

MECHANICAL TESTING

Tensile tests are performed in accordance with the stated requirements of the applicable ASTM or EU standard material specification, which reference testing specification detail.

In addition to the standard tensile test, a minimum of two interlock strength tests are performed for each heat of PS sections.

TOLERANCES

When using steel sheet piling it is necessary to make allowances for deviations from theoretical exactness. The basic character of the rolling processes and normal limitations of mill equipment limit the degree of precision obtainable in the production of steel sheet piling. Therefore, care must be taken during installation to assure that each pair of sheets is being set at the desired driving dimensions.

Interlocks should be continuous, reasonably free-sliding to grade when threaded, and for PS sections should have sufficient clearance to allow piles to be swung within the stated limits.

All steel sheet piling has an allowable weight variation of 2.5% and are invoiced on theoretical weight. Length tolerance is minus 0 inches (0 millimeters) and plus 5 inches (127 millimeters).

LENGTHS

Sheet piling sections are rolled and cut to ordered length. For best economy, the designer should specify the actual length as calculated in the design process. Stock lengths are typically available in 5 feet (1.5 meters) increments.

All sections are readily available in lengths up to 70 feet (21 meters) from regular rollings. Gerdau can supply longer lengths, sometimes in excess of 100 feet (30 meters). Before ordering lengths exceeding 70 feet (21 meters) check for availability.

SPLICING

If possible, splicing of Z-piling sections should be avoided. If splicing is necessary, sections should be ordered full length from the mill. They should be match-marked and cut at the job site. These match-marked sections should then be spliced together. This procedure improves section geometry match-up. Splicing of random sheets could result in setting and driving difficulties.