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 (54) Title: PLUG ASSEMBLY WITH PLUG HEAD ATTACHMENT

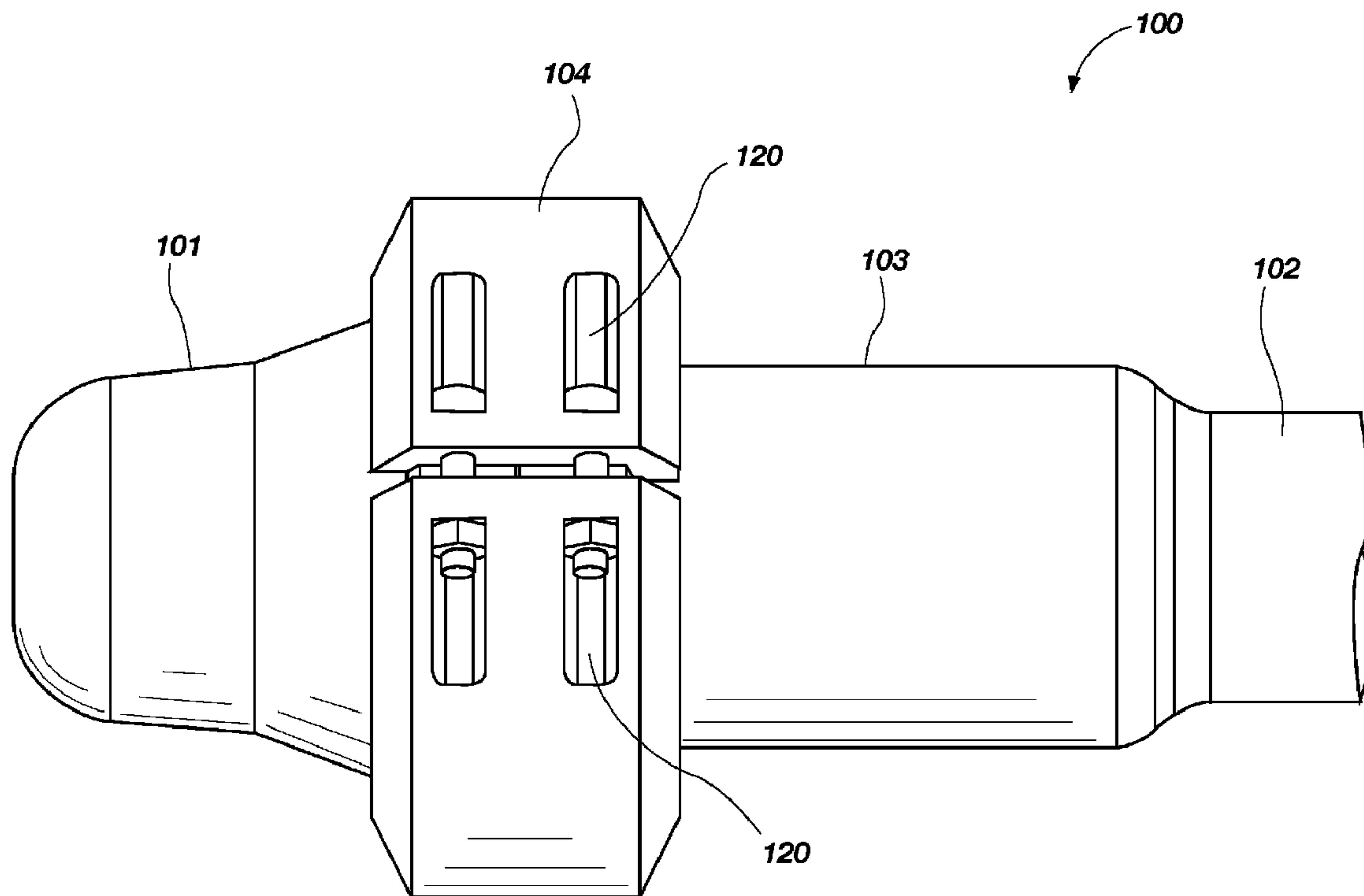


FIG. 3

(57) Abrégé/Abstract:

A plug assembly includes a plug stem having a plug stem base, a plug head, and a fastening mechanism for fastening the plug stem base to the plug head, the fastening mechanism comprising at least two retainer clamps that surround and provide an

(57) **Abrégé(suite)/Abstract(continued):**

interference fit between the plug stem base and the plug head. A method of replacing or attaching a plug head to a plug stem includes providing a plug stem having a plug stem base, providing a plug head, providing a fastening mechanism comprising at least two retainer clamps, and coupling the fastening mechanism around the plug stem base and the plug head to provide an interference fit between the plug stem base and the plug head.

