

INCOMING INSPECTION REPORT

Customer	Nghi Son Refinery & Petrochemical LLC	Report Date	June 12, 2026
Report No.	UNEW-NSRP-825355-SB2-IIR-Rev01	UNEW Job No.	825355
Customer P.O. No.	WO-1004061634-100406	Component	MS6001FA 2nd Stage Shroud Block
Engine Type	MS6001FA (GE Frame 6FA)	Qty. Received	24 pieces (1 complete set)
Component Part No.	146E3480G001 / G002 / G003 REV-	As-Received Coating	No coating reported
Material	Haynes HR-120	As-Received Seal	Honeycomb seals applied
Repair Classification	Level 6 of 10 – Medium Repair	Repair Work Category	Standard / Medium Refurbishment (Levels 4–7 band)
Service Cycle	No information supplied	Fuel Hours	No information supplied

Reviewed and approved by



Paul McGill
Engineering Manager

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1. EXECUTIVE SUMMARY

Twenty-four (24) MS6001FA 2nd stage shroud blocks were received from Nghi Son Refinery and Petrochemical LLC for incoming inspection and repair routing under UNEW Job No. 825355. The set consists of shroud block P/N 146E3480G001, 146E3480G002 and 146E3480G003, material Haynes HR-120. The as-received condition included honeycomb seals and no coating reported on the received components.

The incoming inspection identified full-set seal restoration requirements, honeycomb seal ID rejection, corrosion, fretting/wear, local FOD indications, local cracking, dimensional verification requirements and repeat inspection/heat-treatment control requirements. The incoming inspection findings route all twenty-four honeycomb seals for replacement, and the dimensional inspection records the honeycomb seal ID as rejected (REJ) for all 24 shroud blocks.

The required restoration is a controlled full-set refurbishment. The work is driven by the combined condition of all 24 shroud blocks, including 24/24 honeycomb seal replacement, weld-and-blend requirements at local crack/FOD areas, blend repair for corrosion and fretting areas, incoming solution heat treatment, repeated FPI, dimensional checks in the 3-piece fixture, age heat treatment, honeycomb braze heat treatment, final dimensional verification and final visual inspection. Based on these technical findings and the composite repair-scope assessment in Section 5, the complete set is classified Level 6 of 10 – Medium Repair (significant but controlled restoration) within the Standard / Medium Refurbishment band (Levels 4–7) of the ten-level repair severity classification.

2. INTRODUCTION

The MS6001FA 2nd stage shroud block operates in the hot gas path and is exposed to high-temperature gas flow, thermal cycling, seal rubbing, vibration, corrosion, fretting and repeated service exposure. The incoming inspection identified multiple repair drivers, including honeycomb seal wear/rejection, corrosion on pressure face, forward side, aft side and side faces, local cracks, local FOD, fretting at honeycomb and seal contact areas, and dimensional control requirements.

The repair work remains within repairable limits at the incoming inspection stage. No scrap recommendation is made at this stage. All recorded indications are addressable by controlled shop processes within the normal repairability margin of the component. Final release remains subject to completed repair results, FPI/NDT acceptance, heat-treatment records, dimensional verification, honeycomb braze inspection, assembly/fixture fit-up verification, final visual inspection and final acceptance documentation.

3. INSPECTION SUMMARY

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Order / History	Finding	Component / Routing	Finding
Customer P.O. No.	WO-1004061634-100406	Engine Type	MS6001FA
Date of Report	June 12, 2026	Component Type	2nd Stage Shroud Block
UNEW Job No.	825355 (IPRS No. 3069-40, Rev. 00)	Component Part No.	146E3480G001 / G002 / G003 REV-
Quantity Received	24 pieces	Material Type	Haynes HR-120
Incoming Packing	Good	As-Received Coating	No coating reported
Transit Damage	No transit damage reported	As-Received Seal	Honeycomb seals
Total Fired Hours	No information supplied	Previous Repairs	No information supplied
Fuel Type / Mode	No information supplied	Repair Classification	Level 6 of 10 – Medium Repair
Scrap Recommendation	None at incoming stage	Disposition	Repair and restore per technical work scope

4. DEFECT SUMMARY

This section summarizes the as-received condition, the numerical/quantity basis and the required restoration process for each affected area. Individual indications are repairable by controlled shop processes; because the complete 24-piece set is affected, the work requires coordinated repair control, repeated FPI, heat treatment, seal-system renewal, dimensional verification and final fit-up confirmation.

No.	Defect Basis	Finding	Required Restoration / Repair Process	Technical Significance / Repair Control
1	Total received components	24 shroud blocks received. P/N 146E3480G001/G002/G003 REV-, Haynes HR-120 material.	Full-set inspection, serial control, defect mapping, dimensional baseline, repair routing and final release.	All 24 pieces require serial control and final release documentation.
2	Honeycomb seal condition	24/24 honeycomb seals require replacement. Honeycomb seal ID is	Remove existing honeycomb, prepare pressure-face surfaces, fit replacement	Seal function and honeycomb ID restoration are full-set repair drivers.

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		recorded as REJ for 24/24 components.	honeycombs, braze heat treatment, blend excess honeycomb and inspect.	
3	Pressure face condition	Pressure face corrosion is recorded across the set. The defect map identifies 2-5 mm cracks at pressure face on shroud blocks No. 1, 7 and 11.	Blend corrosion areas; excavate local cracks; weld-and-blend as required; verify by FPI and visual inspection.	Local crack restoration plus full-set corrosion blending requires controlled repair and inspection hold points.
4	Left/right side condition	Left/right side cracking is routed as weld-and-blend across 24/24 shroud blocks. Local FOD is identified at left side No. 13, 20 and 24, and right side No. 17 and 20.	Prepare local crack/FOD areas, weld-and-blend where required, blend to profile and perform FPI after repair.	Side-wall crack and FOD repair is a major routing driver but remains within normal repairability margin.
5	Forward side condition	Forward side light corrosion and light-to-medium frettage are shown on typical defect mapping. Forward-side corrosion/frettage is routed for blend repair.	Blend corrosion/frettage areas, clean repair surfaces and verify profile/fit-up.	Forward-side repair is controlled by surface restoration and final fit-up check.
6	Aft side condition	Aft side corrosion and light-to-heavy frettage are identified. Aft-side wear/frettage is routed mainly to blend repair, with local weld-and-blend at No. 24.	Blend repair and local weld-and-blend where required; verify profile and surface condition after repair.	Aft-side frettage affects sealing/contact condition and requires final verification.
7	FOD indications	Medium FOD is recorded at left side No. 13, 20, 24 and right side No. 17, 20.	Remove damaged material by controlled blend; weld-and-blend if remaining defect exceeds blend limits.	Local FOD affects material buildup/blend routing and requires FPI after repair.
8	Dimensional baseline	Incoming dimensional record covers A through K for 24/24 components (264 recorded measurement points). Measured ranges are A 0.18 mm, B 0.19 mm, C 0.35 mm, D 0.34 mm, E 0.14 mm, F 0.38 mm, G 0.39 mm, H 0.25 mm, I 0.34 mm, J 0.29 mm and K 0.12 mm.	Use incoming baseline for final comparison after repair, honeycomb replacement, braze heat treatment and final assembly/fixture check.	Geometry is recoverable, but final dimensional verification is required.
9	Inspection / heat treatment	Work scope includes incoming solution heat treatment, FPI, dimensional inspection, age heat treatment, FPI after heat treatment, honeycomb braze	Execute repair sequence with documented QA hold points and final acceptance review.	Multiple process hold points are required before release.

