

FINAL INSPECTION REPORT & CERTIFICATE OF CONFORMANCE

UNEW's capital part refurbishment operations are governed by proprietary engineering technologies, precision standards, and rigorous QA/QC procedures developed for aviation-grade manufacturing. While refurbishment work is normally conducted at UNEW's U.S. facility, certain components from restricted regions are not eligible for import under U.S. national security and export control regulations.

To maintain uninterrupted service and consistent product quality, UNEW has partnered with EthosEnergy (United Kingdom)—a world-class turbine repair and overhaul organization operating one of the most advanced facilities in the industry. The EthosEnergy shop is equipped with fully automated precision systems, vacuum furnaces, electron beam welders, and advanced HVOF/TBC coating cells. Its quality system is certified to ISO 9001:2015, ISO 14001:2015, ISO 45001:2018, and ISO 17025:2017, ensuring full traceability, environmental stewardship, and occupational safety compliance.

All repair activities performed at EthosEnergy strictly follow UNEW's proprietary refurbishment procedures, material specifications, and inspection standards. The physical repair processes are executed by EthosEnergy, while UNEW retains full technical authority over repair methodology, metallurgical control, quality benchmarks, and final acceptance. This partnership guarantees that every refurbished component meets UNEW's aviation-grade quality and reliability standards for power generation service.

Customer Name: Nghi Son Refinery & Petrochemical, LLC.

WORK ORDER #: PO04102025-HGP

Component type: MS6001FA 1st STAGE SHROUD

Date of Report: 27 October, 2025

Responsible Product Engineer: 

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FINAL INSPECTION REPORT

1. INTRODUCTION

24 pcs. of MS6001FA 1st stage shroud block have been fully refurbished based on the requirements of the incoming inspection report findings.

Order Information	
EE Work Order no.	824031
Date of report	02 September 2025
Customer P.O. no.	PO04102025-HGP
Component Details	
Engine type	MS6001FA
Component type	1st Shroud block
Component part number	109E9147G05 REV T
Qty. received	24
Material type	Body
	Inner plate (or Tip shoe)
As received coating type (s)	Body
	Inner plate (or Tip shoe)
Additional items received with main set (if any)	-
Customer supplied component history	
Total fired hours	24,000
Total starts	(No information supplied)
Total factor fired hours	(No information supplied)
# of previous repairs	(No information supplied)
Hours of operation since last repair interval	(No information supplied)
Operational fuel type	(No information supplied)
Mode of operation (base load / peaking)	(No information supplied)
Maintenance Intervals Combustion	(No information supplied)
Maintenance Intervals Hot gas path	(No information supplied)
Unloaded condition	
Incoming packing / container condition	Good
Signs of transit damage (if damaged upon receipt photos to be included within report)	No

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2. INSPECTION SUMMARY

Based on the results of the detailed incoming inspection (see full findings in the following section of this report), EthosEnergy submits the following recommendations in alignment with UNEW’s advanced repair specifications.

This particular set of shrouds exhibits significant degradation and wear beyond standard refurbishment limits. As such, the repair scope has been classified as a heavy-duty restoration requiring specialized processes, proprietary coatings, and precision material replacement techniques. To restore the components to a fully serviceable and reliable condition, the following extraordinary repair actions—mandated by UNEW’s engineering standards—will be required:

- Application of high-performance protective coatings, including UNEW’s proprietary thermal barrier ceramic system
- Precision rebuilding of critical surfaces using advanced welding or additive material deposition
- Dimensional restoration and realignment to recover original mechanical tolerances
- Material replacement and structural reinforcement in high-stress zones beyond typical erosion or oxidation

These procedures exceed standard repair practices and reflect the complexity and criticality of this specific hardware set. All work will be executed in strict accordance with UNEW’s QA/QC protocols and technological requirements to ensure the highest levels of reliability and performance.

REPAIR LEVEL REQUIREMENT			
Descriptions		Qty	Unit
Inspection	Incoming inspection	1	Set
Repair level	Heavy repair	1	Set

Additional Items for Heavy Repair			
Descriptions		Qty	Unit
Required	Restore tip shoe (inner plates) by special UNEW process and equipment	2	p/pc
Required	Replace new inner plate side seals (flat and bone type)	1	p/set
Required	Replace new tile retention pins	2	p/ea
Optional	Weld plug pin of old down holes, Need to weld if this set of shrouds is not to use the same turbine. Need to drill the holes during the inspection.	1	p/set
Special Coating	Advanced Thermal Barrier Coating (TBC) with Engineered Abradable Ceramic Layer (heavy repair).	1	Set
Extensive welding and CNC	Extensive welding and CNC machining to restore critical surfaces, followed by post-weld heat treatment for structural integrity. Completed FPI inspection and final dimensional checks on fixture per UNEW’s quality standards.	1	set

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3. SPARE PART (Repair / Replace):

Item	Part description	Received/Required	Condition	Quantity	Remark
1	Tile Retention Pins (EETH4069-01)	72/72	Repaired Replaced	70 2	- Additional
2	Internal retaining ring	72/72	Repaired	72	-
3	Inner plates side seal – long (L605 Dog bone seal) (EETH4070-01)	25/70	Replaced	70	Additional
4	Inner plates side seal – short upper (L605 Dog bone seal) (EETH4070-03)	20/70	Replaced	70	Additional
5	Inner plates side seal – short lower (L605 Dog bone seal) (EETH4070-02)	27/70	Replaced	70	Additional
6	Split line seal-Inner plate-long (L605 Flat seal) (EETH4070-01)	2/2	Replaced	2	Additional
7	Split line seal-Inner plate-short upper (L605 Flat seal) (EETH4070-03)	2/2	Replaced	2	Additional
8	Split line seal-Inner plate-short lower (L605 Flat seal) (EETH4070-02)	2/2	Replaced	2	Additional

4. ENGINEERING SUMMARY:

All components identified within the allowable repair limits established by EthosEnergy Engineering have been refurbished in full accordance with the approved Work Scope of Repair and under the supervision of UNEW’s proprietary engineering and QA/QC system. Each detected anomaly was evaluated, categorized, and repaired using the method defined in the Defect Reference and Repair Method Table, which specifies the applied technology—precision blending, localized weld and blend restoration, high-temperature brazing, or dimensional re-establishment, individually or in combination.

Throughout the process, UNEW’s engineering team maintained complete control of repair methodology, material selection, and acceptance criteria, ensuring metallurgical integrity and dimensional accuracy beyond OEM reference limits. Each component underwent multi-stage heat treatment cycles optimized to its alloy microstructure, material fatigue history, and metallographic response verified during the incoming inspection.

Advanced inert-gas welding systems, vacuum furnaces, and precision machining centers were employed to achieve uniform grain structure, full stress relief, and geometric restoration to sub-millimeter tolerances. Non-destructive testing (FPI, dimensional laser mapping, and coating adhesion analysis) verified complete defect elimination and metallurgical soundness.

Unlike OEM parts, which are designed for generic global environments, UNEW’s refurbishment and manufacturing standards are specifically calibrated for the unique ambient, fuel, and load conditions of NSRP’s MNQC turbine fleet. This environmental customization—combined with aviation-grade materials and EthosEnergy’s state-of-the-art facility—results in component performance and reliability that exceeds OEM baseline quality.

All refurbished shroud blocks are therefore certified as fully serviceable, compliant with UNEW and EthosEnergy standards, and engineered for superior durability under NSRP’s specific operating conditions.

5. CERTIFICATE OF CONFORMANCE STATEMENT:

EthosEnergy (Thailand) Ltd. hereby certifies and guarantees that all components referenced in the correlation section of this report have been fully refurbished, processed, and inspected in strict accordance with EthosEnergy’s approved repair standards, UNEW’s proprietary specifications, and all applicable contractual and quality requirements.

All refurbishment activities were executed under controlled conditions using qualified procedures, calibrated equipment, and certified personnel. Each component has successfully passed dimensional verification, metallurgical evaluation, and final QA/QC inspection.

Accordingly, all components covered by this report are confirmed to be in fully serviceable condition and are released for operational use with performance and reliability meeting or exceeding OEM standards.

