHOP TRAVLER 245-2025

TEMPERING TEMP AT 1100

BCVO 9-20
B11634 TESTING REQ'ED
USE QTY (12) CYLINDERS FROM PIPE SHOP TRAVLER 246-2025

TEMPERING TEMP AT 1100

BCUR 21-24
B11422
USE QTY (4) CYLINDERS FROM PIPE SHOP TRAVLER 247-2025

TEMPERING TEMP AT 1200

BCPD 25
B10890
USE QTY (1) CYLINDERS FROM PIPE SHOP TRAVLER 248-2025

TEMPERING TEMP AT 1100

Routing

Routed By:

Quantity 25

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

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10	PIPE 3 PLATE BURN	Burning Table Plate Burn	11/06/2025 11/06/2025	25
				
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating	11/11/2025 11/11/2025	25
				
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	11/11/2025 11/11/2025	25
				
40	PIPE 7 STRING UP	Initial Weld String-up	11/11/2025 11/11/2025	25
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	11/13/2025 11/13/2025	25
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	11/17/2025 11/17/2025	25
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	11/18/2025 11/18/2025	25
				
80	PIPE 9 OD WELD	OD Weld OD Weld	11/19/2025 11/19/2025	25
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	11/26/2025 11/27/2025	25
				

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100	FORGE 8 TRIM	Torch Cut Cut hole	01/22/2026 01/22/2026	25
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	01/22/2026 01/22/2026	25
				
120	FORGE 8 TRIM	Torch Cut Trim	01/22/2026 01/28/2026	25
				
130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	10/21/2026 10/29/2026	25
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	10/29/2026 11/03/2026	25
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	11/03/2026 11/05/2026	25
				
160	E1 MACHINING	E1 Extender Expander	11/05/2026 11/05/2026	25
				
170	M1 MACHINING	M1 Big Mill Machining	11/05/2026 11/26/2026	25
				
180	STAMP 1 STAMP	Stamping	11/26/2026 11/26/2026	25
				

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INSPECT 1
INSPECTION

Inspection 1

11/26/2026 11/26/2026

25



200

SHIPPING
SHIPPING

Shipping

11/26/2026 11/26/2026

25



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: 25

----- Quantity -----									
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>	<u>Unit</u>	<u>Description</u>			<u>Sub- Assy</u>	<u>Vendor</u>
104,374.00000	281,384.00000	104,374.00000	0.00000	LB	0PL1375633			NO	CLIFF STEEL
					PL0 1.375-A633-E				
					Quantities from Bins/Lot Number:				
					BCUR-04 (10770.0)	} 14701 ea.			
					BCVO-05 (40250.0)				
					BCVO-03 (40250.0)				
					BCVO-04 (40250.0)				
					BCWJ-01 (14927.0)				
					BCVB-15 (14927.0)				
4,228.00000	275,030.00000	4,228.00000	0.00000	LB	0PL15633			NO	CLIFF STEEL
					PL0 1.5-A633-E				
					Quantities from Bins/Lot Number:				
					BCPD (4228.0)				

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Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

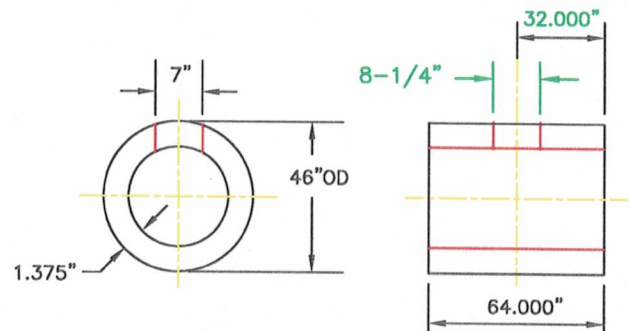
BCVB
42X20
.888X.500
WPHY70
252495-02

42" Run Diameter = 42.785"
 20" Outlet Diameter = 20.700"

Material Size 46" O.D. x 1.375"W
 Length 64.000"

Ovaling Data: Oval HOT to: 42"±1/4"

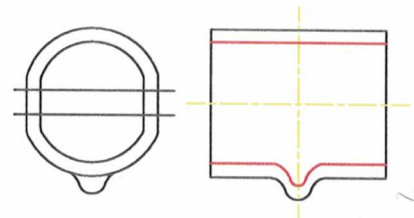
Hole size -torch cut 7"x8-1/4" oval
 Grind 1/8" radius on hole edges
 I.D. & O.D.



