HAMMER UNION FIG 1003 BUTT WELD

Three Lug Hammer Union · Forged Steel · Butt Weld Ends · 7,500 to 10,000 psi CWP

BRAND: SARA SAE | SKU: SW-0056 | SIZE 3" TO 5" | 7,500 / 10,000 PSI CWP



FIG. 1 | HAMMER UNION FIG 1003, BUTT WELD ENDS

PRODUCT OVERVIEW

The Sara Sae Fig 1003 hammer union is a quick make-up pipe connection for air, water, oil, mud and gas service on high pressure manifolds and drilling rigs where the piping cannot be aligned exactly. 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.

A replaceable O-ring on the male sub provides the primary seal, and the joint tolerates misalignment between the two pipe ends. Both subs are prepared with bevelled ends for butt welding to the line pipe. The union is rated to 7,500 to 10,000 psi cold working pressure and is colour coded for identification: black nut, green subs.

Product type	**Hammer union, three lug**
Figure	**Fig 1003**
Material	**Forged steel**
End connection	**Butt weld**
Pressure rating	**7,500 to 10,000 psi CWP**
Size range	**3" to 5"**

TECHNICAL SPECIFICATION

Figure	**Fig 1003**	Nut	**Three lug wing nut, forged steel**
Cold working pressure	**7,500 to 10,000 psi**	Subs	**Forged steel, male and female**
Test pressure	**11,250 to 15,000 psi**	Colour code	**Black nut, green subs**
End connection	**Butt weld, ASME B16.25**	Sour service	**See page 3**
Sealing	**O-ring on male sub**	Pipe schedule	**To order**
Nut thread	**ACME**	Make-up	**Hammer, no special tools**

BILL OF MATERIALS

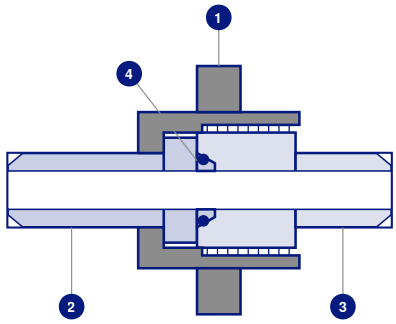


FIG. 2 | SECTIONAL ARRANGEMENT

#	COMPONENT	MATERIAL
1	Wing nut, three lug	Forged steel
2	Male sub	Forged steel
3	Female sub, ACME thread	Forged steel
4	O-ring on male sub	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)	CWP (PSI)
3"	4.80	122	8.87	225	21.5	10,000
4"	6.00	152	10.90	277	35.4	7,500
5"	6.00	152	10.90	277	36.1	7,500

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. 5" unions are supplied with butt weld ends only.

ORDERING INFORMATION

FIELD	OPTIONS
Product code	SW-0056
Figure	Fig 1003, 7,500 to 10,000 psi CWP
Size	3", 4", 5"
End connection	Butt weld. State pipe schedule
Service	Standard or sour gas
Order example	**SW-0056 / FIG 1003 / 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

3" standard service	**10,000 psi CWP, 15,000 psi test**
3" sour service	**7,500 psi CWP, 11,250 psi test**
4" and 5" standard service	**7,500 psi CWP, 11,250 psi test**
4" and 5" sour service	**5,000 psi CWP, 7,500 psi test**

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
- Cementing, fracturing and mud pump lines
- Choke and kill, standpipe and manifold connections
- Truck mounted and skid mounted pumping units
- Temporary pipework and hose connections
- Marine and industrial fluid transfer

COMPLIANCE AND QUALITY

- Figure 1003 pattern, colour coded: black nut, green 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

Sunel Wala Building Materials
Trading Co. LLC (SWBM)
Dubai, United Arab Emirates

SALES ENQUIRIES

info@swbm-fittings.com
Tel: +971 4 238 5652
Mobile / WhatsApp: +971 50 748 1772

ONLINE

www.swbm-fittings.com
Brand: Sara Sae

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