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(54) Title: METHOD FOR REPAIRING A SINGLE CRYSTAL TURBINE BLADE

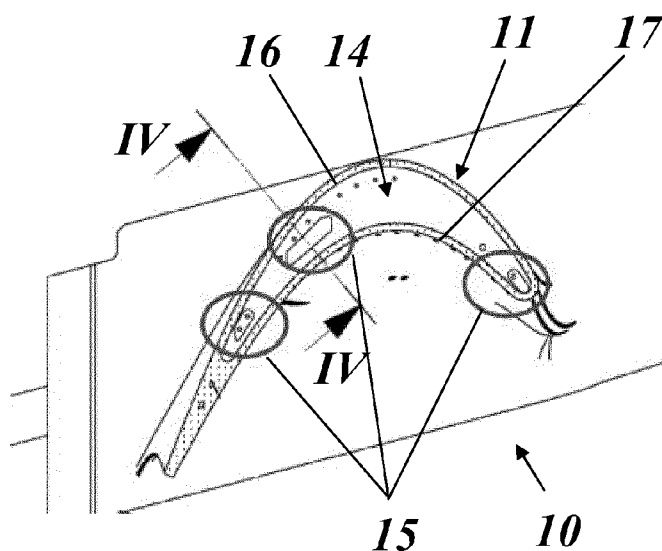


Fig. 3

(57) Abstract: Method for repairing a single crystal turbine blade (10), which comprises an airfoil (11) with a tip (14) having a tip cover plate, tip cooling air holes (17) and a tip crown (16), said method comprising the steps of: a) removing the tip crown (16) by manual grinding, thereby preserving the underlying tip cover plate; b) preparing the tip cooling air holes (17) by manual grinding; c) closing said prepared tip cooling air holes (17) by manual welding; and d) building-up a new tip crown by a LMF (Laser Metal Forming) process.



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10 METHOD FOR REPAIRING A SINGLE CRYSTAL TURBINE BLADE

BACKGROUND OF THE INVENTION

15 The present invention relates to the technology of gas turbines. It refers to a method for repairing a single crystal turbine blade according to the preamble of claim 1.

20 PRIOR ART

Fig. 1 shows a photograph of a typical gas turbine blade 10 in a perspective view. The turbine blade 10 comprises an airfoil 11, which extends in radial direction from a shaft and ends with a blade tip 14. Below the shaft 12 a foot 13 of the fir-tree type is provided for mounting the blade in a respective groove of the rotor. Part of the blade tip 14 is a crown (16 in Fig. 4), a circumferential rim. Fig. 2 is a side view of the blade 10. Fig. 3 is a top view. Further features of the blade tip 14 are tip cooling air holes 17 and so-called letterboxes 15, slots in the tip cover plate (25 in Fig. 4), which are closed by brazed closing plates (26 in Fig. 4).

30

The tip of a moving turbine blade is often prone to damages, which have to be repaired in order to restore the efficiency of the turbine. A special problem is connected with such a repair when the blade is of the single crystal type.

- 5 Document US 2011/052386 A discloses a method for depositing material on a turbine airfoil having a tip wall extending past a tip cap, wherein the tip wall includes a first alloy with a single crystal microstructure. The method includes: depositing a second alloy on at least a portion of the tip wall to form a repair structure, wherein a high temperature oxidation resistance of the second alloy is
- 10 greater than a high temperature oxidation resistance of the first alloy, and wherein the repair structure has a crystallographic orientation that is substantially the same as a crystallographic orientation of the tip wall.

- Document EP 1 674 658 A1 furnishes a damaged gas turbine blade which has
- 15 previously been in service, and which is made of a base metal. Any damaged material is removed from the damaged blade tip. The damaged blade tip is weld repaired with a nickel-base superalloy that is more resistant to oxidation resistance than is the base metal in the operating environment of the tip-repaired gas turbine blade. The method does not include any step of coating a lateral surface of the
- 20 repaired blade tip with a non-ceramic coating after the step of weld repairing.

