



- 1st stage bucket
- 2nd stage bucket
- 3rd stage bucket

Buckets Equivalent to GE MS6001FA+e

Sulzer provides design and manufacturing of new gas turbine components in both hot and cold sections. We focus on lifetime extension and performance improvement of your equipment. We have unique insight into designing a high quality product that is compatible and interchangeable with the original equipment. All bucket kits include installation hardware suitable for installation in PG6101FA (6FA/6FA.01) and PG6111FA (6FA.03/FA+e) gas turbines.

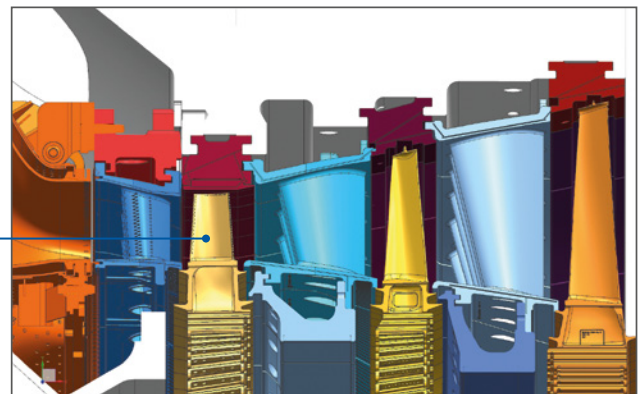
1st stage bucket

Manufactured through an investment casting process using an advanced directionally solidified nickel-based super alloy EEQ-110 which is equivalent to the original DS GTD 111™. The first stage bucket features a Sulzer aero airfoil design with optimized aerodynamic performance and an internal serpen-

tine cooling scheme and leading edge and concave side tip cooling holes to maximize airfoil cooling. Sulzer applies a MCrAlY and Thermal Barrier Coating (TBC) to the airfoil. This coating system has superior oxidation and corrosion resistance for base load as well as peak load applications. The application of a

Thermal Barrier Coating on the airfoil surface produces a life extension, resulting in improved durability. Internally the bucket has an aluminum diffusion coating to improve resistance against intergranular attack.

Bucket stage 1	
Firing temp.	Up to 1,327°C (2,420°F)
Design	Sulzer aero design
Cooling	Serpentine core and leading edge and tip film cooling holes
Material	EEQ-110
Coating	Internal aluminum coating External MCrAlY and TBC
Sealing	Aluminum seal strip on fir tree
Auxiliaries	Locking hardware included
Interchangeability	PG6101FA (6FA/6FA.01) and PG6111FA (6FA+e/6FA.03)



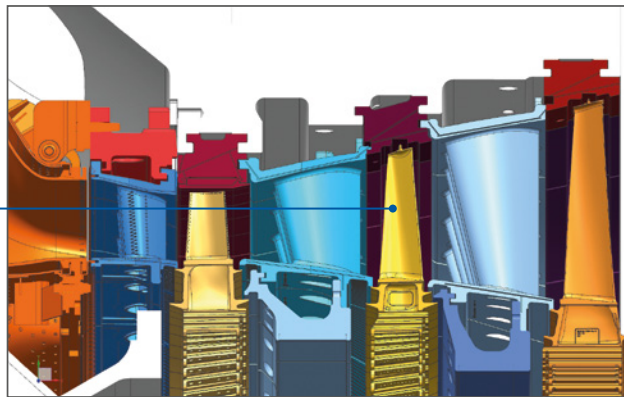
2nd stage bucket

The second stage bucket is manufactured through investment casting. The base material is equiaxed EEQ-111. The second stage bucket features 10 turbulated cooling holes to enhance heat transfer in the high temperature areas. Externally, a MCrAlY and Thermal Barrier Coating is applied to provide

good corrosion and oxidation resistance and reduce metal temperatures. The radial cooling holes are internally coated with an aluminum diffusion coating to improve resistance against intergranular attack. The bucket has central cutter teeth to optimize blade balance. The cutter teeth are used in conjunction

with the honeycomb of the second stage shroud block. This limits material transfer between knife edges and honeycomb in the shroud blocks during operation.

Bucket stage 2	
Firing temp.	Up to 1,327°C (2,420°F)
Design	With cutter teeth
Cooling	Turbulated radial cooling holes
Material	EEQ-111
Coating	Internal aluminum coating External MCrAlY and TBC
Sealing	Aluminum seal strip on fir tree
Auxiliaries	Locking hardware included
Interchangeability	PG6101FA (6FA/6FA.01) and PG6111FA (6FA+e/6FA.03)

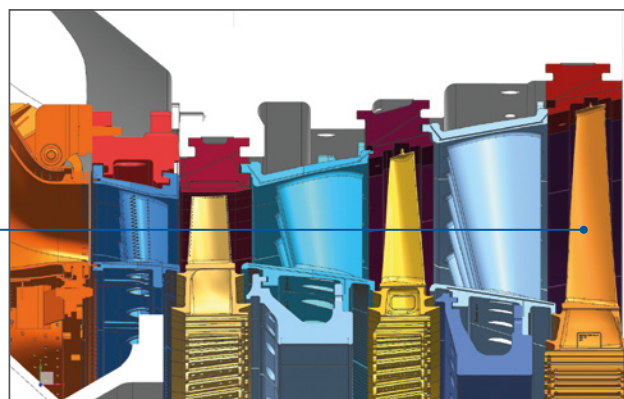


3rd stage bucket

The third stage bucket is manufactured through investment casting. The base material is the EEQ-110. Similar to the second stage bucket, the knife edges of the third stage bucket will

be supplied with cutter teeth to prevent material transfer between knife edges and honeycomb in the shroud block during operation.

Bucket stage 3	
Firing temp.	Up to 1,327°C (2,420°F)
Design	With cutter teeth
Material	EEQ-110
Coating	Chrome optional
Auxiliaries	Locking hardware included
Interchangeability	PG6101FA (6FA/6FA.01) and PG6111FA (6FA+e/6FA.03)



About Sulzer

Sulzer provides cutting-edge services and solutions for rotating equipment dedicated to improving customers' processes and business performances. When pumps, turbines, compressors, generators, and motors are essential to operations, customers need a service partner they can trust. With our technically advanced and innovative solutions, we give our customers the assurance they need to focus on their operations. Customized solutions help to reduce maintenance time and cost. Our partners' business demands are ever increasing and changing but they can rely on our experts to provide the optimal solution to improve operational efficiency and reliability. We provide high-quality services at competitive prices and delivery times.



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