



SPLICE DETAILS

FLANGE & WEB WELDS

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.

SUPERSEDED

⑤ DRAFTING STANDARDS PAGE: 3.6

		TRANSPORTATION AND UTILITIES TECHNICAL STANDARDS BRANCH	
		STANDARD H-PILE SPLICE	
NO	DATE	REVISIONS	BY
DESIGNED	DRAWN	DATE	APPROVED
DHQ	MIK	87-03-11	EXECUTIVE DIRECTOR
		SIGNATURE	DATE
		<i>[Signature]</i>	11/9/87
		PAGE	DRAWING
		3.13	S-1415-87