- Document US 2010/050435 A1 discloses a gas turbine blade, a gas turbine blade airfoil repair method, and an airfoil corresponding to the product of the method. The airfoil extends radially from a platform and includes a tip having a tip edge
- 25 radially distant from the platform; a trailing edge; and a leading edge. The method includes forming a joining plane extending from the leading edge to the tip edge, wherein the joining plane forms at least one arc; forming a replacement tip fittable on the joining plane; and bonding the replacement tip to the airfoil.

- 30 In document EP 1 701 004 A1 a repaired gas turbine blade has a monocrystalline airfoil made of a first nickel-base superalloy, and a repair squealer tip welded to a tip of the airfoil. The repair squealer tip is made of a second nickel-base superalloy

different from the first nickel-base superalloy and having less than about 0.15 weight percent total of carbon, boron, silicon, zirconium, and hafnium.

Document US 6,332,272 B1 discloses a method for repairing a turbine blade wherein the tip of the blade is removed and a replacement cap is attached by welding. The cap may consist of a plate attached by welding and a squealer formed by depositing weld material. The plate and/or squealer may be formed from a material different from the material of the airfoil portion of the blade in order to optimize the performance of the blade.

The various known repairing methods for blade tips have different disadvantages.

For some methods there is not enough remaining wall thickness and attachment points for crown plate replacement, resulting in a high risk of failure (high temperature, high load on tip of the first blades). A full letterbox removal for crown plate replacement would cause either a dimensional change of the repaired blade or cause complicated repair effort to keep original dimensions.

A restoration of blade crown height by LMF (Laser Metal Forming) and subsequent crack brazing of letterboxes is not applicable in other cases for following reasons: The method works only for lightly damaged parts, combined welding and brazing would massively exceed any reconditioning cost restrictions.

An EDM removal of damaged tip letterbox and replacement with new brazed-in letterbox is not applicable in other cases for following reasons: A letterbox replacement has high risk of NCR and is an instable process, there is no solution for crown replacement, and the high costs exceed reconditioning cost restrictions for such a component.

The method for replacing blade tips of directionally solidified and single crystal turbine blades according to document US 5,822,852 with a replacement of the squealer tip by brazing or welding is not applicable in other cases for following reasons: There is no solution for damaged ex-service letterbox repair, there is

problematic handling of tip cooling air holes with squealer tip replacement, and damages below squealer tip level cannot be repaired.

5 SUMMARY OF THE INVENTION

It is an object of the present invention to provide a method for repairing a single crystal turbine blade, which avoids the disadvantages of known methods and preserves the structural integrity of original cast material by preserving as much of
10 it as possible during the repair process and reduces the repairing efforts..

This object is obtained by a method according to claim 1.

According to the invention, the method for repairing a single crystal turbine blade,
15 which comprises an airfoil with a tip having a tip cover plate, tip cooling air holes and a tip crown, comprises the steps of:

- a) removing the tip crown by manual grinding, thereby preserving the underlying tip cover plate;
- b) preparing the tip cooling air holes by manual grinding;
- 20 c) closing said prepared tip cooling air holes by manual welding; and
- d) building-up a new tip crown by a LMF (Laser Metal Forming) process.

According to an embodiment of the invention the tip comprises at least one letterbox, and that said at least one letterbox is prepared in step (b) by manual
25 grinding and closed in step (c) by manual welding. The letterbox comprises a slot in the tip cover plate of the blade and a closing plate by which the slot can be closed by brazing the closing plate. Typically at least one side wall of the blade has a slit arranged in the region of the cover plate which allows insertion of the closing plate. The cover plate can extend to the surface of the blade wall thereby
30 closing the slit when it is inserted into the letterbox.

According to another embodiment of the invention the tip comprises at least one damaged region, which extends beyond the crown into the airfoil and that said at least one damaged region is prepared in step (b) by manual grinding and closed in step (c) by manual welding.

5

According to another embodiment of the invention a TIG (Tungsten Inert Gas) welding process is used for the manual welding in step (c).

- 10 According to a further embodiment of the invention the tip is contour-grinded in preparation for the LMF welding process between steps (c) and (d).

According to just another embodiment of the invention the LMF process uses an oscillating weld path for optimum weld quality and heat transport during the LMF process.