6. COMPONENT CORRELATION:

CORRELATION SHEET (Body)			
Item	Part number	Serial number	Material
1	109E9147G05 REV T	POT-2107-01	SS310
2	—	POT-2107-02	SS310
3	109E9147G05 REV T	POT-2107-03	SS310
4	109E9147G05 REV T	POT-2107-04	SS310
5	—	POT-2107-05	SS310
6	—	POT-2107-06	SS310
7	109E9147G05 REV T	POT-2107-07	SS310
8	—	POT-2107-08	SS310
9	109E9147G05 REV T	POT-2107-09	SS310
10	109E9147G05 REV T	POT-2107-10	SS310
11	—	POT-2107-11	SS310
12	109E9147G05 REV T	POT-2107-12	SS310
13	—	POT-2107-13	SS310
14	109E9147G05 REV T	POT-2107-14	SS310
15	109E9147G05 REV T	POT-2107-15	SS310
16	109E9147G05 REV T	POT-2107-16	SS310
17	109E9147G05 REV T	POT-2107-17	SS310
18	109E9147G05 REV T	POT-2107-18	SS310
19	—	POT-2107-19	SS310
20	109E9147G05 REV T	POT-2107-20	SS310
21	109E9147G05 REV T	POT-2107-21	SS310
22	109E9147G05 REV T	POT-2107-22	SS310
23	109E9147G05 REV T	POT-2107-23	SS310
24	109E9147G05 REV T	POT-2107-24	SS310

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6. COMPONENT CORRELATION:(Continue)

CORRELATION SHEET(Tip shoes/Inner plate)							
Item	Part number	Serial number	Material	Item	Part number	Serial number	Material
1A	176D3829P001	176DDH84H-056	Inconel 738	13A	176D3829P001	176DDH84H-086	Inconel 738
1B	176D3829P001	176DDH84H-179	Inconel 738	13B	176D3829P001	76DDH84H-086	Inconel 738
1C	176D3829P001	176DDH84H-047	Inconel 738	13C	176D3829P001	176DDH84H-148	Inconel 738
2A	176D3829P001	176DDH84H-209	Inconel 738	14A	176D3829P001	176DDH84H-018	Inconel 738
2B	176D3829P001	176DDH84H-189	Inconel 738	14B	176D3829P001	176DDH84H-155	Inconel 738
2C	176D3829P001	176DDH84H-211	Inconel 738	14C	176D3829P001	176DDH84H-133	Inconel 738
3A	176D3829P001	176DDH84H-100	Inconel 738	15A	176D3829P001	176DDH84H-020	Inconel 738
3B	176D3829P001	176DDH84H-016	Inconel 738	15B	176D3829P001	176DDH84H-083	Inconel 738
3C	176D3829P001	176DDH84H-017	Inconel 738	15C	176D3829P001	176DDH84H-087	Inconel 738
4A	176D3829P001	176DDH84G-191	Inconel 738	16A	176D3829P001	176DDH84H-140	Inconel 738
4B	176D3829P001	176DDH84G-174	Inconel 738	16B	176D3829P001	176DDH84H-014	Inconel 738
4C	176D3829P001	176DDH84H-193	Inconel 738	16C	176D3829P001	176DDH84H-066	Inconel 738
5A	176D3829P001	176DDH84H-064	Inconel 738	17A	176D3829P001	176DDH84H-038	Inconel 738
5B	176D3829P001	176DDH84H-036	Inconel 738	17B	176D3829P001	176DDH84H-006	Inconel 738
5C	176D3829P001	176DDH84G-171	Inconel 738	17C	176D3829P001	176DDH84H-153	Inconel 738
6A	176D3829P001	176DDH84G-194	Inconel 738	18A	176D3829P001	176DDH84H-200	Inconel 738
6B	176D3829P001	176DDH84H-205	Inconel 738	18B	176D3829P001	176DDH84H-42	Inconel 738
6C	176D3829P001	176DDH84G-168	Inconel 738	18C	176D3829P001	176DDH84H-093	Inconel 738
7A	176D3829P001	176DDH84G-155	Inconel 738	19A	176D3829P001	176DDH84G-169	Inconel 738
7B	176D3829P001	176DDH84G-199	Inconel 738	19B	176D3829P001	76DDH84H-190	Inconel 738
7C	176D3829P001	176DDH84H-187	Inconel 738	19C	176D3829P001	176DDH84H-195	Inconel 738
8A	176D3829P001	176DDH84G-162	Inconel 738	20A	176D3829P001	176DDH84H-058	Inconel 738
8B	176D3829P001	176DDH84H-204	Inconel 738	20B	176D3829P001	176DDH84H-194	Inconel 738
8C	176D3829P001	176DDH84G-198	Inconel 738	20C	176D3829P001	176PDH6HH-180	Inconel 738
9A	176D3829P001	176DDH84H-186	Inconel 738	21A	176D3829P001	176DDH84H-026	Inconel 738
9B	176D3829P001	176DDH84H-005	Inconel 738	21B	176D3829P001	176DDH84H-208	Inconel 738
9C	176D3829P001	176DDH84G-163	Inconel 738	21C	176D3829P001	176DDH84H-062	Inconel 738
10A	176D3829P001	176DDH84H-043	Inconel 738	22A	176D3829P001	176DDH84H-035	Inconel 738
10B	176D3829P001	176DDH84G-173	Inconel 738	22B	176D3829P001	176DDH84H-196	Inconel 738
10C	176D3829P001	176DDH84H-061	Inconel 738	22C	176D3829P001	176DDH84H-045	Inconel 738
11A	176D3829P001	176DDH84H-094	Inconel 738	23A	176D3829P001	176DDH84H-185	Inconel 738
11B	176D3829P001	176DDH84H-098	Inconel 738	23B	176D3829P001	176DDH84H-167	Inconel 738
11C	176D3829P001	176DDH84H-145	Inconel 738	23C	176D3829P001	176DDH84H-210	Inconel 738
12A	176D3829P001	176DDH84H-162	Inconel 738	24A	176D3829P001	176DDH84G-172	Inconel 738
12B	176D3829P001	176DDH84H-040	Inconel 738	24B	176D3829P001	176DDH84G-170	Inconel 738
12C	176D3829P001	176DDH84H-178	Inconel 738	24C	176D3829P001	176DDH84G-166	Inconel 738

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7. Scope of Work

Work scope	Inspect	Heavy	Coating
Inspect			
Perform receipt inspection and record serial numbers	X		
Degrease components	X		
Perform metallurgical evaluation of base material and coating type, report on condition	X		
Disassemble inner plate from shroud body, record block number plates are removed from.	X		
Abrasive blast to remove coating and to clean, blow out with dry compressed air to remove all media	X		
Perform visual inspection and segregate obvious scrap components	X		
Perform incoming solution heat treatment in partial pressure vacuum environment (shroud face only)	X		
Mask non coated surfaces and chemical strip to remove coating.	X		
Perform fluorescent penetrant inspection and record all defects	X		
Perform dimensional inspection, report all non-conformities	X		
Compile incoming inspection report and forward to customer	X		
Repair			
Blend to remove oxidation product on pressure face surface		X	
Scallop/ Route to remove defective material in pressure face, location rails preparation for weld repair		X	
Perform local penetrant inspection		X	
Perform weld repairs to the slot, pressure face, location rails		X	
Blend all repaired areas to restore component profile		X	

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Perform fluorescent penetrant inspection		X	
Perform post weld heat treatment heat treatment in full vacuum environment		X	
Perform fluorescent penetrant inspection (FPI)		X	
Perform visual inspection		X	
Perform dimensional inspection		X	
Coating			
Mask off non coated areas in preparation for abrasive blast			X
Abrasive blast gas path surfaces to receive coating			X
Blow out with clean dry compressed air to ensure no media entrapment			X
Apply TBC Abradable coating to gas path areas/heavy			X
Perform coating heat treatment in furnace/heavy			X
Perform dimensional inspection			X
Perform final visual inspection (plates and blocks)			X
Final assemblies shroud plates to blocks			X
Compile Final Report, pack and ship components with all required documentation			X

9. ENGINEERING DETAIL WORK DONE:

9.1 Detailed Repair Process

The GE 6FA.03 1st Stage Shroud Blocks underwent a comprehensive heavy-repair refurbishment performed under UNEW's proprietary engineering control system and executed by EthosEnergy's certified turbine component repair facilities. All tasks were carried out by qualified personnel using precision-controlled processes, calibrated equipment, and traceable consumables. The operations below summarize the complete repair flow, following UNEW's approved repair work scope.

9.1.1 Strip Inner Shroud Coating

All existing abrasadable and thermal barrier coatings were removed to expose the base substrate for inspection and metallurgical evaluation. Coatings were removed using a combination of chemical stripping and controlled grit blasting, maintaining substrate integrity. All datum faces, seal lands, and attachment points were masked to preserve dimensional accuracy. Following coating removal, surfaces were cleaned and documented photographically for traceability.

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9.1.2 Blend Minor Indications Existing in Block and Tile

Surface oxidation, fretting, or superficial cracking was eliminated without compromising the base structure. Indications identified through fluorescent penetrant inspection (FPI) were blended using micro-abrasive tools under magnification. All blending depths were limited to engineering-approved thresholds per UNEW technical specifications.

9.1.3 Perform Pre-Weld Heat Treat on Shroud Segments

Each segment underwent vacuum furnace pre-weld heat treatment under a defined temperature-time cycle specific to SS310 and Inconel 738 alloys. Controlled ramp and soak rates prevented grain coarsening or intergranular oxidation.

9.1.4 Weld Repair Shroud Block

Damaged zones such as erosion, corrosion, or cracks were excavated and cleaned using carbide tools and ultrasonic cleaning. GTAW welding was performed using compatible filler alloy under inert gas shielding. Weld layers were deposited gradually, maintaining interpass temperature control to ensure metallurgical bonding and minimize distortion.

9.1.5 Weld Repair of Tiles (Inner Plates)

Defective areas were removed by mechanical routing and restored through precision micro-TIG welding using aerospace-grade filler material. Post-weld heat treatment was performed to restore grain boundary integrity and eliminate residual stress.

9.1.6 Reestablish Seal Slot on Tiles

Seal slots were laser-mapped to determine distortion or wear, rebuilt by weld addition, and machined to original geometry using precision CNC milling.

9.1.7 Recoat Shroud with Current Production Coating

A new generation TBC Abradable Coating System was applied to protect against thermal fatigue and erosion. Surfaces were grit blasted to achieve a defined surface roughness profile. A multilayer abradable ceramic coating was applied using High Velocity Oxy-Fuel (HVOF) deposition equipment. Final curing and diffusion bonding were performed in an inert environment to stabilize coating structure.

9.1.8 Final Clean and QA Inspection

All parts underwent ultrasonic cleaning to remove contaminants. A complete FPI re-inspection confirmed no remaining cracks or surface defects. Dimensional verification was performed using coordinate measuring machines (CMM). Coating thickness and adhesion were validated using cross-section samples and bond-strength tests.

