



Hammer unions, or WECO couplings, as they are called, allow for quick connecting the pipelines and flexible hose assemblies in the oil and gas industry. They are popularly used on onshore and offshore drilling rigs to transfer petroleum, gas, drilling mud, cement, water, air and many other media.

D-LINE® offers a comprehensive range of standard and sour gas Hammer Unions. Each union is thoroughly inspected to ensure long, dependable service in the most extreme conditions.

SPECIFICATIONS

- Range size: 1/2"-12"
- ASTM A-105 for a working pressure less than 6,000psi
- AISI 4130 for a working pressure greater than or equal to 6,000psi
- Meet or exceed National Association of Corrosion Engineers standard NACE MR-01-75
- Maximum cold working pressure: 15,000psi

FEATURES

- Complete traceability
- Three lug nuts and self-locking ACME threads provide quick make-up and break-out
- Color coded for quick identification
- All unions provide pressure-tight & positive sealing for low-pressure services (500 to 2,000 PSI)
- The spherical surface male sub and angular surface female sub form a metal-to-metal seal, the ball and tangent provides a perfect seal
- Fully interchangeable with most major brands of Hammer Unions.

FIGURE NUMBER	ASSEMBLY KEY	PRESSURE RATING				NORMAL PIPE SIZE													
		STANDARD SERVICE		SOUR SERVICE			1	1/4	1/2	2	2 1/2	3	4	5	6	8	10	12	
		COLD WORKING	TEST	COLD WORKING	TEST	(MM)	25	32	40	50	65	80	100	100	125	150	250	300	
40		400	600	400	600					T									
50		500	750	500	750									T					
100		1000	1500	1000	1500				T/W	T	T/W	T/W	T/W	T/W	T/W	T/W			
200		2000	3000	2000	3000		T	T	T/W	T/W	T	T/W	T/W	T/W	T/W	T/W	T/W		
201		2000	3000	2000	3000					T									
206		2000	3000	2000	3000		T	T	T/W	T/W	T	T/W	T/W	T/W	T/W	T/W	T/W		
207		2000	3000	2000	3000							T/W	T/W		T/W				
207		2000	3000	2000	3000					T									
211		2000	3000	2000	3000					•									
300		2000	3000	N/A	N/A					T									
301		3000	3000	N/A	N/A					T		T/W		•	•	•	•		
400		4000	6000	4000	6000					T									
600		6000	9000	N/A	N/A							T/W							
602		6000	9000	6000	9000		T/W		T/W	T/W		T/W	T/W						
1002		10000	15000	7500	11250							T/W	T/W	•	•				
1003		10000	15000	7500	11250							W	•	•					
1004		10000	15000	7500	11250										W				
1502		15000	22500	10000	15000		T		T	T/W	T	T/W	T/W	W	W				
2202		N/A	N/A	15000	22500					W		W							
AG		6000	9000	6000	9000					T									

• Indicates reduced CWP due to pipe size or other design facts.