15

According to still another embodiment of the invention after finishing the LMF process step (d) the tip area of the turbine blade is finally contoured by manual grinding.

20

Specifically, the final height of the tip is established by CNC machining.

According to a further embodiment of the invention after finishing the outer contour of the turbine blade the blade is coated with a coating layer.

25

Specifically, after coating the blade the closed tip cooling air holes are re-drilled, especially by means of a laser.

- 30 According to a further embodiment of the invention the turbine blade is provided with other cooling air holes outside of the tip, and that these other cooling air holes are re-opened after having been overcoated.

BRIEF DESCRIPTION OF THE DRAWINGS

The present invention is now to be explained more closely by means of different
5 embodiments and with reference to the attached drawings.

Fig. 1 shows a photograph of a typical gas turbine blade in a perspective
view;

10 Fig. 2 shows the turbine blade of Fig. 1 in a side view;

Fig. 3 shows the turbine blade of Fig. 1 in a top view;

15 Fig. 4 shows a sectional view of the blade tip along the line IV-IV in Fig.
3;

Fig. 5 shows a sectional view of the blade tip through a tip cooling air
hole to be prepared by manual grinding;

20 Fig. 6 shows the view of Fig. 5 with the prepared tip cooling air hole
closed by manual welding;

Fig. 7 shows a sectional view of the blade tip similar to Fig. 4 with the
letterbox being prepared by manual grinding;

25 Fig. 8 shows the view of Fig. 7 with the prepared letterbox closed by
manual welding;

Fig. 9 shows the process of LMF for building-up a new crown;

30 Fig. 10 shows a photograph with a top view of a blade tip similar to Fig. 3,
with a new crown built-up by LMF; and

Fig. 11 shows the blade tip of Fig. 10 after fine grit blasting and before coating.

5

DETAILED DESCRIPTION OF DIFFERENT EMBODIMENTS OF THE INVENTION

A main characteristic of the method according to the invention is to preserve as much original cast base material as possible during blade tip repair to ensure structural integrity.

The blade crown is removed by manual grinding thereby preserving the whole crown plate and ex-service letterboxes.

15

The letterboxes and tip cooling air holes are sealed by manual TIG welding.

The blade crown is built-up by laser metal forming (LMF).

20 The various process steps are shown in the Figures:

As shown in Fig. 4, the tip crown 16 is removed from the blade tip 14 to a height h by manual grinding. The tip cover plate 25 is thereby preserved.

25 Then, according to Fig. 5 and 7, the tip cooling air holes 17 and letterboxes 15 are prepared by manual grinding. For the preparation of the tip cooling air holes 17, a grinding tool 20 is used (Fig. 5). The preparation of the letterboxes 15 results in grinded recesses 18a and 18b (Fig. 7)

30 Manual TIG welding is then used to close the letterboxes 25 with fillings 19a-c (Fig. 8), and the tip cooling air holes with fillings 21 (Fig. 6).

After the letterboxes and tip cooling air holes have been closed, contour grinding is applied to the tip as preparation for the subsequent LMF weld process.

Then, a new tip crown (16' in Fig. 10) is built-up by LMF with a LMF device 22 (Fig. 9) by using a laser beam 23 and supplying a powder material 24. A special oscillating welding path at the trailing edge is used for optimum weld quality and heat transport during LMF process. It is advantageous to use same filler material as with TIG welding (wire used for TIG welding), for example Haynes[®] 230 alloy. A respective LMF process is for example disclosed in: M.B. Henderson et al., Nickel-Based Superalloy Welding Practises for Industrial Gas Turbine Applications.

A final contouring step of the tip area by manual grinding and a CNC tip height machining leads to a repaired blade tip as shown in Fig. 11.

Following steps to be made are: coating of blade, re-drilling of closed tip cooling air holes by laser, re-opening of over-coated cooling air holes, finishing.

