



Welded Steel Chains

Welded Steel Chain from Union is designed and manufactured to offer strength, precision, impact resistance, and wear resistance. This versatile chain is built to withstand punishing shock loads and abrasive conditions. Each component is engineered to close tolerances. It is found throughout the world in lumber mills, paper pulp mills, and any industry where severe applications require strength and reliability.

Welded Steel Mill and Drag Chains are available with a variety of attachments and are ideally suited for field welding.

Greater Strength

Union's oversized rivet head outlasts conventional rivet heads. That means longer wear life and less downtime in your plant.

Cost-Effective Operation

We use the best technology to accurately control hole size and pitch. That means longer wear life for chains and sprockets, reducing your operating costs.

Long-Lasting Construction

One-piece construction means bushings are stronger and last longer. You get more mileage from Union Chain.

Built to Last

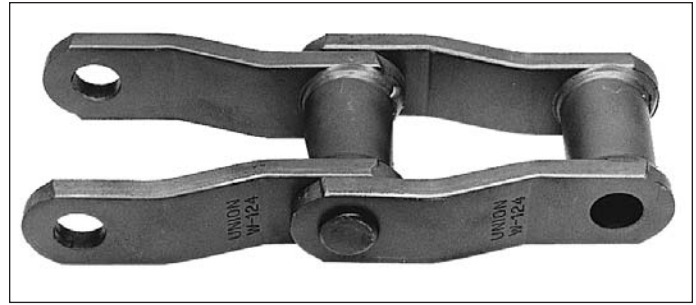
Our Welded Steel Chains are built to exacting Union specifications using heat-treated alloy-grade steel. Barrels are hand-welded to sidebars to create the highest fatigue resistance in the industry.

Easy to Assemble

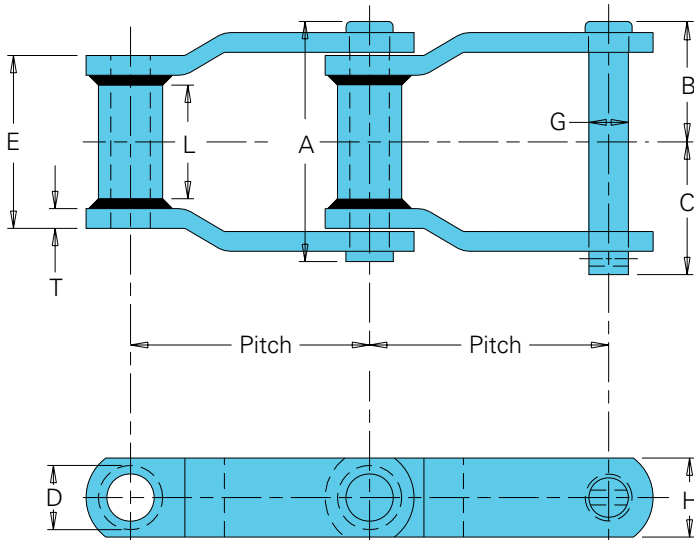
Chain pins are manufactured from high quality steels and through-hardened for maximum strength. Special design considerations include enlarged shoulders for tight press fit in the sidebars and tapered construction for rapid assembly.

Welded Steel Mill Chain

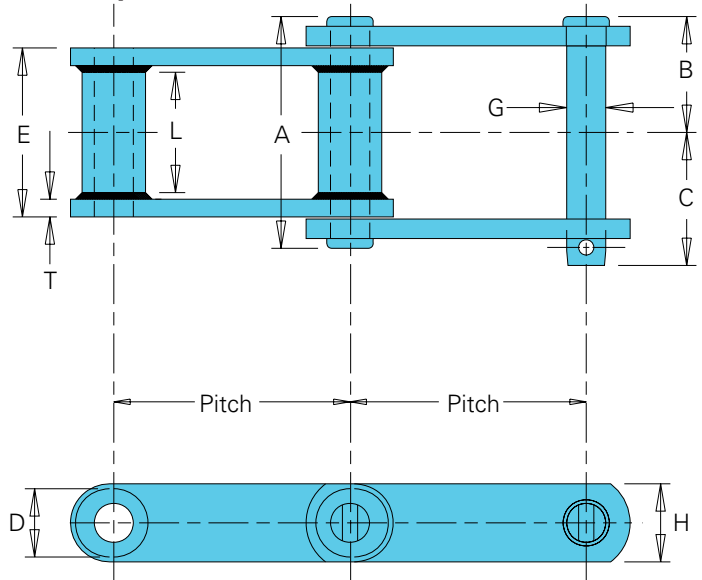
Union offers a line of Welded Steel Mill Chains for most conveying, driving and elevating applications where high strength rollerless chains are required. They are available with a full line of attachments which makes them easily adaptable to a wide variety of applications.



Offset Sidebar



WCH-Style Chain



Welded Steel Mill Chain Specifications

All dimensions are in inches unless otherwise indicated.

