

# Job Traveler

Job Number: 252777-09



Due Date: 02/17/2026

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

**Ship** MAVERICK 201 WAREHOUS  
**To:** 18291 Englin Rd.  
Winnie, TX 77665  
United States

**Order No:** 252777

**Dated:** 12/04/202

**Quote No:** 35915

**Customer:** MAVERI255587

**PO Num:** 4059760

**Ship Via:** BUBBA.NELSON@MAVINT.COM

**Priority:** 3 - STANDARD

**Part Number:** \*3TE3020Y

**Product Code:** TEE

**Description:** TE 30X20 .750 X .500-  
WPHY60

**Master Job No:**

M8120

**Total Qty Open:** 15 EA

**Qty Posted:** 0 EA

**Qty To Make:** 15

**Start Date:** 12/25/2025

**Phone:** 409-833-7878

**Contact:** BUBBA NELSON

**Fax:**

## Job Notes

BCKV  
B10579

\*\*\*TEMPER AT 1100 QTY 2

USE QTY (2) AT 46 INCHES FROM PIPE SHOP TRAVELER 286-2025

BCUP  
B11419

\*\*\*TEMPER AT 1200 QTY 5

USE QTY (2) AT 46 INCHES FROM PIPE SHOP TRAVELER 287-2025  
USE QTY (2) AT 46 INCHES FROM PIPE SHOP TRAVELER 288-2025  
USE QTY (1) AT 46 INCHES FROM PIPE SHOP TRAVELER 289-2025

BCLV  
B10661

\*\*\*TEMPER AT 1100 QTY 1

USE QTY (1) AT 46 INCHES FROM PIPE SHOP TRAVELER 290-2025

BCUL  
B11402

\*\*\*TEMPER AT 1200 QTY 2

USE QTY (2) AT 46 INCHES FROM PIPE SHOP TRAVELER 291-2025

BCVL  
B11489 - TESTING REQ'ED

\*\*\*TEMPER AT 1100 QTY 5

USE QTY (3) AT 46 INCHES FROM PIPE SHOP TRAVELER 292-2025  
USE QTY (2) AT 46 INCHES FROM PIPE SHOP TRAVELER 293-2025

JD

## Routing

Routed By:

Quantity 15

| Step No<br><u>Dept</u>                                                                                                                                                  | Work Cntr / Vendor<br><u>Operation</u> | <u>Description</u>                 | <u>Setup</u><br><u>Time</u> | <u>Cycle</u><br><u>Time</u> | <u>Total</u><br><u>Time</u> | <u>Pieces</u><br><u>Per Hour</u> | <u>--- Scheduled ---</u><br><u>Start</u> <u>End</u> |            | <u>Run</u><br><u>Quantity</u> |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------|------------------------------------|-----------------------------|-----------------------------|-----------------------------|----------------------------------|-----------------------------------------------------|------------|-------------------------------|
| 10                                                                                                                                                                      | PIPE 3<br>PLATE BURN                   | Burning Table<br>Plate Burn        |                             |                             |                             |                                  | 12/22/2025                                          | 12/22/2025 | 15                            |
|       |                                        |                                    |                             |                             |                             |                                  |                                                     |            |                               |
| 20                                                                                                                                                                      | PIPE 6<br>FURNACE HEAT                 | Pipe Furnace<br>Furnace heating    |                             |                             |                             |                                  | 12/23/2025                                          | 12/24/2025 | 15                            |
|       |                                        |                                    |                             |                             |                             |                                  |                                                     |            |                               |
| 30                                                                                                                                                                      | PIPE 4<br>BIG ROLL                     | Big Roller<br>Roll on large roller |                             |                             |                             |                                  | 12/24/2025                                          | 12/24/2025 | 15                            |
|       |                                        |                                    |                             |                             |                             |                                  |                                                     |            |                               |
| 40                                                                                                                                                                      | PIPE 7<br>STRING UP                    | Initial Weld<br>String-up          |                             |                             |                             |                                  | 12/29/2025                                          | 12/29/2025 | 15                            |
|     |                                        |                                    |                             |                             |                             |                                  |                                                     |            |                               |
| 50                                                                                                                                                                      | PIPE 8<br>ID WELD # 1                  | ID Weld # 1<br>ID Weld             |                             |                             |                             |                                  | 01/01/2026                                          | 01/01/2026 | 15                            |
|   |                                        |                                    |                             |                             |                             |                                  |                                                     |            |                               |
| 60                                                                                                                                                                      | PIPE 12<br>PIPE GOUGE                  | Pipe Gouge<br>Pipe gouge           |                             |                             |                             |                                  | 01/05/2026                                          | 01/05/2026 | 15                            |
|   |                                        |                                    |                             |                             |                             |                                  |                                                     |            |                               |
| 70                                                                                                                                                                      | PIPE 5<br>WELD PREP                    | Grind After Gouge<br>Weld prep     |                             |                             |                             |                                  | 01/07/2026                                          | 01/07/2026 | 15                            |
|   |                                        |                                    |                             |                             |                             |                                  |                                                     |            |                               |
| 80                                                                                                                                                                      | PIPE 9<br>OD WELD                      | OD Weld<br>OD Weld                 |                             |                             |                             |                                  | 01/12/2026                                          | 01/12/2026 | 15                            |
|   |                                        |                                    |                             |                             |                             |                                  |                                                     |            |                               |