The advantages of the disclosed method are:

- Profit from structural integrity of original cast material by preserving as much of it as possible during the repair process.
- Profit from the combination of manual TIG welding and automated LMF welding: manual TIG is flexible and cheap (locational variance of tip cooling air holes and letterboxes), LMF is fast and accurate (stable and uniform process preparation by TIG welding, only slight final machining and contouring of repaired tip necessary),

LIST OF REFERENCE NUMERALS

	10	turbine blade (single crystal type)
5	11	airfoil
	12	shaft
	13	foot
	14	tip
	15	letterbox
10	16,16'	tip crown
	17	tip cooling air hole
	18a,b	grinded recess (manual grinding)
	19a-c,21	filling (manually TIG welded)
	20	grinding tool
15	22	LMF device
	23	laser beam
	24	powder material
	25	tip cover plate
	26	closing plate
20		

CLAIMS

1. Method for repairing a single crystal turbine blade (10), which comprises an airfoil (11) with a tip (14) having a tip cover plate (25), tip cooling air holes (17) and a tip crown (16), said method comprising the steps of:

- a) removing the tip crown (16) by manual grinding, thereby preserving the underlying tip cover plate (25);
- b) preparing the tip cooling air holes (17) by manual grinding;
- c) closing said prepared tip cooling air holes (17) by manual welding; and
- d) building-up a new tip crown (16') by a LMF (Laser Metal Forming) process.

2. Method according to claim 1, characterized in that the tip (14) comprises at least one letterbox (15), and that said at least one letterbox (15) is prepared in step (b) by manual grinding and closed in step (c) by manual welding.

3. Method according to claim 1 or 2, characterized in that the tip (14) comprises at least one damaged region which extends beyond the crown (16) into the airfoil (11), and that said at least one damaged region is prepared in step (b) by manual grinding and closed in step (c) by manual welding.

4. Method according to one of the claims 1-3, characterized in that a TIG (Tungsten Inert Gas) welding process is used for the manual welding in step (c).

5. Method according to one of the claims 1-4, characterized in that between step (c) and (d) the tip (14) is contour-grinded in preparation for the LMF welding process.

6. Method according to one of the claims 1-5, characterized in that the LMF process uses an oscillating weld path for optimum weld quality and heat transport during the LMF process.

