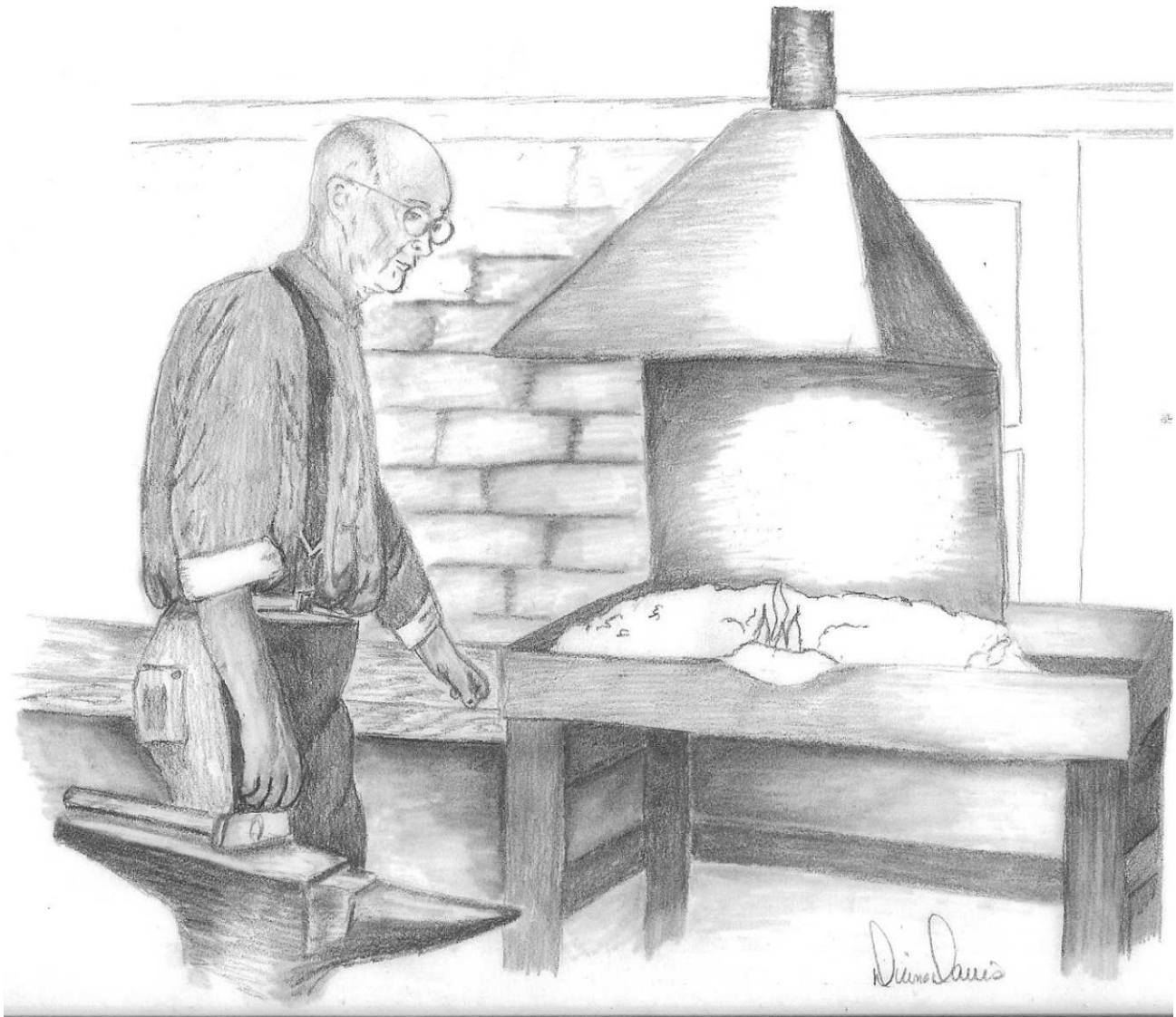


# Saltfork Craftsmen Artist-Blacksmith Association

August 2008



**SCABA Conference brochure enclosed in this issue.**

**Saltfork Craftsmen  
Artist-Blacksmith Association  
Officers and Directors**

President: Jim Carothers 580-336-9213  
9501 Frontier, Perry Ok. 73077  
frontiershop@wildblue.net

Vice-President: Gerald Franklin 580-467-8667  
Rt. 3 Box 239J, Duncan, Ok 73533  
franklin@gci-wireless.net

Sec-Treas. Mike George 580-327-5235  
1227 4<sup>th</sup> St. Alva, Ok. 73717  
mike-marideth@sbcglobal.net

Director: JC Banks 580-482-3209  
16007 S. CR 206 Altus, Ok. 73521  
jc.banks@okstate.edu

Director: Byron Doner 405-650-7520  
6520 Alameda, Norman Okla.  
byrondoner@earthlink.net

Director: Bill Kendall 918-742-7836  
1756 E. 59<sup>th</sup> St Tulsa Ok. 74105  
wwkendall@aol.com

Director: Richard Dyer 918-582-5065  
1119 S Birmingham Pl. Tulsa, Ok. 74104  
irondyer@aol.com

**Assignments:**

Editor: Diana Davis 580-549-6824  
23966 NE Wolf Rd Fletcher, Ok 73541  
Lazyassforge@tds.net

Librarian/Education:  
Gerald Franklin 580-252-6002  
Rt 3 Box 239J Duncan, Ok 73533  
franklin@gci-wireless.net  
cell phone 580-467-8667

Events coordinator: Bill Davis 580-549-6824  
Lazyassforge@tds.net

The Saltfork Craftsmen Artist-Blacksmith Association, a non-profit organization of amateur and professional artist and craftsmen, publishes this newsletter monthly. Our purposes are the sharing of knowledge, education and to promote a more general appreciation of the fine craftsmanship everywhere. We are a chapter of the Artist-Blacksmith Association of North America.

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**Visit our Saltfork Craftsmen Website:**  
[www.saltforkcraftsmen.org](http://www.saltforkcraftsmen.org)

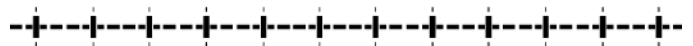
**Trading Post**

**For Sale:**

3/4" round bar of 5160 (\$3.30 per foot plus shipping)  
3/4" and 1" round bar of 52100 (\$6.00 and \$9.45 per foot plus shipping) Contact Ray Kirk, ray@rakerknives.com or 1-918-456-1519



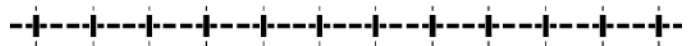
Army surplus round nosed pliers that make good scroll pliers for small items. They are 6" long \$5.00 each plus shipping. I also tie brooms on your handle or mine. \$20.00 plus shipping. Diana Davis 580-549-6824 or lazyassforge@tds.net



Due to health problems, I have decided not to rebuild any more Little Giant hammers. I have for sale :One decent used 100# hammer (\$3,500), one completely rebuilt 50# hammer (\$4,500), one good condition used #50 hammer (\$3,500), two rebuild able 50# hammers (one at \$1750 and one at \$2,000 ), I have some miscellaneous parts, dies, babbit mandrels, and etc. for sale. Contact Mike George at 580-327-5235 (home), 580-829-1968 (cell) or Mike-marideth@sbcglobal.net

**Wanted:**

Advertising Coal Hammers, Contact Mike George at 1-580-327-5235 or o Mike-Marideth@sbcglobal.net



Complete blacksmith line-shaft. Good Running Condition with post drill, pedestal grinder/wire wheel and 40 lb Perfect Power Hammer, Lots of extras, Call for info. 817-329-5299 Jim White

## Club Coal

Saltfork Craftsmen has Arkansas coal for sale. The coal is \$95/ton to members and \$145/33non-members. Bring your own containers. Contact Tom Nelson at 1-580-862-7691 to make arrangements to pick up a load. **DO NOT CALL AFTER 9 P.M.** If you make arrangement well in advance, Tom can load your truck or trailer with his skid steer loader. Otherwise you will need to bring a shovel. The coal can be weighed out at the Douglas Coop Elevator scales. The coal is in large chunks; bring something to break up the coal into manageable size pieces.

**S/C Region coal location:** Coal is in 1-2" size pieces. Bring your own container. The coal is at Max Scrudder's place in Mountain View. Contact Max for load out instructions.

