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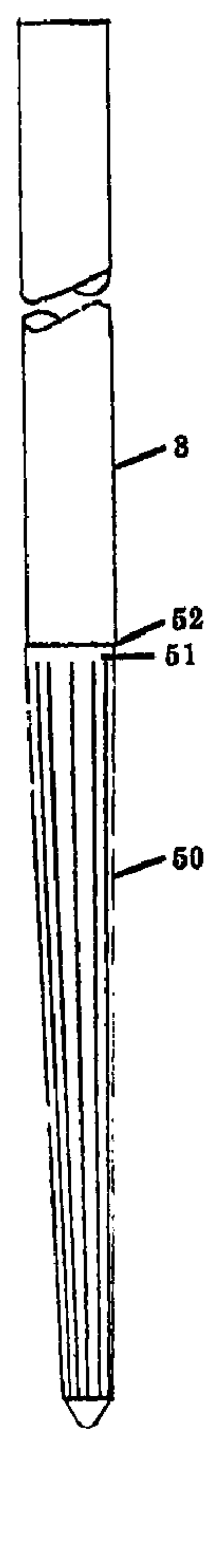


(57) Abrégé/Abstract:
A pile consisting of a tapered bottom of polygon-shaped steel tubing and a top cylindrical section of steel tubing spliced together to form a composite pile, which. after being driven is filled with concrete.

Abstract of the Disclosure

A pile consisting of a tapered bottom of polygon-shaped steel tubing and a top cylindrical section of steel tubing spliced together to form a composite pile, which. after being driven is filled with concrete.

Patent Application

Composite Pile

Composite pile

This invention relates to piling.

Present commercial pile driving practice utilizes piles having a variety of materials and geometric shapes to produce capacities in excess of 30 tons (about 270 kN). These piles are often concrete-filled steel tubes having closed-ends that are driven into a variety of soil types, including those with granular (sand and/or gravel) and cohesive (silt and/or clay) characteristics.

Generally, the piles have a constant cylindrical cross-section. However, it is well known that a gradually increasing tapered configuration often enhances the load bearing capacity of piles, particularly in granular soils. Thus, piles having such geometries, such as full-length fluted piles with tapered fluted bottom sections below a length of fluted cylindrical tubing having a diameter equal to that at the top of the tapered section, have been shown to be effective by producing higher capacities than cylindrical piles at similar penetrations into those soils. These piles have been used successfully for decades. They are described at pages 158 and 159 of the book "Foundation Construction" by A. Brinton Corson published 1965 by McGraw-Hill Book Company.

The piles for this invention have tapered bottom sections made of steel tubing shaped into a polygon cross-section having substantially equal sides (preferably about 8-16, e.g. 12 sides), or of said polygonal cross-section having a short transitional length to a circular cross-section at the top, which is joined by a fabricated splicer, or by butt welding, to conventional circular steel cylindrical pipe having a diameter that may be equal to, or less than, the top diameter of the taper. Wall thicknesses for both the tapered section and pipe section can be up to 0.5 in. (about 13 mm) compared to 0.24 in (about 6mm) for the conventional fluted piles, top diameters of the tapered section may be from 12 in. (300 mm) to 24 in. (600 mm), bottom diameters may be from 8 in. (200 mm) to 20 in. (500 mm); tapered lengths may be fabricated in lengths of 5 to 40 feet (1.5 m to 12 m), and circular pipe lengths fabricated to lengths of 80 feet (24 m) and longer. For conventional fluted piles, the splice between the tapered section and cylindrical fluted section is a lap weld from the top of the tapered section to the side of the cylindrical section which has been inserted for several inches into the tapered section, maximum metal thickness if 0.24 in. (about 6 mm), tapered sections have a maximum upper diameter of 18 in. (about 450 mm) and bottom diameters are all 8 in. (about 200 mm), and cylindrical fluted sections are made to a maximum length of 40 ft. (about 12 m).

These piles will produce comparable and greater capacities than the previously described fluted piles.

Among the advantages of these piles are:

1. A wide range of geometries and lengths for the tapered bottoms can be fabricated by means of existing equipment and technology, such as brake-forming. The pile length, top and bottom diameter, and wall thickness can be made to satisfy site-specific pile capacities and soil conditions.

2. Significant cost savings are possible by the use of conventional cylindrical pipe for the tops of these piles. Pipe costs considerably less than fluted cylindrical tubing. Added savings will result if the pipe diameter used is less than the top diameter of the tapered section, and by the re-use of pipe remaining from previously driven piles that can easily be spliced. Furthermore, the use in the practice of this invention of thin-walled pipe (or alternatively corrugated steel shell) that is driven with an internal mandrel will also produce significant cost-savings.

3. Specific design considerations not possible with existing configurations may be designed by using the proposed piles. These include tapered and pipe wall thicknesses of up to 0.5 in. (about 13mm) to provide stiffness and suitable stress levels for both driving conditions and service conditions. Heavier wall thicknesses may be used for proposed piles to avoid damage often caused to fluted tapered piles with available maximum wall thickness. Added pile stiffness and strength also improves the driving efficiency thereby yielding improved pile load capacity.

4. The splices for these piles may be drive-fit, weld-fit or butt-welded. In all cases, the load transfer from the top of the pile to the bottom is made by continuous bearing of each of the components, and not through a shear transfer in a lap-welded splice as is customary for fluted piles. The convenience, effectiveness and economy of these splices will make it possible to perform more splicing at the job site, thereby allowing preferable and less costly shipment of shorter lengths.

5. The circular cylindrical pipe sections of these piles may be manufactured in lengths to 80 feet (about 25 m).Thus, the splicing of the pipe to a typical tapered section of 25 feet (about 8 m) will produce an overall length of about 105 feet (about 33 m). Additional sections of pipe may be conveniently added, if needed, by the use of butt-welded splices or mechanical sleeves. Fluted piles generally have a fabrication length limitation for the cylindrical sections of 40 feet (about 12 m) which, with tapered lengths of 25 feet (about 8 m),

will produce overall lengths of up to only 65 feet (about 20 m). Additional piling length requires costly splicing of the fluted cross-section. Thus, the use of piles of this invention will often eliminate costly added splices when the pile lengths are longer than 65 feet, and allow for effective and efficient splices if needed at any length.

These piles may be produced in a great variety of configurations anf capacity requirements. Examples are:

A pile having a 10 foot (about 3 m) long tapered section of 0.188 in. (about 5mm) thick steel with a bottom diameter of 8 in. (about 200 mm) and a top diameter of 12 in. (about 300 mm), and connected to an 8-5/8 inch (about 220 mm) O.D. x .188 in. (about 5 mm) thick pipe having a length of 30 feet (about 10 meters) may be used to produce a capacity of 40 tons (about 360 kN) when driven to penetrate through 5 feet (about 1.5 m) of miscellaneous fill, 20 to 25 feet (about 6 to 8 m) of organic silt, and 10 feet (about 3 m) or so into a lower loose sand or medium soft clay stratum having an "N" value of about 15.

Or, a pile having a 25 foot (about 8 m) long tapered section of .312" (about 6 mm) thick steel formed into a tapered structure having 12 substantially equal faces, the upper outside diameter of the tapered section being about 18 inches (about 460 mm) across and its lower outside diameter being about 8 inches (about 200 mm) across, the very top of the tapered section being deformed into a circular cross-section of 18 inch (about 460 mm) outside diameter and butt-welded to an 18 inch O.D. x 0.375 inch (about 10 mm) thick pipe having a length of 40 feet (about 12 m) may be used to produce a capacity of 150 tons (about 1,330 kN) when driven to penetrate through 10 feet (about 3 m) of dredged sand, 5 feet (about 2 m) of organic soil, and 45 to 50 feet (14 to 16 m) into a loose to medium dense sand stratum having a standard penetration value that varies between 10 and 30.

In general, the length of the tapered section should be such as to fully develop the capacity of the pile in the bearing stratum, which is usually a granular soil such as sand, gravel, or a combination thereof. The pipe will have the length necessary for the pile to extend up to the bottom of the foundation (i.e., pile cap or grade beam) for the structure above.

These piles must have a suitable thickness and yield strength to accommodate any dynamic stresses generated during the driving. Pile driving criteria to establish the requisite pile capacity at acceptable driving stresses may be predetermined by wave equation analysis, and load testing may be done to confirm capacity. After driving, the piles are filled with concrete. Generally, it is not necessary to use reinforcement in the concrete, e.g., the internal reinforcing steel cage conventionally employed in fluted steel piles may be omitted, as may the reinforcement often necessary (to prevent buckling during driving) at the tops of the fluted sections of the conventional piles. Where piles are to be driven into corrosive soils additional steel thickness may be used to offset the projected loss to corrosion instead of applying an expensive coating as is done for the conventional fluted piles. The preferred thickness of steel for these piles is between .188 inches (about 5 mm) to .500 inches (about 13 mm). The steel may be mild steel (suitable for welding) with a yield strength of 50 KSI (3.54 kPa). The combined strength of steel and concrete must satisfy the design capacity requirements.

The figures (FIG. 1 through FIG. 15) that are shown describe certain preferred forms of the invention.

FIGS. **1** and **2** are elevations of composite piles having transition rings.

