

Hammer Unions



Hammer Unions are high-pressure threaded or welded connections with two halves; a threaded female half and a wing male half with swivel nut. The two halves seal upon turning and hammering the nut half together with the threaded half. Hammer unions come in sizes from 1" up to 12", and for pressures up to 15,000 psi. Hammer unions are commonly used in oilfield and industrial applications for sealing two pieces of pipe or hose together. Hammer unions are generally attached via welding or threads.

HDS are able to supply a full line of union swivel connections to fit a variety of applications. Available with line pipe, butt-weld or socket weld connections, our unions are interchangeable with other name brand manufacturers that adhere to industry standards.

All hammer unions are colour coded to specific pressure ratings. For example a figure 1002 is blue with red nut and is rated at 10,000 psi, where as a figure 100 is yellow with black nut and rated for 1,000 psi. Please see below chart for complete pressure rating and colour codes for each high pressure hammer union available.

To ensure customer satisfaction, Unions are available with with full trace-ability and type approved by Det Norske Veritas. In addition, they meet API 6A and API 16C requirements, as well as NACE-MR-01-75 (sour gas service).

Hammer union working pressure chart and size availability

Chart		Pressure Rating (Psi)				Nominal Pipe Size											
Figure Number	Assembly Key	Standard Service		Sour Gas Service		1	1¼	1½	2	2½	3	4	5	6	8	10	12
		Working	Test	Working	Test	25	32	40	50	65	80	100	125	150	200	250	300
		(mm)															
40		400	600	n/a	n/a				•								
50		500	750	n/a	n/a							•					
100		1,000	1,500	n/a	n/a			•	•	•	•	•	•	•	•	•	•
200		2,000	3,000	n/a	n/a	•	•	•	•	•	•	•	•	•	•	•	•
206		2,000	3,000	n/a	n/a	•	•	•	•		•	•	•	•	•	•	•
207		2,000	3,000	n/a	n/a						•	•		•			
300		2,000	3,000	n/a	n/a			•									
400		2,500	3,750	2,500	3,750									•	•	•	•
400		4,000	6,000	4,000	6,000				•		•	•					
602		6,000	9,000	6,000	9,000	•		•	•		•	•					
607		6,000	9,000	6,000	9,000				•								
1002		10,000	15,000	7,500	11,250	•			•		•	•	•	•			
1003		10,000	15,000	7,500	11,250						•	•	•				
1004		10,000	15,000	7,500	11,250							•	•				
1502		15,000	22,500	10,000	15,000	•		•	•	•	•	•	•				
2202		n/a	n/a	15,000	22,500				•		•						

HDS Hoses Australia Pty Ltd
 34 Beaconsfield Ave, Midvale, WA 6056
 Tel: +61 89274 0020
 Fax: +61 89274 6134
admin@HDS-Hoses.com



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