



**GENERAL NOTES**

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

2

**REQUIREMENTS AND PROCEDURE FOR SPLICING PIPE PILES**

4

1. FIELD WELDING SHALL BE IN ACCORDANCE WITH SECTION 13.4
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.

**SUPERSEDED BY  
S-1414-87 REVISION 5**

DRAFTING STANDARDS PAGE: 3.7

4	2001-06-19	GENERAL NOTES	AW
3	99-03-29	BEB CHANGED TO TSB	RY
2	94-11-30	GENERAL NOTES	RJR
1	87-03-09	REDRAWN FROM S-1414	DHQ
NO	DATE	REVISIONS	BY

**Alberta** TRANSPORTATION AND UTILITIES  
TECHNICAL STANDARDS BRANCH

**STANDARD  
PIPE PILE SPLICE**

DESIGNED DHQ	DRAWN MIK	DATE 87-03-09	APPROVED EXECUTIVE DIRECTOR	SIGNATURE <i>[Signature]</i>	DATE May 8/87	PAGE 3.15	DRAWING S-1414-87
-----------------	--------------	------------------	--------------------------------	---------------------------------	------------------	--------------	----------------------