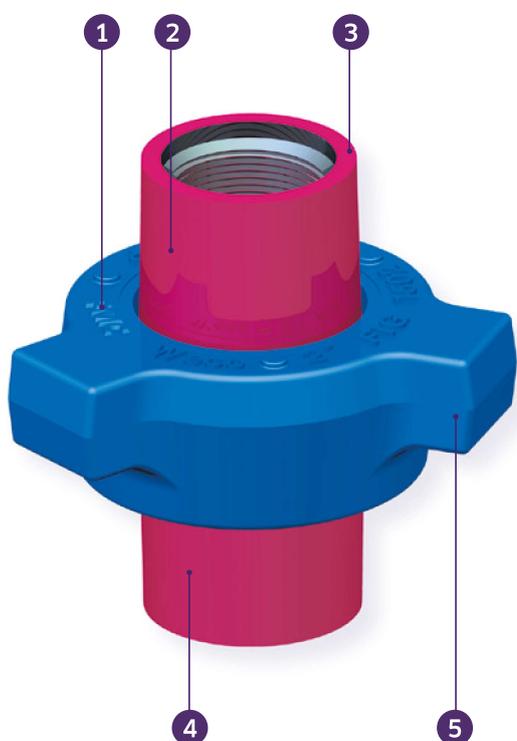


# Original Weco® wing unions

Weco® wing unions are the most complete line of standard and sour gas service pipe connectors in the world.

Available in 1 to 12-inch nominal pipe sizes with cold working pressures up to 20,000 psi, Weco® wing unions are manufactured using the finest raw materials, tooling procedures, and heat-treating techniques available. Materials meet ASME and AISI standards. Each union is carefully inspected to ensure long, dependable service in the most extreme conditions. Like all pressure containing products, Weco® wing unions require special handling. **(See Warnings, page 66).**



## 1. Positive identification

For positive identification in the field, all Weco® wing union nuts and subs include the Weco® name union figure number, size, and pressure rating. Additionally, for sour gas service are stamped "Sour Gas."

## 2. Simple identification

New, factory-shipped Weco® wing unions are color coded for quick identification.

## 3. Choice of end connections

Weco® wing unions are available with line pipe or tubing threads, butt-weld, or non-pressure seal end connections.

## 4. Interchangeable parts

All Weco® wing union parts of the same figure number, size, and pressure rating are interchangeable. This feature makes it easy to mate male and female subs that are frequently made-up and broken-out.

## 5. Fast make-up, break-out

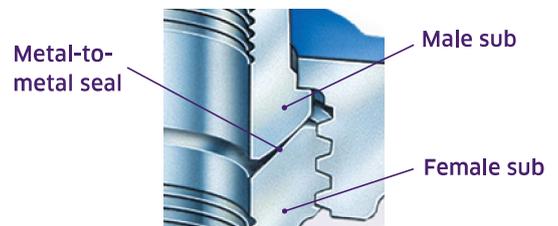
Three lug nuts and self-locking ACME threads provide fast make-up and break-out regardless of position or space restrictions.

# Proven seal designs

Pressure rating shown for integral and non-threaded end configuration. May be derated for threaded end configuration.

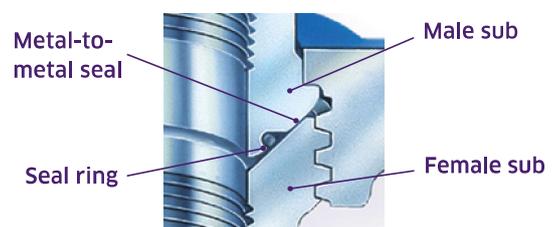
## Low-pressure services (1,000 to 2,000 psi)

Weco® wing unions for low-pressure services feature a primary metal-to-metal seal. The spherical surface of the male sub and conical surface of the female sub provide a large, ball-and-cone sealing surface. This metal-to-metal seal remains leak-proof even when one surface is slightly pitted or misaligned.



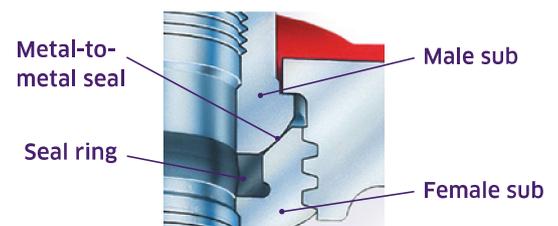
## Medium-pressure services (2,000 to 4,000 psi)

Many Weco® wing union designs supplement the metal-to-metal seal with a resilient O-ring in the male sub. The replaceable O-ring extends union life and protects the metal-to-metal seal against corrosion.



