

Job Traveler

Job Number: 252504-01



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: 252504	Dated: 10/28/202	Quote No:
Customer: SMP SUPPLY		PO Num: 134737-1
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: 18 EA	Qty Posted: 0 EA	Qty To Make: 18

Start Date: 12/08/2025

Contact: CHRIS ACKER

Phone: (713)840-9333

Fax: (713)840-9339

Job Notes

BCRX
B11043 - TESTING REQ'ED

USE QTY (8) CYLINDERS FROM PIPE SHOP TRAVELER 262-2025

BCWM
B11649 - TESTING REQ'ED

USE QTY (8) CYLINDERS FROM PIPE SHOP TRAVELER 263-2025

BCWZ
B11648 - TESTING REQ'ED

USE QTY (2) CYLINDERS FROM PIPE SHOP TRAVELER 264-2025

Routing

Routed By:

Quantity 18

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- Start End		Run Quantity
10	PIPE 3 PLATE BURN	Burning Table Plate Burn					12/08/2025	12/08/2025	18



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Report Generated: 11/24/2025 2:06:51

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20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating	12/09/2025 12/09/2025	18
				
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller	12/10/2025 12/10/2025	18
				
40	PIPE 7 STRING UP	Initial Weld String-up	12/11/2025 12/11/2025	18
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	12/17/2025 12/17/2025	18
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	12/18/2025 12/18/2025	18
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	12/23/2025 12/23/2025	18
				
80	PIPE 9 OD WELD	OD Weld OD Weld	12/25/2025 12/25/2025	18
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	01/01/2026 01/05/2026	18
				
100	FORGE 8 TRIM	Torch Cut Cut hole	02/11/2026 02/12/2026	18
				

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110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	02/12/2026 02/12/2026	18
				
120	FORGE 8 TRIM	Torch Cut Trim	02/23/2026 02/25/2026	18
				
130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	01/25/2027 02/01/2027	18
				
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/01/2027 02/02/2027	18
				
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/02/2027 02/03/2027	18
				
160	E1 MACHINING	E1 Extender Expander	02/03/2027 02/04/2027	18
				
170	M1 MACHINING	M1 Big Mill Machining	02/04/2027 02/18/2027	18
				
180	STAMP 1 STAMP	Stamping	02/18/2027 02/18/2027	18
				
190	INSPECT 1 INSPECTION	Inspection 1	02/18/2027 02/18/2027	18
				

Job Number: 252504-01



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 -----						Quantity: 18
<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>
64,579.00000	205,813.00000	64,579.00000	0.00000	LB	0PL1375633	NO CLIFF STEEL
					PL0 1.375-A633-E	
					Quantities from Bins/Lot Number:	
					BCRX-04 (14438.0)	
					BCRX-05 (14214.0)	
					BCWM-01 (14214.0)	
					BCWM-02 (14438.0)	
					BCWZ-01 (7275.0)	

Pipe Shop Traveler Tee Cyl.

262-2025

11/24/2025

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>SMP</u>	SFI Order No	<u>252604-01</u>	Due Date	<u>1/16/2026</u>
Part	<u>46.000</u> OD X <u>1.375</u> X <u>64.000</u>	Ship Date	<u>2/13/2026</u>	NoPcs	<u>8</u>
Plate Size	<u>1.375</u> X <u>140.194</u> X <u>64.000</u>	Code	<u>BCRX-04,05</u>	Test No	
Heat No.	<u>R4094</u>				
Material	<u>A633E</u>	Test Material			

Cut 8 Plate(s) 1.375 X Thick X 140.194 Width X 64.000 Length 3499 Lbs.

