



Helical Anchor System Technical Specifications

Shaft Material: Yield Strength = 80 ksi (minimum)

Helix Blades: ASTM A572 Grade 50

Yield Strength = 50 ksi (minimum)

Helix blade geometry in accordance with ICC-ES AC358

Helix Plate Weldment: Fillet Weld per ANSI/AWS D1.1

Welding Process: GMAW (Pulse arc)

Electrode: ER70s-6 0.045 diameter

Gas: 90% Argon, 10% CO₂

Box Connection: AISI 4125M; Q&T to HRC 28-32

Yield Strength = 107 ksi (minimum)

Pin Connection: AISI C4140; Q&T to HRC 28-32

Yield Strength = 107 ksi (minimum)

Tube/Connection Weldment: Inertia Friction Weld per ANSI/AWS

C6.1 Full Strength Metallurgical

Bond

Coupling Bolts: ASTM A325 Yield Strength = 92 ksi (minimum)

Anchor Finish: Available plain or hot-dip galvanized coating per ASTM A123



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