## High-pressure services (6,000 to 20,000 psi)

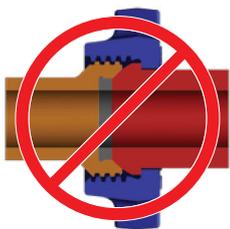
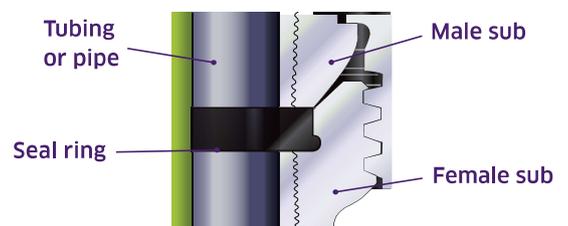
Weco® wing unions for high-pressure services feature a replaceable, lip-type seal ring in the female sub. This primary seal protects the secondary metal-to-metal seal from abrasion and corrosion while minimizing flow turbulence.



## NPS (non-pressure seal)

(Option Figures 602, 1002, and 1502)

The Weco® non-pressure seal option is especially designed for abrasive, high-pressure wing union services where welded connections are undesirable. This design provides strong, permanent end connections without butt-welding. The union ends are shop assembled to pipe or tubing. An epoxy thread compound is used to secure the connection.

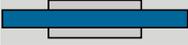
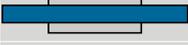
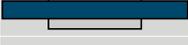
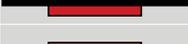
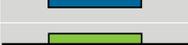
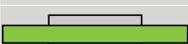


## Warning

### Interchangeable parts

Weco® wing union parts of the same figure number, size and pressure rating are interchangeable, making it easy to match male and female subs that are frequently made-up and broken-out. For positive identification in the field, all Weco® wing union nuts and subs include the Weco® name, figure number, size, and pressure rating. It is vital that the user positively identify union connections and components to avoid mismatch conditions and potential union failure.

## Wing Unions

Figure No.	Assembly color key standard service	Pressure rating, psi, bar				Nominal pipe sizes, inches		
		Standard		Sour gas (see note 8)		1 25	1¼ 32	1½ 40
		Cold working	Test	Cold working	Test			
100		1,000 69	1,500 103	N/A	N/A			
200		2,000 138	3,000 207	N/A	N/A	▶	▶	▶
206		2,000 238	3,000 207	N/A	N/A	▶	▶	▶
207		2,000 138	3,000 207	N/A	N/A			
400		2,500 172	3,750 259	2,500 172	3,750 259			
400		4,000 276	6,000 414	4,000 276	6,000 414			
602		6,000 414	9,000 621	6,000 414	9,000 621	▶	▶	▶
1002		10,000 690	15,000 1034	7,500 517	11,250 776	▶	▶	▶
1003		10,000 690	15,000 1034	7,500 517	11,250 776			
1502		15,000 1034	22,500 1551	10,000 690	15,000 1034	▶		▶
1505		15,000 1034	22,500 1551	10,000 690	15,000 1034			
2002		20,000 1379	30,000 2068	N/A	N/A			
2202		N/A	N/A	15,000 1034	22,500 1551			

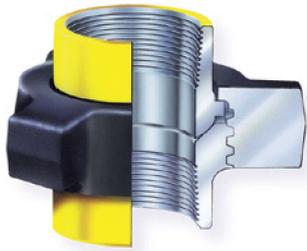
\* N/A - Not Available

\* All end connections with line pipe threads unless otherwise noted.

1. Butt-weld available. Consult factory for wall thickness.
2. Non-pressure seal configurations available.
3. Power make-up must be used for line pipe threaded connections to achieve rated cold working pressure.
4. Line pipe threads are not offered for sour gas service in this figure number.
5. Line pipe threads are not recommended for sour gas service above 4-inch nominal pipe size.
6. Figure 400 available in 5 1/2 - and 7-inch OD with casing threads.
7. Available in butt-weld ends only.
8. All unions for sour gas service are painted olive green, stamped "SOUR GAS" or "NACE MR-01-75" and have specially modified material properties.
9. 5 and 6-inch sizes rated at 7,500 psi CWP and 11,250 test; 5 and 6-inch unions for sour gas service rated at 5,000 psi CWP and 7,500 psi test.
10. 4 and 5-inch sizes rated at 7,500 psi CWP and 11,250 test; 4 and 5-inch unions for sour gas service rated at 5,000 psi CWP and 7,500 psi test.
11. Available as integral end connection only.

Nominal pipe sizes, inches									Notes
2 50	2½ 65	3 80	4 100	5 125	6 150	8 200	10 250	12 300	
▶	▶	▶	▶		▶	▶			
▶	▶	▶	▶						1
▶	▶	▶	▶		▶	▶	▶		1
		▶	▶		▶	▶	▶		1
				▶	▶	▶		▶	1,5,6
▶	▶	▶	▶						1,4
▶	▶	▶	▶						1,2
▶	▶	▶	▶	▶	▶				1,2,3,9
▶		▶	▶	▶					1,3,10
▶	▶	▶	▶						1,2,3
		▶							11
▶		▶							7
▶		▶							7

**Sour Gas** TechnipFMC manufactures Weco® sour gas unions in accordance with the National Association of Corrosion Engineers (NACE) Standard MR-01-75 and American Petroleum Institute's (API) Standard RP-14-E.