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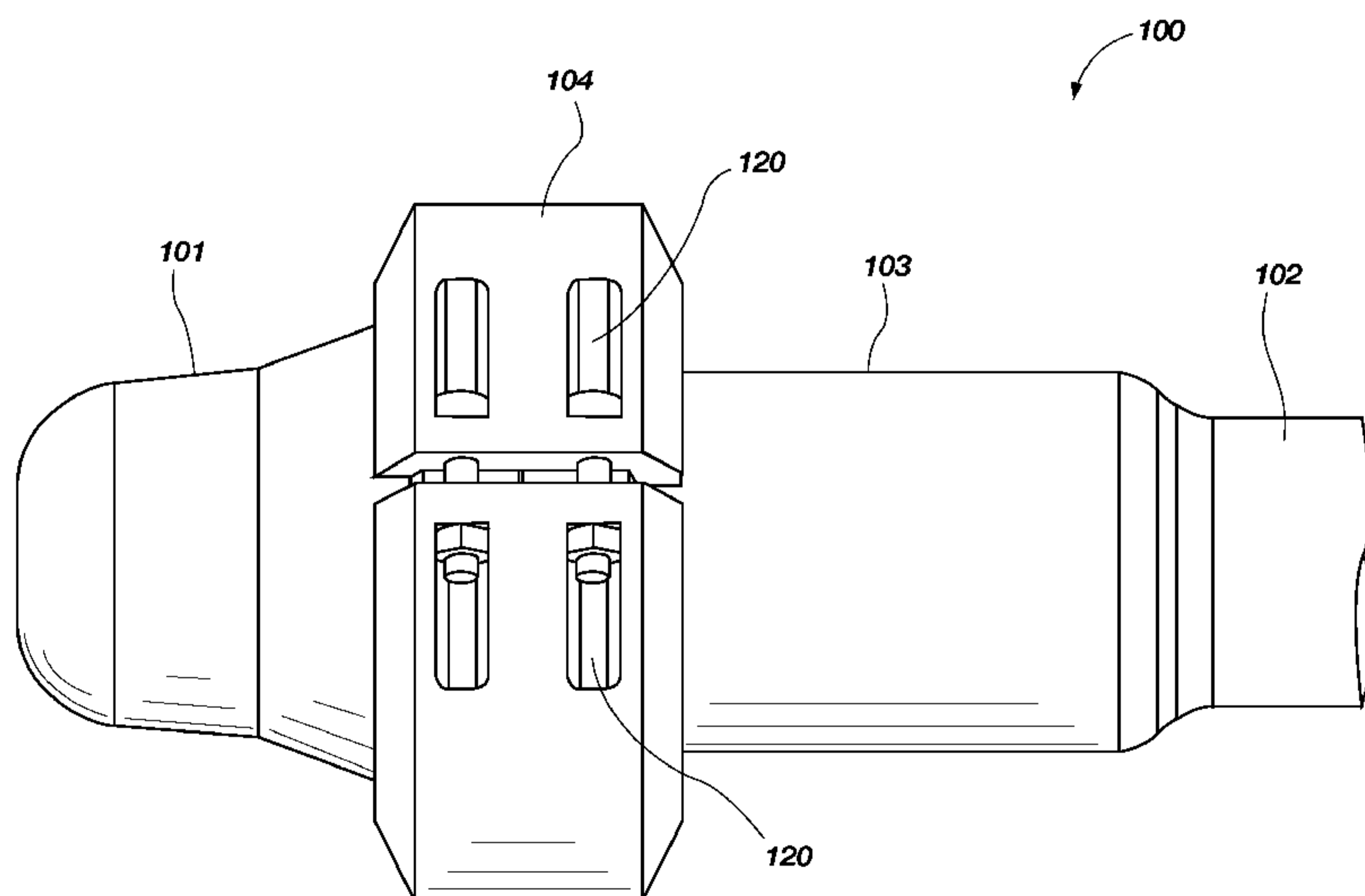


FIG. 3

(57) Abstract: A plug assembly in-
cludes a plug stem having a plug stem
base, a plug head, and a fastening
mechanism for fastening the plug
stem base to the plug head, the fasten-
ing mechanism comprising at least
two retainer clamps that surround and
provide an interference fit between
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PLUG ASSEMBLY WITH PLUG HEAD ATTACHMENT

PRIORITY CLAIM

This application is a utility conversion of United States Provisional Patent
5 Application Serial No. 61/059,682, filed June 6, 2008, for "PLUG ASSEMBLY
WITH PLUG HEAD ATTACHMENT."

TECHNICAL FIELD

This invention relates to industrial valves. More specifically, this invention
10 relates to devices for attaching valve plug heads to valve plug stems.

BACKGROUND OF THE INVENTION

Valves and valve plugs are well known in the art. Typically, valve plug
heads are positioned within the valve to control the volume of flow passing through
15 the valve. By modifying the position of the plug head relative to the valve seat,
control of the flow volume is achieved, thus allowing diversion and restriction of
fluid flow. Plug heads are subjected to fluid forces, chemical attack, thermal
stresses, impact from particulates and debris, as well as the forces used to attach it to
the plug stem and seat loading forces that can occur when the plug head comes into
20 contact with the valve seat. The valve head is typically attached to a plug stem,
which in turn is connected to an actuating device. This actuating device is
controlled to move the plug stem, which acts to change the position of the plug head
to control the flow passing through the valve.

The plug stem is subjected to axial forces as the actuator moves it, mounting
25 forces relating to the actuator attachment, and the long cylindrical section is
subjected to bending forces. The plug head and the plug stem perform distinctly
different purposes and are subjected to very different forces. The plug head, sitting
in the middle of the flow stream, diverts and/or restricts flow, and is subjected to
fluid and seat loading forces and to forces related to attaching the plug head to the
30 plug stem. In contrast, the plug stem is moved by an actuating device to provide a
sealing surface and is subject to axial and bending forces. In industrial, high

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volume/flow rate valves, the forces placed on plug stems and plug heads are typically significant contributors to valve failure.

Traditionally, valve plug heads are either composed of one monolithic material or make use of more than one material. Plug heads employing more than
5 one type of material have particular advantages, in particular better erosion and corrosion resistance, improved shock absorption, working life, and thermal expansion qualities. However, the use of a plurality of material types has been limited by the ability to effectively join the materials together economically and without creating stress points that limit the life of the plug head.

10 The most common methods of fixing dissimilar materials together in a valve plug are taper fitting or interference fitting, both of which employ a retaining ring that is fixed around the plug head. Taper fittings have been shown typically subject the plug head to undesirable stresses, contribute to thermal expansion problems, and are difficult to repair. The typical taper fitting design requires a mating of two
15 conical surfaces, one on the plug head, and the other on the retaining ring. Since neither the plug head nor the retaining ring can be manufactured with ideal cone shapes, the plug and seat may not mate perfectly. As such, loading between the two mated structures may not be uniform. Additionally, the force of the retaining ring on the plug head is exerted close to the edge of the plug head and is generally
20 perpendicular to the angle of the conical surface. The location and angle of the force can introduce undesirable tensile forces into the portion of the plug head that bears the force. Often the desired plug head material may demonstrate weak tensile strength, thus introducing additional tensile forces that can either limit the selection of plug head materials or that can cause breaking of the edge of the plug head,
25 separating the plug head from the plug stem and causing valve failure. Also, as the retaining ring wears away through normal corrosion and erosion, the shape of the contact area can change, typically moving closer to the edge of the plug head. This contact area change tends to concentrate forces on the edge of the plug head and increases the likelihood that the edge of the plug head will fracture, thereby causing
30 the plug head to separate from the plug stem. The stresses induced with the taper fit are difficult to quantify and, therefore, can detract from a valve plug's performance. Variables in the welding process, such as weld shrinkage, inter-pass temperature,

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amperage of weld, inert gas environment, the amount of initial burn in, can change the amount of stress in the plug head.

