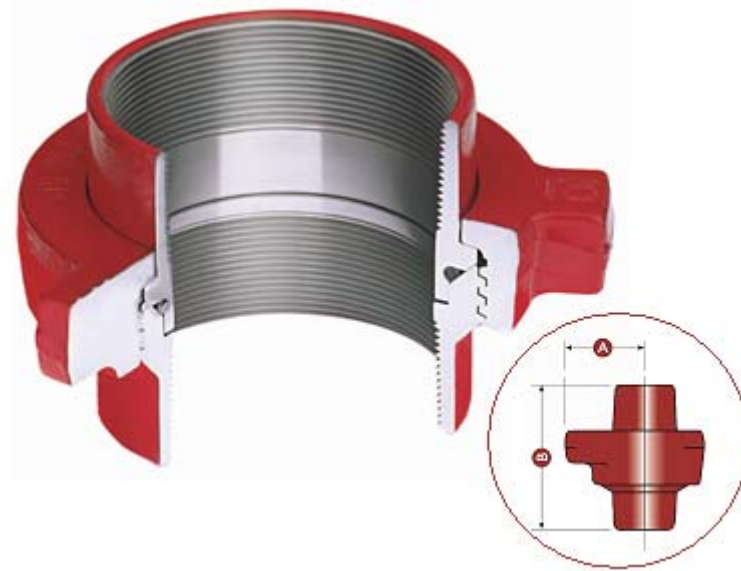




***Weco couplings -  
Hammer lug unions***



## HAMMER LUG UNIONS FIGURE 50

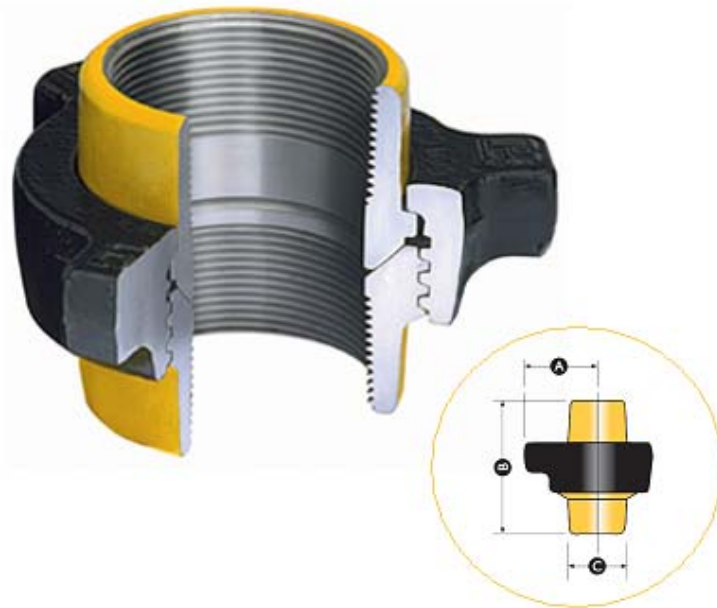


The suction and low pressure Figure 50 is manufactured from steel throughout and is available threaded or socket weld in 4" or 5" sizes. The same nut and 'O' ring are used in both sizes, male and female blanking caps are also available.

The Figure 50 is so named because it is designed to withstand 500 psi cold working pressure (35 bar).

Size [inch]	Threaded			Socket Weld	
	Weight [kg]	Nut radius A [mm]	Total length B [mm]	Weight [kg]	Total length B [mm]
4 "	12,4	130,3	152,4	11,7	103,1
5"	9,90	130,3	142,7	9,30	103,1
<b>Note:</b> Where dimensions and weight are critical, please consult us.					

## HAMMER LUG UNIONS FIGURE 100



A low pressure general purpose threaded union suitable for air, water, oil or gas service. Figure 100 unions are manufactured from steel, *not* cast iron. This has enabled us to reduce the weight and physical dimensions, at the same time retaining interchangeability with other leading brands.

The Figure 100 gets its name from its ability to withstand 1.000 psi cwp (69 bar).

