HAMMER UNION FIG 100 BUTT WELD

Three Lug Hammer Union · Forged Steel · Butt Weld Ends · 1,000 psi CWP

BRAND: SARA SAE | SKU: SW-0050 | SIZE 2" TO 8" | 1,000 PSI CWP



FIG. 1 | HAMMER UNION FIG 100, BUTT WELD ENDS

PRODUCT OVERVIEW

The Sara Sae Fig 100 hammer union is a quick make-up pipe connection for low pressure manifold lines and air, water, oil or gas service. A three lug wing nut draws the male and female subs together and is tightened or released with a hammer, so lines can be assembled and broken out quickly without special tools.

Sealing is metal to metal between the ground faces of the two subs, with no elastomer in the joint. Both subs are prepared with bevelled ends for butt welding to the line pipe. The union is rated to 1,000 psi cold working pressure and is colour coded for identification: black nut, yellow subs.

Product type	**Hammer union, three lug**
Figure	**Fig 100**
Material	**Forged steel**
End connection	**Butt weld**
Pressure rating	**1,000 psi CWP**
Size range	**2" to 8"**

TECHNICAL SPECIFICATION

Figure	**Fig 100**
Cold working pressure	**1,000 psi**
Test pressure	**1,500 psi**
End connection	**Butt weld, ASME B16.25**
Sealing	**Metal to metal**
Nut thread	**ACME**

Nut	**Three lug wing nut, forged steel**
Subs	**Forged steel, male and female**
Colour code	**Black nut, yellow subs**
Sour service	**Not rated**
Pipe schedule	**To order**
Make-up	**Hammer, no special tools**

BILL OF MATERIALS

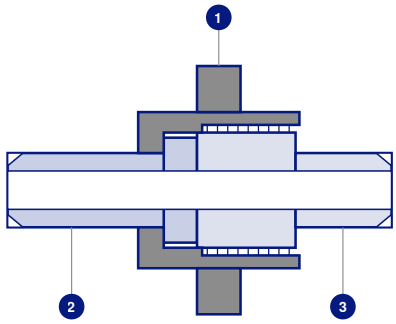


FIG. 2 | SECTIONAL ARRANGEMENT

#	COMPONENT	MATERIAL
1	Wing nut, three lug	Forged steel
2	Male sub	Forged steel
3	Female sub, ACME thread	Forged steel

Steel grade and heat treatment are as per the manufacturer certificate for the supplied batch.

DIMENSIONS AND WEIGHTS

SIZE	NUT RADIUS (IN)	NUT RADIUS (MM)	TOTAL LENGTH (IN)	TOTAL LENGTH (MM)	WEIGHT (KG)
2"	2.90	74	3.23	82	2.6
2.1/2"	3.60	91	4.25	108	5.2
3"	4.00	102	4.59	117	6.3
4"	4.70	119	4.94	125	8.8
5"	5.80	147	6.00	152	14.7
6"	6.50	165	6.84	174	21.0
8"	7.87	200	7.31	186	31.7

Nut radius = pipe centreline to the tip of the lug. Total length = overall length of the made-up union. Figures are converted from the manufacturer catalogue, are nominal and are given for guidance only. Butt weld length can vary with the pipe schedule. Confirm before fabrication. Size 10" is offered against enquiry.

ORDERING INFORMATION

FIELD	OPTIONS
Product code	SW-0050
Figure	Fig 100, 1,000 psi CWP
Size	2", 2.1/2", 3", 4", 5", 6", 8"
End connection	Butt weld. State pipe schedule
Service	Standard
Order example	**SW-0050 / FIG 100 / 2.1/2" / BW SCH 80**

Stock held in Dubai for fast despatch across the UAE and GCC. Contact our sales desk for pricing, availability, project quantities and certification requirements.

PRESSURE AND TEMPERATURE

Cold working pressure	**1,000 psi**
Test pressure	**1,500 psi**
Sour service	**Not applicable**
Service	**Non-shock, cold working**

CWP = cold working pressure, non-shock. On butt weld unions the usable pressure of the joint is also limited by the pipe schedule and the weld. Seal material sets the temperature limit where a seal is fitted. Confirm the duty with SWBM before ordering.

TYPICAL APPLICATIONS

- Oilfield service and well site flow lines
- Water, air and utility manifolds
- Tank, suction and transfer lines
- Truck mounted and skid mounted pumping units
- Temporary pipework and hose connections
- Marine and industrial fluid transfer

COMPLIANCE AND QUALITY

- Figure 100 pattern, colour coded: black nut, yellow subs
- Forged steel wing nut and subs
- Three lug nut for fast make-up and break-out with a hammer
- Weld ends bevelled to ASME B16.25
- Figure number, size and pressure rating marked on the nut
- Material and test certificates on request

INSTALLATION AND OPERATION

- Check that the figure number, size and pressure rating on both halves match before make-up
- Never join halves of different figure numbers or pressure ratings, even where the threads appear to engage
- Remove the seal ring, if fitted, and separate the halves before welding. Weld to a qualified procedure
- Clean and inspect the ACME threads and sealing faces. Replace any damaged seal ring
- Run the nut up by hand, then tighten by striking the lugs squarely with a hammer
- Never tighten, loosen or strike a union while the line is under pressure
- Wear eye protection. Dress or replace nuts with mushroomed or cracked lugs

COMPANY

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