Chain No.	Pitch	Chain Width				Barrel		Pin Dia.	Sidebars		Average Ult. Strength (lbs.)	Maximum Work Load (lbs.)	Approx. Weight (lbs./ft.)
		Overall	Pin Head to CL	Pin End to CL	Lgth. of Bearing	D	L		Thick.	Height			
		A	B	C	E	D	L	G	T	H			
WH-78	2.609	3.00	1.44	1.56	2.00	.88	1.13	.50	.25	1.13	33,000	3,500	4.0
WH-82	3.075	3.25	1.56	1.69	2.25	1.06	1.25	.56	.25	1.25	36,000	4,400	4.8
WH-124 ¹	4.000	4.25	2.03	2.22	2.75	1.25	1.63	.75	.38	1.50	60,000	7,350	8.3
WH-124H	4.063	4.75	2.28	2.47	3.00	1.63	1.44	1.00	.50	2.00	100,000	10,500	14.7
WH-111	4.760	4.88	2.34	2.54	3.38	1.38	2.38	.75	.38	1.75	60,000	8,850	9.5
WH-106	6.000	4.25	2.03	2.31	2.75	1.25	1.63	.75	.38	1.50	60,000	7,200	7.0
WH-132 ¹	6.050	6.25	3.00	3.40	4.38	1.75	2.88	1.00	.50	2.00	100,000	15,300	14.2
WH-150	6.050	6.25	3.00	3.25	4.38	1.75	2.88	1.00	.50	2.50	100,000	15,300	16.8
WH-155	6.050	6.91	3.25	3.66	4.63	1.75	3.00	1.13	.63	2.50	184,000	20,000	20.0
WCH-132	6.050	6.25	3.00	3.25	4.38	1.75	2.88	1.00	.50	2.00	100,000	15,300	14.2

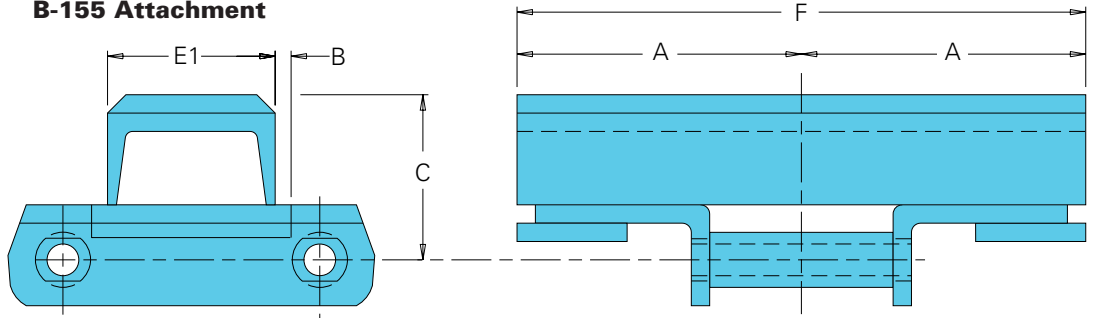
Indicates this chain is normally stocked. All others are made-to-order.

¹Chain numbers WH-124 and WH-132 are also stocked in stainless steel with riveted and cottered construction.

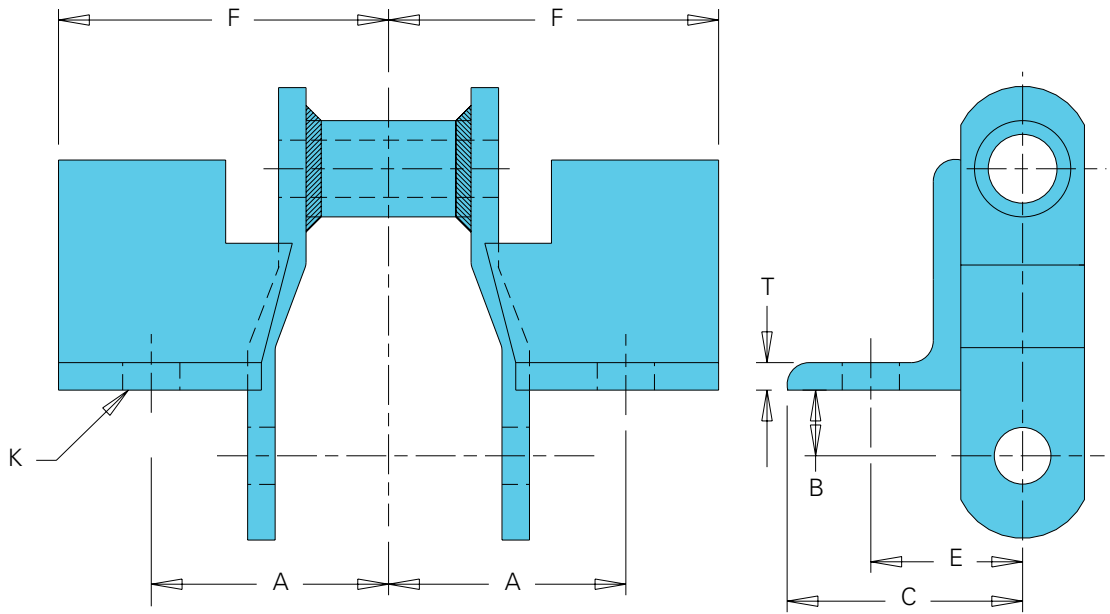
To locate compatible sprockets for your chain, refer to the Product Cross-Reference in Section D.

