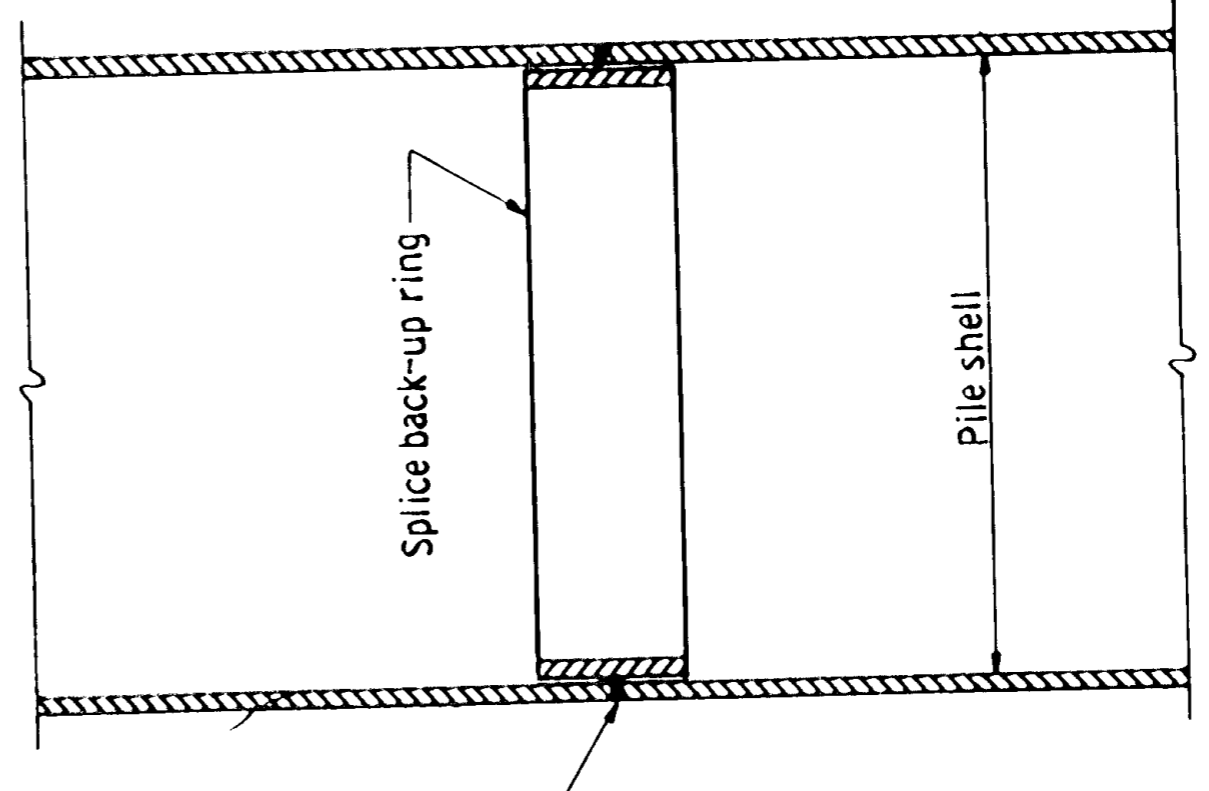


**PLAN VIEW**  
(Pile not shown)

**SECTION B - B**  
(Pile not shown)

**NOTES:**

- Approved commercial pile splice back-up ring may be used in lieu of the type detailed. Back-up ring shall have a tight fit.
- Welding electrodes shall be A. W. S. Type E7016 or E7018 (low-hydrogen).
- Low-hydrogen electrodes shall be supplied in hermetically (air-tight) sealed containers.
- Low-hydrogen electrodes shall be stored in holding ovens at a temperature of not less than 250° F.
- Low-hydrogen electrodes shall be placed in a holding oven for at least 8 hours, after having been exposed to the atmosphere for more than 2 hours.
- Electrodes which have become wet, soiled or damaged shall not be used.
- Welding shall not be done when the ambient temperature is lower than 0° F. or when the pile is wet or exposed to falling rain or snow. When the pile metal temperature is below 32° F., the pile metal in the area of the weld shall be heated to a minimum temperature of 70° F. and maintained at this temperature during welding.

