



ArtWeld Gabion Standard Submittal Documents

For: 9 Gauge
Black 3"x3"
Welded Wire
Mesh
100% Domestic



- Sample Certification
- Product Specification
- Standard Drawing

Click to jump to section

- Construction Guide
- Product Warranty



Oklahoma Steel and Wire

Highway 70 South
Madill, OK 73446
(580) 795-7311 (800) 654-4164 Fax (580) 795-7422

Physical Test Report

Date: 03/14/2025
 Customer Name HILFIKER CO
 Customer Address:

Customer Order Number: 01012742

PO Number: 14209

Item Number: 1048-0

Item Description: 3X3X9X9 6'X400' FC BLK

First Bundle #: 77490

Last Bundle #: 77514

Pieces Per Bundle: 1

Number of Bundles: 25

Number of Pieces: 25

Description	Original		Breaking ▯ Strength	Tensile ▯ Strength	Yield ▯ Strength	Reduced		Percent ▯ Reduction of Area	Bend ▯ Test	Weld ▯ Shear ▯ Test 1	Weld ▯ Shear ▯ Test 2	Weld ▯ Shear ▯ Test 3	Weld ▯ Shear ▯ Test 4	Required ▯ Weld ▯ Shear
	Diameter	Area	LBS	PSI	LBS	Diameter	Area							
Line Wire	0.148		1760	102306	91805	0.090	0.006	65.116	pass	1516	1297	1011	1007	602
Cross Wire	0.148	0.017	1812	105328	94828	0.089	0.006	65.116						

CHEMICAL PROPERTIES

Description	Heat Number	Carbon	Manganese	Phosphorus	Sulfur	Silicon
Line Wire	2424608	0.050	0.340	0.010	0.025	0.130
Cross Wire	2424608	0.050	0.340	0.010	0.025	0.130

This material has been produced and tested in accordance with the requirements of ASTM A-1064-14 & AASHTO M55, and we hereby certify that the above test results are representative of those obtained on the material in this shipment. All materials listed above where fabricated in the United States of America. The raw material listed above used to produce this product was melted and rolled in the United States.

Quality Manager
 Oklahoma Steel and Wire Co., Inc.

Sworn and Subscribed to before me this

14th Day of March 2025

NOTARY PUBLIC State of OK
TINO DIAZ
 Comm. # 09004486
 Expires 05-27-2025

Notary Public

My Commission Expires





ArtWeld Gabion Product Specification (Non-Galvanized Black Wire)

1.0 DESCRIPTION

This work shall consist of Hilfiker ArtWeld Gabions (welded wire mesh) and filling the gabions with rock in accordance with the details shown on the plans and these special provisions.

2.0 MATERIALS

Gabions shall be of a single unit construction. The base, ends, sides, and lid shall be fabricated from 3"x3" 9 Gauge Black Welded Wire Mesh and connected in such a manner that strength and flexibility at the connection are at least equal to that of the wire mesh. The gabions shall be fabricated in such a manner that they can be assembled at the construction site with Spiral Binders and pre-formed stiffeners to form rectangular baskets of the specified size.

The height, length, and width of the gabions shall not vary more than 5 percent from the dimensions shown on the plans.

Gabions shall be divided into cells of equal length, not more than 3 feet long, by diaphragms made of the same wire mesh as used for the gabion body. Each gabion shall be fabricated with the necessary diaphragm or diaphragms secured in proper position on the base in such a manner that no additional tying at the base will be necessary.

A Certificate of Compliance shall accompany each shipment of gabions to a job site.

Wire for the manufacture and assembly of gabions shall meet or exceed all of the following requirements:

<u>Description</u>	<u>Requirement</u>
3"x3" (9 ga. - 0.144 in. min.) Welded Wire Fabric	ASTM A1064 <i>Exception: Weld Shear at 800 lbs of force min.</i>
9 ga. Pre-Formed Stiffener	ASTM A1064
9 ga. Spiral Binder	ASTM A1064

3.0 ROCK

Rock for filling the gabions shall be as listed:

100% passing 8 inches (20.3 cm), 0-5% passing 4 inches (10.2 cm)

4.0 CONSTRUCTION

Gabions shall first be assembled individually as empty units. Each gabion shall be manufactured with the necessary panels, properly spaced and secured, so they can be rotated into position at the construction site with no additional tying of the rotation joint. The panels and diaphragms shall be rotated into position and joined along vertical edges.

When 13.5-gauge tie wire is used as the joint material, all vertical edges of each gabion panel shall first be constructed to form individual empty gabions. Simple spiraling (looping without locking) of 13.5-gauge tie wire is not permitted. For welded-mesh, the joint shall be constructed using alternating single and double half hitches (locked loops) in every mesh opening along the joint.



When 9-gauge spiral binders are used, the spiral shall be screwed into position such that it passes through each mesh opening along the joint. Both ends of all 9-gauge spiral binders shall be crimped to secure the spiral in place.

Temporary fasteners may be used to hold panels wherever gabion-to-gabion joints will be constructed. Temporary fasteners may remain in place.

4.1 Assembly of Successive Gabions (Gabion-to-Gabion Joints)

Empty gabions shall be set in place. Individually constructed empty gabions shall be joined successively to the next empty gabion with 13.5-gauge tie wire or 9-gauge spirals, before filling with rock begins. The 13.5-gauge tie wire or 9-gauge spiral binders shall secure, in one pass, all selvage or end wires of panels of all the adjacent gabions along the joint.

4.2 Assembly of Multiple Layered Gabions

Multi-layered gabion configurations can be stepped and staggered as shown on the plans or as directed by the Engineer. When constructing multi-layered gabion configurations, each layer of gabions can be joined to the underlying layer along the front and ends, or as shown on the plans.

4.3 Assembly of Single-Layered Gabions

Single-layered gabion configurations shall be butted and joined along the front, back, and ends as shown on the plans, including tops and bottoms of adjacent gabions.

4.4 Assembly of Shear Key Gabions

Shear key gabions (also called "counterforts") shall be spaced as shown on the plans. Shear key gabions shall be tied to adjacent gabions in the manner specified for "Assembly of Successive Gabions."

4.5 Modified Geometry

To match the geometry of the planned gabion configuration, or to meet specific conditions panels shall be folded, cut, and/or re-tied to dimensions shown on the plans or as approved by the Engineer.

4.6 Filling with Rock

Rock shall be placed in gabions to insure proper alignment, avoid bulges, and provide a minimum of voids. All exposed rock surfaces shall have a smooth and neat appearance. No sharp edges shall project through the wire mesh.

When constructing with 1.5-foot high or 3-foot high gabions, pre-formed stiffeners shall be used to produce a flat, smooth external surface.

Pre-formed Stiffeners shall be installed on the exposed face of the gabion prior to rock placement, two rows at 1/3 points on 3' high gabions, one row at 1/2 point in 1.5' high gabions.

When filling 3-foot high gabions, rock shall be placed in 3 nominal 12-inch layers; when filling 1.5-foot high gabions, rock shall be placed in two 9-inch layers.

The last layer of rock shall slightly overfill the gabions such that the lid will rest on rock when it is closed.



HILFIKER RETAINING WALLS

*Welded Wire Wall • Eureka Reinforced Soil
Gabion Faced M.S.E. • Reinforced Soil Embankment
ArtWeld Gabions • Spiralnail • Steepened Slope • Trinity Wall*

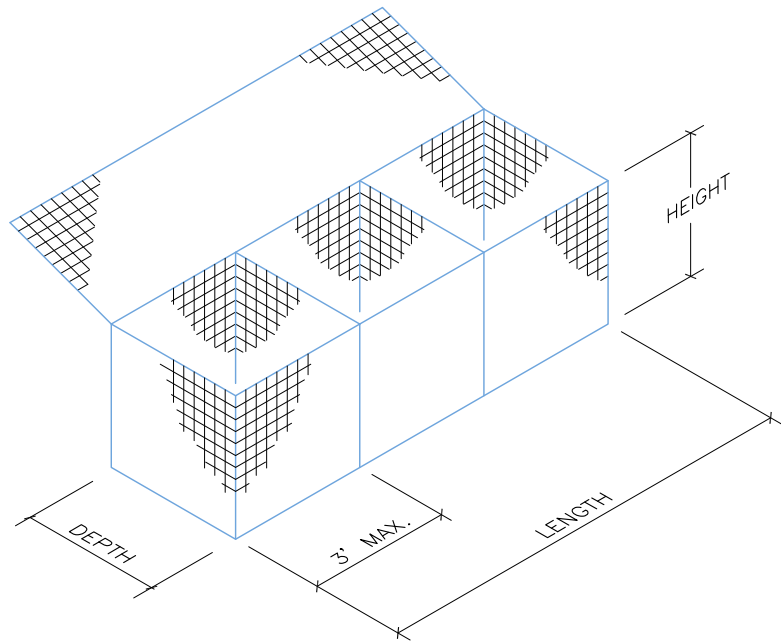
4.7 Closure of Lids

Lids shall be tied along the front, ends, and diaphragms of individual gabions and to successive gabions with 9-gauge spiral binders in the same manner as specified elsewhere in this specification.

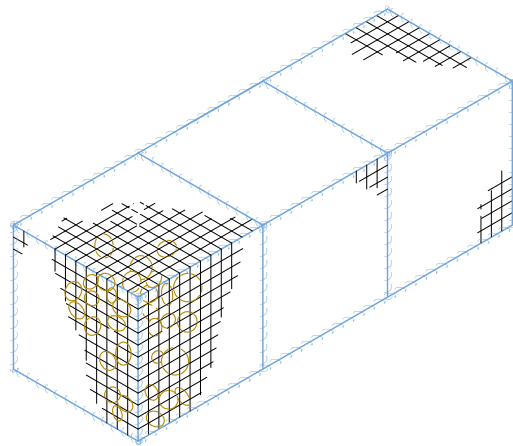
5.0 MEASUREMENT

Quantities of gabions to be paid for will be measured by the cubic yard and will be determined from the dimensions shown on the plans or the dimensions directed by the Engineer.

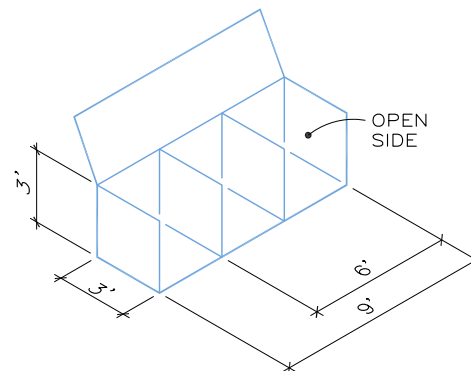
• End of Section •



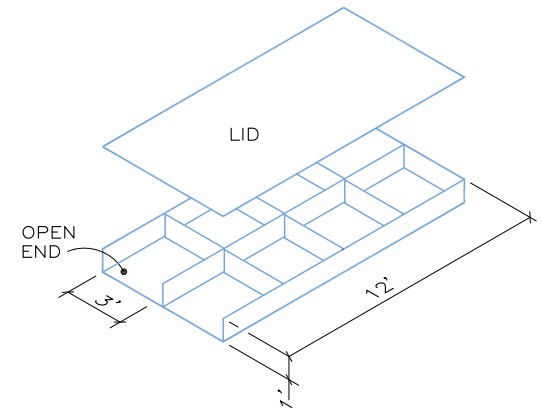
TYPICAL GABION
NOT TO SCALE



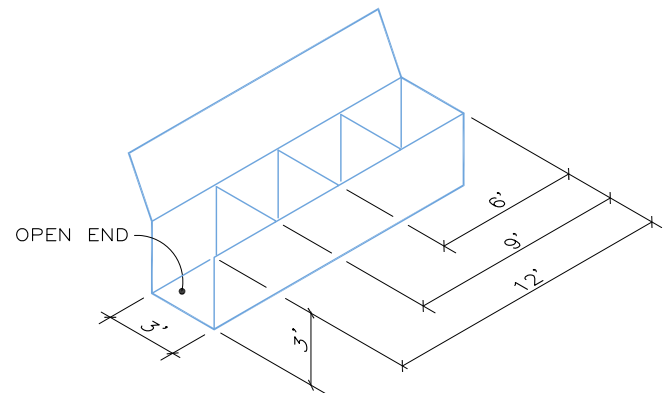
TYPICAL ASSEMBLED GABION
NOT TO SCALE



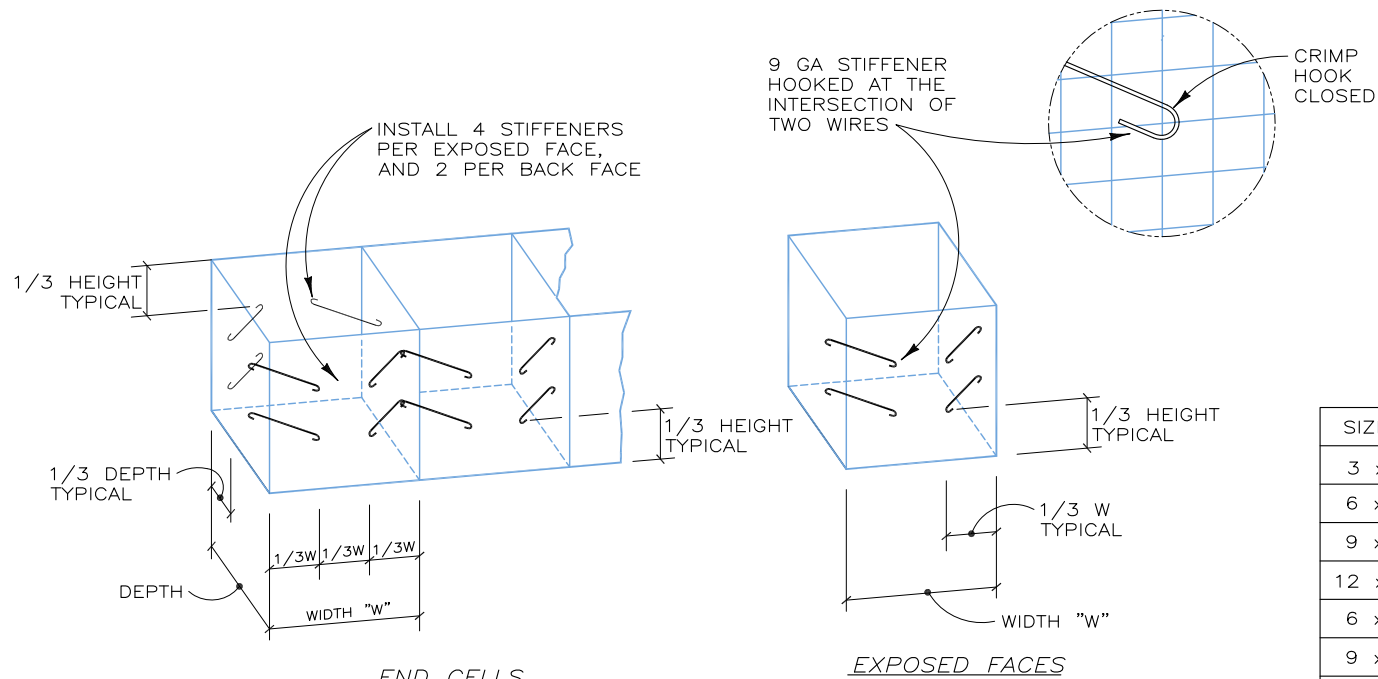
NOTE: SIZES CAN VARY
TYPICAL OPEN SIDE
NOT TO SCALE



NOTE: SIZES CAN VARY
TYPICAL MATTRESS
NOT TO SCALE



NOTE: SIZES CAN VARY
TYPICAL OPEN END
NOT TO SCALE



WHERE HEIGHT OF GABION IS 2' OR LESS, INSTALL 2 STIFFENERS PER FACE
WHERE HEIGHT IS 12", NO STIFFENERS REQUIRED

STIFFENER DETAILS
NOT TO SCALE

STANDARD GABION SIZES

SIZE LxWxH	CU.YD.	SIZE LxWxH	CU.YD.	SIZE LxWxH	CU.YD.
3 x 3 x 3	1	3 x 3 x 1.5	0.5	3 x 3 x 1	0.33
6 x 3 x 3	2	6 x 3 x 1.5	1	6 x 3 x 1	0.67
9 x 3 x 3	3	9 x 3 x 1.5	1.5	9 x 3 x 1	1
12 x 3 x 3	4	12 x 3 x 1.5	2	12 x 3 x 1	1.33
6 x 6 x 3	4	6 x 6 x 1.5	2	6 x 6 x 1	1.33
9 x 6 x 3	6	9 x 6 x 1.5	3	9 x 6 x 1	2
12 x 6 x 3	8	12 x 6 x 1.5	4	12 x 6 x 1	2.67

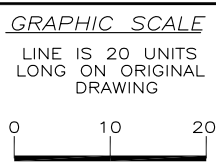
NOTES

- GABION SIZES ARE EXPRESSED IN FEET.
- MATTRESSES AND CUSTOM SIZES PROVIDED ON REQUEST.
- GABIONS WHICH ARE TO BE CONNECTED TOGETHER SIDE-TO-SIDE OR END-TO-END, MAY BE PROVIDED OPEN-SIDED OR OPEN-ENDED AS SHOWN TO REDUCE WEIGHT, COST, AND ASSEMBLY TIME.
- GABIONS ARE MANUFACTURED OF 3"x3" WELDED WIRE MESH, 9 GA. WITH 0.9 OZ/SF ZINC COATING, OR 11 GA. WITH 0.85 OZ/SF ZINC COATING. OPTIONAL 2.0 OZ/SF ZINC COATING IS AVAILABLE ON REQUEST.

COLOR COMPILED GABION DETAILS

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REV.NO.	DATE	BY	DESCRIPTION
1	6/16/98	DR	REVISED ZINC COATING THICKNESS
2	4/12/02	DR	UPDATED BORDER
3	12 SEP 07	AMJ	UPDATED BORDER, MINOR CHANGES
4	29 OCT 13	AMJ	ADDED COLOR TO DETAILS



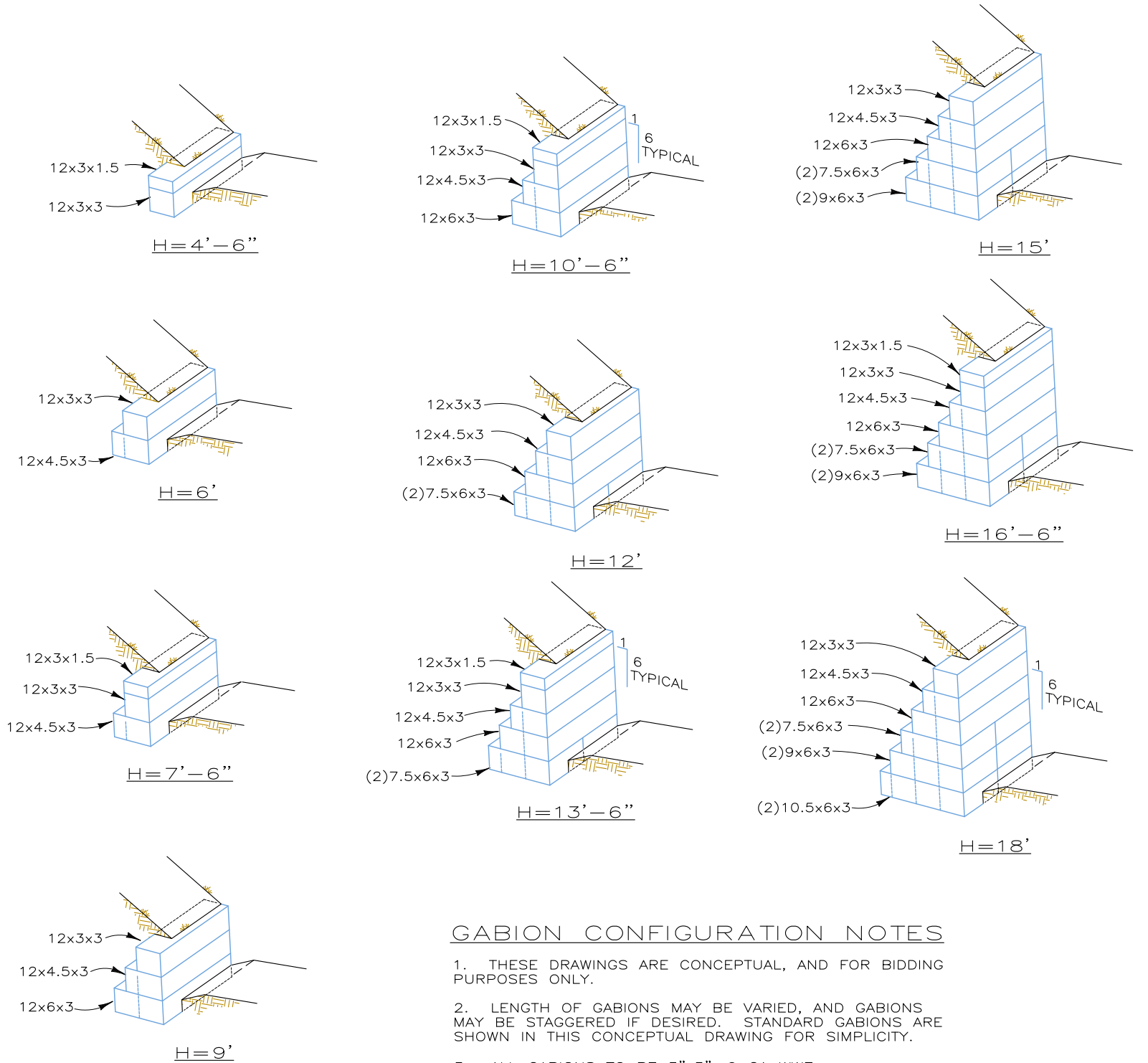
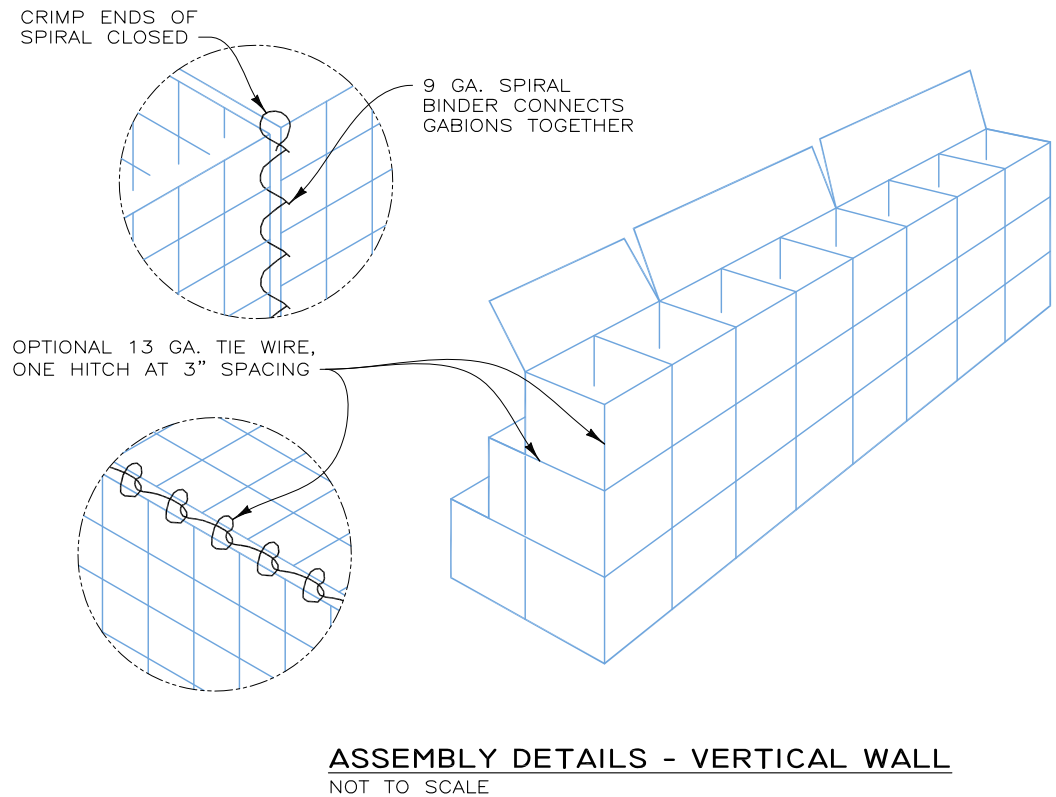
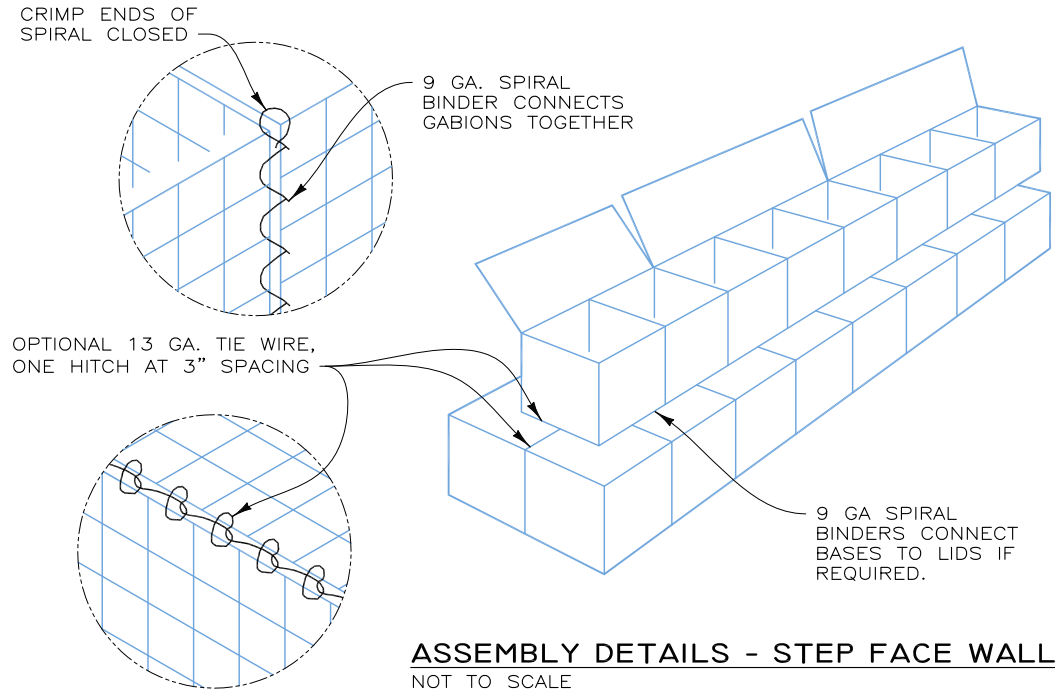
PROJ.MGR.
ENGINEER
CADD BY
HRW

HILFIKER RETAINING WALLS

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WEBSITE www.hilfiker.com E-MAIL info@hilfiker.com

DWG DATE
17 JUL 95
REVISION DATE
29 OCT 13
SCALE
NOTED

STANDARD DRAWING	PROJECT NO.
ARTWELD GABIONS	SHEET 1
DETAILS AND NOTES	OF 4

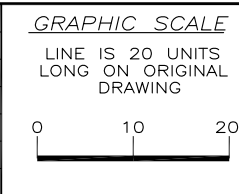


GABION CONFIGURATION NOTES

1. THESE DRAWINGS ARE CONCEPTUAL, AND FOR BIDDING PURPOSES ONLY.
2. LENGTH OF GABIONS MAY BE VARIED, AND GABIONS MAY BE STAGGERED IF DESIRED. STANDARD GABIONS ARE SHOWN IN THIS CONCEPTUAL DRAWING FOR SIMPLICITY.
3. ALL GABIONS TO BE 3"x3", 9 GA WWF.
4. FLAT 9 GA END PANELS WILL BE SUPPLIED TO CLOSE OFF OPEN ENDS OF LIDS.

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1	6/16/98	DR	REVISED ZINC COATING THICKNESS
2	4/12/02	DR	UPDATED BORDER
3	12 SEP 07	AMJ	UPDATED BORDER, MINOR CHANGES
4	29 OCT 13	AMJ	ADDED COLOR TO DETAILS



PROJ.MGR.

ENGINEER

CADD BY
HRW

HILFIKER RETAINING WALLS

HW

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SINCE 1902
QUALITY PRODUCTS

DWG DATE
17 JUL 95

REVISION DATE
29 OCT 13

SCALE
NOTED

STANDARD DRAWING
ARTWELD GABIONS
DETAILS AND NOTES

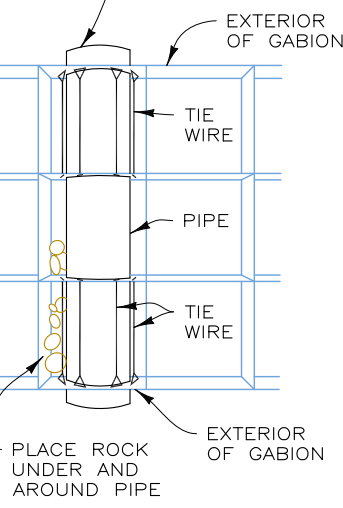
PROJECT NO.

SHEET
2
OF 4

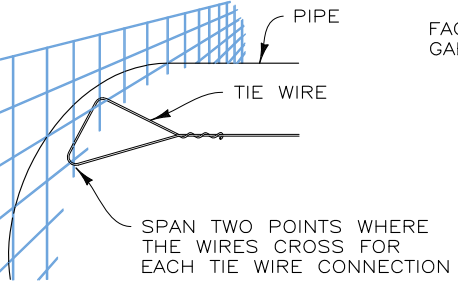
COLOR COMPILED GABION DETAILS



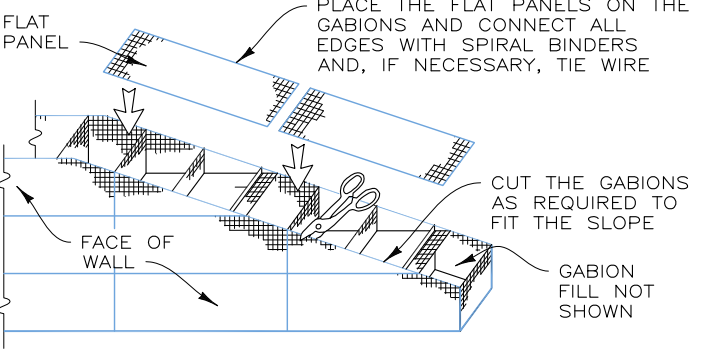
CUT A HOLE THRU THE WALLS OF THE GABION THE SAME SIZE AS THE OUTSIDE DIAMETER OF THE PIPE



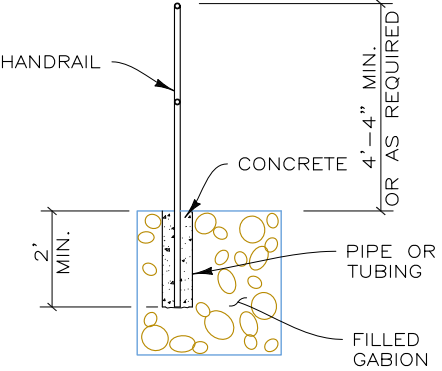
PIPE THRU GABION DETAIL
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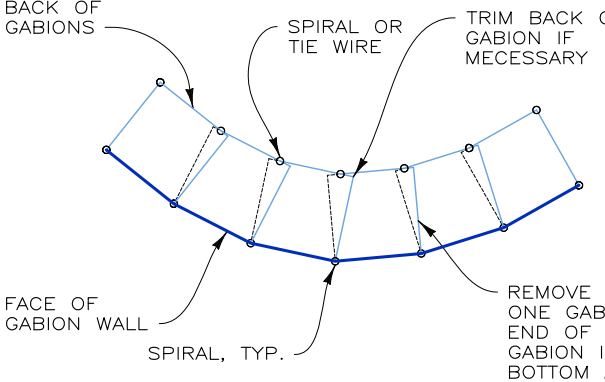
TIE WIRE DETAIL



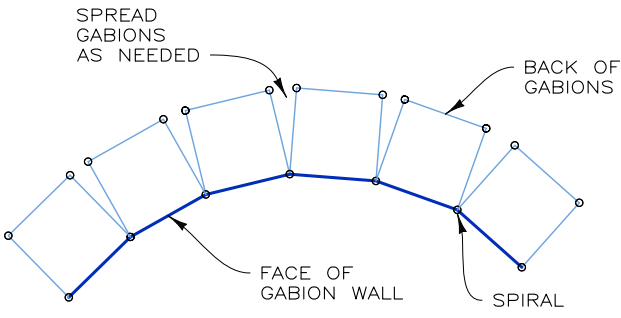
PICTORIAL ELEVATION
SLOPED GABION DETAIL
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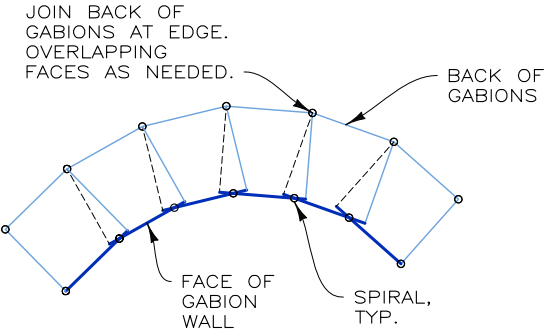
HANDRAIL ANCHORED IN GABION
NOT TO SCALE



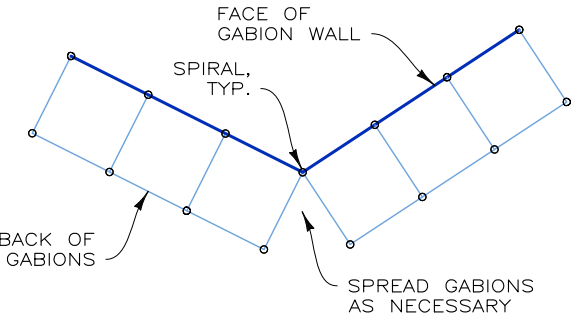
PLAN VIEW
CONVEX CURVE
NOT TO SCALE



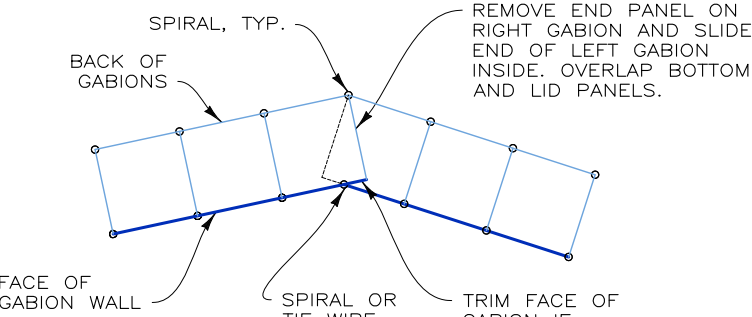
PLAN VIEW
CONCAVE CURVE
GAPPED BACK



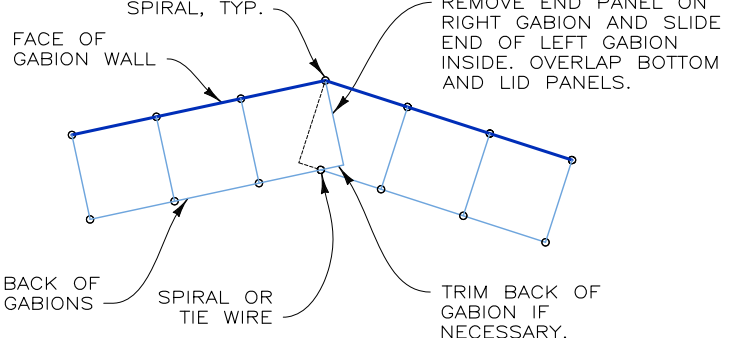
PLAN VIEW
CONCAVE CURVE
JOINED BACK



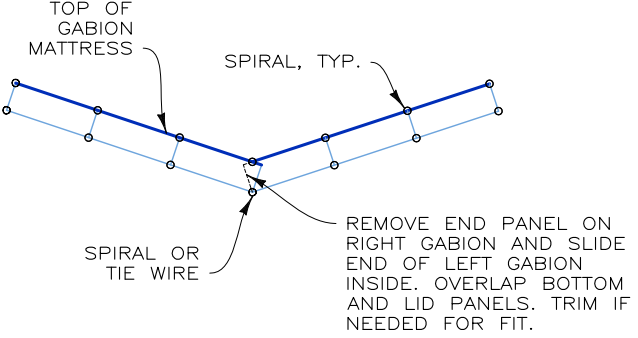
PLAN VIEW
CONCAVE ANGLE
GAPPED BACK



PLAN VIEW
CONCAVE ANGLE
NOT TO SCALE



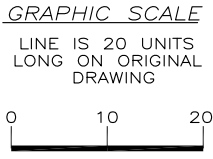
PLAN VIEW
CONVEX ANGLE
NOT TO SCALE



V-DITCH SECTION
NOT TO SCALE

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4	29 OCT 13	AMJ	ADDED COLOR TO DETAILS



PROJ.MGR.
ENGINEER
CADD BY
HRW

HILFIKER RETAINING WALLS

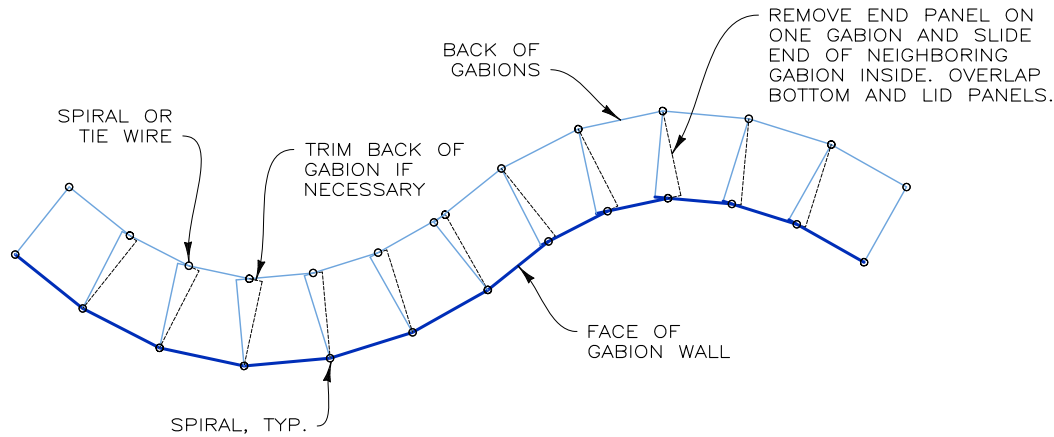
1902 Hilfiker Lane
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WEBSITE www.hilfiker.com E-MAIL info@hilfiker.com

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19 SEPT 08
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29 OCT 13
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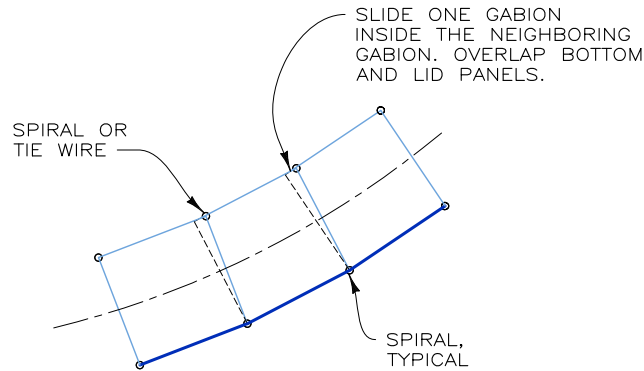
STANDARD DRAWING
ARTWELD GABIONS
MISCELLANEOUS DETAILS

PROJECT NO.
SHEET
3
OF 4

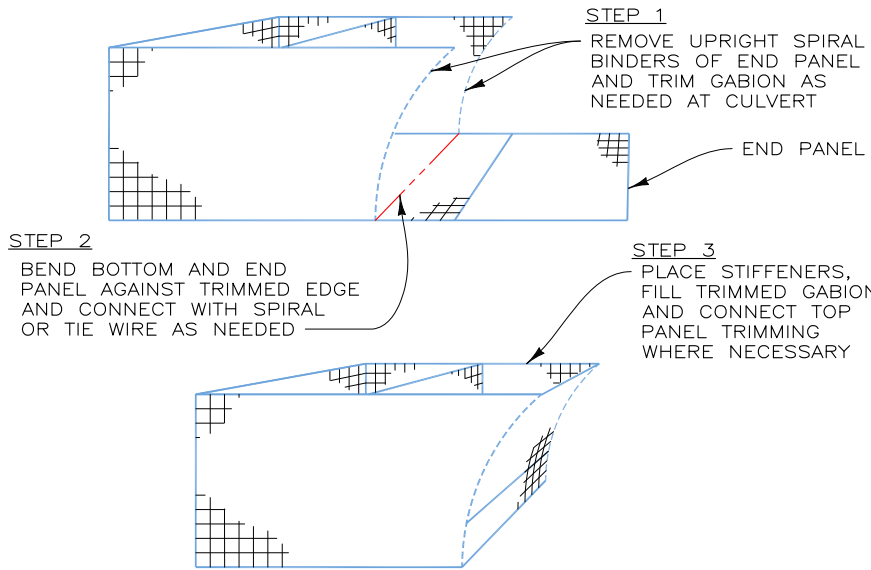
COLOR COMPILED GABION DETAILS



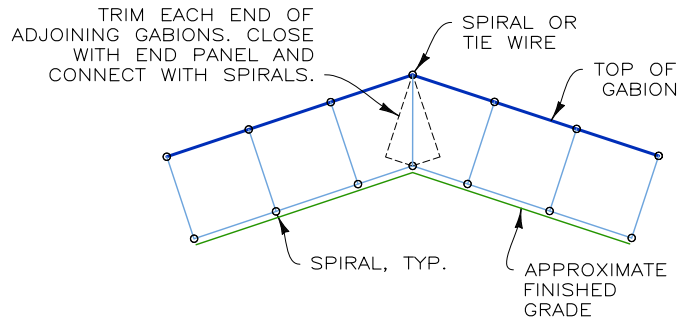
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CURVILINEAR DETAIL
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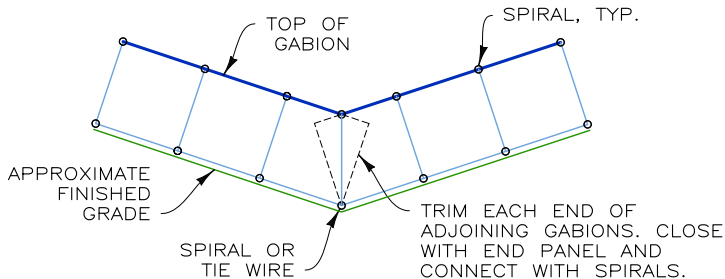
PLAN VIEW
FITTING GABIONS TO CURVE
SCALE: 1"=5'



PICTORIAL ELEVATION
TRIMMED GABION DETAIL
NOT TO SCALE



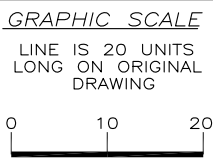
ELEVATION VIEW



ELEVATION VIEW
GABIONS ON GRADE
NOT TO SCALE

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PROJ.MGR.

ENGINEER

CADD BY
HRW

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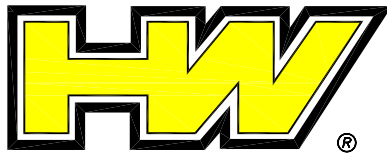
DWG DATE
19 SEPT 08

REVISION DATE
29 OCT 13

SCALE
NOTED

STANDARD DRAWING	PROJECT NO. SHEET 4 OF 4
ARTWELD GABIONS	
MISCELLANEOUS DETAILS	

ARTWELD GABIONS & GABION FACED M.S.E. Construction Guide



HILFIKER RETAINING WALLS

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Web: <http://hilfiker.com> email: info@hilfiker.com



SCAN TO VISIT OUR WEBSITE

The **ArtWeld Gabion** is named for our friend and coworker, Arthur Lee Hilfiker, who originated, developed and tested the gabions before his untimely death in June 1986. Arthur's idea was to develop a gabion that was easily shipped, quickly assembled and structurally superior to conventional gabions. He succeeded admirably.

*The possible uses of **ArtWeld Gabions** are so varied that this guide can not show them all. The purpose of this guide is to detail only the assembly process. Follow your plans for the structural design and site placement.*

ArtWeld Gabions are factory cut from galvanized or non-galvanized 3" x 3" Welded Wire Mesh. The main panel components are fastened together at our facilities with galvanized clips and spiral binders. They are then folded and shipped flat to the site. No flattening, bending, stretching or folding is required in the field. The sides are simply raised and connected together with spiral binders. Because the wire is not bent, no cracking of the galvanized coating can occur. Typically, a 6' x 3' x 3' gabion takes less than 5 minutes to make ready for filling.

The strength of Welded Wire Mesh offers many advantages. It allows careful machine filling. It is easy to hold the alignment of the face. The manufacture of large gabions is possible, up to 24' x 6' x 3', meaning fewer seams to be joined in the field. Also, if a gabion must be cut to fit site conditions, the wire can be cut with bolt cutters without losing structural strength.

ArtWeld Gabions can be manufactured in conventional sizes, or custom sizes for special site conditions. Wire diameter and thickness of galvanizing, if any, can be varied to suit job requirements.

For your next gabion project, contact Hilfiker Retaining Walls for a quote on a product we are proud to manufacture. We look forward to being of service to you and your clients.

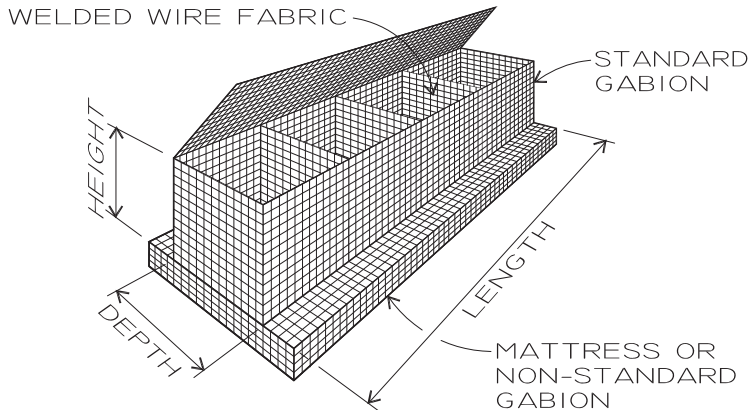
July 2014



3" = 76MM	6' = 1.83M
3' = 914MM	24' = 7.32M



ARTWELD GABIONS CAN BE MANUFACTURED IN BOTH ENGLISH AND METRIC UNITS. FOR SIMPLICITY, DIMENSIONS IN THIS GUIDE REFER ONLY TO **ENGLISH UNITS**. CONSTRUCTION METHODS FOR BOTH TYPES ARE IDENTICAL.



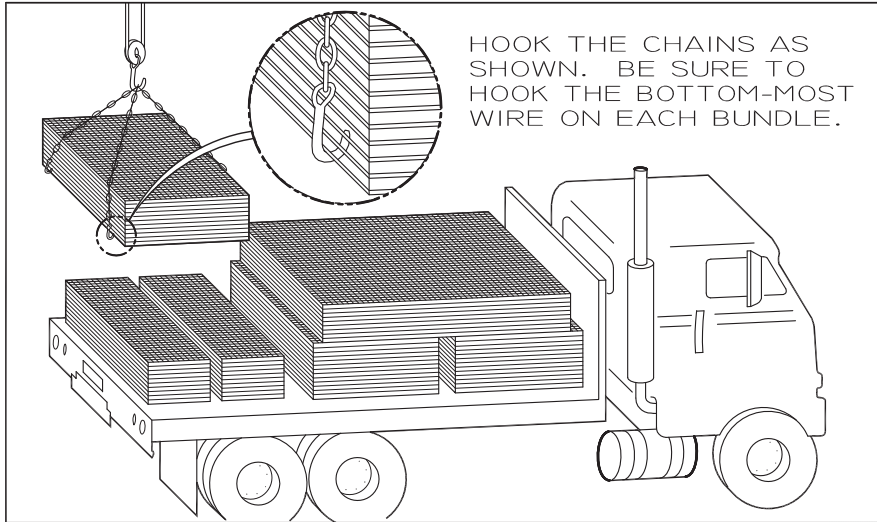
STANDARD **ENGLISH** UNIT GABIONS ARE SIZED IN MULTIPLES OF 3 FEET (0.914 METERS). THEY ARE MANUFACTURED OF 3"x3" (76MM X 76MM) WELDED WIRE FABRIC.

BOTH ENGLISH UNIT AND METRIC UNIT GABIONS ARE SUPPLIED IN 9 GA AND 11 GA GALVANIZED, AND 9 GA NON-GALVANIZED WELDED WIRE FABRIC.

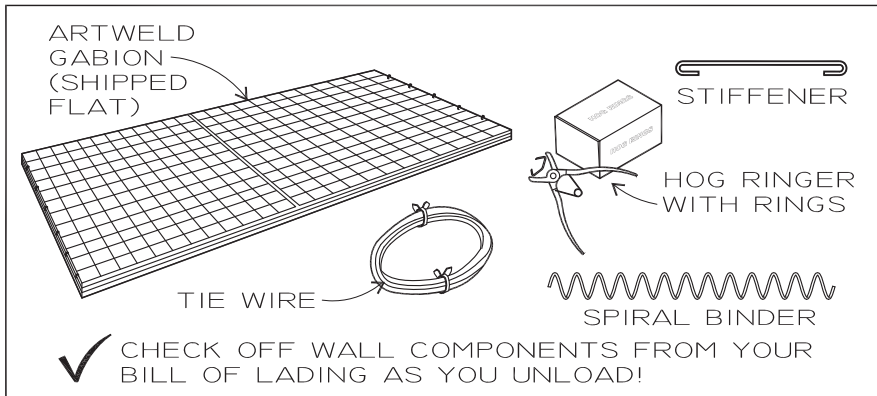
NON-STANDARD SIZES, AND MATTRESSES, CAN BE SPECIAL-ORDERED TO FIT PROJECT REQUIREMENTS.

*HILFIKER NO LONGER OFFERS METRIC SPACING. WE WILL ATTEMPT TO MATCH THE OVERAL METRIC DIMENTIONS THE BEST WE CAN WITH IMPERIAL UNITS.

RECOMMENDED UNLOADING PROCEDURE

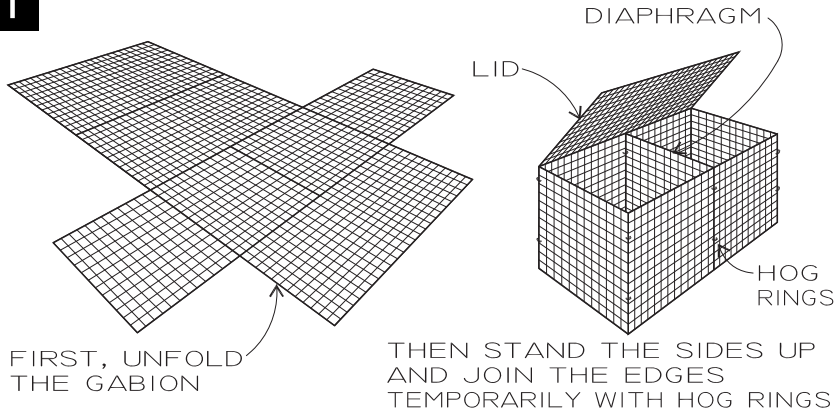


GABION PARTS (NOT TO SCALE)

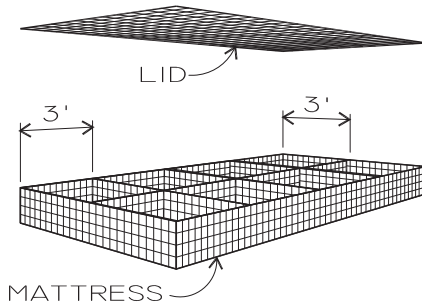


ON-SITE ASSEMBLY

1



THIS GUIDE SHOWS ASSEMBLY WITH HOG RINGS AND SPIRAL BINDERS BECAUSE THAT IS THE EASIEST AND FASTEST ASSEMBLY METHOD.



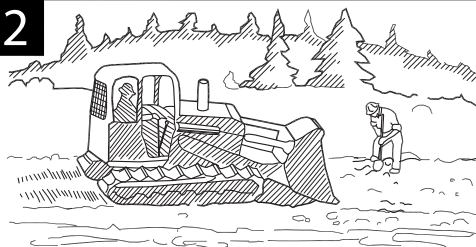
YOU MAY USE TIE WIRE AND HALF-HITCH LACING FOR ALL CONNECTIONS IF DESIRED.

HOG RINGS ARE **NOT** PERMANENT CONNECTIONS AND MUST BE FOLLOWED BY SPIRAL BINDERS OR TIE WIRE.

LIDS ARE NOT FACTORY ATTACHED ON GABIONS WIDER THAN 3'.



2

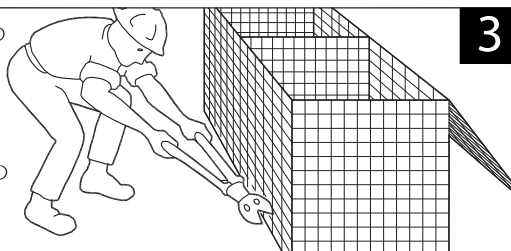


EXCAVATE AND FINE-
GRADE THE
FOUNDATION.

FOUNDATION MUST
BE REASONABLY
LEVEL AND
CAPABLE OF
SUPPORTING
IMPOSED LOADS

GABIONS MAY BE FIELD
CUT TO FIT CURVES,
CULVERTS OR ANGLES.

RECONNECT THE ENDS
OF THE GABIONS THE
SAME WAY YOU WOULD
ASSEMBLE AN UNCUT
GABION



3

4

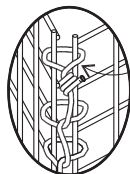
CLIP
TOP
EDGES
OF THE
BASKETS
TOGETHER
WITH HOG
RINGS

USE ONE SPIRAL
AT *EVERY*
VERTICAL
CONNECTION.