Note: Dimensions are subject to change. Contact Union Chain to obtain certified prints for design and construction.

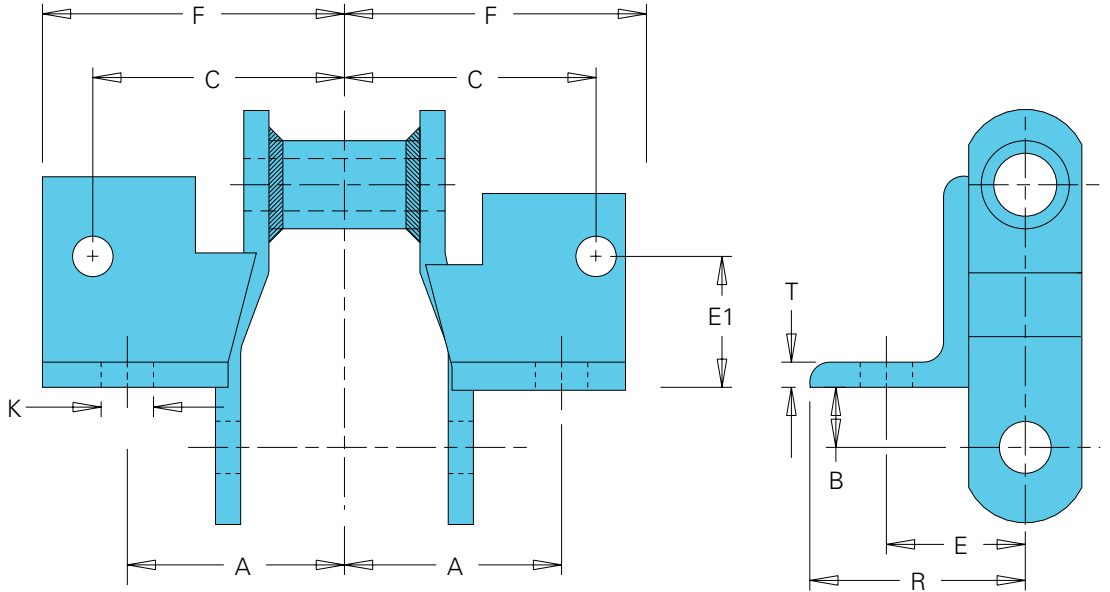
B-155 Attachment

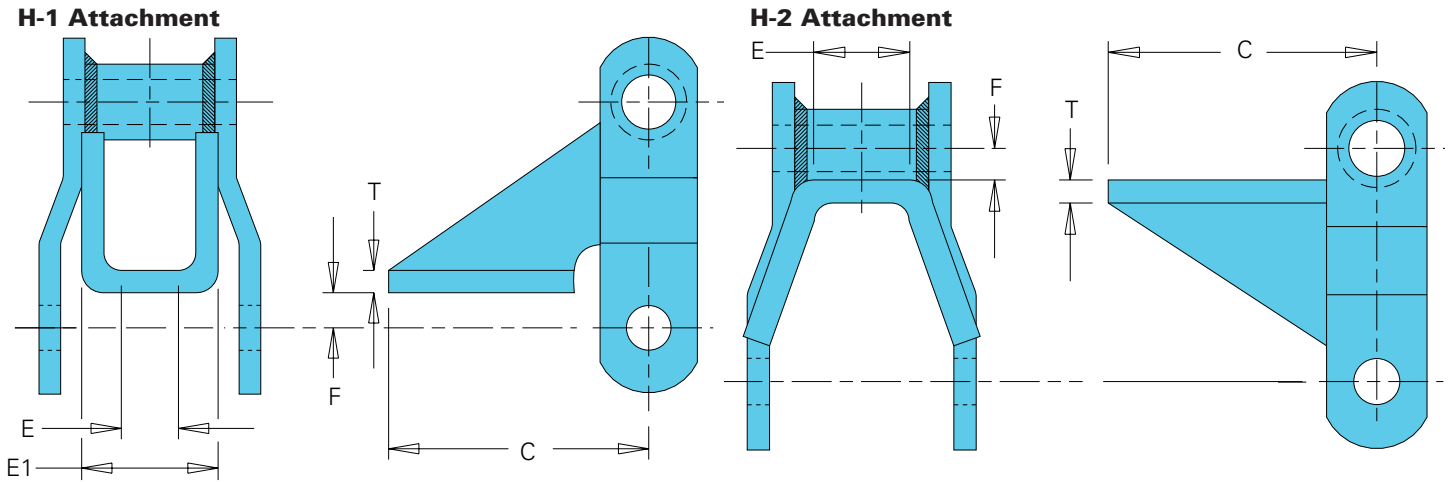


F-2 Attachment



F-4 Attachment





Welded Steel Mill Chain Attachments

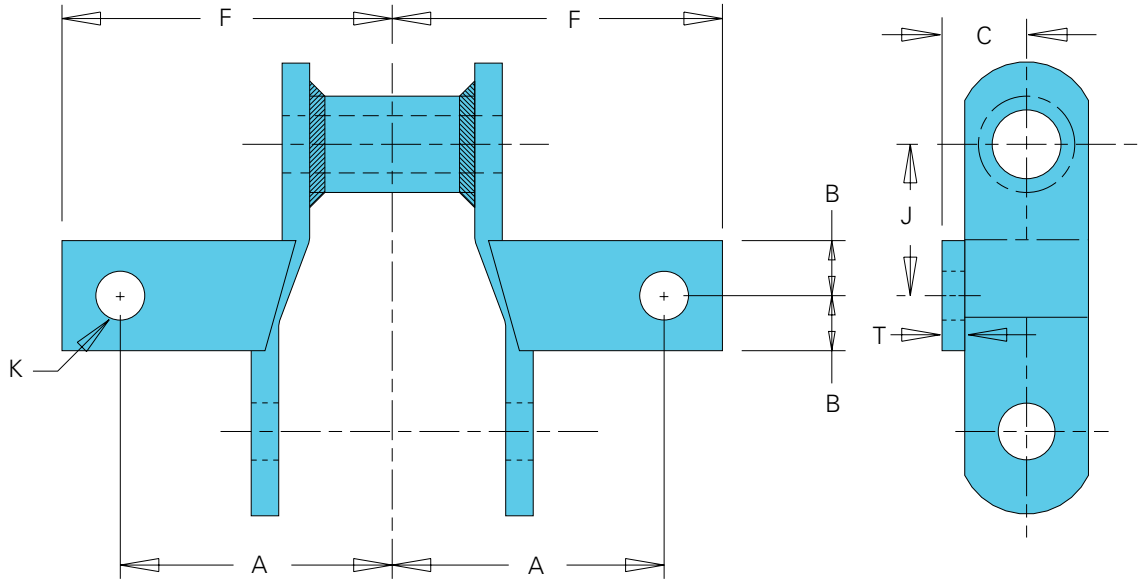
All dimensions are in inches unless otherwise indicated.

Attach. Number	Chain Number	A	B	C	E	E1	F	Bolt Diameter	K	T	R	Approx Weight (lbs./ft.)
B-155	WH-132	7.00	1.03	4.25		4.00	14.00					49.6
	WH-150	7.00	1.03	4.50		4.00	14.00					54.6