As noted above, typical prior taper fit designs attach the taper fit ring to the plug stem via welding. This approach results in the retaining ring and the plug stem becoming permanently joined into one component. If the plug head wears away or breaks and the plug stem is still usable, the typical taper fit design does not lend itself to achieving the proper concentricity between the plug head and the plug stem after the plug head has been replaced. When a taper fit valve plug is repaired, the plug stem has already been machined, so it is not possible to make adjustments in the plug stem to ensure concentricity with the plug head. If the plug head is misaligned, adjustments cannot be made without cutting the taper fit ring off. For at least these reasons, taper fit valve plugs are usually discarded (as opposed to being repaired) when the plug head has broken or worn away. During assembly, the taper fit ring is typically fit tightly around the ceramic and the taper fit ring is welded to the plug stem. At elevated operating temperatures, the taper fit ring increases in size more than the plug head, and the plug head becomes somewhat loose in the taper fit ring, thereby leading to early failure of the fit in operating conditions.

Interference fittings typically require a bulkier retaining ring, contributing to the load on the plug head. Interference fittings also require more complex procedures to replace plug heads and are generally limited in their service temperature ranges. An interference fit achieves more uniform loading of the plug head than does the taper fit. However, the typical interference fit uses a one-piece retaining ring that not only holds the plug head but also attaches the plug head/retaining ring assembly to the plug stem. The interference fit also must have sufficient material to allow for the wear due to erosion and corrosion without causing the plug head to separate from the plug stem. These requirements result in a bulkier retaining ring than is required to hold the plug head in place, which contributes to an additional load on the plug head. This additional load introduces tensile stresses, which tend to contribute to plug head breaking and separation, which can result in valve failure.

Even with interference fit designs, the task of replacing the plug head is quite complex. To replace the plug head, the interference fit ring must be cut, separating

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the plug head and ring assembly from the plug stem. This process is usually performed on a lathe or mill. If the ring is to be used again, it is necessary to separate the ring from the plug head. Certain combinations of plug head and interference fit ring materials can be separated by heating the assembly in an industrial oven. If the coefficient of thermal expansion of the retaining ring is sufficiently higher than the plug head, the retaining ring will expand more quickly and the interference fit will be negated as a space forms between the two surfaces. This approach is somewhat destructive and requires that the interference-fit ring be carefully checked before reuse. Also, this heating method only works with certain combinations of materials. Moreover, even when it may work, the plug head replacement process requires specialized manufacturing facilities that are generally unavailable to users in remote locations. Therefore, replacing plug heads for valve plugs is not a typical industry practice for certain combinations of materials or user locations.

Another problem with interference fittings is that service temperature ranges are limited because of differential thermal expansion between the plug head and ring materials. The amount of interference between the plug head and the ring is directly related to the amount of stress in a plug head. The amount of interference at ambient temperature becomes a concern when it places large amounts of stress on the plug head. Thus, when the valve plug is installed and is warming to operating temperature, the plug head is more highly stressed and is more vulnerable to failure. It has also been observed that because of these stresses, certain valve plugs, head and rings, could not be used because the ambient temperatures, or below ambient storage temperatures, could cause the plug head to fail before they could be placed into service.

Also, both taper fittings and interference fittings suffer from the impracticalities of stress relieving heat affected weld zones with heat treatments. For highly corrosive fluid applications and with certain materials, it is important to stress relieve heat affected weld zones with heat treatments. With both prior existing taper fit and interference fit designs, this has not been considered practical because stress-relieving typically is performed at temperatures high enough to allow the plug head to be excessively loose in the ring, and it is not possible to assure that

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the plug head would return to its proper position upon cooling. Therefore, even though heat treatments might be beneficial, they have generally been avoided.

In view of the foregoing shortcomings, it would be desirable to provide a valve plug design that uses a clamping system to attach the valve plug head to its valve plug stem, and to thereby provide a means of assembling and replacing worn plug heads in the field, while allowing use of different materials for the plug head and the plug stem, where the different materials are selected specifically to address the different function of the plug head and the plug stem. This type of plug design is particularly desirable for use in flow streams that are erosive or corrosive in nature, because plug heads in these kinds of streams typically suffer material loss due to the erosion and/or corrosion and require regular replacement. Often the plug head wears out before other valve components. Therefore, minimizing the occurrences when the plug head fails and must be replaced is very desirable in improving the life cycle and efficiency of the valve.

15

DISCLOSURE OF THE INVENTION

One embodiment of the present invention includes attaching a ceramic (or other sacrificial material) plug head to a plug stem. The embodiment uses two retainer half rings (clamps) and two or more bolts/nuts to hold the head onto the plug stem. In this fashion, replacement of the plug head can easily and quickly accomplished in the field. The two clamps are configured such that a gap is left therebetween on both sides. The bolts/nuts are sacrificial bolts which are inexpensive. Rather than undo the bolting, these bolts can easily be cut off and thrown away. The bolting can then be replaced and a new plug head installed, reusing the all of the major components. Other embodiments may use three or more retainer rings (clamps) to hold the head onto the plug stem. It is understood that all modifications and embodiments discussed herein may also be adapted to include three or more retainer rings (clamps).

When ceramic plugs are used, it is common to replace field worn plug heads with new ones. These applications often involve scaling, erosion and high temperatures. This design has several advantages over current designs. This design is easier to work on in the field and the factory. Assembly of this design is simpler

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than previous designs. Some old designs even required shrink fitting and welding of the parts to hold them together. This precluded field assembly of plugs. This design allows simple field assembly. Assembly in the factory is also simplified. The gap left between the two clamps is important as many of the services which require
5 erosion resistant plug heads have solids in the fluid stream. Solids tend to build up on parts. When threaded parts are used it can make undoing threads impractical or impossible, which would make reusing the stem impossible.

MODE(S) FOR CARRYING OUT THE INVENTION

10 An embodiment of the present invention includes a plug assembly that includes a plug head made of a sacrificial material that is attached to a plug stem with two retainer half rings. The plug assemblies of this invention are adapted for use in industries such as, for example, mining, chemical processing, and oil and gas refining, where the flow is abrasive and/or corrosive and which may contain
15 substantial quantities of sediment, debris or scale. Valves in certain erosive and/or corrosive flow streams encounter a significant amount of sediment, debris or scale which comes through the pipe line. This invention provides plug heads and stems being made of dissimilar materials having different properties that optimize the performance of the plug head, the plug stem and the fastening band. Also, this
20 invention is adapted to ease the process of repair and replacement of valve plug components, permitting maintenance to be accomplished in the field without requiring specialized manufacturing equipment or highly skilled personnel. The invention is also adapted to provide a tight shutoff by permitting improved alignment of the plug head and seat ring.

25 In a particular embodiment of the invention, the plug assembly allows the plug head to shift from side to side. When control valves are produced, there is always a certain amount of variation in the parts and assembly. However, in order to provide tight shutoff, the plug head and seat ring must line up perfectly. Since manufacturers cannot make the parts perfectly, plug assemblies need a certain
30 amount of adjustability.

