

# Offshore Drilling & Pipeline Equipment

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## Hammer Lug Unions

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# 7

Hammer Lug Unions are designed and manufactured in accordance with the following specifications:

<b>API 6A</b>	Specification for Wellhead and Christmas Tree Equipment.
<b>API RP-14E</b>	Recommended Practice for Design and Installation of Offshore Production Platform Piping.
<b>NACE MR-01-75</b>	Sulphide Stress Cracking Resistant Metallic Materials for Oilfield Equipment
<b>ASME VIII</b>	Boiler and Pressure Vessel Code.
<b>ANSI B31.3</b>	Chemical Plant and Petroleum Refinery Piping.

Hammer Lug Unions are available in a range of sizes for use with the following ratings and services:

**TABLE 7.0**

Figure No.	100	200	206	600	602	1002*	1003**	1004	1502	2002	2202
<b>Standard Service</b>											
Max. Working Pressure	1,000 PSI	2,000 PSI	2,000 PSI	6,000 PSI	6,000 PSI	10,000 PSI	10,000 PSI	10,000 PSI	15,000 PSI	20,000 PSI	N/A
Max. Test Pressure	1,500 PSI	3,000 PSI	3,000 PSI	9,000 PSI	9,000 PSI	15,000 PSI	15,000 PSI	15,000 PSI	22,500 PSI	30,000 PSI	N/A
<b>Sour Service</b>											
Max. Working Pressure	N/A	N/A	N/A	6,000 PSI	6,000 PSI	7,500 PSI	7,500 PSI	7,500 PSI	10,000 PSI	N/A	15,000 PSI
Max. Test Pressure	N/A	N/A	N/A	9,000 PSI	9,000 PSI	11,250 PSI	11,250 PSI	11,250 PSI	15,000 PSI	N/A	22,500 PSI

Please contact IVP Solutions for any special material or dimensional requirements.

\*NOTE: 4", 5" and 6" Fig 1002 HLU's are de-rated to 7500 PSI CWP in standard service and 5,000 PSI CWP in sour service.

\*\*NOTE: 4" and 5" Fig 1003 HLU's are de-rated to 7500 PSI CWP in standard service and 5,000 PSI CWP in sour service.



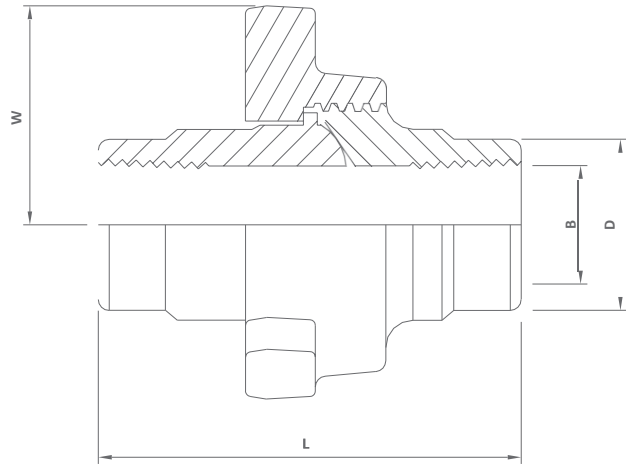


TABLE 7.1

Figure 100 Union						
Nominal Pipe Size		W. Nut Radius	D. Outside Diameter	L. End-to-End Threaded	B. Max Inside Diameter	Weight
(in)	(mm)	(mm)	(mm)	(mm)	(mm)	(kg)
2	50	73	70	82	55	2.20
2 1/2	65	89	86	108	65	4.50
3	80	103	105	116	81	7.50
4	100	116	130	123	106	10.50
5	125	146	162	152	130	14.80
6	150	165	187	174	160	21.60
8	200	184	243	183	209	30.00

