PIRTEK OIL & GAS

HAMMER UNIONS

MATERIAL:
Unions are manufactured from steel forgings using materials appropriate to specific pressure ratings.

END CONNECTIONS:
Available in a choice of end connections. API line pipe threads are standard. Butt weld ends can be provided. Customer to specify schedule of pipe while ordering.

SOUR SERVICE:
Sour service is available and all H2S service 2 parts of Sara unions conform to the latest NACE specifications.

LOW TEMPERATURE SERVICE:
Can be supplied for low temperature applications with suitable impact value testing.

INTERCHANGEABILITY:
All our union components of the same size and figure number are Weco interchangeable. All union nuts have three hammer lugs.

TRACEABILITY:
Our unions are supplied with full traceability documentation for each component.

PRESSURE RATING (psi)

NOMINAL PIPE SIZE (In mm)

Assembly Colour Key for Standard Service		STANDARD SERVICE		SOUR GAS SERVICE		1	1¼	1½	2	2½	3	4	5	6	8	10	12
FIG NO.	↓	COLD WORKING	TEST	COLD WORKING	TEST	25	32	40	50	65	80	100	125	150	200	250	300
50		500	750	NA	NA							✓	✓				
100		1000	1500	NA	NA				✓	✓	✓	✓	✓	✓	✓		
200		2000	3000	NA	NA	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
206		2000	3000	NA	NA	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
207		2000	3000	NA	NA						✓	✓		✓			
211		2000	3000	NA	NA				✓		✓						
400		2500	3750	2500	3750									✓	✓	✓	✓
400		4000	6000	4000	6000				✓		✓	✓					
600		6000	9000	NA	NA	✓			✓		✓	✓					
602		6000	9000	6000	9000	✓	✓	✓	✓		✓	✓					
1002		10000	15000	7500	12000	✓	✓	✓	✓		✓	✓	✓	✓			
1003		10000	15000	7500	12000				✓		✓	✓	✓				
1502		15000	22500	10000	15000	✓			✓		✓	✓	✓				
2002		20000	30000	NA	NA				✓		✓	✓					
2202		NA	NA	15000	22500				✓		✓	✓					

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FIGURE 50

Recommended for air, water, oil, or gas service to 500 PSI NSCWP. Standard subs are threaded for API line pipe.

PRODUCT CODE	SIZE (inch)	LENGTH (inch)	NUT RADIUS (inch)	WEIGHT (kg)
HUF50100N	4"	5 1/2"	5 1/4"	10.20
HUF50125N	5"	5 1/2"	5 1/4"	10.80

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FIGURE 100

Recommended for air, water, oil, or gas service to 1,000 PSI NSCWP. Standard subs are threaded for API line pipe and are Weco interchangeable. Also available with butt weld ends.

PRODUCT CODE	SIZE (inch)	LENGTH (inch)	NUT RADIUS (inch)	WEIGHT (kg)
HUF100050N	2"	3 5/8"	2 29/32"	2.60
HUF100065N	2 1/2"	4 9/32"	3 5/8"	5.20
HUF100080N	3"	5 1/8"	4"	6.20
HUF100100N	4"	5 3/4"	4 11/16"	10.20
HUF100125N	5"	6 33/64"	5 9/16"	13.80
HUF100150N	6"	6 7/8"	6 7/8"	23.20
HUF100200N	8"	7 5/16"	7 13/16"	32.20

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FIGURE 206

Recommended for air, water, oil or gas service to 2,000 PSI NSCWP. A Buna-N 'O' ring is mounted on the plain sub to provide an additional seal. Subs and nuts of the Fig. 206 union are interchangeable with the Fig. 200 union. Standard subs are threaded for API line pipe. Sizes of 2" and above also available with butt weld ends. connections.

PRODUCT CODE	SIZE (inch)	LENGTH (inch)	NUT RADIUS (inch)	WEIGHT (kg)
HUF206025N	1"	2 19/32"	2"	1.00
HUF206032N	1 1/4"	2 25/32"	2 5/32"	1.07
HUF206040N	1 1/2"	2 29/32"	2 13/32"	1.07
HUF206050N	2"	3 1/4"	2 29/32"	2.40
HUF206065N	2 1/2"	4 1/4"	3 5/8"	5.02
HUF206080N	3"	4 17/32"	4 /1/4"	6.60
HUF206100N	4"	4 15/16"	5"	9.10
HUF206150N	6"	6 25/32"	6 1/2"	19.30
HUF206200N	8"	7 5/16"	7 13/16"	29.10
HUF206250N	10"	9 3/32"	9 1/16"	41.36

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FIGURE 207

Recommended for air, water, oil, or gas service to 2,000 PSI NSCWP. A blanking cap with Buna-N 'O' ring seal provides an efficient and dependable closure. The threaded sub is interchangeable with Fig. 200 threaded sub. Also available with butt weld ends.

PRODUCT CODE	SIZE (inch)	LENGTH (inch)	NUT RADIUS (inch)	WEIGHT (kg)
HUF207080N	3"	3 3/4"	2 3/4"	4.45
HUF207100N	4"	4 45/64"	3 17/32"	7.38
HUF207150N	6"	5 37/64"	4 27/32"	17.10

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FIGURE 602

Recommended for air, water, oil, gas or mud service to 6,000 PSI NSCWP. This union has a replaceable lip-type seal ring of Buna-N specifically designed to minimize fluid flow turbulence. Lip-type ring provides a pressure seal and protection for metal-tometal seating surfaces. Smaller and lighter than Fig. 600 unions and are recommended for manifold and truck mounting where size and weight are critical.

PRODUCT CODE	SIZE (inch)	LENGTH (inch)	NUT RADIUS (inch)	WEIGHT (kg)
HUF602025N	1"	3 17/32"	2 5/32"	1.59
HUF602032N	1 1/4"	4 29/32"	3 7/32"	4.54
HUF602040N	1 1/2"	4 29/32"	3 7/32"	4.10
HUF602050N	2"	5 1/4"	3 3/4"	5.90
HUF602080N	3"	6 1/4"	4 1/2"	10.45
HUF602100N	4"	8 1/4"	5 7/32"	15.00

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FIGURE 1502

Recommended for air, water, oil, gas and mud service to 15,000 PSI NSCWP. This union has a replaceable lip-type seal ring of Buna-N specifically designed to minimize fluid flow turbulence. The lip-type ring also provides a pressure seal and protection for metal to metal seating surface and are recommended for manifold and truck mounting or other installations where high pressure is encountered.

PRODUCT CODE	SIZE (inch)	LENGTH (inch)	NUT RADIUS (inch)	WEIGHT (kg)
HUF1502025N	1"	4 3/8"	2 3/4"	3.82
HUF1502050N	2"	7"	4"	9.54
HUF1502080N	3"	7 5/8"	4 13/16"	14.10
HUF1502100N	4"	8 1/2"	6 1/6"	34.00
HUF1502125N	5"	9 7/64"	6 45/64"	44.40

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