

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.



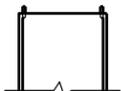
2. **Lower Section**
Prepare top of pile to be extended by squaring all surfaces. Grind all surfaces to be welded, extending 1/2" beyond weld area(s).



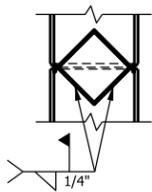
3. **Upper Section**
Fillet weld web splice plate to upper section at 2 locations.
See Detail A



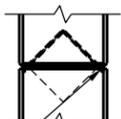
4. **Lower Section**
Tack weld two backer plates to inside of flange.



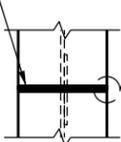
5. **Combine Sections**
Lift and hold upper section into place, maintaining 1/4" gap between upper and lower pile sections by using the remaining two backer plates as a guide. Plumb the pile. Tack weld the untacked side of the two backer plates to the inside upper flange. Remove the backer plate spacers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



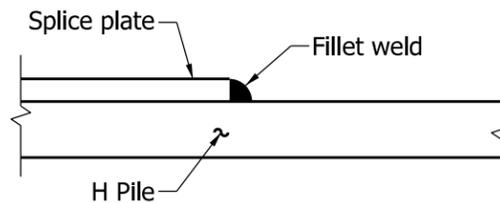
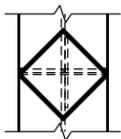
6. **Combined Section**
Complete Joint Penetration (CJP) weld the web.



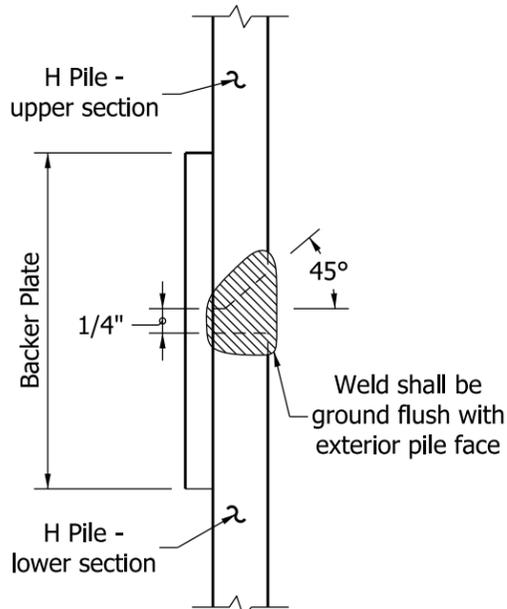
7. **Combined Section**
Complete Joint Penetration (CJP) weld both flanges.
Grind weld smooth with the pile.



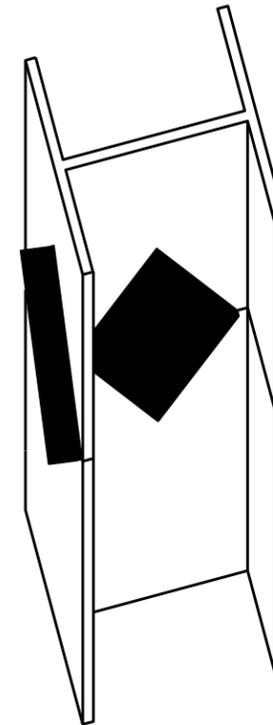
8. **Combined Section**
Fillet weld the flange splice plates to the flanges.



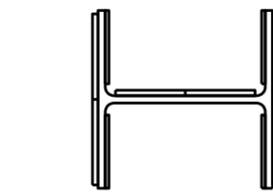
DETAIL A



DETAIL B



COMPLETED SPLICE ISOMETRIC (backer plates not shown)

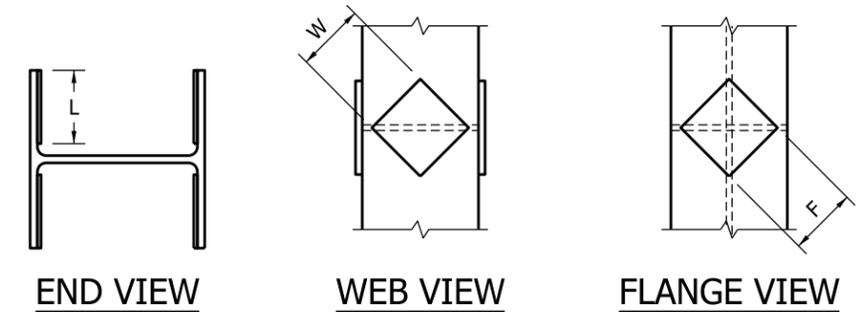


COMPLETED SPLICE END VIEW

NOTES:

- 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.
- Use 3/8 in. thick square splice plates and 1/4 in. fillet welds. All fillet welds shall be single pass.
- Use 1/4 in. thick backer plates.

SPLICE PLATE AND BACKER PLATE DIMENSIONS AND PLACEMENT



SPLICE PLATE AND BACKER PLATE DIMENSIONS

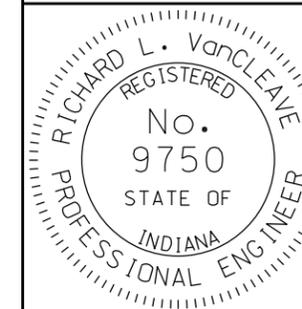
H-PILE SIZE	HP 10	HP 12	HP 14
FLANGE, F	7"	8 1/4"	10 1/4"
WEB, W	5 3/8"	6 3/4"	8"
LENGTH, L	4 1/8"	5"	6 1/4"

INDIANA DEPARTMENT OF TRANSPORTATION

STEEL H-PILE SPLICE PROCEDURE

SEPTEMBER 2011

STANDARD DRAWING NO. E 701-BPIL-05



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

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

DESIGN STANDARDS ENGINEER