



DETAIL A
SCALE 1 : 2

Tack weld
2 opposite
faces of nut.

8 places

ROTATE ONE OF THE SPLICER HALVES
180 DEGREES FOR NON STAGGERED
ASSEMBLY.

DESCRIPTION	WELD
HP 8 X 36, HP 10 X 42 & 57	1/4"
HP 12 X 53, 63, 74 & 84	5/16"
HP 14 X 73, 89, 102 & 117	5/16"

Welding Procedure

1. Cut 1.0" wide x 1.0" long notch in center of web of one pile.
2. Chamfer outside edges of flanges on ends of one or both piles to be spliced. Make chamfer to about 1/2 material thickness.
3. Insert splicer on first pile making sure bolt is completely inside notch.
4. Install next section of pile and tighten bolt.
5. Using a 70xx series rod, weld the flanges of splicer to the flanges of the pile with (TABLE)" by 3" vertical fillets.
6. Weld the outside flanges of the piles to complete.

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DIMENSIONS ARE IN INCHES
TOLERANCES:

1/X ± 1/16"
.XX ± .01
.XXX ± .003
.XXXX ± .0005

MATERIAL

FINISH

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	CFH	7/15/05
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:		

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

Description: **WELD ILLUSTRATION
H-PILE SPLICER, BOLTED**

SIZE
A

DWG. NO. **VS-400B WELD INST.** REV. **A**

SCALE: 1:5

WEIGHT:

Lbs.

SHEET 1 OF 1