Per Sketch #

From (2) Plate(s) 1.375 Thick X 130.000 Wide X 390.000 Long

Stamp Plates With Heat Code

BCRX-04,05

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

Condition Grind Weld Bevels

Roll Hot To 46.000 " 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 0 Pcs @

0

Inches

Paint Mark on Cylinder

SMP

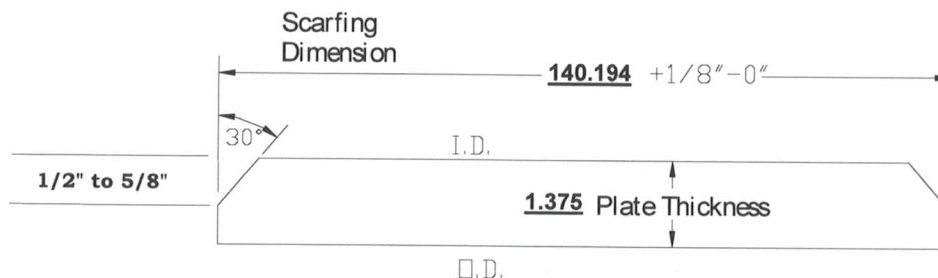
252604-01

Stamp Each Cylinder in (2) Places With Heat Code

BCRX-04,05

Fitting Description: QTY (8) TE 42X20

Comments:



Pipe Shop Traveler Tee Cyl.

263-2025

11/24/2025

☐ Pipe Shop Copy

☐ Pipe Shop Original

Customer	<u>SMP</u>			SFI Order No	<u>252604-01</u>	Due Date	<u>1/16/2026</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>8</u>	
Heat No.	<u>R6636</u>						Code	<u>BCWM -01,02</u>	
Material	<u>A633E</u>			Test Material	<u>CUT (8) 6X12 FOR (4) 12X12</u>			Test No	<u>B11649</u>

Cut 8 Plate(s) 1.375 X Thick X 140.194 Width X 64.000 Length 3499 Lbs.

Per Sketch #

From (2) Plate(s) 1.375 Thick X 130.000 Wide X 390.000 Long

Stamp Plates With Heat Code

BCWM -01,02

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

Condition Grind Weld Bevels

Roll Hot To 46.000 " 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 8 Pcs @ 64 Inches

Paint Mark on Cylinder

SMP

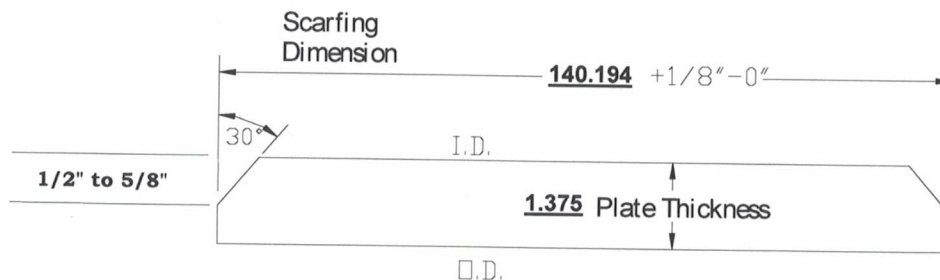
252604-01

Stamp Each Cylinder in (2) Places With Heat Code

BCWM -01,02

Fitting Description: QTY (8) TE 42X20

Comments:



Pipe Shop Traveler Tee Cyl.

264-2025

11/24/2025

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	<u>SMP</u>			SFI Order No	<u>252054-01</u>	Due Date	<u>1/16/2026</u>	
Part	<u>46.000</u>	OD	X	<u>1.375</u>	X	<u>64.000</u>	Ship Date	<u>2/13/2016</u>
Plate Size	<u>1.375</u>		X	<u>140.194</u>	X	<u>64.000</u>	NoPcs	<u>2</u>
Heat No.	<u>R6708</u>						Code	<u>BCWZ-01</u>
Material	<u>A633E</u>			Test Material	<u>CUT (6) 6X12 FOR (3) 12X12</u>		Test No	<u>B11648</u>

Cut 2 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 130.000 Wide X 390.000 Long

Stamp Plates With Heat Code

BCWZ-01

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

Condition Grind Weld Bevels

Roll Hot To 46.000 " 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 @ 64 Inches

