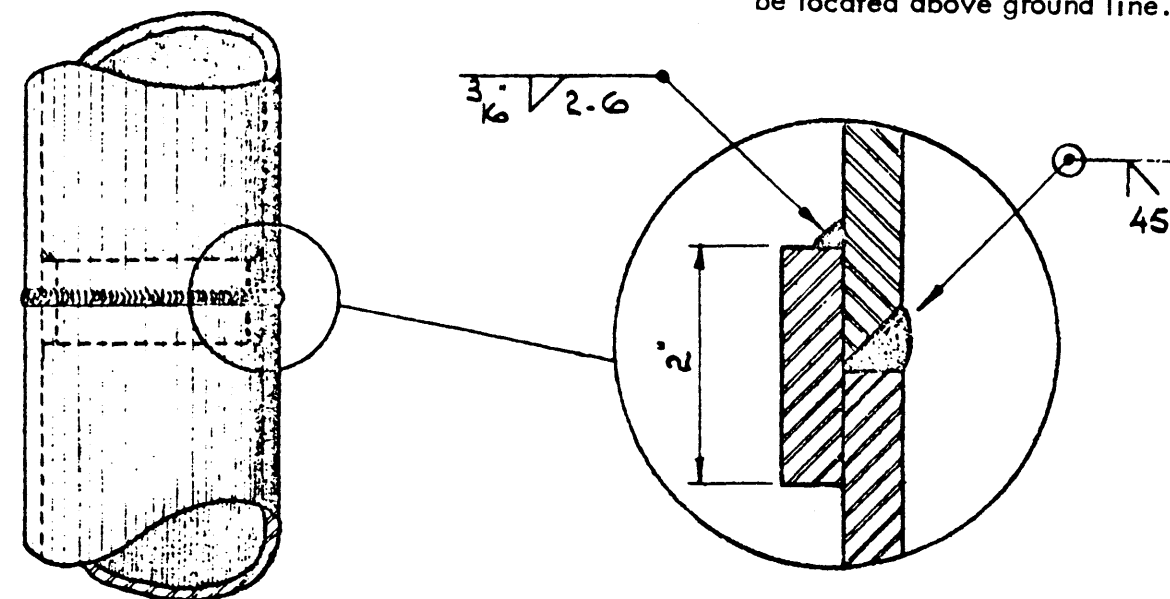
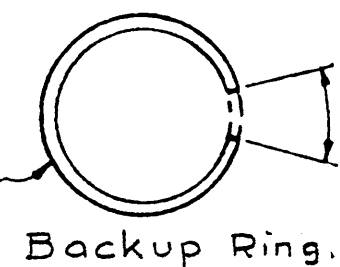


NOTE: Grind weld smooth if splice will be located above ground line.



2" long section of pipe pile.



Remove section to fit ring inside pile.

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. All piles to be flame cut using a steel yoke to secure a square and even cut.
4. Prepare bevel on end of added pile by flame cutting.
5. Weld backup ring inside added pile.
6. Place added pile on top of driven pile with the backup ring fitted into the driven pile.
7. Butt weld the two piles together. Weld is to penetrate into backup ring. If the pipe wall is greater than $\frac{5}{16}$ thick, two passes are to be used.
8. When the air temperature is below 32°F all material to be welded shall be preheated to 200°F and sheltered from wind. The material shall be preheated to a distance 3" beyond the weld.
9. When the air temperature is below 0°F welding will not be permitted unless suitable hoarding is provided and approved by the Engineer.

STANDARD STEEL PIPE PILE (2)

N.T.S.

REVISED MARCH 29/76

SPLICE

A T & U SEMI-ACTIVE RECORDS CENTRE

Fig. S-827.



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