



NOTE:

GRIND WELD SMOOTH IF SPLICE WILL BE LOCATED ABOVE GROUND

BACKUP RING

SUPERSEDED
87-05-00

NOTES :

1. ALL WELDERS SHALL HOLD A CURRENT ALBERTA SECOND CLASS CERTIFICATE OF PROFICIENCY.
2. TRIM DRIVEN PILE SO THAT TOP IS ROUND AND LEVEL.
3. PREPARE BEVEL ON END OF ADDED PILE BY FLAME CUTTING Δ WITH A MECHANICAL PIPE BEVELLING MACHINE.
4. WELD BACKUP RING INSIDE ADDED PILE.
5. PLACE ADDED PILE ON TOP OF DRIVEN PILE WITH BACKUP RING FITTED INTO THE DRIVEN PILE.
6. BUTT WELD THE TWO PILES TOGETHER. WELD IS TO PENETRATE INTO BACKUP RING. IF THE PIPE WALL IS GREATER THAN 8mm THICK, TWO PASSES ARE TO BE USED.
7. WHEN THE AIR TEMPERATURE IS BELOW 0°C ALL MATERIAL TO BE WELDED SHALL BE PREHEATED TO 95°C AND SHELTERED FROM WIND, THE MATERIAL SHALL BE PREHEATED TO A DISTANCE 80mm BEYOND THE WELD.
8. WHEN THE AIR TEMPERATURE IS BELOW -20°C WELDING WILL NOT BE PERMITTED UNLESS SUITABLE HOARDING IS PROVIDED AND APPROVED BY THE ENGINEER.
9. ALL DIMENSIONS ARE GIVEN IN mm.

METRIC

Δ NOTE REVISED - 82 05 19 J.C.

APPROVED: *[Signature]*
CHIEF BRIDGE ENGINEER

Alberta		TRANSPORTATION BRIDGE BRANCH (2)	
STANDARD STEEL PIPE PILE SPLICE			
BY: T.S.	DATE: 77-11-15	DWG. No.	S-1414

SUPERSEDED
3-1414-87
ON SHEET (3)

3.7

(2)