

Aligns Boiler Tube Ends for Accurate Welding

Key Features

- Aligns tube ends quickly for tube joint tack welding
- Ideal for waterwall, economizer, header, crossover, superheat, reheater, and generating tubes
- Speeds boiler tube waterwall welding process
- Reduces the risk of costly tube joint failure due to misalignment
- Safety Lanyard easily connects clamp halves for fall protection
- Made of high strength precision machined steel for long service
- For tube sizes 1.125" (28.757mm) O.D. to 3.250" (82.55mm) O.D.
- Threaded inserts are replaceable
- Available kits come with everything needed
- Set-up is easy and fast
- Saves time and money
- For Sale and Rent

Simplifies Tube Alignment and Improves Tube Joint Welds

The HOG TIE® boiler tube joint alignment clamps speed the welding process for boiler tube waterwall panel replacement by quickly and accurately aligning new boiler tube ends with existing tubes in preparation for creating welded tube joints.

The two piece design is simple and easy to use. One piece has a through hole and the other has a threaded replaceable insert. Bolts draw the assembly together. Each bolt passes through the through hole and threads into the threaded insert. With the two tube ends between the HOG TIE® assembly, the tack weld window on each HOG TIE® piece is centered. When the bolts are tightened, it draws the tube ends into alignment.

During this process, adjustments can be made to ensure a proper gap is maintained between the tube ends before tack welding them. After the HOG TIE® is removed, the tack weld holds the tube ends in alignment, allowing for full access to the tube joint in order to complete the tube joint weld.

Accurate tube end alignment helps to make a better welded tube joint and reduces the risk of tube joint failure due to inaccurate alignment which saves time and money on costly boiler shut-down and re-work.

The HOG TIE® alignment tool can also be used in other applications requiring accurate alignment for tube and pipe welding. It is made of precision machined high strength steel for long service and is available for tube sizes from 1.125" (28.6mm) O.D. to 3.250" (82.6mm) O.D.



HOG TIE® tube alignment tools speed waterwall boiler tube fit-up and helps reduce tube joint failure due to misalignment.



Available impact wrench draws the HOG TIE® assembly together for fast tube end alignment.



HOG TIE® assemblies are designed for use on boiler tube waterwall panels with 0.5" / 12.7mm wide membrane. For other pipe and tube applications please consult factory.



Available HOG TIE® kits include an impact tool, 7/8" socket, safety lanyard, spare bolts, spare threaded inserts and carrying case.

Available Sizes*

DOUBLE TUBE HOG TIE® (single bolt)

Designed for 1/2" / 12.7mm membrane



Tube Size: **1-1/8" / 28.6mm**
Part #: **HTK-11812**
Dim: 6" x 3" / 152.4mm x 101.6mm
Weight: 9 lbs / 4.08 kgs



Tube Size: **1-1/4" / 31.75mm**
Part #: **HTK-11412**
Dim: 6" x 3" / 152.4mm x 76.2mm
Weight: 9 lbs / 4.08 kgs



Tube Size: **1-3/8" / 34.9mm**
Part #: **HTK-13812**
Dim: 6" x 3-1/2" / 152.4mm x 88.9mm
Weight: 10 lbs / 4.54 kgs



Tube Size: **1-1/2" / 38.10mm**
Part #: **HTK-11212**
Dim: 6" x 3-1/2" / 152.4mm x 88.9mm
Weight: 10 lbs / 4.54 kgs

SINGLE TUBE HOG TIE® (double bolt)

Designed for minimum 1/2" / 12.7mm membrane



Tube Size: **1-3/4" / 44.5mm**
Part #: **HTK-134**
Dim: 6" x 3-1/4" / 152.4mm x 82.6mm
Weight: 7.5 lbs / 3.4 kgs



For Tube Size: **2" / 50.8mm**
Part #: **HTK-200**
Dim: 6" x 4" / 152.4mm x 101.6mm
Weight: 7.5 lbs / 3.4 kgs



For Tube Size: **2-1/4" / 57.2mm**
Part #: **HTK-214**
Dim: 6" x 4" / 152.4mm x 101.6mm
Weight: 8 lbs / 3.63 kgs



For Tube Size: **2-3/8" / 60.3mm**
Part #: **HTK-238**
Dim: 6" x 4-3/8" / 152.4mm x 111.1mm
Weight: 8 lbs / 3.63 kgs



For Tube Size: **2-1/2" / 63.5mm**
Part #: **HTK-212**
Dim: 6" x 4-3/8" / 152.4mm x 111.1mm
Weight: 8 lbs / 3.63 kgs



For Tube Size: **2-3/4" / 69.9mm**
Part #: **HTK-234**
Dim: 6" x 4-3/8" / 152.4mm x 111.1mm
Weight: 8 lbs / 3.63 kgs



For Tube Size: **3" / 76.2mm**
Part #: **HTK-300**
Dim: 6" x 4-3/4" / 152.4mm x 120.7mm
Weight: 10 lbs / 4.54 kgs



For Tube Size: **3-1/4" / 82.6mm**
Part #: **HTK-314**
Dim: 6" x 4-3/4" / 152.4mm x 120.7mm
Weight: 10 lbs / 4.54 kgs

Standard / Optional Kit Contents



Bolt w/ Washer
Part # 123-2872



Bolt & Washer
Part # 123-2864



Bolt w/ Washer
Part # 123-2856



Bolt w/ Washer
Part # 123-2484



Threaded Insert
Part # HT-X002



Safety Lanyard
(for fall protection)
Part # HT-X007



Impact Tool
Part # HT-X003
(Optional)



7/8" Socket
Part # HT-X004
(Optional)

HOG TIE® Clamp Selector Chart and Corresponding Hardware

Hog Tie Series	Tube O.D.		Bolt Length		Bolt Part #	Washer Part #	Threaded Insert Part #
	in	mm	in	mm			
HTK-11812	1-1/8	28.6	4	101.6	123-2864	165-001	HT-X002
HTK-11412	1-1/4	31.8	4	101.6	123-2864		
HTK-13812	1-3/8	34.9	4	101.6	123-2864		
HTK-11212	1-1/2	38.1	4	101.6	123-2864		
HTK-134	1-3/4	44.5	3	76.2	123-2484		
HTK-200	2	50.8	3-1/2	88.9	123-2856		
HTK-214	2-1/4	57.2	3-1/2	88.9	123-2856		
HTK-238	2-3/8	60.3	4	101.6	123-2864		
HTK-212	2-1/2	63.5	4	101.6	123-2864		
HTK-234	2-3/4	69.9	4	101.6	123-2864		
HTK-300	3	76.2	4-1/2	114.3	123-2872	165-001	HT-X002
HTK-314	3-1/4	82.6	4-1/2	114.3	123-2872		

*consult factory for special sizes

Standard and Optional Kit Contents

Available HOG TIE® kits come with the following...

- Threaded Insert Clamp Half (side A)
- Through Hole Clamp Half (side B)
- Safety Lanyard (for fall protection)
- Bolt w/ washer (x2 for single tube HOG TIE®)
- Spare Bolt w/ washer (x2 for single tube HOG TIE®)
- Spare Threaded Insert (x2 for single tube HOG TIE®)
- 1/2" Drive Impact Tool w/ 7/8" Socket (OPTIONAL)