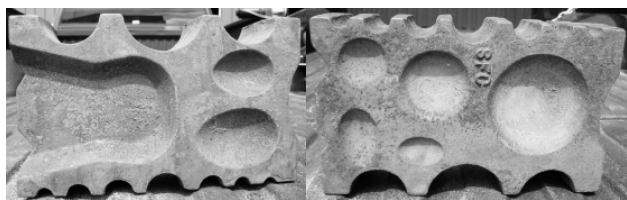
Cost for this coal is .06/pound or \$120.00/ton. NO SALES to non-members.

Max Scrudder can be contacted at (405) 226-9951

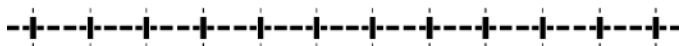
**NE Region coal location:** Dan Cowart also has coal to sell. He can be contacted at dacowart@dishmail.net or CowartPat@gmail.com

Saltfork Craftsmen Swage Blocks \$105.00 each plus shipping. SCABA members can purchase one block for a special members price of \$85.00

Contact Mike George at 1-580-327-5235 or mike-marideth@sbcglobal.net or Bill Kendall at 1-918-742-7836 or wwkendall@aol.com



Mail your ads to the editor or email them to lazyassforge@tds.net



## MEETING SCHEDULE

### August

**South/Central region—August 16th.** Hosted by Richard Simpson. Meal is provided but bring a side dish to help out. The trade items is anything to use over a campfire. There is a map in the newsletter with directions.

**Northeast regional meeting. August 9th** hosted by Omar Reed. The meeting will be held at the Fort Gibson historic Site, which is about 9 miles east of Muskogee (US. Hwy 62) turn north onto (State hwy 80). On St. Hwy. go north for about 1 1/2 miles along the railroad tracks. You will come to the old Log Fort. We will set up under the trees

On the east side of the stockade. The coffee will be on and the donut box open. Some type of cold beverage (pop, tea, cool-aid) will be available. Lunch will be on me, the menu is being discussed.

**Southeast regional meeting. August 2nd Open**

**Northwest regional August 23rd Open**

## PUBLIC DEMO'S AND REQUEST

**Sept 26-27** 18th National Two Cylinder Show and Threshing Show, at Fairview, Ok. This is what they call a working show with games, plowing, baling, threshing, etc. Contact James @ 580-227-4985

**October 18-19** SCABA conference at Perry Ok.

You need to be making your plans for the SCABA Conference in October. **Don't forget that hotel rooms are sometimes in short supply.** Book your room early, you can always cancel it (according to hotel regulations ) if something comes up and you can't attend.

Also start working on a nice item for the auction and collect items for the Iron-n-hat.

You can also make a tool to be donated to the tool box. Adam is putting final touches on the box and David Seigrist has tickets printed and for sale now.

## Editor's notes:

I am taking a couple of week off to make a trip to Alaska. Bill and I will be leaving the 18th of August and will not be back until the 30th. ***Sept. newsletter will be late.*** Don't expect to receive it before the 4th or 5th of the month.

What I need from the membership is ....If you do a demo or host a meeting please send a WORD document to me by email. If you don't have internet access mail me a brief letter telling me about your demo,,etc. If you have them, include no more than 5 pictures along with the email. If you mail in your report and can send me some photos, I will scan them and return the originals if necessary.

We have some open dates on the calendar, if anyone would like to host a meeting on one of these dates, please let me know. I know that the temp is in the 3 digit range and my be too hot to forge for most but we could still meet and visit. *Diana Davis*

*Editor*

## SCABA TOOL BOX

Raffle tickets are now available for the tool box. If you would like to purchase tickets or get some to sell for the club please contact David Seigrist, tool box chairman. The tickets are \$2.00 each and come in booklets of 5 tickets or \$10.00 each booklet. The drawing for the box will be done during the conference in October. Check out the list of tools and pick out something to make and donate to the box. You can contact David Seigrist at **580-688-3555** if you want to make and donate a tool or if you need tickets for yourself or to sell. This is one of the best tool boxes so far.

## Knife show

The annual Knife show held at the Holiday Inn at 2101 S. Meridian will be held on Sept 20, 21st. You can contact Ray Kirk for more information. [ray@rakerknives.com](mailto:ray@rakerknives.com)

## SOUTH/CENTRAL REGIONAL MEETING

Max and Ann Scrudder hosted our July meeting again this year. Max has a new shop in Mountain View and will soon have his home ready to move into.

Like most July's in Oklahoma it was hot but with a little breeze out of the south. I'm not sure how the guys managed to work at the forges but they kept them going until time to call it a day and go home. The rest of us, the smart ones, set around in the shade and watched.



Allen and Judy Hamm came up from Texas for the meeting. We enjoyed getting to visit with them. We

usually only get to see them when we both attend the North Texas meeting at the Sid Richardson Boy Scout Ranch, which is coming up in Sept.

Max and Ann provided a delicious lunch of smoked brisket and beans. Max poured the ingredients into the beans so quickly that I couldn't figure out the recipe but they were good.



Kent Hadick and his daughter Rebecca came and Kent was helping Rebecca learn the basics of forging.



Rebecca, along with help from dad, forged two heart shapes that they then joined together with a collar and it was a part of the trade items, which was a wall hanging.

There were several nice examples in the trade items. JC made a frog, Bill D. and Gerald Franklin both made a cross, Jerry Cathy made a church outline and Max made a large grill, just to name a few. They were all nice items.



Frog by JC Banks



Max has volunteered to host the meeting in July of 09 and has decided that the trade item would be a “Fly Swatter” I think it will be interesting to see what some of us can come up with.

## Decorative Punch Workshop

I’ve only had two signups for this workshop so if anyone wants to attend give me a call. Gerald Franklin will be conducting a decorative punch workshop on the 30<sup>th</sup> of August at his place in Duncan, OK.

Often times we would like to add that little something special to our work to really highlight our piece and make it stand out from the crowd but just can’t think of what it would be. A decorative punch with a few hammer blows can really make your work stand out and provide that extra detail so prospective clients will stand up and take notice. Usually some of us realize how much a decorative mark would add to the piece when we see it on someone else’s work and say “Wow! Why didn’t I think of that?” usually followed by “How did you do that?”

Gerald will put on a cold forge workshop, since it’s in August, to teach us how to make our own decorative punches. We’ll be able to make a punch or two and before it’s over, take with us the knowledge to make a wide variety of punches in our own shop. It’s a one-day workshop to help folks who are traveling. Gerald tells me it’s not that hard we just sometimes need a boost on the basics to upgrade our skills at the forge, increase confidence in our ability to make tooling, and potentially the price of our product.

All that’s required is a Dremel tool and if you don’t have one, Harbor Freight (I know that’s taboo to some folks) has one for about \$8. If you have a small belt sander, perhaps a 1” or 2” and can bring it that would be good.

We will start at 9:00 am on Saturday the 30<sup>th</sup> and finish the same day. Cost for the workshop is \$20 and limited to 8 students and no observers. If you would like to attend please give me a call or send an email and I’ll add your name to the list. I’m also making an alternate list in case we have dropouts.

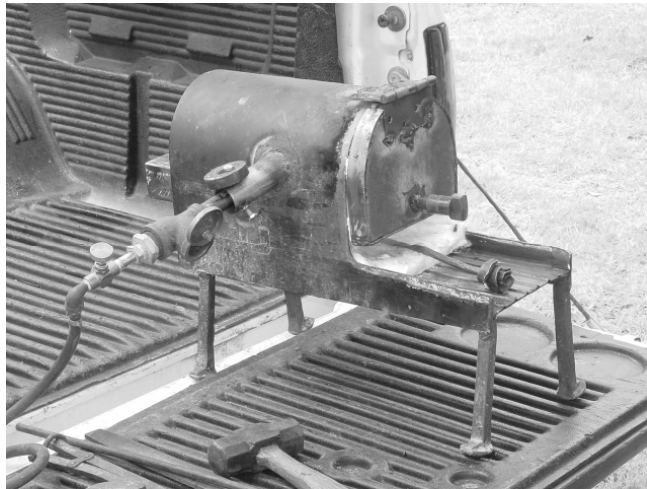
It’s never too late to turn in a survey, and those who return a survey requesting that class has first dibs.

David Seigrist  
P.O. Box 163  
Hollis, OK 73550

(580) 381-0085  
dseigrist2004@yahoo.com

# NORTH EAST REGIONAL MEETING

Images from the meeting...by Jim Carothers



Mike Sweany and his forge made from a mail box. Is this proper use of government property?



Ron cutting out a cowboy face from 1/2 " sq stock. He makes a hat from a washer.