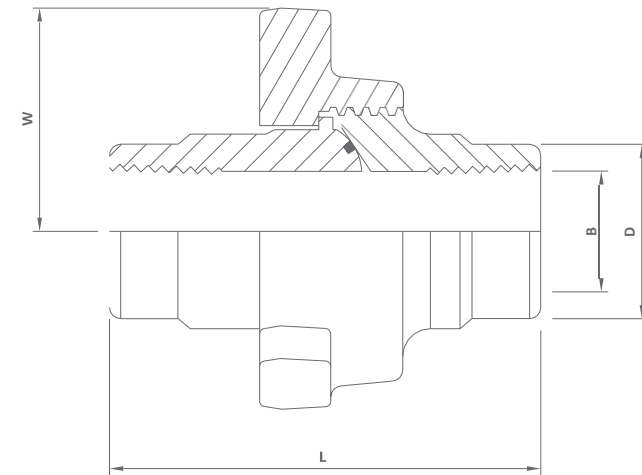


TABLE 7.2

Figure 200 and 206 Union						
Nominal Pipe Size		W. Nut Radius	D. Outside Diameter	L. End-to-End Threaded	B. Max Inside Diameter	Weight
(in)	(mm)	(mm)	(mm)	(mm)	(mm)	(kg)
1	25	51	40	63	28	0.80
1 1/4	32	57	51	71	37	1.00
1 1/2	40	62	58	74	43	1.20
2	50	73	70	81	55	2.20
2 1/2	65	89	84	105	65	3.80
3	80	99	104	117	81	6.70
4	100	114	130	125	106	8.30
5	125	146	162	152	130	14.80
6	150	165	187	174	160	21.60
8	200	184	243	183	209	30.00



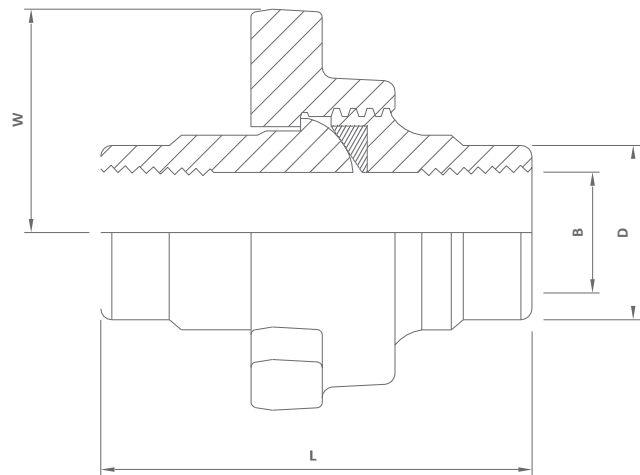


TABLE 7.3

Figure 600 Union						
Nominal Pipe Size		W. Nut Radius	D. Outside Diameter	L. End-to-End Threaded	B. Max Inside Diameter	Weight
(in)	(mm)	(mm)	(mm)	(mm)	(mm)	(kg)
1	25	57	44	90	28	1.70
2	50	89	76	163	55	6.60
3	80	114	106	222	81	13.20
4	100	125	133	255	106	18.20

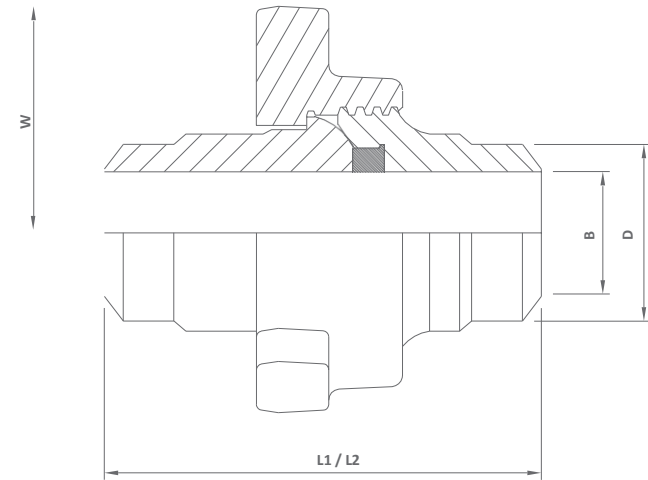


TABLE 7.4

Figure 602 Union							
Nominal Pipe Size		W. Nut Radius	D. Outside Diameter	L1. End-to-End Threaded	L2. End-to-End Butt Weld	B. Inside Diameter Threaded	Weight
(in)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(kg)
1	25	57	44	89	90	28	1.80
1 1/2	40	76	65	124	-	43	4.10
2	50	89	78	133	128	52	6.60
3	80	114	107	157	136	81	11.10
4	100	125	135	208	147	106	15.30