FIGS, **3** and **4** are cross-sectional details showing the rings of 1 and **2**. respectively.

FIG. **5** is a cross-sectional detail of a pile driven with a mandrel.

FIG. **6** is a plan view of the tapered bottom section of the composite pile.

FIGS. **7** and **8** are elevations showing piles fully driven into various soil strata.

FIG. **9** is a view showing the folding of the plate from which the bottom section of the pile is formed.

FIG. **10** is an elevation showing the result of the folding.

FIG. **11** is an elevation showing a bottom section composed of several short sections.

FIG. **12** is an elevation of a composite pile which does not employ a transition ring.

FIG. **13** is an elevation showing a cross-section of FIG. **12**.

FIG. **14** is a cross-section of a welded portion of the bottom portion of the pile.

FIG **15** is a cross-section of a splice at the top of the bottom section of a pile that does not employ a transition ring.

FIG. 1 is an elevation of the composite pile having a tapered lower cross-section **1** with a regular polygonal cross-section of a number of equal sides joined by a transition ring **2** to a circular pipe **3** whose diameter is approximately equal to the diameter of the top of the taper and whose thickness is suitable for direct driving. A steel point **6** has a taper of about 60 degrees, or may be rounded, is welded to the bottom of the tapered lower section for closure. A flat plate may be used in lieu of the tapered or rounded point.

FIG. 2 is an elevation of a composite pile having a tapered lower section 1 with a regular polygonal cross-section of a number of equal sides joined by a transition ring **4** to a circular pipe **5** whose diameter is less than the diameter of the top of the taper and whose thickness is suitable for direct driving. A point **6** is welded to the bottom of lower tapered section for closure.

FIG. **3** is a cross-sectional detail showing the transition ring **2** joining the tapered lower section **1** to the circular pipe **3** described for FIG. **1**. These are joined by continuous welds **7** and **8**. The transition ring **2** has a lower portion **16**, of polygonal cross-section to fit snugly into the top **17** of lower section **1** which bears on an integral shoulder **18**. The integral socket **9** into which the pipe **3** fits may be configured to produce a "drive-fit" connection with no weld. The pipe bears on an integral shoulder **19**. The pile is driven by the blows of a conventional pile driving hammer applied to the top of pipe **3**.

FIG. **4** is a cross-sectional detail showing the transition ring **4** joining the tapered lower section **1** to the pipe **5** having a diameter smaller than that for the top of **1** as described for FIG. **2**. These are joined by welds **7** and **8**. The transition ring **4** has a lower portion **16**, of polygonal cross-section to fit snugly into the top of **17** of lower section **1**, an integral shoulder **18**. The integral socket **9** into which the pipe **5** fits may be configured to produce a "drive-fit" connection with no weld. That pipe bears on the upper part of shoulder **19**. The pile is driven by the blows of a conventional pile driving hammer on the top of pipe **3**.

FIG. **5** is a cross-sectional detail of a pile whose upper section is a thin-walled steel pipe **13**. The pile is driven by pile driving hammer blows to the top of a conventional pipe mandrel **12** which fits inside the thin-walled steel pipe and rests on an extended inner drive shoulder **11** of the transition ring **10**. These are joined by continuous welds **7** and **8**.

FIG. **6** is a plan of the tapered bottom section **1** viewed from the top. This cross-sectional shape is a polygon having 12 sides **15** of equal length. The number of sides can vary from 4 to 16 or more.

FIG. **7** is an elevation showing a fully driven pile **30** driven through upper soils of miscellaneous fill **31** and organic silt **32** into a stratum of loose to medium sand and gravel **33**. The tapered lower section **1** of the pile is usually fully embedded in stratum **33**, and the upper section, **5**, is made of cylindrical pipe having a diameter smaller than the top of the tapered lower section **1** which extends through the fill and organic silt, and usually some distance into the lower sand and gravel.

FIG. **8** is an elevation showing a fully driven pile **35** driven through the upper soils of soft clay **36** and peat **37** into a stratum of medium to dense sand **38**. The tapered lower section of the pile **1** is usually fully embedded in stratum **38**, and the upper section, **3**, is made of cylindrical pipe having a diameter approximately equal to the top of the tapered lower section **1** which extends through the clay and peat, and usually for some distance into the lower sand and gravel.

FIG. **9** is a view of a partially formed polygon **40** during fabrication. A section of steel plate is cut to the requisite dimensions, and shaped by a brake-forming machine into an equal sided polygonal tube having a uniform taper.

FIG. **10** shows a full length of tube **41** after being formed. A continuous longitudinal weld **42** is made and the ends **43** and **44** are trimmed square to complete the tubular form. The tube may be made of a single sheet of steel for lengths of 25 feet (about 8 m) or more.

FIG. **11** shows a tube made of several shorter sections of matching tubes **45**, **46**, and **47** which are joined together by transverse butt welds **48** to yield lengths of 30 feet (10 m) or more (e.g., 80 feet – about 25 m).

FIG. **12** shows a full pile having a tapered tube **50** of polygonal cross-section for all of its length except at the very top where there is an integral transitional length of tube **51** of circularized cross-section to match the inner (or outer) diameter of the circular pipe, **3**. A butt-weld **52** splices the two sections together. The circularization may be effected by inserting an expandable die into the large end of the polygonal structure to cold work and expand that end into the circular form. The whole transition from polygon to circular cross-section may extend over a very short length of the structure, e.g., about 1 inch (25 mm).

FIG. **13** shows the butt weld **52** joining the circular top **51** of the tapered tube **50** to the circular pipe **3**.

FIG. **14** shows a transverse cross-section through the longitudinal butt weld **42** joining the outside edges of the folded plate of the tapered tube **50**.

FIG. **15** shows a longitudinal cross-section showing the butt weld splice **52** joining the tapered tube **50** to the pipe **3**. Internal backing ring **55** is used to contain the weld metal.

It is understood that the foregoing detailed description is given merely by way of illustration and that variations may be made without departing from the spirit of the invention. The "Abstract" which follows is given merely for the convenience of technical researchers and is not to be given any weight with respect to the scope of the invention.

The embodiment of this invention in which an exclusive property or privilege is claimed are defined as follows:

1. In a pile having
(a) a hollow uniformly tapered bottom load-bearing portion for extended engagement with the soil into which the pile is to be driven and to be filled with concrete after driving and
(b) a hollow straight upper load-bearing portion, the improvement in which the said hollow tapered portion has a cross-section, taken perpendicular to a longitudinal axis, which is a convex polygon having at least four sides, said sides being substantially equal in length, said hollow straight portion has a cross-section, taken perpendicular to a longitudinal axis, which is circular, the very top end of said hollow tapered portion being formed to a circular cross section of substantially the same diameter, as and matching with, the cross-section of said hollow straight portion and the bottom end of said hollow straight portion being butt-welded to said top of the hollow tapered portion so that the load transfer from the top of the pile to the bottom is made by continuous bearing of said hollow straight upper portion and said hollow tapered bottom portion.

2. In a pile as in claim **1,** said convex polygon having 8 to 24 sides.

3. In a pile as in claim **2,** said tapered portion being a unitary steel sheet folded into tapered polygon shape and having its longitudinally extending free edges welded together.

4. A driven pile in place in the ground and having the structure set forth in claim **3** and filled with concrete.

5. A driven pile in place in the ground and having the structure set forth in claim **4** and filled with concrete.

6. In a pile as in claim **1,** said hollow straight upper portion, being a circular steel pipe attached to the top of said hollowed tapered bottom portion, the diameter of said pipe being no greater than an upper diameter of said bottom portion.

7, In a pile as in claim **6,** said tapered portion being a unitary steel sheet folded into tapered regular polygon shape in cross-section and having its longitudinally free edges welded together.

8. A driven pile in place in the ground and having the structure set forth in claim **7** and filled with concrete.

9. A driven pile in place in the ground and having the structure set forth in claim **6** and filled with concrete.

10. In a pile as in claim **1,** said tapered portion having a closure at its bottom to substantially prevent ingress of the soil into said tapered portion during the driving of the pile

11. A driven pile in place in the ground and having the structure set forth in claim **10** and filled with concrete.

12. In a pile as in claim **1,** said tapered portion is about 3 to 13 meters long and has a lower diameter which is about 200 mm to 400 mm and a larger upper diameter which is about 300 mm to 600 mm, and the thickness of the steel for the tapered portion being about 5 to 13 mm.

13. A driven pile in place in the ground and having the structure set forth in claim **12** and filled with concrete.

14. In a pile as in claim **12,** said convex polygon having 8 to 24 sides.

15. In a pile as in claim **14,** said tapered portion being a unitary steel sheet folded into tapered polygon shape and having its longitudinally extending free edges welded together, said straight portion being a steel pipe, said tapered portion having a closure at its bottom to substantially prevent ingress of the soil into said tapered portion during the driving of the pile.

