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REMOVE HARDENED EDGE OR CUT OFF SECTION OF PILE WITH FLAME CUT HOLE TO MARE CIRCOLAR AND REMOVE HARDENED EDGE OR CUT OFF SECTION OF PILE WITH FLAME CUT HOLE PRIOR TO SPLICING OR CONCRETE PLACEMENT. HOLES IN FLANGES ARE PERMITTED FOR HANDLING ONLY IF THAT PORTION OF THE PILE IS CUT OFF PRIOR TO SPLICING OR EMBEDMENT INTO CONCRETE.

PILE	WELD SIZE (E)	BEVEL DEPTH (S)	
HP 10 x 42 HP 10 x 57 HP 12 x 53	5%6" 5%6" 5%6"	5⁄16" 5⁄46" 5⁄16"	
HP 12 x 74 HP 14 x 73 HP 14 x 89	38" 38" 38"	38" 38" 38"	
HP 12 x 84	7⁄16"	7⁄16"	
ALL OTHERS	CHECK WITH MDOT CONSTRUCTION FIELD SERVICES GEOTECHNICAL SECTION AND THE BRIDGE FIELD SERVICES SECTION.		

NOTES:

DO NOT USE THE ALTERNATE SPLICE SLEEVE DETAIL WITH INTEGRAL ABUTMENTS, PILE BENTS, OR ANY OTHER PILES THAT MUST RESIST BENDING STRESSES. ONLY USE FULL PENETRATION BUTT WELD SPLICE DETAIL WITH INTEGRAL ABUTMENTS.

