Providing training for the life of your plant

Siemens Power Plant Operations Support and Training
Customer Training Overview
A well-trained and knowledgeable team of plant Operations and Maintenance (O&M) personnel is essential for a plant to run at maximum performance, to extend the life of equipment, to minimize costly unscheduled maintenance resulting from operator error and to maximize the profitability of the plant for years to come.

Training Course Overview
To help improve plant efficiency and reliability, Siemens Plant Operations Support and Training Team offers total plant operations and maintenance assistance and support services. Periodic repeat / refresher training is necessary and essential to help ensure O&M personnel maintain an acceptable level and depth of knowledge. Periodic training is also an effective means to keep personnel engaged and proactive.

At the Core of our training programs are the Familiarization and Operations courses. Both courses integrate a combination of classroom instruction and associated system walk downs. The goal of the Familiarization and Operation course is to provide this understanding of the Siemens turbines and generators, customized to each customer’s specific site. The Familiarization and Operation courses are prepared for gas turbines, steam turbines and water/steam cycle components.

The Distributed Control System (DCS) is another critical topic within the training process. The Siemens plant operations support and training team utilizes state-of-the-art power plant simulators to provide an exceptional platform for operators of all experience levels to gain the necessary confidence and experience in controlling, recognizing and interpreting the interactions between the various plant systems. Training will also show how the power plant equipment and systems interact with the SPPA-T3000 control system.

Content and delivery is customized to allow the training delivered to be conducted based on your needs and to fit into your shift-work schedule.

Following the Familiarization and Operations training, learning pathways are opened based on an individual’s role at the plant. We have constructed a comprehensive listing of courses to meet the training needs for both Operations and Maintenance staff personnel.

To continue training beyond the commissioning period, the Long Term Training Program was developed. This is an annual training program with a mix of On-Site Instructor Support and off-site advanced operations training.

Whatever your training needs are, the Plant Operations Support and Training team stands ready to be your point of contact for all your training needs.

All information contained herein is provided on a confidential basis solely to customers of Siemens Energy. Disclosure to any third parties is prohibited, unless prior written approval by Siemens Energy is provided to the customer.
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On-Site Instructor Support

Operations Based

Training Objectives
The Instructor is stationed in your control room or observing the auxiliary operator to observe evolutions and recommend possible revisions or operator training that could increase overall plant efficiency and availability.

<table>
<thead>
<tr>
<th>Course Code:</th>
<th>SER201.1</th>
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<tbody>
<tr>
<td>Course Length:</td>
<td>5—30 days</td>
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<tr>
<td>Location:</td>
<td>Customer Site</td>
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Main Features
- Course will consist of informal and impromptu onsite discussions and demonstrations
- Topics will cover the normal day-to-day operation and maintenance of plant systems during equipment erection, startup/ commissioning or any trouble areas experienced at the plant
- Actual course content conforms to equipment and system availability as well as customer requirements

On-Site Instructor Support

I&C Technician Based

Training Objectives
The Instructor is stationed in with your I&C technician to observe evolutions and recommend possible revisions or technician training that could increase overall plant efficiency and availability. Site Technical documentation and historical data is used to troubleshoot and repair existing plant conditions.

<table>
<thead>
<tr>
<th>Course Code:</th>
<th>SER202.1</th>
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<tbody>
<tr>
<td>Course Length:</td>
<td>5—30 days</td>
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<tr>
<td>Location:</td>
<td>Customer Site</td>
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Main Features
- Assist technicians in utilizing the control system to find, analyze and correct instrumentation deficiencies
- Train technicians in use of drawings and technical documentation during troubleshooting efforts
- Assist in tracing control signals both in the control system and in the instrumentation cabling
- Provide guidance in setup and calibration of control valves
- Provide guidance in use of HART communicator functions
- Provide guidance in troubleshooting DCS issues and repair paths
### Gas Turbine Familiarization / Operations

**Training Objectives**
The Gas Turbine Familiarization and Operations course provides personnel with a broad knowledge of Siemens gas turbine engines and the supporting auxiliary systems.