**Figure 100**

1,000 psi cold working pressure

**Recommended service**

Manifold and line connections

**Features**

- ▶ Pressure-tight make-up with hammer
- ▶ Economical low-pressure union



**Figure 200**

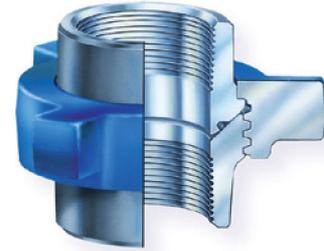
2,000 psi cold working pressure

**Recommended service**

General service manifolds and lines

**Features**

- ▶ Pressure-tight make-up with hammer
- ▶ Economical low-pressure union



**Figure 206**

2,000 psi cold working pressure

**Recommended service**

Manifold line connections, suction service, and corrosion service

**Features**

- ▶ O-ring in male sub improves sealing and protects metal-to-metal seal against corrosion
- ▶ Replaceable O-ring extends union service life
- ▶ 1 to 10-inch sizes



**Figure 207**

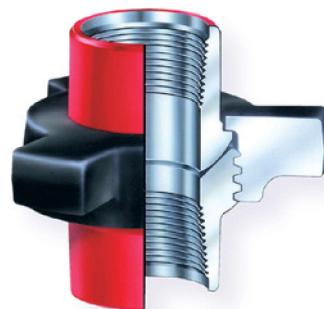
2,000 psi cold working pressure

**Recommended service**

Seals manifold connections and protects union threads

**Features**

- ▶ Parts interchangeable with Figures 200 and 206
- ▶ O-ring on blanking cap ensures a leak-free seal
- ▶ Cap can be tapped for pressure gauge
- ▶ Available in butt-weld



**Figure 400**

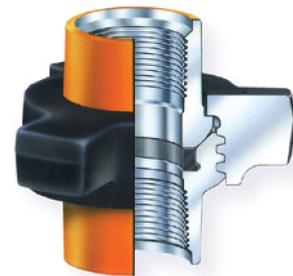
4,000 psi cold working pressure through 4-inch sizes; 2,500 psi cold working pressure, 5 through 12-inch sizes

**Recommended service**

Manifold line connections, pump suction, and mud services

**Features**

- ▶ 2-1/2 through 12-inch sizes have O-rings for primary seal
- ▶ Butt-weld available
- ▶ Available for sour gas service



**Figure 602**

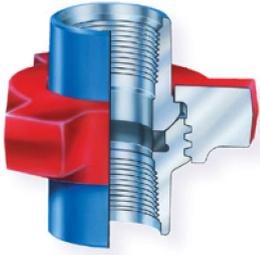
6,000 psi cold working pressure

**Recommended service**

Manifold line connections and mud service

**Features**

- ▶ Replaceable, lip-type seal provides primary seal, protects secondary metal-to-metal seal, and minimizes flow turbulence
- ▶ Butt-weld available
- ▶ Available for sour gas service at 6,000 psi cold working pressure



**Figure 1002**

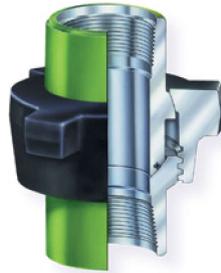
10,000 psi cold working pressure through 4-inch sizes; 7,500 psi cold working pressure, 5 and 6-inch sizes

**Recommended service**

Cementing, fracturing, acidizing, testing, and choke-and-kill lines

**Features**

- ▶ O-ring in male sub improves sealing and protects metal-to-metal seal against corrosion
- ▶ Replaceable O-ring extends union service life
- ▶ 1 to 10-inch sizes



**Figure 1003**

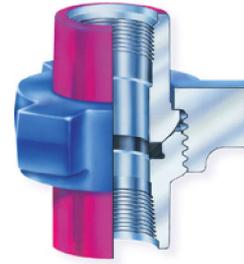
10,000 psi cold working pressure, 2 and 3-inch sizes; 7,500 psi cold working pressure, 4 and 5-inch sizes

**Recommended service**

For high-pressure connections where lines cannot be aligned

**Features**

- ▶ Ball seat provides positive seal with up to 7-1/2° misalignment; 2-inch model up to 4°
- ▶ Replaceable O-ring on male sub provides primary seal
- ▶ Available with threaded or butt-weld ends



**Figure 1502**

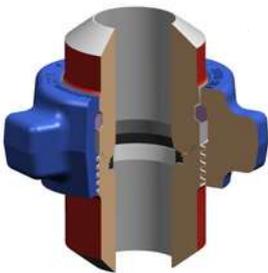
15,000 psi cold working pressure

**Recommended service**

Cementing, fracturing, acidizing, testing, and choke-and-kill lines

**Features**

- ▶ Replaceable, lip-type seal
- ▶ Available for sour gas service: 10,000 psi cold working pressure; butt-weld or non-pressure seal configurations only
- ▶ Butt-weld available



