



**Fast, Easy & Affordable
Ready-To-Install Repair Products for GE Gas Turbine First Stage Nozzles**

Comprehensive and high-quality inventory of gas turbine repair products
 In-stock repair coupons, repair plates and "H" guide blocks are ready to ship
 Products are cast with FR-FSX414 Alloy
 All products are shipped in the "as-cast" condition
 Material certifications can be provided
 Custom cooling hole configurations are available
 Credit cards accepted

Frame 3/5: Trailing Edge Coupons

Used to repair the trailing edge on GE Frame 3 and Frame 5 first stage nozzles.

PART#	T.E. COOLING	CONCAVE COOLING	SIZE
50101	No holes	Tapered	3.5" x 1"
50102	No holes	Tapered	8.5" x 1"
50103	No holes	9 holes (.100" dia) Wishbone	3.17" x 3.87"
50104	No holes	19 holes (.073" dia) High Tech	3.17" x 3.87"
50108	No holes	11 holes (.088" dia) High Tech	3.5" x 2.3"

Frame 6B: Trailing Edge Coupons

Dimensions: 4.7" wide x 3.4" long. Custom sizes can be produced. 36 coupons included per set.

PART #	T.E. COOLING	CONCAVE COOLING	USED ON
36101	27 slots (.045/.099")	19 holes (.080" dia.)	Old 932E105
36102	44 holes (.050" dia.)	19 holes (.080" dia.)	New 948E0729
36103	44 holes (.050" dia.)	26 slots (.050/.080")	Uprate 104D8935
36104	44 holes (.053" dia.)	19 holes (.087" dia.) Tapered Entry	Advanced 112E1569
7247	Core Plugs – 6B (cast)	Equal to & interchangeable with 247B7247P1 plug-trailing edge	

Frame 6B: Trailing Edge Coupons "Extended"

Dimensions: 4.65" wide x 4.65" long. Used to repair damage further down the vane.

PART #	T.E. COOLING	CONCAVE COOLING	USED ON
36101X	27 slots (.045/.099")	19 holes (.080" dia.)	Old 932E105
36102X	44 holes (.050" dia.)	19 holes (.080" dia.)	New 948E0729
36103X	44 holes (.050" dia.)	26 slots (.050/.080")	Uprate 04D8935
36104X	44 holes (.053" dia.)	19 holes (.087" dia.) Tapered Entry	Advanced 12E1569

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Frame 6B: Trailing Edge Coupons "XM"

Dimensions: 4.5" wide x 4.2" long

PART #	T.E. COOLING	CONCAVE COOLING	USED ON
36102XM	44 holes (.050" dia.)	19 holes (.080" dia)	
36103XM	44 holes (.050" dia.)	52 hole (.050" dia)	
36104XM	44 holes (.053" dia.)	19X holes (.087" dia) Tapered Entry	

Frame 6B: Trailing Edge Coupons "Mini"

Dimensions: 1.75" deep in from the trailing edge and 4.7" wide. Used for repairs when vane damage has not extended to the pressure side cooling holes.

PART #	T.E. COOLING	USED ON
18101	27 slots (.045/.099")	Old 932E105
18102	44 holes (.050" dia.)	New 948E0729 or 104E8935
18103	44 holes (.053" dia.)	Uprate 112E1569

Frame 7B: Trailing Edge Coupons

Dimensions: 6.25" wide x 3.5" long. 48 coupons included per set.

PART #	T.E. COOLING	CONCAVE COOLING
7001-B	48 holes (.060" dia.)	48 holes (.060" dia.)
7001-B50	50 holes (.060" dia.)	50 holes (.060" dia.)

Frame 7E: Trailing Edge Coupons

Dimensions: 6.7" wide x 3.92" long concave side 6.03". 36 coupons included per set.

PART #	T.E. COOLING	CONCAVE COOLING	USED ON
49201	57 holes (.050" dia.)	56 holes (.051" dia.)	Old 855E460
49202	45 holes (.053" dia.)	26 holes (.081" dia.)	New 932E0178
49203	45 holes (.060" dia.)	28 slots (.048/.119" dia.)	Uprate 105E8652
49204	45 holes (.070" dia.)	19 slots (.125/.125") Tapered	Heavy Fuel 115E6380
49205	45 holes (.060" dia.)	19 holes (.100" dia.)	G3/G26 114E1068
49207	45 holes (.050" dia.)	26 holes (.081" dia.)	
49208	36 slots (.052" x .115")	20 holes (.100" dia.)	Heavy Fuel
49209	36 slots (.052" x .115")	20 holes (.160" dia.)	887E0989
49210	45 holes (.060" dia.)	19 slots (.100" dia.) Tapered	
49211	45 holes (.057" dia.)	26 holes (.043" dia.)	

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Frame 7E: Trailing Edge Coupons "Extended"

Dimensions: 6.75" x 6.03" concave side x 3.92"

PART #	T.E. COOLING	CONCAVE COOLING	USED ON
49201X	57 holes (.050" dia.)	56 holes (.051" dia.)	Old 855E460
49202X	45 holes (.053" dia.)	26 holes (.081" dia.)	New 932E0178
49203X	45 holes (.060" dia.)	28 slots (.048/.119")	Uprate 105E8652
49204X	45 holes (.073" dia.)	19 slots (.125/.125") Tapered	Heavy Fuel 115E6380
49205X	45 holes (.060" dia.)	19 holes (.100" dia.)	G3/G26 Mod 114E1068
49207X	45 holes (.050" dia.)	26 holes (.081" dia.)	
49208X	36 slots (.052" x .115")	20 holes (.100" dia.)	Heavy fuel
49209X	36 slots (.052" x .115")	20 holes (.160" dia.)	Used on 887E0989
49210X	45 holes (.060" dia.)	19 slots (.100") Tapered	
49212X	45 holes (.187" dia)	19 slots (0.78") Tapered	

Frame 7E: Leading Edge Coupons

Used to replace the cooling hole section on the leading edge of Frame 7E first stage nozzles.

PART #	SIZE	COOLING HOLES
49000LE	6.527" wide x 1.1" tall	96 holes (.058" in 2 rows)

Frame 7F/7FA/7FA+e: Trailing Edge Coupons

Dimensions: 5.95" x 3.0" concave side x 3.3"

PART #	PRESSURE SIDE	NON-PRESSURE SIDE	USED ON
49206	Row 1: 26 holes (.061" dia.) Row 2: 25 holes (.061" dia.) 19 through slots (.065" x .195")	16 funnel-shaped holes (.067" dia.)	116E2265 and similar

Frame 9E: Trailing Edge Coupons

Dimensions: 8" wide x 5.5" long. 36 coupons included per set.

PART #	T.E. COOLING	CONCAVE COOLING	USED ON
81301	45 holes (.069" dia.)	26 slots (.066/.182")	103E5589/932E1648P2
81302	56 holes (.060" dia.)	56 holes (.060" dia.)	Old Frame 9E Heavy
81303	45 holes (.069" dia.)	19 tapered slots	Fuel
81304	45 holes (.069" dia.)	26 holes (.066" dia.)	

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First Stage Nozzle Repair Plates

Used to weld repair heavy sections of vane segments.

PART #	SIZE
93535	3.5" x 3.5" x .125"
94040	4" x 4" x .5"
93507	3.5" x .75" x .25"

"H" Guide Blocks

PART #	DESCRIPTION
B6639-1	Equivalent to 259B66398001

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