Charlie McGee and Dan Cowart forging at the meeting.



Unique set of tongs owned by Mike Sweany. They look to be pretty simple to make. The material was 1/4" x 1/2" flat bar.

## DEMO-ING AROUND THE STATE

As most of you know, on any given weekend you can find a blacksmith demonstrating their skills. Every City planning a celebration or historical group doing a reenactment seems to want a blacksmith present. July was no exception to that rule. Even with high heat, members of the Saltfork Craftsmen ABA were out in force to support their favorite event.

Each year for the past several there has been one or more SCABA members demonstrating for the public at the Pawnee Bill Ranch. This year I was able to get tickets to see the Wild West Show and also spend some time checking out the vendors that set up before each show. Along with all that activities there was also Tom Nelson (member working on the Sat. that I went) working in the blacksmith shop at Pawnee Bill's ranch.

Tom would demo for a little while and then take a break and watch the magic or medicine show that was right outside his door. The kids really like the magic show.



Tom seemed to have a good crowd during most of his demo's.



For a short time he got a break when he talked Bill into doing a little forging. Bill made a man from a RR Spike and a hoof pick from a horse shoe.

If you get a chance next year to go and see the Wild West Show by all means try to go, It is a very entertaining and by all means go by and say "HELLO" to one of our members that will probably be in the Blacksmith Shop.

**MEDICINE PARK...**Larry Moorefield spent the next Saturday after his meeting in July helping the local Fire department raise money for equipment. As you know Medicine Park is in the heart of the Wichita Mountains and thus experiences devastating fires each summer. Larry set up his blacksmith wagon next to the fire station under a large shade tree. With the shade it provided it was not too bad forging.



This was their annual "Wagon Camp" with a full two days of events planned. On Friday they had a City picnic where everyone was invited to come eat. Larry said you had to be careful but you could be sure what some of them threw in the pot. There was also a parade on Friday and probably (we didn't stay to watch) fireworks that night.

At the wagon camp not only did Larry Morefield do some blacksmithing but his Medicine wagon is used for the backdrop for the melodrama that is put on during the evening hours. Larry has a part in the melodrama but we didn't get to watch this year. We came by to visit and I met an old school mate. Him and his wife were from the Duncan area and he was setting up a covered wagon next to Larry's.

## **Francis Whitaker Blacksmithing Scholarship at John C. Campbell Folk School**

Two paid scholarships for tuition will be awarded for the **Traditional joinery Projects Class** taught by Clay Spencer October 26-31 2008.

For more information about this class go to; [http://www.folkschool.org/index.php?section=class\\_detail&class\\_id=2414](http://www.folkschool.org/index.php?section=class_detail&class_id=2414)

Students must be intermediate to advanced skill level and will be responsible for their own meals, lodging/camping, materials and fuel fee.

### **Application Requirements;**

1. Describe your blacksmithing training/experience; any classes, demonstrations, jobs, commissions, crafts shows, work at your forge, etc.
2. Several photos of your work.
3. Drawing of the project you propose to do in class. It should be to scale showing stock size and joinery, no MIG or arc welding in project.
4. Goals for your blacksmithing, briefly.
5. Why you need scholarship help, briefly.

### **Send to:**

Clay Spencer  
73 Penniston Pvt. Drive  
Somerville, AL 35670  
Clay@otelco.net

You may call 256-558-3658 with any questions.

**Application must be received by Sept. 15 2008**

## **SEPT. MEETING FOR THE NE REGION.**

On Saturday September 13, 2008 we are having the Northeast meeting at 210 W. Main in Pawhuska, OK. This is the site of the Blacksmith House the Osage Indians built in 1871 so they could get a blacksmith to come to the area. Main street is the mail artery through Pawhuska.

The Chamber of Commerce which owns the Blacksmith house wants to build a working Blacksmith shop with a demonstration area behind the house. It would be in a building with an area to shoe horses also. He has asked the SCABA to help with this project. The Blacksmith shop will be in an 1870 to 1890 time period. It would be great if some of you smiths who have built some shops in that era could come and give some advice and share the day with us.

Mike McCartney has invited us to set up and demo. He is allowing us to sell any thing we have made. He is having the Osage Tribe to supply our lunch and it will be true Osage Indian food. Because of this, it would be nice if I could give him a close guess as to how many people might show. It doesn't have to be a close count but would help. If you are planning to attend and can contact me at (home) 918.534.0299 or (cell) 918.440.0653 or E-mail me at [ddcowart@gmail.com](mailto:ddcowart@gmail.com) I would appreciate it.

**"The Bronze Horse"** owner John Free Jr. has agreed to give some tours during our meeting. They make bronze statues and I have toured their facilities twice and it is real fascinating to see what they do. **This is part of an article taken off the internet:** *'The Bronze Horse, Pawhuska, Okla., a metal casting facility that specializes in sculptures, has been chosen to assist in the production of "The American,"--a cast bronze statue that will eclipse the Statue of Liberty as the largest in the world'*.

Danny Cowart



# Home Sweet Home

Pawhuska Chamber Offices in historic blacksmith's house

By Bill Waller

"Historical tourism" is the horse to which the Pawhuska Chamber of Commerce has hitched its campaign to put the tradition-rich city back on track after some years of economic malaise.

So what could be more fitting than having the home of the Chamber of Commerce ranking right near the top of "things you really ought to see"?

Pawhuska Chamber has chosen to office in what is arguably the oldest building in North Central Oklahoma—certainly the oldest in the city—known to most who are aware of its past as "the blacksmith's house."

Fixed firmly in the footprint onto which it was set in 1872 (some say "1871," but they are in the minority), the solid little stone building is literally the starting point around which Pawhuska was built, and it has been an impassive witness to the rambunctious history of this region for almost 140 years.

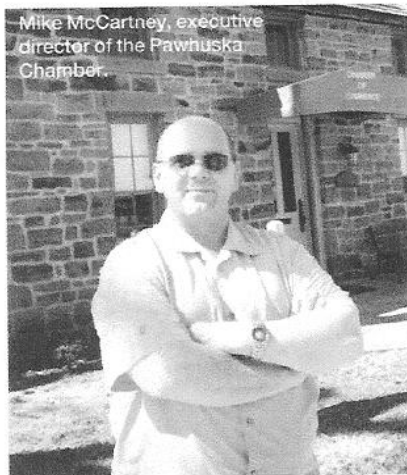
Like much of what has happened in this section of the state, the story of "the blacksmith's house" is associated with the coming-and-going fortunes of the Osage Indian Tribe.

History traces how, early into the 19<sup>th</sup> century, the Osage Tribe numbered 18,000 to 20,000 members as a dominant presence in an expansive area west of the Mississippi River, but had been reduced to only about 2,000 members in 1872 when they moved from a reservation in Kansas to their current reservation, selfsame with what is now Osage County.

As part of that final relocation the ready availability of a trusted blacksmith was high on the list of needs for the traditionally horse-reliant Osages, and they prevailed on Sid Delarue, a blacksmith of Swiss provenance, to make the move to the new territory with them. But as the story goes, his acceptance of the offer came only upon receiving unequivocal assurance that his would be the first house built by the tribe in its new homeland.

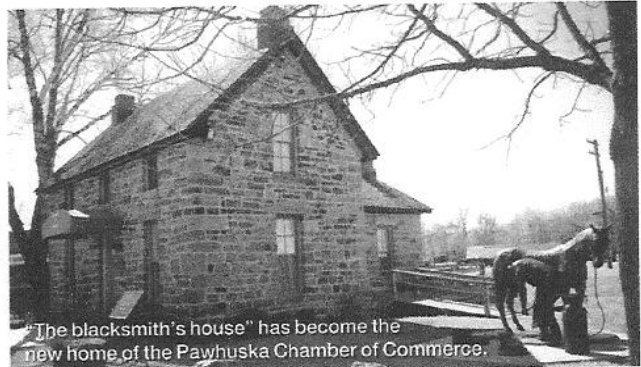
The consequence of that compact is the blacksmith's house - now occupied by the Pawhuska Chamber of Commerce - at 210 West Main Street. In 1979 it was listed in the National Register of Historic Places.

Mike McCartney, executive director of the Pawhuska Chamber, could not be happier with the office arrangement. He points out the building's eye-catching presence and the fact that it is located at the center of downtown Pawhuska fronting squarely on Main Street.



Mike McCartney, executive director of the Pawhuska Chamber.

"We're right next door to the Osage Tribe's tourism department," he points out, "and we have several programs working with the tribe." The tribal building also houses a gift shop



and the Osage language school. The chamber and the tribe share a large parking lot.