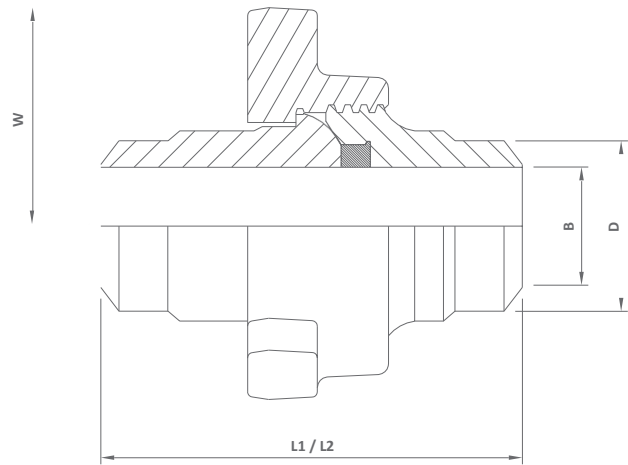


TABLE 7.5

Figure 1002 Union							
Nominal Pipe Size		W. Nut Radius	D. Outside Diameter	L1. End-to-End Threaded	L2. End-to-End Butt Weld	B. Inside Diameter Threaded	Weight
(in)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(kg)
1	25	57	33	89	90	28	1.80
2	50	89	77	133	127	52	6.60
3	80	114	107	157	136	77	11.10
4	100	125	135	208	147	102	15.30
5	125	152	141	-	157	-	27.00
6	150	184	169	-	166	-	39.00

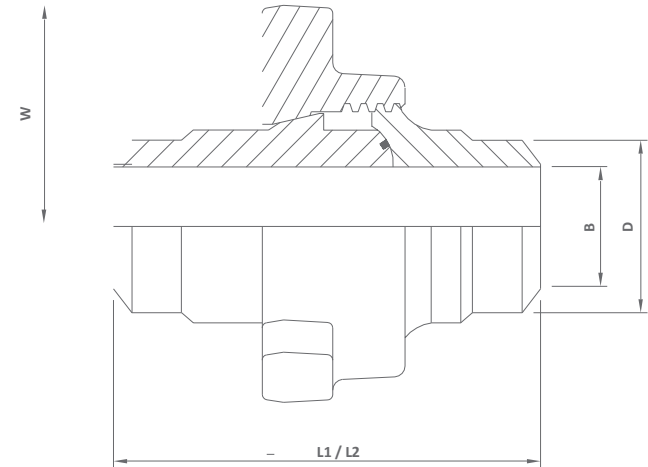


TABLE 7.6

Figure 1003 Misaligned Union							
Nominal Pipe Size		W. Nut Radius	D. Outside Diameter	L1. End-to-End Threaded	L2. End-to-End Butt Weld	B. Inside Diameter Threaded	Weight
(in)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(kg)
2	50	89	73	120	120	50	6.00
3	80	124	113	232	231	81	20.10
4	100	152	140	279	279	101	36.90
5	125	152	141	-	278	-	36.40



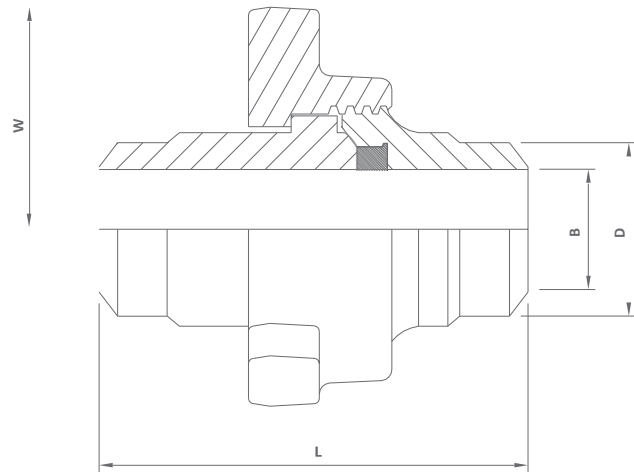


TABLE 7.7

Figure 1004 Union					
Nominal Pipe Size		W. Nut Radius	D. Outside Diameter	L. End-to-End Butt Weld	Weight
(in)	(mm)	(mm)	(mm)	(mm)	(kg)
5	125	152	141	210	38.60
6	150	184	168	238	36.60