	WH-155	7.00	1.03	4.50		4.00	14.00					56.6
F-2	WH-78	1.88	.69	2.06	1.44		2.69	.38		.25		6.0
F-4	WH-78	1.88	.69	2.25	1.44	1.25	2.75	.38		.25	2.06	6.1
	WH-82	2.06	.75	2.50	1.50	1.13	2.97	.38		.25	2.38	8.9
	WH-124	2.19	.88	2.63	2.06	1.44	3.09	.38		.39	2.75	11.6
H-1	WH-78			3.56	.88	1.75	.50			.25		8.3
	WH-82			3.63	1.13	2.00	.63			.25		9.9
H-2	WH-78			3.56	.81		.31			.25		7.5
	WH-82			3.63	1.03		.38			.25		8.8

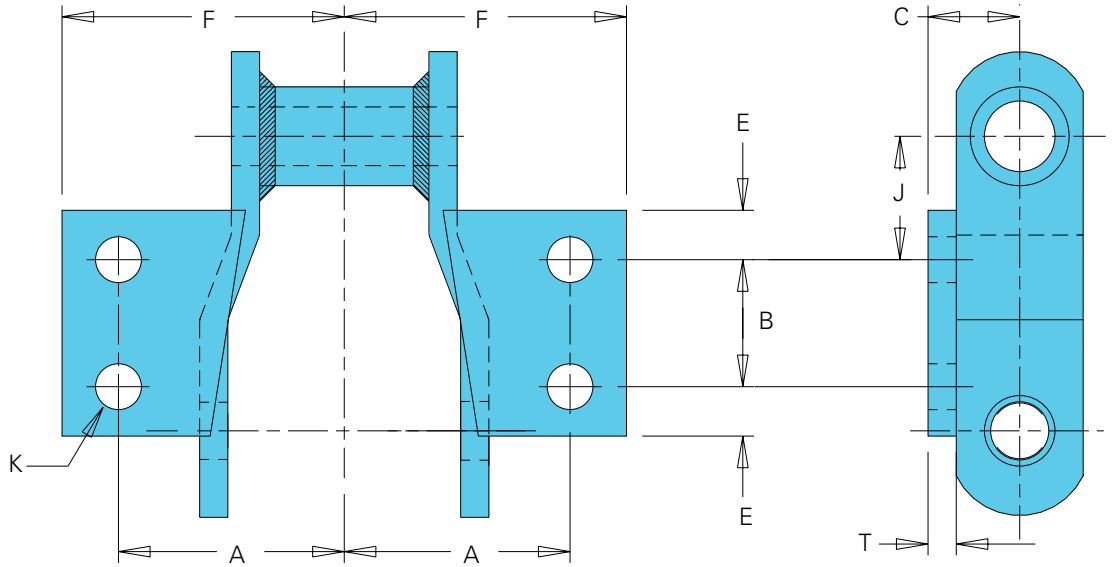
To locate compatible sprockets for your chain, refer to the Product Cross-Reference in Section D.