In most valves, the seat ring can shift a little from side to side to allow the seat ring to center up on the plug. This is typically done by keeping the bonnet a

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little loose while stroking the plug into the seat repeatedly. Once the seat ring has moved to center itself, the bonnet is then tightened, locking the seat into place. This process is described in detail in the Mark One Users Manual (VLENIM0001) steps 7.9 to 7.9.2. Some valve designs allow the bonnet to shift a little from side to side instead of shifting the seat ring, as when a screwed in seat is used. In the case of
5 survivor, the seat ring is pinched between the valve outlet and the valve body. Performing a seat centering procedure is more difficult and is described in the Survivor Users Manual (VLENIM0036).

Because this process is so difficult to perform, one particular embodiment of
10 the present assembly is configured to allow the plug head to float (instead of the bonnet or seat ring). This particular embodiment allows the plug head to move slightly from side to side. This action allows the plug head to find a natural center on the seat ring, providing the best shutoff possible.

Referring to FIGs. 1 and 3, a particular embodiment of the plug head and
15 plug stem of the present invention is illustrated. A valve plug 100 is shown having a plug head 101 held in a plug stem base 103 which in turn is mounted on the plug stem 102. As shown in FIG. 2, the plug head 101 includes a base portion with a beveled edge 110. A distal portion of the plug stem 102 includes a beveled edge 112. The plug head 101 is held in the plug stem base 103 by two clamps (half
20 rings) 104 which provide an interference fit between the plug head 101 and the plug head 101 and the plug stem 102. The two clamps are fitted over the plug head 101 and the plug stem base 103 and are tightly held in place by four bolts 120. In a particular embodiment of the invention, the bolts are fixed in place by nuts 107a,b. Alternatively, two clamps can be held in place by pins, screws, welds, brazing,
25 clamps or the equivalent. Additionally, the clamps 104 can include a hinge mechanism or tongue-and-groove mechanism to hold the two clamps 104 together on one end, while relying on two bolts 120 to secure the two clamps 104 together at an opposing end. The two clamps 104 can provide shock absorbing capabilities and stress relief to the plug head 101 during use.

30 The preferred plug head 101 can be composed of structural ceramics because of its resistance to wear and degradation in flow streams that are erosive (having fine-grit particles) and corrosive (due to the chemical composition of the flow).

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Structural ceramics are a class of materials that includes, but is not limited to silicon carbide, silicon nitride, aluminum oxide, zirconium oxide, tungsten carbide, whisker-reinforced blends of ceramics, two-phase ceramics and the like. Alternative materials which may be substituted for structural ceramics for the plug head 101, include, but are not necessarily limited to, cermets, which are compounds that are combinations of ceramics and metals, cast iron, silicon iron, white iron, heat treated martensitic steels (such as 440 or 416 grade steel), CrCoFe alloys (such as stellite #3, stellite #6, and stellite #12), or other metals. Alternative materials with similar properties can be substituted without departing from the concept of this invention.

The plug stem 102, plug stem base 103 and clamps 104 can be composed of materials selected for ease of machining to a smooth surface, having good tensile strength, reasonable ductility and cost effectiveness. Included within this class of materials are titanium and its alloys, zirconium and its alloys, niobium and its alloys, titanium-niobium alloys, alloy steels, carbon steels, iron-base superalloys, stainless steels, nickel and its alloys, nickel-base superalloys, copper based alloys, cobalt alloys, cobalt-base superalloys, aluminum and its alloys, magnesium alloys, tantalum and the like. Alternative materials with similar properties can be substituted without departing from the concept of this invention.

The clamps 104 can be composed of metal alloys, including but not limited to titanium and its alloys, zirconium and its alloys, niobium and its alloys, titanium-niobium alloys, alloy steels, carbon steels, iron-base superalloys, stainless steels, nickel and its alloys, nickel-base superalloys, copper based alloys, cobalt alloys, cobalt-base superalloys, aluminum and its alloys, magnesium alloys, tantalum and metals of similar properties. Alternative materials with similar properties can be substituted without departing from the concept of this invention.

FIG. 4 shows a representative system of a valve plug 100 of this invention in a valve assembly 300. The valve plug 100 is shown in a substantially closed position with the plug head 101 closing a first flow path 303 from the valve chamber 301 and a second flow path 302. The valve plug stem 102 is shown connected to the actuator 304 and sealed with the shaft 305 in close, preferably fluid tight proximity, with valve stem support (or shaft support) packing (not shown).

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FIG. 2 shows an embodiment of the valve plug 100 in its working environment in a typical valve 300. The actuator 304 functions to position the valve plug 100 either in the shown closed position or retracted to permit fluid flow from the first flow path 303 to the second flow path 302. Alternatively, the flow can, as is common in some valves, flow in the opposite direction.

FIG. 5 shows a section view of an alternative embodiment of a valve plug 200 having a plug head 201 mounted to plug stem base 203 of a plug stem 202, this embodiment have additional compliance structure provided. In contrast to the embodiment described in FIG. 1, the present embodiment includes a plug stem base 203 having a base portion with a non-beveled end or edge 214. Additionally, the plug stem base 203 can have a smaller diameter than the diameter of the plug head 201. This design permits the plug head 201 and clamps 204 to move and adjust relative to the plug stem 202, which allows the plug to self center when in use in the valve assembly 300. An embodiment of the valve plug 200 can include washers or springs 220 within or adjacent to plug stem base 203 to provide cushioning and separation between the plug stem base 203 and the plug head 201. Representative spacers include, but are not limited to Bellville washers and spring mechanisms.

Alternative embodiments of the invention include spacers (not shown) on the bolt sections between sections of the clamps 204 that are adjacent to plug head 201 in order to prevent deflection of the clamps 204.

The described embodiments, including the various materials specific components and dimensions, are to be considered in all respects only as illustrative and not as restrictive. The invention should not be considered limited to the particular preferred and alternative embodiments, rather the scope of the invention is indicated by the appended claims. All changes, modifications and alternatives which come within the meaning and range of equivalency of the claims are to be embraced as within their scope.