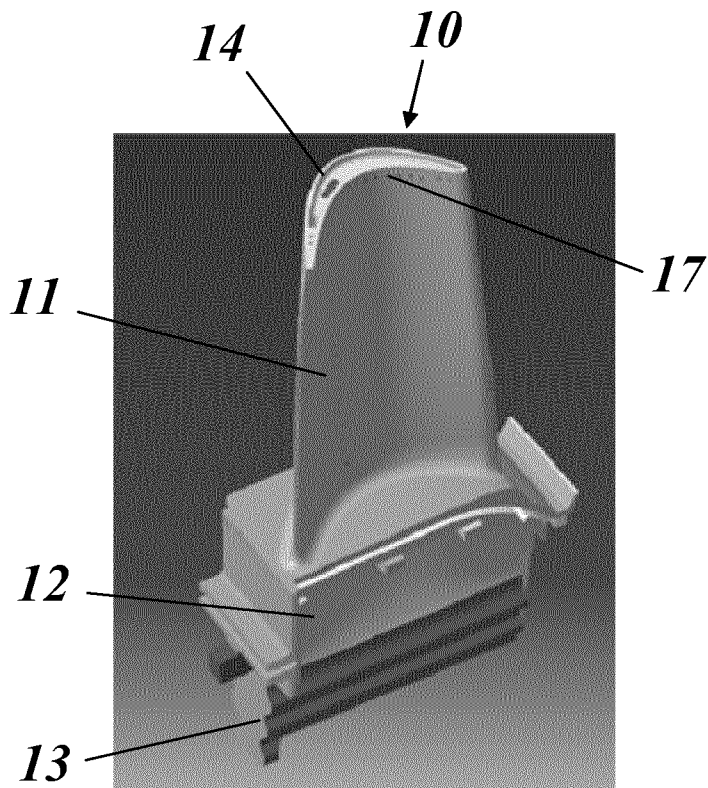
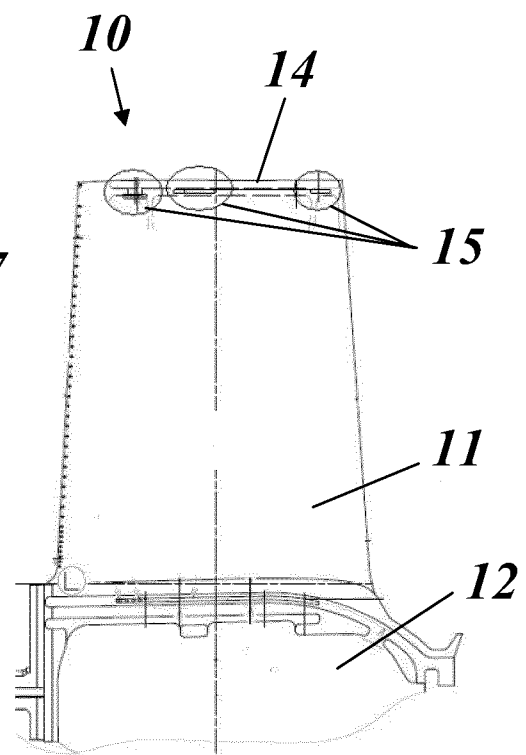
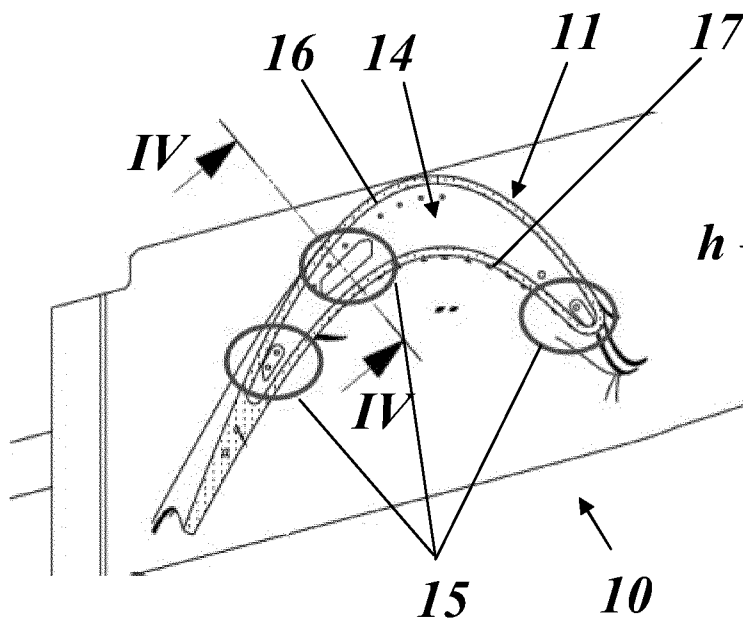
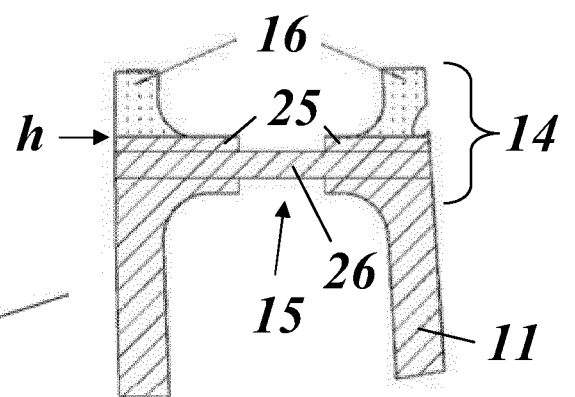
7. Method according to one of the claims 1-6, characterized in that after finishing the LMF process step (d) the tip area of the turbine blade (10) is finally contoured by manual grinding.

5 8. Method according to claim 7, characterized in that the final height of the tip (14) is established by CNC machining.

10 9. Method according to one of the claims 1-8, characterized in that after finishing the outer contour of the turbine blade (10) the blade is coated with a coating layer.

15 10. Method according to claim 9, characterized in that after coating the blade (10) the closed tip cooling air holes (17) are re-drilled, especially by means of a laser.

20 11. Method according to claim 9 or 10, characterized in that the turbine blade (10) is provided with other cooling air holes outside of the tip (14), and that these other cooling air holes are re-opened after having been overcoated.