9.2 Technical Integrity of the Process

The operations described above represent the highest class of industrial turbine component repair, involving controlled welding, heat treatment, advanced coating systems, and precision metrology.

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Each process was executed using UNEW's proprietary engineering procedures under EthosEnergy's ISO-certified environment. The integration of UNEW's design oversight with EthosEnergy's automated infrastructure ensures repeatable precision and technical accountability at every stage.

9.3 Adaptation to NSRP's MNQC Turbines

This repair program was not generic; it was specifically adapted to NSRP's operational data and environmental conditions. UNEW's engineering analysis considered actual fuel composition and sulfur content used at NSRP, firing temperature profiles and start/stop cycle history, ambient humidity, corrosion trends, and cooling air chemistry unique to the Nghi Son Refinery. These factors guided every repair parameter from welding filler selection to coating thickness specification, making these components engineered for NSRP, not merely repaired for reuse.

9.4 Exceeding OEM Standards

Unlike OEM components, which are manufactured to uniform global specifications, UNEW's refurbished parts are custom-optimized for NSRP's site conditions. This results in extended component life expectancy, reduced maintenance cycle frequency, improved gas path sealing and turbine output efficiency, and enhanced resistance to corrosion, oxidation, and thermal distortion. Each completed shroud block exceeds OEM metallurgical, dimensional, and coating standards.

9.5 Quality Assurance and Certification

All processes were governed under UNEW's comprehensive QA/QC management system, with EthosEnergy performing under ISO 9001:2015, ISO 14001:2015, and ISO 45001:2018 certifications. UNEW maintains full technical authority and traceability for process parameters, welding records, coating batch data, and final inspection validation results. Each part has been verified as fully compliant, serviceable, and cleared for operational use under NSRP's LTSA framework.

9.6 Declaration

This refurbishment program represents the highest level of technical commitment from UNEW and EthosEnergy to NSRP. It combines U.S. aviation-grade engineering, U.K. repair precision, and site-specific customization to produce components that will deliver safe, efficient, and durable performance for NSRP's MNQC turbine fleet. This document stands as both a technical certification and a declaration of engineering excellence, affirming that NSRP's turbines are now supported by components restored to standards exceeding those of original manufacture.

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10. MATERIAL EVALUATION

Report No.	L11061				Job order no.	824031					
Serial no.(or ID)	Item# 1				Cutting location	Body					
Received status	<input checked="" type="checkbox"/> As-Received <input type="checkbox"/> Pre-Weld HT <input type="checkbox"/> Post-Weld HT <input type="checkbox"/> Other										
Analysis Result											
Main composition,%									Hardness Test	-	
Element	Co	Cr	Ni	Ti	W	Ta	Mo	Fe	Al	Grain size	-
Nominal	-	24-26	19-22	-	-	-	-	Bal	-	Coating Type	No Coating
Result	-	23.9	19.4	-	-	-	-	53.9	-	Nearest Alloy	SS310
Microstructure											

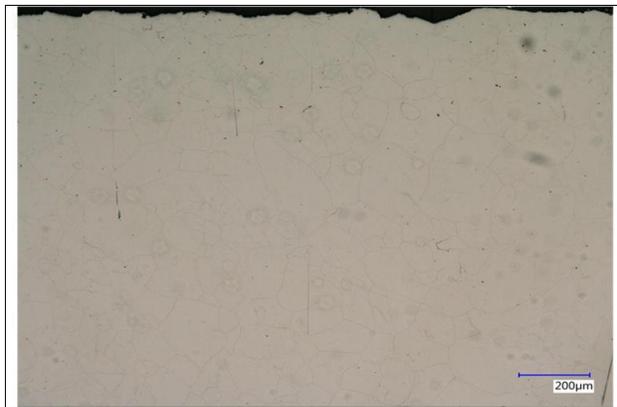


Fig.1 Showing the hot gas path surface condition.(Etched)

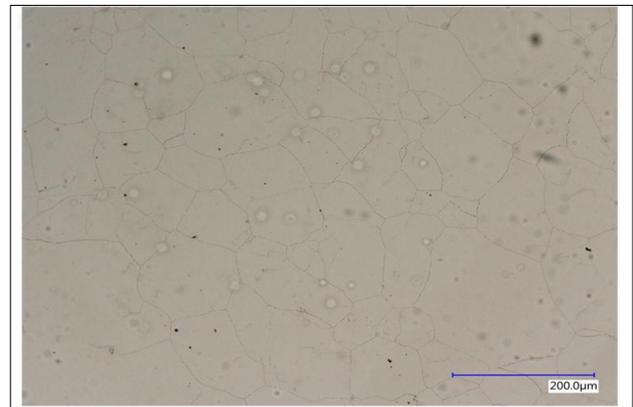


Fig.2 Showing the typical microstructure at higher magnification.(Etched)

The entire hot gas path surface was uncoated, leaving the base alloy directly exposed to high-temperature gas flow and resulting in significant thermal degradation. This condition confirms that the component requires a heavy repair process rather than a standard refurbishment.

Despite the extent of distress, the part remains fully restorable within UNEW’s engineering capability through the application of our aviation-grade metallurgical restoration technologies. All repair operations were performed using precision-controlled equipment, qualified welding procedures, and advanced heat treatment profiles developed under UNEW’s proprietary standards.

Upon structural recovery, the component were received UNEW’s proprietary thermal barrier coating (TBC) abrasible system, a next-generation ceramic coating technology derived from aerospace turbine applications and specifically adapted to NSRP’s operating environment. This coating delivers superior oxidation resistance, thermal fatigue stability, and controlled abrasibility, providing protection and durability significantly beyond that of standard OEM coatings.

Fig. 1: Metallurgical analysis identifies the substrate as SS310 alloy, exhibiting a stable austenitic gamma matrix with grain-boundary and secondary carbides indicative of long-term high-temperature exposure.

Fig. 2: The microstructure remains structurally sound and fully suitable for UNEW’s advanced weld restoration and coating application processes, ensuring continued reliability in future turbine service.

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Report No.	L11061-1	Job order no.	824031
Serial no.(or ID)	Item# 1	Cutting location	Inner plate
Received status	<input checked="" type="checkbox"/> As-Received <input type="checkbox"/> Pre-Weld HT <input type="checkbox"/> Post-Weld HT <input type="checkbox"/> Other		

Analysis Result

Main composition,%										Hardness Test	
Element	Co	Cr	Ni	Ti	W	Ta	Mo	Fe	Al	Grain size	
Nominal	8.5	16.0	61.5	3.4	2.6	-	1.8	-	3.4	Coating Type	TBC-Abradable coating
Result	8.8	14.6	61.6	3.4	2.8	-	1.9	-	3.4	Nearest Alloy	In738

Microstructure



Fig.1 Showing the hot gas path coating and substrate condition.(Etched)

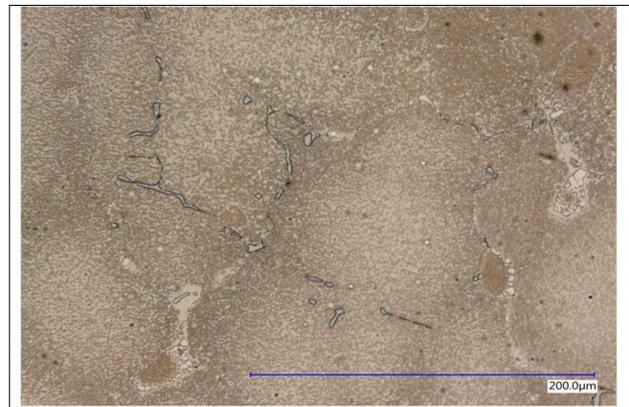


Fig.2 Showing the typical microstructure at higher magnification.(Etched)

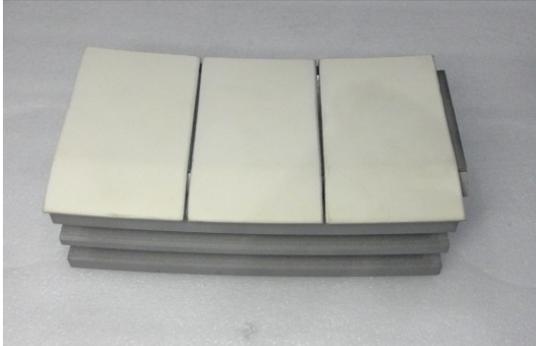
The sample was mounted in fixture L11061-1 to evaluate its suitability for heavy repair. Examination showed that the hot gas path surface was previously protected with a TBC-Abradable coating (see Fig. 1). The condition indicates significant thermal exposure and operational wear, confirming the need for an extensive restoration process.

The base material was identified as IN738 alloy, featuring a gamma matrix with fine gamma prime, grain boundary carbide, primary carbide, and dispersed secondary carbide (Fig. 2). This high-performance alloy remains structurally sound and is fully compatible with UNEW's advanced repair procedures.

After applying UNEW's proprietary aviation-grade TBC-Abradable ceramic coating, the component will gain thermal protection and dimensional integrity, with significantly improved durability and extended life compared to the generic coatings typically used by OEMs.