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CLAIMS

What is claimed is:

- 5 1. A plug assembly comprising:
a plug stem having a plug stem base;
a plug head; and
a fastening mechanism for fastening the plug stem base to the plug head, the
fastening mechanism comprising at least two retainer clamps that
10 surround and provide an interference fit between the plug stem base
and the plug head.
2. The plug assembly of claim 1, wherein fastening mechanism is
configured to allow the plug head to move side to side to allow the plug head to find
15 a natural center on the seat clamp.
3. The plug assembly of claim 1, wherein the plug head is made of a
sacrificial material.
- 20 4. The plug assembly of claim 1, wherein the at least two retainer
clamps are held in place by sacrificial bolts.
5. The plug assembly of claim 4, wherein the bolts are held in place by
nuts.
25 6. The plug assembly of claim 4, further comprising spacers between
one or more sections of the at least two retainer clamps.
7. The plug assembly of claim 1, wherein the at least two retainer
30 clamps are held in place by sacrificial pins, screws, welds, brazing, or clamps.

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8. The plug assembly of claim 1, wherein the at least two retainer clamps comprise a hinge mechanism or tongue-and-groove mechanism to hold the at least two clamps together on one end.

5 9. The plug assembly of claim 1, wherein the fastening mechanism provides shock absorbing capabilities to the plug head.

10 10. The plug assembly of claim 1, wherein the plug stem comprises titanium, zirconium, niobium, alloy steels, carbon steels, iron-base superalloys, stainless steels, nickel, nickel-base superalloys, copper based alloys, cobalt alloys, cobalt-base superalloys, aluminum, magnesium alloys, tantalum, or any alloys thereof.

15 11. The plug assembly of claim 1, wherein the plug head comprises silicon carbide, silicon nitride, aluminum oxide, zirconium oxide, tungsten carbide, whisker-reinforced blends of ceramics, two-phase ceramics, and cermets.

20 12. The plug assembly of claim 1, wherein the fastening mechanism comprises titanium, zirconium, niobium, alloy steels, carbon steels, iron-base superalloys, stainless steels, nickel, nickel-base superalloys, copper based alloys, cobalt alloys, cobalt-base superalloys, aluminum, magnesium alloys, tantalum, or any alloys thereof.

25 13. The plug assembly of claim 1, wherein the plug stem base has a beveled edge.

14. The plug assembly of claim 1, wherein the plug head has a beveled edge.

30 15. The plug assembly of claim 1, wherein the plug stem base has a smaller diameter than the diameter of the plug head.

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16. The plug assembly of claim 1, further comprising washers or sp clamps positioned within or adjacent to plug stem base to provide cushioning and separation between the plug stem base and the plug head.

5 17. The plug assembly of claim 1, wherein the at least two retainer clamps are configured to be spaced apart from one another.

18. A method of replacing or attaching a plug head to a plug stem comprising:

10 providing a plug stem having a plug stem base;
providing a plug head;
providing a fastening mechanism comprising at least two retainer clamps;
and
coupling the fastening mechanism around the plug stem base and the plug
15 head to provide an interference fit between the plug stem base and the
plug head.

19. The method of claim 18, wherein the fastening mechanism further comprises a sacrificial interconnecting mechanism for connecting each of the at least
20 two retainer clamps together.

20. The method of claim 19, wherein the sacrificial interconnecting mechanism comprises bolts, pins, screws, welds, brazing, or clamps.