*Fig. 1**Fig. 2**Fig. 3**Fig. 4*

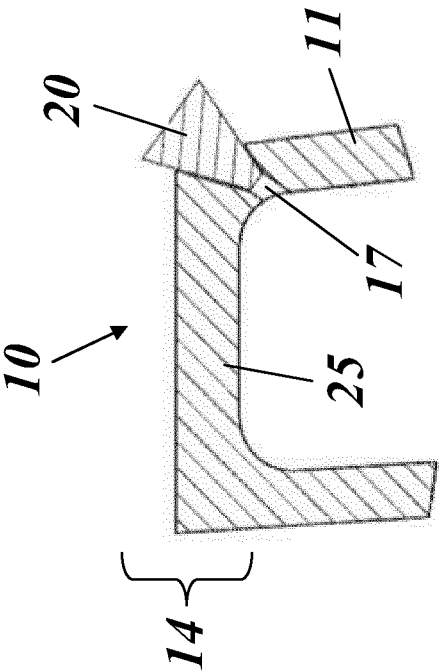


Fig. 5

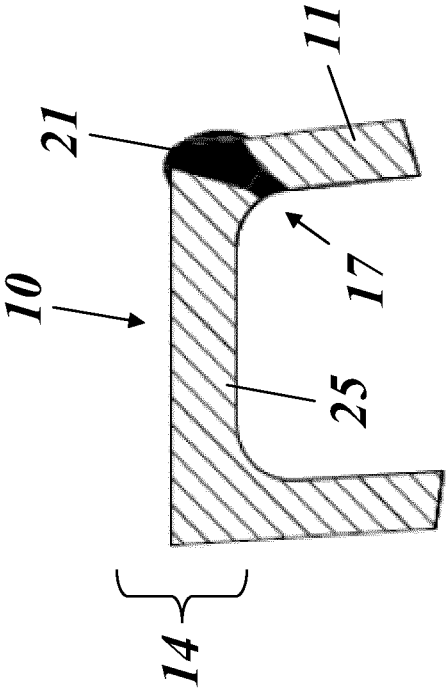


Fig. 6

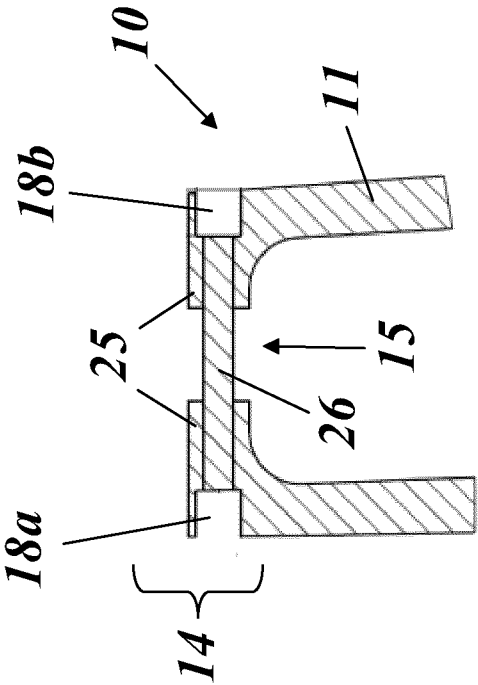


Fig. 7

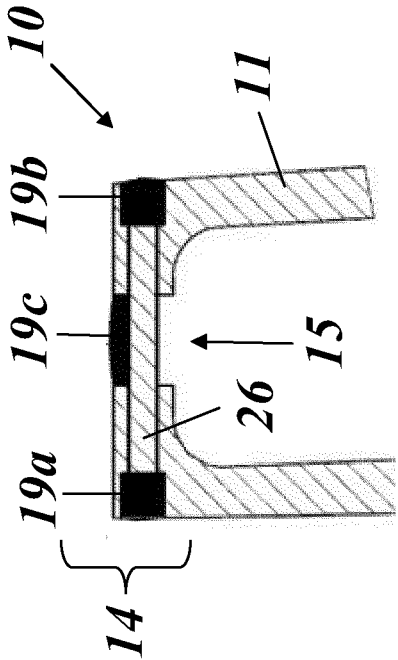
