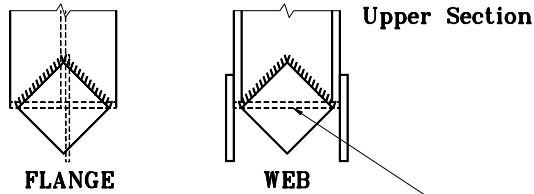
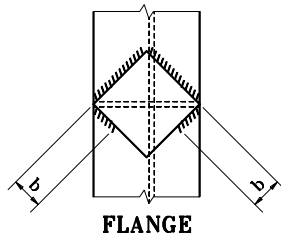


PROCEDURE FOR SPLICING PARTIALLY DRIVEN PILING

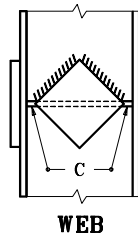


Prepare inside of both flanges one side of web, and weld on splice plates.

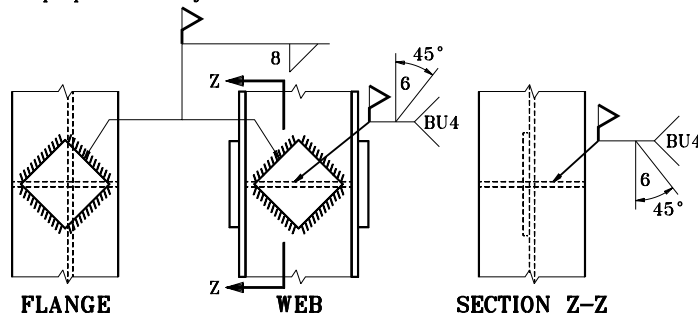
a.) Hold upper section in place with pile line, then plumb pile.



b.) Weld fillet for 50 mm on each outside corner of flange plates.



c.) Weld prepared butt joint for 40 mm at each end of the web.



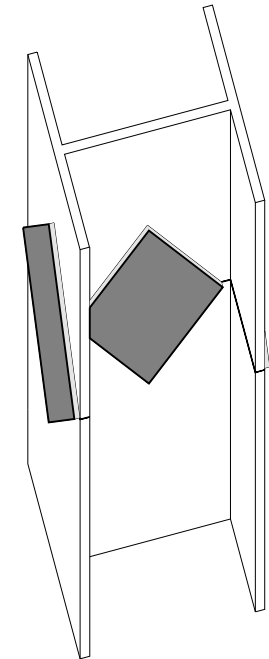
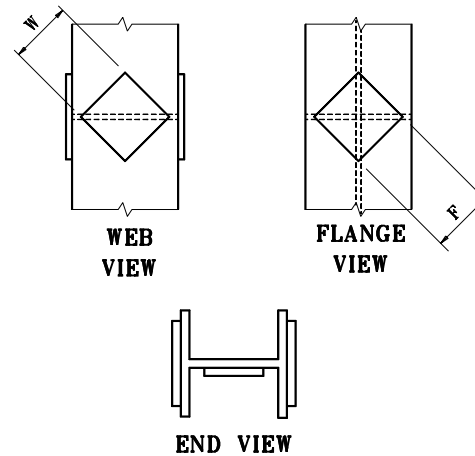
COMPLETED SPLICE

d.) Remove pile line and complete all welds.

PROCEDURE FOR SPLICING PILING BEFORE DRIVING

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. The welding sequence need not be followed provided the piling remains straight after welding.

SPLICE PLATE DIMENSIONS & PLACEMENT



COMPLETED SPLICE ISOMETRIC

All dimensions are in mm unless otherwise specified.

INDIANA DEPARTMENT OF TRANSPORTATION

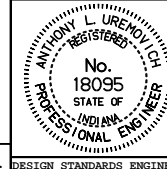
STEEL H-PILE SPLICE PROCEDURE

SEPTEMBER 1994

STANDARD DRAWING NO. 701-BPIL-05

10 mm Square Plates

PILE	200	250	310	360
F FLANGE	140	180	210	260
W WEB	110	140	170	200



/s/ Anthony L. Uremovich 9-30-94
DESIGN STANDARDS ENGINEER DATE

/s/ Donald W. Lucas 9-30-94
CHIEF HIGHWAY ENGINEER DATE

Source Sheet: C-1

DESIGN STANDARDS ENGINEER