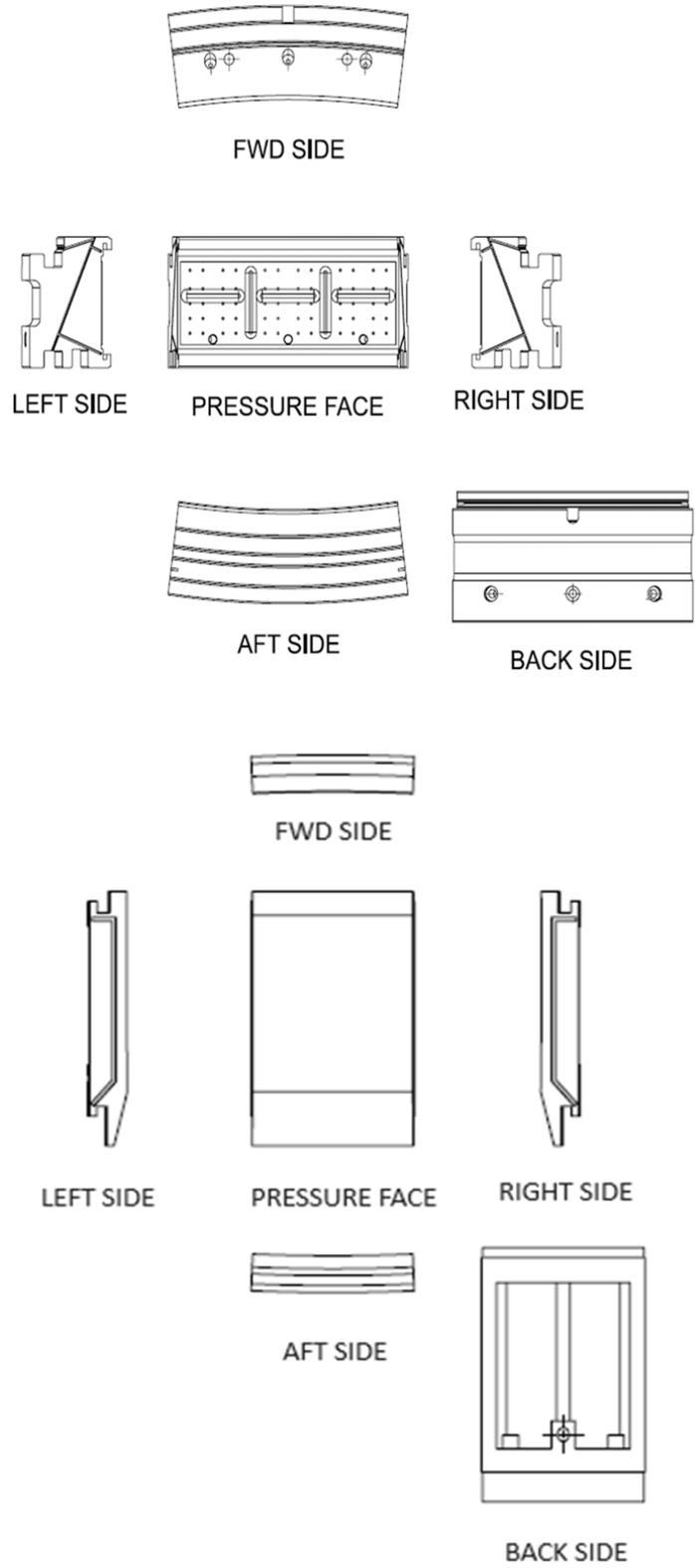
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11. PHOTOGRAPHS:

	
<p>Fig.1 Final inspection/repair.</p>	<p>Fig.2 Final inspection/repair.</p>
	
<p>Fig.3 Final inspection/repair.</p>	<p>Fig.4 Final inspection/repair.</p>
	
<p>Fig.5 Final inspection/repair.</p>	<p>Fig.6 Final inspection/repair.</p>

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12. DEFECT LEGEND TABLE:



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DEFECT LEGEND LABEL: Body											
ITEM	POSITION										
	Top face					Left side/Right side					
	Cracking	Frettage	Corrosion	Porosity	F.O.D.	Cracking	Frettage	Corrosion	Porosity	Deformation	F.O.D.
1											B/WB
2											B
3											B
4											B
5											B
6											B
7											B
8											B/WB
9											B/WB
10											B
11											B
12											B
13											B/WB
14											B
15											B/WB
16											B/WB
17											B/WB
18											B
19											B
20											B
21											B
22											B
23											B/WB
24											B/WB

DEFECT LEGEND LABEL: Body											
ITEM	POSITION										
	FWD side						AFT side				
	Cracking	Frettage	Corrosion	Porosity	Deformation	F.O.D.	Cracking	Frettage	Corrosion	Porosity	F.O.D.
1		B/WB						B			
2		B/WB						B			
3		B/WB						B			
4		B/WB						B			
5		B/WB						B			
6		B/WB						B			
7		B/WB						B			
8		B/WB						B			
9		B/WB						B			
10		B/WB						B			
11		B/WB						B			
12		B/WB						B			
13		B/WB						B			
14		B/WB						B			
15		B/WB						B			
16		B/WB						B			
17		B/WB						B			
18		B/WB						B			
19		B/WB						B			
20		B/WB						B			
21		B/WB						B			
22		B/WB						B			
23		B/WB						B			
24		B/WB						B			

FINAL INSPECTION REPORT

DEFECT LEGEND TABEL: Body											
ITEM	POSITION										
	Back side					Cover plate					
	Cracking	Frettage	Corrosion	Porosity	F.O.D.	Cracking	Corrosion	Deformation	Porosity	F.O.D.	Missing material
1											
2											
3											
4											
5											
6											
7											
8											
9											
10											
11											
12											
13											
14											
15											
16											
17											
18											
19											
20											
21											
22											
23											
24											

DEFECT LEGEND TABEL: Inner plate/Tip shoe											
ITEM	POSITION										
	Pressure face					Left side/Right side					
	Cracking	Frettage	Corrosion	Porosity	Missing material	Cracking	Frettage	Corrosion	Porosity	Deformation	F.O.D.
1			B					B			
2			B/WB					B/WB			
3			B/WB					B/WB			
4			B					B			
5			B					B			
6			B/WB					B/WB			
7			B					B			
8			B/WB					B/WB			
9			B/WB					B/WB			
10			B/WB					B/WB			
11	WB		B/WB					B/WB			
12	WB		B/WB					B/WB			
13			B					B			
14			B					B			
15			B					B			
16			B					B			
17	WB		B					B			
18			B					B			
19	WB		B/WB					B/WB			
20			B					B			
21			B					B			
22			B					B			
23			B					B			
24			B					B			B/WB

FINAL INSPECTION REPORT

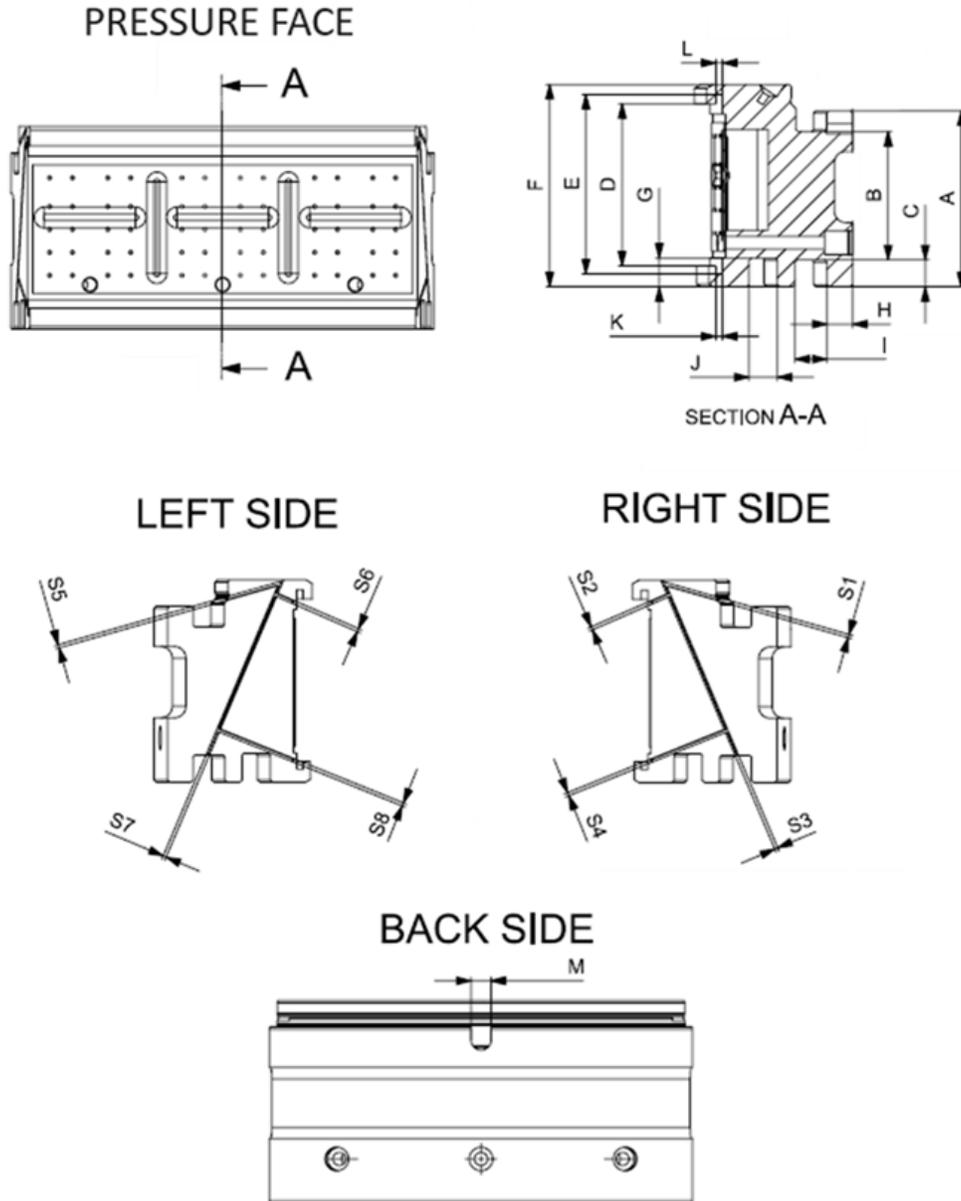
DEFECT LEGEND TABLE: Inner plate											
ITEM	POSITION										
	FWD side					AFT side					
	Cracking	Frettage	Corrosion	Missing material	F.O.D.	Cracking	Corrosion	Deformation	Missing material	F.O.D.	Frettage
1			B								
2			B								
3			B								
4			B								
5			B								
6			B								
7			B								
8			B								
9			B								
10			B								
11			B								
12			B								
13			B								
14			B	WB/WM					WB/WM		
15			B								
16			B								
17			B	WB/WM					WB/WM		
18			B								
19			B								
20			B								
21			B								
22			B								
23			B								
24			B								

