HOT PLATE HOLE REPAIR – TEMPORARY

If a hole is burned or arced in the hot plate, a temporary repair can be made to maintain operation until a scheduled shut down.

1. Use arc gouge or cutting torch to remove damaged plate material. A minimum of 1” of plate material all around the hole should be removed (Fig. 1). Corners of the cut out area should be rounded. Inspect the cutout to be sure original thickness in the hot plate exists.

![Figure 1](image1.png)

2. Fillet weld an original thickness patch plate over the cutout maintaining a maximum of 1/4” overlap between the plates (Figs. 2A & 2B). Plate can be installed on hot side or cooling side, whichever is most convenient.

![Figure 2A](image2a.png)  
![Figure 2B](image2b.png)

3. Reinstall slag retainers. If 3/8” wall original equipment retainers are not available, use 2” or 2 1/2” diameter Schedule 160 or XXS carbon steel pipe cut to 1” lengths. Fasten the retainers to the plate using a 1/4” fillet weld on the entire outside and ends of the retainer.