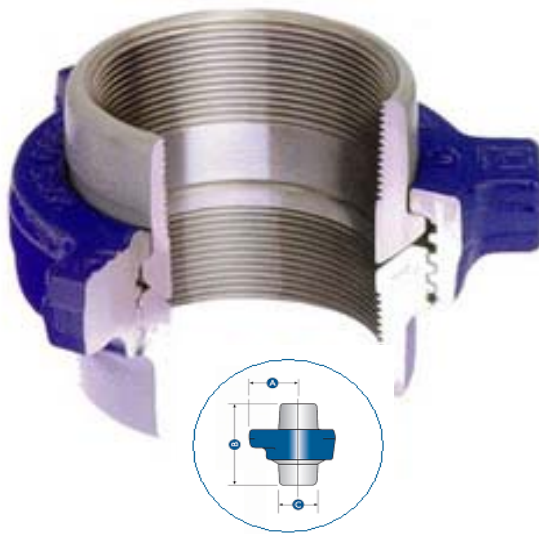
Threaded				
Size [inch]	Weight [kg]	Nut radius A [mm]	Total length B [mm]	Dia. Body C [mm]
2 "	2,2	73,1	82,0	69,8
2 ½"	4,5	88,9	107,9	85,8
3"	7,5	103,1	103,1	104,6
4"	10,4	115,8	122,6	130,0
5"	14,7	146,0	152,4	162,0
6"	21,5	165,1	173,7	184,4
8"	29,9	184,1	182,6	242,8
<b>Note:</b> Where dimensions and weight are critical, please consult us.				

## HAMMER LUG UNIONS FIGURE 200

A general purpose, all steel constructed union designed to meet a variety of applications up to and including service at 2,000 pounds per square inch. The Figure 200 is a compact and economical union, available with threaded and butt weld ends.

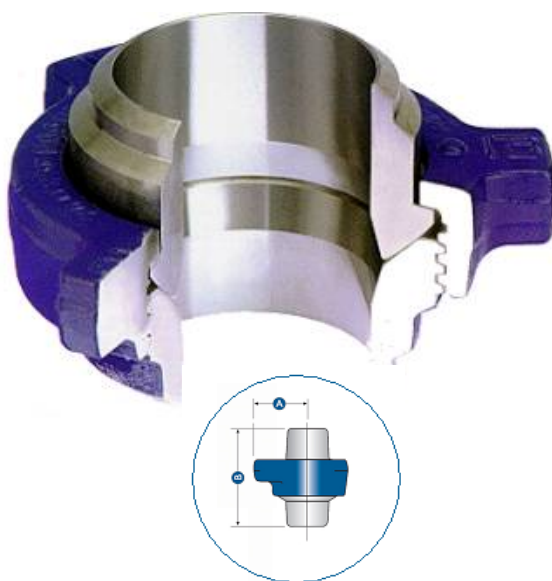
The Fig 200 Union is designed to work with 2.000 psi cwp (138 bar).

### Threaded ends



Threaded				
Size [inch]	Weight [kg]	Nut radius A [mm]	Total length B [mm]	Dia. Body C [mm]
1 "	0,8	50,8	62,9	40,3
1 ¼"	1,0	57,1	70,6	50,8
1 ½"	1,2	61,9	73,6	57,9
2"	2,2	73,1	81,0	69,8
2 ½"	3,8	88,9	104,6	84,0
3"	6,7	98,5	116,5	103,8
4"	8,2	114,3	125,4	130,0
5"	14,7	146,0	152,4	162,0
6"	21,5	165,1	173,7	187,4
8"	30,0	184,1	182,6	142,8
<b>Note:</b> Where dimensions and weight are critical, please consult us.				

## Butt weld ends

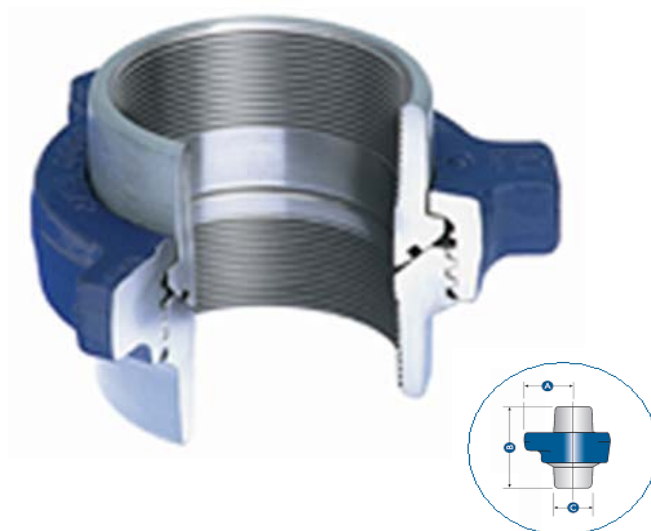


Butt Weld Sch 40				Butt Weld Sch 80	
Size [inch]	Weight [kg]	Nut radius A [mm]	Total length B [mm]	Weight [kg]	Total length B [mm]
2"	2,5	73,1	80,0	2,6	82,5
3"	5,7	98,5	101,6	5,6	105,1
4"	6,7	114,3	122,4	7,3	126,4
5"	14,8	146,0	152,4	17,0	156,7
6"	21,7	165,1	147,8	23,3	153,9
8"	31,1	184,1	175,5	33,9	182,6
<b>Note:</b> Where dimensions and weight are critical, please consult us.					