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		heat treatment and final inspection.		
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5. TECHNICAL REPAIR SCOPE ASSESSMENT MATRIX

The table below links each observed condition to its incoming measurement or quantity basis and to the required repair control. The purpose is to document what was found, why the work is technically controlled, and how the shroud blocks will be restored and verified before release. Each core technical review category is assessed against the ten-level repair severity classification basis; where multiple criteria apply, the more severe technical condition governs.

Technical Area	Inspection Reference / Technical Criteria	Incoming Measurement / Repair Requirement and Repair Control	Assessment Value
Welding / Material Buildup	Assessment value 3: multiple local weld areas or local crack/FOD excavation requiring weld, blend, FPI and heat-treatment control.	Incoming basis: 2-5 mm crack indications are identified at pressure face No. 1, 7 and 11. Left/right side cracking is routed as weld-and-blend across 24/24 shroud blocks. Medium FOD is identified at left side No. 13, 20, 24 and right side No. 17, 20. Repair control: local weld-and-blend with FPI hold points.	3
Dimensional Restoration	Assessment value 3: local geometry/fit/seal condition affected but recoverable by controlled repair and final verification.	Incoming basis: honeycomb seal ID recorded as REJ for 24/24 components. Dimensional A–K measured for all 24 components (264 measurement points). Maximum observed measured range among A–K is 0.39 mm at Dimension G; second largest is 0.38 mm at Dimension F. Repair control: final comparison after weld/blend, braze, honeycomb replacement and 3-piece fixture check.	3
Coating / Base Metal Condition	Assessment value 2: localized light surface oxidation/corrosion requiring cleaning, blend and inspection; no coating-system restoration required.	Incoming basis: no coating reported as received; the component is processed in the uncoated as-received condition, and no coating strip/re-coat cycle is required. Corrosion recorded on pressure face, left/right side, forward side and aft side is light per the typical defect map and is removable by abrasive blast and controlled blend without structural base-metal buildup. Repair control: abrasive blast, blend corrosion/oxidation products, FPI/visual inspection and final acceptance.	2
Seal Path / Honeycomb Recovery	Assessment value 3: seal-path recovery is required with local machining/blend	Incoming basis: 24/24 honeycomb seals require replacement and 24/24 honeycomb seal ID positions are rejected. Heavy	3

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	and replacement of sealing features.	fretting at honeycomb seal and aft-side fretting are recorded. Repair control: remove honeycomb, prepare pressure face, fit new honeycomb, braze heat treatment, blend excess honeycomb and final dimensional/visual check.	
Inspection / Heat Treatment / Engineering Control	Assessment value 3: repeated inspection or intermediate process hold points are required.	Incoming basis: repair plan includes incoming solution heat treatment in partial pressure vacuum, FPI, dimensional inspection, age heat treatment, FPI after heat treatment, braze heat treatment, final visual inspection and final report. Repair control: documented QA hold points and final release review.	3
Overall Repair Classification	Level 6 of 10 corresponds to significant but controlled restoration: multiple repair areas, larger weld/braze restoration, measurable material loss, base-metal recovery and repeated inspection, while all indications remain within normal reparability margins.	Applicable composite assessment: $3 + 3 + 2 + 3 + 3 = 14$. The complete SB2 set is classified Level 6 of 10 – Medium Repair within the Standard / Medium Refurbishment band (Levels 4–7). This remains an incoming classification and final acceptance will depend on completed repair and QA results.	14

Standard / medium repair (Level 6 of 10) is included in the agreed refurbishment scope and requires no additional repair charge.

6. DIMENSIONAL MEASUREMENT SUMMARY

The following dimensional values are computed from the incoming inspection dimensional record for 24 shroud blocks (dimensions A through K, 264 recorded measurement points in total). They are used as the incoming baseline for post-repair comparison. Unit: mm.

Dimension	Minimum	At Item	Maximum	At Item	Range	Average	Median	Std. Dev.	Measured Points
A	13.29	Item 8	13.47	Item 22	0.18	13.37	13.37	0.038	24
B	13.26	Item 7	13.45	Item 24	0.19	13.32	13.29	0.056	24
C	13.73	Item 7	14.08	Item 9	0.35	13.94	14.00	0.112	24
D	13.75	Item 23	14.09	Item 5	0.34	13.96	13.99	0.093	24

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E	13.16	Item 7	13.30	Item 1	0.14	13.27	13.29	0.043	24
F	11.50	Item 3	11.88	Item 18	0.38	11.70	11.73	0.127	24
G	15.20	Item 3	15.59	Item 20	0.39	15.36	15.32	0.119	24
H	116.52	Item 11	116.77	Item 17	0.25	116.63	116.66	0.065	24
I	25.72	Item 3	26.06	Item 7	0.34	25.95	25.97	0.083	24
J	13.19	Item 15	13.48	Item 20	0.29	13.30	13.27	0.090	24
K	3.80	Item 3	3.92	Item 13	0.12	3.86	3.85	0.032	24

Measurement notes: Dimension G shows the largest recorded range at 0.39 mm, followed by Dimension F at 0.38 mm and Dimension C at 0.35 mm. The smallest recorded range is 0.12 mm at Dimension K. The largest sample standard deviation is 0.127 mm at Dimension F. All A–K positions were measured on all 24 components with no missing data points. The honeycomb seal ID is separately recorded as REJ for 24/24 components and must be restored through honeycomb replacement and final dimensional verification; the honeycomb seal ID is therefore excluded from the A–K statistical baseline above.