Early changes in ownership of the building are uncertain, but its re-emergence as a place of significance occurred in 1976 when the First National Bank of Pawhuska purchased it upon the death of Virgie Stuart, who had lived there several years, to assure its preservation. The bank donated it to the Pawhuska Community Foundation, and the Chamber bought the building from the Foundation in 2005.

The Chamber's modernization of the structure has not to any extent altered the building's exterior appearance, and considering that it is built of 18-inch thick native sandstone, that is understandable.

A structural evaluation of the building conducted by Bartlesville architect-engineer Fred George observed that the interior had been heavily damaged by at least one fire (in 1973) and perhaps earlier ones, but the exterior remained unchanged. At some time in its life—possibly as early as 1908, according to one report—a wood frame addition was built onto the southwest corner to accommodate a bathroom and provide more living space, but it has been removed.

Once inside the building one must be reminded that he or she is surrounded by nearly a century-and-a-half of history. The offices occupied by McCartney and Chamber Coordinator Barbara Smith are pleasantly decorated and furnished, and comfortable. A kitchen/office equipment room and a newly created bathroom share the ground floor with them.

The upstairs area was opened up to provide conference space. Some immediately recognizable positives of the new Chamber office are its distinctive appearance, the unrestricted openness of its grounds, and its accessibility.

McCartney, though not long in his role as executive director, is a native Pawhuskan, and was a member and an active participant in the Chamber's work long before assuming its professional leadership.

It is apparent that he sees the return of the Chamber to the city's virtual roots—the first building in the community—as a symbolic initial step in the process of selling Pawhuska's world-class attractions, like the story of the Osage Tribe, and the Tall Grass Prairie Preserve, along with the community's unique role in history, to an expanding market of visitors and potential new businesses. **B**

## 12th Annual Saltfork Craftsmen ABA Conference

You should receive a brochure in the mail but here is the basic information.

The conference will be held on October 18-19 at the Noble County Fairgrounds in Perry, Okla. The demonstrators will be Bob Alexander, who specializes in colonial lighting and traditional hardware. He also does flowers. The second demonstrator is Allison Finn.

The cost for the conference is \$55.00 for Sat. and Sun. (per family)

\$35.00 for Sat. only

\$35.00 for Sun. only

\$6.50 for Sat. Lunch (per person)

\$10.00 for Sat. supper (per person)

\$7.25 for Sun. lunch (per person)

Family classes extra

Hotel rooms will be in short supply because of other activities going on around the area. It is suggested that you book a room ASAP.

- American Inn & Suites 580-336-2218
- Sooners Corner Motel & RV Park 580-336-2323
- Dan-D Motel 580-336-4463
- Regency Inn 580-336-2277
- Super 8 Motel 580-336-1600
- Tetik's Country Barn Bed & Breakfast 580-336-4996

\* There is ample room at the fair grounds for RV parking, there are no hook ups. (Dry camping only) The arena can be left unlocked for availability of the restrooms.

### Conference Schedule

- Friday, October 17th

Set up will start approximately 8:00 a.m. Everyone's help is appreciated. If you can, please come to the fair grounds ready to help unload equipment and get things set up.

- Saturday, October 18th

Registration opens at 8:00 a. m. *Please register early by mail.*

Demonstrations 8-noon

Lunch break noon-1:00 p.m.

Demonstrations 1-5:00 p.m.

Dinner 6:00 p.m.

Drawing for tool box 7:00 p.m.

Auction 7:00 p.m.

- Sunday, October 19th

Registration opens 8:00 a.m.

Demonstrations 8:00-noon

Lunch Break noon-1:00 p.m.

Demonstrations 1:10-4:00p.m.

Cleanup and teardown 4:00 p.m.

**Don't forget to bring an item for the auction and bring your work to show off in the Gallery.**

# 12th Annual Saltfork Craftsmen Blacksmithing Conference

## Registration

October 18 & 19, 2008

PLEASE PRINT CLEARLY

NAME: \_\_\_\_\_ SPOUSE NAME: \_\_\_\_\_

ADDRESS: \_\_\_\_\_  
 \_\_\_\_\_

PHONE: \_\_\_\_\_

E-Mail: \_\_\_\_\_

Conference Registration Fee (One per family). Membership required for attendance. Charge for non-members is \$10 for membership until March 31, 2008.			
	Number	Cost Each	Total
Saturday & Sunday (per family)		\$55.00	
Saturday only (per family)		\$35.00	
Sunday only (per family)		\$35.00	
Membership until 3-31-08 for Non-Members		\$10.00	
<b>Meals</b>			
Saturday Lunch (per person)		\$6.25	
Saturday Supper (per person)		\$10.00	
Sunday Lunch (per person)		\$7.25	
<b>Family Classes</b>			
Advanced Scrapbooking (Sherill Carothers)		\$10.00	
Decorative Bulletin Board (Diana Davis)		\$5.00	
Build a multi-string necklace (Teresa Gabrish)		\$20.00	
Bookbinding with Hand Made Paper (Diana Davis)		\$10.00	
<b>Total Payment Enclosed</b>			

Only one Registration Fee required per family. (All meals and all material costs for Family Classes must be paid). Saltfork Craftsmen T-shirts will be available at the conference for \$15.00.

Payment Method (Check one):  Check  Money Order

Make checks payable to **Saltfork Craftsmen ABA**.

**Mail this form with full payment to:** Teresa Dyer  
 1119 S. Birmingham Pl.  
 Tulsa, OK 74104

All adults attending the conference must sign this Disclaimer. Parent or legal guardian must sign for minor children.

**Disclaimer:** I understand that blacksmithing can be a dangerous endeavor. I understand that my safety is my responsibility. I understand the need for eye and ear protection; I will provide and utilize the necessary safety equipment for all activities. The Saltfork Craftsmen ABA, its officers and members are not responsible for my well-being. Registration for the Conference indicates my agreement to these terms.

Signed: \_\_\_\_\_

Date: \_\_\_\_\_

Signed: \_\_\_\_\_

Date: \_\_\_\_\_

Signed: \_\_\_\_\_

Date: \_\_\_\_\_

## Bray Church Group Demo

By Gerald Franklin

On Thursday, July 24th, I demonstrated for a group of Vacation Bible School students and teachers from the Eastside Baptist Church in Bray, OK. I was invited to demonstrate by Orvel Robinson of Marlow and the event was held at Orvel's old West style town that he calls "Snake River Junction". The site is located a couple of miles east of Bray. Orvel really went all out to put together a great program for the students and teachers. There were gunfighters, frontier weddings in the church, and of course, a blacksmith.

I was set up in the blacksmith shop where I used the brick forge that I built for the town a couple of years ago. The forge had been moved from the building where I had originally built it and the new building has a much taller roof so the forge doesn't draw as well as it did in the other building. We'll have to extend the chimney higher to make it work better with the taller roof.

Since the time was short, and attention spans even shorter, I concentrated on nail making. As the kids cycled through, I was able to give them a short talk on the history of nail making and talked about some of the reasons for making the nails square instead of the more modern round design. To break things up a little, I forged a couple of leaves on some 3/8" round scraps just to show them how the hot metal can be shaped like clay.

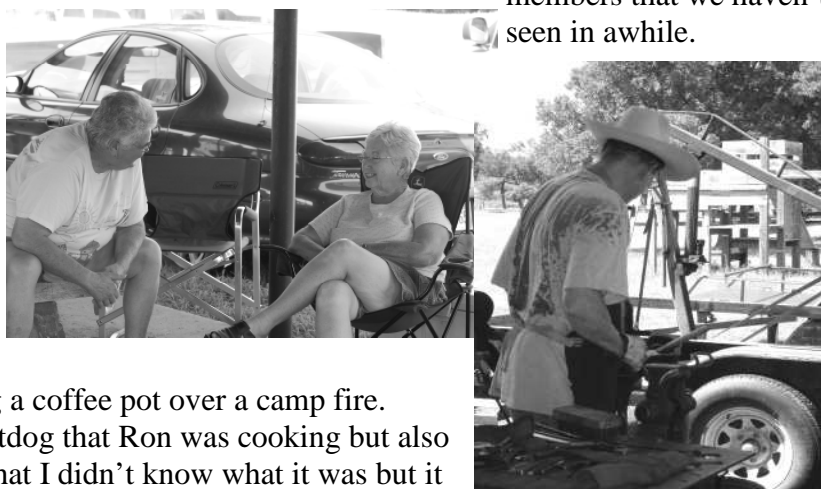
There will be several opportunities to demonstrate at "Snake River Junction" throughout next year so I may be contacting you to offer you the opportunity to come help.

### Northwest Regional meeting

Ron Lehenbauer did another great job at organizing the NW regional picnic. It was almost hot enough that he didn't need the nice cooker/smoker that he used to cook up the hamburgers and hotdogs that we had for lunch.

Gerald Franklin, Bill D and I (Diana) headed out about 7:00 am for the Saltfork Reservoir where the picnic was to take place. This Reservoir is located north of Jet, Okla. and is about a 3 1/2 hour drive for us. Richard and Teresa Dyer were also present and it was nice to get to visit with them. There were about 20 members that can out in the heat to attend the picnic which was organized to honor Ruth Burns. Ruth Burns, along with her husband, was one of the original founding members. Ruth passed away earlier this year.

There was a really nice display showing photos of John and Ruth's life. It was a good day to just sit and enjoy visiting with members that we haven't seen in awhile.



Jim Carothers was the only one tough enough to try any forging. He made a hook for holding a coffee pot over a camp fire.

Lunch included the hamburgers and hotdog that Ron was cooking but also potato salad and cucumbers and another dish that I didn't know what it was but it was good. We had plenty of deserts to finish it all off.

*More pictures on page 18*

# Steer head horse shoe

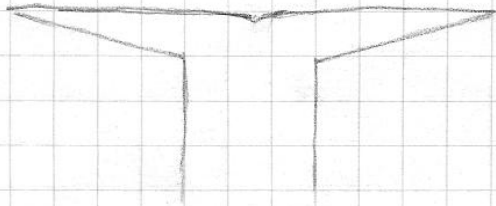
By Bill Epps

Start with 14 inches of  $\frac{1}{4} \times \frac{3}{4}$  flat

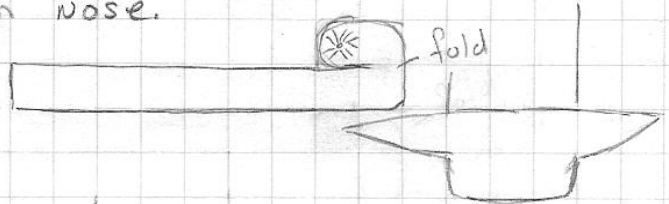


Cut a slit down the middle about 1" long.

Bring the split end up to a good heat and open them up and start drawing them each out to form your steer's horns. Continue until you have a nice set of horns

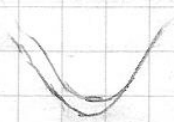


Reheat and fold back onto itself as close as possible to the horns. This fold is enough material to form nose.

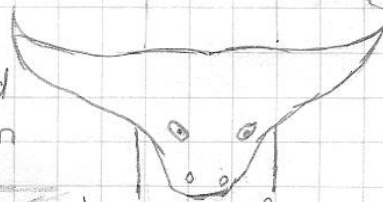


Reheat (Do not burn horns) form a blunt taper for nose.

for

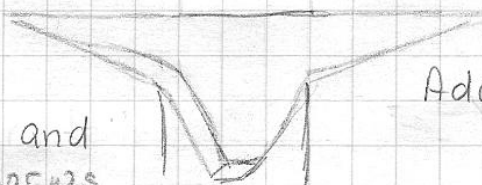


now heat and fold so head points down

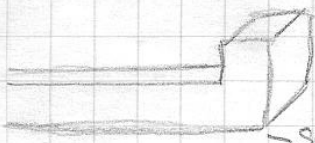


length of material - Add eyes and nostrils.

Carefully heat and give your horns some character by curling them up.



on the rest of the material you are going to form a horse-shoe. first heat up the end and turn up about  $\frac{1}{2}$ ". reheat and drive this down enough to form a square corner.

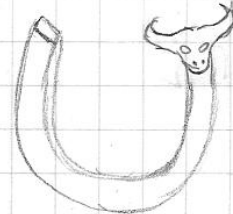
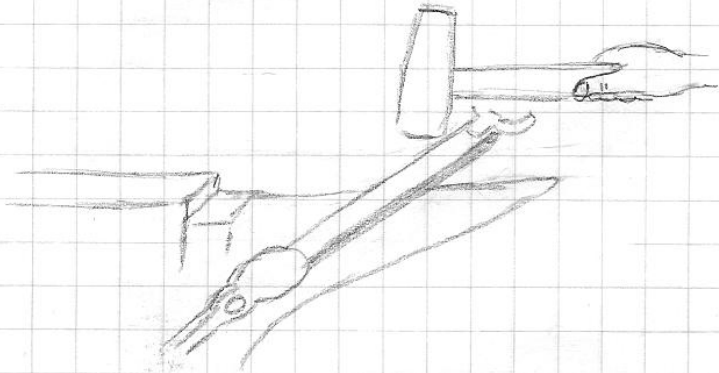


-square corner

now you have a steer head on one end and a "heel calk" on the other end of your material.

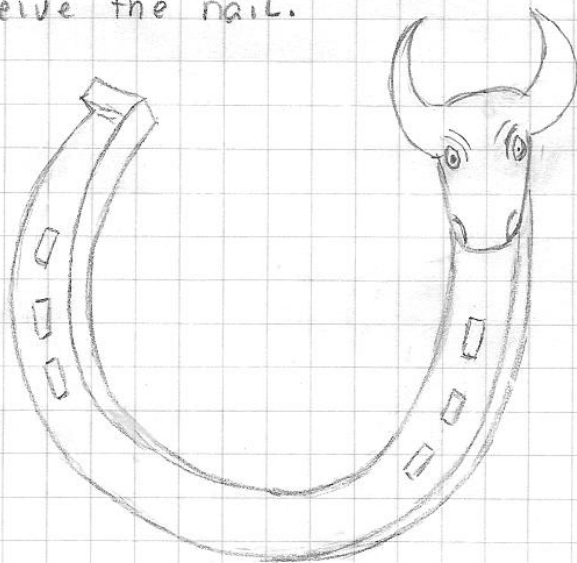
To form the curve of your horse shoe. Take a good heat. Hold onto the "heel calk" and being careful to protect your steers head - bend the metal into a U shape.

horse shoes end and curled in a little



this is what you should now have.

To finish your shoe it need 6 rectangle holes, 3 on each side. To do this you will need a fore punch, which is a blunt, heavy punch to form seat for head of the nail. And a Pritchell punch which finishes up the hole to receive the nail.



## NORTH EAST REGIONAL MEETING DATES

January 12, 2008  
Host: Bill Kendall 918-691-2173

February 9, 2008  
Host: Gary Gloden Letter opener 918-321-5015

March 8, 2008  
Host: Dan Cowart 918-534-0299  
Trade item something for the grill  
Lunch:

April 12, 2008  
Host: Mark Coatney  
Phone #: 918-476-6755

May 10, 2008  
Host: *State meeting*  
Phone #:

June 14, 2008  
Host: Charlie McGee  
Phone #:918-643-3299  
Trade item: hat rack (wall or floor)

July 12, 2008  
Host: Dwayne Moss  
Phone #:918-260-3267

August 9, 2008  
Host: Omar Reed  
Phone# (918)478-4088

Sept. 13, 2008  
Host: Dan Cowart  
Phone #:918-534-0299  
Trade item is a tool to be added to the tool box

October 11, 2008  
Host:  
Phone #:

November 8, 2008  
Host: Mike Sweany  
Phone #: 918-245-8460

December 13, 2008  
Host: **Charlie McGee**  
Phone #: 918-245-7279

## NORTH WEST REGIONAL MEETING DATES

January 26, 2008  
Host: Ron Lehenbauer :(580)758-1126  
Trade item: spoon

February 23, 2008  
Host: Ron Lehenbauer (580)758-1126  
Trade item: fork

March 22, 2008  
Host: Bob Kennemer (tool for cooking on a grill)  
Phone #: 580-225-3361

April 26, 2008  
Host: Mike George (pair of small Shelf brackets)  
Phone #: 580-327-5235

May 2008  
Host: State meeting –No regional meetings  
Phone #:

June 28, 2008  
Host: Charlie Todd  
Phone #:580-242-0105

July 26, 2008  
Host: Ron Lehenbauer  
Phone #: 580-758-1126

August 23, 2008  
Host:  
Phone #:

Sept. 27, 2008  
Host:  
Phone #:

October 25, 2008  
Host:  
Phone#

November 22, 2008  
Host: Tom Nelson  
Phone #: 580-862-7691

December 27, 2008  
Host:  
Phone #:

## SOUTH CENTRAL REGIONAL MEETING DATES

January 19, 2008  
Host: JC Banks  
Phone #(580)482-3209  
Scroll jig workshop

February 16, 2008  
Host: Gerald Franklin  
Phone #: 580-467-8667  
Scroll ends workshop

March 15, 2008  
Host: Byron Donor  
Phone #(405)650-7520

April 19, 2008  
Host: Terry Jenkins  
Phone #(580)485-2394

May 2008  
Host: State meeting no regional meetings  
Phone #:

June 21, 2008  
Host: Larry Morefield  
Phone #: 580-529-3081  
Trade item: Punch or Chisel

July 19, 2008  
Host: Max Scudder  
Phone #: 580-654-2229  
Trade items is a wall hanging

August 16, 2008  
Host: Richard Simpson  
Phone #: 405-344-7413

Sept. 20, 2008  
Host: Terry Jenkins (Sulphur Tractor Show)  
Phone #: 405-485-2394

October 18, 2008  
Host: : SCABA Conference Perry, Okla.