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|                                                                                     |                                                                                     |                               |                       |    |
|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------|-----------------------|----|
| 90                                                                                  | FORGE 10<br>CYLINDER CUT                                                            | Cylinder Cut<br>Cylinder Cut  | 01/22/2026 01/22/2026 | 15 |
|    |    |                               |                       |    |
| 100                                                                                 | FORGE 8<br>TRIM                                                                     | Torch Cut<br>Cut hole         | 03/09/2026 03/09/2026 | 15 |
|    |    |                               |                       |    |
| 110                                                                                 | FORGE 12<br>FORM/PRESS                                                              | 2000 Ton Press<br>Forming     | 03/09/2026 03/10/2026 | 15 |
|    |    |                               |                       |    |
| 120                                                                                 | FORGE 8<br>TRIM                                                                     | Torch Cut<br>Trim             | 03/10/2026 03/11/2026 | 15 |
|    |    |                               |                       |    |
| 130                                                                                 | FORGE 7<br>HEAT TREAT                                                               | Heat Treat<br>Heat treat      | 12/02/2026 12/08/2026 | 15 |
|   |   |                               |                       |    |
| 140                                                                                 | FORGE 5-6<br>FORGE BLAST                                                            | Forge Shotblast<br>Shot blast | 12/08/2026 12/10/2026 | 15 |
|  |  |                               |                       |    |
| 150                                                                                 | PIPE 13<br>X RAY                                                                    | Pipe X Ray<br>X-ray           | 12/10/2026 12/10/2026 | 15 |
|  |  |                               |                       |    |
| 160                                                                                 | E1<br>MACHINING                                                                     | E1 Extender<br>Expander       | 12/10/2026 12/14/2026 | 15 |
|   |  |                               |                       |    |
| 170                                                                                 | M1<br>MACHINING                                                                     | M1 Big Mill<br>Machining      | 12/14/2026 12/24/2026 | 15 |
|   |  |                               |                       |    |

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180

STAMP 1  
STAMP

Stamping

12/24/2026 12/24/2026

15



190

INSPECT 1  
INSPECTION

Inspection 1

12/24/2026 12/24/2026

15



200

SHIPPING  
SHIPPING

Shipping

12/24/2026 12/24/2026

15



|                          |       |       |       |       |
|--------------------------|-------|-------|-------|-------|
| 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: 15        |
|--------------|---------------------|--------------|---------|------|-------------|---------------------|
| Needed       | On Hand             | Posted       | Short   | Unit | Description | Sub-<br>Assy Vendor |
| 29,365.00000 | 1,800,846.0000<br>0 | 29,365.00000 | 0.00000 | LB   | 0PL125633   | NO SFI              |

PL0 1.25-A633-E

Quantities from Bins/Lot Number:

BCLV (2144.0)

BCUL-05 (7288.0)

BCUL-06 (1729.0)

BCUP-02 (6694.0)

BCUP-03 (6694.0)

BCKV-05 (4816.0)

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# Pipe Shop Traveler Tee Cyl.