Note: Dimensions are subject to change. Contact Union Chain to obtain certified prints for design and construction.

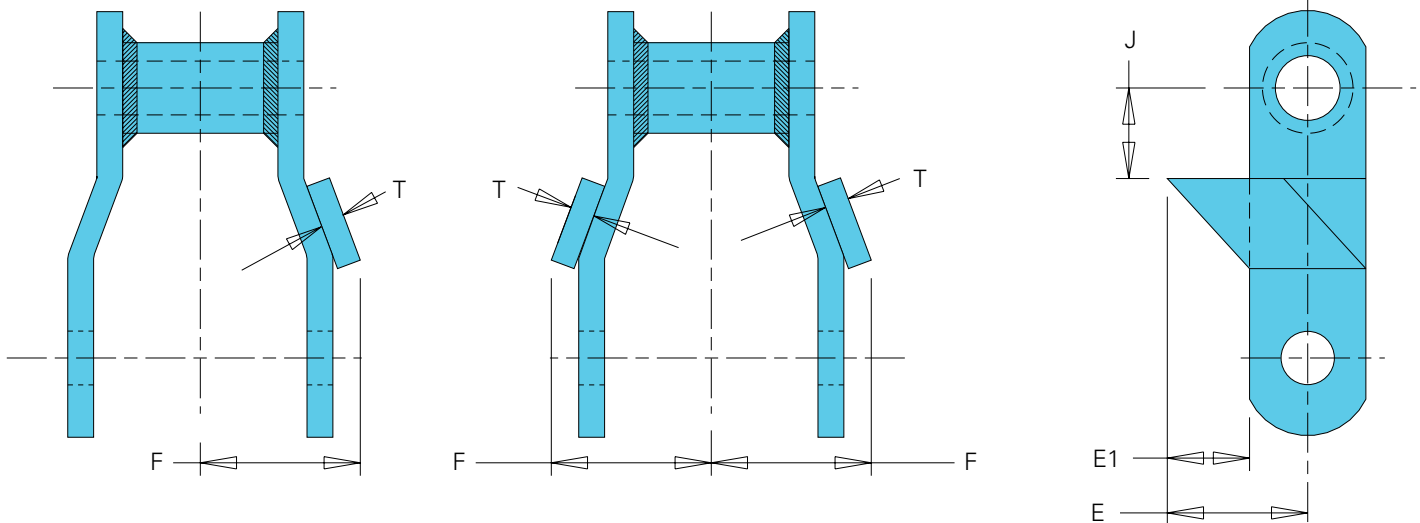
K-1 Attachment



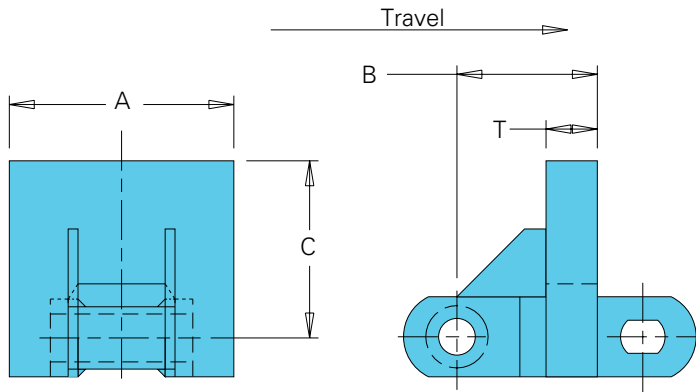
K-2 Attachment



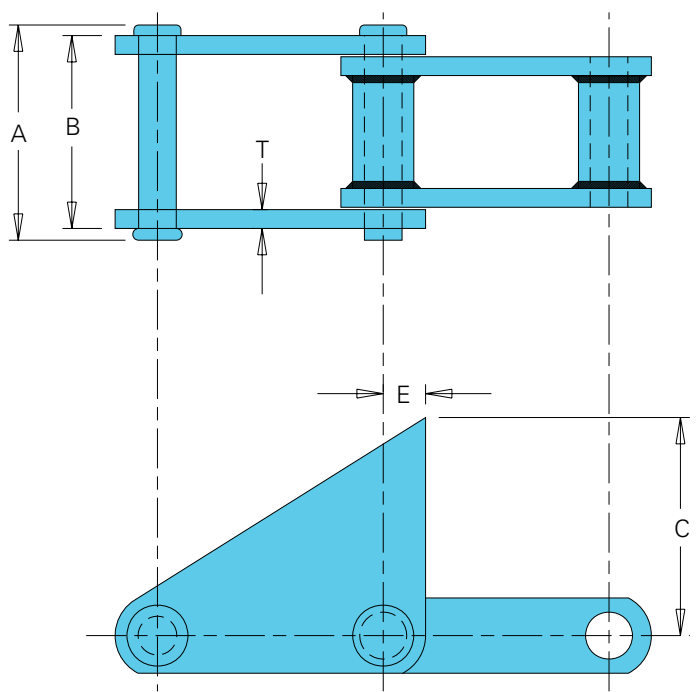
R-1, R-1-1/2, RR Attachment



RF-12 Attachment



S-1 Attachment



Welded Steel Mill Chain Attachments (Continued)