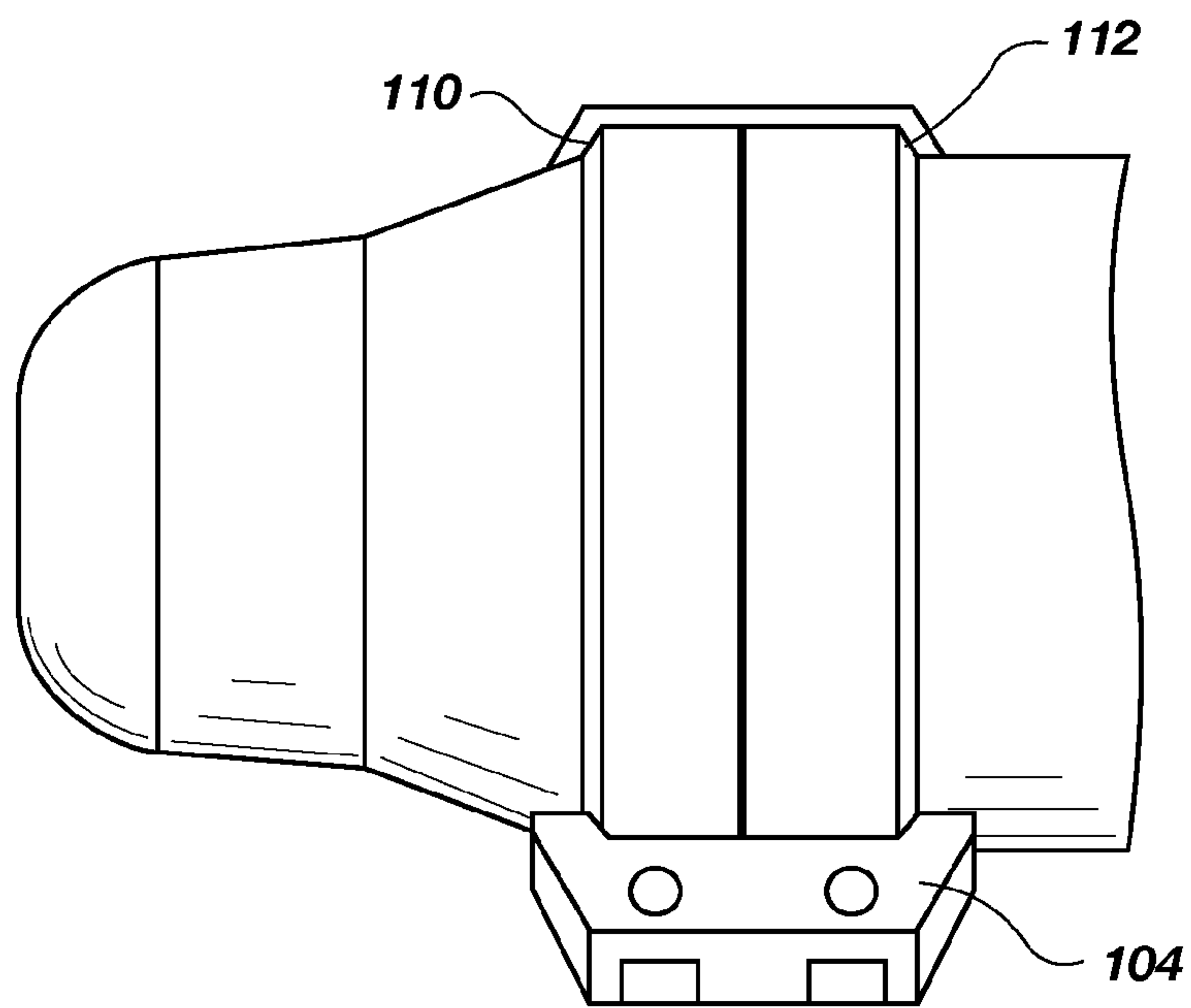
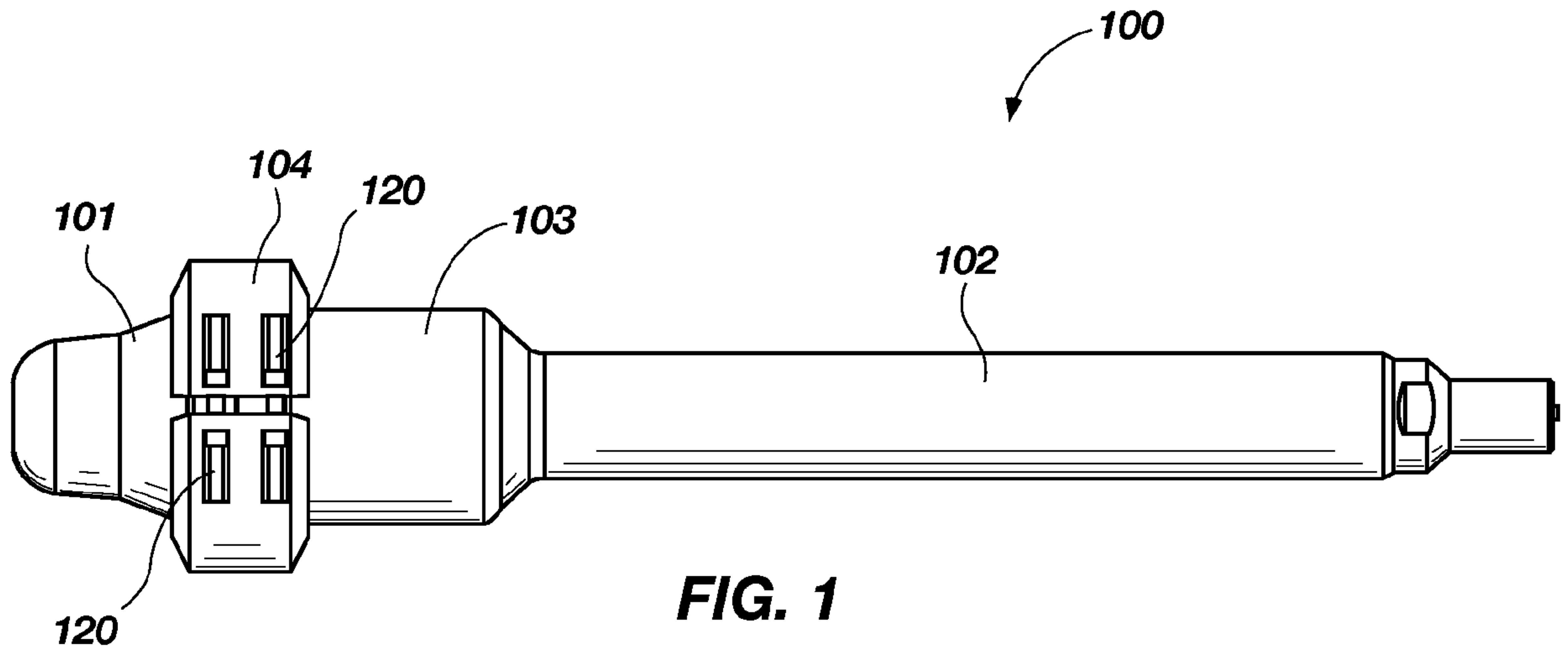
25 21. The method of claim 19, further comprising cutting the interconnecting mechanism.

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22. A plug assembly comprising:
- a plug stem having a plug stem base;
 - a plug head; and
 - a fastening means for fastening the plug stem base to the plug head, the fastening
- 5 means comprising at least two band sections that surround and provide an interference fit between the plug stem base and the plug head, the at least two band sections joined together with and spaced apart by a sacrificial interconnecting means.

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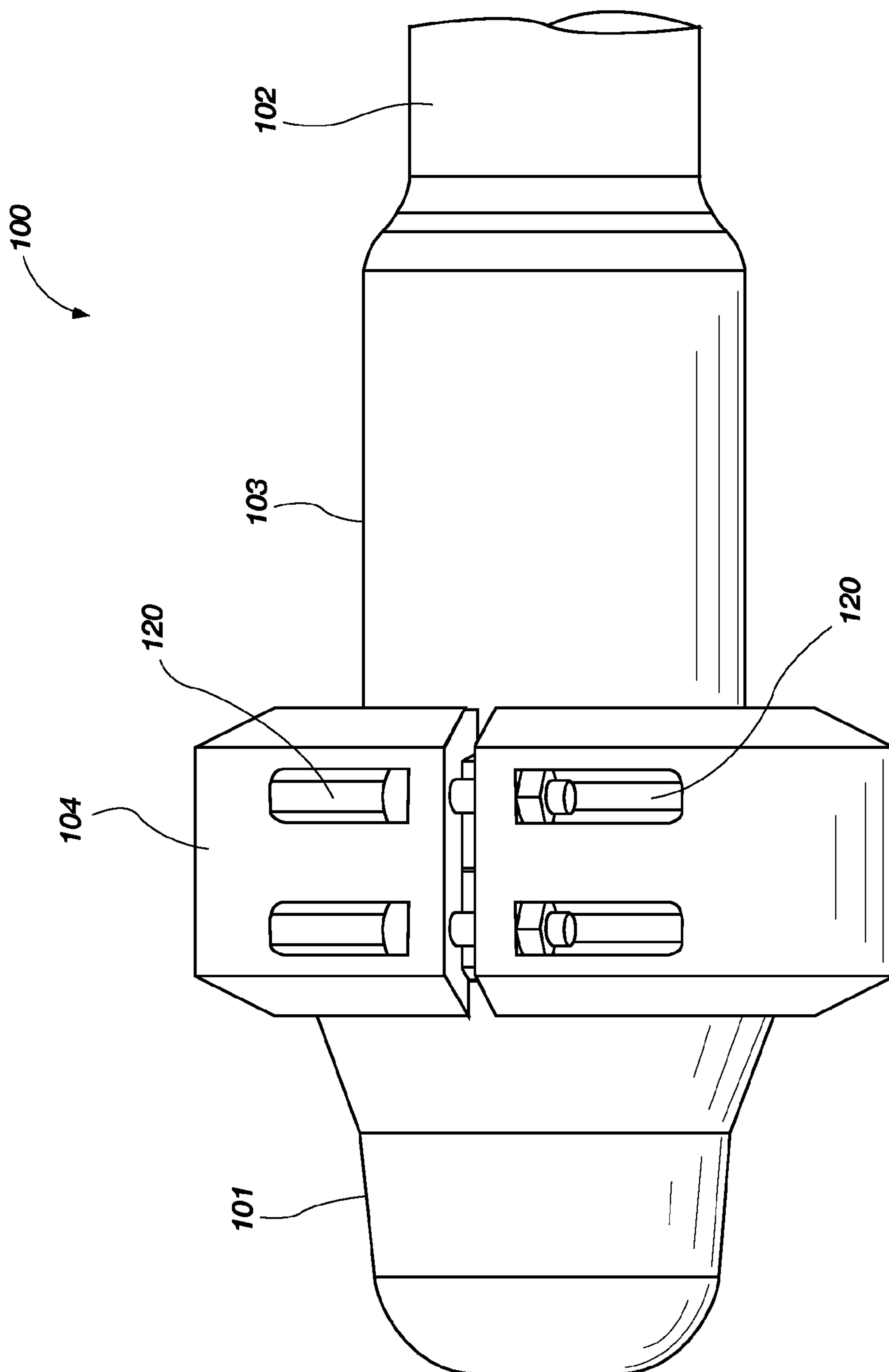