6.1 Detailed Dimension Inspection Record

Item	A	B	C	D	E	F	G	H	I	J	K
1	13.40	13.38	13.96	13.84	13.30	11.79	15.30	116.66	25.97	13.24	3.85
2	13.43	13.27	13.77	13.85	13.30	11.68	15.33	116.66	25.94	13.24	3.88
3	13.38	13.28	13.88	13.85	13.30	11.50	15.20	116.54	25.72	13.28	3.80
4	13.42	13.40	14.05	13.93	13.30	11.74	15.26	116.55	26.01	13.29	3.83
5	13.39	13.28	13.85	14.09	13.28	11.77	15.33	116.68	25.95	13.32	3.88
6	13.35	13.29	13.98	14.00	13.25	11.64	15.54	116.63	25.95	13.22	3.80
7	13.36	13.26	13.73	14.01	13.16	11.50	15.36	116.67	26.06	13.27	3.86
8	13.29	13.35	14.00	13.90	13.23	11.61	15.31	116.66	25.97	13.31	3.85
9	13.37	13.26	14.08	13.98	13.30	11.50	15.56	116.68	26.02	13.25	3.84
10	13.36	13.30	14.00	14.06	13.30	11.56	15.46	116.61	25.90	13.38	3.88
11	13.39	13.26	14.01	14.03	13.22	11.53	15.29	116.52	25.72	13.24	3.88
12	13.33	13.26	13.99	13.95	13.19	11.71	15.25	116.67	26.00	13.25	3.90

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13	13.38	13.36	13.76	14.03	13.25	11.53	15.54	116.62	25.99	13.38	3.92
14	13.34	13.37	14.02	14.02	13.24	11.81	15.27	116.63	26.04	13.26	3.85
15	13.37	13.36	14.01	14.08	13.30	11.76	15.25	116.68	25.96	13.19	3.89
16	13.37	13.27	14.05	14.04	13.21	11.77	15.54	116.73	25.92	13.28	3.83
17	13.37	13.39	13.86	14.01	13.29	11.87	15.26	116.77	25.98	13.24	3.83
18	13.39	13.29	14.00	13.86	13.30	11.88	15.31	116.57	25.95	13.47	3.85
19	13.31	13.37	13.90	13.95	13.30	11.86	15.26	116.69	25.90	13.45	3.86
20	13.40	13.28	14.06	14.06	13.28	11.82	15.59	116.67	25.98	13.48	3.90
21	13.34	13.31	14.01	13.99	13.21	11.66	15.39	116.52	25.91	13.20	3.81
22	13.47	13.33	14.08	13.82	13.25	11.82	15.41	116.55	26.04	13.29	3.82
23	13.35	13.26	13.79	13.75	13.30	11.79	15.32	116.60	26.00	13.22	3.86
24	13.37	13.45	13.77	13.99	13.30	11.71	15.22	116.65	25.97	13.48	3.87

All values in mm. Reference positions A through K are defined on the dimension inspection drawing in Section 17.

7. DAMAGE SUMMARY AND DISPOSITION

Damage Category	Finding (As Inspected)	Disposition / Required Restoration
Honeycomb seal / seal ID	24/24 honeycomb seals require replacement; honeycomb seal ID rejected for 24/24 components.	Remove existing honeycomb, prepare surfaces, fit replacement honeycombs, braze heat treatment, blend excess honeycomb flush with shroud block side walls, inspect.
Pressure face corrosion	Corrosion recorded on pressure face; typical map indicates light corrosion at pressure face.	Abrasive blast, controlled blend to remove corrosion/oxidation products, visual inspection and FPI as required.
Pressure face cracks	2-5 mm cracks recorded at pressure face on shroud blocks No. 1, 7 and 11.	Excavate/scallop crack, weld repair, blend to profile, FPI confirmation and heat treatment.
Left/right side cracks	2-5 mm cracks recorded at left and right sides; defect table routes left/right side cracking as weld-and-blend for 24/24 pieces.	Prepare local crack areas, weld-and-blend repair, restore profile, FPI and dimensional verification.
FOD	Medium FOD at left side No. 13, 20, 24 and right side No. 17, 20.	Blend damaged areas and perform weld-and-blend where defect removal exceeds blend limits; FPI after repair.
Forward side corrosion/fretage	Light corrosion at forward side and light-to-medium fretage at forward side.	Controlled blend, clean and verify surface condition and fit-up.

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Aft side corrosion/fretage/wear	Light corrosion at aft side and light-to-heavy fretage at aft side; local weld-and-blend at No. 24 wear position.	Blend and local weld-and-blend as required; verify profile and final fit-up.
Thermocouple guide / dowel holes	Work scope includes removal/replacement of thermocouple guide as required and optional weld plug pin of old dowel holes.	Perform as required during repair, followed by visual and dimensional verification.

8. ENGINEERING EVALUATION AND RECOMMENDATION

8.1 Damage Assessment

- The defect routing identifies repair requirements across the complete 24-piece SB2 shroud block set.
- The honeycomb seal system requires full-set replacement and honeycomb seal ID recovery, with 24/24 pieces recorded as REJ for honeycomb seal ID.
- Pressure face, side, forward and aft surfaces show corrosion/fretage/wear requiring controlled blend repair and surface verification.
- Local cracks (2-5 mm) and medium FOD indications require controlled weld-and-blend repair at the identified locations (pressure face No. 1, 7, 11; left side No. 13, 20, 24; right side No. 17, 20).
- Dimensional records provide a complete incoming baseline for A through K measurements across all 24 shroud blocks (264 measurement points). Final dimensional verification must be performed after weld/blend, honeycomb replacement, braze heat treatment and final assembly/fixture check.
- The repair scope is beyond light touch-up because it includes full-set honeycomb replacement, local weld-and-blend repair, repeated FPI, heat-treatment sequence, braze heat treatment and final dimensional verification; at the same time, all indications remain within normal repairability margins and no coating-system restoration or structural base-metal buildup is required.

8.2 Engineering Conclusion

The combined technical findings require medium repair control (Level 6 of 10) for the complete 24-piece MS6001FA 2nd stage shroud block set: significant but controlled restoration with multiple repair areas, seal-system renewal, measurable material loss recovery and repeated inspection, remaining within the Standard / Medium Refurbishment band. The set remains repairable at the incoming inspection stage, with final release subject to completed repair results, FPI/NDT acceptance, heat-treatment records, dimensional verification, honeycomb braze inspection, final fit-up verification and final QA documentation.

8.3 Repair Recommendation

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- Maintain serial-number control for all 24 shroud blocks throughout the repair process.
- Perform abrasive blast, metallurgical evaluation as required, incoming solution heat treatment, FPI, visual inspection and dimensional inspection.
- Remove existing honeycomb seals and prepare pressure-face surfaces for replacement honeycombs.
- Perform controlled blend repair on corrosion, frettage and wear areas.
- Perform weld-and-blend repair at crack/FOD/local damage areas as required by the defect map and repair limits.
- Perform age heat treatment, FPI after heat treatment, honeycomb braze heat treatment and visual inspection.
- Perform final dimensional inspection in the 3-piece assembly fixture, final visual inspection, final report and controlled packing.

