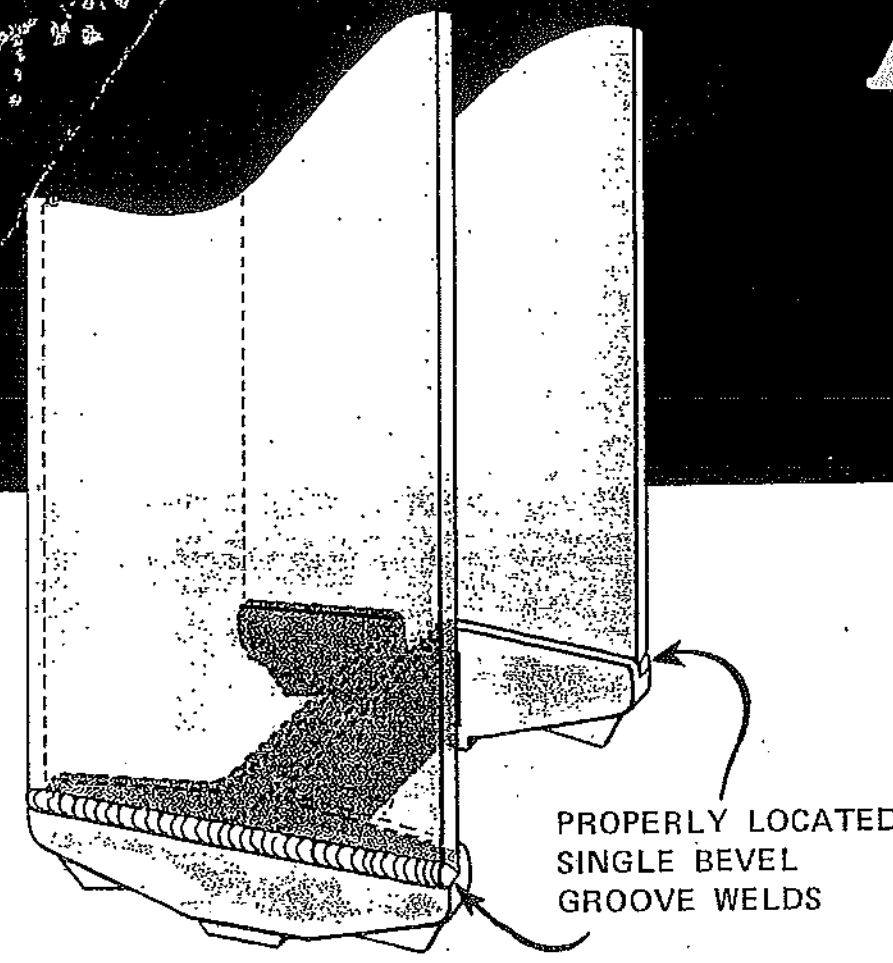


ATTACHMENT



PROPERLY LOCATED
SINGLE BEVEL
GROOVE WELDS

RELIABLE ATTACHMENT IS QUICK AND EASY

APF Cast Steel H-Pile Points are designed for ease of handling and attachment. The integrally cast back-ups for welding, position the point accurately on the pile. For proper load transfer, the points must be attached by a single bevel groove weld across the outside of each flange. With correct weld placement, the load transfers cleanly to the point. Welding along the inside of the flanges is not advisable as it creates a stress pattern which could prove detrimental to the integrity of the pile.

To facilitate attachment, stack the H-piles with webs horizontal and ends accessible. Use cribbing and/or stack with the ends staggered in and out, allowing welding at opposite ends of the stack simultaneously on the protruding piles.

Bevel for a partial groove weld along the outside of each flange of the H. Slip the APF point on the H and hold it in close contact against the pile. For most sizes (see table at right) make a 5/16 in. weld along each flange, being sure to get good penetration for the full width of the flange, not just the corners. E60 or E70 rod is suggested for manual welding. For the semi-automatic Squirt welder, Lincoln Electric Co. suggests AWS E 70 T-G (Lincoln NR 211) flux-cored wire. Total weld consists of a single pass across each flange. Loading and driving are all in compression on the square ledge of a cast steel APF point rather than in shear as with plate and angle reinforcement or weldments.



SIZE OF PILE	FLANGE THICKNESS (INCHES)	SIZE OF FLANGE CUT 45° BEVEL	SIZE OF GROOVE WELD
HP 14 x 117	0.805	3/8	7/16
102	0.705	3/8	3/8
89	0.615	1/2	5/16
73	0.605	1/2	5/16
HP 13 x 100	0.765	3/8	3/8
87	0.665	5/16	5/16
73	0.665	1/2	5/16
60	0.60	1/2	5/16
HP 12 x 84	0.685	1/2	5/16
74	0.610	5/16	5/16
63	0.615	1/2	5/16
53	0.435	1/2	5/16
HP 10 x 67	0.665	1/2	5/16
42	0.420	1/2	5/16
HP 8 x 36	0.445	1/2	5/16