HAMMER UNION FIG 206 BUTT WELD

Three Lug Hammer Union · Forged Steel · Butt Weld Ends · 2,000 psi CWP

BRAND: SARA SAE | SKU: SW-0052 | SIZE 1" TO 10" | 2,000 PSI CWP



FIG. 1 | HAMMER UNION FIG 206, BUTT WELD ENDS

PRODUCT OVERVIEW

The Sara Sae Fig 206 hammer union is a quick make-up pipe connection for general service lines and corrosive environments where a second seal is wanted. 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.

The design follows Fig 200 and adds a secondary O-ring seal to supplement the metal to metal seat. Both subs are prepared with bevelled ends for butt welding to the line pipe. The union is rated to 2,000 psi cold working pressure and is colour coded for identification: blue nut, grey subs.

Product type	**Hammer union, three lug**
Figure	**Fig 206**
Material	**Forged steel**
End connection	**Butt weld**
Pressure rating	**2,000 psi CWP**
Size range	**1" to 10"**

TECHNICAL SPECIFICATION

Figure	**Fig 206**	Nut	**Three lug wing nut, forged steel**
Cold working pressure	**2,000 psi**	Subs	**Forged steel, male and female**
Test pressure	**3,000 psi**	Colour code	**Blue nut, grey subs**
End connection	**Butt weld, ASME B16.25**	Sour service	**2,000 psi working**
Sealing	**Metal to metal + O-ring**	Pipe schedule	**Sch. 40 and 80**
Nut thread	**ACME**	Make-up	**Hammer, no special tools**

BILL OF MATERIALS

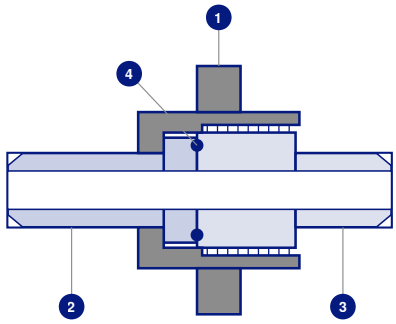

FIG. 2 | SECTIONAL ARRANGEMENT

#	COMPONENT	MATERIAL
1	Wing nut, three lug	Forged steel
2	Male sub	Forged steel
3	Female sub, ACME thread	Forged steel
4	Secondary seal, O-ring	Elastomer

Steel grade and heat treatment are as per the manufacturer certificate for the supplied batch. Seal rings are replaceable and are available as spares.

DIMENSIONS AND WEIGHTS

SIZE	NUT RADIUS (IN)	NUT RADIUS (MM)	TOTAL LENGTH (IN)	TOTAL LENGTH (MM)	WEIGHT (KG)
1"	1.96	50	2.65	67	0.8
1.1/4"	2.17	55	2.78	71	1.1
1.1/2"	2.41	61	2.98	76	1.5
2"	2.90	74	3.17	81	2.5
2.1/2"	3.63	92	4.13	105	4.5
3"	4.26	108	4.58	116	6.8
4"	5.00	127	4.94	125	9.5
5"	5.50	140	6.55	166	15.1
6"	6.43	163	6.66	169	19.3
8"	7.43	189	7.19	183	29.0
10"	9.00	229	9.13	232	41.3

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. Available in butt weld schedules 40 and 80.

ORDERING INFORMATION

FIELD	OPTIONS
Product code	SW-0052
Figure	Fig 206, 2,000 psi CWP
Size	1", 1.1/4", 1.1/2", 2", 2.1/2", 3", 4", 5", 6", 8", 10"
End connection	Butt weld. State pipe schedule
Service	Standard or sour gas
Order example	**SW-0052 / FIG 206 / 1.1/4" / 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	**2,000 psi**
Test pressure	**3,000 psi**
Sour service, working	**2,000 psi**
Sour service, test	**3,000 psi**
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 206 pattern, colour coded: blue nut, grey 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
- Sour gas service versions rated as shown, to NACE MR0175 / ISO 15156
- Butt weld ends available in schedule 40 and 80
- 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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