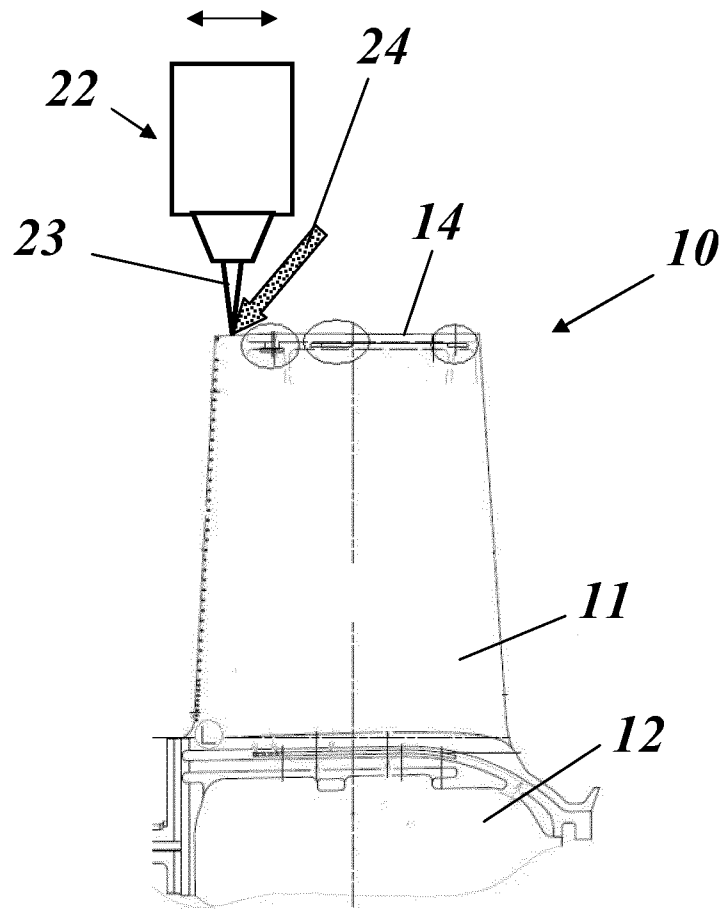


Fig. 8

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***Fig.9***

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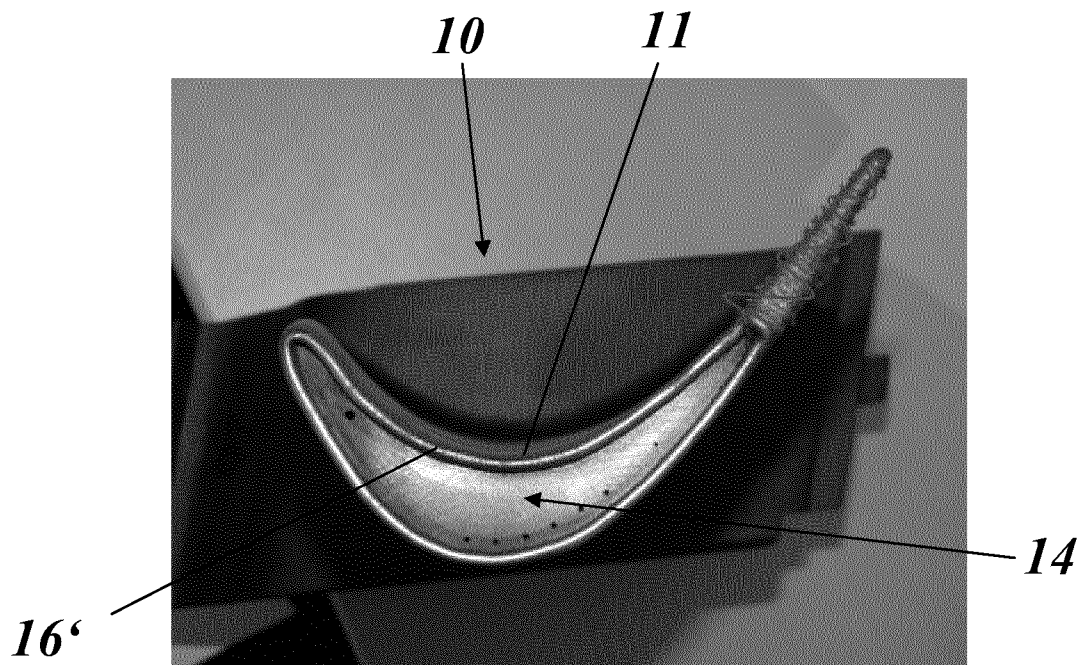