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<thead>
<tr>
<th>Course Code:</th>
<th>OPS201</th>
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<tbody>
<tr>
<td>Course Length:</td>
<td>5—10 days</td>
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</table>

**Main Features**
- Basic gas turbine description
- Lubricating oil
- Control (Hydraulic) oil
- Fuel (fuel gas and/or fuel oil)
- Combustor conventional, DLN, ULN)
- Emission
- Power augmentation
- Compressor water wash
- Turbine water wash

**Location:**
Customer Site or Orlando, Florida

### Steam Turbine Familiarization / Operations

**Training Objectives**
The Steam Turbine Familiarization and Operations course provides personnel with a broad knowledge of Siemens Steam Turbines and the supporting auxiliary systems.

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<tr>
<th>Course Code:</th>
<th>OPS202</th>
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<tr>
<td>Course Length:</td>
<td>5 days, 10 days if Water steam cycle training included</td>
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</tbody>
</table>

**Main Features**
- Basic Steam Turbine description
- Lubricating and Lift Oil Systems
- Hydraulic Control Oil System
- Turbine Seal Steam, Exhauster and Drain Systems
- Cooling Sprays, LP Cooling System and Drains
- Steam Turbine Protection
- Automatic Turbine Tester (ATT)
- Turbine Stress Evaluator (TSE)
- Generator
- Generator Seal Oil
- Starting package
- Inlet air filtration
- Evaporative cooling
- Instrument air
- Turbine air
- Turbine cooling
- Generator and exciter
- Generator cooling
- Hydrogen cooled generator support
- DCS Control
- Integrated System Operations
- Maintenance Considerations

**Location:**
Customer Site or Orlando, Florida

- Generator Cooling Gas (Air to air, Total enclosed water cooled, H2)
- T3000 Control System Overview
- Steam Turbine Operations
- Steam Turbine Operational Guidelines
- Steam Purity Requirements
- Turbine Controller and Operating Concepts
- Prestart checks
- Steam Turbine Startup and Shutdown
- Operating Parameters and Limits
- Water steam cycle familiarization and Operations included if desired for 10 day course
Combined Cycle Familiarization / Operations

Training Objectives
The Combined Cycle Familiarization and Operations course provides personnel with a broad knowledge of Siemens Combined Cycle Power Plants and the supporting auxiliary systems.

Main Features
- Gas Turbine Familiarization
- Lubricating oil
- Control (Hydraulic) oil
- Fuel (fuel gas and/or fuel oil)
- Combustor systems
- Starting system
- Inlet air filtration
- Evaporative cooling
- Generator and exciter
- Generator cooling

Steam Turbine and Balance of Plant Equipment Familiarization (Siemens scope)
- Steam Cycle Overview
- Main Condenser
- Condensate and Feedwater System
- Heat Recovery Steam Generator
- Steam Systems
- Steam Turbine Unit
- Support systems for Steam Turbines

Steam Turbine and Balance of Plant Operation
- Combined cycle operations during startup, loading and steady state operation, shutdown

Gas Turbine Modernization and Upgrades

Training Objectives
Provides an understanding of the system installation and modifications made to the existing mechanical, electrical and the associated auxiliary systems to accommodate the upgrades installed.

Main Features
- Component and construction overview
- System interaction and operation
- Performance benefits
- Operational limitations
- Pre start and startup permissive
- Operational checks during operation
- System function and control
- Maintenance considerations

Rotor air cooler separator installation
- Combustor dynamics monitoring system
- Fiber optic vibration monitoring
- SPPA—T2000 to SPPA—T3000 Upgrade
- Latest SGT6-6000G SPPA-T3000 reference logic upgrade
- Contact us if your modification is not listed and we can create a custom course of any upgrade installed

All available for the following modifications:
- Inlet Heating
- Low Load Turndown

Course Code: OPS205
Course Length: 15—20 days
Location: Customer Site

Course Code: MOD210.x
Course Length: Depends on mods installed (1-3 days typically)
Location: Customer Site
Basic Power Plant Simulator
SPPA-T3000 (T3K) / SPPA-T2000 (TXP)

Training Objectives
This course is an introduction to the control system with extensive hands-on practice in utilizing the control system during plant evolutions. These evolutions may include normal and abnormal equipment operation, normal plant startup, operation, and shutdown procedures.