Paint Mark on Cylinder

SMP

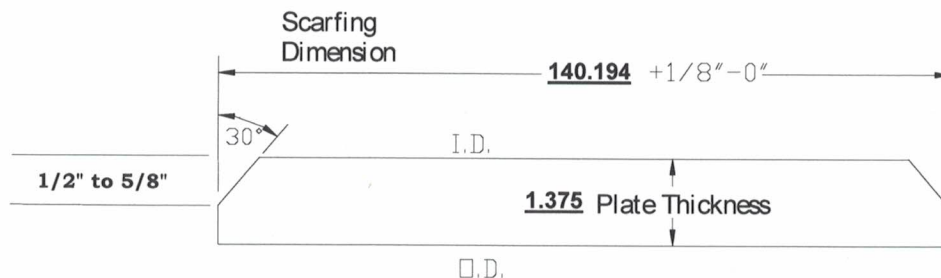
252054-01

Stamp Each Cylinder in (2) Places With Heat Code

BCWZ-01

Fitting Description: QTY (2) TE 42X420

Comments:

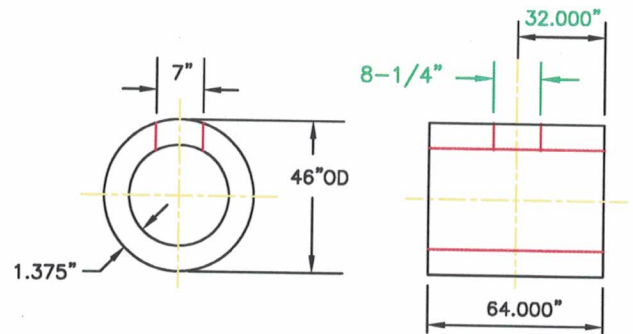


42" Run Diameter = 42.785"
 20" Outlet Diameter = 20.700"

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

Ovaling Data: Oval HOT to: 42"±1/4"

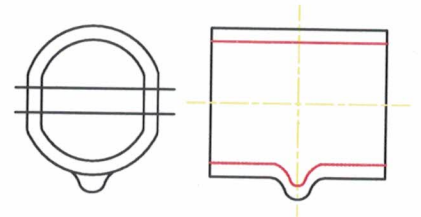
Hole size -torch cut 7"x8-1/4" oval
 Grind 1/8" radius on hole edges
 I.D. & O.D.



Preform Data:

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

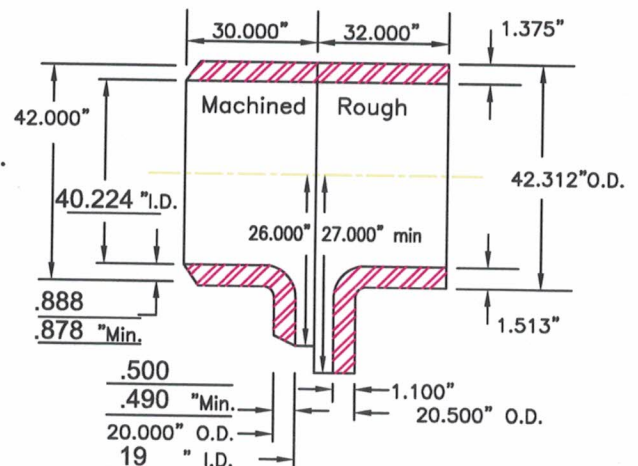
1st Oper: Heat to 1650°F.
 Quench in 27-1/2 inches of water.
 Close dies to 3-1/2" and
 Pull 11-1/2" dia. plug (4" pull rod).



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 TEE MFG. DATA	Use for bevel thicknesses: Run-.834" thru.916". Outlet-.812" max.
REV	DESCRIPTION	BY	DATE			

BCRX 4TY(8)

BLUM 4TY(8) BLWZ QTY(2)

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: 39.474 + 1/4 -0 40.224
0.888
0.878

BORE OUTLET I.D. STRAIGHT TO: 18.500 + 1/8 -0 19.000
0.500
0.490

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCWZ
42X20
.888X.500
WPHY70
252504-01

Qty (2)

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCWM
42X20
.888X.500
WPHY70
252504-01

Qty (8)

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCRX
42X20
.888X.500
WPHY70
252504-01

Qty (8)