16. A driven pile in place in the ground and having the structure set forth in claim **15** and filled with concrete.

17. A driven pile in place in the ground and having the structure set forth in claim **14** and filled with concrete.

18. A driven pile in place in the ground and having the structure set forth in claim **1** and filled with concrete.

19. A process which comprises the steps of driving a pile having
(a) a hollow uniformly tapered bottom load-bearing portion for extended engagement with the soil into which the pile is to be driven and to be filled with concrete after driving and
(b) a hollow straight upper load-bearing portion, wherein, said hollow tapered portion has a cross-section taken perpendicular to the longitudinal axis of said tapered bottom portion, which is a convex polygon having at least four sides, said sides being substantially equal in length, said hollow straight portion has a cross-section, taken perpendicular to a longitudinal axis, which is circular, the very top end of said hollow tapered portion being formed to a circular cross section of substantially the same diameter as, and matching with, the cross-section of said hollow straight portion and the bottom end of said hollow straight portion being butt-welded to said top of the hollow

tapered portion so that the load transfer from the top of the pile to the bottom is made by continuous bearing of said hollow straight upper portion and said hollowed tapered bottom portion into granular soil by hammer blows transmitted to the top of said tapered bottom portion and then filling said hollow portions with concrete.

20. The process of claim **19**, said polygon having 8 to 24 sides.

21. The process of claim **20,** said tapered portion being a unitary steel sheet folded into tapered polygon shape and having its longitudinally extending free edges welded together.

22. The process of claim **19**, said hollow straight upper portion being circular steel pipe attached to the top of said hollow tapered bottom portion, the diameter of said pipe being no greater than an said upper diameter of said bottom portion.

23. The process of claim **22,** said tapered portion being a unitary steel sheet folded into tapered regular polygon shape in cross-section and having its longitudinally free edges welded together.

24. The process of claim **19,** said tapered portion having a closure at its bottom to substantially prevent ingress of the soil into said taped portion during the driving of the pile.

25. The process of claim **19,** in which said tapered portion is about 3 to 13 meters long, and has a lower diameter which is about 200 mm to 400 mm, and a larger upper diameter which is about 300 mm to 600 mm, and the thickness of steel for the tapered portion is about 5 to 13mm.

26. The process of claim **25** in which said convex polygon has 8 to 24 sides.

27. The process of claim **26** in which said tapered portion is a unitary steel sheet folded into tapered polygon shape and having its longitudinally extending free edges welded together, said straight portion is a steel pipe and said hammer blows are applied to the top of said pipe, said tapered portion having a closure at its bottom to substantially prevent ingress of the soil into said tapered portion during the driving of the pile.

28. In a pile having
(a) a hollow uniformly tapered bottom portion for extended engagement with the soil into which the pile is to be driven and to be filled with concrete after driving and
(b) a hollow straight upper load-bearing pipe having a cross-section, taken perpendicular to a longitudinal axis, which is circular, the improvement in which the cross-section, taken perpendicular to a longitudinal axis of said tapered portion is a convex polygon having at least four sides, said sides being substantially equal in length, said tapered portion being connected to said pipe by a transition ring having a lower portion of

polygonal cross-section fitting into the top of said tapered portion, said ring having an upper socket of circular cross-section into which said pipe is received.

29. In a pile as in claim **28,** said convex polygon having 8 to 24 sides.

30. In a pile as in claim **29,** said tapered portion being a unitary steel sheet folded into tapered polygon shape and having its longitudinally extending free edges welded together.

31. In a pile as in claim **30,** said tapered portion having a closure at its bottom to substantially prevent ingress of soil into said tapered portion during the driving of the pile, said convex polygon being a substantially regular polygon, said tapered portion is of steel and is about 3 to 13 meters long and has a lower diameter which is about 200 to 400 mm and is a larger upper diameter which is about 300 to 600 mm the thickness of steel of the tapered portion being about 5 to 13 mm.

32. In a pile as in claim **31,** the diameter of said pipe being no greater than an upper diameter of said bottom portion.

33. A driven pile in place in the ground and having the structure set forth in claim **32** and filled with concrete.

34. A driven pile in place in the ground and having the structure set forth in claim **29** and filled with concrete.

35. In the process of driving a pile into granular soil, the improvement which comprises driving a pile having the structure of claim **29** and then filling said hollow portions with concrete.

36. A driven pile in place in the ground and having the structure set forth in claim **30** and filled with concrete.

37. In the process of driving a pile into granular soil, the improvement which comprises driving a pile having the structure of claim **30** and then filling said hollow portions with concrete

38. A driven pile in place in the ground and having the structure set forth in claim **31** and filled with concrete.

39. In the process of driving a pile into granular soil, the improvement which comprises driving a pile having the structure of claim **31** and then filling said hollow portions with concrete.

40. In the process of driving a pile into granular soil, the improvement which comprises driving a pile having the structure of claim **32** and then filling said hollow portions with concrete.

41. In a pile as in claim **28**, the diameter of said pipe being no greater than an upper diameter of said bottom portion.

42. In a pile as in claim **41**, said convex polygon having 8 to 24 sides, said tapered portion being a unitary steel sheet folded into tapered polygonal shape and having its longitudinally extending free edges welded together.

43. A driven pile in place in the ground and having the structure set forth in claim **42** and filled with concrete.

44. A driven pile in place in the ground and having the structure set forth in claim **31** and filled with concrete.

45. In process of driving a pile into granular soil, the improvement which comprises driving a pile having the structure of claim **41** and then filling said hollow portions with concrete.

46. In the process of driving a pile into granular soil, the improvement which comprises driving a pile having the structure of claim **42** and then filling said hollow portions with concrete.

47. In a pile as in claim **28**, said ring having an integral inwardly extending shoulder on which said pipe rests.

48. In a pile as in claim **47**, said convex polygon being a substantially regular polygon having 8 to 24 sides, said tapered portion being a unitary steel sheet folded into tapered polygonal shape and having its longitudinally extending free edges welded together, said tapered portion having a closure at its bottom to substantially prevent ingress of soil into said tapered portion during the driving of the pile, said tapered portion is of steel and is about 3 to 13 meters long and has a lower diameter which is about 200 to 400 mm and a larger upper diameter which is about 300 to 600 mm, the thickness of the steel of the tapered portion being about 5 to 13 mm, the diameter of said pipe being no greater than an upper diameter of said bottom portion.

49. A driven pile in place in the ground and having the structure set forth in claim **48** and filled with concrete.

50. A driven pile in place in the ground and having the structure set forth in claim **47** and filled with concrete.

51. In the process of driving a pile into granular soil, the improvement which comprises driving a pile having the structure of claim **47** and then filling said hollow portions with concrete.

52. In the process of driving a pile into granular soil, the improvement which comprises driving a pile having the structure of claim **47** by hammer blows transmitted to the top of said pipe and then filling said hollow portions with concrete.

53. In the process of driving a pile into granular soil, the improvement which comprises driving a pile having the structure of claim **48** by hammer blows transmitted to the top of said pipe and then filling said hollow portions with concrete.

54. In the process of driving a pile into granular soil, the improvement which comprises driving a pile having a structure of claim **48** by hammer blows transmitted to a mandrel resting on said shoulder.

55. A driven pile in place in the ground and having the structure set forth in claim **28** and filled with concrete.

56. In the process of driving a pile into granular soil, the improvement which comprises driving a pile having the structure of claim **28** and then filling the hollow portions with concrete.

57. A pile comprising a hollow uniformly tapered steel body, said tapered body having a cross-section, taken perpendicular to a longitudinal axis, which is a convex polygon having 8 to 24 sides, said sides being substantially equal in length, said body being at least about 3 meters long, having a lower diameter which is about 200 mm to 400 mm and a larger upper diameter and being of steel about 5 to 13 mm thick formed from sheet steel folded into the tapered shape of said convex polygon and having its longitudinally extending free edges welded together, said body having at its bottom a closure constructed and arranged to substantially prevent ingress of the soil into said body during the driving of the pile, the construction and arrangement of said hollow body being such that said hollow body can be driven into the ground by hammer blows transmitted to the hollow unfilled top of said body and be filled with concrete thereafter.

58. A pile as in claim **57,** said polygon being a substantially regular polygon.

59. A driven pile in place in the ground, said pile having at its lower end of the body of claim **57** filled with concrete.

60. A pile comprising a hollow uniformly tapered steel body, said tapered body having a cross-section, taken perpendicular to a longitudinal axis, which is a convex polygon having 8 to 24 sides, said sides being substantially equal in length, said body being at least about 3 meters long, having a lower diameter which is about 200 mm to 400 mm and a larger upper diameter and being of steel about 5 to 13 mm thick formed from sheet steel folded into the tapered shape of said convex polygon and having its longitudinally extending free edges welded together, said body having at its bottom a closure constructed and arranged to substantially prevent ingress of the soil into said body during the driving of the pile, the very top of said body being formed to a circular cross-section such that said top can engage with, match and be butt-welded to the end of a straight pipe of corresponding circular cross-section, the construction and arrangement of said hollow body being such that said hollow body can be driven into the ground by hammer blows transmitted to the hollow unfilled top of said body and be filled with concrete thereafter.

