

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 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					12/22/2025	12/22/2025	15
									
20	PIPE 6 FURNACE HEAT	Pipe Furnace Furnace heating					12/23/2025	12/24/2025	15
									
30	PIPE 4 BIG ROLL	Big Roller Roll on large roller					12/24/2025	12/24/2025	15
									
40	PIPE 7 STRING UP	Initial Weld String-up					12/29/2025	12/29/2025	15
									
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld					01/01/2026	01/01/2026	15
									
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge					01/05/2026	01/05/2026	15
									
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep					01/07/2026	01/07/2026	15
									
80	PIPE 9 OD WELD	OD Weld OD Weld					01/12/2026	01/12/2026	15
									

Job Number: 252777-09

Report Generated: 12/16/2025 10:46:52

Page 2 of 5

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

Job Number: 252777-09

Report Generated: 12/16/2025 10:46:52

Page 3 of 5

180	STAMP 1 STAMP	Stamping	12/24/2026 12/24/2026	15
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190	INSPECT 1 INSPECTION	Inspection 1	12/24/2026 12/24/2026	15
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200	SHIPPING SHIPPING	Shipping	12/24/2026 12/24/2026	15
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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: 15

<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>
29,365.00000	1,800,846.0000 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)

Job Number: 252777-09

Report Generated: 12/16/2025 10:46:52

Pipe Shop Traveler Tee Cyl.

287-2025

12/17/2025

☐ Pipe Shop Copy

☐ Pipe Shop Original

Customer	MAVERICK			SFI Order No	252777-09	Due Date	1/19/2026
Part	35.000 OD	X	1.250 X	94.000		Ship Date	2/17/2026
Plate Size	1.250	X	106.029 X	94.000		NoPcs	1
Heat No.	R5619					Code	BCUP
Material	A633E		Test Material			Test No	

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

Per Sketch # **6480**

From (**1**) Plate(s) **1.250** Thick X **108.000** Wide X **131.000** Long

Stamp Plates With Heat Code

BCUP

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

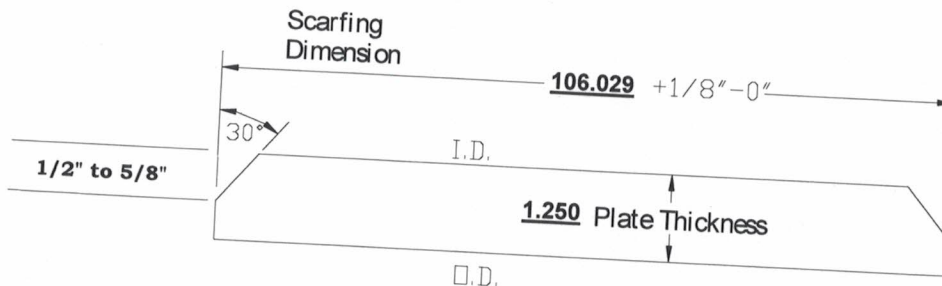
Stamp Each Cylinder in (2) Places With Heat Code

252777-09

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

BCUP

Comments:



Pipe Shop Traveler Tee Cyl.

288-2025

12/17/2025

☐ Pipe Shop Copy

☐ Pipe Shop Original

Customer	MAVERICK			SFI Order No	252777-09	Due Date	2/17/2026
Part	35.000 OD	X	1.250 X	94.000		Ship Date	1/19/2026
Plate Size	1.250	X	106.029 X	94.000		NoPcs	1
Heat No.	R5619					Code	BCUP
Material	A633E			Test Material		Test No	

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

Per Sketch # **6474**

From (**1**) Plate(s) **1.250** Thick X **109.000** Wide X **133.000** Long

Stamp Plates With Heat Code

BCUP

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**

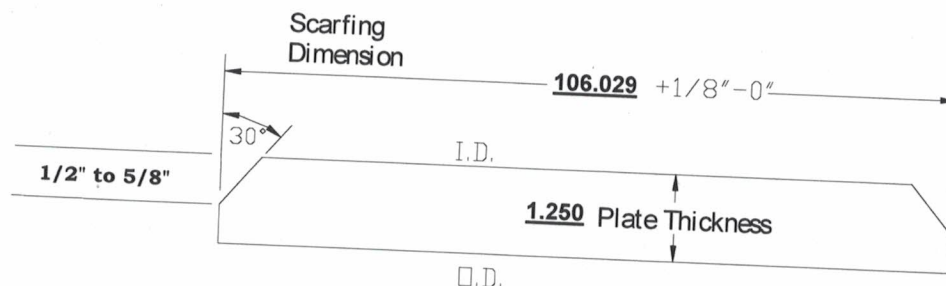
Stamp Each Cylinder in (2) Places With Heat Code

252777-09

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

BCUP

Comments:



Pipe Shop Traveler Tee Cyl.

