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(71) Applicant (for all designated States except US): **ALSTOM TECHNOLOGY LTD** [CH/CH]; Brown Boveri Strasse 7, CH-Baden 5400 (CH).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **NAIK, Shailendra** [GB/CH]; Birkenweg 26B, CH-5412 Gebenstorf (CH). **PATHAK, Gaurav** [GB/CH]; Höhtalstrasse 23, CH-5408 Ennetbaden (CH).

(74) Common Representative: **ALSTOM TECHNOLOGY LTD**; CHTI Intellectual Property, Brown Boveri Str. 7/664/2, CH-Baden 5401 (CH).

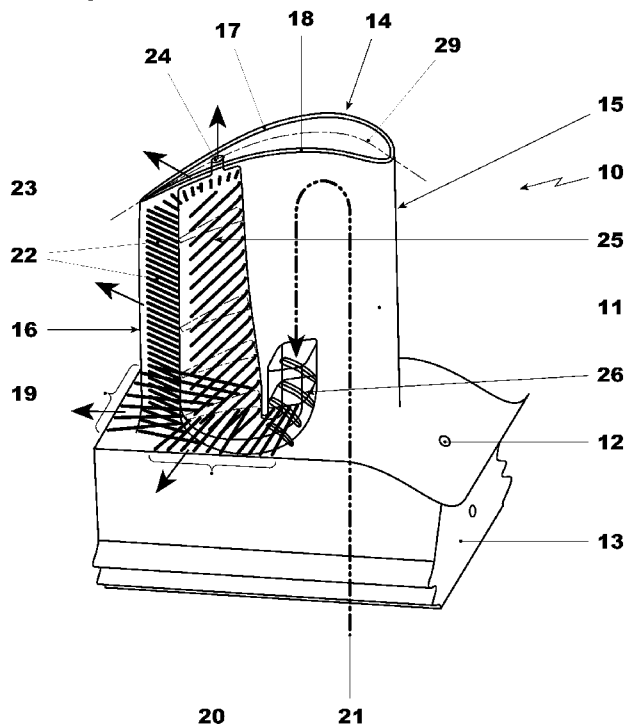
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(54) Title: COOLED BLADE FOR A GAS TURBINE, METHOD FOR PRODUCING SUCH A BLADE, AND GAS TURBINE HAVING SUCH A BLADE

FIG. 1



(57) Abstract: A cooled blade (10) for a gas turbine comprises an airfoil (11) extending in radial direction of the turbine or longitudinal direction of the blade (10), respectively, between a platform (12) and a blade tip (14), said airfoil (11) being bordered across the airfoil (11) by a leading edge (15) and a trailing edge (16), and having a suction side (17) and a pressure side (18), whereby at the trailing edge (16) a first cooling passage (25) runs parallel to the trailing edge (16) from the platform (12) to the blade tip (14) in the interior of the airfoil (11), which cooling passage (25) is supplied with a cooling air flow (21) from the platform side, and from which cooling air is discharged through a plurality of cooling holes (19, 20a, 22, 23) arranged all over the blade (10). For such a blade the cooling is optimized by providing a first cooling passage (25), the passage area of which is tapered in radial direction by between 35% and 59%.

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COOLED BLADE FOR A GAS TURBINE, METHOD FOR PRODUCING
SUCH A BLADE, AND GAS TURBINE HAVING SUCH A BLADE

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Technical field

10 The present invention relates to the field of gas turbine technology. It relates to a cooled blade for a gas turbine in accordance with the preamble of claim 1, and to a method for producing such a blade.

Prior art

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The efficiency of gas turbines depends substantially on the temperature of the hot gas that expands in the turbine while performing work. In order to be able to raise the efficiency, the components (guide vanes, moving blades, heat accumulating segments etc.) exposed to the hot gas must not
20 only be produced from particularly heat resistant materials, but also be cooled as effectively as possible during operation. Different methods have been developed in the prior art in relation to the cooling of blades, and these can be used alternatively or cumulatively. One method consists in conducting a coolant, mostly pressurized cooling air from the compressor
25 of the gas turbine, in cooling ducts through the interior of the blades, and allowing this coolant to emerge into the hot gas duct through cooling bores arranged in distributed fashion. The cooling ducts can in this case repeatedly reverse the interior of the blade in a serpentine fashion (see, for example, WO-A1-2005/068783). The heat transfer between the coolant
30 and the walls of the blade can be improved in this case by virtue of the fact that additional turbulences can be generated in the coolant flow by means of suitable effectively cooling elements, for example turbulators, or impingement cooling. However an occasionally complementary method permits the coolant to emerge from the interior of the blade such that there

is formed on the blade surface a film that is made from coolant, so called film cooling, that affords the blades additional protection against thermal loads.