November 15, 2008  
Host: Bill and Diana Davis  
Phone #: 580-549-6824

December 20, 2008  
Host: Aniela Hadick  
Phone #:405-869-2043  
Trade item: some kind of vessel

## SOUTH EAST REGIONAL MEETING DATES

January 5, 2008  
Host: Bois D'Arc Forge  
Phone #:

February 2, 2008  
Host:  
Phone #:

March 1, 2008  
Host: Gerald Franklin Durant Stockyards  
Phone #: 580-467-8667

April 5, 2008  
Host:  
Phone #:

May 2008  
Host: State meeting in Norman Ok  
Phone #:May 10 ..Info in newsletter

June 7, 2008  
Host:  
Phone #:

July 5, 2008  
Host:  
Phone #:

August 2, 2008  
Host:  
Phone #:

Sept. 6, 2008  
Host:  
Phone

October 4, 2008  
Host:  
Phone #:

November 1, 2008  
Host:  
Phone #:

December 6, 2008  
Host:  
Phone #:



SCABA TOOL BOX AND TOOLS for 2008

Tool/Item	Maker/Buyer	Cost/Value
Box	Adam Hall	\$300
Hardware for toolbox	Mike George	
Cross peen hammer		
Straight peen hammer		
Rounding hammer	Bill Davis	
Tongs:		
¼ v-bit		
3/8 v-bit		
½ v-bit		
¾ v-bit		
¼ flat		
3/8 flat		
½ flat		
¾ flat		
Scrolling		
Side grip		
Pick up tongs	Maurice Hamburger	\$45
Fire tools (Shovel, rake, poker)	Mark Carter	\$75
Hot cut hardie		
Cold cut hardie	Tommy Dean	\$25
Twisting wrench		
Treadle/Hand Hammer Tooling	JC Banks	\$200
Set of punches and holder		
Center punch		
Chisel, large		
Chisel, small		
Chisel, hot slit	JC Banks	\$25
Slitting chisel		
Hold Down		
Flat wire brush w/handle	Tommy Dean	\$30
File, flat bastard cut w/handle		
File, half round w/handle		
Set of monkey tools		
Rivet backing tool		
Rivet setting tool		
Hacksaw	Maurice Hamburger	\$100
Bolster plate		
Square	Maurice Hamburger	\$35
Dividers/Compass	Maurice Hamburger	\$75
Scribe	Bill Kendall	\$30
Bending forks	JC Banks	\$50

Spring swage (necking down)		
Flux spoon	Diana Davis	
Metal folding ruler 24" or 72"		
Soapstone	Diana Davis	
Ball tool (round blunt nose punch)		
Hook Ruler	Gerald Franklin	\$30
Iron Mountain Flux	Diana Davis	\$22
Finishing Wax	Diana Davis	
Nail Header		
Dual Caliper	David Seigrist	\$35
Total value to date:		\$ 1,077

### New feature on the web site....

With the sales of the swage blocks and the membership applications available on the web site the club has made every effort to made the exchange of funds as easy as possible. With this in mind the club has set up a PayPal account for the purchase of swage blocks. You could probably also use it to renew your memberships and also pay for the conference. This would allow you to pay for these items with your credit card. You will need to set up a PayPal account for yourself in order to use this feature.

The information you will need to pay by PayPal is Mike George's email address. You can find this in the front of any newsletter. You will also need to send an email to Mike telling him that you are paying using the PayPal account and what you are paying for. Be advised that it takes a few days for the money to be deposited in the club account so shipping will not be done until the money is deposited. There is a place on the PayPal payment form to add a message or shipping instructions. Make sure you give a good address for what ever you are paying for. Examples: UPS cannot deliver to a P.O. box.

WARNING, once you set up a PayPal account you may start receiving emails that tell you there is a problem with your account and are supposed to be from PayPal. **NEVER go to your PayPal account by clicking on a link in an email.** Always type in the address or go to your favorites to access your account. PayPal does not send out email that will ask for any personal information or you password or username. These email are trying to get a hold of your banking information for fraudulent reasons. If you follow this advice you should not have any problems with a PayPal account. I use mine for the sale of round nosed pliers or broom tying. I have not had any problems with the account. But I do DELETE WITHOUT OPENING a lot of emails, supposedly from PayPal.

*Continued from page 12..*



### More scenes from the NW Picnic.





Directions To Richard Simpson - From 38 and 76 junction:  
 go South  $4\frac{1}{8}$  miles (190th) turn and go 1 mile west -  
 Turn North (Right) about 200 yards turn into 1st drive  
 on East Side of Road - Watch for Signs - House has  
 a Cow skull with "19046" Painted on it.  
 Call Richard if you get lost. 405-344-7413



Thank  
You

TO ALL THE SALT FORK CRAFTSMEN,  
THANK YOU SO VERY MUCH FOR THE  
CARD AND PRAYERS. THEY BROUGHT ME  
GREAT COMFORT.

SINCERELY,  
ROBIN SAIN

# Forge Welding

By Dan Nauman

Illustrations by Tom Latané

Photos by Dan Nauman

Lesson Number 10- Forge Welding

*Definition:*

Fusing two or more bars together by bringing them to a high heat in a forge, and applying pressure to the area being fused by hammer blows.

*Lesson:* Upsetting, scarfing (see \*Definitions, below), and forge welding the ends of two bars of equal size together to make one bar.

*Intent:* The smith will learn the technique of welding two bars of equal size together, accurately maintaining the original stock size and shape after welding.

*Materials:* Two 15" bars of 1/2" square mild steel.

*Tools needed:* Basic tools include standard cross peen hammer and anvil. Flux (see \*Definitions, below), either borax or EZ Weld. Calipers and a square can be used to evaluate your work.

*Method:*

Forge welding is used in several circumstances: to produce a smooth transition of adjoining elements; to secure several elements into a bundle (i.e. leaves, grapes, acorns, basket twist); to join a bundle to another element; to close the ends of a single bar shaped in a ring, oval, or rectangular shape (as in a frame); to join mild steel to high carbon steel (as in an ax bit); or to laminate several bars together to form a billet (as in Damascus laminate).



*A forge welded sample from Cyril Colnik*

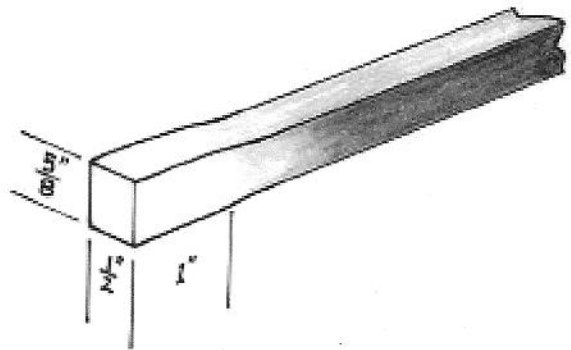
*Definitions:*

- 1.) **Scarf (scarfing):** Preparation or preparing a portion, often the end of a bar for welding by tapering to a thin edge which can be blended into the mating material.
- 2.) **Flux:** The product applied to the areas to be fused to reduce oxidation, and lower the melting temperature of the scale. (Examples: borax, EZ weld, etc.)
- 3.) **Clinker:** The hard, gritty, often glassy mass that congeals in the bottom of the fire-pit.
- 4.) **Coke:** Soft coal that has had the bulk of its impurities burned out. Coke's appearance is puffy. As good quality soft coal burns, it expands and congeals to the neighboring coal nugget forming a larger mass. Almost entirely carbon in its makeup.

