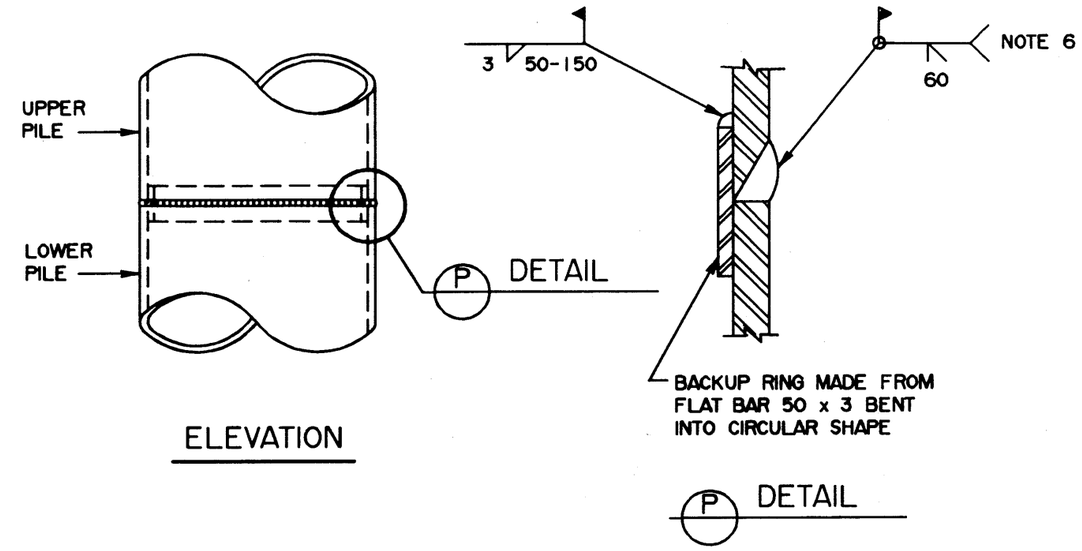

ELEVATION

GENERAL NOTES

- DIMENSIONS ARE GIVEN IN mm. DETAILS ARE NOT TO SCALE

2

REQUIREMENTS AND PROCEDURE FOR SPLICING PIPE PILES

1. 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 0°C, 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 UNLESS SUITABLE HOARDING, APPROVED BY THE ENGINEER, IS PROVIDED.

SUPERSEDED BY S-1414-87 Rev 3 99-03-29 on sheet 5

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DRAFTING STANDARDS PAGE: 3.7

NO	DATE	REVISIONS	BY
4			
3			
2	94-11-30	GENERAL NOTES	RJR
1	87-03-09	REDRAWN FROM S-1414	DHQ

Alberta TRANSPORTATION AND UTILITIES
BRIDGE ENGINEERING BRANCH

STANDARD
PIPE PILE SPLICE

DESIGNED	DRAWN	DATE	APPROVED	SIGNATURE	DATE	PAGE	DRAWING
DHQ	MIK	87-03-09	EXECUTIVE DIRECTOR		May 6/87	3.15	S-1414-87

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