CLAIMS

What is claimed is:

1. A method for working a combustor float wall panel comprising:

providing a supplemental body of a combustor float wall panel; and

attaching at least one cooling pin to the supplemental body.

2. The method of claim 1, wherein the attached cooling pin is longer than the existing cooling pins of the combustor float wall panel.

3. The method of claim 2, further comprising trimming the attached cooling pin to match the length of said pin to the existing pins, after attachment of said pin to the supplemental body.

4. The method of claim 3, further comprising individually attaching each cooling pin and trimming said cooling pin before attaching and trimming another cooling pin.

5. The method of claim 3, further comprising attaching a plurality of cooling pins to the supplemental body and subsequently trimming said plurality of cooling pins.

6. The method of claim 1, further comprising attaching as many cooling pins to the supplemental body as needed to match the pattern of the existing cooling pins on the combustor float wall panel.

7. The method of claim 1, wherein percussion welding is used to attach the at least one cooling pin to the supplemental body.

8. The method of claim 1, further comprising blending the contour of the supplemental body to match the contour of the existing body of the combustor float wall panel.

9. The method of claim 1, wherein the attached cooling pin is between 0.020 inches and 0.060 inches in diameter and between 0.020 inches and 0.200 inches in length.

10. The method of claim 1, further comprising removing a portion of the combustor float wall panel and providing the supplemental body in the area of the combustor float wall panel where the portion was removed.

11. A method for working a combustor float wall panel of a gas turbine engine comprising:

separating a combustor float wall panel from a combustor of a gas turbine engine;

providing a supplemental body to the combustor float wall panel;

attaching at least one cooling pin to the supplemental body; and

returning the combustor float wall panel to the combustor of the gas turbine engine.

12. The method of claim 11, wherein percussion welding is used for attachment of the at least one cooling pin to the supplemental body.

13. The method of claim 11, wherein the attached cooling pin is longer than the existing cooling pins of the combustor float wall panel.

14. The method of claim 13, further comprising trimming the attached cooling pin to match the length of said pin to the existing pins, after attachment of said pin to the supplemental body.

15. The method of claim 14, further comprising individually attaching each cooling pin and trimming said pin before attaching and trimming another cooling pin.

16. The method of claim 15, further comprising using percussion welding to attach as many cooling pins to the supplemental body as needed to match the pattern of the existing cooling pins on the combustor float wall panel.

17. The method of claim 11, wherein the attached cooling pin is between 0.020 inches and 0.060 inches in diameter and is between 0.020 inches and 0.200 inches in length.

18. The method of claim 17, further comprising removing a portion of the combustor float wall panel and providing the supplemental body in the area of the combustor float wall panel where the portion was removed.

19. A method for working a combustor float wall panel comprising:

cutting out a portion of a combustor float wall panel;

filling the area of the combustor float wall panel where the portion was cut out with weld material;

blending the contour of the filled area to match the contour of the existing combustor float wall panel;

attaching at least one cooling pin to the filled area, said pin being longer than the existing cooling pins of the combustor float wall panel; and

trimming the at least one cooling pin to match the length of the existing cooling pins.

20. The method of claim 19, wherein percussion welding is used to attach as many cooling pins to the filled area as needed.

What is claimed is:

1. A method for working a combustor float wall panel having an existing cooling pin and a first contour comprising:

adding a supplemental body to the combustor float wall panel, the supplemental body having a second contour, the supplemental body lacking the existing cooling pin; and

attaching at least one second cooling pin to the supplemental body, the at least one second cooling pin being longer than the existing cooling pin.

2. The method of claim 1, further comprising trimming the second cooling pin to match the length to the existing cooling pin, after attachment of the second cooling pin to the supplemental body.

3. The method of claim 1, wherein the float wall panel includes more than one existing cooling pin and further includes the attaching second cooling pins to the supplemental body to match the pattern of the more than one existing cooling pins on the combustor float wall panel, the second cooling pins being longer than the existing cooling pins.

4. The method of claim 1, wherein percussion welding is used to attach the at least one second cooling pin to the supplemental body.

5. The method of claim 1, further comprising blending the second contour of the supplemental body to match the first contour of the combustor float wall panel before attaching the at least one second cooling pin.

6. The method of claim 1, wherein the second cooling pin is between 0.020 inches and 0.060 inches in diameter and between 0.020 inches and 0.200 inches in length.

7. The method of claim 1, further comprising removing a portion of the combustor float wall panel and then adding the supplemental body to the area of the combustor float wall panel where the portion was removed.

8. The method of claim 2, further comprising individually attaching each second cooling pin and then trimming each second cooling pin before attaching and trimming another second cooling pin.

9. The method of claim 2, further comprising attaching a plurality of second cooling pins to the supplemental body and then trimming the plurality of second cooling pins.

10. The method of claim 2, wherein percussion welding is used to attach the at least one second cooling pin to the supplemental body.

11. A method for working a combustor float wall panel of a gas turbine engine comprising:

separating the combustor float wall panel from a combustor of a gas turbine engine, the combustor float wall panel having an existing cooling pin;

adding a supplemental body to the combustor float wall panel, the supplemental body lacking the existing cooling pin;

attaching at least one second cooling pin to the supplemental body, the at least one second cooling pin being longer than the existing cooling pin; and

returning the combustor float wall panel to the combustor of the gas turbine engine.

12. The method of claim 11, wherein percussion welding is used for attachment of the at least one second cooling pin to the supplemental body.

13. The method of claim 11, further comprising trimming the second cooling pin to match the length of the existing cooling pin, after attachment of the second pin to the supplemental body.

14. The method of claim 11, wherein the float wall panel includes more than one existing cooling pin, and the method further comprising using percussion welding to attach second cooling pins to the supplemental body to match the pattern of the existing cooling pins on the combustor float wall panel.

15. The method of claim 11, wherein the second cooling pin is between 0.020 inches and 0.060 inches in diameter and is between 0.020 inches and 0.200 inches in length.

16. The method of claim 11, further comprising removing a portion of the combustor float wall panel and then adding the supplemental body to the area of the combustor float wall panel where the portion was removed.

17. The method of claim 13, further comprising individually attaching each second cooling pin and then trimming each second pin before attaching and trimming another second cooling pin.

18. The method of claim 13, wherein percussion welding is used to attach the at least one second cooling pin to the supplemental body.

19. A method for working a combustor float wall panel having an existing cooling pin comprising:

cutting out a portion of the combustor float wall panel;

filling the area of the combustor float wall panel where the portion was cut out with weld material;

blending the contour of the filled area to match the contour of the existing combustor float wall panel;

attaching at least one second cooling pin to the filled area by percussion welding, the at least one second cooling pin being longer than the existing cooling pin of the combustor float wall panel; and

trimming the at least one second cooling pin to match the length of the existing cooling pin.