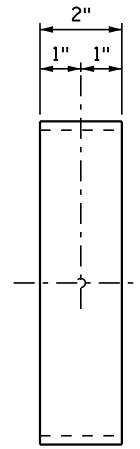
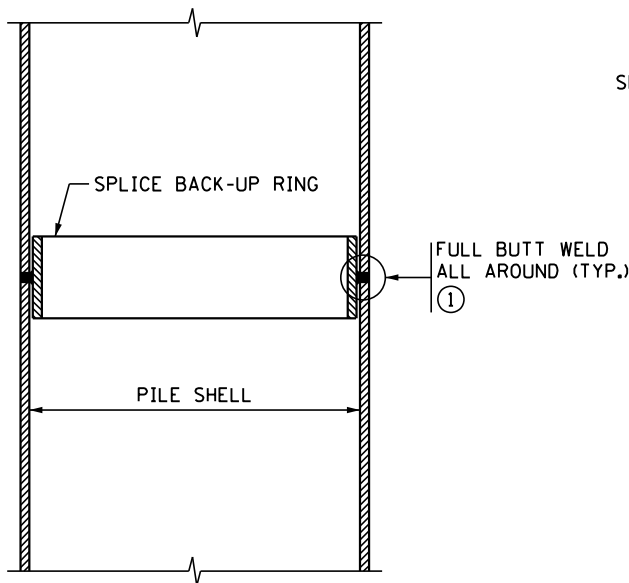


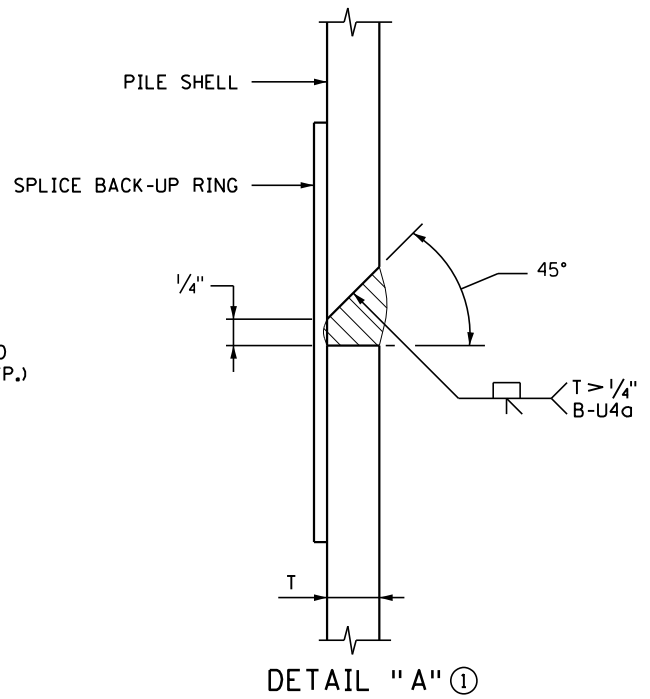
PLAN VIEW - SPLICE BACK-UP RING
PILE NOT SHOWN



SECTION B-B
PILE NOT SHOWN



SECTION A-A



DETAIL "A" ①

NOTES:

APPROVED COMMERCIAL PILE SPLICE BACK-UP RING MAY BE USED IN LIEU OF THE TYPE DETAILED, PROVIDED THAT 1/4" ROOT IS MAINTAINED. BACK-UP RING SHALL HAVE A TIGHT FIT.

WELDING ELECTRODES SHALL BE CELLULOSIC TYPE ELECTRODES E-6010 OR E-6011.

ELECTRODES WHICH HAVE BECOME WET, SOILED OR DAMAGED SHALL NOT BE USED.

WELDING SHALL NOT BE DONE WHEN THE AMBIENT TEMPERATURE IS LOWER THAN 0° F. OR WHEN THE PILE IS WET OR EXPOSED TO FALLING RAIN OR SNOW. WHEN THE PILE METAL TEMPERATURE IS BELOW 32° F., THE PILE METAL IN THE AREA OF THE WELD SHALL BE HEATED TO A MINIMUM TEMPERATURE OF 70° F. AND MAINTAINED AT THIS TEMPERATURE DURING WELDING.

① FOR PILE SHELL THICKNESSES GREATER THAN 1/4", USE A B-U4a WELD CONFIGURATION. SEE DETAIL "A".

APPROVED: NOVEMBER 22, 2002

Samuel J. Hanson
STATE BRIDGE ENGINEER

STATE OF MINNESOTA
DEPARTMENT OF TRANSPORTATION

PILE SPLICE
(CAST-IN-PLACE CONCRETE PILES)

REVISION:
11-06-2013

DETAIL NO.

B201