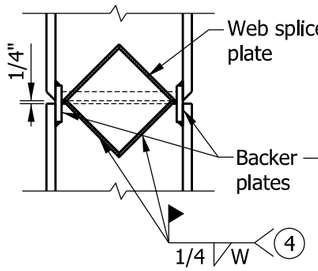
PROCEDURE FOR SPLICING PARTIALLY DRIVEN PILING (cont.)

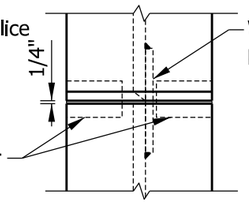
5. Combine Pile Sections

Lift and hold upper pile section into place, maintaining 1/4" gap between upper and lower pile sections by using the remaining two backer plates as a spacing 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.

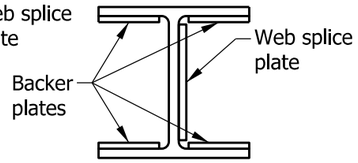
WEB ELEVATION



FLANGE ELEVATION

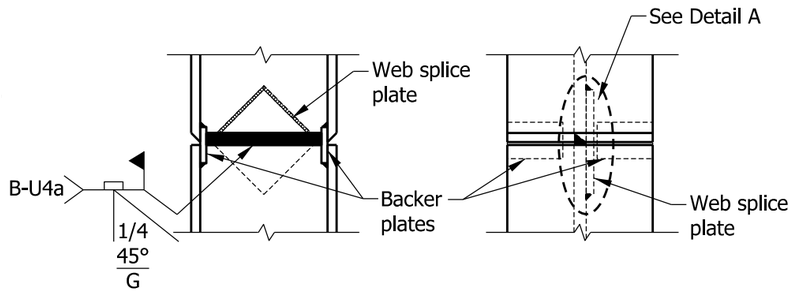


END VIEW



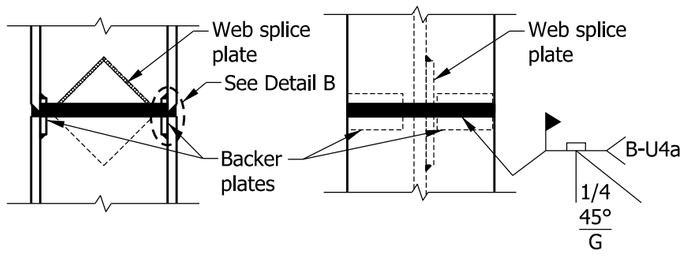
6. Combined Pile Section

Complete Joint Penetration (CJP) weld the web. See Detail A.



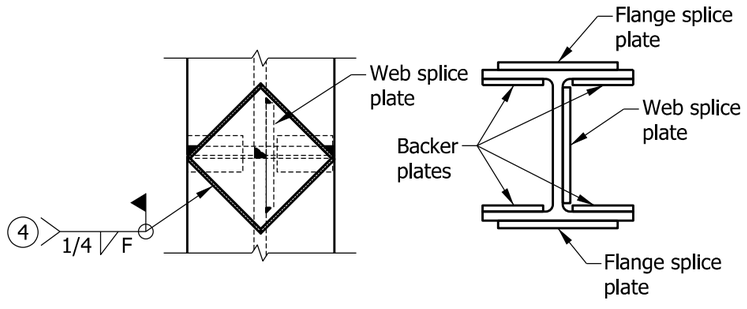
7. Combined Pile Section

Complete Joint Penetration (CJP) weld both flanges. Grind weld smooth with the pile exterior face. See Detail B.



8. Combined Pile Section

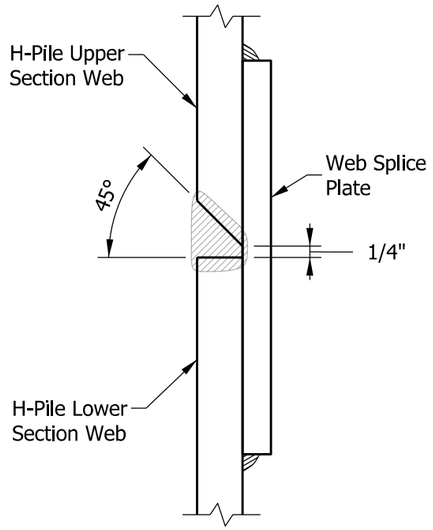
Fillet weld the flange splice plates to the flanges.



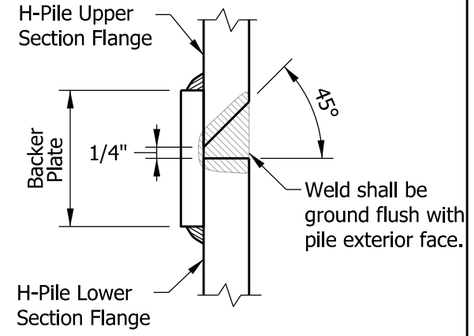
NOTES

1. Steel H piling may be spliced in a horizontal position prior to driving, using splice plates and web and flange welds as shown.
2. Two flange splice plates, one web splice plate, and four backer plates will be required per splice.
3. All fillet welds shall be single pass.

(4) See Standard Drawing E 701-BPIL-03 table for splice plate dimensions W and F.



DETAIL A



DETAIL B

INDIANA DEPARTMENT OF TRANSPORTATION

STEEL H-PILE
SPLICE
(CONTINUED)

SEPTEMBER 2012

STANDARD DRAWING NO. E 701-BPIL-04

RICHARD L. VanCLEAVE REGISTERED No. 9750 STATE OF INDIANA PROFESSIONAL ENGINEER

/s/ Richard L. Van Cleave 09/04/12
SUPERVISOR, ROADWAY STANDARDS DATE

/s/ Mark A. Miller 09/04/12
CHIEF ENGINEER DATE