Course Code: OPS212.1 / OPS211.1
Course Length: 5 days, 2 students
Location: Orlando, Florida

Main Features
- Operator Interface
- Process diagrams
- Operation/Indication Windows and Controllers
- Introduction to Functional Logic Diagrams
- Reading Software (Logic) diagrams
- Troubleshooting
- Dynamic Signal Tracing
- Fault location – techniques
- Point Information
- Display Organization
- Display Selection & Navigation
- Process Operation
- Switching devices ON / OFF
- Changing operating modes MAN / AUTO
- PID Controller operation
- Alarm Sequence Display (ASD)
- Power Plant Control Operations
- Prestart Conditions & Selections
- Cold Plant Starting & Loading
- Load Monitoring & Changing

Advanced Power Plant Simulator SPPA-T3000

Training Objectives
Experience is gained in controlling, recognizing, and interpreting the interactions between various plant components and systems as anomalies are injected into the state of the art power plant simulator requiring the operator to evaluate, isolate, and correct the simulated plant upsets. Each scenario is discussed and feedback is provided to the operator at the completion of each day.

Course Code: OPS311.3
Course Length: 5 days, 2 students
Location: Orlando, Florida

Main Features
- System lineup exercises
- Plant start-up exercises
- Plant load demand exercises
- Equipment failure exercises
- Abnormal condition response exercises
- Plant shutdown exercises
- Creating and interpreting Trends exercises
- Creating and interpreting Reports exercises
- Alarms & responses
- This course requires coordination with plant management to discuss plant casualties to be performed.
- Actual Plant Casualty action plans can be used to evaluate operators on “their” procedures
Operations Personnel

Advanced Control Room Operation Applications

Training Objectives
Provides intensive practice in reading and understanding the control logic diagrams. Through extensive and repeated hands-on practice, the course exercises promote a recognition and interpretation of the interactions between the various control algorithms.

Main Features
- Reading and following Logic
- Define Function Group Concept
- YFR or Logic Diagram Layout
- Input and Output Signals
- Following signals
- Page and Signal Numbering
- YFR or Diagram Navigation
- Review Basic Logic
- Function Blocks
- Sub Loop Controllers
- Drive Controllers
- Sub Group Controller
- Binary changeover switch
- Analog changeover switch
- Mathematical functions
- Operational Sequences
- Automatic and Manual Control
- Pre-start Conditions & Selections
- Cold Plant Starting & Loading
- Troubleshooting
- Inoperable Pumps (Permissives)
- Ready To Starts conditions

<table>
<thead>
<tr>
<th>Course Code:</th>
<th>OPS301.3 / OPS301.2</th>
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<tr>
<td>Course Length:</td>
<td>5 days</td>
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<tr>
<td>Location:</td>
<td>Customer Site</td>
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</table>

Gas Turbine Performance Seminar

Training Objectives
Seminar is designed to provide an understanding of how and why a gas turbine behaves the way it does, and what affects engine capabilities, with an understanding of the basic steps of the gas turbine operating cycle.

Main Features
- Operational theory and function
- Gas turbine operating cycle
  - Introduction to T-s Diagrams
  - Ideal Brayton Cycle
  - Actual Cycle
- Operational considerations
  - Ambient Conditions
  - Instrumentation
  - Mass flow
- Performance and Efficiency
  -Measured values
  - Ambient Conditions
  - Inlet air
  - Compressor outlet
  - Nominal Firing Temperature
  - Exhaust Gas Temperature
- Operator Actions
  - Instrument Calibration
  - Mechanical Calibration (IGV Position)
  - Water Wash
  - On-Line
  - Off-Line

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<thead>
<tr>
<th>Course Code:</th>
<th>SEM310.1</th>
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<tbody>
<tr>
<td>Course Length:</td>
<td>3 days</td>
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<tr>
<td>Location:</td>
<td>Customer Site or Orlando, Florida</td>
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</table>
Gas Turbine Familiarization / Operation for Maintenance

Training Objectives
The Gas Turbine Familiarization and Operations course provides maintenance personnel with a broad knowledge of Siemens gas turbine engines and supporting auxiliary systems from a maintenance level of understanding.