DEFECT LEGEND TABLE: Inner plate					
ITEM	POSITION				
	Back side				
	F.O.D.	Cracking	Frettage	Corrosion	Deformation
1				B	
2				B	
3				B	
4				B	
5				B	
6				B	
7				B	
8				B	
9				B	
10				B	
11				B	
12				B	
13				B	
14				B	
15				B	
16				B	
17				B	
18				B	
19				B	
20				B	
21				B	
22				B	
23				B	
24				B	

B = Blend repair to be performed in accordance with the location blend limits.
JK = jacking and contouring to be performed based on the deformation and distortion detected.
WB = Weld and Blend to be performed based on the area limits and defects detected.
WM = Weld and Machining to be performed to build material dimensions and restore original dimensions and contours.
WE = Welding and Electric discharge machining (EDM) to be performed to build material dimensions and restore original dimensions.
TPR = Transient Phase Restoration to be performed based on the defects detected.
R = Replace with new.
ACC = Acceptable as is.
Rej = Dimension unacceptable and will require repair or cause of scrap.
S = Non-repairable / Scrap
L = Light repair category
M = Medium repair category
H = Heavy repair category
EX = Salvation repair category

FINAL INSPECTION REPORT

13. DIMENSION INSPECTION:(Body)



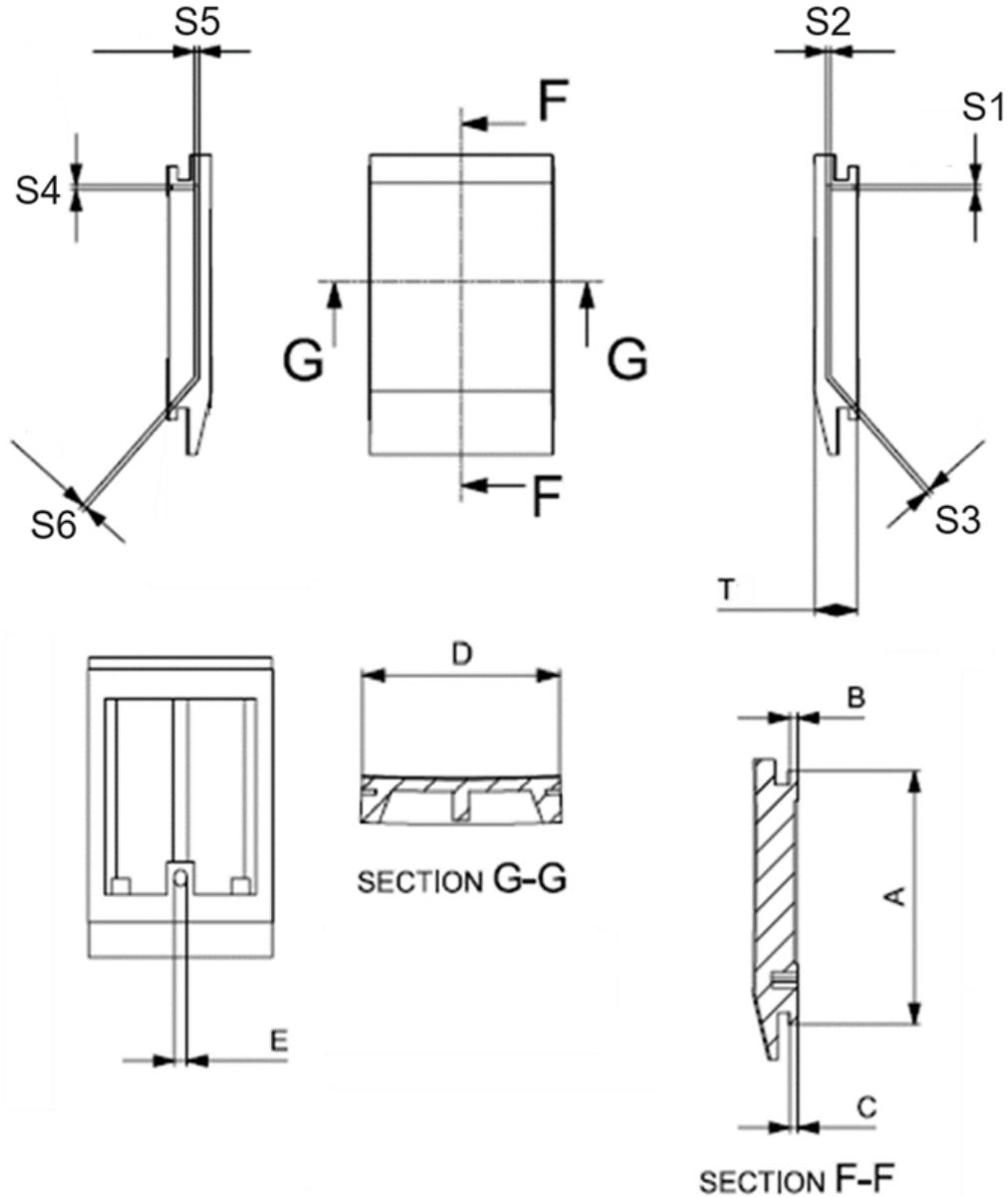
FINAL INSPECTION REPORT

Dimension Inspection (Unit: mm)												
ITEM	POSITION											Result
	A	B	C	D	E	F	G	H	I	J	K	
1	97.43	71.02	14.92	89.63	99.17	111.89	15.93	14.21	17.51	15.73	3.83	ACC
2	97.57	71.08	14.91	89.69	99.12	112.04	16.07	14.57	17.56	15.84	3.85	ACC
3	97.65	71.05	14.99	89.55	99.03	111.90	16.09	14.29	17.58	15.76	3.86	ACC
4	97.50	71.02	15.05	89.61	99.14	111.92	16.03	14.27	17.57	15.86	3.78	ACC
5	97.56	71.04	15.13	89.71	99.15	112.14	16.28	14.29	17.52	15.70	3.86	ACC
6	97.56	71.08	15.14	89.67	99.14	111.94	16.22	14.21	17.52	15.84	3.71	ACC
7	97.50	71.10	14.97	89.62	99.04	112.08	16.27	14.25	17.56	15.84	3.84	ACC
8	97.64	71.13	14.93	89.64	99.08	111.85	16.06	14.31	17.50	15.82	3.88	ACC
9	97.62	71.10	14.91	89.63	99.04	111.94	16.27	14.28	17.50	15.85	3.83	ACC
10	97.48	71.04	15.23	89.64	99.12	111.84	16.17	14.29	17.53	15.84	3.83	ACC
11	97.60	70.95	14.88	89.65	99.14	111.87	16.02	14.33	17.58	15.78	3.86	ACC
12	97.51	71.03	15.23	89.63	99.04	111.82	16.18	14.38	17.52	15.87	3.86	ACC
13	97.50	71.00	14.95	89.57	99.06	111.97	15.98	14.29	17.65	15.80	3.79	ACC
14	97.55	71.09	14.92	89.69	99.02	111.92	16.03	14.56	17.58	15.84	3.80	ACC
15	97.51	71.12	15.13	89.55	99.17	112.04	16.19	14.39	17.58	15.85	3.83	ACC
16	97.65	71.03	15.05	89.60	99.14	112.16	16.16	14.37	17.55	15.75	3.87	ACC
17	97.49	71.09	15.13	89.55	99.04	111.84	16.14	14.05	17.71	15.79	3.84	ACC
18	97.56	71.01	14.80	89.56	99.29	111.86	15.85	14.30	17.56	15.78	3.88	ACC
19	97.46	71.14	14.90	89.58	99.20	111.93	16.14	14.28	17.75	15.82	3.92	ACC
20	97.49	71.01	14.98	89.60	99.01	112.04	16.11	14.39	17.53	15.79	3.84	ACC
21	97.52	70.99	14.98	89.77	99.30	111.86	15.98	14.31	17.73	15.77	3.84	ACC
22	97.49	71.07	14.94	89.61	99.1	112.02	16.05	14.34	17.64	15.68	3.84	ACC
23	97.51	71.03	15.18	89.65	99.13	112.07	16.10	14.25	17.57	15.46	3.83	ACC
24	97.61	71.06	15.25	89.61	99.01	112.11	16.10	14.22	17.52	15.82	3.83	ACC