FIG. 3

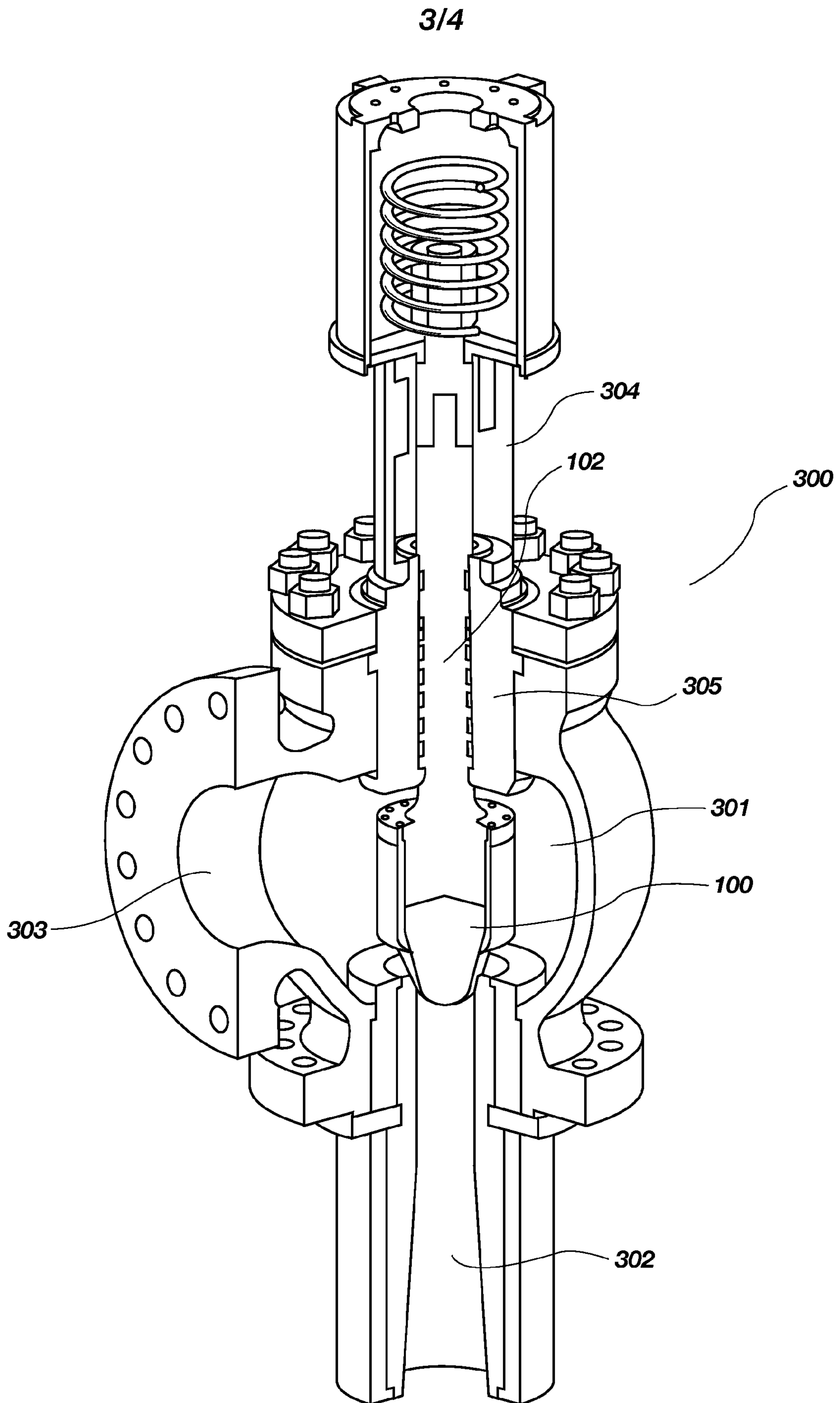


FIG. 4

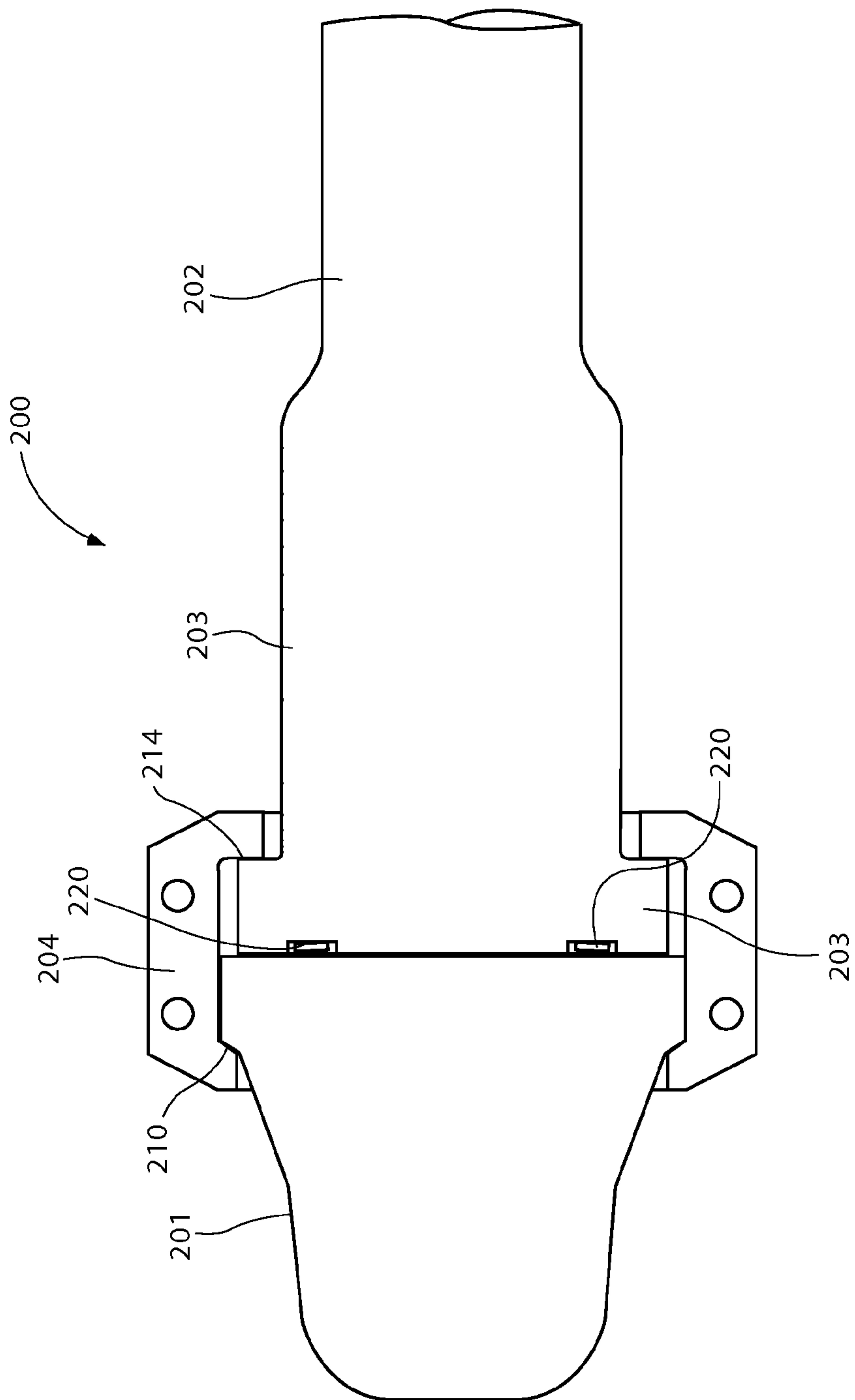


