

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
Contact: BUBBA NELSON

Phone: 409-833-7878
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

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						Quantity: 15
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>	<u>Unit</u>	<u>Description</u>	Sub- <u>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.

292-2025

12/17/2025

☐ 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>140.000</u>	Ship Date	<u>2/17/2026</u>
Plate Size	<u>1.250</u>		X	<u>106.029</u>	X	<u>140.000</u>	NoPcs	<u>1</u>
Heat No.	<u>R5550</u>						Code	<u>BCVL</u>
Material	<u>A633E</u>		Test Material			Test No		

Cut **1** Plate(s) **1.250** X Thick X **106.029** Width X **140.000** Length **5262** Lbs.

Per Sketch # **6519**

From (**1**) Plate(s) **1.250** Thick X **108.000** Wide X **270.000** Long

Stamp Plates With Heat Code **BCVL**

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

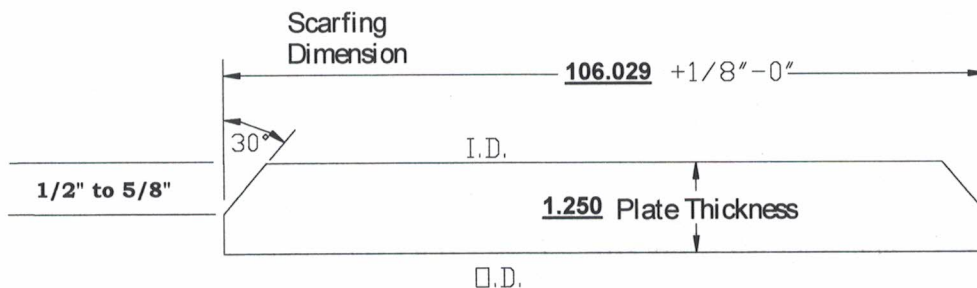
Torch Cut Into **3** Pcs @ **46** Inches

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

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

Fitting Description: **(3) TE 30X20**

Comments:



Pipe Shop Traveler Tee Cyl.

293-2025

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.	R5550						Code	BCVL
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 # **6519**

From (**1**) Plate(s) **1.250** Thick X **108.000** Wide X **270.000** Long

Stamp Plates With Heat Code **BCVL**

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

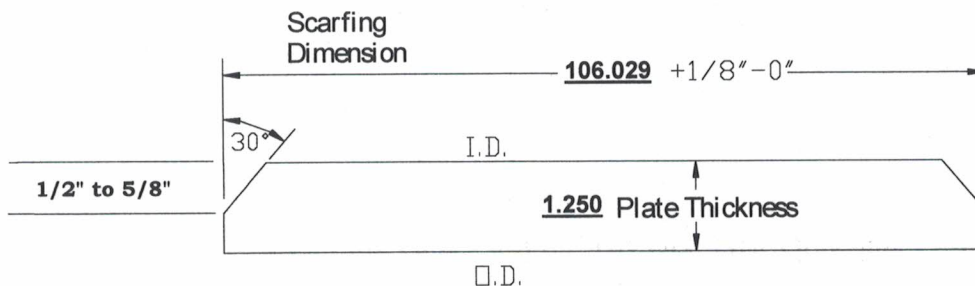
Torch Cut Into **2** Pcs @ **46** Inches

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

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

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

Comments:



20" Outlet Diameter = 20.523"

Hole size 7" x 8" Oval

The technical drawing consists of two views of a thick-walled cylinder:

- Left View (Cross-section):** Shows a thick-walled cylinder with an outer diameter of 35" OD. The wall thickness is 1.250". The inner diameter is 22.500" (calculated as 35" - 2 * 1.250"). The inner bore is labeled with a diameter of 7".
- Right View (Longitudinal Section):** Shows the cylinder with an outer diameter of 8". The length of the cylinder is 23.000". The total length of the part, including the flange, is 46.000".

Preform Data:

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

Technical drawing of a mechanical part with dimensions:

- Top horizontal dimensions: 22.000" and 23.000"
- Top right vertical dimension: 1.250"
- Left side vertical dimensions: 28.5" and 30.000"
- Right side vertical dimensions: 30.188" O.D. and 1.375"
- Internal horizontal dimensions: 20.000" and 21.000"
- Bottom left vertical dimensions: .750" and .740" Min.
- Bottom left horizontal dimensions: .500" and .490" Min.
- Bottom right horizontal dimensions: 1.000" and 20.312" O.D.
- Bottom right vertical dimension: 19" I.D.
- Internal labels: "Machined" and "Rough."

				DATE: 4-6-10	30" x 20" (.750 x .500) HIGH YIELD TEE MFG. DATA	DWG# 30-20-4A
				SCALE: NONE		
				DRAWN BY: J.DAVIDSON		
				CHECKED BY: JL		
REV	DESCRIPTION	BY	DATE			

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

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

BCKV QTY(2)

BCLV QTY(1)

BCLV QTY(5)

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 @ 1100 °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 ROUNDESS 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

BCKV	PC	B	_____	W	_____	H	_____	B	_____	W	_____	H	_____	} BCLV (2) pcs
BCLV	B	_____	W	_____	H	_____	B	_____	W	_____	H	_____		

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