Main Features
- Basic Gas turbine description
- Electrical distribution
- Heating, ventilation & air conditioning
- Lubricating oil
- Control (Hydraulic) oil
- Fuel Gas / Oil
- Compressor water wash
- Inlet Air Filtration
- Evaporative cooler, wet compression
- Turbine air systems
- Generator and Generator Cooling
- Hydrogen cooled generator support
- Integrated System Operations
- Pre-start checks/Ready to start permissives
- Normal startup and shutdown sequence
- Operational checks/ parameters/ limits
- Information Access
- Customer Extranet Portal (CEP) access
- Service Bulletins
- Technical Advisory notices

Simulator Training for I&C Technicians

Training Objectives
Simulator for the I&C Technician Lab covers a practical introduction to the Control System with extensive hands-on practice in utilizing the Control System interface during plant evolutions. These evolutions may include normal and abnormal equipment operation, normal plant startup, operation, and shutdown procedures.

Main Features
- Level of Access
- Plant Displays
- Process Displays
- Reading Software (Logic) diagrams
- Troubleshooting
  - Dynamic Signal Tracing
  - Fault Location – techniques
  - Forcing Ports (signals)/ Restoring Signals
- Display Organization
- Process Operation
- Power Plant Control Operations
  - Operational Considerations
  - Effects of I&C Technician actions on plant operations
- Troubleshooting
- SPPA-T3000 Administrative issues
  - User management
  - Display Hierarchy administration
  - Unique logic applications, limitations and usage
- Physical and network access control
SPPA-T3000 Engineering

Training Objectives
Course is designed to teach the basic principles and views of I&C engineering, diagnostics and operations of the SPPA-T3000 system. Each student will implement a basic control system model, using the workbench to create both function diagrams and plant displays.

Prerequisites
Electrical engineer, electronics technician or competent individual with an electronics background and knowledge of PC operations using MS Windows is needed. Prior experience with a DCS control system is desirable.

Main Features
- System hardware and software architecture, redundancy
- Peripherals
- System Documentation
- Engineering
- Integrated engineering, using AF-blocks and prototypes, creating macros, creating trend displays
- Operation
- Diagnostics
- Commissioning
- Point view
- Plant display hierarchy
- Engineering examples
- Graphics
- SPPA-T3000 system Summary

Course Code: DCS300.1
Course Length: 4 days
Location: Alpharetta, Georgia

SPPA-T3000 Advanced Hardware

Training Objectives
Students will gain an understanding of what each device is used for and how to properly implement, maintain, and troubleshoot. The student will also learn how to properly administer each device in T3000, create each device’s management proxy, and appropriate communication containers when necessary. The course focuses on all users dealing with I&C engineering, commissioning and service.

Prerequisites
Prior completion of SPPA-T3000 Engineering is strongly recommended, or equivalent experience.

Main Features
The following topics are representative of those covered in the course.
- CS3000
- AS3000
- Addfem POCO
- FM458
- Hopf Clock
- Buerk Clock
- Routers/ Firewalls
- OPC
- S7 AP Firmware Upgrade
- Scalance Firmware Upgrade.
SPPA-T3000 Engineering Maintenance / Administration

Training Objectives
Participants will learn how to differentiate between hardware and software problems, diagnose network problems, replace I/O and server modules, preserve system data utilizing backup concepts and learn how to troubleshoot the system using system logic.

<table>
<thead>
<tr>
<th>Course Code:</th>
<th>DCS300.3</th>
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<tbody>
<tr>
<td>Course Length:</td>
<td>4 days</td>
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<tr>
<td>Location:</td>
<td>Alpharetta, Georgia</td>
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</table>

Prerequisites
Prior completion of SPPA-T3000-Engineering I is recommended.