Dimension Inspection (Unit: mm)											
ITEM	POSITION										Result
	L	M	S1	S2	S3	S4	S5	S6	S7	S8	
1	3.82	11.19	1.79	1.72	1.77	1.80	1.75	1.85	1.71	1.74	ACC
2	3.88	11.28	1.83	1.74	1.73	1.75	1.79	1.72	1.81	1.80	ACC
3	3.82	11.20	1.73	1.81	1.88	1.75	1.80	1.78	1.83	1.78	ACC
4	3.79	11.19	1.80	1.72	1.77	1.81	1.73	1.80	1.74	1.84	ACC
5	3.70	11.19	1.70	1.79	1.76	1.76	1.74	1.79	1.82	1.73	ACC
6	3.85	11.17	1.71	1.70	1.83	1.79	1.75	1.80	1.82	1.71	ACC
7	3.79	11.18	1.77	1.84	1.76	1.77	1.74	1.77	1.81	1.72	ACC
8	3.73	11.24	1.74	1.71	1.81	1.84	1.76	1.79	1.85	1.82	ACC
9	3.80	11.18	1.72	1.73	1.78	1.73	1.72	1.73	1.84	1.77	ACC
10	3.72	11.16	1.81	1.72	1.83	1.81	1.78	1.84	1.85	1.84	ACC
11	3.81	11.29	1.81	1.79	1.84	1.72	1.77	1.94	1.73	1.76	ACC
12	3.77	11.27	1.81	1.72	1.84	1.81	1.79	1.79	1.88	1.99	ACC
13	3.75	11.27	1.70	1.72	1.72	1.71	1.74	1.72	1.72	1.76	ACC
14	3.83	11.17	1.70	1.84	1.88	1.88	1.73	1.73	1.78	1.82	ACC
15	3.84	11.21	1.71	1.81	1.72	1.74	1.74	1.76	1.77	1.80	ACC
16	3.81	11.19	1.71	1.73	1.91	1.82	1.79	1.76	1.80	1.82	ACC
17	3.85	11.29	1.72	1.80	1.74	1.78	1.72	1.95	1.80	1.81	ACC
18	3.86	11.20	1.73	1.86	1.96	1.74	1.85	1.70	1.99	1.79	ACC
19	3.86	11.22	1.73	1.81	1.79	1.81	1.90	1.86	1.76	1.72	ACC
20	3.75	11.30	1.73	1.71	1.89	1.75	1.83	1.79	1.89	1.86	ACC
21	3.76	11.20	1.77	1.72	1.76	1.81	1.73	1.74	1.76	1.75	ACC
22	3.80	11.19	1.78	1.73	1.74	1.74	1.73	1.75	1.71	1.72	ACC
23	3.82	11.17	1.70	1.75	1.78	1.76	1.76	1.74	1.72	1.76	ACC
24	3.81	11.24	1.76	1.74	1.77	1.73	1.74	1.73	1.74	1.74	ACC

FINAL INSPECTION REPORT

13. DIMENSION INSPECTION:(Inner plate)



FINAL INSPECTION REPORT

Dimension Inspection (Unit: mm): Segment A													
ITEM	POSITION												Result
	A	B	C	S1	S2	S3	S4	S5	S6	D	T	E	
1	97.98	3.43	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.34	16.66	4.70	ACC
2	98.00	3.50	3.46	1.80	1.80	1.80	1.80	1.80	1.80	71.39	16.74	4.70	ACC
3	98.07	3.43	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.38	17.00	4.70	ACC
4	98.00	3.49	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.27	16.97	4.70	ACC
5	98.00	3.42	3.44	1.80	1.80	1.80	1.80	1.80	1.80	71.37	16.97	4.70	ACC
6	98.02	3.50	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.67	4.70	ACC
7	97.93	3.39	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.37	16.90	4.70	ACC
8	98.00	3.46	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.24	16.96	4.70	ACC
9	98.03	3.42	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.64	4.70	ACC
10	98.05	3.42	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.36	16.96	4.70	ACC
11	98.00	3.40	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.13	16.90	4.70	ACC
12	98.03	3.46	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.96	4.70	ACC
13	98.00	3.48	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.20	17.03	4.70	ACC
14	97.98	3.50	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.38	17.00	4.70	ACC
15	98.05	3.50	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.39	17.22	4.70	ACC
16	98.05	3.41	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.27	16.79	4.70	ACC
17	98.06	3.50	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.27	17.01	4.70	ACC
18	98.01	3.50	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.22	16.50	4.70	ACC
19	97.98	3.46	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.81	4.70	ACC
20	98.01	3.50	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.32	16.94	4.70	ACC
21	98.08	3.48	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.22	16.82	4.70	ACC
22	98.07	3.44	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.37	16.60	4.70	ACC
23	97.92	3.45	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.34	16.91	4.70	ACC
24	97.99	3.50	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.27	16.94	4.70	ACC

Unit:mm

FINAL INSPECTION REPORT

Dimension Inspection (Unit: mm): Segment B													
ITEM	POSITION											Result	
	A	B	C	S1	S2	S3	S4	S5	S6	D	T		E
1	98.01	3.44	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.35	17.02	4.70	ACC
2	98.00	3.46	3.46	1.80	1.80	1.80	1.80	1.80	1.80	71.37	16.92	4.70	ACC
3	98.00	3.44	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.33	16.80	4.70	ACC
4	97.95	3.47	3.46	1.80	1.80	1.80	1.80	1.80	1.80	71.15	16.74	4.70	ACC
5	98.03	3.43	3.45	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.60	4.70	ACC
6	97.98	3.56	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.34	16.85	4.70	ACC
7	98.03	3.45	3.46	1.80	1.80	1.80	1.80	1.80	1.80	71.30	17.01	4.70	ACC
8	97.98	3.46	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.22	17.07	4.70	ACC
9	98.08	3.38	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.93	4.70	ACC
10	97.98	3.50	3.47	1.80	1.80	1.80	1.80	1.80	1.80	71.36	16.95	4.70	ACC
11	98.05	3.48	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.37	17.12	4.70	ACC
12	97.94	3.46	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.93	4.70	ACC
13	98.01	3.48	3.47	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.87	4.70	ACC
14	98.02	3.45	3.46	1.80	1.80	1.80	1.80	1.80	1.80	71.33	17.06	4.70	ACC
15	98.04	3.47	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.13	17.17	4.70	ACC
16	98.03	3.46	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.81	4.70	ACC
17	98.02	3.47	3.45	1.80	1.80	1.80	1.80	1.80	1.80	71.28	16.56	4.70	ACC
18	98.00	3.46	3.46	1.80	1.80	1.80	1.80	1.80	1.80	71.36	16.81	4.70	ACC
19	98.03	3.46	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.34	17.03	4.70	ACC
20	98.01	3.42	3.47	1.80	1.80	1.80	1.80	1.80	1.80	71.30	17.01	4.70	ACC
21	98.01	3.45	3.45	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.94	4.70	ACC
22	97.97	3.49	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.28	17.02	4.70	ACC
23	98.05	3.46	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.38	17.03	4.70	ACC
24	97.99	3.51	3.45	1.80	1.80	1.80	1.80	1.80	1.80	71.34	16.98	4.70	ACC

