



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

NOTE:

See 870-3 for segment usage to convey: production next step, production line unit, production discharge time, edge treatment, theoretical weight formula, weight gain/loss identified at production time and damage type/fault. These requirements may be applicable to any of the production transactions 870-4 thru 870-7 and should be included when applicable.

See 870-5 for segment usage to convey: Relative production processing step when multiple processing steps are performed. Again, these additional segments are required when applicable.

Note Segment can be provided at the Header or Detail Level for free-form information.

X12 870 Format

HEADER AREA

Transaction Set Header

ST*870*0001
Transaction Set Identifier Code (143)
ST01 870 X12 Order Status Report
Transaction Set Control Number (329)
ST02 0001

Beginning Segment for Order Status Report

BSR*2*PP*00123*20000206***0317
Transaction Set Purpose Code (850)
BSR01 2 Prearranged Schedule or Agreement
Order Item Code (847)
BSR02 PP Selected Orders - Selected Items Build-up
Reference Number (127)
BSR03 00123
Date (373)
BSR04 20000206 Transaction Create Date
Time (337)
BSR07 0317 Transaction Create Time

Name

N1*MF**1*005444062
Entity Identifier Code (98)
N101 MF Metals Producer
Identification Code Qualifier (66)
N103 1 DUNs Number
Identification Code (67)
N104 005444062 US Steel Gary Works

Name

N1*OU**1*147757470
Entity Identifier Code (98)
N101 OU Outside Processor
Identification Code Qualifier (66)
N103 1 DUNs Number
Identification Code (67)
N104 147757470

DETAIL AREA - Order Level



X12 Implementation Guideline - USS Outside Processing

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Hierarchical Level

HL*1**O*1
Hierarchical ID Number (628)
HL01 1
Hierarchical Level Code (735)
HL03 0 Order
Hierarchical Child Code (736)
HL04 1

Purchase Order Reference

PRF*EQ02135**20000206 USS work order with OP
Purchase Order Number (324)
PRF01 EQ02135
Purchase Order Date (323)
PRF04 20000206

DETAIL AREA - Component Level (Discharge Item Description)

Hierarchical Level

HL*2*1*F*1
Hierarchical ID Number (628)
HL01 2
Hierarchical Parent ID Number (734)
HL02 1
Hierarchical Level Code (735)
HL03 F Component
Hierarchical Child Code (736)
HL04 1

Reference Numbers

REF*SE*TWB12A
Reference Number Qualifier (128)
REF01 SE Serial Number Discharge Material ID
Reference Number (127)
REF02 TWB12A OP Material ID (Discharge - Welded Blank)



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

Reference Numbers

REF*PM*TW6543

Reference Number Qualifier (128)

REF01 PM Part Number

Reference Number (127)

REF02 TW6543 Finished Part Number

Reference Numbers

REF*90*TW6543-AB

Reference Number Qualifier (128)

REF01 90 Serial Number

Reference Number (127)

REF02 TW6543-AB Subassembly Number (Component Part of Welded Blank)

Date/Time Reference

DTM*009*20000206*0317*ES

Date/Time Qualifier (374)

DTM01 009 Process Business Event - Activity Date/Time

Date (373)

DTM02 20000206

Time (337)

DTM03 0317

Time Code (623)

DTM04 ES

Date/Time Reference

DTM*206*20000206*0317*ES

Date/Time Qualifier (374)

DTM01 206 OP Status Date

Date (373)

DTM02 20000206

Time (337)

DTM03 0317

Time Code (623)

DTM04 ES



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

Baseline Item Data

PO1**1*UN***VO*EQ02135*VN*001*HN*Y00462*SN*U771550
Quantity Ordered (330)
PO12 1
Unit or Basis for Measurement Code
PO13 UN Unit
Product/Service ID Qualifier (235)
PO106 VO Order Number - Intended Ship USS Mill Order #
Product/Service ID (234)
PO107 EQ02135
Product/Service ID Qualifier (235)
PO108 VN Order Item Number - Intended Ship USS Mill Order Item #
Product/Service ID (234)
PO109 001
Product/Service ID Qualifier (235)
PO110 HN Heat Number
Product/Service ID (234)
PO111 Y00462
Product/Service ID Qualifier (235)
PO112 SN Material Identification - USS
Product/Service ID (234)
PO113 U771550 Note: Discharge is that of last charge-in lift