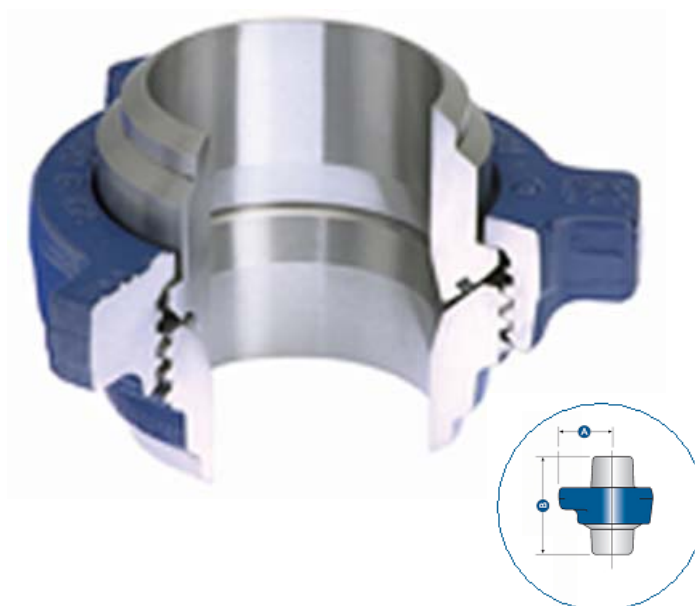
## HAMMER LUG UNIONS FIGURE 206

The Figure 206 is the Figure 200 with a secondary seal to supplement the metal-to-metal ball and cone seat. All dimensions and weights are the same as for the Figure 200 range of unions.

### Threaded ends



### Butt weld ends



## HAMMER LUG UNIONS FIGURE 207

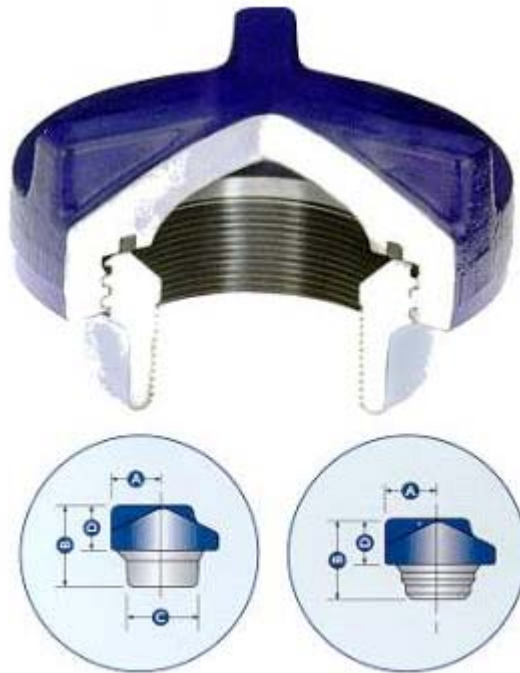


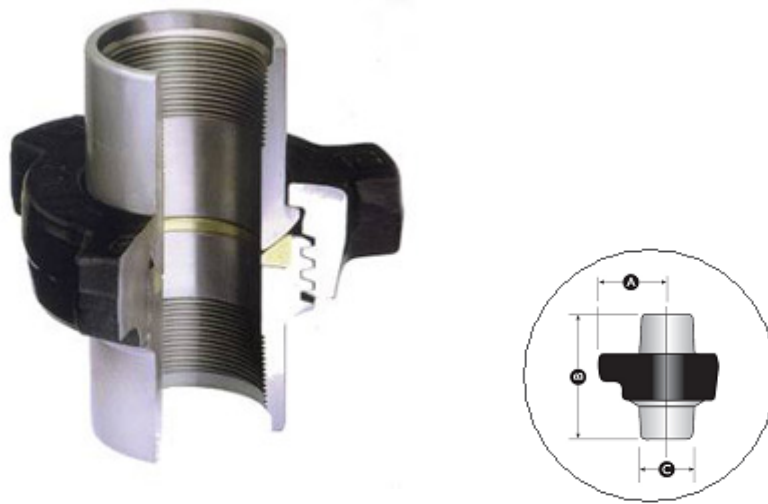
Figure 207 Blanking Caps and unions are fully interchangeable with Figure 200 and 206 Unions. For use where the blanking off at the end of a line is desirable. The cap is fitted with an 'O' ring to ensure a leak proof seal.