**Figure 1505**

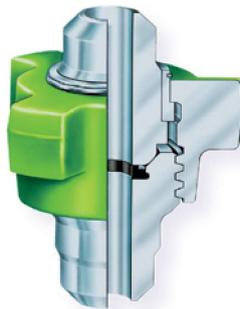
15,000 psi cold working pressure

**Recommended service**

Fracturing,

**Features**

- ▶ Significant improvements in critical areas significantly extending life (available in 3-inch only)
- ▶ Thread start marker on nut eliminates cross-threading and reduces make up time
- ▶ Backward connectable with Weco® 3" 1502 iron
- ▶ Butt-weld available



**Figure 2002**

20,000 psi cold working pressure

**Recommended service**

Cementing, fracturing, acidizing, testing, and choke-and-kill lines

**Features**

- ▶ Replaceable, lip-type seal
- ▶ 2 and 3-inch line sizes
- ▶ Butt-weld configurations only



**To enhance safety,**

2" Figure 602 and 1002 female subs have been modified so they cannot engage the 2" Figure 1502 nut. A Go No-Go identification ring is available to determine whether the female sub is a 2" Figure 602, 1002 or a 2" Figure 1502.

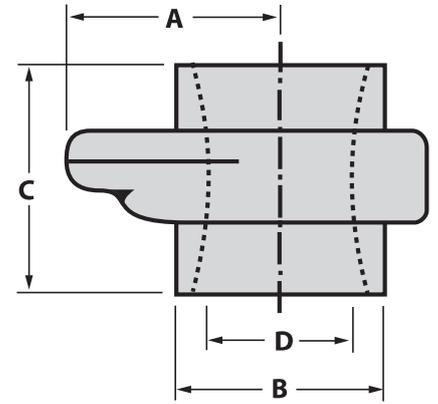


See specifications tables (pgs. 52-55) for sizes, dimensions, weights, materials, and part numbers.

# Weco® wing union specifications

**Figure 100** - 1,000 psi (69 bar) cold working pressure

Nominal pipe size	in.	2	2½	3	4	6	8
Union part No.		3200609	3200610	3200611	3200612	3200795	3200796
Qty/carton		16	10	6	4	1	1
A Clearance radius	in.	3 <sup>3</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>2</sub>	5 <sup>1</sup> / <sub>16</sub>	6 <sup>1</sup> / <sub>16</sub>	8 <sup>7</sup> / <sub>32</sub>
	mm	81	100	114	135	176	209
B Outside diameter	in.	2 <sup>1</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>	4	5 <sup>1</sup> / <sub>16</sub>	7 <sup>1</sup> / <sub>16</sub>	9 <sup>1</sup> / <sub>32</sub>
	mm	69.8	83	102	132	186	241
C End-to-end threaded	in.	3 <sup>3</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>2</sub>	4 <sup>1</sup> / <sub>2</sub>	5 <sup>1</sup> / <sub>4</sub>	6 <sup>3</sup> / <sub>32</sub>	7 <sup>3</sup> / <sub>16</sub>
	mm	92	109	124	146	171	183
D Inside diameter	in.	2 <sup>1</sup> / <sub>2</sub>	2 <sup>5</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>16</sub>	6 <sup>1</sup> / <sub>32</sub>	8 <sup>1</sup> / <sub>16</sub>
	mm	54.7	65	81	106	160	209
Weight	lb	6	10	14	22	45	66
	kg	2.7	4.5	6.4	10	20.4	30
Material, sub		DI	DI	DI	DI	DI	DI
Material, nut		DI	DI	DI	DI	DI	DI



**Figure 200** - 2,000 psi (138 bar) cold working pressure

Nominal pipe size	in.	1	1¼	1½	2	2½	3	4
Union part No.		3200829	3200960	3200773	3200778	3200899	3200782	3200912
Qty/carton		40	28	28	16	10	6	4
A Clearance radius	in.	1 <sup>3</sup> / <sub>32</sub>	2 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	3	3 <sup>3</sup> / <sub>16</sub>	4	4 <sup>1</sup> / <sub>16</sub>
	mm	50	57	64	76	90	102	119
B Outside diameter	in.	1 <sup>1</sup> / <sub>32</sub>	2	2 <sup>1</sup> / <sub>4</sub>	2 <sup>29</sup> / <sub>32</sub>	3 <sup>1</sup> / <sub>32</sub>	4 <sup>3</sup> / <sub>32</sub>	5 <sup>1</sup> / <sub>16</sub>
	mm	40	51	57	74	84	104	130
C End-to-end threaded	in.	2 <sup>19</sup> / <sub>32</sub>	2 <sup>25</sup> / <sub>32</sub>	2 <sup>25</sup> / <sub>32</sub>	3 <sup>3</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>16</sub>	4 <sup>7</sup> / <sub>32</sub>	4 <sup>1</sup> / <sub>16</sub>
	mm	66	71	71	90	105	115	125
D Inside diameter	in.	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>32</sub>	1 <sup>7</sup> / <sub>32</sub>	2 <sup>3</sup> / <sub>32</sub>	2 <sup>1</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	4 <sup>3</sup> / <sub>16</sub>
	mm	28	37	43	55	65	81	106
Weight	lb	2	2	3	5	9	13	18
	kg	0.9	0.9	1.4	2.3	4.1	5.9	8.2
Material, sub		CS	CS	CS	DI	CS	SF	SF
Material, nut		DI	DI	DI	DI	DI	SF	SF