61. A pile as in claim **60**, said polygon being a substantially regular polygon.

62. A pile driving process which comprises driving a hollow uniformly tapered steel body into the ground by blows transmitted to the very top of said body and filling said body with concrete, said tapered body having a cross-section, taken perpendicular to a longitudinal axis, which is a convex polygon having 8 to 24 sides, said sides being substantially equal in length, said body being at least about 3 meters long, having a lower diameter which is about 200 mm to 400 mm and a larger upper diameter and being of steel about 5 to13 mm thick formed from sheet steel folded into the tapered shape of said convex polygon and having its longitudinally extending free edges welded together, said body having at its bottom a closure constructed and arranged to substantially prevent ingress of the soil into said body during the driving of the pile.

63. A process as in claim **62** said polygon being a substantially regular polygon.

64. In a pile having
(a) a hollow uniformly tapered bottom portion for extended engagement with the soil into which the pile is to be driven and to be filled with concrete after driving and
(b) a hollow straight upper load bearing pipe having a cross-section, taken perpendicular to a longitudinal axis, which is circular, the improvement in which the cross-section, taken perpendicular to a longitudinal axis of said tapered portion is a convex polygon having at least four sides, said sides being substantially equal in length, said tapered portion being connected to said pipe by a transition ring having a lower portion of polygonal cross-section fitting into the top of said tapered portion, said ring having an upper socket of circular cross-section into which said pipe is received, said tapered bottom portion being of steel and having a cross-section taken perpendicular to a longitudinal axis which is a convex polygon having 8 to 24 sides, said sides being substantially equal in length, said body being at least about 3 meters long, having a lower diameter which is about 200 mm to 400 mm and a larger upper diameter and being of steel about 5 to 13 mm thick from sheet steel folded into the tapered shape of said convex polygon and having its longitudinally extending free edges welded together, said body having at its bottom a closure constructed and arranged to substantially prevent ingress of the soil into said body during the driving of the pile, the construction and arrangement of said hollow body being such that said hollow body can be driven into the ground by

hammer blows transmitted to the hollow unfilled top of said body and filled with concrete thereafter.