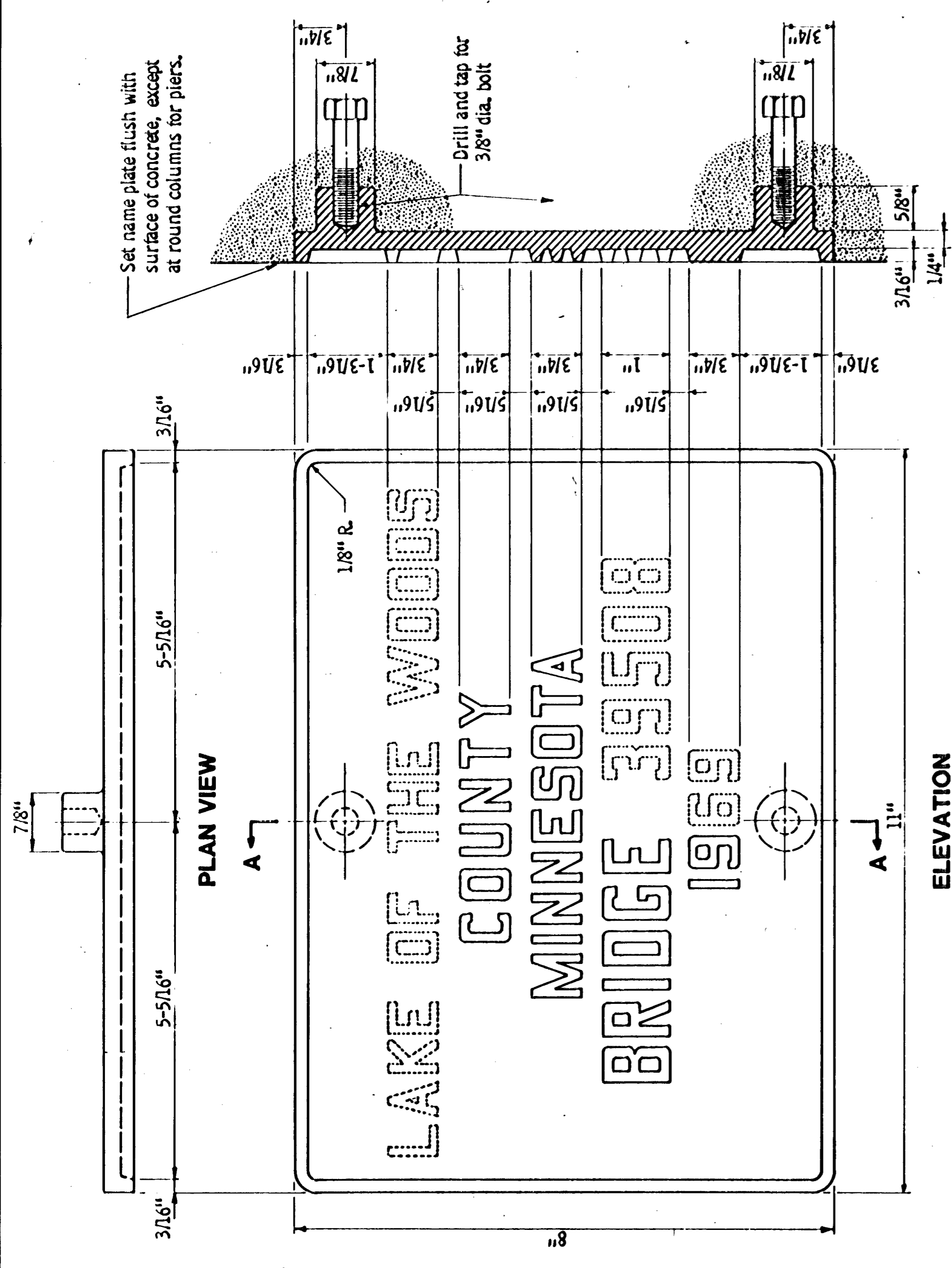


**SECTION A - A**

APPROVED JULY 21, 1972  
  
 Douglas A. Sells  
 Engineer in Charge  
 RESEARCH AND STANDARDS  
 DIVISION

MINNESOTA  
 DEPARTMENT OF TRANSPORTATION  
**PILE SPLICE**  
 CAST-IN-PLACE CONCRETE PILES

DETAIL NO.  
**B201**



**ELEVATION**  
 The dotted letters & numbers shown above are for illustration. Data to be shown on name plate is as follows:

COUNTY DAKOTA  
 BRIDGE 02535  
 YEAR 1969

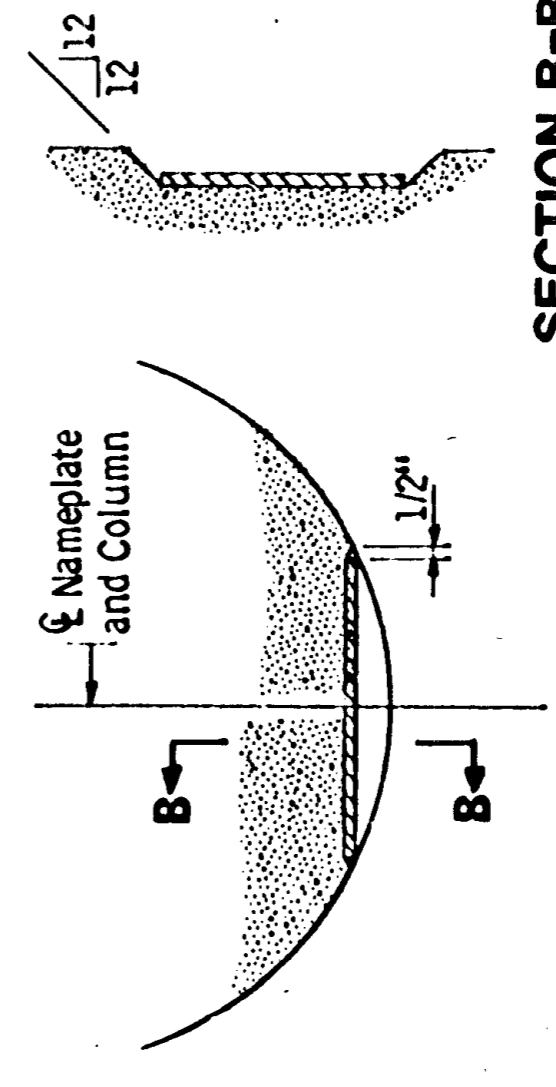
**SECTION A - A**

1234567890  
 ABCDEFGHIJKLMNOPQRSTUVWXYZ

**LETTERS & NUMBERS FOR NAMEPLATES**

**NOTES:**

- No shop drawing required.
- Material shall comply with Spec. 3327
- Letters and numbers shall conform to those shown.
- Draft on letters and numbers shall not be more than 3" in 12".
- Horizontal spacing of letters and numbers shall produce a balanced layout in proportion to spacing shown.
- Top surface of letters, numbers and frames shall be burnished.
- Furnish 2 steel bolts 3/8" dia. x 3" long with each plate.
- All dimensions for 3/4" high letters and numbers shall be in direct proportion to those shown for the 1" high letters and numbers.



**SECTION B - B**

**NAMEPLATE PLACEMENT**  
(Round Concrete Pier Columns)

APPROVED: MAY 1, 1985  
 DEVELOPED BY: ENGINEERING STANDARDS & BRIDGES AND STRUCTURES OFFICES  
 ISSUED BY: OFFICE OF ENGINEERING STANDARDS

STATE OF MINNESOTA  
 DEPARTMENT OF TRANSPORTATION  
**BRIDGE NAMEPLATE**  
 COUNTY BRIDGES

DETAIL NO.  
**B103**