



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.

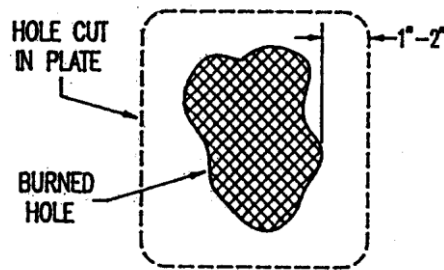


Figure 1

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.

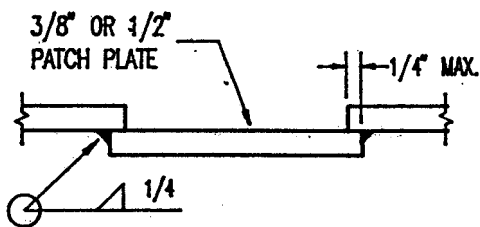


Figure 2A

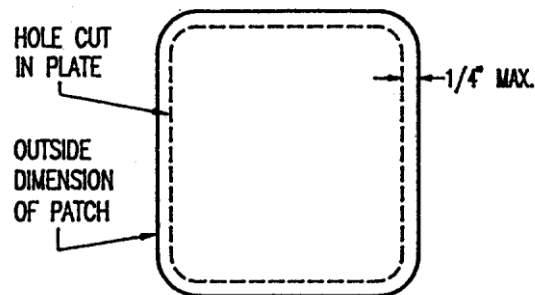


Figure 2B

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.