**Note:**

- Materials
- AS - alloy steel
- CS - carbon steel
- DI - ductile iron casting
- SC - steel casing
- SF - steel forging

**Figure 206** - 2,000 psi (138 bar) cold working pressure

Nominal pipe size	in.	1	1¼	1½	2	2½	3	4	6	8	10
Union part No.		3207627	3207633	3207636	3207281	3207278	3203048	3205449	3202521	3202552	3202566
Qty/carton		40	28	28	16	10	6	4	1	1	1
A Clearance radius	in.	2	2 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	3	3 <sup>3</sup> / <sub>16</sub>	4	4 <sup>1</sup> / <sub>16</sub>	6 <sup>1</sup> / <sub>4</sub>	7 <sup>7</sup> / <sub>16</sub>	9
	mm	51	57	64	76	90	102	119	159	189	229
B Outside diameter	in.	1 <sup>1</sup> / <sub>32</sub>	1 <sup>3</sup> / <sub>32</sub>	2 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>16</sub>	3 <sup>1</sup> / <sub>32</sub>	4 <sup>3</sup> / <sub>32</sub>	5 <sup>1</sup> / <sub>8</sub>	7 <sup>1</sup> / <sub>2</sub>	9 <sup>1</sup> / <sub>16</sub>	11 <sup>1</sup> / <sub>2</sub>
	mm	40	50	57	71	85	104	130	191	243	292
C End-to-end threaded	in.	2 <sup>29</sup> / <sub>32</sub>	2 <sup>29</sup> / <sub>32</sub>	2 <sup>29</sup> / <sub>32</sub>	3 <sup>1</sup> / <sub>4</sub>	4 <sup>1</sup> / <sub>16</sub>	4 <sup>7</sup> / <sub>32</sub>	5	6 <sup>3</sup> / <sub>32</sub>	7 <sup>1</sup> / <sub>16</sub>	9 <sup>3</sup> / <sub>32</sub>
	mm	67	71	71	83	105	115	127	169	183	231
D Inside diameter	in.	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>32</sub>	1 <sup>7</sup> / <sub>32</sub>	2 <sup>3</sup> / <sub>32</sub>	2 <sup>1</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>16</sub>	6 <sup>1</sup> / <sub>32</sub>	8 <sup>1</sup> / <sub>16</sub>	10 <sup>1</sup> / <sub>16</sub>
	mm	28	37	43	55	65	81	106	160	209	262
Weight	lb	2	2	3	5	8	13	18	42	65	90
	kg	0.9	0.9	1.4	2.3	3.6	5.9	8.2	19.1	29.5	40.8
Material, sub		CS	CS	CS	SF	CS	SF	SF	SF	SF	SF
Material, nut		DI	DI	DI	DI	DI	SF	SF	SF	SC	SC

# Weco® wing union specifications

**Figure 207** - 2,000 psi (138 bar) cold working pressure

Nominal pipe size	in.	3	4	6	8	10
Union part No.		3207906	3207907	3207908	3207981	3207982
Qty/carton		8	4	1	1	1
A Clearance radius	in. mm	5¼ 146	7⅞ 135	9⅝ 252	12¾ 314	14½ 368
B Outside diameter	in. mm	4¾ 104	5½ 130	7½ 191	9⅞ 243	11½ 292
C End-to-end threaded	in. mm	3¾ 95	4⅞ 109	5⅝ 148	8 219	9⅞ 246
D Inside diameter	in. mm	3¾ 81	4⅞ 106	6½ 160	8¼ 209	10⅞ 262
Weight	lb kg	10 4.5	16 7.3	37 16.8	70 31.9	96 43.5
Material, sub		SF	SF	SF	SF	SF
Material, nut		SC	SF	SC	SC	SC