5 Particular importance attaches to the cooling of the narrow trailing edge of the blade. It is advantageous for the efficiency of the turbine if the trailing edge can be designed to be as thin as possible. On the other hand, the trailing edge must also be adequately cooled precisely because it is
10 meanwhile being fed sufficient coolant. Moreover, it is necessary to achieve cooling that is as uniform as possible in all operating states, the use of coolant needing to be restricted to what is required in order not to exert a disadvantageous influence on the efficiency of the machine.

15 **Summary of the invention**

It is therefore an object of the invention to provide a cooled blade for a gas turbine which is distinguished by improved cooling, and to specify a method
20 for producing it.

The object is achieved by means of the totality of the features of claims 1 and 17. It is essential to the proposed solution that in the region of the trailing edge and running parallel to the trailing edge from the platform up to the blade tip in the interior of the airfoil there is a first cooling duct to which
25 a coolant flow is applied from the platform and from which coolant is guided to the outside via a multiplicity of holes distributed on the blade, and that the cross section of the first cooling duct tapers toward the blade tip, the taper being between 35% and 59%. The taper is preferably approximately 42%.

30 One refinement of the invention is distinguished in that the cross-sectional area of the first cooling duct has a height in a circumferential direction of the turbine, and a width in an axial direction of the turbine, and in that the height/width side ratio diminishes toward the blade tip. In particular, the
35 height/width side ratio diminishes toward the blade tip at 5% to 14%, preferably by approximately 9%.

The holes arranged distributed on the blade are preferably designed as elongated cooling bores that are produced with low geometric tolerance by EDM (Electro-Discharge Machining) or laser drilling.

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Another refinement of the invention is characterized in that first cooling bores are arranged distributed along the trailing edge, in that second cooling bores are arranged distributed on the blade tip, and in that the first and second cooling bores open into the exterior on the pressure side of the blade or have been introduced into the blade from the pressure side.

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The inlets of the first cooling bores are in this case preferably arranged directly on the centerline of the first cooling duct.

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In particular, the first cooling bores have a cylindrical shape in that the ratio of the length to diameter of the first cooling bores is between 20 and 35, the spacing of neighboring first cooling bores in a radial direction is 2 to 5 times, preferably 3.5 times their diameter, the first cooling bores enclose with the horizontal an angle of 20° - 40° , preferably approximately 30° , and the angle of the first cooling bores to the surface of the blade is between 8° and 15° , preferably approximately 10° .

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In accordance with a further refinement of the invention, at the transition between platform and airfoil the first cooling bores are aligned with the centerline of the airfoil such that the coolant air is ejected centrally through these cooling bores at the intersection point between the centerline and the profile of the trailing edge.

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Another refinement is distinguished in that the first cooling bores merge uniformly at the blade tip into the second cooling bores, in that the second cooling bores have a cylindrical shape, in that the ratio of length to diameter of the second cooling bores is between 4 and 15, in that the spacing of neighboring second cooling bores is 4 to 6 times, preferably 5 times their diameter, and in that the angle of the second cooling bores to the surface of the blade is between 25° and 35° , preferably approximately 30° .

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Furthermore, it is advantageous for the cooling of the blades when third and fourth cooling bores run through the platform, and in that the third cooling bores open into the exterior on the suction side of the blade, and
5 the fourth cooling bores open into the exterior on the pressure side of the blade.

A first development of this refinement is characterized in that the fourth cooling bores have a cylindrical shape and enclose different angles with
10 the edge of the platform, and in that the spacing of neighboring fourth cooling bores on the outside of the platform is 5 to 8 times, preferably approximately 6 times their diameter, and in that the ratio of length to diameter of the fourth cooling bores is between 25 and 35. A proportion of the fourth cooling bores exit from the first cooling channel on its side facing
15 the pressure side of the blade.

A second development of this refinement is characterized in that the third cooling bores have a cylindrical shape and enclose different angles with the edge of the platform, and in that the spacing on neighboring third
20 cooling bores on the outside of the platform is 6 to 8 times, preferably approximately 6.5 times their diameter, and in that the ratio of length to diameter of the third cooling bores is between 30 and 45. The third cooling bores preferably emerge from the first cooling duct on its side facing the suction side of the blade.

25 Another refinement of the invention is distinguished in that in order to generate and/or reinforce a turbulent cooling air flow obliquely positioned ribs are arranged in the first cooling duct, in that in the region of the platform the first cooling duct is connected via a bend to a parallel running
30 second cooling duct, and in that an outwardly guiding particle hole of relatively large diameter is provided in the blade tip at the end of the first cooling duct.

The inventive method for producing the blade is characterized in that holes
35 arranged distributed on the blade are introduced from outside into the blade in the form of cooling bores with low geometric tolerance by means

of EDM (Electro-Discharge Machining) or laser drilling.

The invention can be applied advantageously in a gas turbine having a multiplicity of moving blades fitted on a rotor and of guide vanes fitted in the housing surrounding the rotor, this being done by using blades according to the invention as moving blades and/or guide blades.