T Threaded

W Butt-Weld

T/W Threaded & Butt-Weld

FIGURE 300

2" Threaded CWP 2000/6000 PSI
2" Butt-Weld CWP 6000 PSI

FIGURE 400 STANDARD SERVICE

6", 8", 10" & 12" CWP 2500/5000 PSI

FIGURE 1002 STANDARD SERVICE

5" Threaded CWP 5000 /7500 PSI
5" & 6" Butt-Weld CWP 7500/11250 PSI

FIGURE 1002 STANDARD SERVICE

5" & 6" Butt-Weld CWP 5000/ 7500 PSI

FIGURE 1003 STANDARD SERVICE

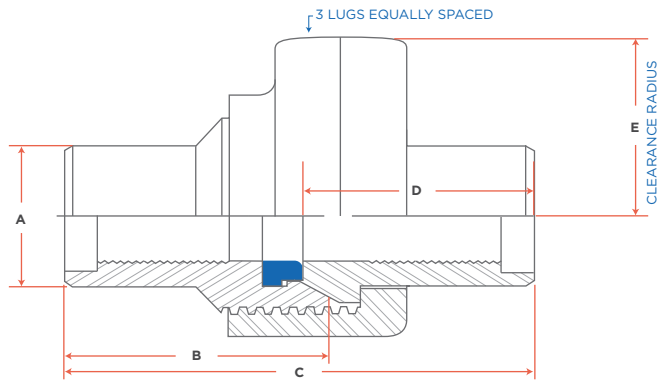
4" & 5" Butt-Weld CWP 7500/ 11250 PSI

FIGURE 1003 STANDARD SERVICE

4" & 5" Butt-Weld CWP 5000/ 7500 PSI

DIMENSIONS

THREADED TYPE



BUTT WELD TYPE

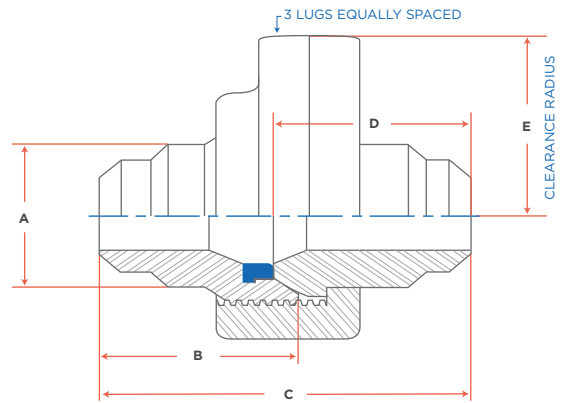


FIG. 100 UNION

- These Hammer Unions are used in low pressure manifold lines and air, water, oil or gas applications.
- Black nut, yellow subs
- Available in threaded end.

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-100NPT-09	2"	2.80	1.90	3.67	2.00	2.96	5.23
HU-100NPT-11	3"	4.10	2.50	4.96	2.89	4.34	14.55
HU-100NPT-12	4"	5.31	2.92	5.81	3.46	4.50	23.48
HU-100NPT-14	6"	7.50	3.50	6.54	3.77	6.39	49.37
HU-100NPT-15	8"	9.63	3.99	7.17	3.87	8.30	69.63



FIG. 200 UNION

- These Hammer Unions are used in general service manifold lines and air, water, oil or gas applications
- Blue nut, gray scrubs
- Available in both threaded and butt weld ends.
- Available in butt weld schedules 40 and 80.

THREADED END

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-200NPT-06	1"	1.59	1.38	2.67	1.50	1.89	1.81
HU-200NPT-08	1 1/2"	2.25	1.50	2.79	1.50	2.31	2.83
HU-200NPT-09	2"	2.80	1.87	3.51	2.00	2.99	5.12
HU-200NPT-11	3"	4.18	2.40	4.56	2.50	4.01	13.78
HU-200NPT-12	4"	5.20	2.62	4.95	2.75	4.50	20.61
HU-200NPT-14	6"	7.50	3.50	6.54	3.77	6.39	49.37
HU-200NPT-15	8"	9.63	3.99	7.17	3.87	8.30	69.63



FIG. 206 UNION

- These Hammer Unions are similar to Fig. 200 with a secondary seal to supplement the metal-to-metal design.
- Recommended for use in corrosive environments.
- Blue nut, gray scrubs
- Available in both threaded and butt weld ends.
- Available in butt weld schedules 40 and 80.

THREADED END

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-206NPT-09	2"	2.80	1.87	3.51	2.00	2.99	5.32
HU-206NPT-11	3"	4.18	2.40	4.56	2.50	4.01	13.71
HU-206NPT-12	4"	5.20	2.62	4.95	2.89	4.50	20.50
HU-206NPT-14	6"	7.50	3.50	6.54	3.77	6.39	49.37
HU-206NPT-15	8"	9.63	3.99	7.17	3.87	8.30	69.63



FIG. 206 UNION

BUTT WELD END

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-206BW80-09	2"	2.38	1.94	3.66	2.09	2.95	5.51
HU-206BW80-11	3"	4.20	3.20	6.06	3.20	4.01	17.09
HU-206BW80-12	4"	5.22	2.66	4.99	2.76	4.50	23.15
HU-206BW80-14	6"	6.63	3.64	6.66	3.76	6.44	52.02
HU-206BW80-15	8"	8.63	3.99	7.16	3.87	8.11	74.94



FIG. 400 UNION

- These Hammer Unions are used in manifold & line connections, pump suction and mud services.
- Black nut, red subs
- Available in threaded end.