PID*S*PR*ST*82***66

Item Description Type (349)
PID01 S
Product/Process Characteristic Code (750)
PID02 PR Manufacturing Process
Agency Qualifier Code (559)
PID03 ST Steel Code tables
Production Description Code (751)
PID04 82 Laser Weld
Source Subqualifier (822)
PID07 66 Steel Table 66

Product/Item Identification

PID*S*MAC*ST*01***67

Item Description Type (349)
PID01 S
Product/Process Characteristic Code (750)
PID02 MAC Material Classification
Agency Qualifier Code (559)
PID03 ST Steel Code tables
Production Description Code (751)
PID04 01 Prime
Source Subqualifier (822)
PID07 67 Steel Table 67



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

Product/Item Identification

PID*S*MA*ST*1***70
Item Description Type (349)
PID01 S
Product/Process Characteristic Code (750)
PID02 MA Outside Processor Status
Agency Qualifier Code (559)
PID03 ST Steel Code tables
Production Description Code (751)
PID04 1 Ready to Ship
Source Subqualifier (822)
PID07 70 Steel Table 70

Product/Item Identification

PID*S*PP*ST*A1**2*76
Item Description Type (349)
PID01 S
Product/Process Characteristic Code (750)
PID02 PP Process / Production Unit
Agency Qualifier Code (559)
PID03 ST Steel Code tables
Production Description Code (751)
PID04 A1 Production Unit Code
Surface / Layer / Position Code (752)
PID06 2 Position Code indicates stage described in
Welded Blanks Reporting Guidelines
Source Subqualifier (822)
PID07 76 Steel Table 76

Measurements See 856-1 for metric UOM qualifiers for following MEA's

MEA*WT*WT*8395*01
Measurement Reference ID Code (737)
MEA01 WT Weights
Measurement Qualifier (738)
MEA02 WT Weight
Measurement Value (739)
MEA03 8395
Unit or Basis for Measurement Code (355)
MEA04 01 Pounds

Measurements

MEA*PD*TH*00.0315*ED
Measurement Reference ID Code (737)
MEA01 PD Actual Dimensions
Measurement Qualifier (738)
MEA02 TH Thickness
Measurement Value (739)
MEA03 00.0315
Unit or Basis for Measurement Code (355)
MEA04 ED Decimal Inches



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

Measurements

MEA*PD*WD*67.9900*ED
Measurement Reference ID Code (737)
MEA01 PD Actual Dimensions
Measurement Qualifier (738)
MEA02 WD Width
Measurement Value (739)
MEA03 67.9900
Unit or Basis for Measurement Code (355)
MEA04 ED Decimal Inches

Measurements

MEA*PD*LN*40.0000*ED
Measurement Reference ID Code (737)
MEA01 PD Actual Dimensions
Measurement Qualifier (738)
MEA02 LN Length
Measurement Value (739)
MEA03 40.0000
Unit or Basis for Measurement Code (355)
MEA04 ED Decimal Inches

Measurements

MEA*CT*NL*200*PC
Measurement Reference ID Code (737)
MEA01 CT Counts
Measurement Qualifier (738)
MEA02 NL
Measurement Value (739)
MEA03 200
Unit or Basis for Measurement Code (355)
MEA04 PC Number of Pieces

DETAIL AREA - Item Level (Charge Item Description)

Hierarchical Level

HL*3*2*I
Hierarchical ID Number (628)
HL01 3
Hierarchical Parent ID Number (734)
HL02 2
Hierarchical Level Code (735)
HL03 I Item

Reference Numbers

REF*RV*471095-2 1st Charge-in Material ID
Reference Number Qualifier (128)
REF01 RV OP Prior Identity
Reference Number (127)
REF02 471095-2