Brief explanation of the figures

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The invention is to be explained in more detail below with the aid of exemplary embodiments in conjunction with the drawing. All elements that are not essential for directly understanding the invention have been omitted. Identical elements are provided with identical reference numerals in the various figures. The flow direction of the media is specified by arrows. In the drawing:

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figure 1 shows a perspective, simplified illustration of a cooled gas turbine blade in accordance with an exemplary embodiment of the invention, only the cooling bores arranged distributed in the region of the trailing edge being drawn in;

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figure 2 shows the cooling duct running parallel to the trailing edge, together with the cooling bores emanating therefrom from figure 1;

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figure 2a shows an enlarged section from figure 2 for the purpose of explaining the cross sectional dimensions in the cooling duct, and

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figure 3 shows, in an illustration comparable to figure 2, the configuration composed of cooling duct and cooling bores as seen from another side.

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Ways of carrying out the invention

Figure 1 shows a perspective, simplified illustration of a cooled gas turbine blade in accordance with an exemplary embodiment of the invention. The blade 10, which can be a moving blade rotating with the rotor about the machine axis, or a guide blade mounted in stationary fashion on the housing, comprises an airfoil 11 that extends in a longitudinal direction of the blade or in a radial direction of the gas turbine and terminates at the free end in a blade tip 14. Adjoining the other end of the airfoil 11 is a platform 12 that bounds the hot gas duct and below which there is integrally formed a blade root 13 for mounting the blade 10 in a groove, provided for the purpose, in the rotor. The airfoil is bounded in the direction transverse to the longitudinal axis, that is to say in the flow direction of the hot gas of the turbine, upstream by a leading edge 15, and downstream by a trailing edge 16. As is to be gathered from the blade tip 14, the airfoil 11 has the cross sectional profile of a wing, the convexly curved side being the suction side 17 and the concavely curved side being the pressure side 18.

The purpose of cooling the blade 10 is served by providing in the interior a number of cooling ducts that run parallel in the longitudinal direction, are connected in a serpentine fashion and of which the figures show only the last cooling duct 25, arranged in the region of the trailing edge 16, and a portion of the cooling duct 26 arranged upstream thereof (figure 2). The two cooling ducts 25 and 26 are interconnected by a bend 28 conforming to the flow (figure 2). In order to cool the blade 10, there is applied to the cooling ducts 25, 26 a cooling air flow 21 that (as indicated by the dashed and dotted arrow in figure 1) is guided up from below through the blade root 13 and the platform 12 from a plenum with compressed air of the gas turbine.

As is to be gathered from the figures, the trailing edge 16, the platform 12 and the blade tip 14 of the blade are penetrated by a multiplicity of long cooling bores 19, 20, 22 and 23 through which cooling air moves outward out of the cooling ducts 25, 26, and in the process cools the regions of the blade 10 which are flowed through. The cooling bores 19, 20, 22 and 23 are produced by means of EDM (Electro-Discharge Machining; spark erosion) and/or laser drilling, it thereby being possible to effect narrow

geometric tolerances in the bores.

All the cooling bores 22 and 23 of the airfoil 11 and of the blade tip 14 open outward on the pressure side 18 of the blade 10. The cooling bores 19 and 20 and 20a, b running through the platform 12 open into the exterior on the suction side 17 of the blade (cooling bores 19) or on the pressure side 18 of the blade (cooling bores 20 and 20a, b). All the cooling bores of the cooling channels 25 (cooling bores 19, 20a, 22, 23) and 26 (cooling bores 20b) emerge in the interior of the blade 10.

In order to permit the cooling air guided up in the cooling ducts 25, 26 to emerge at predetermined rates through all the cooling bores 19, 20, 22, 23 on the trailing edge 16, the blade tip 14 and the platform 12, within the scope of the invention the cooling duct 25 at the trailing edge is optimized with regard to flow cross section and side ratio (H/W in figure 2a). This ensures that the cooling air pressure in the cooling duct 25 assumes and maintains a predetermined optimum value in all operating states of the machine. In particular, the dependence of the flow cross sections and side ratios in the cooling ducts 25 on the blade height (spatial coordinates in blade longitudinal direction) is optimized. The flow cross section of the cooling duct 25 tapers conically toward the blade tip 14, specifically by 35% to 59%, in particular approximately 42%. The ratio H/W of duct height H in a circumferential direction and duct width W in an axial direction (see figure 2a) diminishes toward the blade tip 14 by 5% to 40%, in particular by approximately 9%.

The first cooling bores 22 of the blade 10 are introduced into the airfoil 11 from the pressure side 18. They open in the interior of the blade 10 into the cooling duct 25, specifically such that their holes lie directly on the centerline (dashed and dotted line 30 in figure 2) of the cooling duct cross section.