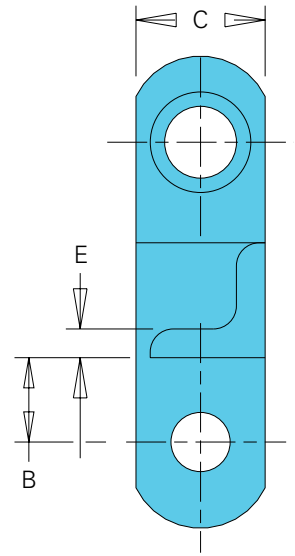
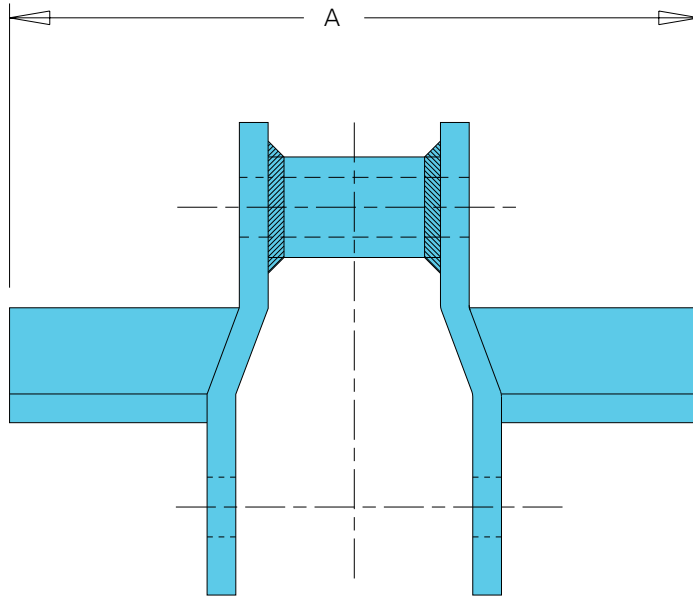
All dimensions are in inches unless otherwise indicated.

Attach. Number	Chain Number	A	B	C	E	E1	F	Bolt Diameter	K	J	T	Approx. Weight (lbs./ft.)
K-1	WH-78	2.00	.63	.81			2.50	.38	1.38	.25	5.5	
	WH-82	2.13	.88	.88			2.75	.38	1.56	.25	7.2	
K-2	WH-78	2.00	1.13	.81	.43		2.50	.38	1.09	.25	6.3	
	WH-82	2.13	1.31	.88	.47		2.75	.38		.25	7.6	
	WH-124	2.63	1.94	1.13	.53		3.50	.38		.38	11.7	
	WH-124H	2.63	1.94	1.50	.53		3.50	.50		.50	18.4	
	WH-132	3.75	2.75	1.38	.63		4.38	.50	1.66	.50	18.0	
	WCH-132	3.75	2.75	1.38	.63		4.38	.50	1.66	.50	18.0	
R-1	WH-78				1.56	1.00	1.56		.75	.25	4.7	
	WH-82				1.88	1.25	1.69		.88	.25	6.1	
	WH-124				1.88	1.13	2.16		1.28	.38	9.4	
R-1-1/2	WH-78				2.06	1.50	1.56		.75	.25	4.9	
RR	WH-78				1.56	1.00	3.13		.75	.25	5.2	
	WH-82				1.88	1.25	3.38		.88	.25	6.7	
	WH-124				1.88	1.13	4.25		1.25	.38	10.4	
	WH-124H				2.13	1.13	4.88		1.25	.50	17.6	
RF-12	WH-132	12.00	4.56	5.25						1.00	55.0	
	WH-150	12.00	4.56	5.50						1.00	58.0	
	WH-155	12.00	4.56	5.50						1.00	63.0	
S-1	WCH-132	6.00	5.44	5.00	1.28					.50	18.1	

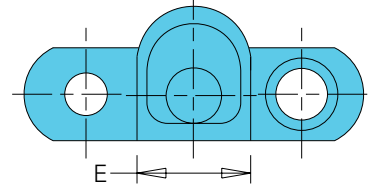
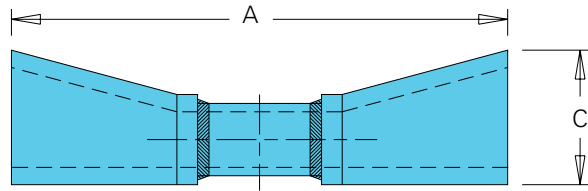
To locate compatible sprockets for your chain, refer to the Product Cross-Reference in Section D.

Note: Dimensions are subject to change. Contact Union Chain to obtain certified prints for design and construction.

