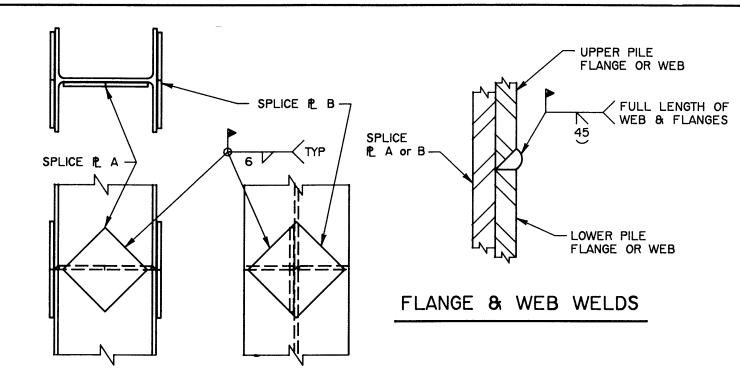
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## SPLICE DETAILS

PILE	SPLICE PLATE DIMENSIONS					
DESIGNATION	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

- I. 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 LOWE PILE; BUTT WELDS SHALL THEN BE MADE.
- 5. WHEN THE AIR TEMPERATURE IS BELOW O°C, ALL MATERIAL TO BE WELDED PREHEATED TO 100°C FOR A DISTANCE OF 80 mm BEYOND THE WELD AND 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.

DRAFTING STANDARDS PAGE: 3.6

<u>A</u>		-		·····	-	Albaria	TRANSPO BRIDGE	RTATION ENGINEE		
						STANDARD H-PILE SPLICE				
$\triangle$	87-03-1	RE	DRAWN FROM	S-1415	DHQ					
NO	DATE	DATE REV		REVISIONS BY	П	-LIFE	SPLI	CE		
1		AWN 11K	DATE 87-03-11	APPROVED EXECUTIVE DIRECTOR	m	SIGNATURE	DATE My 4/87	PAGE 3.13	S-I	RAWING 415-87

PLOTTED MAY 06, 1987 QSA3:[150,12]\$1415X87 .DGN;