

Production Reporting - Build-Up

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Example 870-6, Production - Multiple Charge / Build-Up

Segment Sequence and Looping

Note: All segments required, unless otherwise indicated.

HEADER

ST

BSR

LOOP – N1

N1 – MF

N1 – OU or WH (Dependent on what processor does with material – process or warehouse)

DETAIL - ORDER

HL

PRF

DETAIL – COMPONENT Level (Discharge Item Description)

HL

REF – SE

DTM – 009

DTM – 206

DTM – 105

DTM – 207

PO1

PID – PR

PID – MAC

PID – MA

PID – QAS

PID – CMS

PID – F*02

MEA – WT / WT (Actual)

MEA – WT / WT (Theoretical)

MEA – PD / TH

MEA – PD / WD

MEA – PD / LN

MEA – CT

DETAIL – ITEM Level (Charge Item Description)

HL

REF – RV

PO1

PID – PR

PID – MAC

PID – MA

PID – QAS

PID – CMS

DTM – 206

DTM – 105

DTM – 207

PID – F*02

MEA – WT / WT (Actual)

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Example 870-6, Production - Multiple Charge / Build-Up

DETAIL – ITEM Level (Charge Item Description) – continued

MEA – WT / WT (Theoretical)

MEA – PD / TH

MEA – PD / WD

MEA – PD / LN

MEA – CT

SUMMARY

CTT

SE

MAINTENANCE LOG

Change Date	Description of Change
2/17/2021	Branding changes for Cleveland-Cliffs.

X12 Implementation Guideline – Cleveland-Cliffs Steel – Outside Processing
For use with the following Cleveland-Cliffs plants: Burns Harbor, Cleveland, Indiana Harbor, & Kote.

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Example 870-6, Production - Multiple Charge / Build-Up

HEADER

Transaction Set Header

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

Beginning Segment for Order Status Report

BSR*2*PP*870PR*19960127***0317
Transaction Set Purpose Code (850)
BSR01 2 Prearranged Schedule or Agreement
Order Item Code (847)
BSR02 PP Selected Orders - Selected Items
Reference Number (127)
BSR03 870PR
Date (373)
BSR04 19960127 Transaction Create Date (CCYYMMDD format)
Time (337)
BSR07 0317 Transaction Create Time (HHMM format)

Name

N1*MF**1*005159199
Entity Identifier Code (98)
N101 MF Steel Producer
Identification Code Qualifier (66)
N103 1 DUNs Number
Identification Code (67)
N104 005159199 D&B number of Steel Producer
'005159199' Cleveland-Cliffs Steel LLC (Indiana Harbor)
'613460476' Cleveland-Cliffs Kote Inc.
'003913423' Cleveland-Cliffs Burns Harbor LLC
'122373918' Cleveland-Cliffs Cleveland Works LLC

Name

N1*OU**1*147757470
Entity Identifier Code (98)
N101 OU Outside Processor or 'WH' for Warehouse
Identification Code Qualifier (66)
N103 1 DUNs Number
Identification Code (67)
N104 147757470 D&B number of Processor

DETAIL - Order

Hierarchical Level

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

Purchase Order Reference

PRF*GZ6-3474809***19960120
Purchase Order Number (324)
PRF01 GZ6-3474809 Purchase Order Number
Purchase Order Date (323)
PRF04 19960120 Purchase Order Date (CCYYMMDD format)

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Example 870-6, Production - Multiple Charge / Build-Up

DETAIL - 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*471095

Reference Number Qualifier (128)

REF01 SE Serial Number

Reference Number (127)

REF02 471095 OP Material ID (Discharge)

Date/Time Reference

DTM*009*19960128*0817*ET

Date/Time Qualifier (374)

DTM01 009 Process

Date (373)

DTM02 19960128 Process Date (CCYYMMDD format)

Time (337)

DTM03 0817 Process Time (HHMM format)

Time Code (623)

DTM04 ET Eastern Time 'CT' if Central Time, 'MT' if Mountain Time or
'PT' if Pacific Time

Date/Time Reference

DTM*206*19960128*0817*ET

Date/Time Qualifier (374)

DTM01 206 OP Status

Date (373)

DTM02 19960128 OP Status Date (CCYYMMDD format)

Time (337)

DTM03 0817 OP Status Time (HHMM format)

Time Code (623)

DTM04 ET Eastern Time 'CT' if Central Time, 'MT' if Mountain Time or
'PT' if Pacific Time

Date/Time Reference

DTM*105*19960128

Date/Time Qualifier (374)

DTM01 105 Quality Status

Date (373)

DTM02 19960128 Quality Status Date (CCYYMMDD format)

Date/Time Reference

DTM*207*19960128*0817*ET

Date/Time Qualifier (374)

DTM01 207 Commercial Status

Date (373)

DTM02 19960128 Commercial Status Date (CCYYMMDD format)

Time (337)

DTM03 0817 Commercial Status Time (HHMM format)

Time Code (623)

DTM04 ET Eastern Time 'CT' if Central Time, 'MT' if Mountain Time or
'PT' if Pacific Time

X12 Implementation Guideline – Cleveland-Cliffs Steel – Outside Processing
For use with the following Cleveland-Cliffs plants: Burns Harbor, Cleveland, Indiana Harbor, & Kote.