Unit:mm

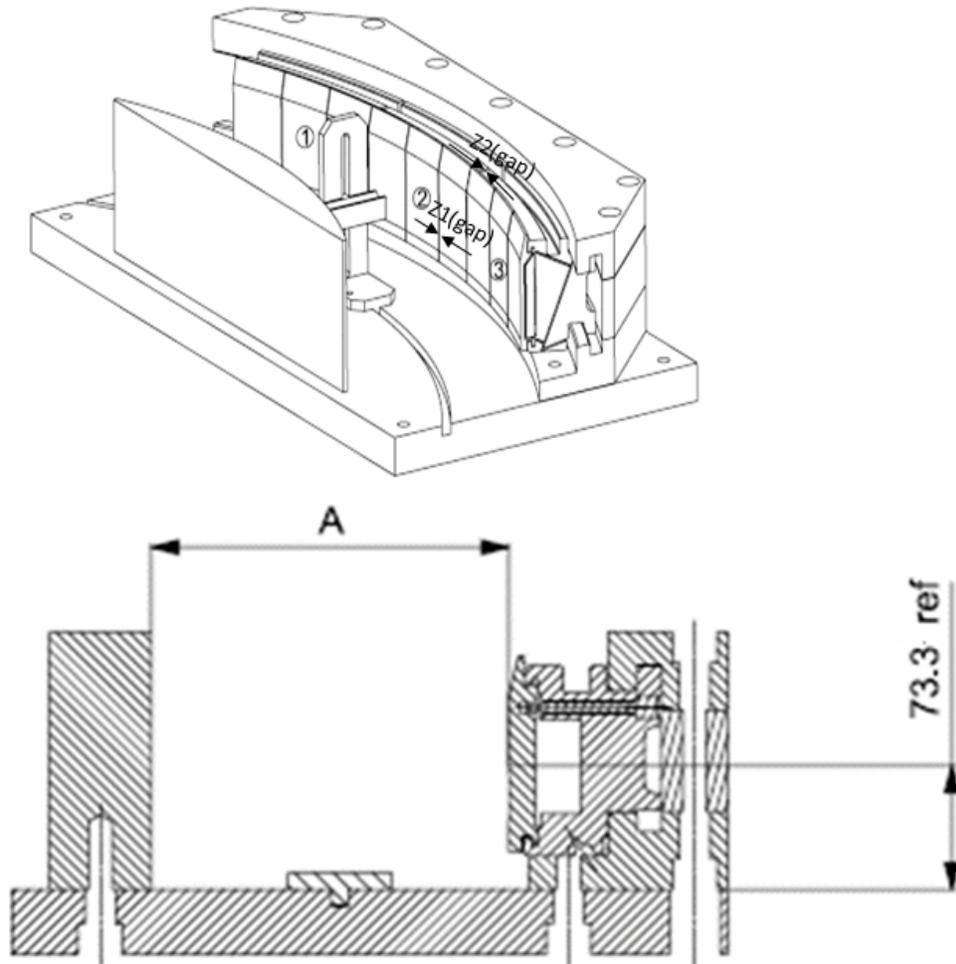
FINAL INSPECTION REPORT

Dimension Inspection (Unit: mm): Segment C													
ITEM	POSITION											Result	
	A	B	C	S1	S2	S3	S4	S5	S6	D	T		E
1	98.01	3.49	3.47	1.80	1.80	1.80	1.80	1.80	1.80	71.38	16.90	4.70	ACC
2	98.00	3.46	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.30	16.92	4.70	ACC
3	98.01	3.47	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.19	16.69	4.70	ACC
4	98.01	3.49	3.46	1.80	1.80	1.80	1.80	1.80	1.80	71.27	17.04	4.70	ACC
5	97.99	3.47	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.26	16.45	4.70	ACC
6	98.02	3.47	3.47	1.80	1.80	1.80	1.80	1.80	1.80	71.39	17.18	4.70	ACC
7	97.99	3.46	3.47	1.80	1.80	1.80	1.80	1.80	1.80	71.39	16.71	4.70	ACC
8	97.99	3.47	3.47	1.80	1.80	1.80	1.80	1.80	1.80	71.37	16.96	4.70	ACC
9	97.97	3.50	3.46	1.80	1.80	1.80	1.80	1.80	1.80	71.39	16.81	4.70	ACC
10	98.01	3.49	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.31	16.83	4.70	ACC
11	98.08	3.47	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.40	17.09	4.70	ACC
12	98.07	3.46	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.30	16.99	4.70	ACC
13	98.03	3.50	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.13	17.00	4.70	ACC
14	98.04	3.48	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.22	16.92	4.70	ACC
15	97.95	3.46	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.39	16.97	4.70	ACC
16	98.03	3.50	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.21	16.97	4.70	ACC
17	98.04	3.47	3.46	1.80	1.80	1.80	1.80	1.80	1.80	71.28	16.70	4.70	ACC
18	98.10	3.49	3.49	1.80	1.80	1.80	1.80	1.80	1.80	71.36	16.90	4.70	ACC
19	97.98	3.46	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.39	17.02	4.70	ACC
20	98.01	3.48	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.37	16.88	4.70	ACC
21	98.05	3.49	3.47	1.80	1.80	1.80	1.80	1.80	1.80	71.39	17.00	4.70	ACC
22	97.95	3.46	3.50	1.80	1.80	1.80	1.80	1.80	1.80	71.37	16.89	4.70	ACC
23	97.98	3.47	3.48	1.80	1.80	1.80	1.80	1.80	1.80	71.39	16.86	4.70	ACC
24	97.99	3.48	3.46	1.80	1.80	1.80	1.80	1.80	1.80	71.35	16.92	4.70	ACC

Unit:mm

FINAL INSPECTION REPORT

13. DIMENSION INSPECTION:(Fixture inspection)



FINAL INSPECTION REPORT

Dimension Inspection (Unit: mm)											
Item no.	Tip shoe/ Inner plate	POSITION			Result	Item no.	Tip shoe/ Inner plate	POSITION			Result
		A	Z1	Z2				A	Z1	Z2	
1	A	207.89	ACC	ACC	ACC	11	A	207.65	ACC	ACC	ACC
	B	207.70	ACC				ACC				
	C	207.81	ACC				ACC				
2	A	207.90	ACC	ACC	ACC	12	A	207.82	ACC	ACC	ACC
	B	207.77	ACC				ACC				
	C	207.80	ACC				ACC				
3		207.78	ACC	ACC	ACC	13	A	207.80	ACC	ACC	ACC
	B	207.90	ACC				ACC				
	C	207.90	ACC				ACC				
4	A	207.88	ACC	ACC	ACC	14	A	207.80	ACC	ACC	ACC
	B	207.89	ACC				ACC				
	C	207.66	ACC				ACC				
5	A	207.78	ACC	ACC	ACC	15	A	207.85	ACC	ACC	ACC
	B	207.89	ACC				ACC				
	C	207.90	ACC				ACC				
6	A	207.88	ACC	ACC	ACC	16	A	207.90	ACC	ACC	ACC
	B	207.88	ACC				ACC				
	C	207.87	ACC				ACC				
7	A	207.82	ACC	ACC	ACC	17	A	207.79	ACC	ACC	ACC
	B	207.90	ACC				ACC				
	C	207.86	ACC				ACC				
8	A	207.68	ACC	ACC	ACC	18	A	207.90	ACC	ACC	ACC
	B	207.79	ACC				ACC				
	C	207.90	ACC				ACC				
9	A	207.87	ACC	ACC	ACC	19	A	207.89	ACC	ACC	ACC
	B	207.82	ACC				ACC				
	C	207.84	ACC				ACC				
10	A	207.75	ACC	ACC	ACC	20	A	207.86	ACC	ACC	ACC
	B	207.88	ACC				ACC				
	C	207.90	ACC				ACC				

Dimension Inspection (Unit: mm)					
Item no.	Tip shoe/ Inner plate	POSITION			Result
		A	Z1	Z2	
21	A	207.83	ACC	ACC	ACC
	B	207.81	ACC		ACC
	C	207.78	ACC		ACC
22	A	207.89	ACC	ACC	ACC
	B	207.73	ACC		ACC
	C	207.73	ACC		ACC
23	A	207.81	ACC	ACC	ACC
	B	207.76	ACC		ACC
	C	207.90	ACC		ACC
24	A	207.77	ACC	ACC	ACC
	B	207.72	ACC		ACC
	C	207.86	ACC		ACC

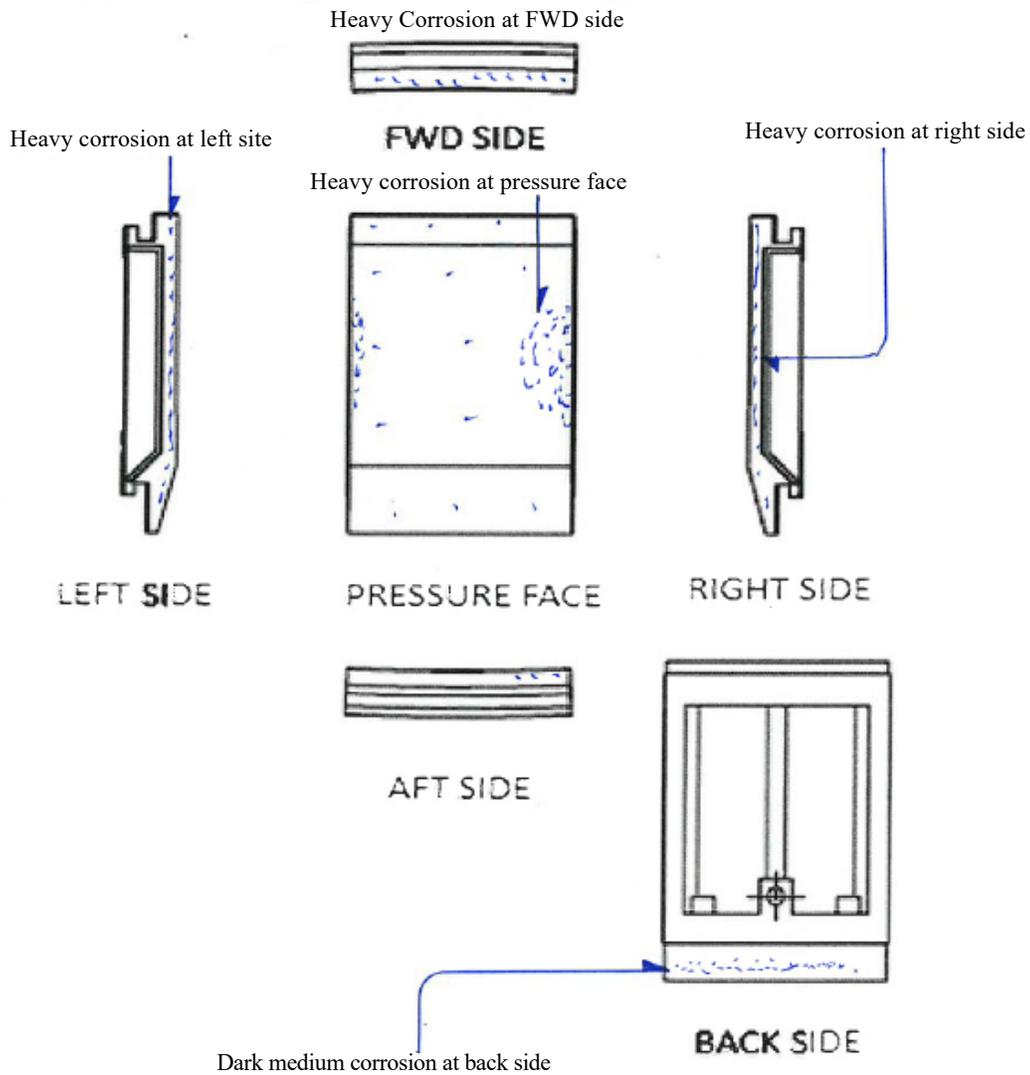
FINAL INSPECTION REPORT

14. DEFECT MAP:

INSPECTION AND PROCESS RECORD SHEET	MS6001FA STAGE 1 SHROUD BLOCK	IPRS NO.	3068-40
	PART NUMBER : GESB01M6FA	REV.	01
CUSTOMER :		CUSTOMER PO :	
JOB NUMBER :	824031	OP.	0120
INSPECTED BY :	Methee	DATE :	04/07/2025