Main Features
- Network Diagnosis
- Client Diagnosis
- Shutdown and Reboot
- Backup and Restore
- Archive Management
- I/O Diagnosis and Replacement and Troubleshooting
- Process Value Simulation and Optimization
- Using the System Maintenance Manual
- Server HW Components Diagnosis and Replacement
- Practical Exercises

Gas Turbine / Steam Turbine Preventive Maintenance

Training Objectives
Course is designed to give operation and maintenance personnel the concepts of preventive maintenance, routine inspections, and site equipment specific preventive maintenance recommendations of the SIEMENS Turbines and their associated systems.

<table>
<thead>
<tr>
<th>Course Code:</th>
<th>MNT201.1, MNT 202.1</th>
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<tbody>
<tr>
<td>Course Length:</td>
<td>5 days</td>
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<tr>
<td>Location:</td>
<td>Customer Site</td>
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</table>

Main Features
- System Preventive Maintenance
- System function overview
- Identify equipment requiring preventive maintenance
- Periodicity guidelines
- Exercise:
  - Gathering component data
  - Vendor recommended maintenance
  - Developing site specific maintenance program
- Administration
- Service Bulletins
- Technical Advisories
- Trending parameters
- Maintenance records
- Equipment history

Add-on:
- Course Code: SER301.2
- Development of Planned Maintenance System (CMMS)
**Maintenance Personnel**

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**Instrumentation and Control Training**

**Training Objectives**

The Instrumentation and Control (I&C) training course is designed to provide an understanding of instrumentation and control systems and the theory behind the equipment operation. The training will enhance the plant operators or technicians understanding of I&C related to operating power generation equipment. This training will prepare an operator or technician to troubleshoot and correct minor instrumentation and controls faulted equipment using site available equipment and schematics.

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<tr>
<th>Course Code:</th>
<th>MNT501.1</th>
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<tr>
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<td>3 days</td>
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<tr>
<td>Location:</td>
<td>Customer Site</td>
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**Main Features**

- Distributed Control System
- DCS hardware overview
- Walk-down system including all cabinets and cabinet hardware
- Field devices through to ET200 and hardware proxy
- Test Instrumentation
- Fluke Calibration System
- Hart Communication protocols and Smart Transmitters
- Field Devices
- Thermocouples
- Pressure and Differential Transmitters
- Positioners
- Site specific Training
- Use of plant’s I&C schematics, P&ID’s and DCS drawings to troubleshoot and correct I&C malfunctions.
- DCS troubleshooting from ASD alarms to field devices
- Hands-on portable trainer is used to calibrate and troubleshoot thermocouple, pressure transmitter and pressure switch instruments.
Long Term Training Program

Introduction
Many customers have found that additional training is required beyond the training received during plant commissioning. This training often requires planning well in advance to ensure the training budget is available. The Long Term Training Program was created to provide power plants with an annual training program to support plant operation beyond commissioning. This training is set up for either a 3 year or 5 year option. This training normally consists of some combination of On-Site Instructor Support and Advanced Simulator training.

On-Site Instructor Support
The On-Site Instructor Support program will allow to have an instructor available on-site to provide the assistance to your operators and/or technicians. Although there are many structured courses available, our On-site Instructor Support can take on a whole new perspective. The instructor can discuss just about anything concerning the equipment, the systems, the controls logic or aspects of plant operations in order to expand the knowledge and abilities of your operators.

Additionally, as part of the Long Term Training Program, other training can be substituted for the On-site Instructor Support.
Possible courses for substitution are refresher training, I & C training or training of new hires with the approval of the Siemens Training Manager.

Advanced Simulator Training

The Advanced Power Plant Control Room Simulator course is designed to familiarize control room operators with the various troubleshooting techniques available in the SPPA-T3000™ Control System as it functions to control a power plant.

A unique feature of this course is flexibility. During the opening discussions, each operator is evaluated to determine his or her level of experience and knowledge. The course is then adapted to challenge each and every operator as he or she operates the simulated power plant through its daily routine. Real world plant problems, based on actual plant history, are also introduced into the training to determine the troubleshooting levels of the individual and help improve their capabilities.

