

Invoice No.: INV-WO-1004061634 / WO-1004061642



UNEW Inc.

3321 SE Gran Park Way, Stuart, FL 34997, United States

FROM	UNEW, Inc. 3321 SE Gran Park Way Stuart, Florida USA 34997 United States	TO	Nghi Son Refinery & Petrochemical, LLC. Nghi Son Economic Zone, Hai Binh Ward Thanh Hoa Province, Vietnam	PAYMENT TERMS	30 days or less after receiving products
				INVOICE DATE	06 July 2026
				CURRENCY	USD
				INVOICE NO.	INV-WO-1004061634 / WO-1004061642
				WORK ORDER REF.	WO-1004061634 / WO-1004061642

INVOICE — GAS TURBINE REPAIR SERVICES AND REPLACEMENT PARTS | WORK ORDERS WO-1004061634 / WO-1004061642

No .	Work Order / Component	Repair Classification	Detailed Invoice Description / Technical Basis	Qty / Unit	Standard / Medium Amount (USD)	Heavy / Additional Amount (USD)	Extended Price (USD)
1	WO-1004061634 / WO-1004061642 MS6001FA 2nd Stage Bucket Set P/N 131E4411 P1H1 Qty 92 pcs GTD111 HEAVY REPAIR, LEVEL 9 Severe Heavy Repair No heavy repair charge per report		HEAVY REPAIR TECHNICAL BASIS - complete 92-bucket rotating stage. Seal fin height REJECT on 92/92 buckets; Z-notch dimension REJECT on 92/92; angel wing height REJECT on 92/92. Z-notch shroud engagement below 50% limit on 23/92 buckets, minimum -20.82% at Item 75, indicating loss of positive interlock contact; 4 buckets at or below 25% engagement. Wall thickness REJECT on 10/92 buckets, thinnest readings 0.62 mm and 0.65 mm at trailing-edge concave region. Five crack indications require excavation and weld repair: Items 7, 28, 29, 33 at angel wing and Item 78 at seal fin. Required restoration includes weld build-up and restoration of seal fin/cutter tooth, Z-notch/shroud, Z-notch engagement contact points, and angel wing areas; machine and EDM restoration of critical seal and interlock geometry; full MCrAlY strip/recoat; three heat-treatment cycles; at least five FPI/NDT control points; CMM/dimensional verification; moment weighing, balance chart and serial/location control for all 92 buckets. Composite severity score 22 of 22 — the maximum of the Level 9 (Severe Heavy Repair) band, held below Level 10 (beyond-economical-repair / replacement) only by metallurgical confirmation that the GTD111 base material remains sound. Per report Sections 12 and 19, UNEW will not apply a heavy repair charge to NSRP for this set: the full Level 9 restoration scope above is performed and absorbed by UNEW, and this line is invoiced at USD 0.00 (NO CHARGE).	1 set	\$147,600.00	\$110,700.00 Discount	\$258,300.00

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2	WO-1004061634 GE 6FA Fuel Nozzle Assemblies P/N 119E9942G033 Qty 6 assemblies S/N 10391431-10391436		Repair/refurbishment of six serial-numbered fuel nozzle assemblies. Incoming condition shows used service-run components with carbon/combustion deposits, oxidation, thermal discoloration, aged tubing/fittings and worn hardware condition. Scope includes controlled disassembly, carbon removal, solvent/ultrasonic cleaning as applicable, dry-out, detailed visual/borescope inspection, FPI/NDT where applicable, dimensional checks, thread and sealing-surface inspection, tubing/fitting condition review, repair/reuse of serviceable bodies/caps/fittings/brackets/tubing supports/sealing surfaces/threads, reassembly, leak check, flow/functional check, final QA and repair documentation. Per Section 6 of the quotation, standard repair labor, cleaning, inspection, reusable-component restoration, minor consumables, leak/flow check and final QA are included in this repair line; reusable nozzle bodies, caps, fittings, brackets, tubing supports, sealing surfaces, threads and serviceable hardware are repaired/included with no separate replacement charge. Expected remaining life after refurbishment: approximately two additional repair/refurbishment cycles, subject to operating condition and final QA acceptance (quotation Section 8).	1 set	\$59,500.00		\$59,500.00
3	WO-1004061634 Fuel Nozzle Replacement Allocation OIL/WATER CARTRIDGE ASSY P/N 241C3228G003		Replacement allocation for the six-nozzle repair package: Oil/Water Cartridge Assembly, P/N 241C3228G003. Reusable related components repaired/included as required with no separate replacement charge unless otherwise confirmed after detailed inspection. Price each: \$8,000.00 Quantity: 5 total: \$8,000.00 x 5 = \$40,000.00	5 EA	\$40,000.00	0	\$40,000.00
4	WO-1004061634 Fuel Nozzle Replacement Allocation KIT, WATER TUBING P/N 728C9024G001		Replacement allocation for the six-nozzle repair package: Water Tubing Kit, P/N 728C9024G001. Remaining reusable items are repaired or included through cleaning, fitting restoration, thread/sealing correction, leak/flow check and final QA. Price each: \$14,400.00 Quantity: 5 Total: \$14,400 x 5 = \$72,000.00	5 KIT	\$72,000.00	0	\$72,000.00
5	WO-1004061634 Fuel Nozzle Replacement Allocation KIT, OIL TUBING P/N 233C2880G001		Replacement allocation for the six-nozzle repair package: Oil Tubing Kit, P/N 233C2880G001. Non-listed minor consumables, shop supplies and reusable-component restoration are included in the repair effort unless final inspection identifies a separate non-standard issue. Price each: \$15,000.00 Quantity: 8 Total: \$15,000.00 x 8 = \$120,000.00	8 KIT	\$120,000.00	0	\$120,000.00