9. SPECIAL ADDITIONAL REPAIR SCOPE

Special Repair Scope	Numeric Basis	Qty / Unit
Incoming inspection and serial control	24 shroud blocks; full set	1 set
Abrasive blast and surface preparation	Clean all surfaces before FPI and repair	24 ea
Incoming solution heat treatment	Partial pressure vacuum environment per work scope	1 set
FPI / NDT inspection	Incoming FPI, FPI after repair/heat treatment as applicable	1 set
Dimensional inspection	A–K measurements for 24/24 shroud blocks; post-repair comparison required	24 ea
Honeycomb seal replacement	24/24 honeycombs require replacement; honeycomb seal ID REJ for 24/24 components	24 ea
Weld-and-blend repair	Cracks and FOD/local damage areas including pressure face No. 1, 7, 11 and side FOD locations	As required
Blend repair	Corrosion/frettage/wear on pressure face, forward side, aft side and side faces	As required
Age heat treatment	Based on HR-120 material specification and repair process	1 set
Honeycomb braze heat treatment	After fitting replacement honeycombs	1 set
Final dimensional / fixture check	3-piece assembly fixture and dimensional inspection after repair	1 set

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Final visual inspection and report	Final QA documentation and controlled packing	1 set
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10. SPARE PART / REPAIR-REPLACE LIST

Item	Part Description	Received / Required	Condition	Quantity	Remark
1	Honeycomb seal, replacement per UNEW repair routing	24/24	Replace	24 ea	Standard work scope

11. COMPONENT SERIAL NUMBER CORRELATION

The following serial-number correlation shall be maintained throughout repair, inspection, honeycomb replacement, heat treatment, final dimensional verification and final release. Set positions correspond to the customer packing list (Section 13).

Item	Part Number	Serial Number	Set Position	Material
1	146E3480G002 REV-	EG425889/1	POT-2108-01	Haynes HR-120
2	146E3480G003 REV-	EG425889/2	POT-2108-02	Haynes HR-120
3	146E3480G001 REV-	EG425889/3	POT-2108-03	Haynes HR-120
4	146E3480G001 REV-	EG425889/4	POT-2108-04	Haynes HR-120
5	146E3480G001 REV-	EG425889/5	POT-2108-05	Haynes HR-120
6	146E3480G003 REV-	EG425889/6	POT-2108-06	Haynes HR-120
7	146E3480G002 REV-	EG425889/7	POT-2108-07	Haynes HR-120
8	146E3480G001 REV-	EG425889/8	POT-2108-08	Haynes HR-120
9	146E3480G001 REV-	EG425889/9	POT-2108-09	Haynes HR-120
10	146E3480G001 REV-	EG425889/10	POT-2108-10	Haynes HR-120
11	146E3480G002 REV-	EG425889/11	POT-2108-11	Haynes HR-120
12	146E3480G001 REV-	EG425889/12	POT-2108-12	Haynes HR-120
13	146E3480G001 REV-	EG425889/13	POT-2108-13	Haynes HR-120
14	146E3480G003 REV-	EG425889/14	POT-2108-14	Haynes HR-120
15	146E3480G001 REV-	EG425889/15	POT-2108-15	Haynes HR-120
16	146E3480G001 REV-	EG425889/16	POT-2108-16	Haynes HR-120
17	146E3480G001 REV-	EG425889/17	POT-2108-17	Haynes HR-120

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18	146E3480G003 REV-	EG425889/18	POT-2108-18	Haynes HR-120
19	146E3480G001 REV-	EG425889/19	POT-2108-19	Haynes HR-120
20	146E3480G001 REV-	EG425889/20	POT-2108-20	Haynes HR-120
21	146E3480G001 REV-	EG425889/21	POT-2108-21	Haynes HR-120
22	146E3480G001 REV-	EG425889/22	POT-2108-22	Haynes HR-120
23	146E3480G001 REV-	EG425889/23	POT-2108-23	Haynes HR-120
24	146E3480G001 REV-	EG425889/24	POT-2108-24	Haynes HR-120

12. REPAIR WORK SCOPE SUMMARY

Work Scope Area	Required Work
Inspect	Perform receipt inspection and record serial numbers; perform metallurgical evaluation of base material as required; abrasive blast to clean all surfaces; perform incoming solution heat treatment in partial pressure vacuum environment; set in 3-piece assembly fixture and perform dimensional inspection; perform FPI; compile incoming inspection report.
Repair	Remove thermocouple guide as required; machine/blend to remove honeycomb section; blend to remove oxidation/corrosion product on external repairable areas; prepare areas for weld repair; perform weld repairs as required; blend repaired areas to restore component profile; perform dimensional inspection and FPI; perform age heat treatment; perform FPI after heat treatment.
Honeycomb	Prepare and fit replacement honeycombs to pressure-face surfaces; perform braze heat treatment; perform visual inspection; blend excess honeycomb section flush with shroud block side walls; clean surfaces if required.
Final Release	Set in 3-piece assembly fixture and perform final dimensional inspection; replace thermocouple guide as required; perform final visual inspection; compile final report; pack and ship components with required documentation.
Option	Weld plug pin of old dowel holes if required by repair routing and final inspection.

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13. PACKING LIST FROM CUSTOMER

Shroud stage #2			
NO	S/N	Set Shroud	Part number
1	EG425889	POT-2108-01	146E3480G002
2	EG425889	POT-2108-02	146E3480G003
3	EG425889	POT-2108-03	146E3480G001
4	EG425889	POT-2108-04	146E3480G001
5	EG425889	POT-2108-05	146E3480G001
6	EG425889	POT-2108-06	146E3480G003
7	EG425889	POT-2108-07	146E3480G002
8	EG425889	POT-2108-08	146E3480G001
9	EG425889	POT-2108-09	146E3480G001
10	EG425889	POT-2108-10	146E3480G001
11	EG425889	POT-2108-11	146E3480G002
12	EG425889	POT-2108-12	146E3480G001
13	EG425889	POT-2108-13	146E3480G001
14	EG425889	POT-2108-14	146E3480G003
15	EG425889	POT-2108-15	146E3480G001
16	EG425889	POT-2108-16	146E3480G001
17	EG425889	POT-2108-17	146E3480G001
18	EG425889	POT-2108-18	146E3480G003
19	EG425889	POT-2108-19	146E3480G001
20	EG425889	POT-2108-20	146E3480G001
21	EG425889	POT-2108-21	146E3480G001
22	EG425889	POT-2108-22	146E3480G001
23	EG425889	POT-2108-23	146E3480G001
24	EG425889	POT-2108-24	146E3480G001

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14. PHOTOGRAPHS

Photographs Fig.1 through Fig.30 document the as-received condition, typical condition and the identified defect locations. Defect record cards visible in the photographs reference UNEW Job No. 825355, OP# 0080, inspection date 23/05/2026.



Fig.1 As-received condition.



Fig.2 As-received condition.



Fig.3 As-received condition.



Fig.4 As-received condition.