The long term training plan will typically offer 2, 3, 4 or 5 sessions of simulator training, with 2 students in each session.

Like the On-Site Instructor Support, other courses can be substituted for one of these sessions. Possible courses for substitution are Basic Simulator, Simulator for I&C Technicians or Advanced Control Room Operator Applications with the approval of the Siemens Training Manager.
Executive Overview

Training Objectives
The Executive Overview seminar is one or two managers with an instructor away from the distraction of daily operations. The course will cover all Siemens installed equipment from both a familiarization and operations standpoint. Additionally, a broad overview of the control system is presented emphasizing trends, reports and alarm displays.

<table>
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<tr>
<th>Course Code:</th>
<th>SEM100.1</th>
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<tr>
<td>Course Length:</td>
<td>3 days</td>
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<tr>
<td>Location:</td>
<td>Orlando, Florida</td>
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</tbody>
</table>

Main Features
- Course covers all Siemens equipment using site specific training manuals and documentation.
- Course will also include use of a simulator to present the Control System, including operations, trends, and reports.
- Actual course content will be customized to the customer’s needs.
Additional Courses and Services

Gas Turbine Maintenance Awareness & Borescope Training

**Training Objectives**

The Gas Turbine Maintenance Awareness and Borescope Training course is designed to provide personnel with a general knowledge of the scope of work involved in scheduled turbine maintenance inspections, provide in depth knowledge of the turbine component parts and the associated periodic maintenance on the turbine unit, as well as provide an introduction to using a borescope in order to perform internal inspections.

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<tr>
<th>Course Code:</th>
<th>MNT301.1</th>
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<tbody>
<tr>
<td>Course Length:</td>
<td>5 days,</td>
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<tr>
<td>Location:</td>
<td>Houston, Texas</td>
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</table>

**Main Features**

- Gas Turbine
- Detailed Gas Turbine Construction
- Individual Component Descriptions including hands-on walk-throughs on a training Gas Turbine.
- Recommended Routine Component Maintenance
- Suggested Periodic Maintenance Intervals
- Equivalent Hour and Equivalent Starts Based Maintenance and Inspections.
- Minor Combustor Inspection with Borescope
- Major Combustor Inspection
- Hot Gas Path Inspection
- Major Inspection
- Discussion of various applicable Service Bulletins, Product Improvement Bulletins and Technical Advisories.
- Hands-on training of the Borescope on the training gas turbine.
Additional Courses and Services

Operating Process and Procedures Development

Service Objectives
Provide plant technicians with a consistent set of procedures that will serve as a useful tool that enhances their ability to perform functions vital to the safe and efficient operation of a power plant.

Course Code: SER301.3
Location: Customer Site

Main Features
- Expertly generated integrated plant operating procedures
- Key elements used in the preparation of detailed operating procedures are:
  - Program objectives and philosophies
  - Procedure format (Customer specified or Siemens recommended)
  - Utilization of a technical writing and style guide
  - Review and approval process
  - Defined program responsibilities
Plant Operator Qualification Program Development

Training Objectives

Qualification Program provides a comprehensive, systematic training program to maximize the development of our customers’ operations staff. The scope of the program is modified to fit the needs and experience level of the participants.

Main Features

- Provide training and introduction to plant documentation to establish a baseline knowledge.
- Validate knowledge level and understanding by conducting check outs. (Sign-offs at 3 levels)
- Knowledge level
- Practical factors
- Qualification
- Hands on training application and observation during "Under Instruction" watch-standing.

All Additional Service programs can be tailored to meet each site’s individual needs. These programs require a large amount of coordination between Site Operational Management and Orlando Training Group support to make programs successful.

The courses in this document are provided as an overview of the courses offered by the Siemens Plant Operations Support and Training group, Orlando FL. Additional courses are available, or can be created for your specific plant or situational need.

For complete course descriptions or a complete listing of courses, please contact:

Email: omtraining.energy@siemens.com