



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.
- ② • STEEL SHALL CONFORM TO ASTM A36 OR CSA G40.21M 300W.

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.

DRAFTING STANDARDS PAGE: 3.6

SUPERSEDED
 BY 5-1415-87 REV 3
 ON SHEET 5
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TRANSPORTATION AND UTILITIES BRIDGE ENGINEERING BRANCH			
STANDARD H-PILE SPlice			
NO	DATE	REVISIONS	BY
④			
③			
②	94-11-30	GENERAL NOTES	RJR
①	87-03-11	REDRAWN FROM S-1415	DHQ
DESIGNED	DRAWN	DATE	APPROVED
DHQ	MIK	87-03-11	EXECUTIVE DIRECTOR
SIGNATURE		DATE	PAGE
<i>[Signature]</i>		11/2/87	3.13
DRAWING		S-1415-87	