INCOMING INSPECTION REPORT

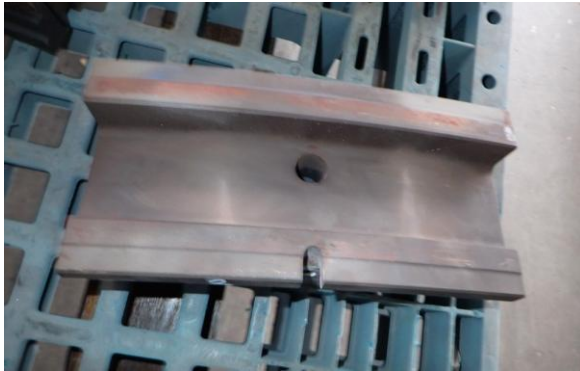


Fig.5 As-received condition.

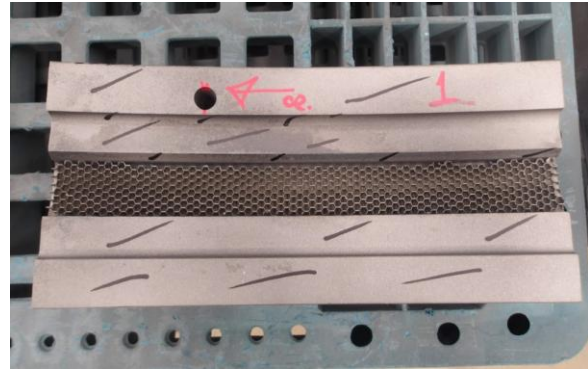


Fig.6 Typical condition.

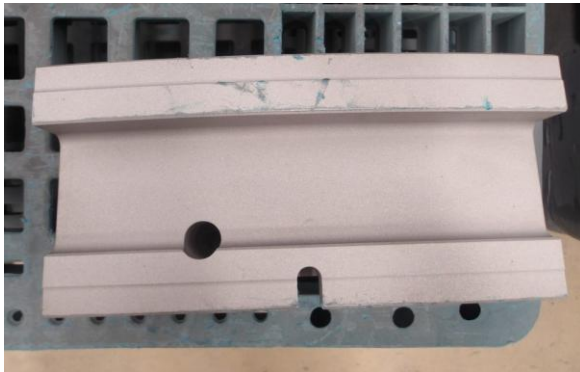


Fig.7 Typical condition.



Fig.8 Typical condition.

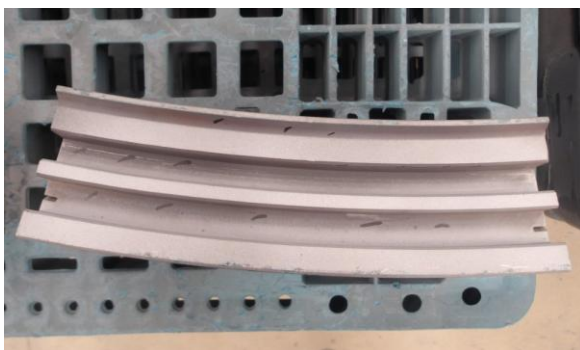


Fig.9 Typical condition.

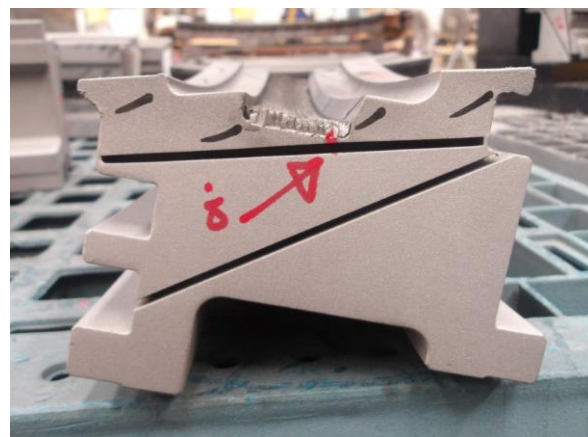


Fig.10 Typical condition.

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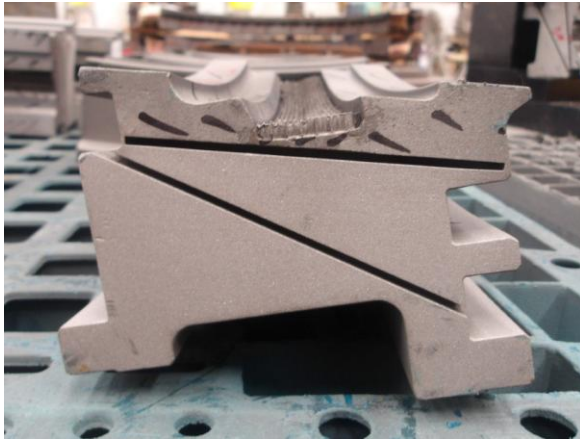


Fig.11 Typical condition.

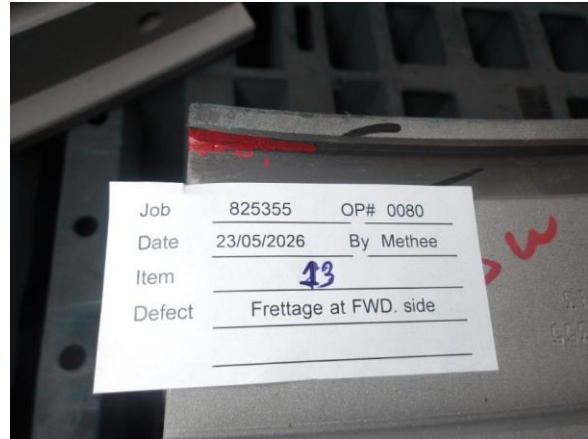


Fig.12 Fretage on forward side.



Fig.13 Fretage on honeycomb seal.

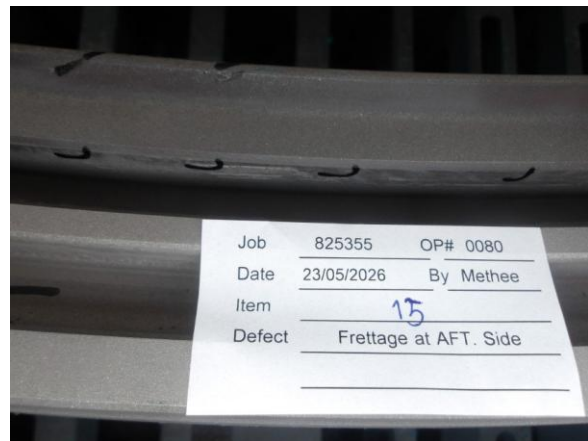


Fig.14 Fretage on aft side.



Fig.15 Fretage on aft side.



Fig.16 Corrosion on aft side.

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Fig.17 FOD on right side.



Fig.18 FOD on right side.

