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HOT PLATE HOLE REPAIR – PERMANENT

1. Use cutting torch or arc gouge to remove damaged area. Ensure rounded corners on hole cut out (Fig. 1A).
2. Bevel hot plate and new *original thickness* plate 30° for flush installation (Fig. 1B).

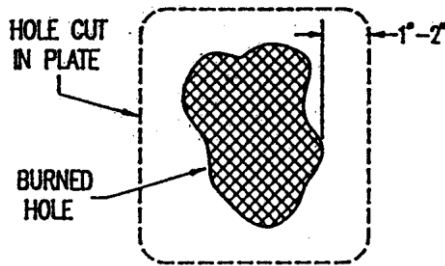


Figure 1A

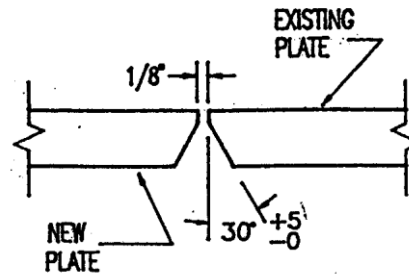


Figure 1B

3. Run root weld using E7018 rod making sure full penetration is achieved.
4. Clean and dye-check root weld.
5. Finish welding with E7018 rod, using stringer beads only. Peen intermediate layers to prevent cracking due to shrinkage. No peening should be done on the root or surface layer of the weld or the base metal at the edges of the weld. Grind surface smooth.
6. Ensure there are no undercuts in weld.
7. Add slag retainers onto the new plate. Original equipment 3/8" wall slag cups are recommended for permanent repair. Fasten the retainers to the plate using a 1/4" fillet weld on the entire outside and ends of the retainer.