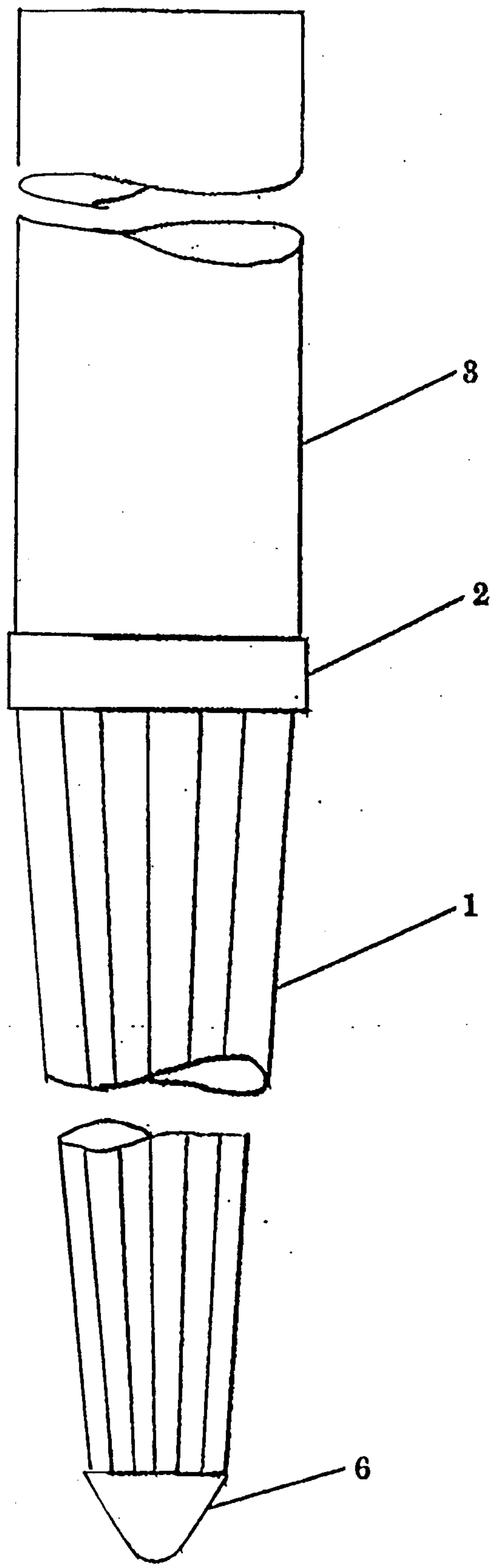


Fig. 1

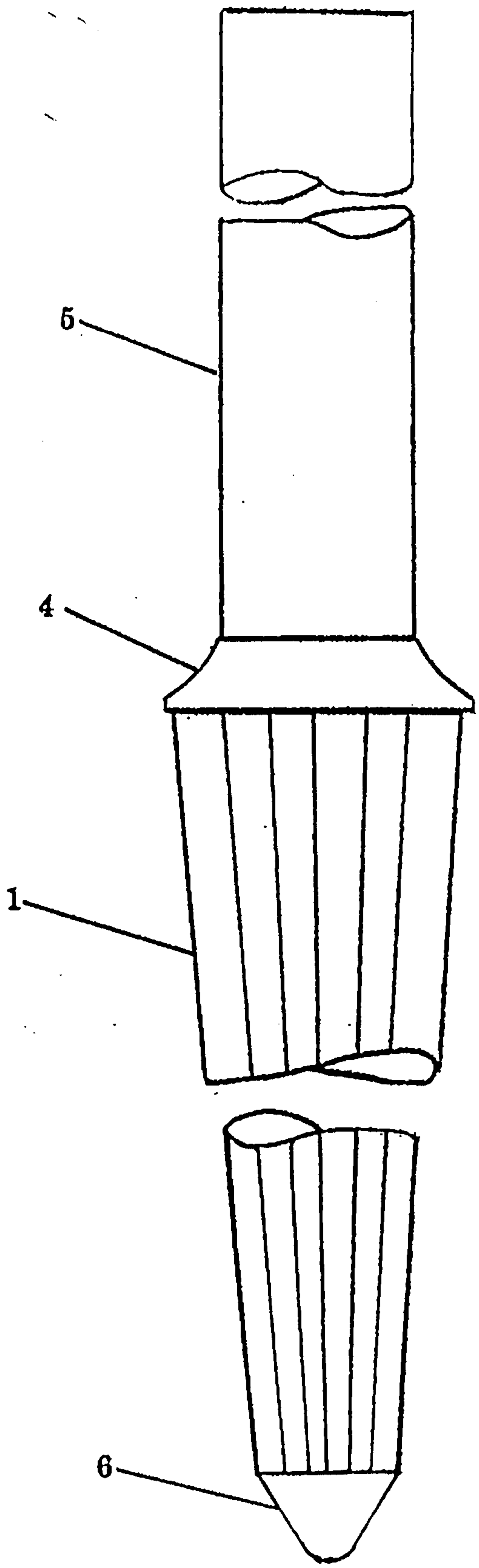


Fig. 2

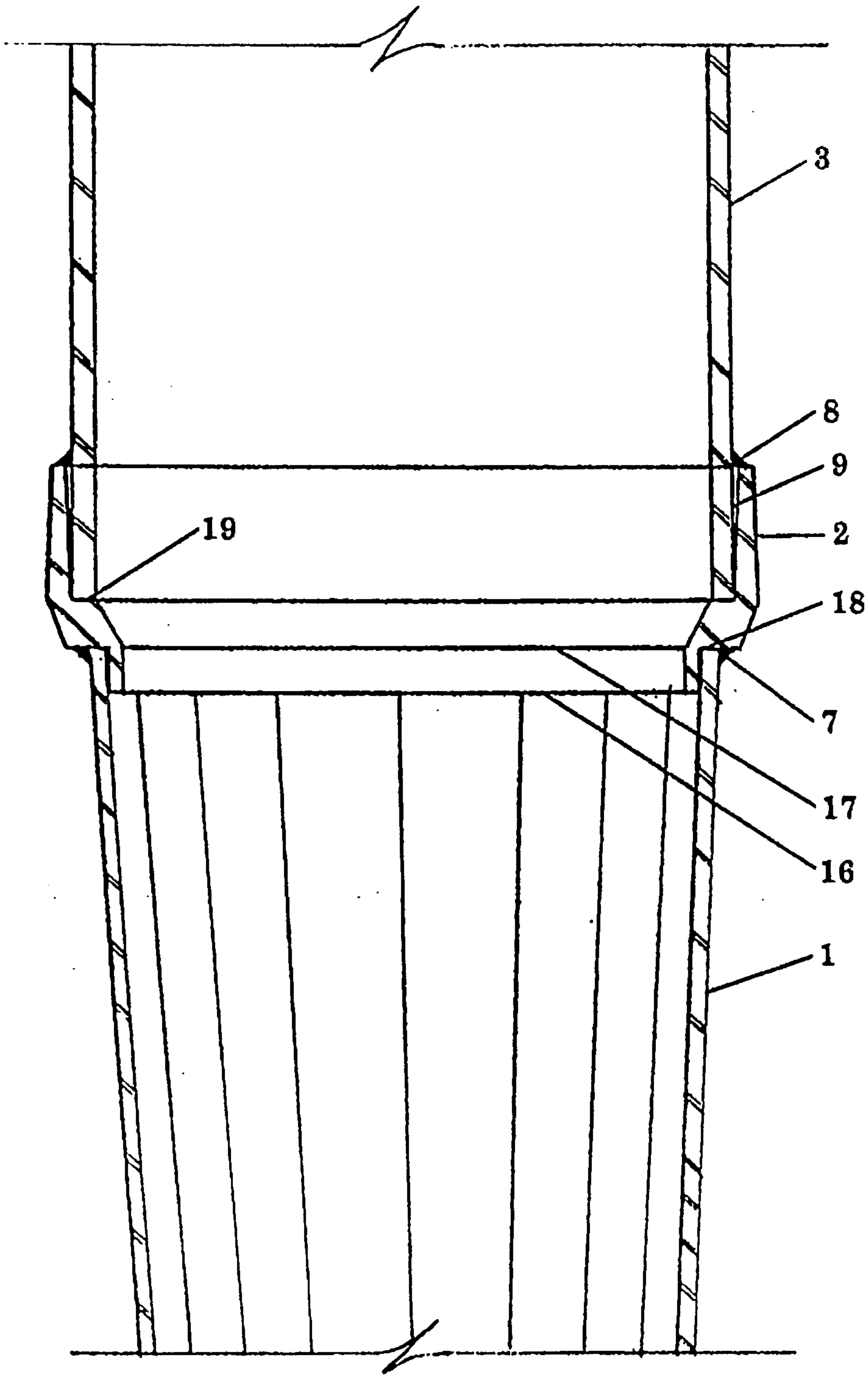


Fig. 8

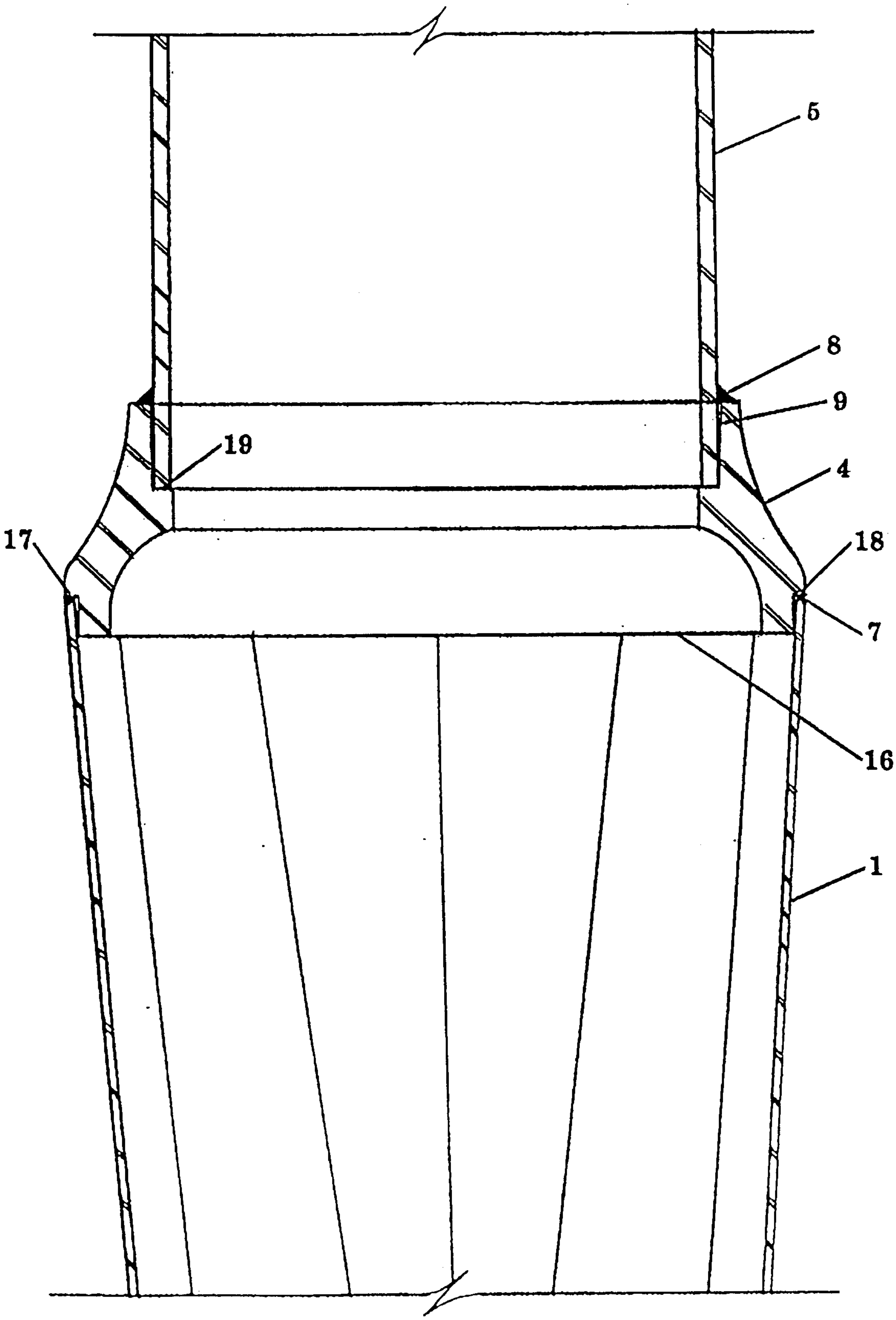


Fig. 4