The Fig 207 Union is designed to work with 2.000 psi cwp (138 bar).

Size [inch]	Threaded					Butt Weld Sch 80	
	Weight [kg]	Cap radius A [mm]	Total length B [mm]	Dia. Body C [mm]	Cap height D [mm]	Peso [kg]	Total length B [mm]
3"	4,5	73,1	93,7	103,8	60,4	4,0	90,4
4"	9,3	92,9	109,4	130,0	66,8	9,9	110,4
6"	20,3	127,0	142,2	187,4	81,0	21	133,3
<b>Note:</b> Where dimensions and weight are critical, please consult us.							



## HAMMER LUG UNIONS FIGURE 600



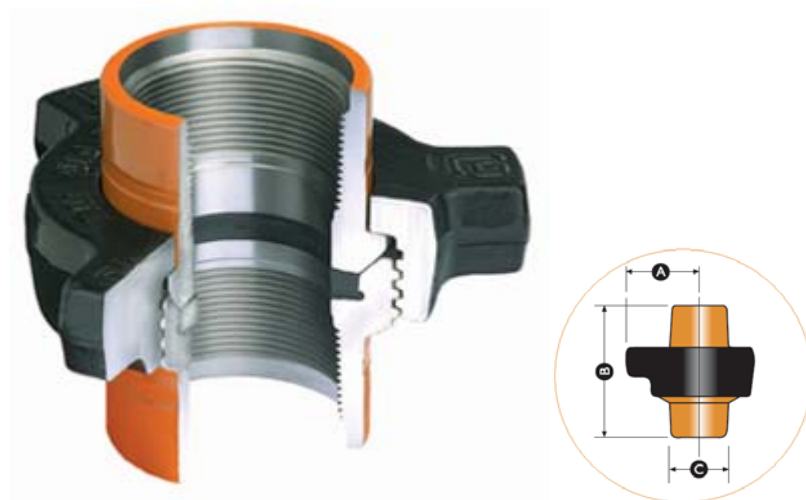
The Fig.600 is ideal for steam service. It is a bronze seated union designed to combat rust and corrosion on lines where a metal-to-metal seal is desirable and condensation is a problem.

The Figure 600 is designed to easily perform at 6.000 psi (414 bar).

Threaded				
Size [inch]	Weight [kg]	Nut radius A [mm]	Total length B [mm]	Dia. Body C [mm]
1 "	1,7	57,1	90,4	44,4
2"	6,6	88,9	162,8	76,2
3"	13,1	114,3	222,2	105,6
4"	18,1	125,4	255,5	133,3
<b>Note:</b> Where dimensions and weight are critical, please consult us.				



## HAMMER LUG UNIONS FIGURE 602



The Figure 602 is designed for pressures up to 6.000 pounds per square inch (414 bar) and is available with threaded and butt weld ends. It is also available in different materials to suit the requirements of well testing companies specifications.

Threaded				
Size [inch]	Weight [kg]	Nut radius A [mm]	Total length B [mm]	Dia. Body C [mm]
1 "	1,8	57,1	89,4	44,4
1 ½"	4,0	76,2	123,9	65,0
2"	6,1	88,9	133,3	77,7
3"	9,7	114,3	157,2	106,6
4"	15,4	125,4	208,0	134,6
<b>Note:</b> Where dimensions and weight are critical, please consult us.				

There are three types of butt weld Fig. 602 unions to suit particular applications.

**Standard Union (Sour or Standard Service) - Fig. 602 Butt Weld** is a fully rated union manufactured for welding to pipe sections up to Sch XXS. Available in sour gas or standard service trim.

**Low Carbon A350 LF2 Type - Fig. 602-LC Butt Weld** is specifically designed for welding to ASTM A106 Grade B or ASTM A333 Grade 6 tubulars of Sch 80 section. This has become a favorite with well test companies as it is a low cost, readily available union, for use with pipework that is not required to function above the recommended pressures as set out in API RP 14E which, in turn, is based on the allowable stress values in ANSI/ASME B31.3. These unions are available in 2" and 3" sizes only.

**High tech, high strength Fig. 602-18 Butt Weld** is manufactured from low carbon steel forgings that retain ductility at high strength. These unions are readily weldable and are available in 2", 3" and 4" sizes with pipe sections up to and including Sch. XXS. Depending upon wall section and pipe used, this union can be fully rated at 6.000 psi cwp.



Size [inch]	Butt Weld Sch 80			Butt Weld Sch XXS	
	Weight [kg]	Nut radius A [mm]	Total length B [mm]	Weight [kg]	Total length B [mm]
1"	1,3	57,1	82,5	1,8	89,6
2"	5,7	88,9	118,8	6,6	127,5
3 "	10,0	114,3	124,4	11,0	135,8
4"	13,2	125,4	133,8	15,2	147,0
<b>Note:</b> Where dimensions and weight are critical, please consult us.					

## HAMMER LUG UNIONS FIGURE 1002

The Figure 1002 union is a high pressure low alloy steel union fitted with a replaceable elastomer seal ring. It is available in a variety of sizes and can be used for both standard, and sour gas services.

### Standard service

- Available in 1", 3" and 4" sizes. Designed for pressures up to 10.000 psi cwp (690 bar)
- Available in 5" and 6" sizes. Designed for pressures up to 7.500 psi cwp (517 bar)

### Sour Gas service

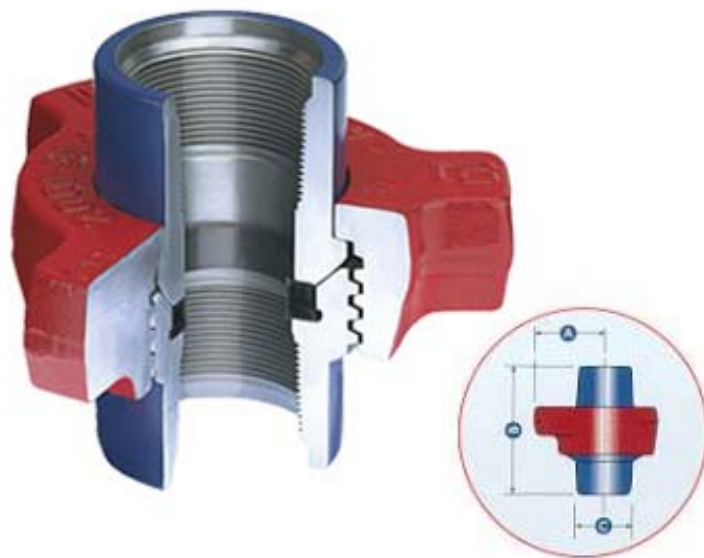
- Available in 1", 3" and 4" sizes. Designed for pressures up to 7.500 psi cwp (517 bar)
- Available in 5" and 6" sizes. Designed for pressures up to 5.000 psi cwp (345 bar)

The 1" through to 4" sizes have lip type seals and the 5" and 6" utilise "O" Rings.

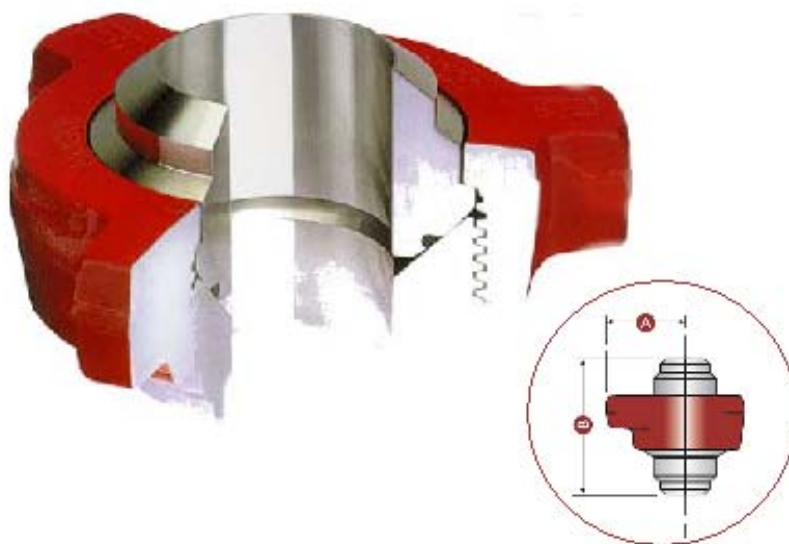
The 5" and 6" are available in butt weld ends only.

Size [inch]	Threaded				Butt Weld Sch XXS	
	Weight [kg]	Nut radius A [mm]	Total length B [mm]	Dia. Body C [mm]	Weight [kg]	Total length B [mm]
1"	1,8	57,15	89,41	44,45	1,8	89,66
2"	6,1	88,90	133,4	77,72	6,6	127,5
3"	9,8	114,3	157,2	106,7	11,1	135,9
4"	15,5	125,5	208,0	134,6	15,3	147,1
5"	-	152,4	-	-	27,0	157,2
6"	-	184,2	-	-	39,0	166,4
<b>Note:</b> Where dimensions and weight are critical, please consult us.						

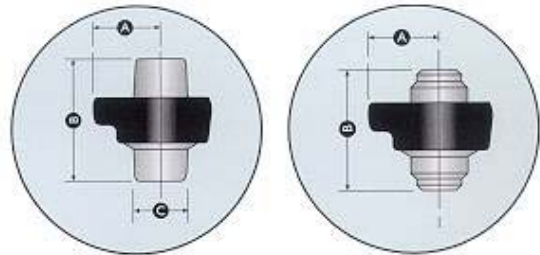
### Threaded ends



### Butt weld ends



## HAMMER LUG UNIONS FIGURE 1003



All Figure 1003 unions are misaligning types and will allow for a misalignment of up to  $7\frac{1}{2}^\circ$  off the center line,  $15^\circ$  included. The exception is the 2" which has an included maximum of  $7^\circ$  or  $3\frac{1}{2}^\circ$  off the center line. Available as line pipe threaded or butt weld with 5" unions available butt weld only.

The Fig.1003 union is designed to work at the following pressures.

### Standard service

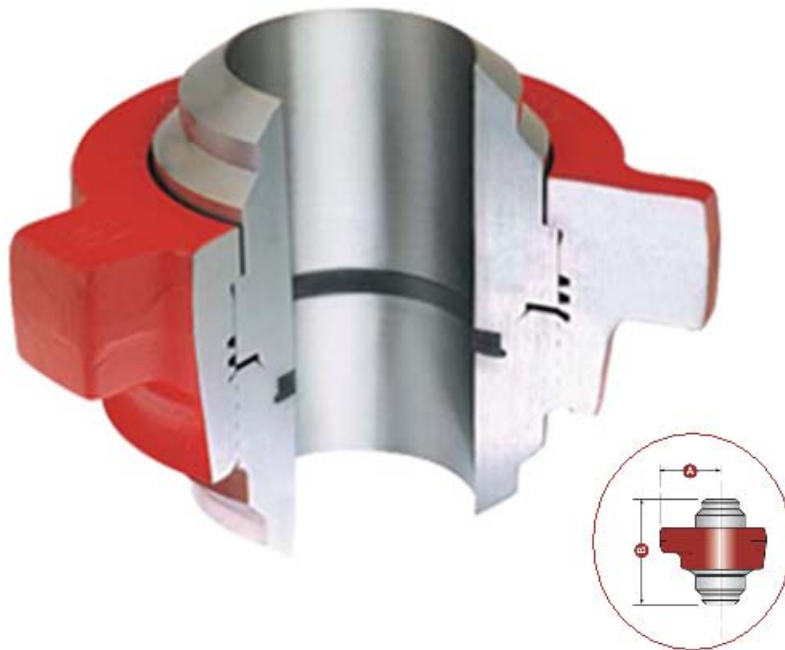
- Available in 2" and 3" sizes. Designed for pressures up to 10.000 psi cwp (690 bar)
- Available in 4" and 5" sizes. Designed for pressures up to 7.500 psi cwp (517 bar)

### Sour gas service

- Available in 2" and 3" sizes. Designed for pressures up to 7.500 psi cwp (517 bar)
- Available in 4" and 5" sizes. Designed for pressures up to 7.500 psi cwp (345 bar)

Size [inch]	Threaded				Butt Weld Sch XXS	
	Weight [kg]	Nut radius A [mm]	Total length B [mm]	Dia. Body C [mm]	Weight [kg]	Total length B [mm]
2"	5,60	88,90	120,1	76,20	6,00	120,1
3"	19,5	124,0	231,6	113,0	20,1	231,6
4"	35,6	152,4	279,4	139,7	36,9	279,4
5"	-	152,4	-	-	36,4	278,1
<b>Note:</b> Where dimensions and weight are critical, please consult us.						

## HAMMER LUG UNIONS FIGURE 1004



The 5" and 6" Fig. 1002 unions utilize elastomer "O" rings for sealing purposes. This type of union must be made up perfectly square and if not it can be troublesome. To improve matters, has introduced two new sizes of Butt Weld Unions that utilize lip type elastomer seals similar to those fitted into the smaller unions. These new sizes are referred to as "Fig. 1004".

They are available in standard service or sour gas trim.

The Fig.1004 union is designed to work at the following pressures:

- Standard service: 10.000 psi cwp (690 bar)
- Sour gas service: 7.500 psi cwp (517 bar)

Size [inch]	Weight [kg]	Threaded	
		Nut radius A [mm]	Total length B [mm]
5 "	38,60	152,4	209,6
6"	63,60	184,2	238,3
<b>Note:</b> Where dimensions and weight are critical, please consult us.			

## HAMMER LUG UNIONS FIGURE 1502

The Fig. 1502 union is probably the most widely used end connection of the hammer union family. It is used in a wide range of applications due to its rugged construction. It is available with line pipe threads or butt weld ends, in standard or sour gas trim.

It has been introduced a 5" and 6" Fig. 1502 (butt weld only) for those applications where modern demands are calling for greater flow rates at high pressure.

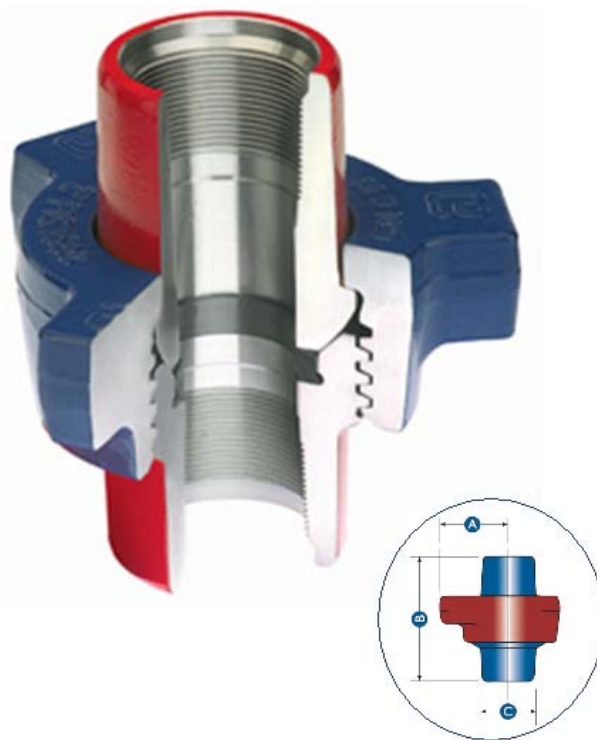
The Fig. 1502 Union is designed to work at the following pressures:

- Standard service: 15.000 psi cwp (1.034 bar)
- Sour gas service: 10.000 psi cwp (690 bar)

Size [inch]	Threaded				Butt Weld Sch XXS	
	Weight [kg]	Nut radius A [mm]	Total length B [mm]	Dia. Body C [mm]	Weight [kg]	Total length B [mm]
1"	3,8	68,58	110,7	55,12	3,7	110,7
1 ½"	7,5	92,20	136,7	75,44	7,5	136,9
2"	8,4	95,25	178,8	81,79	9,5	156,7
3"	14,1	116,1	193,8	114,3	13,0	133,4
4"	-	152,4	-	-	34,0	215,9
5"	-	165,1	-	-	43,0	228,6
6"	-	184,2	-	-	65,8	247,7
<b>Note:</b> Where dimensions and weight are critical, please consult us.						



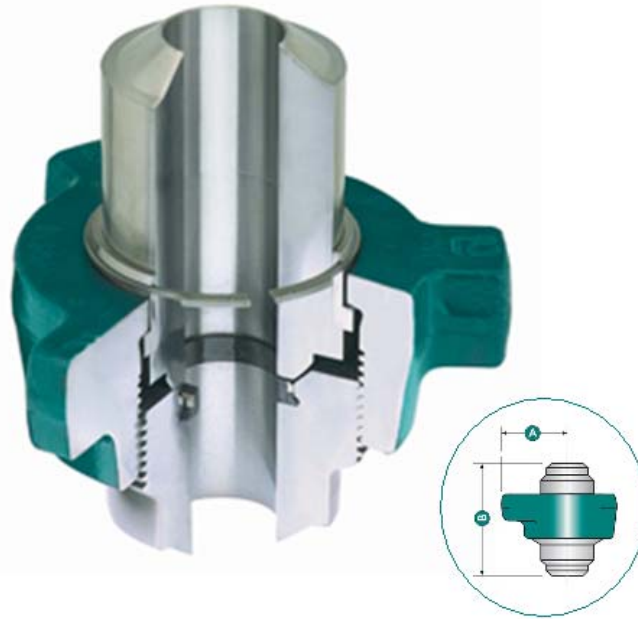
### Threaded ends



### Butt weld ends



## HAMMER LUG UNIONS FIGURE 2002

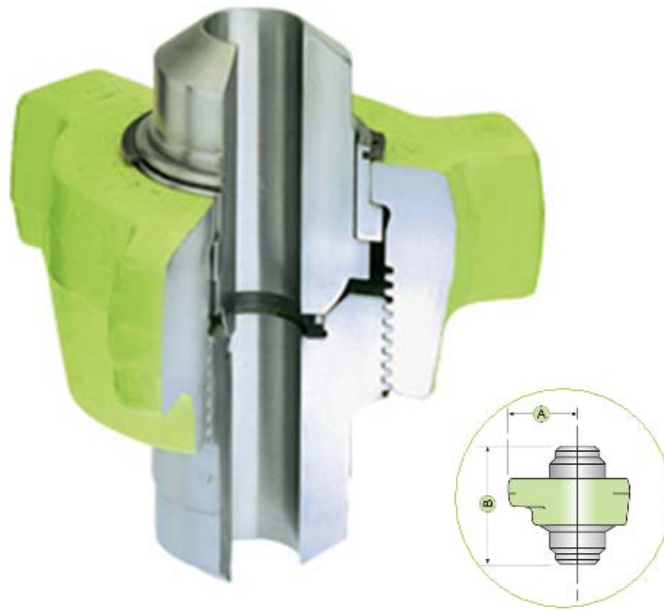


Standard service Fig. 2002 unions are manufactured throughout from the finest of steels selected to give the ultimate in performance. Lip type elastomer seals with anti-extrusion rings are supplied with this union. Available butt weld only.

The Fig 2002 Union is designed to work with 20.000 psi cwp (1380 bar).

Size [inch]	Butt Weld			Weld Prep	
	Weight [kg]	Nut radius A [mm]	Total length B [mm]	O.D.	I.D.
2"	10,43	95,25	188,0	63,50	31,75
3" *	21,77	124,0	242,8	104,8	52,32
4" *	34,47	152,4	215,9	139,7	76,20
5"	49,90	165,1	273,1	155,4	101,6
6"	77,11	184,2	330,2	196,9	127,0
<b>Note:</b>	Where dimensions and weight are critical, please consult us. 3" and 4" unions are sometimes referred to 2 ½" and 3" respectively by other manufacturers. If you have any doubt please don't hesitate to contact us.				

## HAMMER LUG UNIONS FIGURE 2202

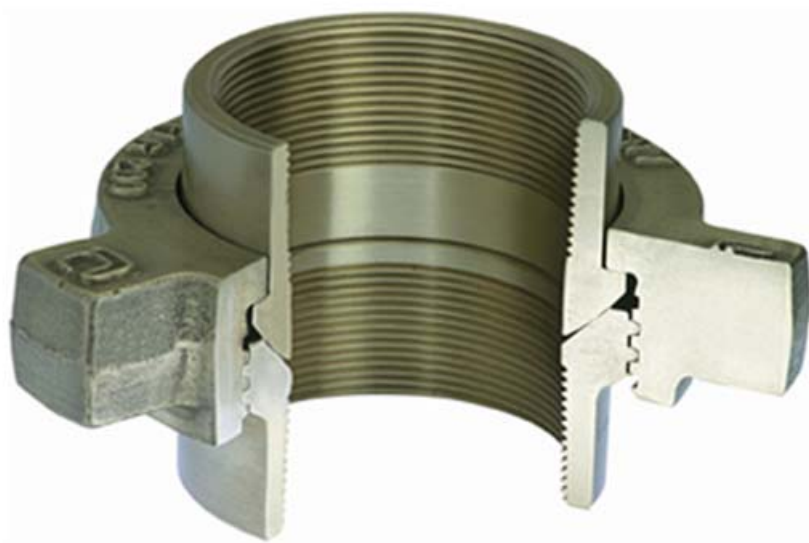


The Fig. 2202 sour gas union is ruggedly proportioned and manufactured to the highest quality standards to ensure safety and reliability in service. Lip type elastomer seals with stainless steel anti-extrusion rings are fitted as standard. All H<sub>2</sub>S service unions are subjected to vigorous examination to ensure the latest requirements of NACE (*National Association of Corrosion Engineers*) are adhered to and the product is fit for purpose.

The Fig 2202 union is designed to work with 15.000 psi cwp (1.034 bar).

Size [inch]	Butt Weld			Weld Prep	
	Weight [kg]	Nut radius A [mm]	Total length B [mm]	O.D.	I.D.
2"	10,43	95,25	188,0	63,50	31,75
3" *	21,77	124,0	242,8	104,8	52,32
4" *	34,47	152,4	215,9	139,7	76,20
5"	49,90	165,1	273,1	155,4	101,6
6"	77,11	184,2	330,2	196,9	127,0
<b>Note:</b> Where dimensions and weight are critical, please consult us. 3" and 4" unions are sometimes referred to 2 ½" and 3" respectively by other manufacturers. If you have any doubt please don't hesitate to contact us.					

## SPECIALS



In addition to the wide range of hammer lug unions shown, regularly manufactures specials to suit customers' specific requirements in regards to materials, dimensions and types.

Please contact us for further information regarding your specific requirements.

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