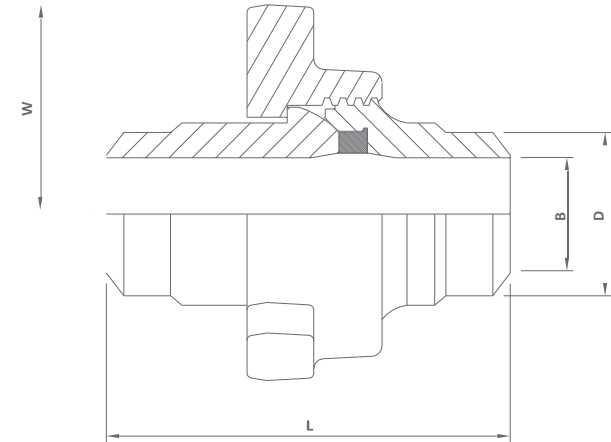


TABLE 7.8

Figure 1502 Union					
Nominal Pipe Size		W. Nut Radius	D. Outside Diameter	L. End-to-End Butt Weld	Weight
(in)	(mm)	(mm)	(mm)	(mm)	(mm)
1	25	69	55	111	3.70
1 1/2	40	93	75	137	7.50
3	80	116	114	133	13.00
4	100	152	114	216	34.00
5	125	165	141	229	43.00
6	150	184	168	248	66.00



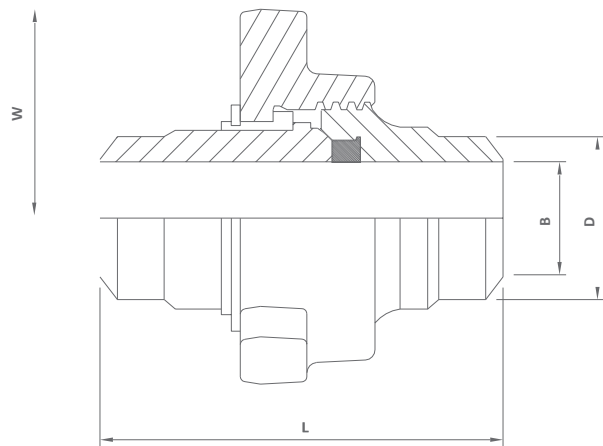


TABLE 7.9

Figure 2002 Union					
Nominal Pipe Size		W. Nut Radius	D. Outside Diameter	L. End-to-End Butt Weld	Weight
(in)	(mm)	(mm)	(mm)	(mm)	(kg)
2	50	95	64	188	10.50
3*	80	124	105	243	21.80
4**	100	152	132	216	34.50
5	125	165	155	273	50.00
6	150	184	197	330	77.30

\*NOTE: 3" Fig 2002 HLU is also known as 2 1/2" by other suppliers

\*\*NOTE: 4" Fig 2002 HLU is also known as 3" by other suppliers

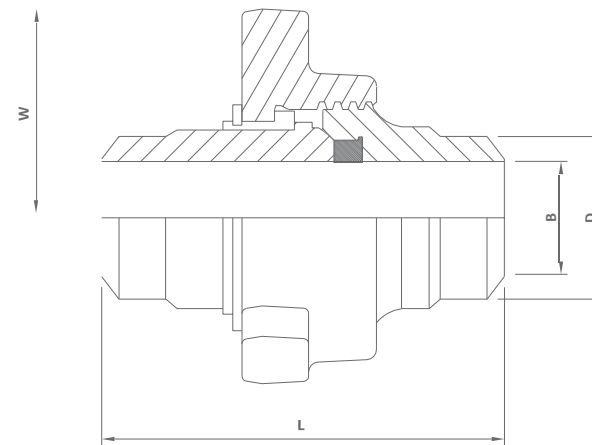


TABLE 7.10

Figure 2202 Union					
Nominal Pipe Size		W. Nut Radius	D. Outside Diameter	L. End-to-End Butt Weld	Weight
(in)	(mm)	(mm)	(mm)	(mm)	(kg)
2	50	95	64	188	10.50
3*	80	124	105	243	21.80
4**	100	152	140	216	34.50
5	125	165	155	273	50.00
6	150	184	197	330	77.30

\*NOTE: 3" Fig 2202 HLU is also known as 2 1/2" by other suppliers

\*\*NOTE: 4" Fig 2202 HLU is also known as 3" by other suppliers







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