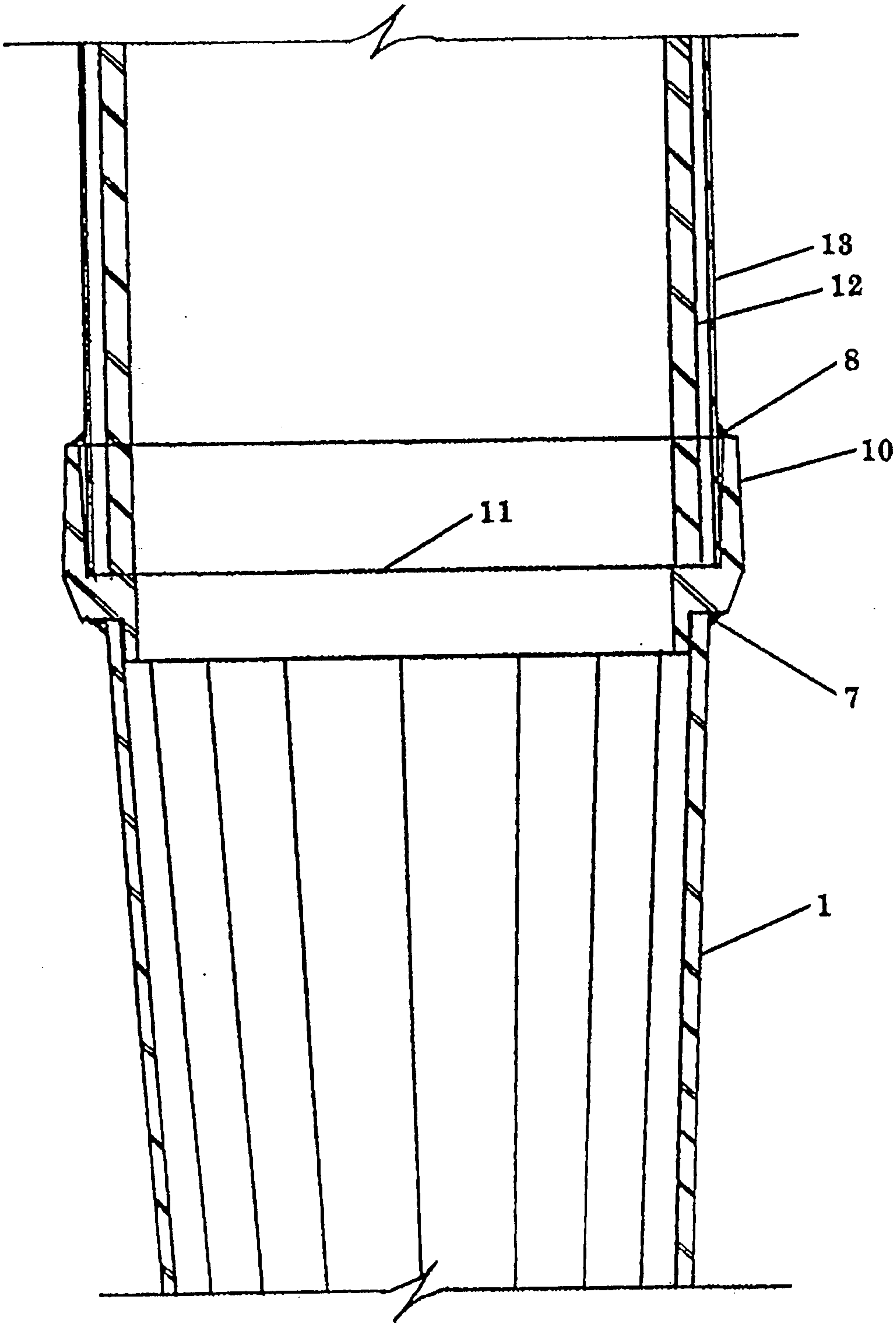


Fig. 5

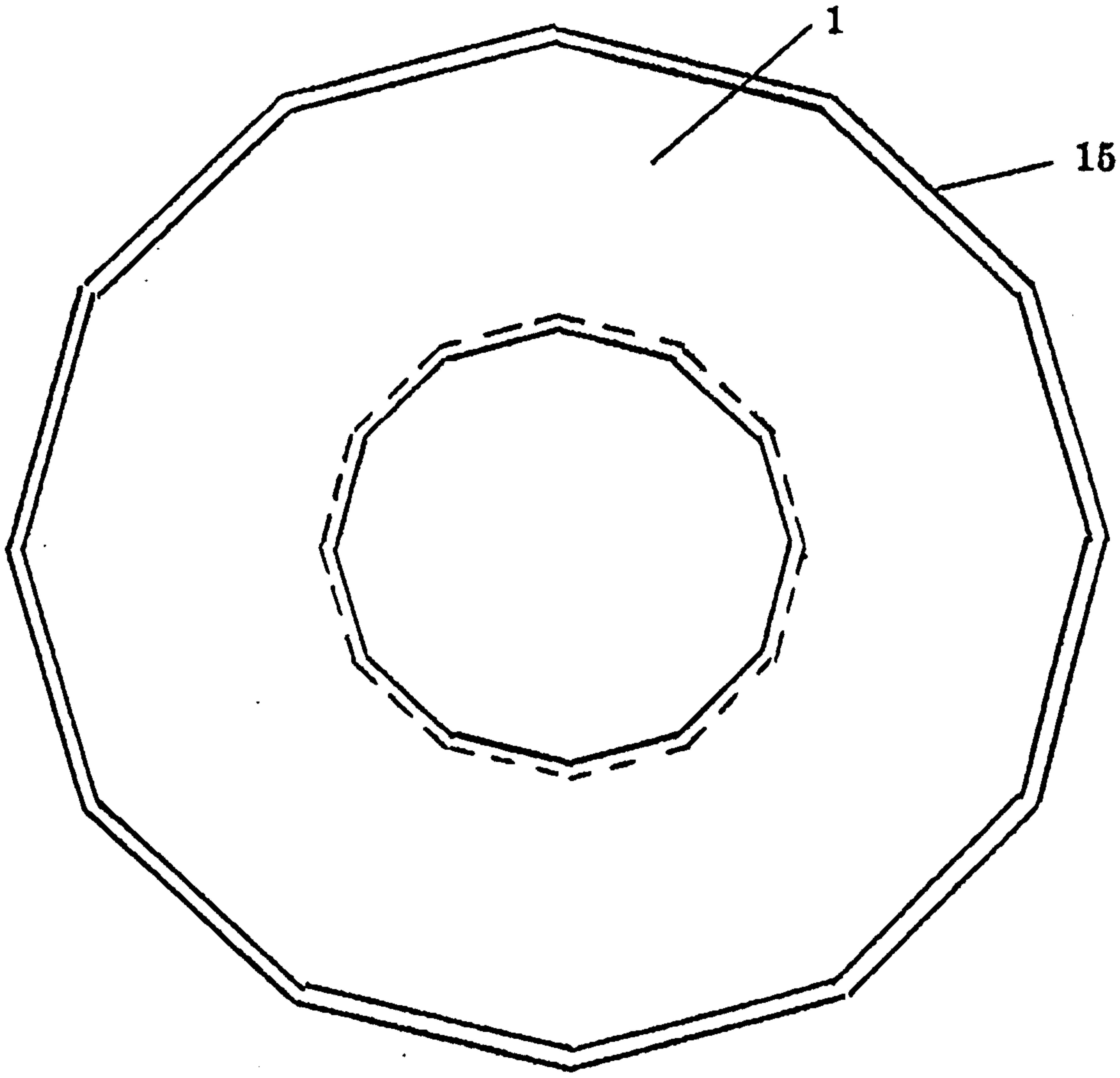


Fig. 6

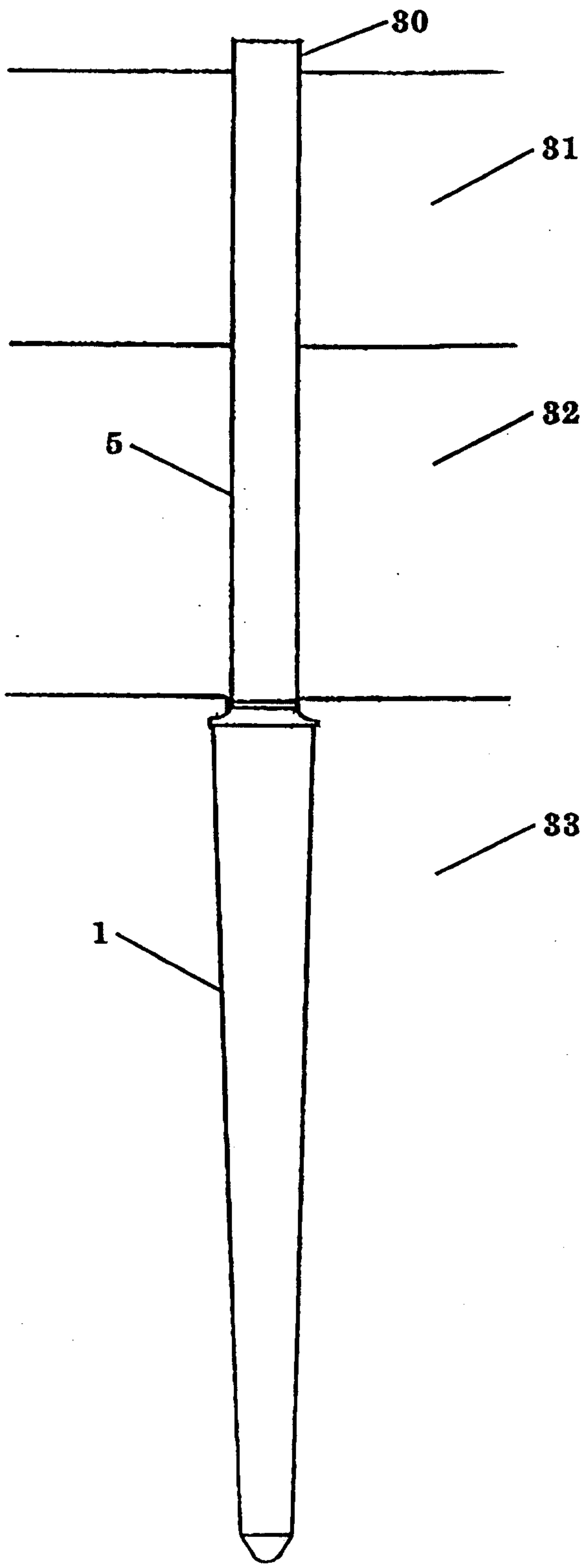


Fig. 7

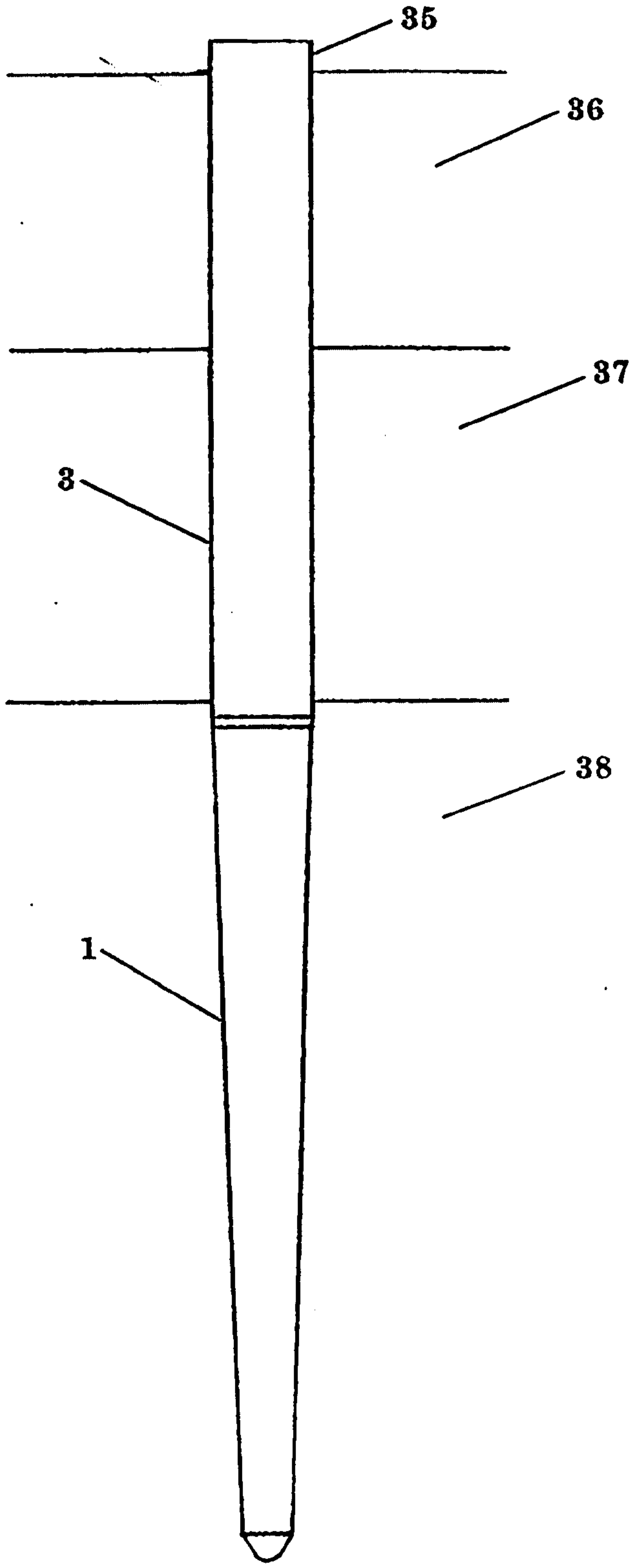


Fig. 8

