Burn four equally spaced slots in lower section before inserting extension.

Welding Sequence:
- Completion of Sections 1, 2, 3 & 4 constitutes one pass.

Welding Detail:
- Weld ring spacer or chill ring
- 1/4" to 3/8"
- 30° to 45°
- Weld shall be ground flush with exterior pile face

For Fluted Pipe
- B-U1a
- Flute
- 1/2" (typ.)
- 6" min. len.

For Rounded Pipe
- B-U1a
- Weld ring spacer or chill ring

Indiana Department of Transportation
Splicing Pipe Piles in Field
September 2010

Standard Drawing No. E 701-BPIL-04

/s/ Richard C VanCleave 09/01/10
Design Standards Engineer Date

/s/ Mark A. Miller 09/01/10
Chief Highway Engineer Date