291-2025

12/15/2025

☐ Pipe Shop Copy  
☐ Pipe Shop Original

|            |                 |    |   |                |                  |               |                  |                  |
|------------|-----------------|----|---|----------------|------------------|---------------|------------------|------------------|
| Customer   | <u>MAVERICK</u> |    |   | SFI Order No   | <u>252777-09</u> | Due Date      | <u>1/19/2026</u> |                  |
| Part       | <u>35.000</u>   | OD | X | <u>1.250</u>   | X                | <u>94.000</u> | Ship Date        | <u>2/17/2026</u> |
| Plate Size | <u>1.250</u>    |    | X | <u>106.029</u> | X                | <u>94.000</u> | NoPcs            | <u>1</u>         |
| Heat No.   | <u>R5550</u>    |    |   |                |                  | Code          | <u>BCUL</u>      |                  |
| Material   | <u>A633E</u>    |    |   | Test Material  |                  | Test No       |                  |                  |

Cut **1** Plate(s) **1.250** X Thick X **106.029** Width X **94.000** Length **3533** Lbs.

Per Sketch # **6520**

From ( **1** ) Plate(s) **1.250** Thick X **104.000** Wide X **109.000** Long

Stamp Plates With Heat Code **BCUL**

Scarf to **106.029** + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To **35.000** " 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

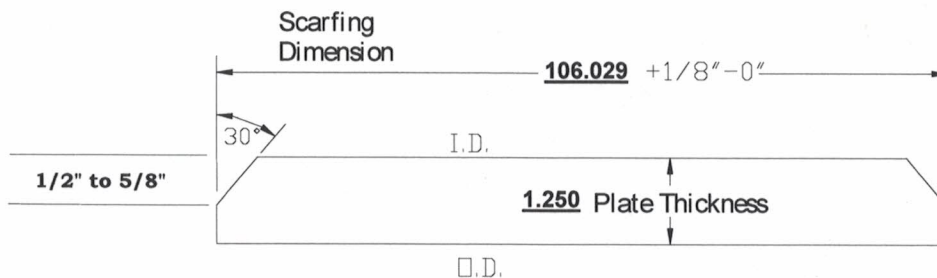
Torch Cut Into **2** Pcs @ **46** Inches

Paint Mark on Cylinder **MAVERICK** **252777-09**

Stamp Each Cylinder in (2) Places With Heat Code **BCUL**

Fitting Description: **(2) TE 30X20**

Comments:



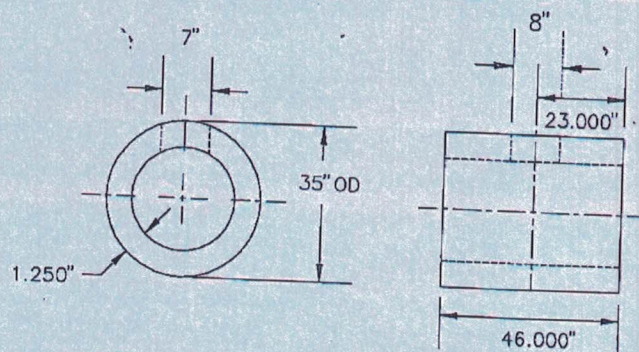
30" Run Diameter = 30.476"

20" Outlet Diameter = 20.523"

Material Size 35" O.D. x 1.250" W  
Length 46.000"

Hole size 7" x 8" Oval

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



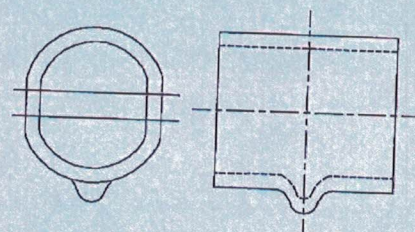
Ovaling Data: Oval: HOT Oval width: 29-3/4" ± .1/4"

Preform Data:

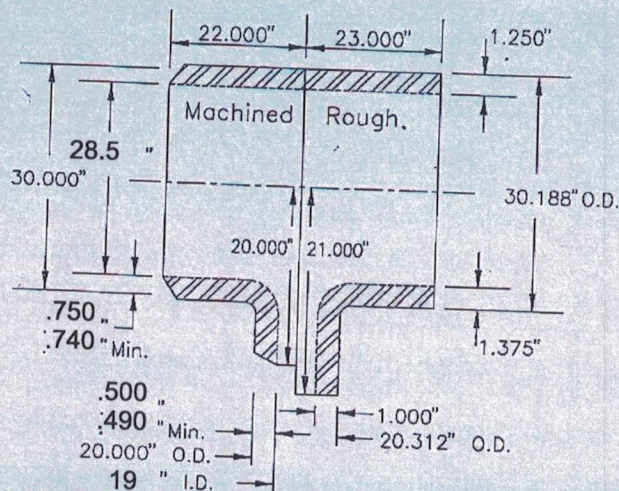
Press: Machine 2000 Ton Set up#10138 Upper Die# 50037  
Lower Die# 50083

1st Oper: Heat to 1650°F  
Quench in 22-1/2" of water  
Close dies to 4"  
Pull 11-1/4" plug(4" rod)

2nd Oper: Re-heat to 1650°F  
Quench in 18-1/2" of water  
Close dies to 1-1/2" &  
Pull 15-7/8" plug(4" rod)



Final Oper: Re-heat to 1650°F  
Do not quench  
Close dies &  
Pull 18-1/4" plug(4" rod)



|     |             |    |      |                      |
|-----|-------------|----|------|----------------------|
|     |             |    |      | DATE: 4-6-10         |
|     |             |    |      | SCALE: NONE          |
|     |             |    |      | DRAWN BY: J.DAVIDSON |
|     |             |    |      | CHECKED BY: JL       |
| REV | DESCRIPTION | BY | DATE |                      |

30" x 20"  
(.750 x .500)  
HIGH YIELD  
TEE MFG. DATA

DWG#  
30-20-4A

**Marking Information:**



***FLEET-LINE***

MADE IN USA  
STEEL FORGINGS

BCUL  
30X20  
.750X.500  
WPHY60  
252777-09

BCUP QTY(5)

BCUL QTY(1)

**DO NOT USE GRADE C MATERIAL**

HOLE LOCATION MUST BE VERIFIED AND SIGNED OFF \_\_\_\_\_

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 @ 1200 °F - AIR COOL - FURNACE LOAD# \_\_\_\_\_

SHOTBLAST TO NEAR WHITE FINISH

**100% RADIOGRAPH WELD SEAM PER SPEC. XL-RT-100 (LATEST REVISION)** \_\_\_\_\_

0.750

BORE RUN I.D. STRAIGHT TO: 27.750 + 1/4 -0 28.500

0.740

0.500

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

0.490

MACHINE RUN ENDS PER MSS-SP75-2019: EXCEPT ID TOLERANCE ± 3/32FINISH MACHINE OUTLET PER MSS-SP75-2019 EXCEPT ID TOLERANCE ± 3/32

OUT OF ROUNDNESS 1/8" MAX

MIN. WALL AT BEVEL NO LESS THAN .010" UNDER NOMINAL

STAMP PER MSS-SP75-19

RANDOM HARDNESS TEST (30%): 3 PCS (BASE, WELD, HAZ); 240 BHN MAX

|    |         |         |         |         |         |         |
|----|---------|---------|---------|---------|---------|---------|
| PC | B _____ | W _____ | H _____ | B _____ | W _____ | H _____ |
|    | B _____ | W _____ | H _____ | B _____ | W _____ | H _____ |

BCUL

PAINT MARK ON ID (6" FROM ONE END) \_\_\_\_\_

COAT OD SURFACES ONLY - AFTER INSPECTION

PACKAGING - PROVIDE SUITABLE END PROTECTION, 16" AND LARGER REQUIRES END PROTECTION AND 1 PC PER PALLET

BCUP  
(2) pcs