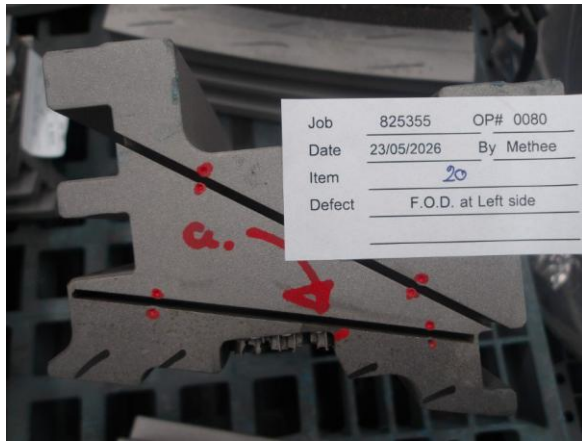


Fig.19 FOD on left side.

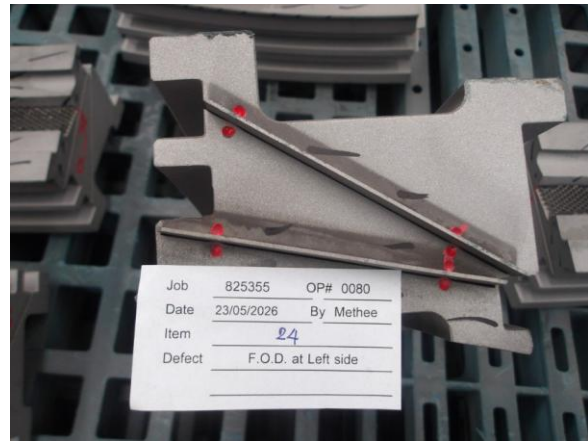


Fig.20 FOD on left side.



Fig.21 Crack on right side.



Fig.22 Crack on right side.

INCOMING INSPECTION REPORT



Fig.23 Corrosion on right side.



Fig.24 Corrosion on left side.



Fig.25 Crack on left side.

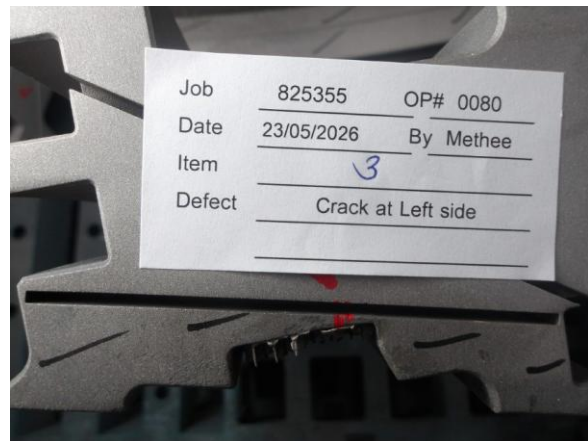


Fig.26 Crack on left side.



Fig.27 Corrosion on pressure face.



Fig.28 Corrosion on pressure face.

INCOMING INSPECTION REPORT



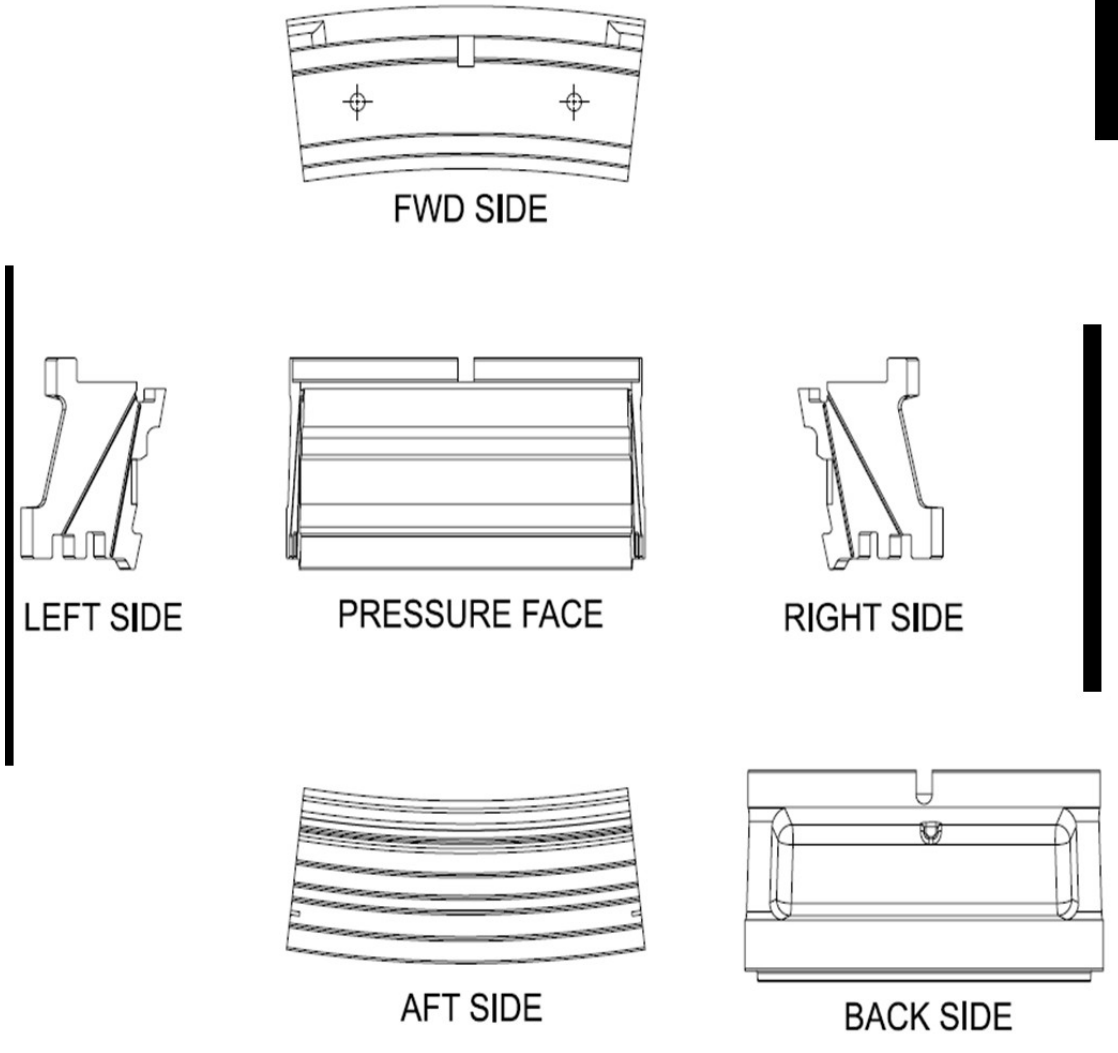
Fig.29 Crack on pressure face.



Fig.30 Crack on pressure face.

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15. DEFECT LEGEND TABLE



INCOMING INSPECTION REPORT

16. INSPECTION FINDINGS MATRIX (24/24 COMPONENTS)

Mapping of FPI and visual inspection findings per component (IPRS No. 3069-40, Rev. 00, inspected 23/05/2026). Cell entries identify the required restoration per position; blank cells indicate no recordable indication at that position.