FIG. 5

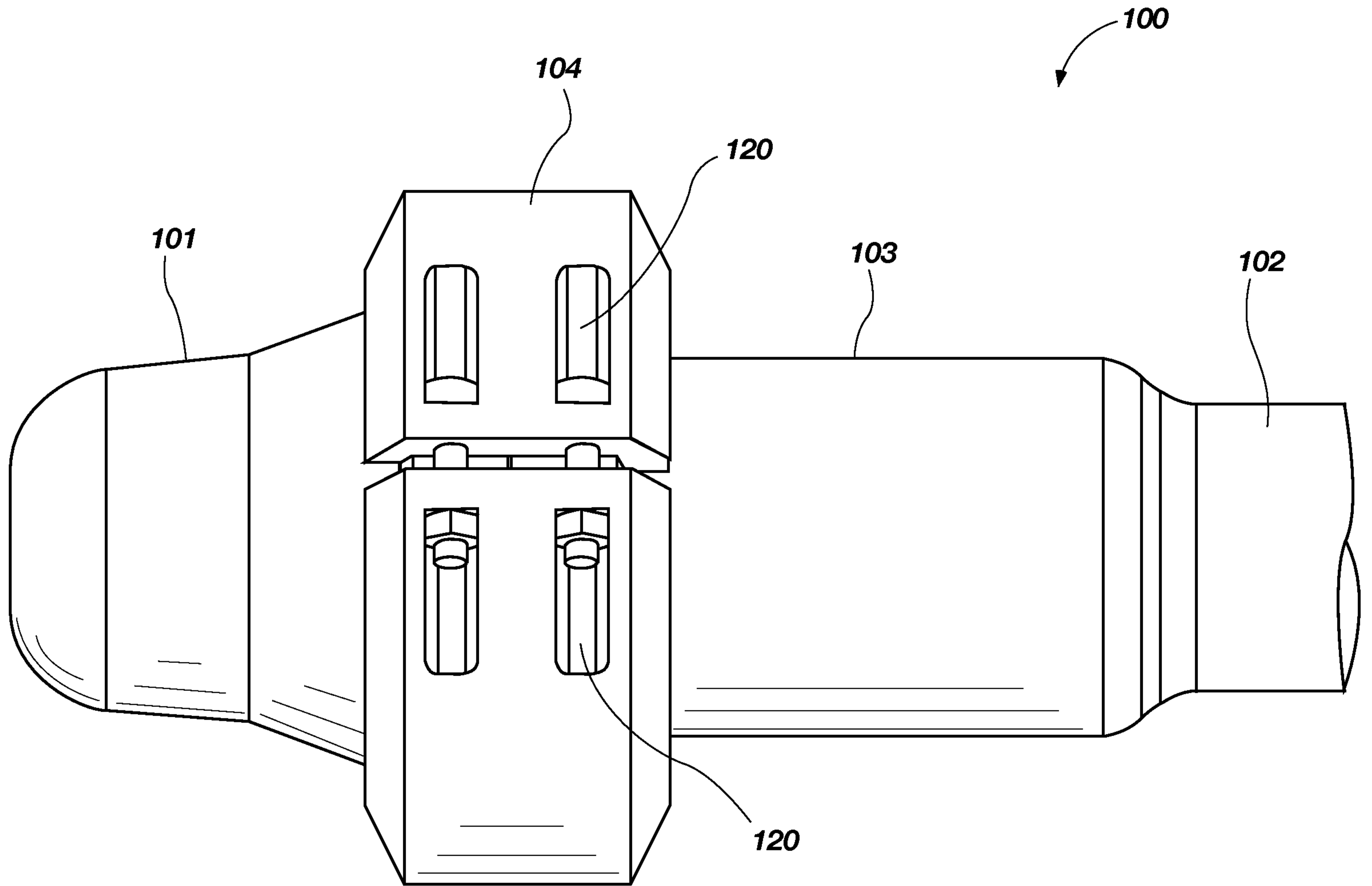


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