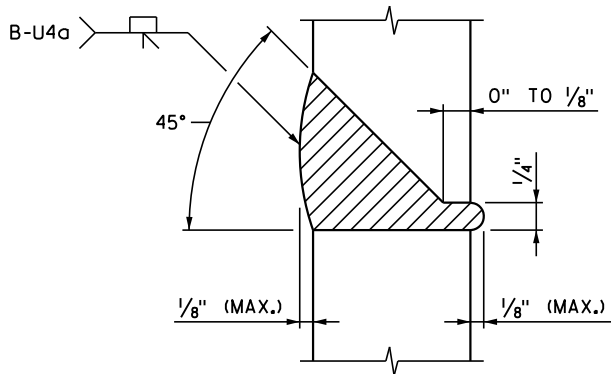


SECTION AT SPLICE



SECTION A-A

100% BUTT WELDED PILE SPLICE

NOTES:

CELLULOSIC TYPE ELECTRODES E-6010 OR E-6011 SHALL BE USED FOR 100% BUTT WELDED SPLICES.

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.

APPROVED: NOVEMBER 22, 2002

Samuel J. Wagoner
STATE BRIDGE ENGINEER

STATE OF MINNESOTA
DEPARTMENT OF TRANSPORTATION

PILE SPLICE
(STEEL H BEARING PILES 10" TO 14")

REVISION:
11-06-2013

DETAIL NO.

B202