

**JOINT WELDING
PROCEDURE SPECIFICATION**

Material specification PL1E = ASTM A572 GR. 50 / EQUIVALENT ; POINT = ASTM A27 65/35
 Welding process SMAW
 Manual or machine MANUAL
 Position of welding HORIZONTAL OR VERTICAL
 Filler metal specification AWS A5.1
 Filler metal classification E7018
 Flux N/A
 Shielding gas N/A Flow rate N/A
 Single or multiple pass MULTIPLE (IF REQUIRED)
 Single or multiple arc SINGLE
 Welding current DC
 Polarity REVERSE
 Welding progression N/A
 Root treatment NONE - POINTS ARE PRE-BEVELLED TO PROFILE
 Preheat and interpass temperature PRE AWS D1.1
 Postheat treatment NONE

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1	1/8"	120-150	12-24	1 F1/MIN	
2+	5/32"	140-180	12-24	1 F1/MIN	

Vermont Agency of Transportation

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CK'D BY JWC OK'D BY _____

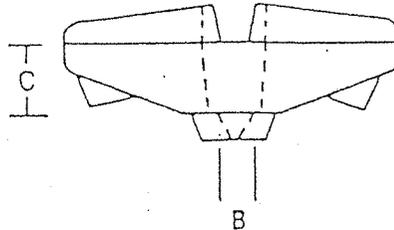
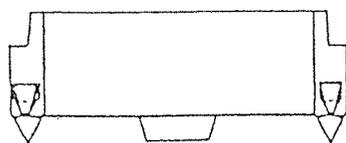
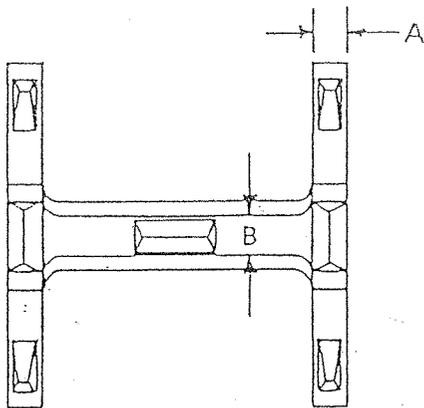
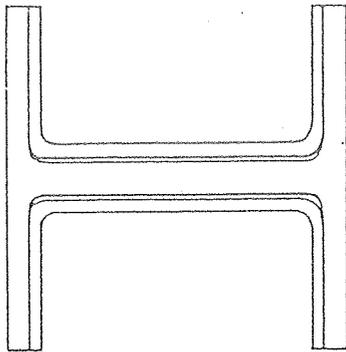
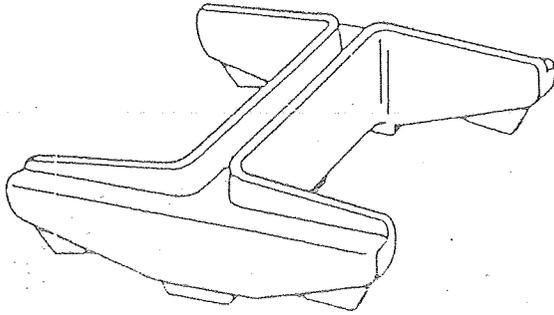
December 21, 2012

RESUBMIT _____ APPROVED X
 BY KMH DATE 1-11-13

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure no. A PL1E POINT ATTACHMENT Contractor A.B. FLEMING, INC.
 Revision no. 0 Authorized by [Signature]
 Form E-2 Date 12/21/12

HARD-BITE® HP 77600
Patented



Commercially manufactured H-pile driving points shall have the following characteristics:

1. Material: Points shall be made in one piece of ASTM A 27 65/35 or AAR M-201 Grade B.
2. Design:
 - 2.01 Points shall have continuous back-up on the entire inner edges of the H for the purposes of:
 - a. Backing up welds along the outside of the flanges.
 - b. Encasing the web of the pile to assure alignment and prevent separation.
 - 2.02 The soil bearing surface of the driving points shall have seven integrally cast tapered cutting wedges, three to be located on each flange, one to be centered on the web.
 - 2.03 Minimum overall widths of the flanges of 8", 10", 12" and 14" points shall be as in chart, line A.
 - 2.04 Minimum width of the web (exclusive of protruding cutting wedge of 8", 10", 12" and 14" points shall be as in chart, line B.
 - 2.05 Minimum height of the point (exclusive of the protruding cutting wedges) from the soil bearing surface of the web to point-pile interface shall be as in chart, line C.
 - 2.06 Chart

	8"	10"	12"	14"
A	1-1/16"	1-1/8"	1-1/8"	1-3/8"
B	15/16"	1"	1"	1-1/4"
C	1-7/8"	2-1/16"	2-1/2"	2-7/8"

NOT TO SCALE

SAMPLE SPECIFICATION
PROVIDED AS A CONVENIENCE
TO ENGINEERS & DESIGNERS



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