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Example 870-6, Production - Multiple Charge / Build-Up

Baseline Item Data

PO1**1*UN***VO*1235727*VN*01*SN*856-80843*HN*920818*GC*XXXX

Quantity Ordered (330)

PO102 1

Unit or Basis for Measurement Code (355)

PO103 UN Unit

Product/Service ID Qualifier (235)

PO106 VO Vendor's Order Number - Intended Cliffs Ship Order #

Product/Service ID (234)

PO107 1235727 Cliffs Order Number Indiana Harbor or Kote example: 1235727
Burns Harbor example: BH83515005A
Cleveland example: CS2844

Product/Service ID Qualifier (235)

PO108 VN Vendor's Item Number (from Vendor Order)

Product/Service ID (234)

PO109 01 Item Number Indiana Harbor or Kote will always be '01'
Burns Harbor will correspond to order
Cleveland will always be '01'

Product/Service ID Qualifier (235)

PO110 SN Serial Number - Steel Producer's Material Identification

Product/Service ID (234)

PO111 856-80843 Cliffs Coil Number Indiana Harbor example: 856-80843
Burns Harbor example: 143100P21
Cleveland example: 5662973

Product/Service ID Qualifier (235)

PO112 HN Heat Number

Product/Service ID (234)

PO113 920818 Cliffs Heat Number Indiana Harbor or Kote example: 920818
Burns Harbor example: 832Y34320
Cleveland example: 4142806

Product/Service ID Qualifier (235)

PO114 GC Grade Code

Product/Service ID (234)

PO115 XXXX Cliffs Grade Code Burns Harbor example: LFQ
Indiana Harbor or Kote example: XXXX
Cleveland example: 9311

Product/Item Identification

PID*S*PR*ST*27***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 27 Buildup

Source Subqualifier (822)

PID07 66 Steel Table #66 (AISI Process codes)

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 (AISI material classification codes)

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Example 870-6, Production - Multiple Charge / Build-Up

Product/Item Identification

PID*S*QAS*ST*19*68**

Item Description Type (349)

PID01 S

Product/Process Characteristic Code (750)

PID02 QAS Quality Status Table

Agency Qualifier Code (559)

PID03 ST Steel Code tables

Production Description Code (751)

PID04 19 Blank

Source Subqualifier (822)

PID07 68 Steel Table #68 (AISI Material Status-Quality Assurance codes)

Product/Item Identification

PID*S*CMS*ST*19*69**

Item Description Type (349)

PID01 S

Product/Process Characteristic Code (750)

PID02 CMS Commercial Status

Agency Qualifier Code (559)

PID03 ST Steel Code tables

Production Description Code (751)

PID04 19 Blank

Source Subqualifier (822)

PID07 69 Steel Table #69 (AISI Material Status-Commercial codes)

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 1 Ready To Ship

Source Subqualifier (822)

PID07 70 Steel Table #70 (AISI material status-O.P. codes)

Product/Item Identification

PID*F*02*Comments**

Item Description Type (349)

PID01 F

Product/Process Characteristic Code (750)

PID02 02 comments

Description (352)

PID05 Comments

Measurements

MEA*WT*WT*10000*01*31**

Measurement Reference ID Code (737)

MEA01 WT Weights

Measurement Qualifier (738)

MEA02 WT Weight

Measurement Value (739)

MEA03 10000

Unit or Basis for Measurement Code (355)

MEA04 01 Pounds

Measurement Significance Code

MEA07 31 Calculated

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Example 870-6, Production - Multiple Charge / Build-Up

Measurements

MEA*WT*WT*9900*24

Measurement Reference	ID Code (737)
MEA01 WT	Weights
Measurement Qualifier (738)	
MEA02 WT	Weight
Measurement Value (739)	
MEA03 9900	
Unit or Basis for Measurement Code (355)	
MEA04 24	Theo Pounds

Measurements

MEA*PD*TH*.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*63.0000*IN

Measurement Reference	ID Code (737)
MEA01 PD	Actual Dimensions
Measurement Qualifier (738)	
MEA02 WD	Width
Measurement Value (739)	
MEA03 63.0000	
Unit or Basis for Measurement Code (355)	
MEA04 IN	Inches