The first cooling bores 22 are aligned in this case such that they enclose an angle between 20° and 40°, preferably approximately 30°, with the horizontal. The angle between the first cooling bores 22 and the surface of the airfoil 11 is between 8° and 15°, preferably approximately 10°. The

spacing between neighboring first cooling bores 22 in a radial direction corresponds to 2 to 5 times, preferably approximately 3.5 times the bore diameter. The ratio of the length of the first cooling bores 22 to the diameter varies along the blade heights in the region between 20 and 35.

5 The first cooling bores 22 all have a cylindrical shape.

At the transition between the platform 12 and the airfoil (at the lower end of the cooling duct 25 at the transition to the bend 28), the first cooling bores 22 there are aligned exactly or largely exactly along the chord line 29 of the
10 airfoil 11 (dashed and dotted line in figure 1) such that the cooling air is ejected centrally through these first cooling bores 22 at the intersection point between the chord line 29 and the profile of the trailing edge 16.

The first cooling bores 22 merge uniformly into shorter second cooling
15 bores 23 on the blade tip 14. The second cooling bores 23 have a cylindrical shape. The ratio of length to diameter of the second cooling bores 23 is between 4 and 15. The spacing of neighboring second cooling bores 23 is 4 to 6 times, preferably 5 times their diameter. The angle of the second cooling bores 23 to the surface of the blade 10 is between 25° and
20 35°, preferably approximately 30°.

As already mentioned further above, third and fourth cooling bores 19 and 20, 20a, b run through the platform 12, the third cooling bores 19 opening into the exterior on the suction side 17 of the blade 10, and the fourth
25 cooling bores 20, 20a, b opening into the exterior on the pressure side 18 of the blade 10. The fourth cooling bores 20, 20a, b also have a cylindrical shape. They enclose various angles with the edge of the platform 12 (spreading). The spacing on neighboring fourth cooling bores 20; 20a, b on the outside of the platform 12 is 5 to 8 times, preferably approximately 6
30 times their diameter. The ratio of length to diameter of the fourth cooling bores 20, 20a, b is between 25 and 35. A proportion (20a) of the fourth cooling bores exit from the first cooling channel 25 on its side facing the pressure side 18 of the blade 10. Another portion (20b) exits from the second cooling duct 26 at its side facing the pressure side 18 of the blade
35 10.

The third cooling bores 19 also have a cylindrical shape and enclose different angles with the edge of the platform 12. The spacing of neighboring third cooling bores 19 on the outside of the platform 12 is 6 to 8 times, preferably approximately 6.5 times their diameter. Ratio of length to diameter of the third cooling bores 19 lies between 30 and 45. The third cooling bores 19 exit from the first cooling duct 25 at its side facing the suction side 17 of the blade 10.

Furthermore, in order to generate and/or reinforce a turbulent cooling air flow obliquely positioned ribs 27 are advantageously arranged in the first cooling duct 25. It is possible to provide in the blade tip 14 at the end of the first cooling duct 25 a dust hole 24 of larger diameter that leads outward and is known per se, for example from EP-A2-1 882 817 and contributes to preventing accumulation of dust in the cooling duct 25.

In summary, the invention exhibits the following characteristic features and advantages:

- large quantities of cooling air are ejected through numerous long cooling bores owing to cooling ducts with optimized geometry at the trailing edge of the blade.
- The cooling ducts are equipped with turbulators and interconnected by bends with optimized geometry in order to minimize the pressure loss and to control the flows through the various cooling bores.
- Both the duct cross section and the side ratio of the cooling duct at the trailing edge decrease toward the blade tip.
- An optimized arrangement of a multiplicity of cooling bores exits from the cooling duct at the trailing edge of the blade. The cooling bores are introduced into the blade by means of EDM and/or laser drilling.
- In order to optimize the cooling, cooling bores on trailing edge, on the blade tip and in the platform have specific spatial orientations (angles of inclination etc.), length/diameter ratios and spacings from one another.

List of Reference Numerals

	10	Blade (gas turbine)
5	11	Airfoil
	12	Platform
	13	Blade root
	14	Blade tip
	15	Leading edge
10	16	Trailing edge
	17	Suction side
	18	Pressure side
	19, 20, 20a,b	Cooling hole
	22, 23	Cooling hole
15	21	Cooling air flow
	24	Dust hole
	25,26	Cooling passage
	27	Rib
	28	Bend
20	29	Chord line (airfoil)
	30	Centerline (cooling passage 25)