**Figure 400** - 4,000 psi (276 bar) to 4"; 2,500 psi (172 bar) cold working pressure, 5" to 12"

Nominal pipe size	in.	2	2½	3	4	5½ OD*	6	7 OD*	8	12
Union part No.		3200291	3200290	3200292	3200337	3206347	3202179	3204333	3202060	3201578
Qty/carton		6	5	4	3	1	1	1	1	1
A Clearance radius	in. mm	3½ 89	4½ 103	4¾ 111	5 127	5⅝ 148	6¼ 171	6¼ 171	7⅞ 198	10⅞ 272
B Outside diameter	in. mm	3¾ 78	3¾ 89	4¾ 106	5½ 133	6¼ 159	7¼ 197	7¼ 171	9⅞ 244	14 356
C End-to-end threaded	in. mm	5¼ 133	6¼ 154	6¾ 158	8½ 209	10⅞ 266	11⅞ 281	11⅞ 281	11⅞ 291	10⅞ 278
D Inside diameter	in. mm	2¾ 55	2¾ 65	3¾ 81	4¾ 106	5 130	6½ 160	6¾ 169	8¼ 209	12⅞ 313
Weight	lb kg	11 5	16 7.3	19 8.6	28 12.7	47 21.3	64 29	61 27.7	95 43.1	163 73.9
Material, sub		SF	CS	SF	SF	SF	CS	CS	SF	SC
Material, nut		SF	SF	SF	SF	SC	SC	SC	SC	SC

**Figure 602** - 6,000 psi (414 bar) cold working pressure

Nominal pipe size	in.	1	1¼	1½	2	3	4
Union part No.		3202377	3202434	3202428	P533564	3202416	3202399
Qty/carton		32	9	9	6	4	2
A Clearance radius	in. mm	2¾ 60	3¼ 83	3¾ 83	3¾ 92	4½ 114	5¾ 132
B Outside diameter	in. mm	1¾ 44	2¾ 65	2¾ 65	3¾ 78	4¾ 106	5¾ 133
C End-to-end threaded	in. mm	3¾ 90	4¾ 124	4¾ 124	5¾ 146	6¾ 159	8¼ 210
D Inside diameter	in. mm	1¾ 28	1¾ 36	1¾ 43	2¾ 52	3¾ 81	4¾ 106
Weight	lb kg	3 1.4	10 4.5	9 4.1	15 6.8	21 9.5	31 14
Material, sub		CS	CS	CS	SF	SF	SF
Material, nut		SF	SF	SF	SF	SF	SF

**Note:**

\* Casing thread standard  
- 2 inch does have O-ring

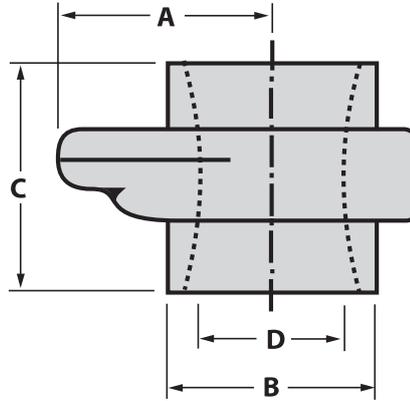
**- Materials**

- AS - alloy steel
- CS - carbon steel
- DI - ductile iron casting
- SC - steel casing
- SF - steel forging

# Weco® wing union specifications

**Figure 1003** - 10,000 psi (690 bar) 2"-3"; 7,500 psi (517 bar) cold working pressure 4"-5" \*

Nominal pipe size	in.	2	3	4
Union part No.		3208519	3219928	3219932
Qty/carton		6	2	1
A Clearance radius	in. mm	3¼ 95	4¾ 124	5¼ 146
B Outside diameter	in. mm	3 76	4¾ 111	5½ 140
C End-to-end threaded	in. mm	4¾½ 118	9¾ 232	10¾½ 278
D Inside diameter	in. mm	2¾½ 55	3¾ 81	4 102
Weight	lb kg	12 5.4	45 20.4	74 33.6
Material, sub		AS	AS	AS
Material, nut		SF	SC	SF



**Figure 1002** - 10,000 psi (690 bar) to 4"; 7,500 psi (517 bar) cold working pressure, 5"-6" \*

Nominal pipe size	in.	1	1¼	1½	2	2½	2½ (EUE)	3	4
Union part No.		3205681	3205675	3205665	P535063	3205626	3206927	3205565	3205533
Qty/carton		32	10	10	6	5	5	4	2
A Clearance radius	in. mm	2¾½ 56	3¾½ 77	3¾½ 77	3¾½ 97	3¾ 99	4 102	4¾½ 115	4¾½ 126
B Outside diameter	in. mm	1¾ 44	2¾ 65	2¾ 65	3¾ 78	3¾ 89	3¾ 94	4¾ 108	5¾ 135
C End-to-end threaded	in. mm	3¾½ 90	4¾ 124	4¾ 124	5¾ 146	6¾ 156	5¾ 151	6¾ 158	8¾ 209
D Inside diameter	in. mm	1¾ 28	1¾½ 36	1¾ 43	2¾ 52	2¾ 65	2¾ 71	3¾ 81	4¾ 106
Weight	lb kg	4 1.8	10 4.5	9 4.1	16 7.3	18 8.2	16 7.3	22 10	32 14.5
Material, sub		AS	AS	AS	SF	AS	AS	AS	AS
Material, nut		SF	SF	SF	SF	SC	SF	SF	SF

**Note:**

\* 5" - 6" available with butt weld ends; consult factory for other configurations.