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-400NPT-09	2"	3.00	2.81	5.23	2.88	3.84	13.60
HU-400NPT-11	3"	4.25	3.40	6.15	3.32	4.36	25.35
HU-400NPT-12	4"	5.31	4.49	8.26	4.27	4.72	34.17



FIG. 602 UNION

- These Hammer Unions are used in water, oil, gas and mud service.
- Lip type elastomer seal protects metal-to-metal designed to reduce turbulence in the line.
- Black nut, orange subs
- Available in both threaded and butt weld ends.

THREADED END

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-602NPT-06	1"	1.77	2.00	3.56	1.75	2.20	3.84
HU-602NPT-09	2"	3.06	2.83	5.28	2.80	3.48	14.24
HU-602NPT-11	3"	4.35	3.48	6.27	3.15	4.74	25.24
HU-602NPT-12	4"	5.30	4.50	8.22	4.08	5.31	34.72



FIG. 602 UNION

BUTT WELD END

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-602BWXXS-09	2"	3.05	2.78	5.18	2.75	3.84	15.17
HU-602BWXXS-11	3"	3.50	3.05	5.70	3.00	4.75	26.89
HU-602BWXXS-12	4"	4.50	3.26	5.91	3.02	5.31	34.72



FIG. 1002 UNION

- These Hammer Unions are used in high pressure applications for choke and kill lines, cementing and acidizing.
- Lip type elastomer seal protects metal-to-metal designed to reduce turbulence in the line
- 5" and 6" sizes have o-ring for primary sealing.
- Red nut, blue subs
- Available in both threaded and butt weld ends.

THREADED END

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-1002NPT-09	2"	3.06	2.83	5.28	2.80	3.84	13.78
HU-1002NPT-11	3"	4.36	3.46	6.26	3.15	4.78	25.24
HU-1002NPT-12	4"	5.30	4.50	8.15	4.08	5.31	34.72

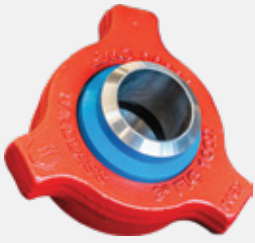


FIG. 1002 UNION

BUTT WELD END

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-1002BWXXS-09	2"	3.05	2.78	5.18	2.75	3.84	14.70
HU-1002BWXXS-11	3"	4.25	3.05	5.70	3.00	4.50	26.89
HU-1002BWXXS-12	4"	4.50	3.11	5.54	2.86	5.31	34.72



FIG. 1502 UNION

- These Hammer Unions are used in cementing, acidizing, choke and kill lines.
- Lip type elastomer seal protects metal-to-metal designed to reduce turbulence in the line.
- Blue nut, red subs
- Available in both threaded and butt weld ends.

THREADED END

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-1502NPT-09	2"	3.25	3.50	6.88	3.75	3.94	21.27
HU-1502NPT-11	3"	4.55	3.82	6.45	3.00	4.56	30.33
HU-1502NPT-12	4"	5.50	4.50	8.49	4.50	5.70	73.15



FIG. 1502 UNION

BUTT WELD END

MODEL	SIZE	A	B	C	D	E	WEIGHT (LBS)
HU-1502BWXXS-09	2"	2.38	3.17	6.23	3.44	3.94	21.60
HU-1502BWXXS-11	3"	3.50	2.87	5.15	2.65	4.56	28.88
HU-1502BWXXS-12	4"	5.63	4.50	8.55	4.57	5.70	81.27