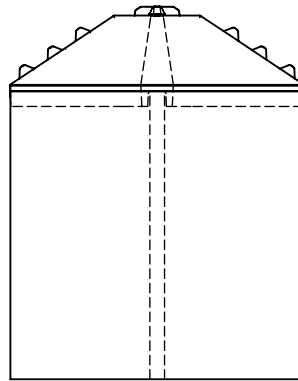
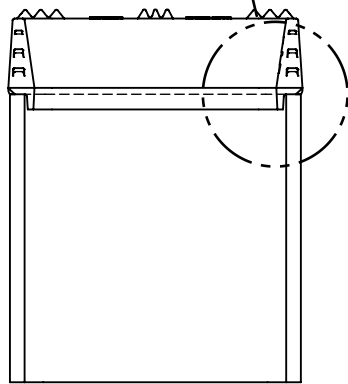


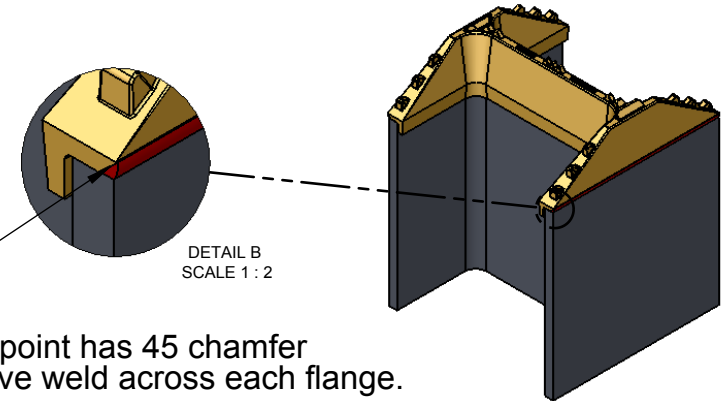
**DETAIL A  
SCALE 1:2**



DESCRIPTION	WELD
HP 14 X 117	7/16"
HP 14 X 102	7/16"
HP 14 X 89	3/8"
HP 14 X 73	5/16"
HP 12 X 53, 63, 74 & 84	5/16"
HP 10 X 42 & 57	5/16"
HP 8 X 36	5/16"

**WELD PROCEDURE**

1. To insure proper seating of the tip, remove all flash from end of pile and insert tip.
2. Using a 70xx series rod, make a single pass weld (see table) across each flange on the outside only.
3. Do not weld web or inside of flanges.
4. For heavier sections, you may want to use multiple welding passes.
5. For heavier sections, chamfer the HP to accomplish weld size.



**DETAIL B  
SCALE 1:2**

DIMENSIONS ARE IN INCHES  
TOLERANCES:

- 1/X ± 1/8"
- .XX ±
- .XXX ±
- .XXXX ±

MATERIAL  
**ASTM A27 65/35**  
FINISH  
**Bare**

DO NOT SCALE DRAWING

**PROPRIETARY AND CONFIDENTIAL**

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	NAME	DATE
DRAWN	CFH	7/6/06
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:		

**Versa-Steel, Inc**  
Portland, Oregon USA  
Ph 503-287-9822

Description: **HP Series Pile Tips  
Weld Instruction**

SIZE	DWG. NO.	REV.
<b>A</b>	<b>VS-300 Weld Inst.</b>	<b>B</b>
SCALE: 1:8	WEIGHT:	SHEET 1 OF 1