Measurements

MEA*PD*LN*51.0000*IN

Measurement Reference	ID Code (737)
MEA01 PD	Actual Dimensions
Measurement Qualifier (738)	
MEA02 LN	Length
Measurement Value (739)	
MEA03 51.0000	
Unit or Basis for Measurement Code (355)	
MEA04 IN	Inches

Measurements

MEA*CT*NL*338*PC

Measurement Reference	ID Code (737)
MEA01 CT	Counts
Measurement Qualifier (738)	
MEA02 NL	
Measurement Value (739)	
MEA03 338	
Unit or Basis for Measurement Code (355)	
MEA04 PC	Number of Pieces

X12 Implementation Guideline – Cleveland-Cliffs Steel – Outside Processing
For use with the following Cleveland-Cliffs plants: Burns Harbor, Cleveland, Indiana Harbor, & Kote.

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Example 870-6, Production - Multiple Charge / Build-Up

DETAIL - 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

Reference Number Qualifier (128)

REF01 RV OP Prior Identity

Reference Number (127)

REF02 471095-2

Baseline Item Data

PO11*UN***VO*1235727*VN*01*SN*856-80843*HN*920818*GC*XXXX**

Quantity Ordered (330)

PO102 1

Unit or Basis for Measurement Code (355)

PO103 UN Unit

Product/Service ID Qualifier (235)

PO106 VO Vendor's Order Number - Intended Cliffs Ship Order #

Product/Service ID (234)

PO107 1235727 Cliffs Order Number
Indiana Harbor or Kote example: 1235727
Burns Harbor example: BH83515005A
Cleveland example: CS2844

Product/Service ID Qualifier (235)

PO108 VN Vendor's Item Number (from Vendor Order)

Product/Service ID (234)

PO109 01 Item Number
Indiana Harbor or Kote will always be '01'
Burns Harbor will correspond to order
Cleveland will always be '01'

Product/Service ID Qualifier (235)

PO110 SN Serial Number - Steel Producer's Material Identification

Product/Service ID (234)

PO111 856-80843 Cliffs Coil Number
Indiana Harbor example: 856-80843
Burns Harbor example: 143100P21
Cleveland example: 5662973

Product/Service ID Qualifier (235)

PO112 HN Heat Number

Product/Service ID (234)

PO113 920818 Cliffs Heat Number
Indiana Harbor or Kote example: 920818
Burns Harbor example: 832Y34320
Cleveland example: 4142806

Product/Service ID Qualifier (235)

PO114 GC Grade Code

Product/Service ID (234)

PO115 XXXX Cliffs Grade Code
Burns Harbor example: LFQ
Indiana Harbor or Kote example: XXXX
Cleveland example: 9311

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Example 870-6, Production - Multiple Charge / Build-Up

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 Charged Into Build-Up

Source Subqualifier (822)

PID07 66 Steel Table #66 (AISI Process codes)

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 (AISI material classification codes)

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 (AISI material status-O.P. codes)

Product/Item Identification

PID*F*02***Comments

Item Description Type (349)

PID01 F

Product/Process Characteristic Code (750)

PID02 02 Comment

Description (352)

PID05 Comments

Measurements

MEA*WT*WT*8300*01***31

Measurement Reference ID Code (737)

MEA01 WT Weights

Measurement Qualifier (738)

MEA02 WT Weight

Measurement Value (739)

MEA03 8300

Unit or Basis for Measurement Code (355)

MEA04 01 Pounds

Measurement Significance Code

MEA07 31 Calculated

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Example 870-6, Production - Multiple Charge / Build-Up

Measurements

MEA*WT*WT*8200*24

Measurement Reference	ID Code (737)
MEA01 WT	Weights
Measurement Qualifier (738)	
MEA02 WT	Weight
Measurement Value (739)	
MEA03 8200	
Unit or Basis for Measurement Code (355)	
MEA04 24	Theo 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*63.0000*IN

Measurement Reference	ID Code (737)
MEA01 PD	Actual Dimensions
Measurement Qualifier (738)	
MEA02 WD	Width
Measurement Value (739)	
MEA03 63.0000	
Unit or Basis for Measurement Code (355)	
MEA04 IN	Inches

Measurements

MEA*PD*LN*51.0000*IN

Measurement Reference	ID Code (737)
MEA01 PD	Actual Dimensions
Measurement Qualifier (738)	
MEA02 LN	Length
Measurement Value (739)	
MEA03 51.0000	
Unit or Basis for Measurement Code (355)	
MEA04 IN	Inches

Measurements

MEA*CT*NL*282*PC

Measurement Reference	ID Code (737)
MEA01 CT	Counts
Measurement Qualifier (738)	
MEA02 NL	
Measurement Value (739)	
MEA03 282	
Unit or Basis for Measurement Code (355)	
MEA04 PC	Number of Pieces

X12 Implementation Guideline – Cleveland-Cliffs Steel – Outside Processing
For use with the following Cleveland-Cliffs plants: Burns Harbor, Cleveland, Indiana Harbor, & Kote.