289-2025

12/17/2025

☐ Pipe Shop Copy

☐ Pipe Shop Original

Customer	MAVERICK			SFI Order No	252777-09	Due Date	1/19/2026
Part	35.000 OD	X	1.250 X	46.000		Ship Date	2/17/2026
Plate Size	1.250	X	106.029 X	46.000		NoPcs	1
Heat No.	R5619					Code	BCUP
Material	A633E			Test Material		Test No	

Cut 1 Plate(s) 1.250 X Thick X 106.029 Width X 46.000 Length 1729 Lbs.

Per Sketch # 6470

From (1) Plate(s) 1.250 Thick X 46.000 Wide X 163.000 Long

Stamp Plates With Heat Code

BCUP

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 1 Pcs @ 46 Inches

Paint Mark on Cylinder

MAVERICK

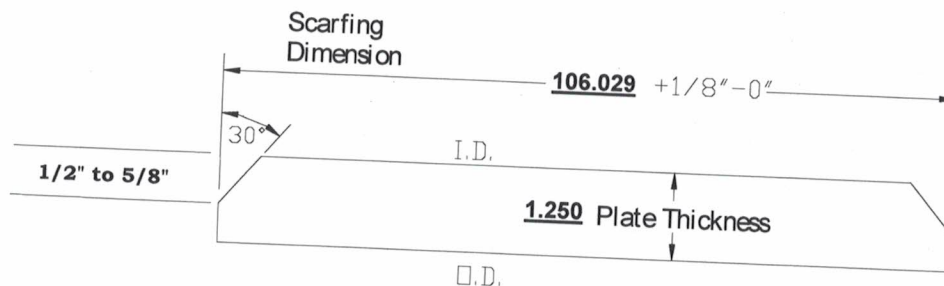
Stamp Each Cylinder in (2) Places With Heat Code

252777-09

Fitting Description: (1) TE 30X20

BCUP

Comments:



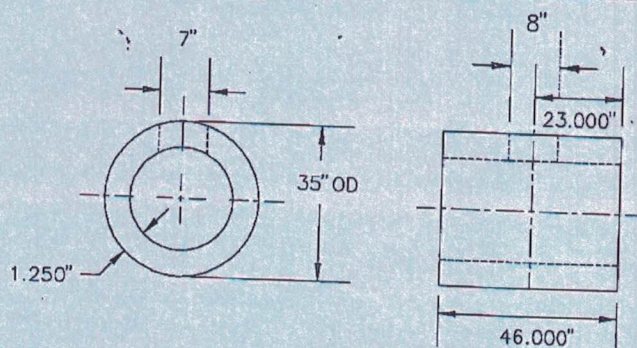
30" Run Diameter = 30.476"

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.

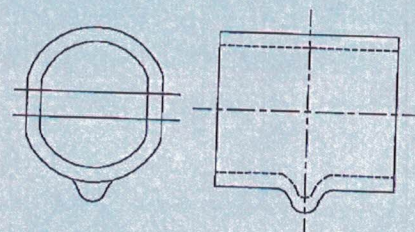


Ovaling Data: Oval: HOT Oval width: 29-3/4" ± .1/4"

Preform Data:

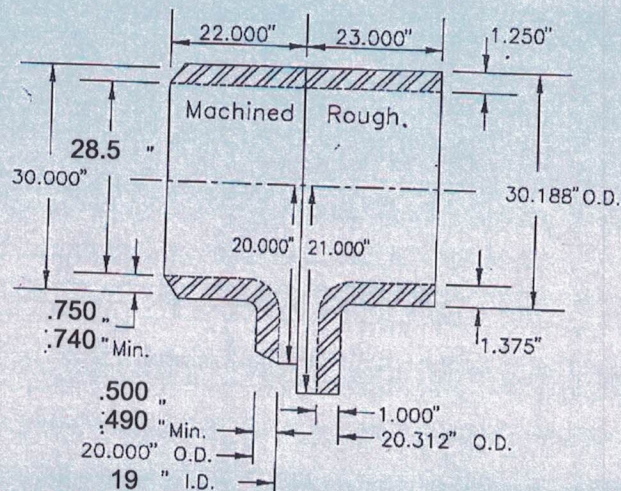
Press: Machine 2000 Ton Set up#10138 Upper Die# 50037
Lower Die# 50083

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

BCUP
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** ± 3/32

FINISH 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