PROCEDURE FOR SPLICING PARTIALLY DRIVEN PILING

1. Upper Section
   Prepare outside of both flanges and one side of web by beveling to a 45 deg angle. Grind all surfaces to be welded.

2. Lower Section
   Prepare top of pile to be extended by squaring all surfaces. Grind all surfaces to be welded, extending 1/2" beyond weld area(s).

3. Upper Section
   Fillet weld web splice plate to upper section at 2 locations. See Detail A

4. Lower Section
   Tack weld two backer plates to inside of flange.

5. Combine Sections
   Lift and hold upper section into place, maintaining 1/4" gap between upper and lower pile sections by using the remaining two backer plates as a guide. Plumb the pile. Tack weld the untacked side of the two backer plates to the inside upper flange. Remove the backer plate spacers and tack weld them to the inside flange portion of the upper and lower sections of the pile. Fillet weld the remaining two sides of the web splice plate to the lower section.

6. Combined Section
   Complete Joint Penetration (CJP) weld the web. See Detail B

7. Combined Section
   Complete Joint Penetration (CJP) weld both flanges. Grind weld smooth with the pile.

8. Combined Section
   Fillet weld the flange splice plates to the flanges.

NOTES:
1. Steel H piling may be spliced in a horizontal position prior to driving using splice plates and web and flange penetration welds as shown below.
2. Use 3/8 in. thick square splice plates and 1/4 in. fillet welds. All fillet welds shall be single pass.
3. Use 1/4 in. thick backer plates.

SPLICE PLATE AND BACKER PLATE
DIMENSIONS AND PLACEMENT

SPLICE PLATE AND BACKER PLATE DIMENSIONS

<table>
<thead>
<tr>
<th>H-PILE SIZE</th>
<th>HP 10</th>
<th>HP 12</th>
<th>HP 14</th>
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</thead>
<tbody>
<tr>
<td>FLANGE, F</td>
<td>7&quot;</td>
<td>8 1/4&quot;</td>
<td>10 1/4&quot;</td>
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<tr>
<td>WEB, W</td>
<td>5 3/8&quot;</td>
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<td>8&quot;</td>
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<tr>
<td>LENGTH, L</td>
<td>4 1/8&quot;</td>
<td>5&quot;</td>
<td>6 1/4&quot;</td>
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</table>

INDIANA DEPARTMENT OF TRANSPORTATION

STEEL H-PILE SPLICE PROCEDURE
SEPTEMBER 2011

STANDARD DRAWING NO. E 701-BPIL-05

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