Patent claims

1. A cooled blade (10) for a gas turbine, comprising an airfoil (11) that
5 extends in a radial direction of the turbine or in a longitudinal
direction of the blade (10), respectively, between a platform (12) and
a blade tip (14), is bounded transverse to the longitudinal direction
by a leading edge (15) and a trailing edge (16) and has a suction
side (17) and a pressure side (18), wherein in the region of the
10 trailing edge (16) and running parallel to the trailing edge (16) from
the platform (12) up to the blade tip (14) in the interior of the airfoil
(11) there is a first cooling duct (25) which is fed with a coolant flow
(21) from the platform (12) and from which coolant is guided to the
outside via a multiplicity of holes (19, 20a, 22, 23) arranged
15 distributed on the blade (10), characterized in that the cross section
of the first cooling duct (25) tapers toward the blade tip (14), the
taper being between 35% and 59%.
2. The blade as claimed in claim 1, characterized in that the taper is
20 approximately 42%.
3. The blade as claimed in claim 1 or 2, characterized in that the cross-
sectional area of the first cooling duct (25) has a height (H) in a
circumferential direction of the turbine, and a width (W) in an axial
25 direction of the turbine, and in that the height/width (H/W) side ratio
diminishes toward the blade tip (14).
4. The blade as claimed in claim 3, characterized in that the
height/width (H/W) side ratio diminishes toward the blade tip (14) by
30 5% to 14%, preferably by approximately 9%.
5. The blade as claimed in one of claims 1 to 4, characterized in that
the holes arranged distributed on the blade (10) are designed as
elongated cooling bores (19, 20a, 22, 23), and in that the cooling
35 bores (19, 20a, 22, 23) are produced with low geometric tolerance
by EDM (Electro-Discharge Machining) or laser drilling.

- 5 6. The blade as claimed in claim 5, characterized in that first cooling bores (22) are arranged distributed along the trailing edge (16), in that second cooling bores (23) are arranged distributed on the blade tip (14), and in that the first and second cooling bores (22, 23) open into the exterior on the pressure side (18) of the blade (10) or have been introduced into the blade (10) from the pressure side (18).
- 10 7. The blade as claimed in claim 6, characterized in that the inlets of the first cooling bores (22) are arranged directly on the centerline (30) of the first cooling duct (25).
- 15 8. The blade as claimed in claim 6 or 7, characterized in that the first cooling bores (22) have a cylindrical shape, in that the ratio of the length to diameter of the first cooling bores (22) is between 20 and 35, in that the spacing of neighboring first cooling bores (22) in a radial direction is 2 to 5 times, preferably 3.5 times their diameter, in that the first cooling bores (22) enclose with the horizontal an angle of 20°-40°, preferably approximately 30°, and in that the angle of the first cooling bores (22) to the surface of the blade (10) is between 8° and 15°, preferably approximately 10°.
- 20 9. The blade as claimed in claim 8, characterized in that at the transition between platform (12) and airfoil (11) the first cooling bores (22) are aligned with the chord line (29) of the airfoil (11) such that the cooling air is ejected centrally through these cooling bores (22) at the intersection point between the chord line (29) and the profile of the trailing edge (16).
- 25 10. The blade as claimed in claim 6, characterized in that the first cooling bores (22) merge uniformly at the blade tip (14) into the second cooling bores (22), in that the second cooling bores (23) have a cylindrical shape, in that the ratio of length to diameter of the second cooling bores (23) is between 4 and 15, in that the spacing of neighboring second cooling bores (23) is 4 to 6 times, preferably 5 times their diameter, and in that the angle of the second cooling
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bores (23) to the surface of the blade (10) is between 25° and 35°, preferably approximately 30°.

- 5 11. The blade as claimed in claim 6, characterized in that third and fourth cooling bores (19 and 20, 20a, b, respectively) run through the platform (12), and in that the third cooling bores (19) open into the exterior on the suction side (17) of the blade (10), and the fourth cooling bores (20, 20a, b) open into the exterior on the pressure side (18) of the blade (10).
- 10 12. The blade as claimed in claim 11, characterized in that the fourth cooling bores (20; 20a, b) have a cylindrical shape and enclose different angles with the edge of the platform (12), and in that the spacing of neighboring fourth cooling bores (20; 20a, b) on the
- 15 outside of the platform (12) is 5 to 8 times, preferably approximately 6 times their diameter, and in that the ratio of length to diameter of the fourth cooling bores (20; 20a, b) is between 25 and 35.
- 20 13. The blade as claimed in claim 12, characterized in that a proportion (20a) of the fourth cooling bores exit from the first cooling channel (25) on its side facing the pressure side (18) of the blade (10).
- 25 14. The blade as claimed in claim 11, characterized in that the third cooling bores (19) have a cylindrical shape and enclose different angles with the edge of the platform (12), and in that the spacing of neighboring third cooling bores (19) on the outside of the platform (12) is 6 to 8 times, preferably approximately 6.5 times their diameter, and in that the ratio of length to diameter of the third cooling bores (19) is between 30 and 45.
- 30 15. The blade as claimed in claim 14, characterized in that the third cooling bores (19) emerge from the first cooling duct (25) on its side facing the suction side (17) of the blade (10).
- 35 16. The blade as claimed in one of claims 1 to 15, characterized in that in order to generate and/or reinforce a turbulent cooling air flow

5 obliquely positioned ribs (27) are arranged in the first cooling duct (25), in that in the region of the platform (12) the first cooling duct (25) is connected via a bend (28) to a parallel running second cooling duct (26), and in that an outwardly guiding dust hole (24) of relatively large diameter is provided in the blade tip (14) at the end of the first cooling duct (25).