Preform Data:

Press: Machine 2000 Ton Set up#10391 Upper Die# 50048
 Lower Die# 50151 with 42x20" Insert #41622-2

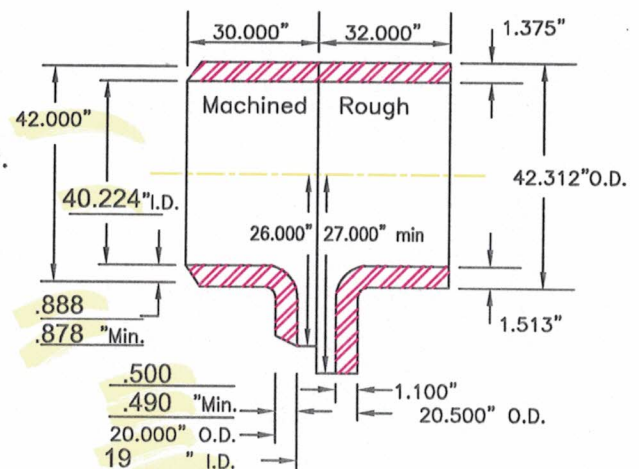
1st Oper: Heat to 1650°F.
 Quench in 27-1/2 inches of water.
 Close dies to 3-1/2" and
 Pull 11-1/2" dia. plug (4" pull rod).



2nd Oper: Re-heat to 1650°F.
 Quench in 26 inches of water
 Close dies to 2" and
 Pull 14" plug (4" pull rod).

3rd Oper: Re-heat to 1650°F.
 Quench in 25 inches of water
 Close dies to 1" and
 Pull 16-1/4" plug (4" pull rod).

4th Oper: Re-heat to 1650°F.
 Do not quench
 Close dies hot and
 Pull 18-1/4" dia. plug
 (4" pull rod)



				DATE: 12-9-99	42 x 20" .888 X .500	DWG# 42-20-3
				SCALE: NONE		
				DRAWN BY: J.D.		
				CHECKED BY: Bull		
1	Add operation 2	JD	8/7/25		HIGH YIELD	Use for bevel thicknesses: Run-.834" thru-.916". Outlet-.812" max.
REV	DESCRIPTION	BY	DATE		TEE MFG. DATA	

Pipe Shop Traveler Tee Cyl.

244-2025

11/3/2025

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>SMP</u>	SFI Order No	<u>252495-02</u>	Due Date	<u>1/5/2026</u>
Part	<u>46.000</u> OD X <u>1.375</u> X <u>64.000</u>			Ship Date	<u>2/13/2026</u>
Plate Size	<u>1.375</u> X <u>140.194</u> X <u>64.000</u>			NoPcs	<u>4</u>
Heat No.	<u>R5971</u>			Code	<u>BCVB-15</u>
Material	<u>A633E</u>	Test Material		Test No	

Cut 4 Plate(s) 1.375 X Thick X 140.194 Width X 64.000 Length 3499 Lbs.
Per Sketch #

From (1) Plate(s) 1.375 Thick X 132.000 Wide X 290.000 Long

Stamp Plates With Heat Code BCVB-15

Scarf to 140.194 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 46.000 " 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

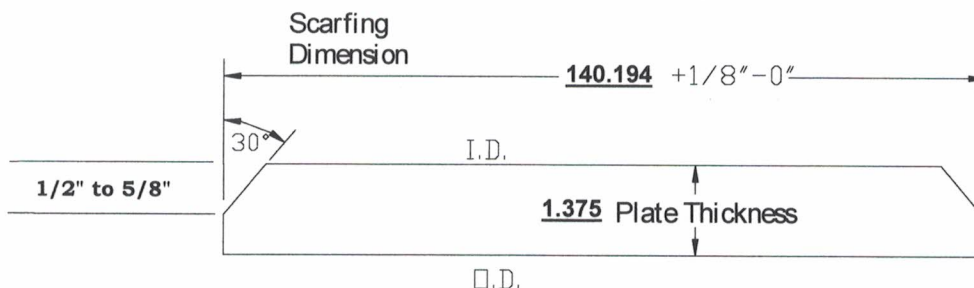
Torch Cut Into 4 Pcs @ 64 Inches

Paint Mark on Cylinder SMP 252495-02

Stamp Each Cylinder in (2) Places With Heat Code BCVB-15

Fitting Description: QTY(4) TE 42X20

Comments:



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

0.888

BORE RUN I.D. STRAIGHT TO: 39.474 + 1/4 -0 40.224

0.878

0.500

BORE OUTLET I.D. STRAIGHT TO: 18.500 + 1/8 -0 19.000

0.490

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE

BCAD Qty 1
BCVB Qty 4
BCVO Qty 12
BCWS Qty 4

Pipe Shop Traveler Tee Cyl.

244-2025

11/3/2025

☐ Pipe Shop Copy
☐ Pipe Shop Original

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Plate Size	<u>1.375</u> X <u>140.194</u> X <u>64.000</u>	Code	<u>BCVB-15</u>	Test No	
Heat No.	<u>R5971</u>	Test Material			
Material	<u>A633E</u>				

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Stamp Each Cylinder in (2) Places With Heat Code BCVB-15

Fitting Description: QTY(4) TE 42X20

Comments:

