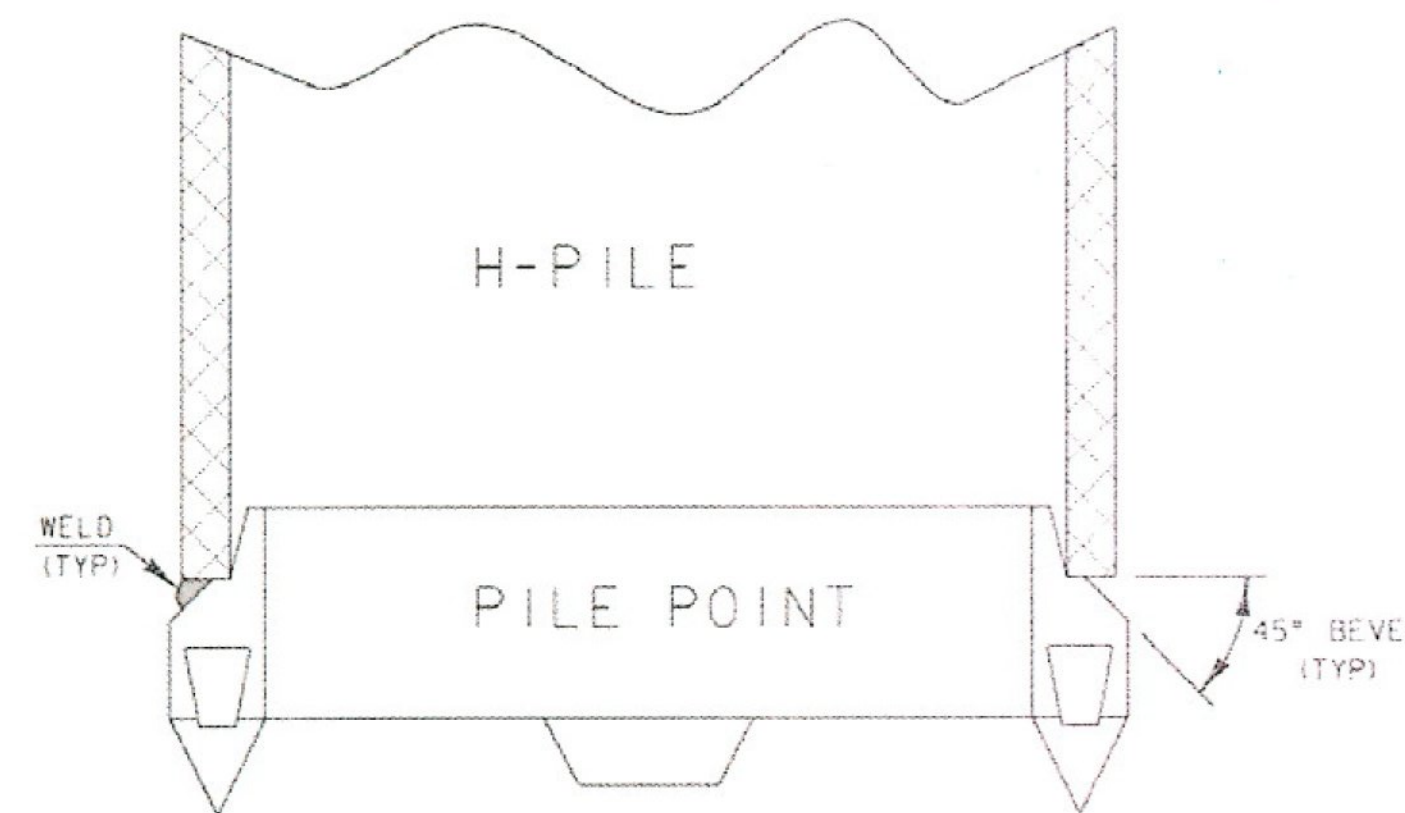


Pile tip detail

- Pile Tips shall be welded onto piles per the specifications of the Manufacturer. These can be welded in the field or in a fabrication plant, however in either case, pre-approval is required for procedures and welder/fabricator by the Agency's Shop Inspector. Piles that arrive to the construction site with tips welded to them without pre-approved procedures/welders are rejectable.



NOTES:

H-PILE SHALL HAVE A SQUARE CUT END FOR THE PILE POINT TO FIT ON TO.

PILE POINT SHALL BE WELDED IN EITHER THE FLAT OR VERTICAL POSITION USING 70XX OR 60XX ELECTRODES.

WELD ACROSS THE FULL WIDTH OF BOTH FLANGES WHILE MAINTAINING THE MINIMUM WELD SIZE ACCORDING TO THE CHART BELOW.

Pile Size	Flange Thickness	Min. Size Groove Weld*
HP 14 x 117	0.805	7/16
HP 14 x 102	0.705	3/8
HP 14 x 89	0.615	3/8
HP 14 x 73	0.505	5/16
HP 12 x 84	0.685	3/8
HP 12 x 74	0.610	3/8
HP 12 x 63	0.515	5/16
HP 12 x 53	0.435	5/16
HP 10 x 57	0.565	5/16
HP 10 x 42	0.420	5/16
HP 8 x 36	0.445	5/16

* UNLESS OTHERWISE SPECIFIED BY THE MANUFACTURER.



Pile Point