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6	WO-1004061634 / WO-1004061642 MS6001FA 1st Stage Shroud Block Set P/N 109E9147G05 body Qty 24 blocks / 72 inner plates MEDIUM REPAIR, LEVEL 7 Standard / Medium Refurbishment		Level 7 medium repair, large extent but standard repair methods. Full set retained for restoration; no scrap. Repair scope includes blend, weld-and-blend, dimensional restoration, heat treatment and fresh TBC abradable coating on inner plate gas path. Weld build and blend needed on body of 7 blocks and inner plate faces of 16 blocks. Corrosion covers inner plate pressure, side and back faces across all 24 blocks. Cracking of 2-5 mm on inner plate side faces of 16 blocks and block top face of 2 blocks. FOD on block side rails of 6 blocks. Inner plate seating outside fixture gap limit on all 24 assemblies at Z1 and Z2; restored to design by dimensional restoration and rechecked in fixture. Additional replacement per report spare parts schedule (Section 4): inner plate side seals, dog-bone type — long 70 ea, short upper 70 ea, short lower 70 ea, supplied new; inner plate split-line seals, flat type — long 2 ea, short upper 2 ea, short lower 2 ea; internal retaining rings 72 ea, replaced with new; tile retention pins — 72 received, 41 repaired and 31 replaced new. No component scrapped: all 24 shroud block bodies and all 72 inner plates are within UNEW repair limits and retained for restoration.	1 set	\$130,320.00	\$0.00	\$130,320.00
7	WO-1004061634 / WO-1004061642 MS6001FA 2nd Stage Nozzle Set P/N 119E2604 G04 REV A Qty 24 pcs GTD262 MEDIUM REPAIR, LEVEL 6 Standard / Medium Refurbishment		Level 6 medium repair: significant but controlled restoration. Full 24-segment set retained; no scrap. All 24 segments require weld-and-blend restoration across airfoil gas-path surfaces and both leading-edge/trailing-edge core-plug cavities; weld zones are on weld-repairable, non-critical locations, not cooling holes, seal slots, root/attachment, shroud contact faces or thin-wall high-stress areas. Downstream deflection is REJECT on 23/24 segments and restored by controlled cold straightening, weld build-up and machining. GTD262 base metal confirmed sound and recovered by pre-weld solution heat treatment; diffused aluminide coating required. Additional replacements per report spare parts schedule (Section 4): 154 segment-assembly cloth seals (L605), 44 diaphragm cloth seals (L605), 14 segment joint seals (Hast-X), 4 diaphragm joint seals (Hast-X), 24 locking plates (SS316), 24 honeycombs (Haynes 214), 2 thermocouple guides and 1 bush/sleeve replaced on dimensional grounds; 48 diaphragm retaining screw pins, 24 outer cover plates, 48 L/E core plugs, 48 T/E core plugs and 23 bush/sleeves repaired and reused. No scrap reported: all 24 nozzle segments and 24 diaphragm assemblies retained for restoration.	1 set	\$19,944.00	\$0.00	\$19,944.00