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

Baseline Item Data

PO1**1*UN***VO*EQ02135*VN*001*HN*Y00462*SN*U771553
Quantity Ordered (330)
PO12 1
Unit or Basis for Measurement Code
PO13 UN Unit
Product/Service ID Qualifier (235)
PO106 VO Order Number - Intended Ship USS Mill Order #
Product/Service ID (234)
PO107 EQ02135
Product/Service ID Qualifier (235)
PO108 VN Order Item Number - Intended Ship USS Mill Order Item #
Product/Service ID (234)
PO109 001
Product/Service ID Qualifier (235)
PO110 HN Heat Number
Product/Service ID (234)
PO111 Y00462
Product/Service ID Qualifier (235)
PO112 SN Material Identification - USS
Product/Service ID (234)
PO113 U771553

Product/Item Identification

PID*S*PR*ST*29***66
Item Description Type (349)
PID01 S
Product/Process Characteristic Code (750)
PID02 PR Manufacturing Process
Agency Qualifier Code (559)
PID03 ST Steel Code tables
Production Description Code (751)
PID04 29 Laser Weld Charged Material
Source Subqualifier (822)
PID07 66 Steel Table 66

Product/Item Identification

PID*S*MAC*ST*01***67
Item Description Type (349)
PID01 S
Product/Process Characteristic Code (750)
PID02 MAC Material Classification
Agency Qualifier Code (559)
PID03 ST Steel Code tables
Production Description Code (751)
PID04 01 Prime
Source Subqualifier (822)
PID07 67 Steel Table 67



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

Product/Item Identification

PID*S*MA*ST*7***70
Item Description Type (349)
PID01 S
Product/Process Characteristic Code (750)
PID02 MA Outside Processor Status
Agency Qualifier Code (559)
PID03 ST Steel Code tables
Production Description Code (751)
PID04 7 Inprocess
Source Subqualifier (822)
PID07 70 Steel Table 70

Measurements See 856-1 for metric UOM qualifiers for following MEA's

MEA*WT*WT*7005*01

Measurement Reference ID Code (737)
MEA01 WT Weights
Measurement Qualifier (738)
MEA02 WT Weight
Measurement Value (739)
MEA03 7005
Unit or Basis for Measurement Code (355)
MEA04 01 Pounds

Measurements

MEA*PD*TH*00.0315*ED

Measurement Reference ID Code (737)
MEA01 PD Actual Dimensions
Measurement Qualifier (738)
MEA02 TH Thickness
Measurement Value (739)
MEA03 00.0315
Unit or Basis for Measurement Code (355)
MEA04 ED Decimal Inches

Measurements

MEA*PD*WD*67.9900*ED

Measurement Reference ID Code (737)
MEA01 PD Actual Dimensions
Measurement Qualifier (738)
MEA02 WD Width
Measurement Value (739)
MEA03 67.9900
Unit or Basis for Measurement Code (355)
MEA04 ED Decimal Inches



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

Measurements

MEA*PD*LN*40.0000*ED
Measurement Reference ID Code (737)
MEA01 PD Actual Dimensions
Measurement Qualifier (738)
MEA02 LN Length
Measurement Value (739)
MEA03 40.0000
Unit or Basis for Measurement Code (355)
MEA04 ED Decimal Inches

Measurements

MEA*CT*NL*200*PC
Measurement Reference ID Code (737)
MEA01 CT Counts
Measurement Qualifier (738)
MEA02 NL
Measurement Value (739)
MEA03 200
Unit or Basis for Measurement Code (355)
MEA04 PC Number of Pieces

DETAIL AREA - Item Level (Charge Item Description)

Hierarchical Level

HL*4*2*I
Hierarchical ID Number (628)
HL01 4
Hierarchical Parent ID Number (734)
HL02 2
Hierarchical Level Code (735)
HL03 I Item

Reference Numbers

REF*RV*471095-1
Reference Number Qualifier (128)
REF01 RV OP Prior Identity 2nd Charge-in Material ID
Reference Number (127)
REF02 471095-1