Mapping of FPI and Visual Inspection

Crack (mm)
 Foreign Object Damage (L/M/H)
 Fretting (L/M/H)
 Distortion (mm/mm²)
 Corrosion (L/M/H)
 Missing Material (mm²)



TYPICAL DEFECT

Unit: mm

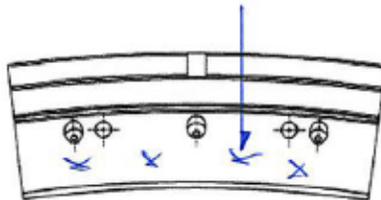
FINAL INSPECTION REPORT

INSPECTION AND PROCESS RECORD SHEET	MS6001FA STAGE 1 SHROUD BLOCK		IPRS NO. 3068-40
	PART NUMBER : GESB01M6FA		REV. 01
CUSTOMER :		CUSTOMER PO :	
JOB NUMBER :	824031	OP.	0130
INSPECTED BY :	Methree	DATE :	4/9/2025

Mapping of FPI and Visual Inspection



Heavy fretting at FWD side



FWD SIDE

Heavy F.O.D. at left side

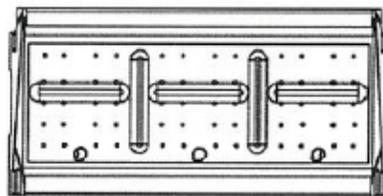


LEFT SIDE

Heavy F.O.D. at right side

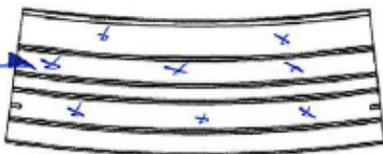


RIGHT SIDE

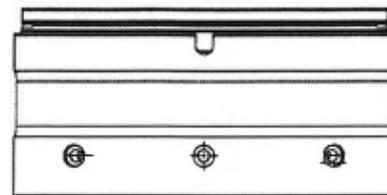


PRESSURE FACE

Dark medium F.O.D. at AFT side



AFT SIDE



BACK SIDE

TYPICAL DEFECT

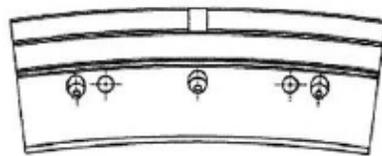
Unit: mm

FINAL INSPECTION REPORT

INSPECTION AND PROCESS RECORD SHEET	MS6001FA STAGE 1 SHROUD BLOCK	IPRS NO.	3068-40
	PART NUMBER : GESB01M6FA	REV.	01
CUSTOMER :		CUSTOMER PO :	
JOB NUMBER :	824031	OP.	0120
INSPECTED BY :	Melhee	DATE :	11/7/2025

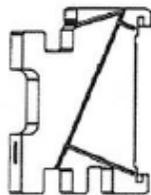
Mapping of FPI and Visual Inspection

Crack (mm)
 Foreign Object Damage (L/M/H)
 Fretting (L/M/H)
 Deformation area(mm²)
 Corrosion (L/M/H)
 Missing Material (mm²)

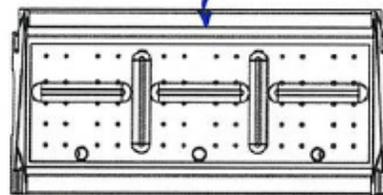


FWD SIDE

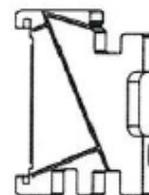
Cutting for lab No. 1



LEFT SIDE



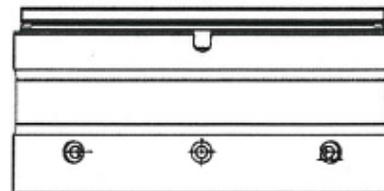
PRESSURE FACE



RIGHT SIDE



AFT SIDE



BACK SIDE

NON TYPICAL DEFECT

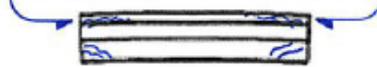
Unit: mm

FINAL INSPECTION REPORT

INSPECTION AND PROCESS RECORD SHEET	MS6001FA STAGE 1 SHROUD BLOCK	IPRS NO.	3068-40
	PART NUMBER : GESB01M6FA	REV.	01
CUSTOMER :		CUSTOMER PO :	
JOB NUMBER :	824031	OP.	0120
INSPECTED BY :	Methee	DATE :	04/07/2025
Mapping of FPI and Visual Inspection			

Crack (mm)
 Foreign Object Damage (L/M/H)
 Fretting (L/M/H)
 Deformation (mm)
 Corrosion (L/M/H)
 Missing Material (mm)

20x20 mm missing part on FWD side, No. 14,17

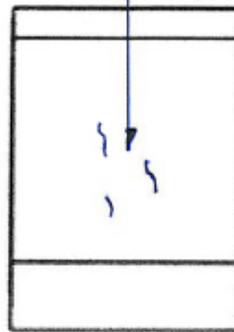


FWD SIDE

2-15mm crack at pressure face No. 11, 12, 17, 19



LEFT SIDE



PRESSURE FACE



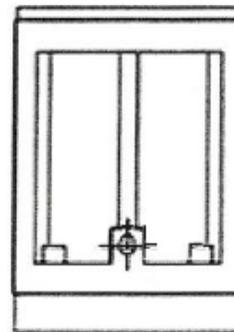
RIGHT SIDE

Heavy F.O.D. at left side, No. 24



AFT SIDE

20x20mm missing materials at AFT side No. 14, 17



BACK SIDE

NON TYPICAL DEFECT

Unit: mm

FINAL INSPECTION REPORT

INSPECTION AND PROCESS RECORD SHEET	MS6001FA STAGE 1 SHROUD BLOCK	IPRS NO.	3068-40
	PART NUMBER : GESB01M6FA	REV.	01
CUSTOMER :	Nghi Son Refinery &	CUSTOMER PO :	PO04102025-HGP
JOB NUMBER :	824031	OP.	Final
INSPECTED BY :	Kriangkrai.	DATE :	30/08/2025
Mapping of FPI and Visual Inspection			

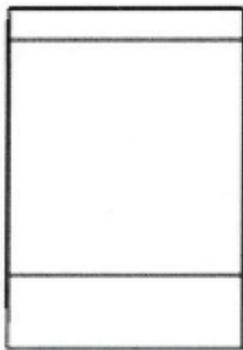
Crack (mm)
 Foreign Object Damage (L/M/F)
 Porosity (L/M/F)
 Distortion (mm)
 Corrosion (L/M/F)
 Missing Material (mm²)



FWD SIDE



LEFT SIDE



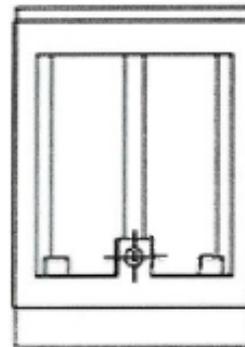
PRESSURE FACE



RIGHT SIDE



AFT SIDE



BACK SIDE

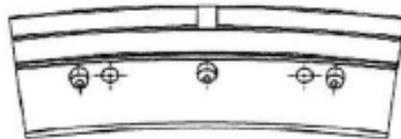
Unit: mm

FINAL INSPECTION REPORT

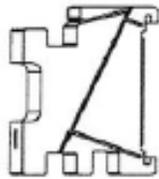
			
INSPECTION AND PROCESS RECORD SHEET	MS6001FA STAGE 1 SHROUD BLOCK	IPRS NO.	3068-40
	PART NUMBER : GESB01M6FA	REV.	01
CUSTOMER :	Nghi Son Refinery &	CUSTOMER PO :	PO04102025-HGP
JOB NUMBER :	824031	OP.	Final
INSPECTED BY :	Kriangkrai.	DATE :	30/08/2025

Mapping of FPI and Visual Inspection

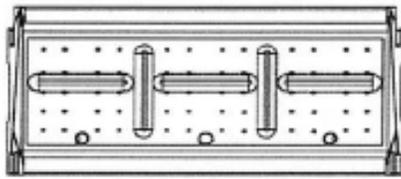
-  Crack (mm)
-  Foreign Object Damage (L/M/H)
-  Fracture (L/M/H)
-  Distortion (arc/mm²)
-  Corrosion (L/M/H)
-  Missing Material (mm²)



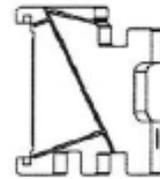
FWD SIDE



LEFT SIDE



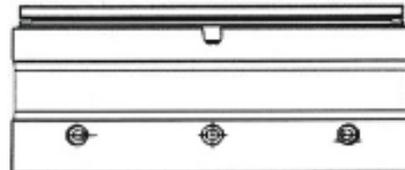
PRESSURE FACE



RIGHT SIDE



AFT SIDE



BACK SIDE