Fig. 9

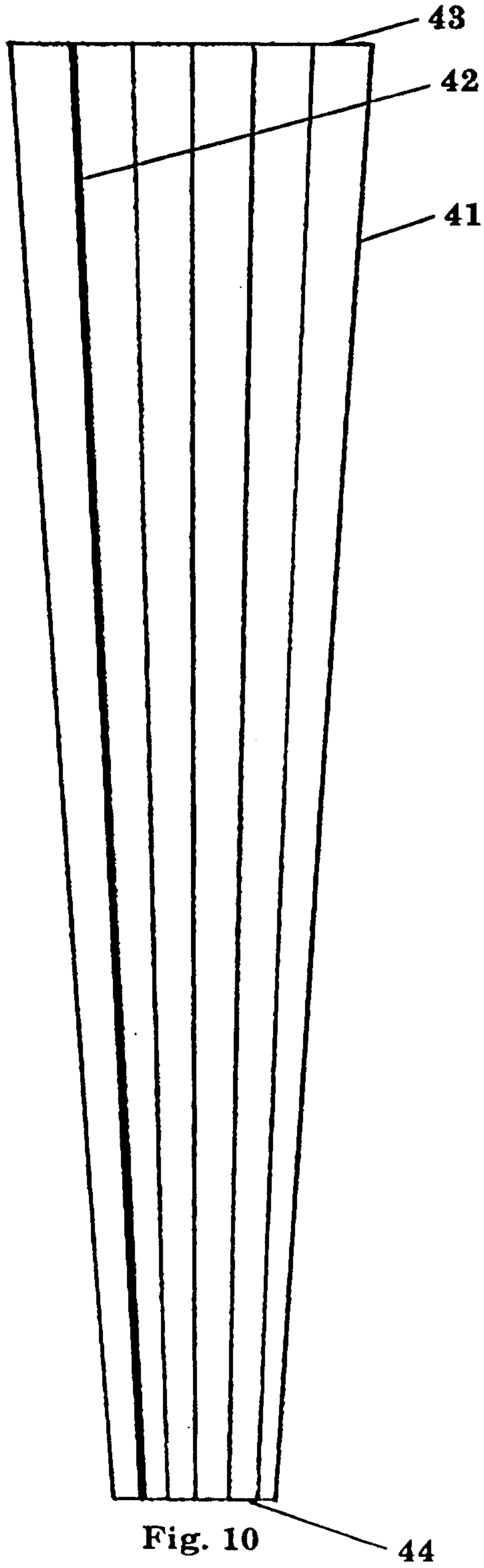


Fig. 10

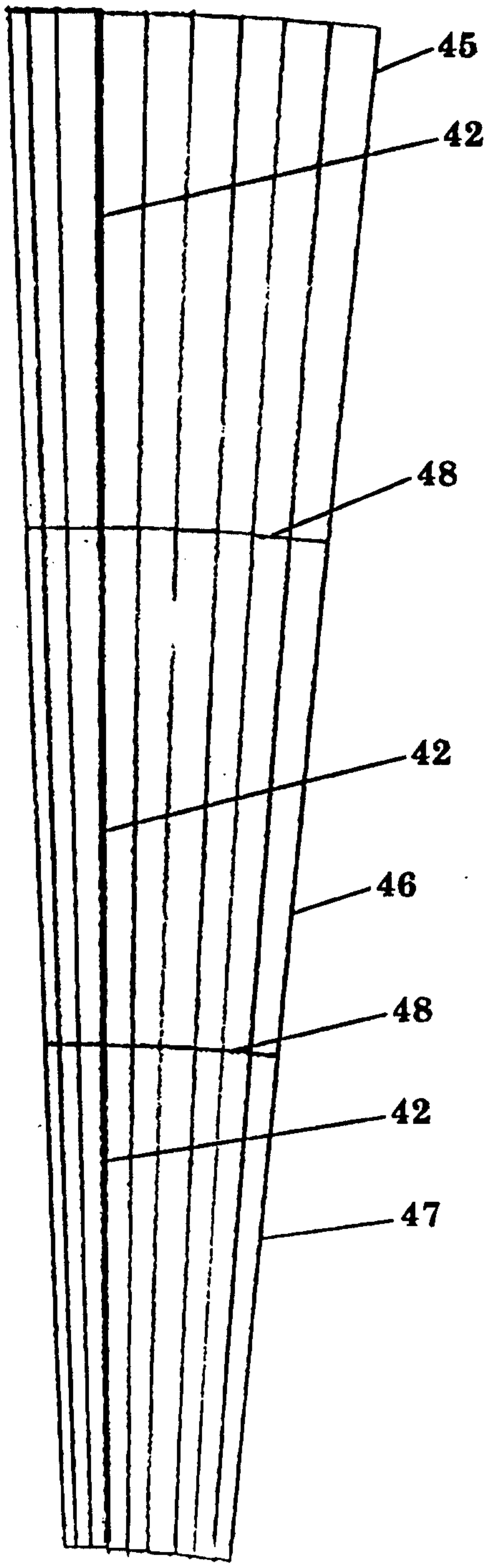


Fig. 11

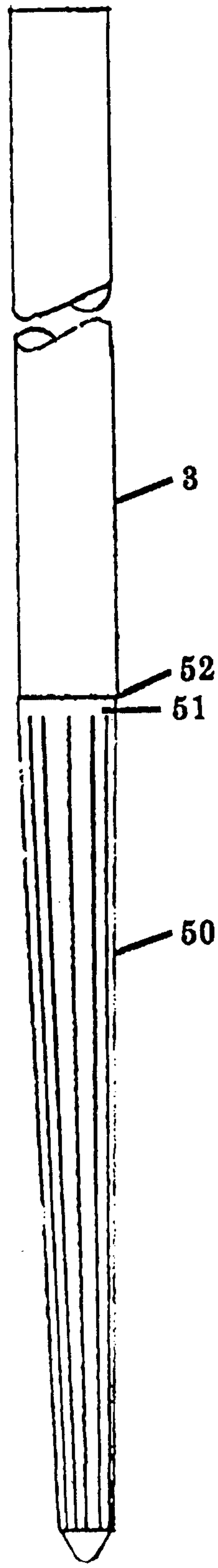


Fig 12

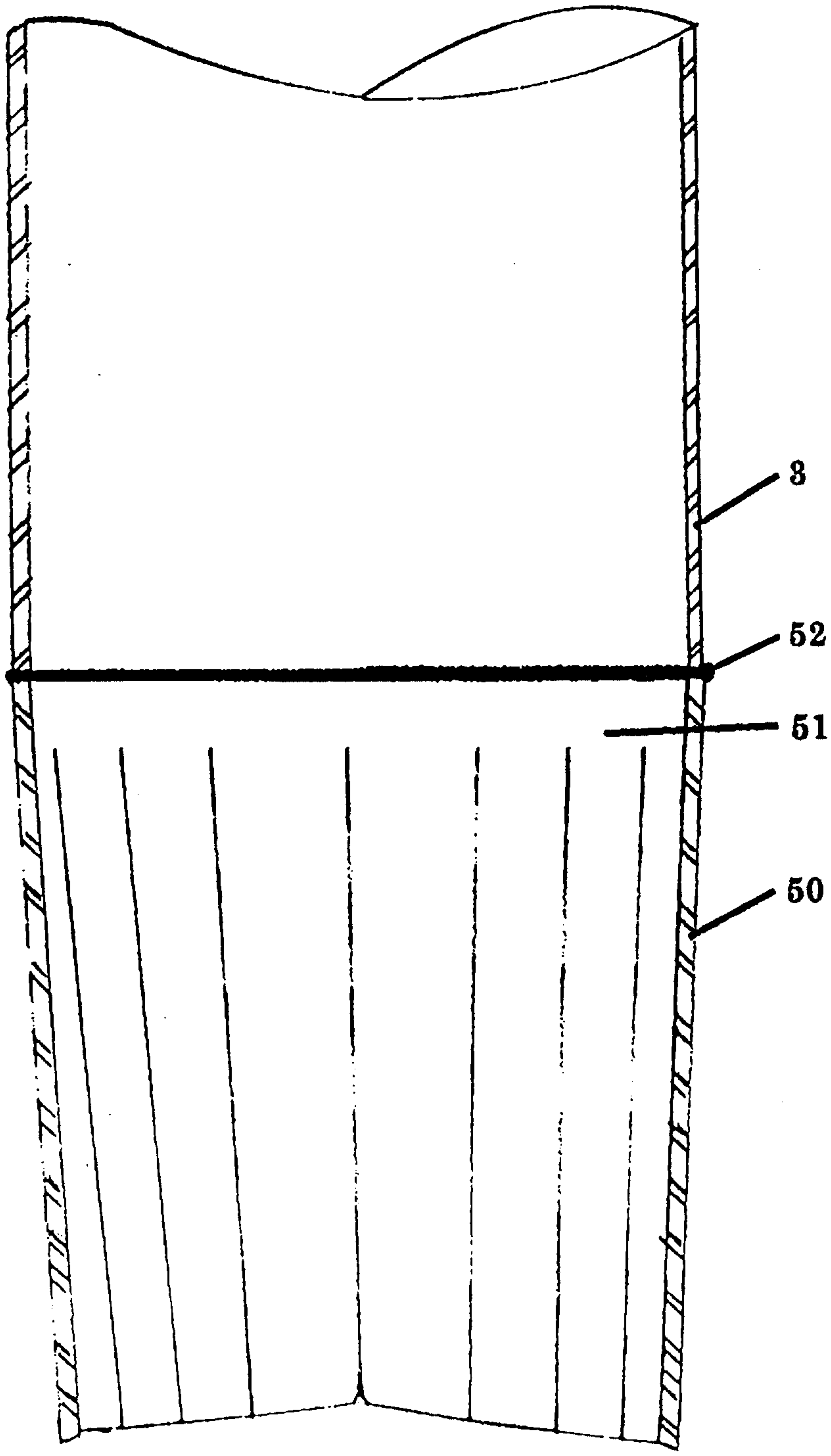