*Note:* Just as there are different approaches to other aspects of forging, the same is true for forge welding. It cannot be said that any one way is best, as there are many experienced smiths who produce consistently sound welds in a different manner than explained here. Different scarf forms, different fluxes, and several other aspects of forge welding can be learned and utilized. To introduce these differences in this lesson would prove confusing to the student. Thus, this lesson will concentrate on the method taught to me in the 1970's. Differences aside, the fundamentals usually prove to be similar or identical.

In all cases, a high heat is needed at the point of fusion to successfully weld the bars together. The color of the bars should be yellow to yellow/white when removed from the fire. The only exception to this would be when welding high carbon steel to mild steel. A lower heat of orange/yellow should be the highest heat applied so as not to burn the carbon out of the carbon steel.

The gray scale that forms on a bar when heated is the enemy of the forge weld. The bars will not fuse properly when scale is present. Scale forms on the outside of the bar in the presence of oxygen. Flux forms a barrier around the areas to be fused, protecting it from oxidation. It is applied to the bars at an orange heat. Flux is not glue, or a bonding agent, rather it lowers the melting temperature of this scale, and prevents more scale from forming while heating in the fire. Some smiths theorize that to



*Figure 1: Upset end preparation*

## CONTROLLED HAND FORGING

some degree flux also raises the burning temperature of the metal.

Another important aspect of welding is to be absolutely sure you have a "clean," domed fire. A clean fire is free of a clinker in the fire-pit, and has no fresh coal burning in the center of the fire. A good welding fire also has an abundance of coke domed and banked in the fire-pit. Should the fire "hollow out" while heating the bars, only coke should be added to the fire to replenish the fuel. Fresh coal cools the fire, and also introduces impurities naturally found in coal. These impurities are largely burned out as the coal becomes coke.

When taking a welding heat, a good deep fire with the bar in the center of the fire under a good two or so inches of coke will reduce (but not eliminate) the amount of scale which forms on the bar during heating.

### Step One—Preparing the scarf:

Taking a short high (yellow) heat on the last 1" of the bar. Then upset about 1" of the end of the bar so that the bar measures at least  $9/16$ " square. (See previous lesson Number 7) Next, forge one dimension back to  $1/2$ " producing a cross section measuring  $1/2$ " x  $5/8$ ".

### Step Two:

Take another yellow heat on the end of the bar, again on the last 1" of the bar, place the end of the bar (with the  $5/8$ " sides vertical) squarely on the anvil's face with the end of the bar  $1/4$ " from the inside edge of the anvil. The edge of the anvil should be somewhat sharp for this step. Hitting straight down with the hammer's face halfway above the anvil face and halfway beyond the anvil face (Figure 2, photo), reduce the cross section to about  $1/2$  the thickness of the material, in this case to  $5/16$ ".

Tip: In order to create a clean shoulder in this operation, put a slight downward pressure on the bar so the bar stays where you put it. Then after the first or second blow add a slight forward pressure to keep the bar from "stepping" off the anvil.

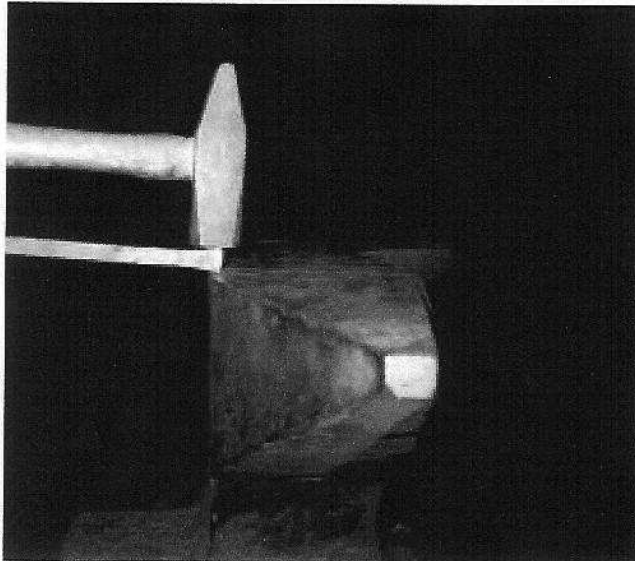


Figure 2: A half-face blow

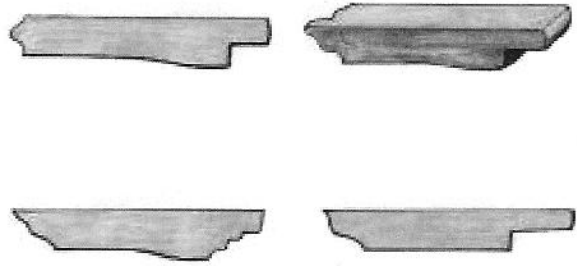


Figure 3: Above, correct. Below, incorrect. Left—initial shoulder backed off anvil too soon. Right—no upset remains for scarf to be laid upon during weld.

### Step Three:

The forging dynamics of the material will cause the area of the bar on top of the anvil to slightly spread wider than desired. In the same heat from step two, turn the bar 90 degrees, and forge this area back down to  $1/2$ " in thickness.

### Step Four:

Take another yellow heat on the last inch of the bar. Place the shoulder produced on a sharp edge of the anvil, pressing the shoulder squarely against the side of the anvil. The hand the bar is holding should be lowered slightly so the face of the scarf is off the anvil face. (Figure 4, photo). Move the hand holding the bar to the left of square, and take a blow. Moving the bar back and forth at a 90 degree angle (right to left), and using each step produced by the previous blow to brace against the side of the anvil, slowly step the bar off the anvil. (Figure 5, photos). In this same process, the profile of the bar should be drawn out to a flat point. (Figure 6, photo). If done correctly, the face of the scarf should have steps as shown in the figure 7 below. When the scarf

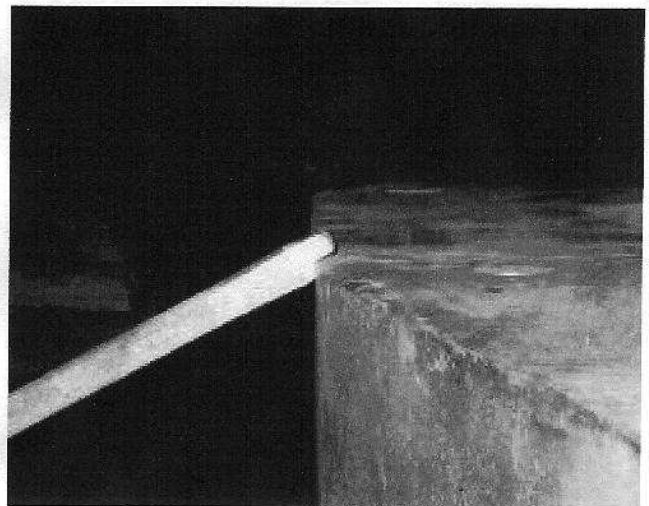


Figure 4

## CONTROLLED HAND FORGING

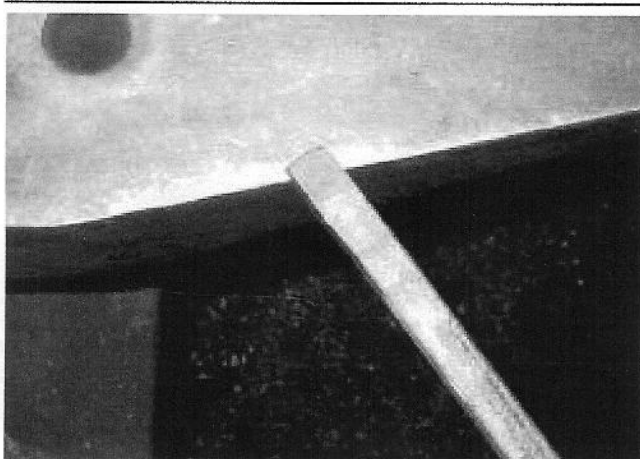


Figure 5



Figure 6

is drawn out, forge a slight curve at the end of the scarf. (Figure 7) You should be able to do all of step four in one heat.

### Notes on scarves:

The reason for the curve at the end of the scarf is simple. The anvil acts as a heat sink when hot metal is applied to it. If the end of the scarf is not off the anvil when welding, it might cool too rapidly, and the weld will not be properly fused in this area. The curve keeps the thin edge of the scarf off the anvil before the first blow, retaining the heat longer to produce a sound weld.

