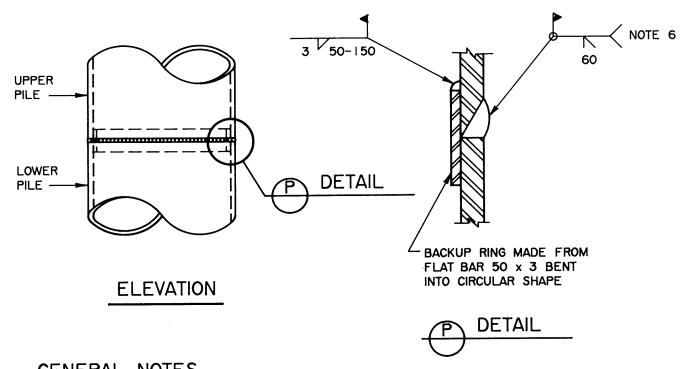
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## GENERAL NOTES

- DIMENSIONS ARE GIVEN IN mm. DETAILS ARE NOT TO SCALE
- PILING AND BACKUP RINGS WILL BE SUPPLIED BY THE DEPARTMENT.

## REQUIREMENTS AND PROCEDURE FOR SPLICING PIPE PILES

- I. WELDERS SHALL HOLD A CURRENT ALBERTA SECOND CLASS CERTIFICATE OF PROFICIENCY.
- 2. THE LOWER PILE SHALL BE TRIMMED TRUE AND SQUARE.
- 3. THE BEVEL ON THE UPPER PILE SHALL BE FLAME CUT USING A MECHANICAL PIPE BEVELLING MACHINE.
- 4. THE BACKUP PLATE SHALL BE WELDED TO THE UPPER PILE.
- 5. THE UPPER PILE SHALL BE POSITIONED WITH THE BACKUP RING FITTED INTO THE LOWER PILE.
- 6. SPLICE WELD SHALL PENETRATE BACKUP RING. TWO PASSES ARE REQUIRED IF THE PILE WALL IS GREATER THAN 8 mm. GRIND WELD SMOOTH IF THE SPLICE IS LOCATED ABOVE GROUND LEVEL.
- 7. WHEN THE AIR TEMPERATURE IS BELOW OOC, ALL MATERIAL TO BE WELDED SHALL BE PREHEATED TO 100°C FOR A DISTANCE OF 80 mm BEYOND THE WELD AND SHALL BE SHELTERED FROM THE WIND.
- 8. WHEN THE AIR TEMPERATURE IS BELOW -20°C, WELDING WILL NOT BE PERMITTED SUITABLE HOARDING, APPROVED BY THE ENGINEER, IS PROVIDED.

SUPERSEDED BY 5-1414-01 DEAFTING STANDARDS PAGE: 3.7

Aborta Transportation and Utilities Bridge Engineering Branch

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NO	DATE	DATE REVISIONS		BY	PIP	E PILE SPLICE				
		WN IK	DATE 87-03-09	APPROVED EXECUTIVE DIRECTOR	m	SIGNATURE	DATE My 8/87	PAGE 3.15	S-1414-8	

PLOTTED MAY 06, 1987 QSA3:[150,12]S1414X87 .DGN:1