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8	WO-1004061634 / WO-1004061642 MS6001FA 3rd Stage Bucket Set P/N 101T5421 G001/G002 (91 pcs G001 + 1 pc G002) Qty 92 pcs GTD111 HEAVY REPAIR, LEVEL 9 Severe Heavy Repair		HEAVY REPAIR TECHNICAL BASIS - complete 92-bucket rotating stage, service cycle 2, 21,605 running hours, one previous repair. Damage is present across multiple critical features: seal fin and cutter teeth fretage on 92/92 buckets with seal fin height REJ across the population; Z-notch fretage on 92/92 with Item 72 showing approx. 2 x 3 mm missing material at the Z-notch; angel wing fretage on 92/92 and FOD on 36/92; location pin slot fretage on 92/92 and FOD on 40/92; leading-edge FOD on 7/92; corrosion/oxidation on 92/92 airfoils. Metallurgical sample confirms GTD111 with oxidation corrosion and substrate alloy depletion on the uncoated hot gas path surface. Required Level 9 scope includes multi-feature weld build-up and restoration of seal fin/cutter tooth, Z-notch/shroud and angel wing areas; EDM and machining to recreate critical seal, interlock and fit-up geometry; controlled material removal, heat treatment and metallurgical acceptance; at least three heat-treatment cycles; at least five FPI/NDT control points; full dimensional/CMM verification; shot peen of fir-tree root; moment weighing, balance chart and blade location labeling for all 92 buckets. Severity determination per report Section 7: welding/material build-up Level 9, dimensional restoration Level 9, inspection/heat-treatment/engineering-risk Level 9 and coating/base-metal condition Level 8 — under the UNEW method the more severe condition governs, classifying the set HEAVY REPAIR, LEVEL 9 (Severe Heavy Repair). Per report Sections 12–14, the set is processed, restored and invoiced as one balanced turbine bucket set under serial-number control of all 92 buckets — not as isolated single-bucket repairs — and is released only after dimensional verification, FPI/NDT results, heat-treatment records and moment/balance verification with final acceptance documentation. The heavy repair charge on this invoice applies to this line, per the Level 9 restoration scope of report Section 12.	1 set	\$100,656.00	\$75,492.00	\$176,148.00
9	WO-1004061642 MS6001FA 3rd Stage Nozzle Set P/N 119E4885 G05/G06/G07 REV A Qty 20 pcs GTD262 MEDIUM REPAIR, LEVEL 6 Standard / Medium Refurbishment		Level 6 medium repair: full-set controlled refurbishment within standard/medium repair envelope. 20/20 nozzle segments require blend repair for airfoil/gas-path corrosion and weld-and-blend routing for crack/shroud/local repair areas; 20/20 diaphragm bodies require weld-and-blend repair; nozzle cavity condition acceptable on 20/20. Full replacement required for 20/20 honeycombs, 90/90 segment assembly cloth seals, 36/36 diaphragm cloth seals, 10/10 segment joint seals, 4/4 diaphragm joint seals and 20/20 locking plates. Material evaluation confirms GTD262 sound and repairable after surface cleaning; pre-weld heat-treated material recorded at 36.2 HRC. Repair includes repeated FPI/NDT, heat treatment, EDM/local recovery of cooling holes and seal slots as required, diffused aluminide coating, final dimensional inspection, assembly build and seal alignment verification. UNEW Job No. 825353; Report No. UNEW-NSRP-825353-NZ3-IIR-Rev01.	1 set	\$123,552.00	\$0.00	\$123,552.00