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Example 870-6, Production - Multiple Charge / Build-Up

DETAIL - 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

Reference Number (127)

REF02 471095-1

Baseline Item Data

PO11*UN***VO*1235727*VN*01*SN*856-80843*HN*920818*GC*XXXX**

Quantity Ordered (330)

PO102 1

Unit or Basis for Measurement Code (355)

PO103 UN Unit

Product/Service ID Qualifier (235)

PO106 VO Vendor's Order Number - Intended Cliffs Ship Order #

Product/Service ID (234)

PO107 1235727 Cliffs Order Number
Indiana Harbor or Kote example: 1235727
Burns Harbor example: BH83515005A
Cleveland example: CS2844

Product/Service ID Qualifier (235)

PO108 VN Vendor's Item Number (from Vendor Order)

Product/Service ID (234)

PO109 01 Item Number
Indiana Harbor or Kote will always be '01'
Burns Harbor will correspond to order
Cleveland will always be '01'

Product/Service ID Qualifier (235)

PO110 SN Serial Number - Steel Producer's Material Identification

Product/Service ID (234)

PO111 856-80843 Cliffs Coil Number
Indiana Harbor example: 856-80843
Burns Harbor example: 143100P21
Cleveland example: 5662973

Product/Service ID Qualifier (235)

PO112 HN Heat Number

Product/Service ID (234)

PO113 920818 Cliffs Heat Number
Indiana Harbor or Kote example: 920818
Burns Harbor example: 832Y34320
Cleveland example: 4142806

Product/Service ID Qualifier (235)

PO114 GC Grade Code

Product/Service ID (234)

PO115 XXXX Cliffs Grade Code
Burns Harbor example: LFQ
Indiana Harbor or Kote example: XXXX
Cleveland example: 9311

Production Reporting - Build-Up

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Example 870-6, Production - Multiple Charge / Build-Up

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 Charged Into Build-Up

Source Subqualifier (822)

PID07 66 Steel Table #66 (AISI Process codes)

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 (AISI material classification codes)

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 (AISI material status-O.P. codes)

Product/Item Identification

PID*F*02*Comments**

Item Description Type (349)

PID01 F

Product/Process Characteristic Code (750)

PID02 02 comments

Description (352)

PID05 Comments

Measurements

MEA*WT*WT*1700*01*31**

Measurement Reference ID Code (737)

MEA01 WT Weights

Measurement Qualifier (738)

MEA02 WT Weight

Measurement Value (739)

MEA03 1700

Unit or Basis for Measurement Code (355)

MEA04 01 Pounds

Measurement Significance Code

MEA07 31 Calculated

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Example 870-6, Production - Multiple Charge / Build-Up

Measurements

MEA*WT*WT*1600*24

Measurement Reference ID Code (737)
 MEA01 WT Weights
 Measurement Qualifier (738)
 MEA02 WT Weight
 Measurement Value (739)
 MEA03 1600
 Unit or Basis for Measurement Code (355)
 MEA04 24 Theo 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*63.0000*IN

Measurement Reference ID Code (737)
 MEA01 PD Actual Dimensions
 Measurement Qualifier (738)
 MEA02 WD Width
 Measurement Value (739)
 MEA03 63.0000
 Unit or Basis for Measurement Code (355)
 MEA04 IN Inches

Measurements

MEA*PD*LN*51.0000*IN

Measurement Reference ID Code (737)
 MEA01 PD Actual Dimensions
 Measurement Qualifier (738)
 MEA02 LN Length
 Measurement Value (739)
 MEA03 51.0000
 Unit or Basis for Measurement Code (355)
 MEA04 IN Inches

Measurements

MEA*CT*NL*56*PC

Measurement Reference ID Code (737)
 MEA01 CT Counts
 Measurement Qualifier (738)
 MEA02 NL
 Measurement Value (739)
 MEA03 56
 Unit or Basis for Measurement Code (355)
 MEA04 PC Number of Pieces

Summary

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)

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Example 870-6, Production - Multiple Charge / Build-Up

Transaction Set Trailer

SE*43*0001

Number of Included Segments (96)

SE01 43 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.