

APPROVED JOINT DETAIL FOR COMPLETE JOINT PENETRATION GROOVE
 WELD OF H-PILE FLANGE SPLICES

JOINT DESIGNATION : BU4a

SHEET # 2

Single-bevel-groove weld (4) Butt joint (B)				Tolerances	
Welding Process	Joint Designation	Base Metal Thickness (U = unlimited)		As Detailed (see 2.12.1)	As Fit-Up (see 3.3.4)
		T ₁	T ₂	R = +1/16, -0	+1/4, -1/16
SMAW	B-U4a	U	—	a = +10°, -0°	+10°, -5°
				Groove Preparation	
		Root Opening	Groove Angle	Allowed Welding Positions	
		R = 1/4	α = 45°	F, H	Gas Shielding for FCAW
		R = 3/8	α = 30°	F, H	—
				Notes	
				a, i, m	

