

MH536B – CJP BUTT WELD SPLICE SPECIFICATION AND DETAIL

This weld procedure is for Magnum helical pile MH536B only. All welds must be performed by a certified welder. For galvanized piles, remove galvanizing prior to welding per AWS/ANSI Z49:1 “Safety and Cutting in Welding”. After welding, replace any galvanizing in accordance with ASTM A780.

This detail is not valid for splices that are subjected to cyclic loading.

Weld Notes:

1. The welds shall be Complete-Joint-Penetration and shall have continuous backing, since the weld will be from one side only.
2. Per AWS D1.1 Section 5.10.2, the backing is permitted to be made from one or two pieces.
3. Per AWS D1.1 Section 5.10.3 *Backing Thickness*, the backing shall have a minimum thickness of 1/4" for GMAW weld process.
4. The backing material shall be in contact with the materials being butt welded.
5. Backing should extend beyond the width of the root (no specification for overlap found).
6. The filler metal strength shall be 100ksi or greater ($F_{EXX} = 100$ ksi).
7. The root width shall be equal to the wall thickness of the pipe (0.36 inches). Tolerances for this weld can be found in AISC Table 8-2 or AWS D1.1 Figure 3.4, shown in Figure 2.

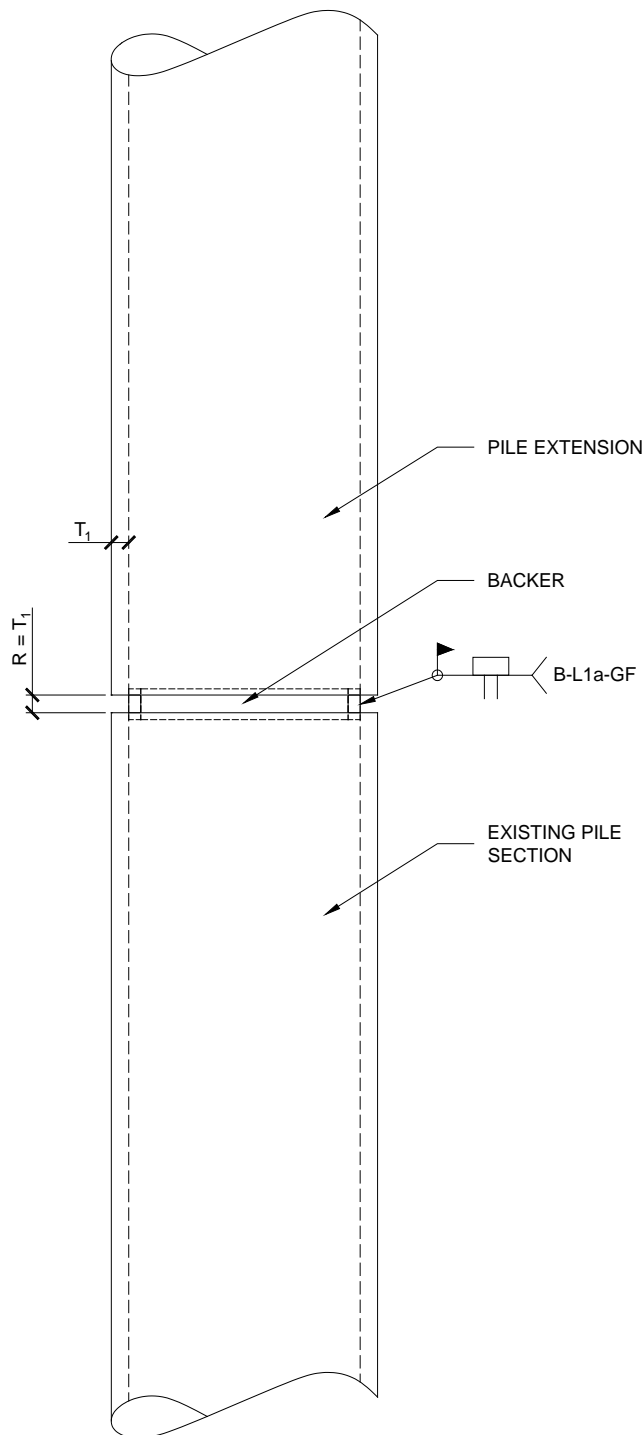


Figure 1. Butt Weld Splice Detail

MH536B – CJP BUTT WELD SPLICE SPECIFICATION AND DETAIL

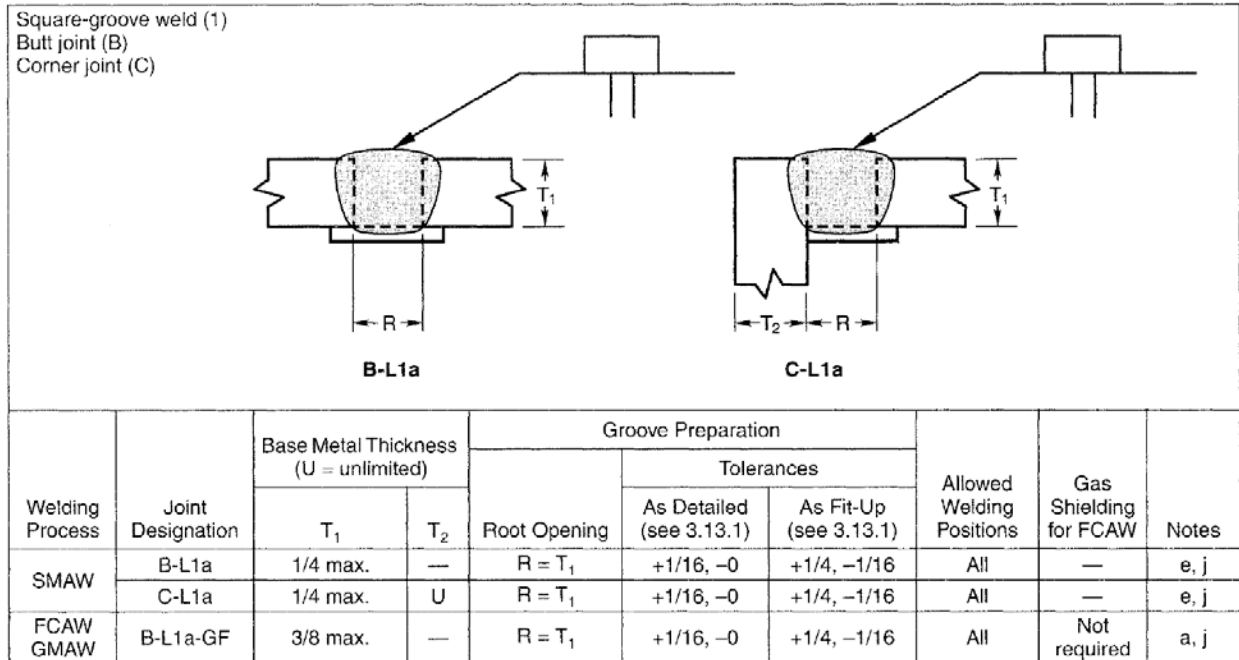


Figure 2. AWS D1.1 Figure 3.4 – Prequalified CJP Groove Welded Joint Details