



SPLICE DETAILS

PILE DESIGNATION	SPLICE PLATE DIMENSIONS	
	PLATE A (WEB)	PLATE B (FLANGE)
HP 250 x 62	140 x 10 x 140	170 x 10 x 170
HP 310 x 94	175 x 12 x 175	200 x 12 x 200
HP 360 x 132	200 x 16 x 200	250 x 16 x 250

GENERAL NOTES

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

REQUIREMENTS AND PROCEDURE FOR SPLICING H-PILES

1. WELDERS SHALL HOLD A CURRENT ALBERTA SECOND CLASS CERTIFICATE OF PROFICIENCY.
2. PILE ENDS TO BE SPLICED SHALL BE FLAME CUT USING A STEEL GUIDE TO OBTAIN A SQUARE AND EVEN CUT. BEVEL CUTS SHALL BE MADE AT 45°.
3. SPLICE PLATES A & B SHALL BE WELDED TO THE UPPER PILE BEFORE POSITIONING IT.
4. THE UPPER PILE SHALL BE POSITIONED ON AND THE SPLICE PLATES WELDED TO THE LOWER PILE; BUTT WELDS SHALL THEN BE MADE.
5. 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.
6. WHEN THE AIR TEMPERATURE IS BELOW -20°C, WELDING WILL NOT BE PERMITTED UNLESS SUITABLE HOARDING, APPROVED BY THE ENGINEER, IS PROVIDED.

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**SUPERSEDED**  
 BY S-1415-87 REV 2  
 ON SHEET 4

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1	87-03-11	REDRAWN FROM S-1415	DHQ
NO	DATE	REVISIONS	BY

**Alberta** TRANSPORTATION AND UTILITIES  
 BRIDGE ENGINEERING BRANCH

STANDARD  
 H-PILE SPLICE

DESIGNED DHQ	DRAWN MIK	DATE 87-03-11	APPROVED EXECUTIVE DIRECTOR	SIGNATURE <i>[Signature]</i>	DATE May 87	PAGE 3.13	DRAWING S-1415-87
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