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

Baseline Item Data

PO1**1*UN***VO*EQ02135*VN*001*HN*Y00462*SN*U771550
Quantity Ordered (330)
PO12 1
Unit or Basis for Measurement Code
PO13 UN Unit
Product/Service ID Qualifier (235)
PO106 VO Order Number - Intended Ship USS Mill Order #
Product/Service ID (234)
PO107 EQ02135
Product/Service ID Qualifier (235)
PO108 VN Order Item Number - Intended Ship USS Mill Order Item #
Product/Service ID (234)
PO109 001
Product/Service ID Qualifier (235)
PO110 HN Heat Number
Product/Service ID (234)
PO111 Y00462
Product/Service ID Qualifier (235)
PO112 SN Material Identification - USS
Product/Service ID (234)
PO113 U771550

Product/Item Identification

PID*S*PR*ST*29***66
Item Description Type (349)
PID01 S
Product/Process Characteristic Code (750)
PID02 PR Manufacturing Process
Agency Qualifier Code (559)
PID03 ST Steel Code tables
Production Description Code (751)
PID04 29 Laser Weld Charged Material
Source Subqualifier (822)
PID07 66 Steel Table 66

Product/Item Identification

PID*S*MAC*ST*01***67
Item Description Type (349)
PID01 S
Product/Process Characteristic Code (750)
PID02 MAC Material Classification
Agency Qualifier Code (559)
PID03 ST Steel Code tables
Production Description Code (751)
PID04 01 Prime
Source Subqualifier (822)
PID07 67 Steel Table 67



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

Product/Item Identification

PID*S*MA*ST*7***70
Item Description Type (349)
PID01 S
Product/Process Characteristic Code (750)
PID02 MA Outside Processor Status
Agency Qualifier Code (559)
PID03 ST Steel Code tables
Production Description Code (751)
PID04 7 Inprocess
Source Subqualifier (822)
PID07 70 Steel Table 70

Measurements See 856-1 for metric UOM qualifiers for following MEA's

MEA*WT*WT*1390*01
Measurement Reference ID Code (737)
MEA01 WT Weights
Measurement Qualifier (738)
MEA02 WT Weight
Measurement Value (739)
MEA03 1390
Unit or Basis for Measurement Code (355)
MEA04 01 Pounds

Measurements

MEA*PD*TH*00.0315*ED
Measurement Reference ID Code (737)
MEA01 PD Actual Dimensions
Measurement Qualifier (738)
MEA02 TH Thickness
Measurement Value (739)
MEA03 00.0315
Unit or Basis for Measurement Code (355)
MEA04 ED Decimal Inches

Measurements

MEA*PD*WD*67.9900*ED
Measurement Reference ID Code (737)
MEA01 PD Actual Dimensions
Measurement Qualifier (738)
MEA02 WD Width
Measurement Value (739)
MEA03 67.9900
Unit or Basis for Measurement Code (355)
MEA04 ED Decimal Inches



X12 Implementation Guideline - USS Outside Processing

Order Status Report - Production Reporting - Normal Example 870-7, Production - Multiple Charge / Laser Weld

Measurements

MEA*PD*LN*40.0000*ED
Measurement Reference ID Code (737)
MEA01 PD Actual Dimensions
Measurement Qualifier (738)
MEA02 LN Length
Measurement Value (739)
MEA03 40.0000
Unit or Basis for Measurement Code (355)
MEA04 ED Decimal Inches

Measurements

MEA*CT*NL*200*PC
Measurement Reference ID Code (737)
MEA01 CT Counts
Measurement Qualifier (738)
MEA02 NL
Measurement Value (739)
MEA03 200
Unit or Basis for Measurement Code (355)
MEA04 PC Number of Pieces

Summary Area

Transaction Totals

CTT*4
Number of Line Items (354)
CTT01 4 Total Number of HL Segments
One Order (O), Two Item (I), One Component (F)

Transaction Set Trailer

SE*46*0001
Number of Included Segments (96)
SE01 46 Total number of segments in the transaction
including the ST and SE segments
Transaction Set Control Number (329)
SE02 0001 Transaction Set Control Number. Same as ST02
in the Transaction Set Header segment.