Fig 13

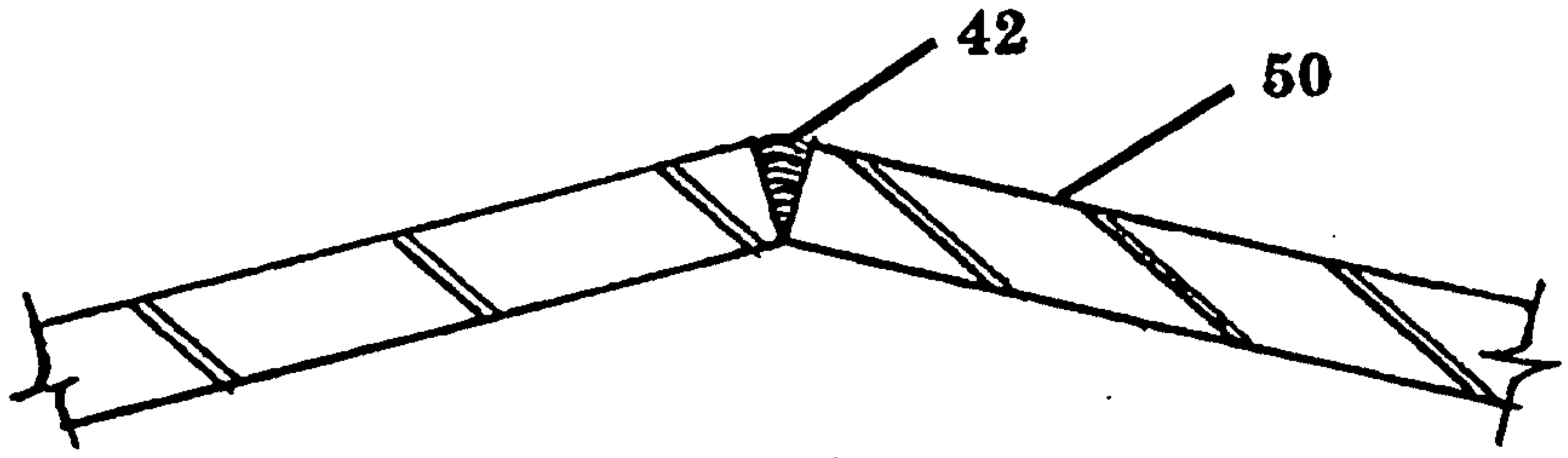


Fig. 14

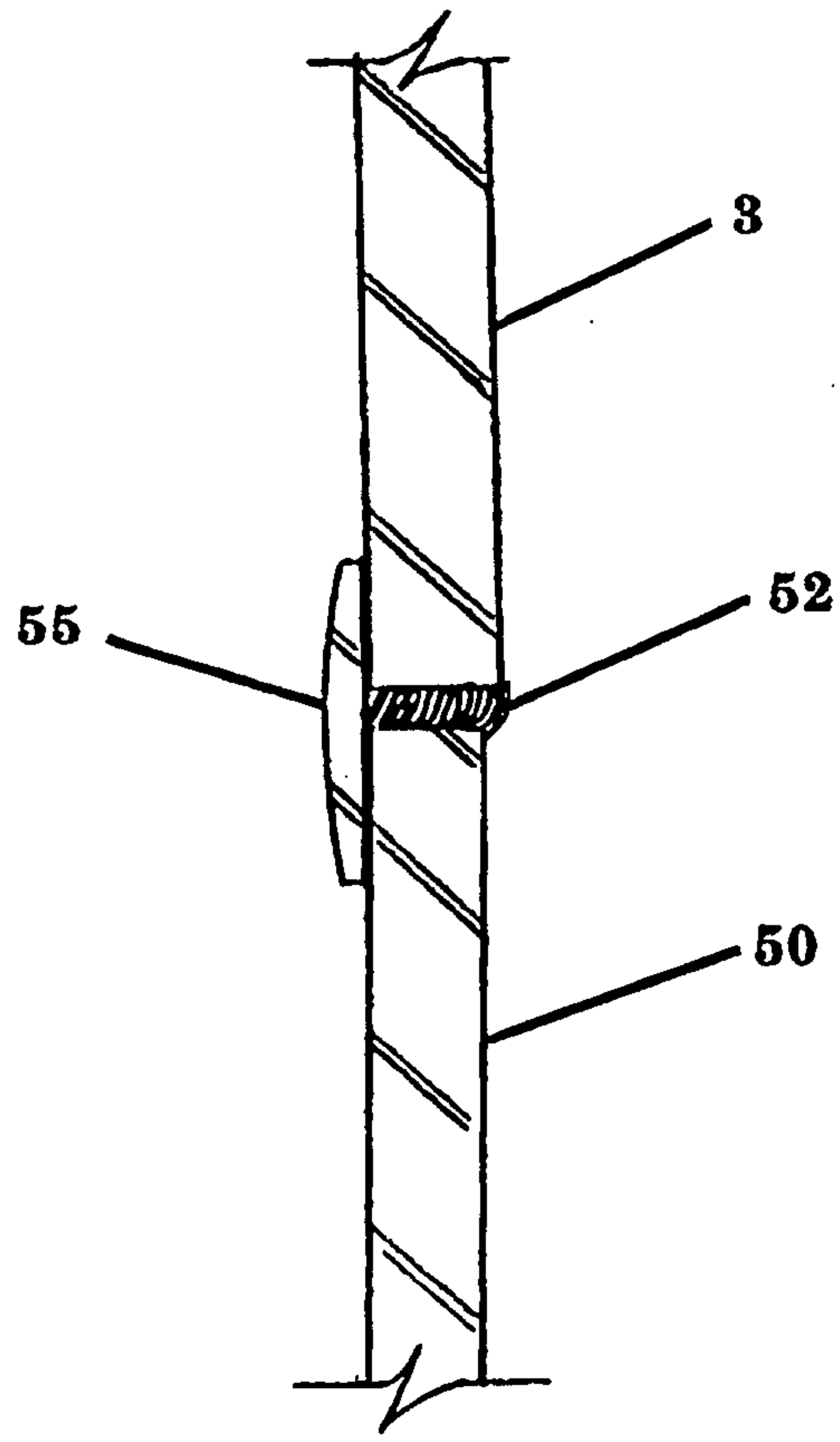
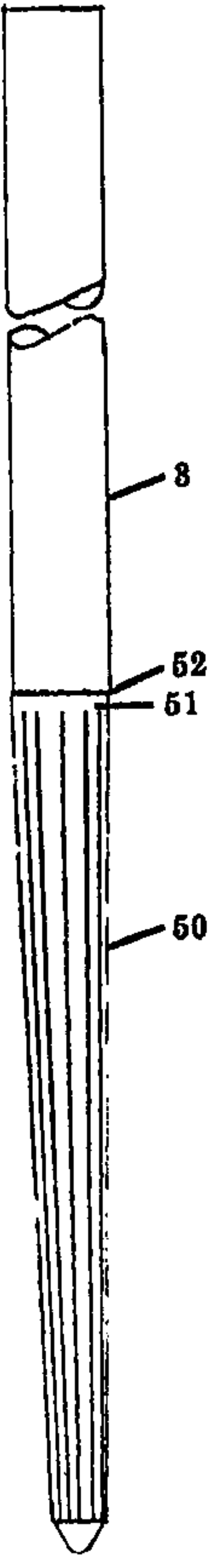


Fig. 15



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