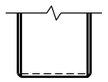
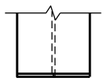
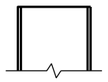
PROCEDURE FOR SPLICING PARTIALLY DRIVEN PILING

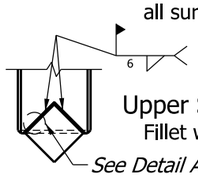
WEB VIEWS (this column) FLANGE VIEWS (this column)

1. 


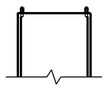
Upper Section
Prepare outside of both flanges and one side of web by beveling to a 45 deg angle. Grind all surfaces to be welded.

2. 

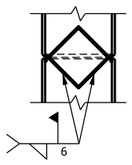
Lower Section
Prepare top of pile to be extended by squaring all surfaces. Grind all surfaces to be welded, extending 13mm beyond weld area(s).

3. 

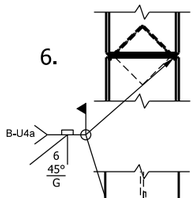
Upper Section
Fillet weld web splice plate to upper section at 2 locations.

4. 

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

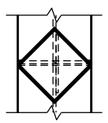
5. 

Combine Sections
Lift and hold upper section into place, maintaining 6mm 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.

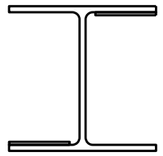
6. 

Combined Section
Complete Joint Penetration (CJP) weld the web.

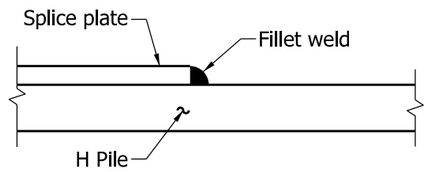
7. **Combined Section**
Complete Joint Penetration (CJP) weld both flanges. Grind weld smooth with the pile.

8. 

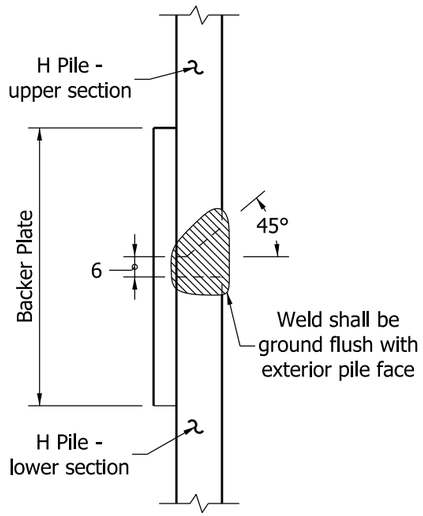
Combined Section
Fillet weld the flange splice plates to the flanges.



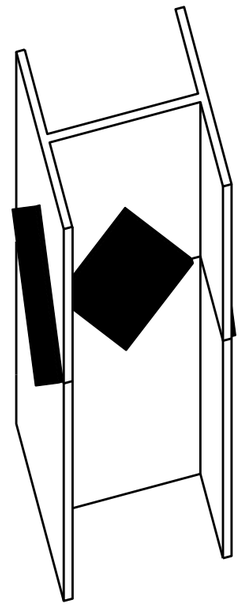
END VIEW



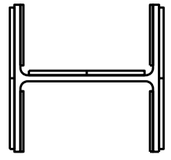
DETAIL A



DETAIL B



COMPLETED SPLICE ISOMETRIC
(backer plates not shown)

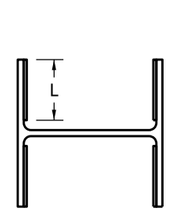


COMPLETED SPLICE END VIEW

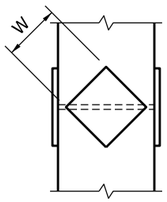
NOTES:

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 10mm thick square splice plates and 6mm fillet welds. All fillet welds shall be single pass.
3. Use 6mm thick backer plates.

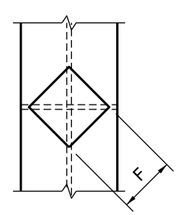
SPLICE PLATE AND BACKER PLATE DIMENSIONS AND PLACEMENT



END VIEW



WEB VIEW



FLANGE VIEW

SPLICE PLATE AND BACKER PLATE DIMENSIONS

H-PILE SIZE	HP 250	HP 310	HP 360
FLANGE, F	180	210	260
WEB, W	140	170	200
LENGTH, L	105	130	160

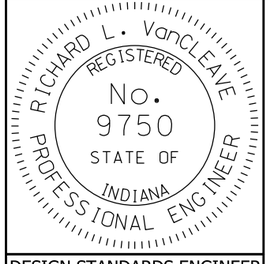
All Dimensions are in mm unless otherwise specified.

INDIANA DEPARTMENT OF TRANSPORTATION

STEEL H-PILE
SPLICE PROCEDURE

SEPTEMBER 2011

STANDARD DRAWING NO. 701-BPIL-05



DESIGN STANDARDS ENGINEER

/s/ Richard L. VanCleave 09/01/11
DESIGN STANDARDS ENGINEER DATE

/s/ Mark A. Miller 09/01/11
CHIEF HIGHWAY ENGINEER DATE