- 10 17. The method for producing a blade as claimed in one of claims 1 to 16, characterized in that holes (19, 20a, 22, 23) arranged distributed on the blade (10) are introduced from outside into the blade (10) in the form of cooling bores with low geometric tolerance by means of EDM (Electro-Discharge Machining) or laser drilling.
- 15 18. A gas turbine having a multiplicity of moving blades fitted on a rotor, and of guide blades fitted in a housing surrounding the rotor, characterized in that blades as claimed in one of claims 1 to 16 are used as moving blades and/or guide blades.

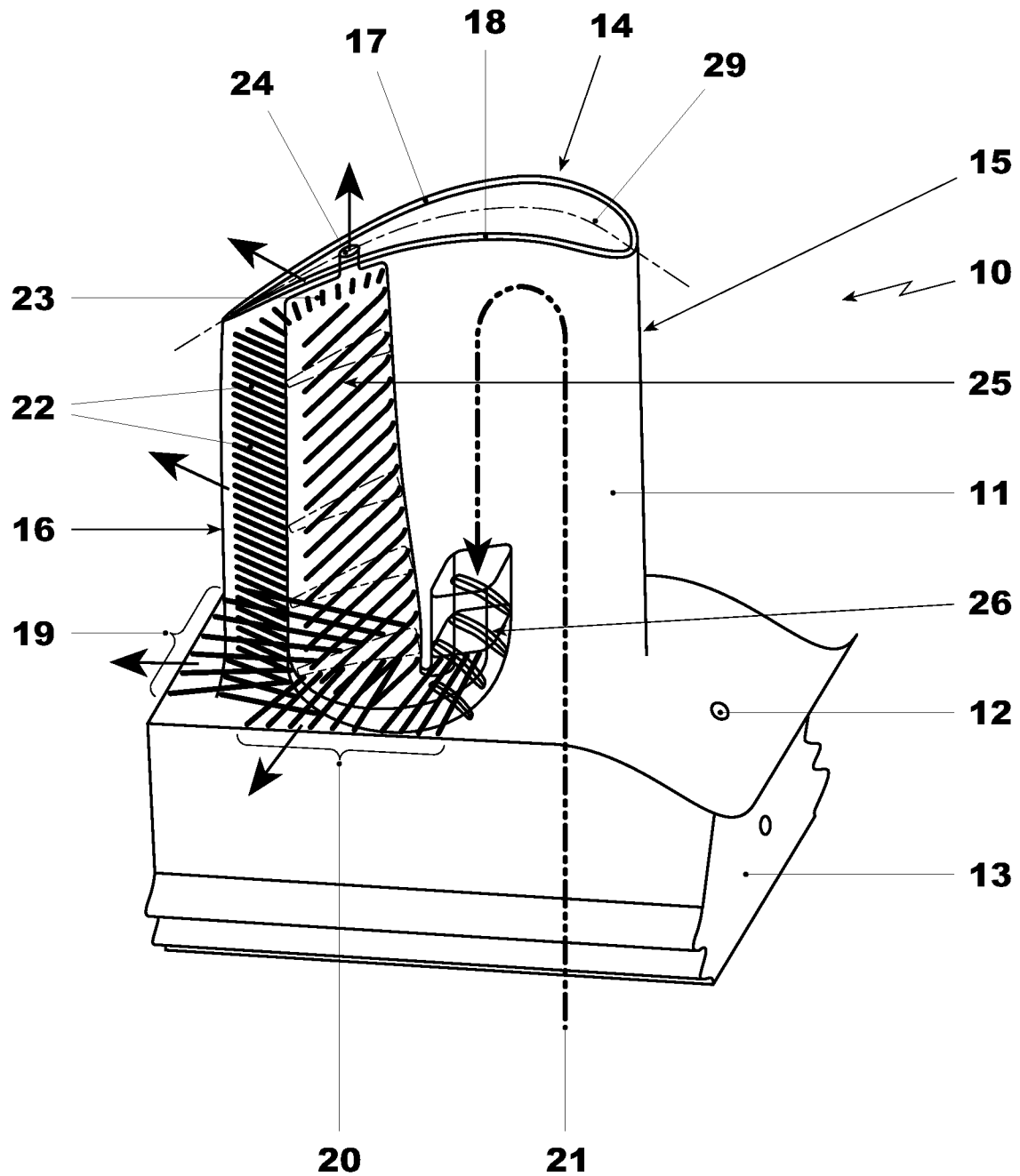
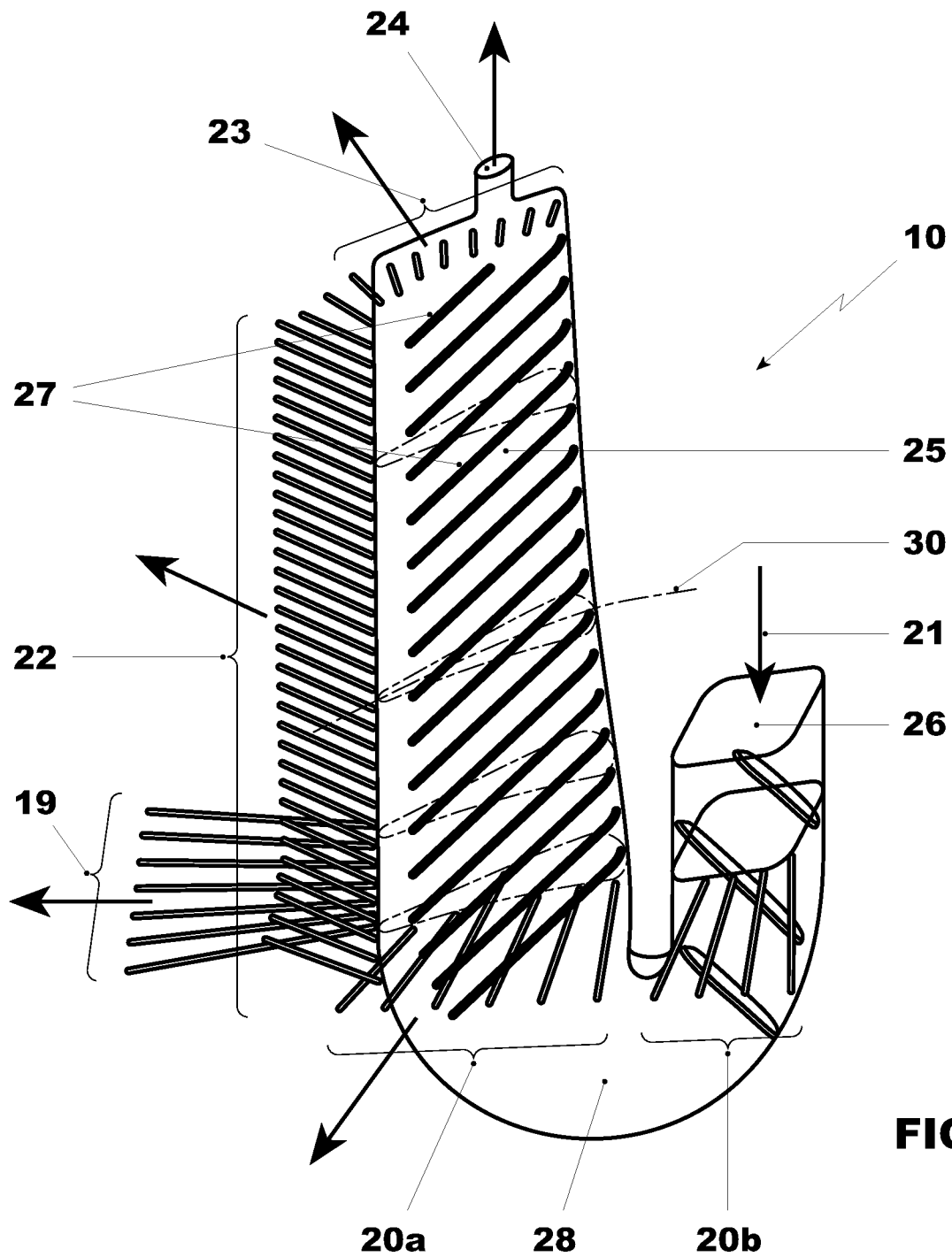
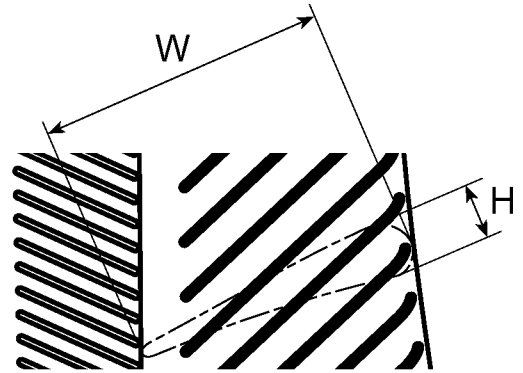


