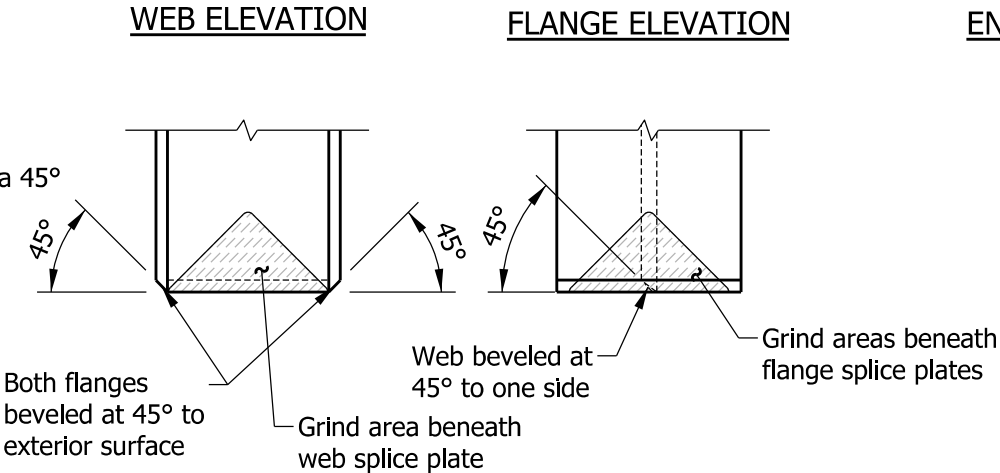


PROCEDURE FOR SPLICING PARTIALLY DRIVEN PILING

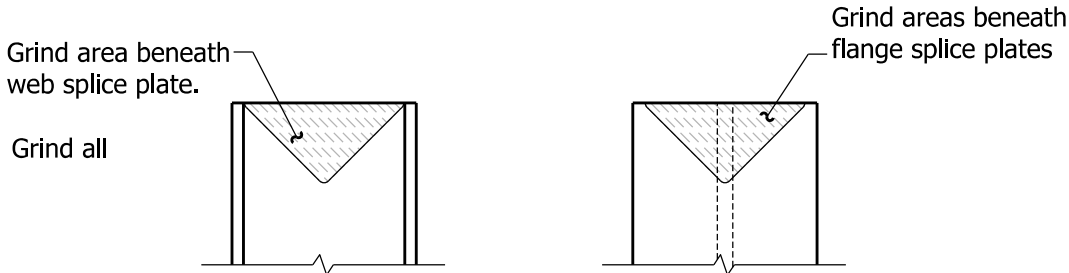
1. Upper Pile Section

Prepare outside of both flanges and one side of web by beveling to a 45° angle. Prepare all surfaces to be welded by grinding.



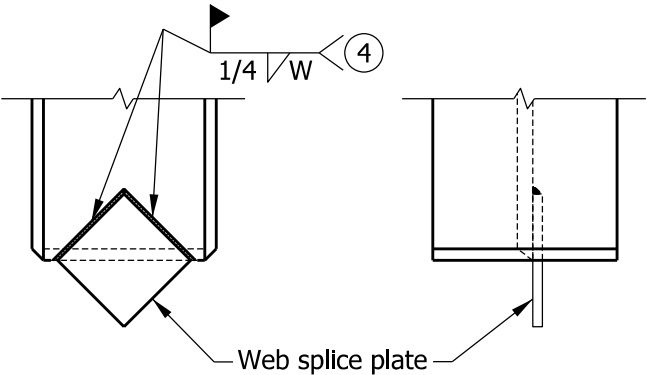
2. Lower Pile Section

Prepare top of pile by restoring it to its original cross section. Grind all surfaces to be welded, extending 1/2" beyond weld area(s).



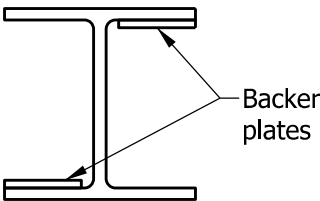
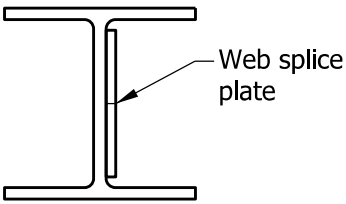
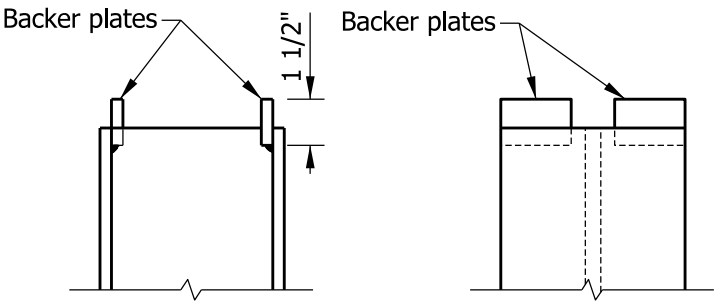
3. Upper Pile Section

Fillet weld web splice plate to upper pile section at two locations.



4. Lower Pile Section

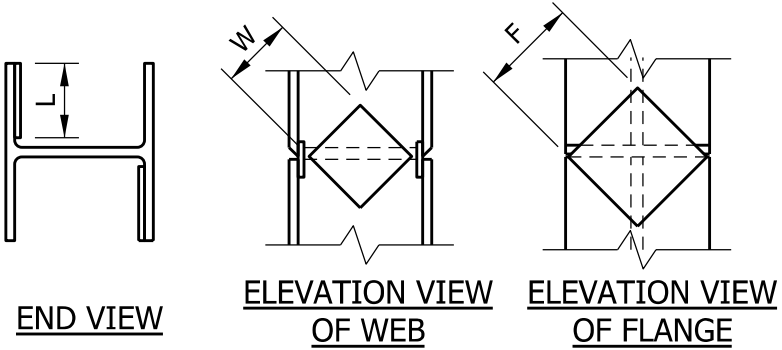
Tack weld two backer plates to inside of flange.



NOTES

- Steel H piling may be spliced in a horizontal position prior to driving, using splice plates and web and flange welds as shown.
- Two flange splice plates, one web splice plate, and four backer plates will be required per splice.
- All fillet welds shall be single pass.
- See table for splice plate dimensions W and F.

SPLICE PLATE AND BACKER PLATE DIMENSIONS



H-PILE SIZE	HP 10	HP 12	HP 14
Flange Splice Plate, F	7"	8 1/4"	10 1/4"
Web Splice Plate, W	5 3/8"	6 3/4"	8"
Backer Plate Length, L	4 1/8"	5"	6 1/4"

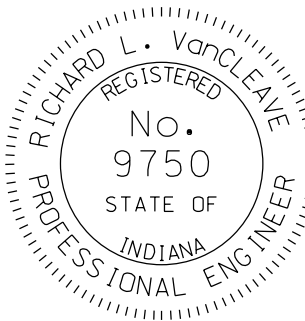
NOTE: Splice plate thickness = 3/8"  
Backer plate thickness = 1/4"

INDIANA DEPARTMENT OF TRANSPORTATION

STEEL H-PILE  
SPLICE

SEPTEMBER 2012

STANDARD DRAWING NO. E 701-BPIL-03



/s/ Richard L. VanCleave 09/04/12

SUPERVISOR, ROADWAY STANDARDS DATE

/s/ Mark A. Miller 09/04/12

CHIEF ENGINEER DATE

Procedure continued on Standard Drawing E 701-BPIL-04.