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10	WO-1004061634 / WO-1004061642 MS6001FA 2nd Stage Shroud Block Set P/N 146E3480G001/G002/G003 Qty 24 pcs Haynes HR-120 MEDIUM REPAIR, LEVEL 6 Standard / Medium Refurbishment		Level 6 medium repair: significant but controlled restoration for complete 24-piece shroud block set. 24/24 honeycomb seals require replacement and 24/24 honeycomb seal ID positions are REJ, driving full seal-path recovery. Pressure face corrosion recorded across the set; 2-5 mm cracks at pressure face on shroud blocks No. 1, 7 and 11. Left/right side cracking routed as weld-and-blend across 24/24 shroud blocks; medium FOD at left side No. 13, 20, 24 and right side No. 17, 20. Forward side has light corrosion/light-to-medium frettage; aft side has corrosion and light-to-heavy frettage, with local weld-and-blend at No. 24. Dimensional A-K baseline captured for 24/24 pieces (264 measurements); final verification required after weld/blend, honeycomb replacement, braze heat treatment, 3-piece fixture check and final visual inspection. No coating system restoration or structural base-metal build-up is required. UNEW Job No. 825355; Report No. SB2-IIR-Rev01.	1 set	\$53,400.00	\$0.00	\$53,400.00
11	WO-1004061634 / WO-1004061642 1st Stage bucket		There are 17 broken blades in this 1 st stage bucket set. UNEW Engineering will scan selected repairable blades to obtain dimensional data and material composition. This information will be used to develop engineering drawings, blueprint data, and material property specifications for manufacturing new interchangeable replacement parts to replace the missing or damaged blades.	1 set	0	0	0
UNEW's price is net price, exclusive of VAT and any bank charges, and all other taxes/fees unless otherwise stated in the final commercial invoice. Line 1 (MS6001FA 2nd Stage Bucket Set, HEAVY REPAIR LEVEL 9) is invoiced at USD 0.00: per the incoming inspection report, UNEW does not apply a heavy repair charge for that set. The heavy repair charge on this invoice applies only to Line 8 (MS6001FA 3rd Stage Bucket Set, HEAVY REPAIR LEVEL 9).				TOTAL (USD)		\$1,053,164.00 Discount:\$ 110,700.00 Total: \$942.464.00	
THANK YOU FOR YOUR BUSINESS!							

REPAIR WORK HOURS

STANDARD / MEDIUM REPAIR VERSUS HEAVY REPAIR

MS6001FA (GE Frame 6FA) 2nd Stage and 3rd Stage Bucket Sets
Work Order WO-1004061642 and Work Order WO-1004061634

Customer	Nghi Son Refinery & Petrochemical LLC	Document date	17 August 2026
Contract	LTSA No. 128/2024.NSRP.Maint-UNEW	Engine type	MS6001FA (GE Frame 6FA)
2nd Stage Bucket	WO-1004061642, 92 pieces, P/N 131E4411 P1H1	3rd Stage Bucket	WO-1004061634, 92 pieces, P/N 101T5421 G001 / G002
Material, both sets	GTD 111	Classification, both sets	HEAVY REPAIR, Level 9 of 10

Hours shown are the shop working hours required for the complete set of 92 pieces at each repair level.

1. 2nd Stage Bucket, WO-1004061642

Major task	Standard / Medium repair (hours)	Heavy repair (hours)	Difference
1. Cleaning, coating removal and surface preparation	129	322	2.5 times (+150%)
2. Welding and material build up	184	1,330	7.2 times (+623%)
3. Geometry restoration by machining and EDM	129	929	7.2 times (+620%)
4. Heat treatment	0	240	Not performed at Medium
5. Coating removal and rebuild	156	460	2.9 times (+195%)
6. Moment weighing, balancing and set control	92	316	3.4 times (+243%)
TOTAL FOR THE SET, 92 PIECES	690	3,597	5.2 times (+421%)

2. 3rd Stage Bucket, WO-1004061634

Major task	Standard / Medium repair (hours)	Heavy repair (hours)	Difference
1. Cleaning, surface preparation and defect mapping	129	193	1.5 times (+50%)
2. Airfoil corrosion removal and metallurgical acceptance	74	288	3.9 times (+289%)
3. Welding and material build up	184	695	3.8 times (+278%)
4. Geometry restoration by machining and EDM	129	563	4.4 times (+336%)
5. Heat treatment	0	180	Not performed at Medium
6. Moment weighing, balancing and set control	92	316	3.4 times (+243%)
TOTAL FOR THE SET, 92 PIECES	608	2,235	3.7 times (+268%)

3. Result

Component set	Standard / Medium repair (hours)	Heavy repair (hours)	Difference
2nd Stage Bucket, WO-1004061642	690	3,597	5.2 times (+421%)
3rd Stage Bucket, WO-1004061634	608	2,235	3.7 times (+268%)
BOTH SETS, 184 PIECES	1,298	5,832	4.5 times (+349%)

Heavy repair on these two bucket sets takes **4.5 times** the working hours of a Standard or Medium repair on the same parts. That is **349% more work**.

The difference is concentrated in welding, geometry restoration by machining and EDM, and heat treatment. Heat treatment is not performed at Standard or Medium level at all.

The 2nd Stage Bucket set under WO-1004061642 is invoiced to NSRP at the Standard and Medium rate. The heavy repair hours on that set are not charged.



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