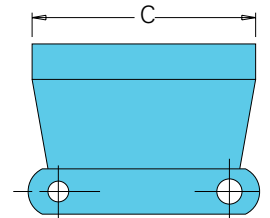
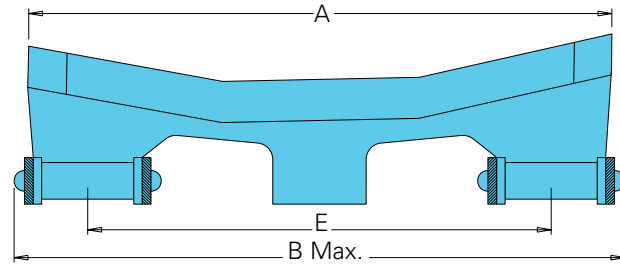
Wing



Log Cradle



Double Strand Log Cradle



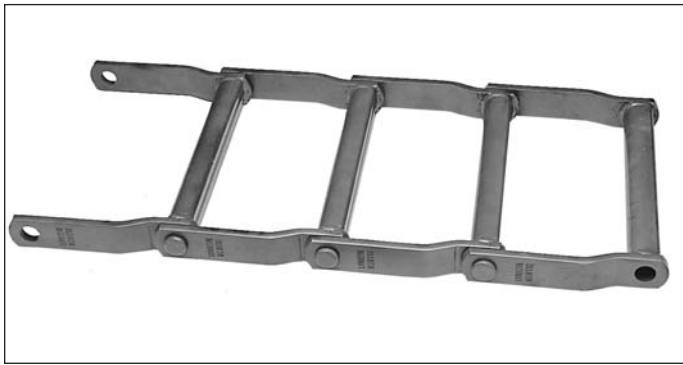
Welded Steel Mill Chain Attachments (Continued)

All dimensions are in inches unless otherwise indicated.

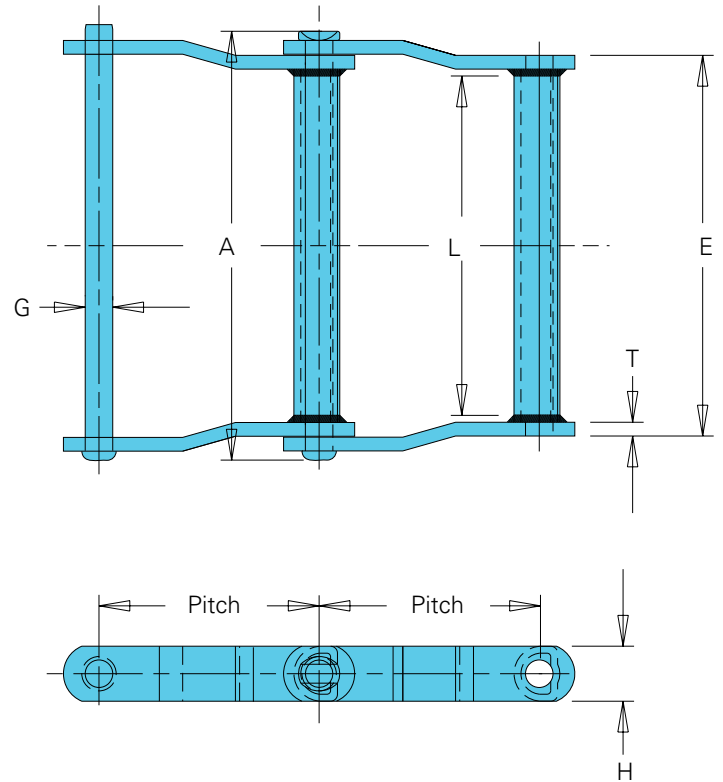
Attachment Number	Chain Number	A	B	C	E	Approximate Weight (lbs./ft.)
Wing	WH-78	6.00	.75	1.00	.25	7.3
	WH-82	6.50	.81	1.25	.25	8.6
	WH-124	8.50	1.19	1.50	.25	14.2
	WH-132	12.38	1.44	2.00	.38	21.0
	WCH-132	12.38	1.44	2.00	.38	21.0
	WH-124H	8.50	1.38	2.00	.50	19.1
Log Cradle	WH-132	11.13		3.00	3.50	29.2
	WH-132	13.00		3.00	3.50	32.2
	WCH-132	11.13		3.00	3.50	29.2
	WCH-132	13.00		3.00	3.50	32.2
Double Strand Log Cradle	WH-132	16.00	17.50	6.00	12.00	96.0
	WCH-132	16.00	17.50	6.00	12.00	96.0

To locate compatible sprockets for your chain, refer to the Product Cross-Reference in Section D.

Note: Dimensions are subject to change. Contact Union Chain to obtain certified prints for design and construction.



Drag Chain



Welded Steel Drag Chain

All dimensions are in inches unless otherwise indicated.