**Figure 1502** - 15,000 psi (1034 bar) cold working pressure

Nominal pipe size	in.	1	1½	2	2½	3	4*
Union part No.		3254059	3254057	3201570	3203088	3207510	3252926
Qty/carton		19	10	5	4	3	1
A Clearance radius	in. mm	2¾ 73	3¾½ 93	3¾½ 99	4¾½ 106	4¾ 114	6 300
B Outside diameter	in. mm	2¾ 55	2¾½ 75	3¾ 81	3¾ 95	4¾½ 112	5¾ 146
C End-to-end threaded	in. mm	4¾½ 110	5¾½ 137	7 178	7¾ 184	7¾ 194	8¾* 216
D Inside diameter	in. mm	1¾ 28	1¾ 43	2¾ 52	2¾ 65	3¾ 81	-
Weight	lb kg	9 4.1	17 7.7	19 8.6	22 10	30 13.6	64 29
Material, sub		AS	AS	SF	AS	AS	AS
Material, nut		SF	SF	SF	SC	SF	SF

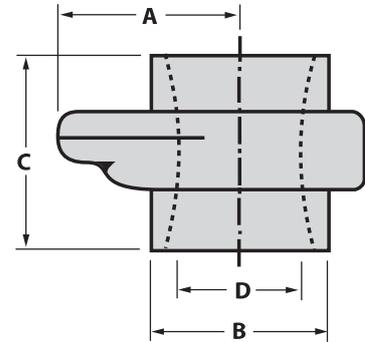
**Note:**

\* Non-pressure seal

# Wecco® wing union specifications

**Figure 1505** - 15,000 psi (1034 bar) cold working pressure

Nominal pipe size	in.	1	1½	2	2½	3	4*
Union part No. Qty/carton		3254059 19	3254057 10	3201570 5	3203088 4	3207510 3	3252926 1
A Clearance radius	in. mm	2¼ 73	3¾ 93	3¾ 99	4¾ 106	4½ 114	6 300
B Outside diameter	in. mm	2¾ 55	2¾ 75	3¼ 81	3¼ 95	4¾ 112	5¼ 146
C End-to-end threaded	in. mm	4¾ 110	5¾ 137	7 178	7¼ 184	7¾ 194	8½* 216
D Inside diameter	in. mm	1¼ 28	1¼ 43	2¼ 52	2¼ 65	3¼ 81	-
Weight	lb kg	9 4.1	17 7.7	19 8.6	22 10	30 13.6	64 29
Material, sub		AS	AS	SF	AS	AS	AS
Material, nut		SF	SF	SF	SC	SF	SF



**Note:**

\* Non-pressure seal

**Figure 2002** - 20,000 psi (1380 bar) cold working pressure

Nominal pipe size	in.	2	3
Union part No. Qty/carton		3222761 5	3245911 1
A Clearance radius	in. mm	3¼ 95	6¾ 155
B Outside diameter	in. mm	2¾ 66	5¼ 140
C End-to-end threaded	in. mm	7¾ 188	10½ 267
D Inside diameter	in. mm	1¼ 33	3 76
Weight	lb kg	21 9.5	87 39.5
Material		AS	AS

**Figure 2202** - 15,000 psi (1034 bar) cold working pressure

Nominal pipe size	in.	2	3
Union part No. Qty/carton		3235746 5	3257994 1
A Clearance radius	in. mm	3¼ 95	6¾ 155
B Outside diameter	in. mm	2¾ 73	5¼ 140
C End-to-end threaded	in. mm	8¾ 224	10½ 267
D Inside diameter	in. mm	1¼ 33	3 76
Weight	lb kg	22 10	53 24
Material		AS	AS

# Sour gas service

TechnipFMC manufactures Weco® sour gas wing unions in accordance with the National Association of Corrosion Engineers (NACE) Standard MR-01-75 and American Petroleum Institute (API) Standard RP-14-E. These outstanding, field-proven unions are specially heat treated for controlled hardness. For fast, sure identification, each Weco® sour gas union is stamped “Sour Gas” or “NACE MR-01-75” using low stress dot stamping and painted with an olive green zinc-chromate primer that is unique to sour gas equipment. TechnipFMC flowline products use fluoroelastomer seals or O-rings in all sour gas unions, but do not warrant the performance of any elastomer for sour gas service. **(See Warnings).**

## 1. Quick, positive identification

Weco® unions for sour gas service are stamped “Sour Gas” and painted with an olive green zinc-chromate primer to ensure quick, positive identification.

## 2. Meets industry standards

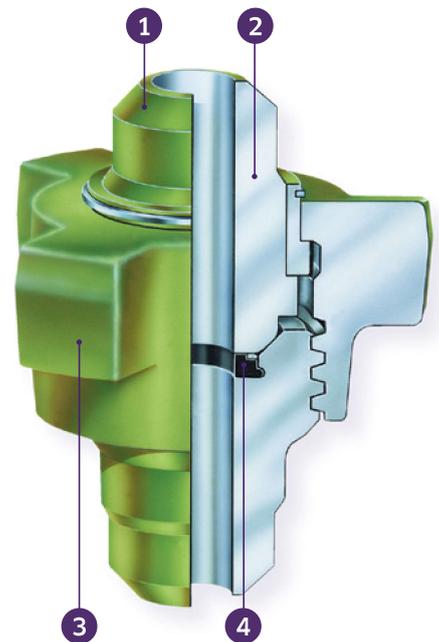
All Weco® wing unions for sour gas service meet both the NACE Standard MR-01-75 and API Standard RP-14-E.