FIG. 1

FIG. 2a



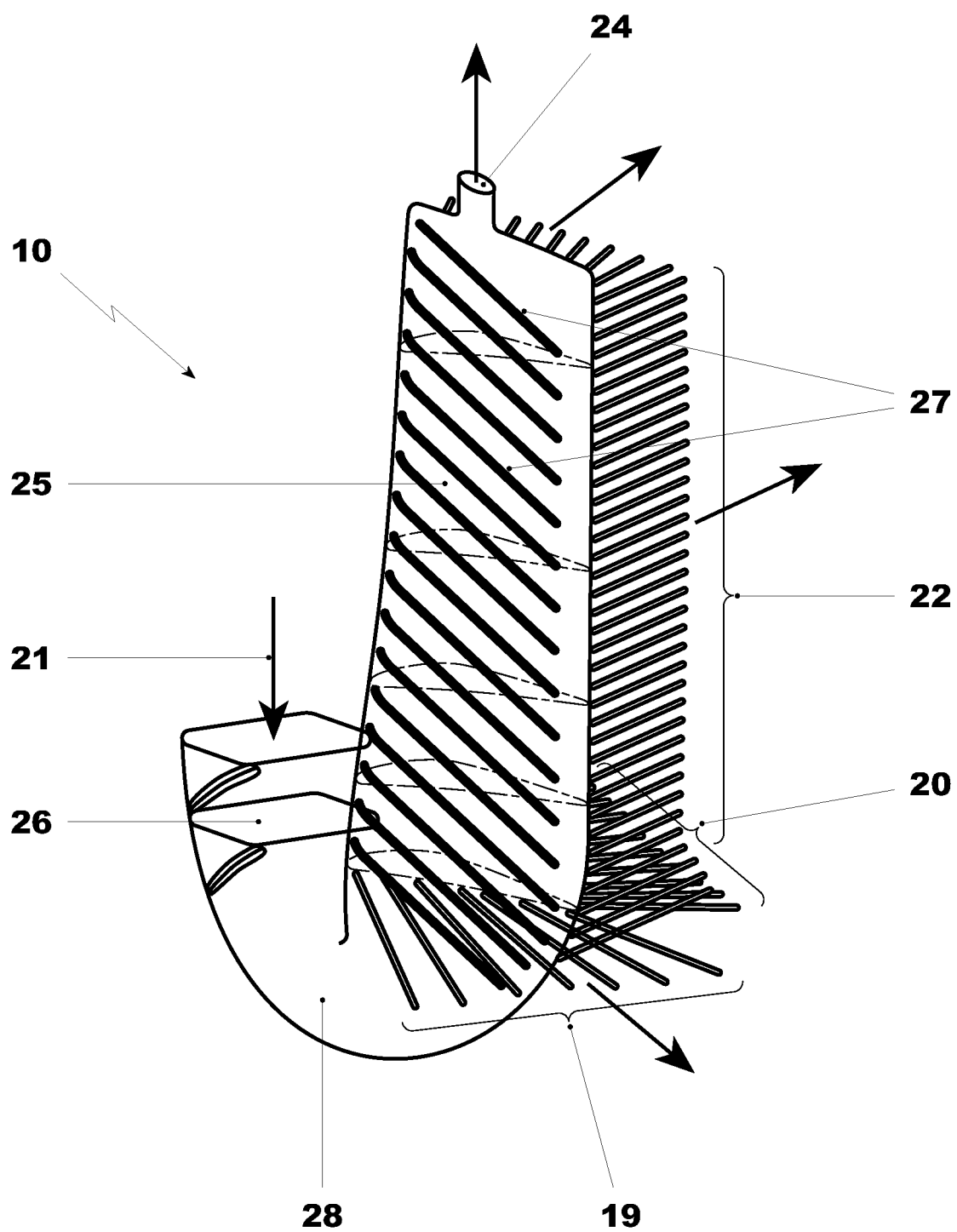


FIG. 3

INTERNATIONAL SEARCH REPORT

International application No

PCT/EP2009/063388

A. CLASSIFICATION OF SUBJECT MATTER

INV. F01D5/18

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)

F01D

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 practical, search terms used)

EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 1 630 352 A (ROLLS ROYCE PLC [GB]) 1 March 2006 (2006-03-01)	1-4, 18
Y	figures 3,5 paragraph [0001] paragraph [0011] paragraph [0024] paragraph [0026] paragraph [0029] -----	11-15
X	EP 1 443 178 A (UNITED TECHNOLOGIES CORP [US]) 4 August 2004 (2004-08-04)	1,3-7, 10,16-18
Y	paragraph [0001] paragraph [0011] paragraph [0012] paragraph [0013] figures 1-3 -----	8-9, 11-15
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☒ Further documents are listed in the continuation of Box C.

☒ See patent family annex.

* Special categories of cited documents :

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Date of the actual completion of the international search

15 January 2010

Date of mailing of the international search report

28/01/2010

Name and mailing address of the ISA/

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040,
Fax: (+31-70) 340-3016

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Rapenne, Lionel

INTERNATIONAL SEARCH REPORT

International application No

PCT/EP2009/063388

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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