No.	Pressure face				Left/Right side					Forward side				Aft side				Back side			Honeycomb				Honeycomb seals ID (Dimensional inspection)
	Crack king	Corrosio n	Wea r	FOD	Crack king	Corrosio n	Wea r	FOD	Miss ing mat erial	Corrosio n	Wea r	FOD	Crack king	Corrosio n	Wea r	FOD	Crack king	Crack king	Wea r	FOD	Crack king	Wea r	FOD	Defo rmat ion	
1	WB	B			WB	B				B	B			B	B							R			REJ
2		B			WB	B				B	B			B	B							R			REJ
3		B			WB	B				B	B			B	B							R			REJ
4		B			WB	B				B	B			B	B							R			REJ
5		B			WB	B				B	B			B	B							R			REJ
6		B			WB	B				B	B			B	B							R			REJ
7	WB	B			WB	B				B	B			B	B							R			REJ
8		B			WB	B				B	B			B	B							R			REJ
9		B			WB	B				B	B			B	B							R			REJ
10		B			WB	B				B	B			B	B							R			REJ
11	WB	B			WB	B				B	B			B	B							R			REJ
12		B			WB	B				B	B			B	B							R			REJ
13		B			WB	B		B/WB		B	B/WB			B	B							R			REJ
14		B			WB	B				B	B			B	B							R			REJ
15		B			WB	B				B	B			B	B							R			REJ
16		B			WB	B				B	B			B	B							R			REJ
17		B			WB	B		B/WB		B	B			B	B							R			REJ
18		B			WB	B				B	B			B	B							R			REJ
19		B			WB	B				B	B			B	B							R			REJ
20		B			WB	B		B/WB		B	B			B	B							R			REJ
21		B			WB	B				B	B			B	B							R			REJ

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MS6001FA 2nd STAGE SHROUD BLOCK

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22		B			WB	B				B	B			B	B							R			REJ
23		B			WB	B				B	B			B	B							R			REJ
24		B			WB	B		B/WB		B	B			B	WB							R			REJ

WB = Weld-and-blend repair: welding and controlled blending to be performed to build material dimensions and restore original dimensions.

B = Blend repair to be performed based on the defects detected.

TPR = Transient Phase Restoration to be performed based on the defects detected.

R = Replace with new.

ACC = Acceptable as is.

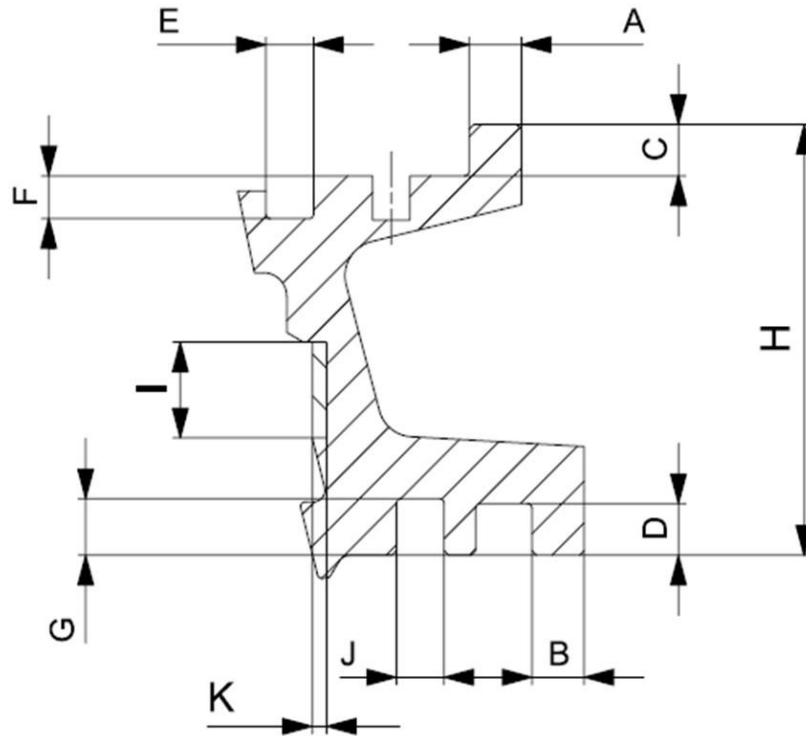
REJ = Dimension unacceptable and will require repair or cause of scrap.

S = Non-repairable / Scrap. L = Light repair category. M = Medium repair category. H = Heavy repair category. EX = Salvation repair category.

INCOMING INSPECTION REPORT

17. DIMENSION INSPECTION

Reference positions A through K are defined on the drawing below. The complete incoming dimensional record for all 24 components is repeated here against the drawing for direct reference. Unit: mm.



Item	A	B	C	D	E	F	G	H	I	J	K
1	13.40	13.38	13.96	13.84	13.30	11.79	15.30	116.66	25.97	13.24	3.85
2	13.43	13.27	13.77	13.85	13.30	11.68	15.33	116.66	25.94	13.24	3.88
3	13.38	13.28	13.88	13.85	13.30	11.50	15.20	116.54	25.72	13.28	3.80
4	13.42	13.40	14.05	13.93	13.30	11.74	15.26	116.55	26.01	13.29	3.83
5	13.39	13.28	13.85	14.09	13.28	11.77	15.33	116.68	25.95	13.32	3.88
6	13.35	13.29	13.98	14.00	13.25	11.64	15.54	116.63	25.95	13.22	3.80
7	13.36	13.26	13.73	14.01	13.16	11.50	15.36	116.67	26.06	13.27	3.86
8	13.29	13.35	14.00	13.90	13.23	11.61	15.31	116.66	25.97	13.31	3.85
9	13.37	13.26	14.08	13.98	13.30	11.50	15.56	116.68	26.02	13.25	3.84
10	13.36	13.30	14.00	14.06	13.30	11.56	15.46	116.61	25.90	13.38	3.88
11	13.39	13.26	14.01	14.03	13.22	11.53	15.29	116.52	25.72	13.24	3.88
12	13.33	13.26	13.99	13.95	13.19	11.71	15.25	116.67	26.00	13.25	3.90
13	13.38	13.36	13.76	14.03	13.25	11.53	15.54	116.62	25.99	13.38	3.92

