

EXAMPLES OF UNACCEPTABLE LOCK SEAM CONSTRUCTION



CROSS - SECTION
of
LOCK SEAM



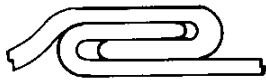
INTERIOR ANGULARITY



INTERIOR ANGULARITY
and
ROLLER INDENTATION



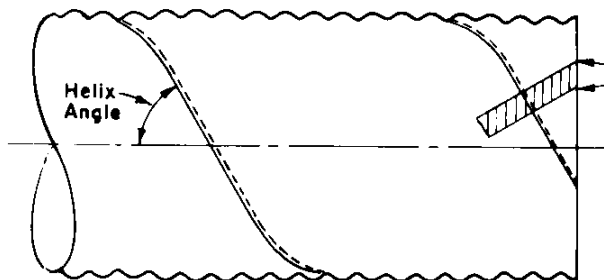
LACK OF CONTACT ON LAPPED
SURFACES, IMPROPER RETAINING
OFFSET LOCATION



INSUFFICIENT RETAINING OFFSET



ROLLER INDENTATION, INTERIOR ANGULARITY, LACK
OF TIGHT CONTACT ON LAPPED SURFACES



TYPICAL SAW CUTS FOR
SAMPLING LOCK SEAM
(TAKEN AT RANDOM)

Alberta
TRANSPORTATION
Engineering Division

DWG. No	CB - 6 5.15.M6
Date	
Original	Dec. 1978
Revised	

**LOCK SEAM
ON HELICALLY FABRICATED
CORRUGATED STEEL PIPE**