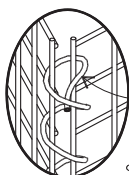
BIND ALL
EXTERIOR
CORNERS &
DIAPHRAGMS

PLACE THE FIRST
COURSE OF
GABIONS ON THE
FOUNDATION.

YOU MAY CLIP THE
SIDES TOGETHER
WITH HOG RINGS
TO HOLD THEM
TEMPORARILY.



IF YOU ARE
USING TIE
WIRE, USE
HALF-HITCH
LACING AT 3"



CRIMP
ENDS
OF ALL
SPIRAL
BINDERS

PERMANENTLY
BIND THE GABIONS
TOGETHER AS
SHOWN FOR THE
FULL HEIGHT
AT ALL CORNERS
AND DIAPHRAGMS.



STIFFENER INSTALLATION

5

BEFORE FILLING, INSTALL STIFFENERS ACROSS THE CORNERS OF THE GABIONS ON ALL EXTERIOR SIDES OF THE STRUCTURE

NO STIFFENERS IN INTERIOR CELLS

FACE OF STRUCTURE

STIFFENER

1/3 (1' MAX)

1/3 (1' MAX)

1/3 (1' MAX)

TWO ROWS OF STIFFENERS MINIMUM (4 PER CELL) ARE REQUIRED AT ALL EXTERIOR SIDES

END OF STRUCTURE

6

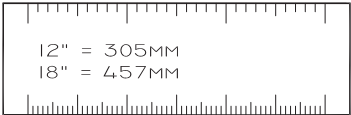
18" & 24" GABIONS REQUIRE ONLY ONE ROW OF STIFFENERS

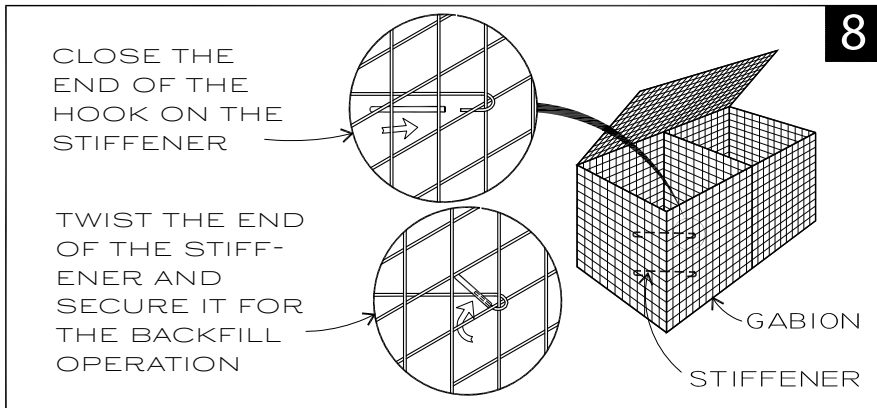
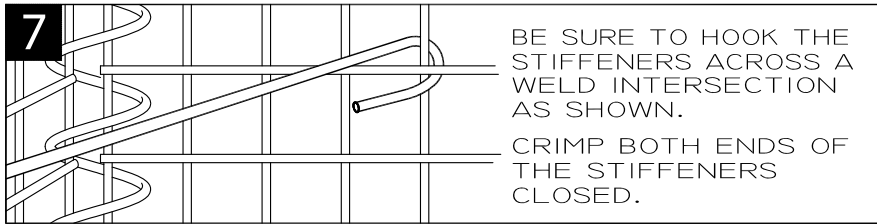
1/2

1/2

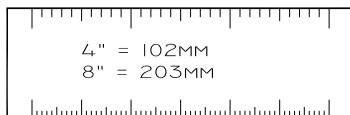
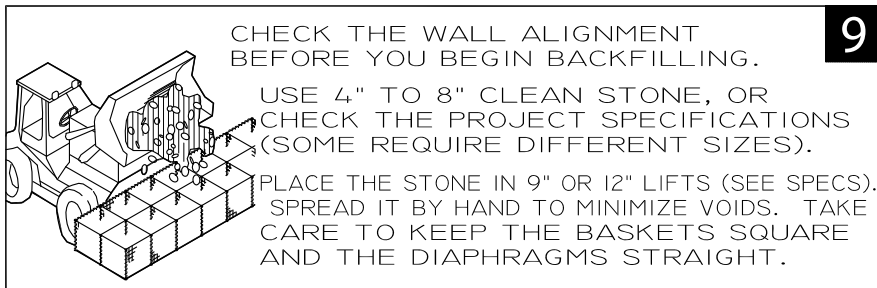
A 12" GABION DOES NOT REQUIRE STIFFENERS

12"



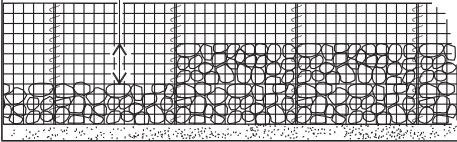


BEGIN THE FILL



10

12" MAXIMUM
RECOMMENDED

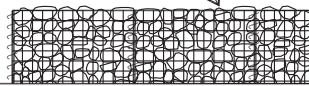


IT IS RECOMMENDED
THAT THE FILL IN ANY
CELL NEVER BE MORE
THAN 12" HIGHER
THAN THE FILL IN
AN ADJOINING CELL.

11

CONTINUE FILLING THE GABIONS
IN 12" LIFTS UNTIL THEY ARE
FILLED. FILL FLUSH OR SLIGHTLY
ABOVE THE TOP OF THE GABION.

FLUSH



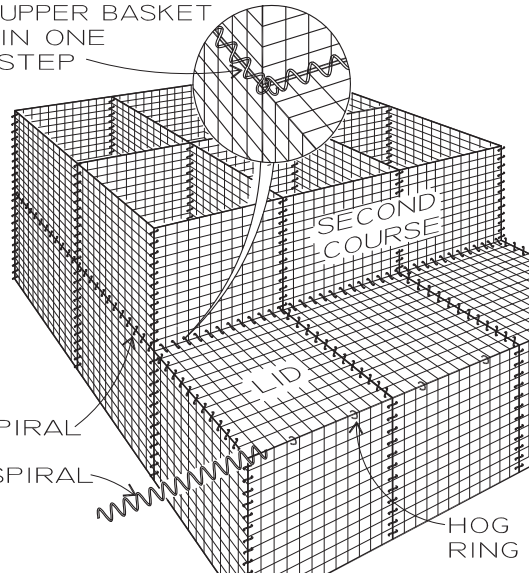
LOWER THE LIDS.
YOU MAY USE HOG
RINGS FOR
TEMPORARY
CONNECTIONS.
INSTALL SPIRALS
AT ALL PERIMETER
AND DIAPHRAGM
EDGES.

PLACE THE NEXT
COURSE OF GABIONS.
USE SPIRALS TO
PERMANENTLY BIND
THE FRONT, BACK
AND SIDES TO THE
FILLED GABIONS
OR PER THE PROJECT
SPECIFICATIONS.

REPEAT STEPS ④
THRU ⑫ TO
THE TOP OF THE
STRUCTURE.

ONE SPIRAL MAY BE USED
TO CONNECT THE LID AND
UPPER BASKET
IN ONE
STEP

12



12" = 305MM

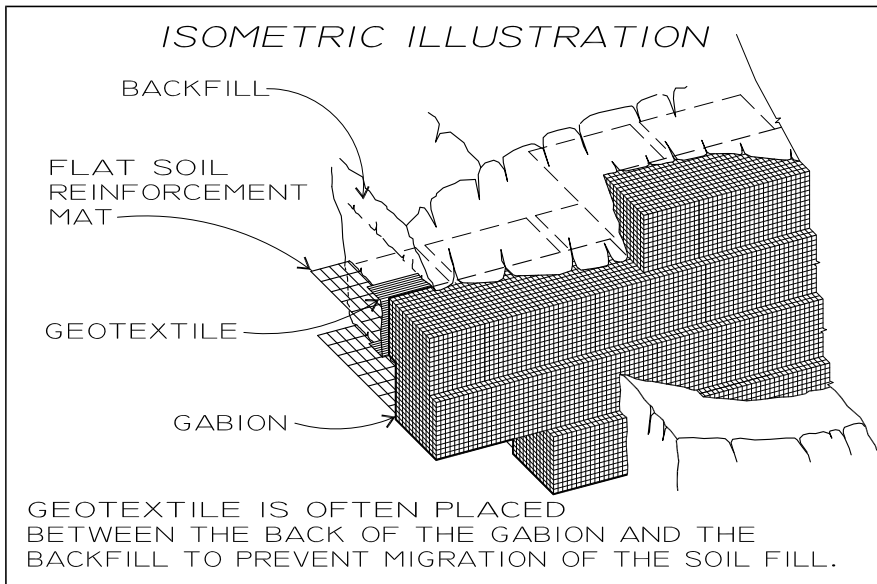
NOTES

GABION-FACED M.S.E. WALL

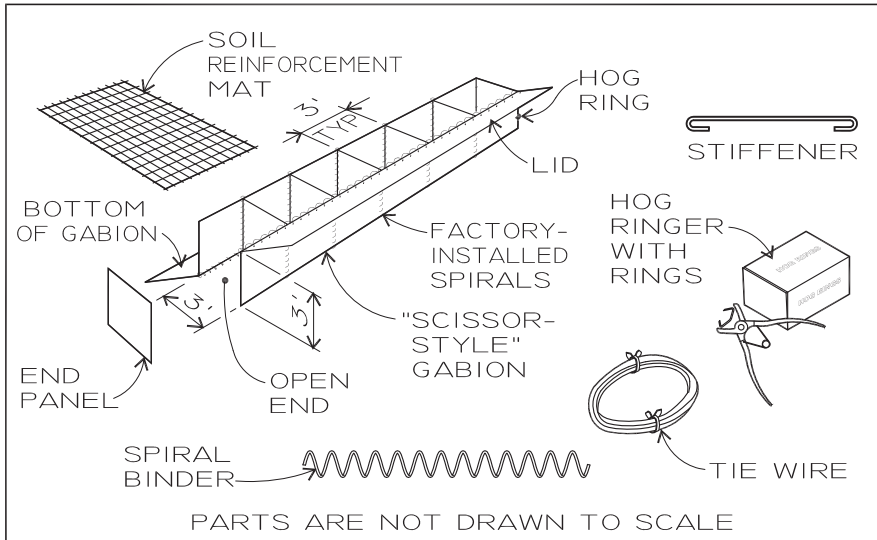
The Hilfiker Gabion Faced M.S.E. Wall combines **ArtWeld Gabions** at the face of the structure, with welded wire soil reinforcement mats spaced vertically at 3-foot intervals.

The "scissor-style" gabions are manufactured in lengths up to 18 feet. "Scissor-style" refers to the folding pattern of the gabions. They are partially pre-assembled at our factory, with the vertical edges of the diaphragms permanently connected to the vertical faces, and the lid and bottom panels connected to the main body along one long side. They are folded flat for shipment.