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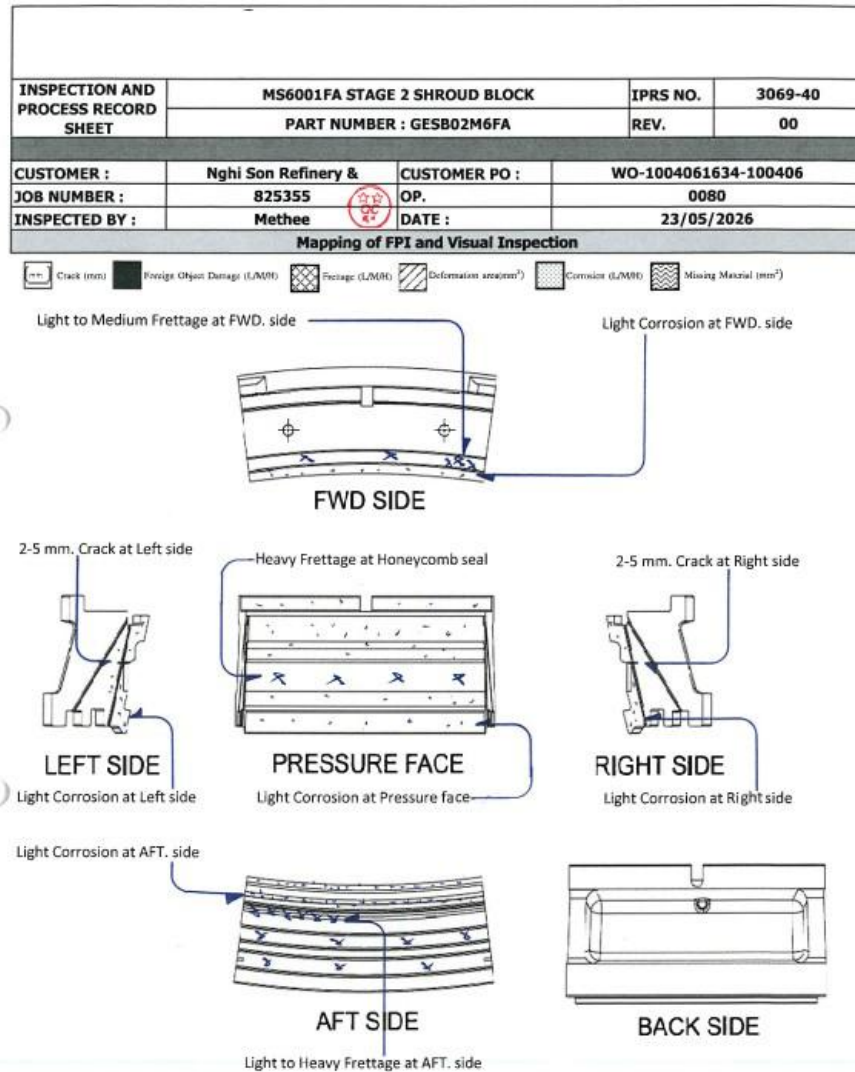
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14	13.34	13.37	14.02	14.02	13.24	11.81	15.27	116.63	26.04	13.26	3.85
15	13.37	13.36	14.01	14.08	13.30	11.76	15.25	116.68	25.96	13.19	3.89
16	13.37	13.27	14.05	14.04	13.21	11.77	15.54	116.73	25.92	13.28	3.83
17	13.37	13.39	13.86	14.01	13.29	11.87	15.26	116.77	25.98	13.24	3.83
18	13.39	13.29	14.00	13.86	13.30	11.88	15.31	116.57	25.95	13.47	3.85
19	13.31	13.37	13.90	13.95	13.30	11.86	15.26	116.69	25.90	13.45	3.86
20	13.40	13.28	14.06	14.06	13.28	11.82	15.59	116.67	25.98	13.48	3.90
21	13.34	13.31	14.01	13.99	13.21	11.66	15.39	116.52	25.91	13.20	3.81
22	13.47	13.33	14.08	13.82	13.25	11.82	15.41	116.55	26.04	13.29	3.82
23	13.35	13.26	13.79	13.75	13.30	11.79	15.32	116.60	26.00	13.22	3.86
24	13.37	13.45	13.77	13.99	13.30	11.71	15.22	116.65	25.97	13.48	3.87

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18. DEFECT MAP

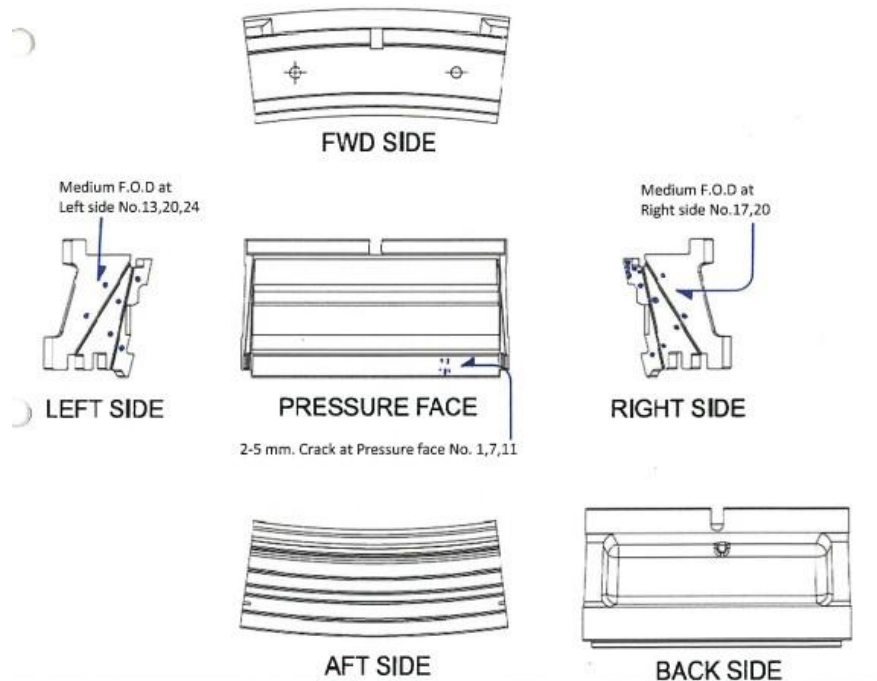
Typical and non-typical defect mapping from the inspection and process record sheet (IPRS No. 3069-40, Rev. 00). Unit: mm.



Defect Map 1 – Typical defect distribution (all components).

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INSPECTION AND PROCESS RECORD SHEET	MS6001FA STAGE 2 SHROUD BLOCK	IPRS NO.	3069-40
	PART NUMBER : GESB02M6FA	REV.	00
CUSTOMER :	Nghi Son Refinery &	CUSTOMER PO :	WO-1004061634-100406
JOB NUMBER :	825355	OP.	0080
INSPECTED BY :	Methee	DATE :	23/05/2026
Mapping of FPI and Visual Inspection			
 Crack (mm)  Foreign Object Damage (L/MSH)  Fouling (L/MSH)  Deformation area(mm²)  Corrosion (L/MSH)  Missing Material (mm²)			



NON TYPICAL DEFECT

Unit: mm

Defect Map 2 – Non-typical defect locations (cracks at pressure face No. 1, 7, 11; FOD at left side No. 13, 20, 24 and right side No. 17, 20).