## 3. Controlled hardness

Weco® union subs and nuts are specially heat-treated and 100% tested for controlled hardness.

## 4. Positive sealing

Primary fluoroelastomer seal and metal-to-metal seal combine to deliver positive sealing throughout the stated pressure range.



## Weco® wing unions for sour gas service

### Figure 400

4,000 psi cold working pressure, 1 through 4-inch sizes;  
2,500 psi cold working pressure, 5 through 12-inch;  
butt-weld only above 4-inch sizes

### Figure 602

6,000 psi cold working pressure, 1 through 4-inch sizes

### Figure 1003

7,500 psi cold working pressure, 2 and 3-inch sizes;  
5,000 psi cold working pressure, 4 and 5-inch sizes

### Figure 1502

10,000 psi cold working pressure, 1 through 4-inch sizes;  
butt-weld or non-pressure seal configurations only

### Figure 2202

15,000 psi cold working pressure, 2, and 3-inch sizes;  
butt-weld only

➤ See specifications tables **(pgs .52-55)** for sizes, dimensions, weights, materials, and part numbers.

# Other Weco® unions

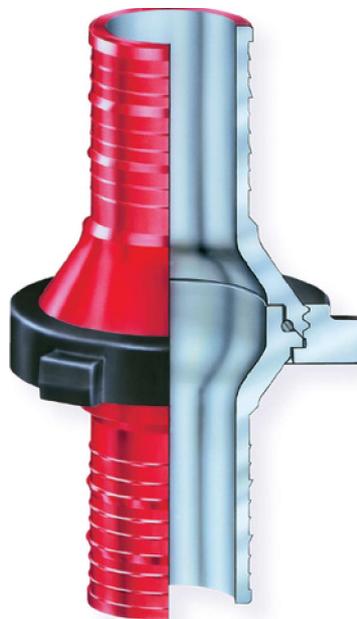
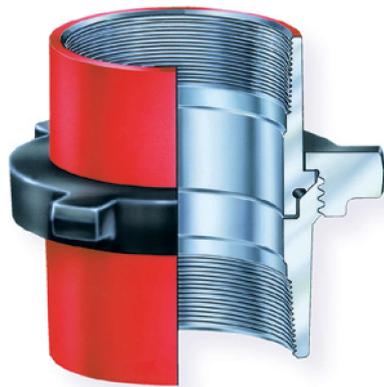
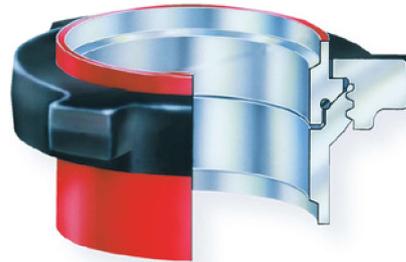
## Suction-hose unions

500 psi maximum line pressure, 4, 5, and 6-inch sizes

**Recommended service**  
Mud system suction lines

### Features

- ▶ Replaceable O-ring seal
- ▶ Choice of end fittings
- ▶ Secondary metal-to-metal seal
- ▶ Socket welded, threaded, or hose nipple



### Caution:

It is possible to interchange sour gas parts with standard service products. Users must adopt safe practices for identification, installation, use, maintenance, and storage of sour gas equipment. **(See warnings and cautions, page 88).**

## Suction-hose unions - 500 psi (34 bar) maximum line pressure

Size/type	Part No.	Qty./carton	Length		Nut radius		Materials		Weight	
			in.	mm	in.	mm	Nut	Sub	lb	kg
6-inch hose	P512200	1	14 $\frac{3}{4}$	356	5	127	SF	CS	40	18.1
5-inch hose	3251341	1	14 $\frac{3}{4}$	356	5	127	SF	CS	31	14
5-inch socket weld	3202072	4	4 $\frac{5}{8}$	104	5	127	SF	SF	18	8.2
5-inch line pipe thread	3248972	2	7 $\frac{3}{4}$	194	5	127	SF	DI	28	13
4-inch line pipe thread	3215198	2	5 $\frac{1}{8}$	161	5	127	SF	DI	26	12
4-inch hose	3207912	2	14 $\frac{5}{8}$	368	5	127	SF	DI	25	12
Blanking cap assy.	3220990	2	3 $\frac{1}{8}$	92	5	127	SF	CS	25	12

**Note:** - Materials - AS - alloy steel, CS - carbon steel, DI - ductile iron casting, CS - steel casting, SF - steel forging