The wire gauge and length of the welded wire soil reinforcement mats will vary as required for each specific site.

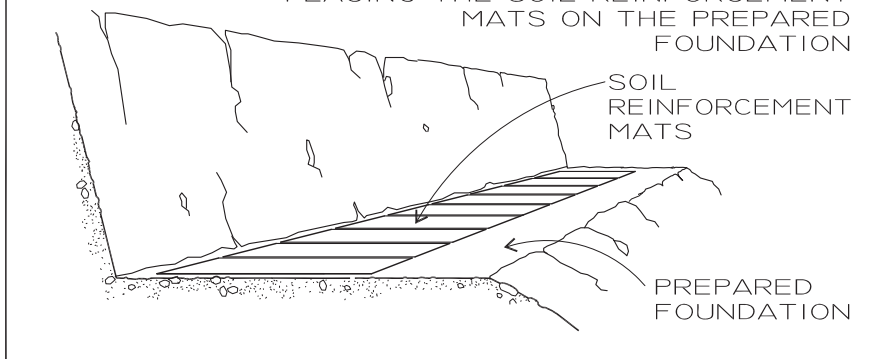


GABION FACED M.S.E. WALL PARTS



13

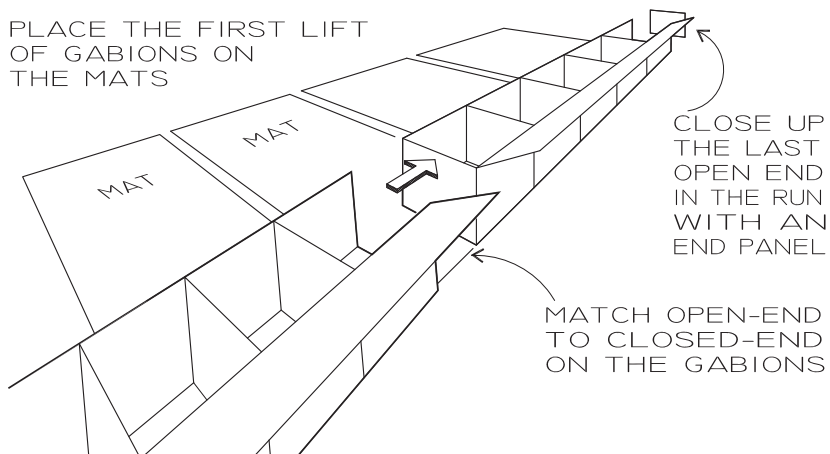
BEGIN THE GABION FACED M.S.E. WALL BY PLACING THE SOIL REINFORCEMENT MATS ON THE PREPARED FOUNDATION



14

UNFOLD THE GABIONS AND CLOSE THE BOTTOM PANELS. YOU CAN CLIP THEM TEMPORARILY WITH HOG RINGS.

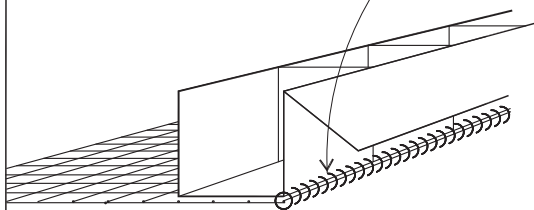
PLACE THE FIRST LIFT OF GABIONS ON THE MATS



15

LINE UP THE BOTTOM FACE OF THE GABION WITH THE FIRST TRANSVERSE WIRE ON THE MAT.

SPIRAL THE BOTTOM FACE OF THE GABION TO THE FIRST TRANSVERSE WIRE ON THE MAT

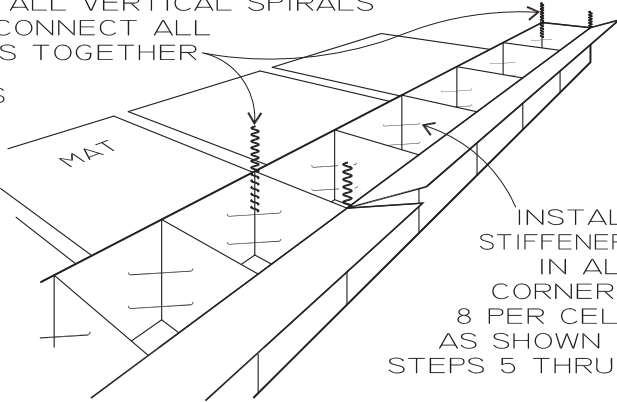
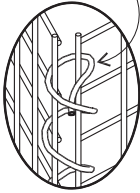


THE SPIRAL WILL PERMANENTLY CONNECT THE BOTTOM OF THE GABION TO THE FRONT, AND CONNECT THE GABION TO THE MAT IN ONE STEP

16

INSTALL VERTICAL SPIRALS
TO CONNECT ALL
ENDS TOGETHER

CRIMP ENDS
OF ALL
SPIRALS
CLOSED



INSTALL
STIFFENERS
IN ALL
CORNERS,
8 PER CELL,
AS SHOWN IN
STEPS 5 THRU 8

BEGIN THE BACKFILL

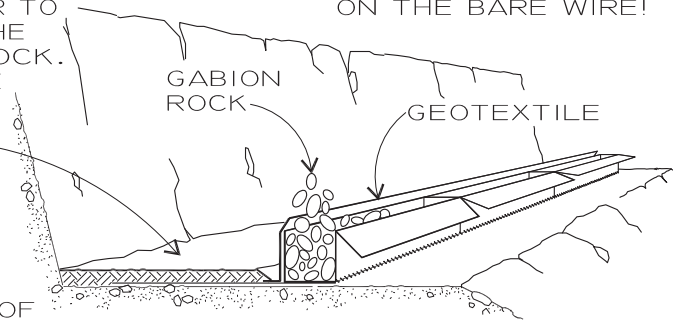
INSTALL GEOTEXTILE AGAINST THE
BACK OF THE GABIONS.

17

PLACE AND COMPACT A LIFT
OF BACKFILL OVER THE
MATS PRIOR TO
PLACING THE
GABION ROCK.
PLACE THE
THE ROCK
AS SHOWN
IN STEPS
9 TO 11.

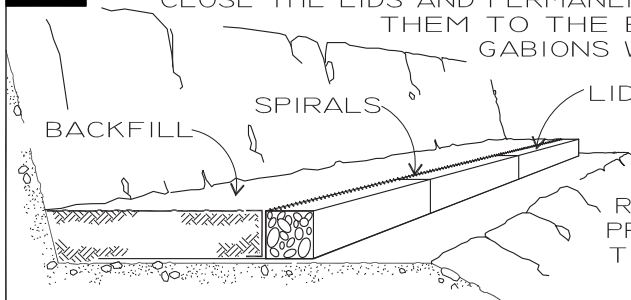
DO NOT OPERATE
HEAVY EQUIPMENT
ON THE BARE WIRE!

NEVER
BACKFILL
AGAINST
THE BACK OF
AN EMPTY BASKET



18

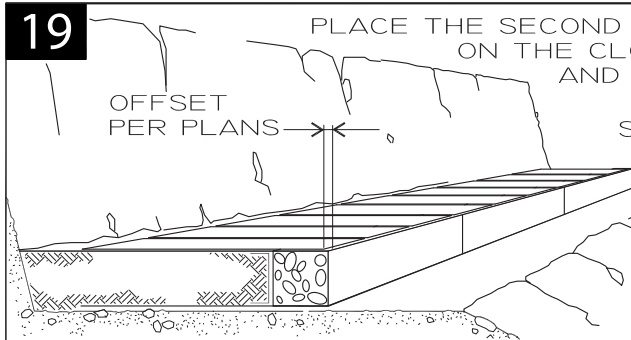
WHEN THE GABIONS ARE FILLED WITH ROCK, CLOSE THE LIDS AND PERMANENTLY CONNECT THEM TO THE BACK OF THE GABIONS WITH SPIRALS.



COMPLETE THE SOIL BACKFILL AND COMPACTION AS REQUIRED IN THE PROJECT PLANS TO THE TOP OF THE BASKETS

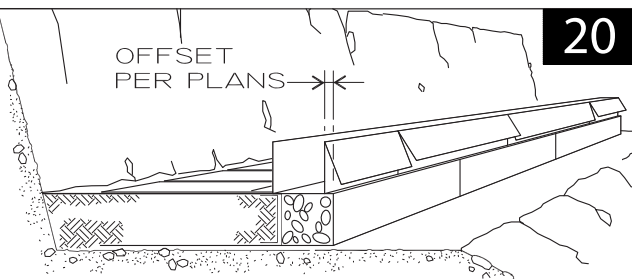
19

PLACE THE SECOND LIFT OF MATS ON THE CLOSED GABIONS AND THE BACKFILL



SET THE FIRST TRANSVERSE WIRE ON THE MATS 6" BACK FROM THE FACE OF THE GABIONS. SEE STEP 21.

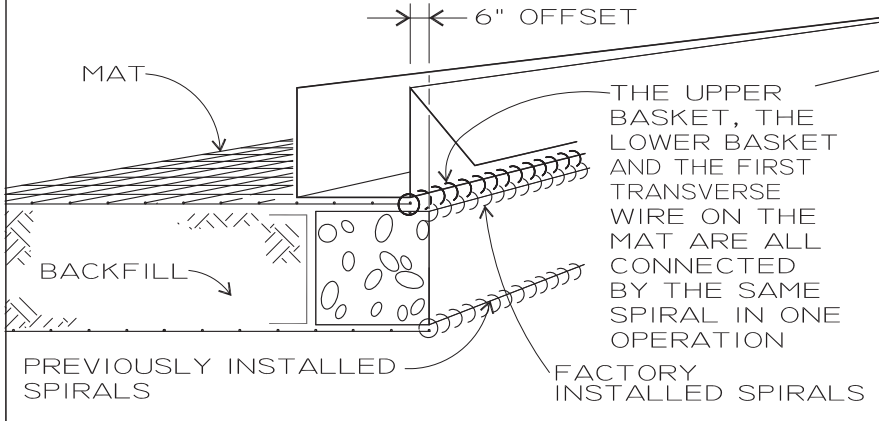
PLACE THE SECOND ROW OF GABIONS ON THE MATS, WITH THE FRONT FACE OFFSET FROM THE GABIONS BELOW



20

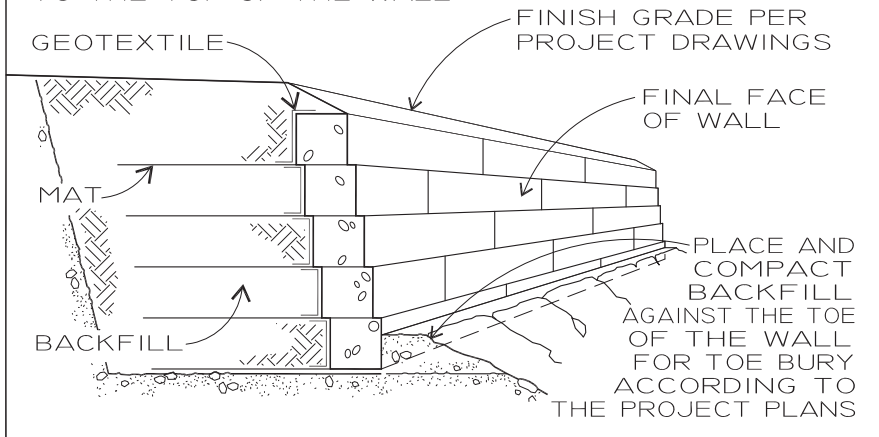
21

PERMANENTLY CONNECT THE GABIONS AND MATS WITH SPIRALS AS SHOWN.