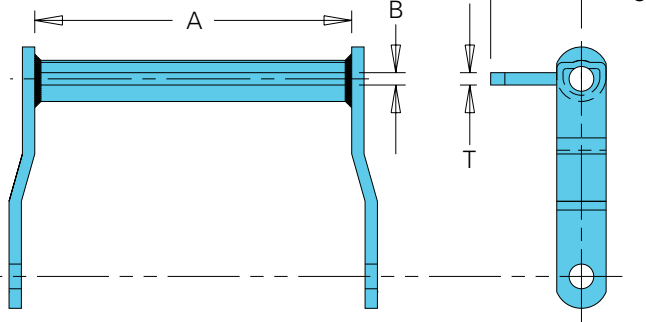
Chain Number	Pitch	Chain Width		Barrel L	Pin Diameter G	Sidebars		Average Ultimate Strength (lbs.)	Maximum Working Load (lbs.)	Approx. Weight (lbs./ft.)
		Overall A	Length of Bearing E			Thickness T	Height H			
WDH-102	5.000	9.25	7.75	6.38	.75	.38	1.50	60,000	10,000	11.8
WDH-104	6.000	6.88	5.38	4.13	.75	.38	1.50	60,000	10,000	8.7
WDH-110	6.000	11.88	10.38	9.00	.75	.38	1.50	60,000	10,000	12.0
WDH-113	6.000	12.50	10.63	9.00	.88	.50	1.50	68,000	11,700	15.0
WDH-112	8.000	11.88	10.38	9.00	.75	.38	1.50	60,000	10,000	9.8
WDH-116	8.000	15.38	14.13	12.75	.75	.38	1.75	80,000	11,500	14.5
WDH-480	8.000	14.63	12.75	11.00	.88	.50	2.00	90,000	15,000	18.1

 Indicates this chain is normally stocked. All others are made-to-order.

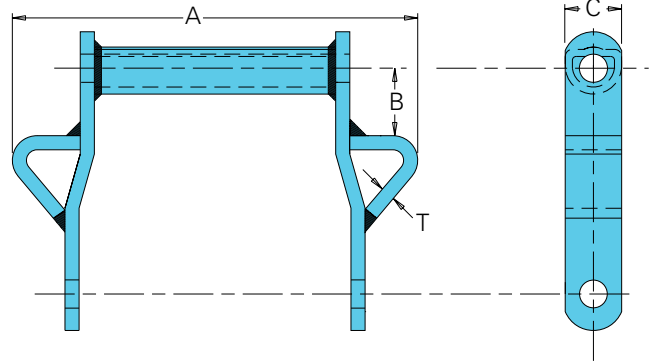
To locate compatible sprockets for your chain, refer to the Product Cross-Reference in Section D.

Note: Dimensions are subject to change. Contact Union Chain to obtain certified prints for design and construction.

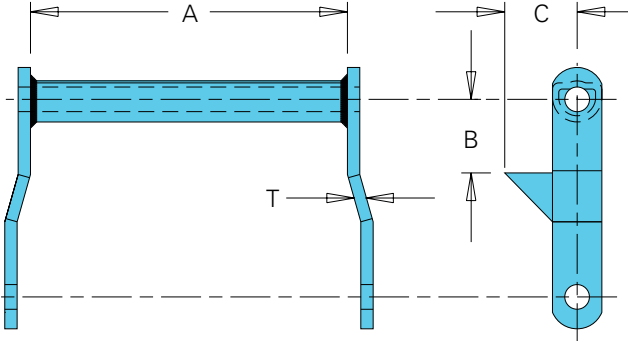
C-1, C-3 and C-4 Attachments



Folded Wing Attachment



RR Attachment



Welded Steel Drag Chain Attachments

All dimensions are in inches unless otherwise indicated.

Attachment Number	Chain Number					Approx. Weight (lbs./ft.)
		A	B	C	T	
C-1	WDH-102	7.00	.38	2.38	.38	14.4
	WDH-104	5.00	.38	2.38	.38	10.1
	WDH-110	10.00	.38	2.38	.38	15.5
	WDH-112	10.00	.38	2.38	.38	12.6
	WDH-116	13.00	.38	2.56	.38	18.4
C-3	WDH-113	10.00	.50	2.25	.50	17.3
	WDH-480	12.00	.50	3.00	.50	25.8
Folded Wing	WDH-102	14.25	1.75	1.50	.38	17.1
	WDH-104	11.50	2.75	1.50	.38	12.5
	WDH-110	17.00	2.63	1.50	.38	17.8
	WDH-112	17.00	3.25	1.50	.38	14.6
	WDH-113	17.00	2.25	1.50	.50	22.2
	WDH-116	22.00	3.25	1.75	.38	21.2
	WDH-480	22.00	3.25	2.00	.50	29.0
C-4	WDH-102	7.00	.38	3.75	.38	17.1
	WDH-104	5.00	.38	3.75	.38	11.7
	WDH-110	10.00	.38	3.75	.38	18.7
	WDH-112	10.00	.38	3.75	.38	15.1
	WDH-113	10.00	.50	4.75	.50	20.9
	WDH-116	13.00	.38	4.81	.38	23.5
	WDH-480	12.00	.50	5.00	.50	32.4
RR	WDH-102	8.50	1.75	2.50	.38	12.0
	WDH-104	6.25	3.00	2.50	.38	8.9
	WDH-112	11.25	3.00	2.50	.38	10.3
	WDH-113	11.63	2.25	2.50	.38	16.0
	WDH-116	14.88	3.25	3.00	.38	15.2
	WDH-480	13.75	3.00	3.25	.50	20.8

To locate compatible sprockets for your chain, refer to the Product Cross-Reference in Section D.

Note: Dimensions are subject to change. Contact Union Chain to obtain certified prints for design and construction.