Fig.10

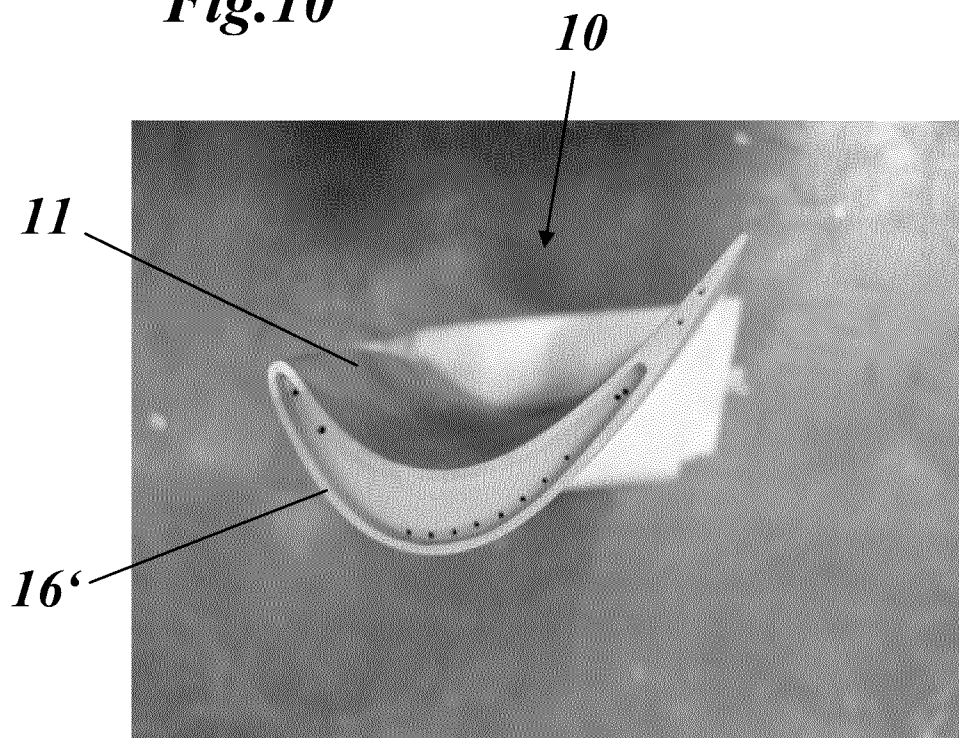


Fig.11

INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2013/064706

A. CLASSIFICATION OF SUBJECT MATTER
INV. B23P6/00 F01D5/00 F01D5/20
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
B23P F01D B23K B24B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

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X	EP 1 701 004 A1 (GEN ELECTRIC [US]) 13 September 2006 (2006-09-13) cited in the application paragraphs [0001], [0003], [0008], [0011], [0012], [0015], [0016], [0018] - [0021], [0026], [0028] figures 1-4	1-11
X	US 2011/052386 A1 (SCHOONOVER JEFFREY JON [US] ET AL) 3 March 2011 (2011-03-03) cited in the application paragraphs [0001], [0005] - [0007], [0014] - [0024] figures 1-5	1-11
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Further documents are listed in the continuation of Box C.



See patent family annex.

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Date of the actual completion of the international search

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Name and mailing address of the ISA/

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Stocker, Christian

INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2013/064706

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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A	EP 1 262 632 A1 (GEN ELECTRIC [US]) 4 December 2002 (2002-12-04) paragraphs [0001], [0006], [0008] - [0012], [0014], [0015], [0018], [0024] figures 1-6 -----	1-11

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

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