22

CONTINUE STEPS 16 THRU 21 TO THE TOP OF THE WALL



FORMING ANGLES WITH GABIONS

TO FORM A CONVEX ANGLE (PLAN VIEW LOOKING DOWN ON THE WALL)

TRIM THE BACK OF
THE GABION IF
NECESSARY

SPIRAL
OR TIE
WIRE

BACK OF
GABION
WALL

REMOVE THE
END PANEL ON
THE LEFT GABION
AND SLIDE THE
END OF THE RIGHT
GABION INSIDE. OVERLAP
THE BOTTOM AND LID PANELS

SPIRAL

FACE OF
GABION
WALL

TO FORM A CONCAVE ANGLE (PLAN VIEW LOOKING DOWN ON THE WALL)

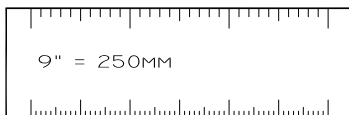
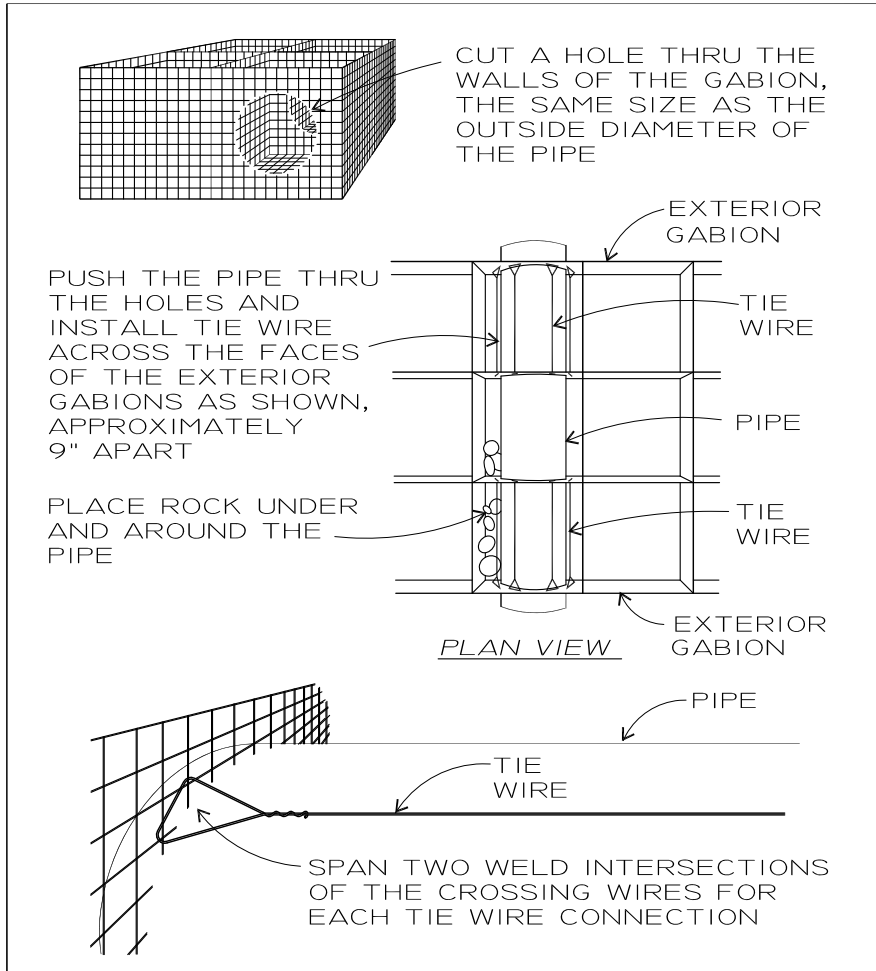
SPREAD THE GABIONS
APART AS NECESSARY

BACK OF
GABION
WALL

SPIRAL

FACE OF
GABION
WALL

PIPE PENETRATION THRU GABION



GABION WIRE SPECIFICATIONS

USA WIRE GAUGE	DIAMETER, INCHES	MINIMUM ALLOWABLE AVERAGE GABION WIRE DIAMETER WITH CLASS 3 ZINC-COATING, INCHES
9	.148	.144
11	.120	.116
13.5	.086	.082 (STANDARD TIE WIRE)

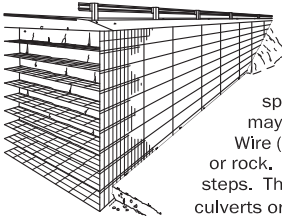
SOIL REINFORCEMENT MAT WIRE SIZE COMPARISON TABLE

"W" SIZE NUMBER	NOMINAL DIAMETER (INCHES)	NOMINAL DIAMETER (MM)
W12.0	.391	9.9
W9.5	.348	8.8
W7.0	.299	7.6
W4.5	.239	6.1
W4.0	.226	5.7
W3.5	.211	5.4

FOR MORE INFORMATION ON WELDED WIRE REINFORCEMENT (WWR)
CHECK THE WEBSITE FOR THE WIRE REINFORCEMENT INSTITUTE.
WWW.WIREREINFORCEMENTINSTITUTE.ORG

HILFIKER MSE WALL SYSTEMS

OTHER HILFIKER PRODUCTS

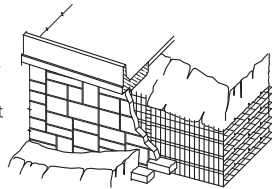


WELDED WIRE WALL

The Hilfiker Welded Wire Retaining Wall is a flexible soil reinforcement system. It is composed of Welded Wire Mesh mats and compacted soil. Mats are supplied in 8' (2.44m) spans, and 24" (610mm) horizontal lifts. The final wall face may be vertical or battered, and may remain exposed Welded Wire (as shown) or may be covered with air-blown mortar, plants or rock. The Welded Wire Wall is adaptable to curves, angles and steps. The mats are easily cut to permit installation of penetrating culverts or pipes, or to fit special site applications.

EUREKA REINFORCED SOIL (E.R.S.)

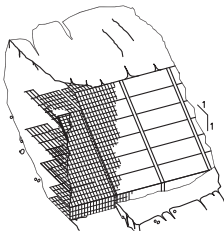
The Hilfiker E.R.S. Retaining Wall begins as a Welded Wire Wall, with the addition of face anchors to tie to a concrete face. After completion and settlement of the Welded Wire Wall, a solid facing is attached. This may be cast-in-place concrete, precast full-height concrete panels, or special rock or gunite as required by the project specifications. The facial treatment of this retaining wall adapts easily to almost any pattern or concept.



HILFIKER STEEPENED SLOPE

The Hilfiker Steepened Slope system is composed of Welded Wire Fabric components. The flat primary soil reinforcement mats are interlocked with bent facing mats, prefabricated to a 1:1 slope. The slope may be flattened, if desired, by stepping back each layer. Behind the facing mats are Welded Wire Fabric backing mats incorporated with erosion mat or sod.

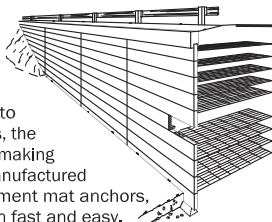
Virtually any type of sod or vegetation that will best suit the environment may be used with this system. Low-growth, maintenance-free vegetation is typically specified.



REINFORCED SOIL EMBANKMENT (SMOOTH FACE)

The R.S.E. Smooth Face Retaining Wall retains most of the advantages of the Hilfiker Welded Wire Wall, while providing the additional durability of precast face panels.

The concrete panels can be cast with a smooth finish, or to match a variety of architectural treatments. In most structures, the simple 12'-6" x 2'-6" (3.81m x 0.76m) standard panel is used, making all the panels interchangeable. Special panel sizes can be manufactured when required. Panels are cast with pre-installed reinforcement mat anchors, and a cantilever footing at the back face, making installation fast and easy.



1902 Hilfiker Lane - Eureka, CA 95503-5711
Local: (707)443-5093 - Toll Free: (800) 762-8962
Web: <http://hilfiker.com> email: info@hilfiker.com



HILFIKER RETAINING WALLS

Welded Wire Wall • Eureka Reinforced Soil
Gabion Faced M.S.E. • Reinforced Soil Embankment
ArtWeld Gabions • Spiralnail • Steepened Slope • Trinity Wall

MATERIAL WARRANTY FOR HILFIKER SYSTEMS

Hilfiker Retaining Walls warrants that all retaining wall and gabion materials manufactured by Hilfiker shall be free from defects in design and workmanship and shall conform in all respects to one or more of the following applicable specifications:

ASTM	AASHTO	Standard Specification Description
A1064 *	M 336 **	Steel Wire and Welded Wire, Plain and Deformed
A53		Steel Pipe
A500-03a		Steel Tubing
A36		Carbon Structural Steel
A370	T 244	Test Methods & Definitions for Mechanical Testing of Steel Products
A123	M 111	Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products (2 oz. / SF galvanization)
A641		Zinc-Coated (Galvanized) Carbon Steel Wire (class 3 galvanization)
A740 - 98(2014)		Hardware Cloth (Woven or Welded Galvanized Steel Wire Fabric)

*ASTM A82 and A185 were combined in 2010 into A1064

**AASHTO M 32 and M 55 were combined in 2018 into M 336

It is assumed that construction and workmanship meet all material requirements and specifications as provided by Hilfiker. All backfill materials are provided by the Contractor who is solely responsible for the material quality and the installation of the backfill. Not covered by any implied or express warranty would be foundation settlement, settlement of the backfill, erosion of the foundation soils, or corrosion of the reinforcement due to the use of non-conforming backfill, and other external stability matters. Hilfiker Retaining Walls cannot offer a performance warranty because we have no control over the wall materials after delivery to the jobsite.

The design associated with this warranty was based on information provided to Hilfiker and their consulting engineer by the Owner/Contractor. The consulting engineer who prepared the associated design has a valid license and provides professional liability coverage. Their obligation is to live up to the standard of practice (standard of care) for the given geographic location at the time the service is, or was provided. Alterations to their design submittals, without prior approval, will nullify any responsibility on their part.

Hilfiker Retaining Walls requires that the wall components are manufactured to the stipulated ASTM standards as well as internal quality assurance standards for fabrication. However, we do not exercise control over the construction, use, or the service conditions to which the wall is subjected and thus would void our insurance by attempting to extend coverage into areas for which we have no control.

Updated: August 12, 2019