The thin tapered edge of the scarf is formed to produce a smooth weld joint. A scarf with a thick edge will produce a weld with a very visible seam (Drawing, figure 8).

### Step Five:

Repeat steps One through Four on the second bar.

### Step Six: Fluxing the scarves.

**SAFETY!** - Some fluxes may emit noxious fumes when heated. Make sure your forge and building are vented properly.

Reduce the air blast in the fire if you have an electric blower. If you are manually applying the air blast, reduce the force of the blast to more of a whisper. This will reduce the chances of burn-

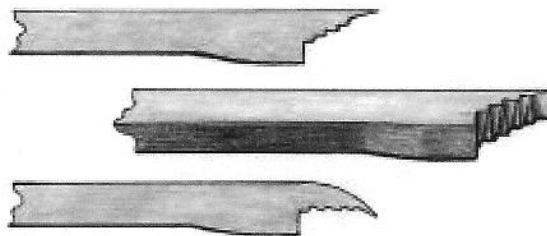


Figure 7: Top- shouldered and stepped scarf. Bottom- Curved tip. Shoulder prevents scarf from overlapping beyond upset area when scarfs are quickly placed together.

ing the scarves while fluxing by reducing the available oxygen in the fire.

Making sure you have a clean and deep fire, place the scarves into the center of the fire, face up. If the bars are not covered with coke, cover them. When the bars reach a bright orange, with the bars remaining in the fire, take your fire rake make a hole in the fire over the scarves so flux may be sprinkled on the face of the scarves. With a small spoon with a long handle (so you do not burn your hand), apply enough flux with to cover the scarf, as well as beyond the scarf where the other scarf will join. (Figure 9, drawing). Cover the bars once again with coke. When you are finished fluxing the scarves, position them so they are facing down in the fire.

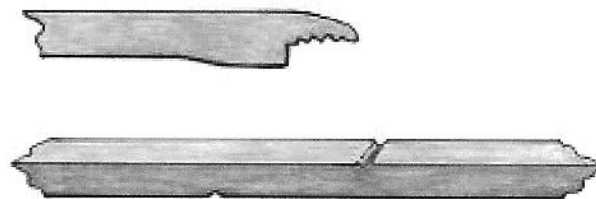


Figure 8: Blunt scarf makes seam difficult to blend

### Notes:

One of the biggest mistakes beginners make in welding is not applying the flux back far enough on the bar where the bars will be fused.

Some smiths prefer to flux all sides of the scarves, while others simply apply flux to the scarf faces. The theory behind fluxing all sides of the bar is to insure that all surfaces are free from scale, as well as to increase the burning temperature of the bar. The bar can and will burn if allowed to get to a full sparkling white heat, at which point the flux will also burn off. The bars likely will not weld at this high temperature. Also, the molecular structure of the material will break down, creating a weaker joint, and often an unsightly weld.

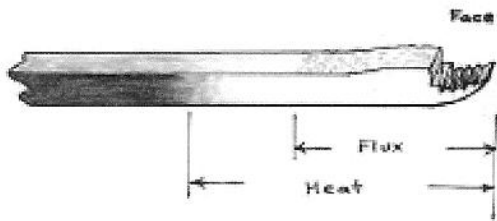


Figure 9: Fluxed face heated from below.

If you choose to flux all sides of the scarves, turn the bar 90 degrees only after you are certain the flux has adhered to the scarf surface. You will know when this happens, as the flux will be the same color as the bar. If one bar gets hotter than the other, move it to the side of the fire where the fire is cooler, or reduce the air blast further.

Fluxing the scarves in the fire keeps them hot, and reduces the amount of scale formed, therefore shortening the time it takes to produce the weld. Removing the bars from the fire to flux the scarves is not necessarily wrong, as many smiths prefer this procedure, and do so successfully. Sometimes, fluxing in the fire is virtually impossible (i.e. welding a wagon wheel tire.) In these cases, removing the bar from the fire is necessary.

Always keep coke on top of the bars when not in the act of fluxing.

*Tip:* Rub soapstone or chalk on the face side of the bar to indicate direction of the scarf face when pulling the bars from the fire.

### Step Seven: Welding the bars

Have your hammer at the anvil in a position to grab it quickly. The scarves are at a welding heat when they are at a yellow-white appearance in color (Often referred to as a "welding heat.") Make sure the scarves are heated well beyond the shoulder where the mating bar will join. Some smiths wait to see just a few sparks coming from the fire, indicating the piece is just starting to burn. This is not necessary, and can lead to burning the tips off of the scarves.

*Tip:* If you are not sure if the pieces are at a welding heat, gently

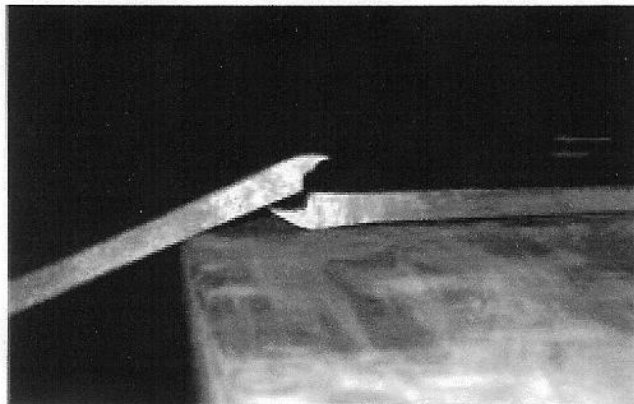
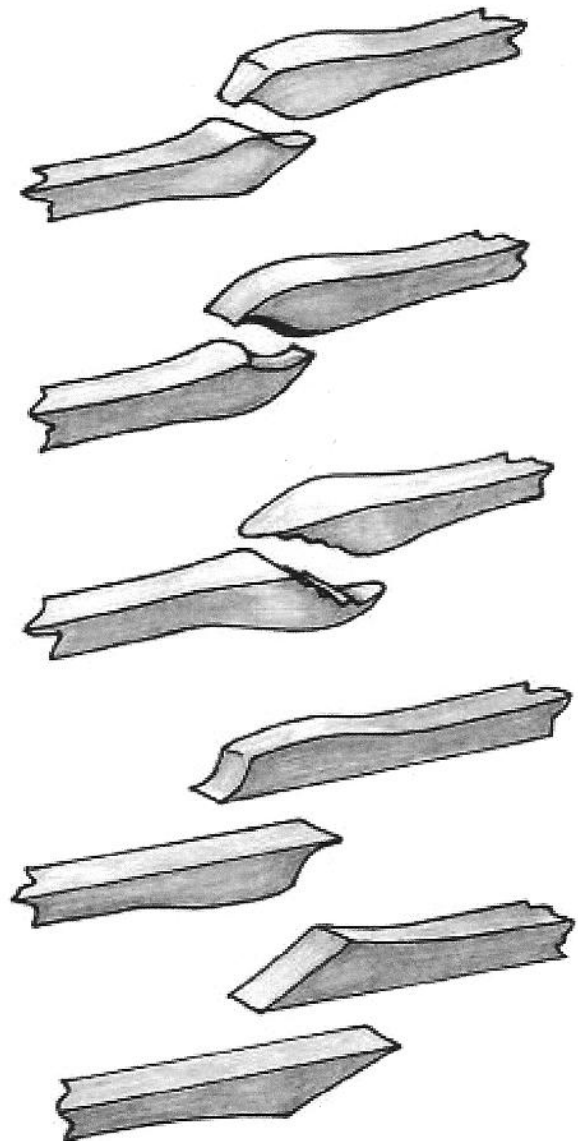


Figure 10



Some other forms of bar end scarfs. The 90° shoulder on the scarf described in the text will aid in quick alignment of bars to be welded, preventing overlap beyond upset material.

touch the pieces together in the fire. If they want to stick, almost like a magnet, they are probably ready to weld. With experience, this touching in the fire will not be necessary.

**SAFETY:** When welding, molten sparks fly from the bars which can burn others, as well as you. Alert others in the area when performing a weld, and make sure other items in the shop that are flammable are protected from the sparks. Some smiths wear a protective leather apron when welding to prevent their clothes from burning. You and anyone else present should be wearing eye protection with side shields at all times. After welding, be aware of the possibility of fire caused from stray sparks in the surrounding area i.e. shop rags, charcoal, dry wood, etc. These items and others ignite easily from molten metal



## CONTROLLED HAND FORGING

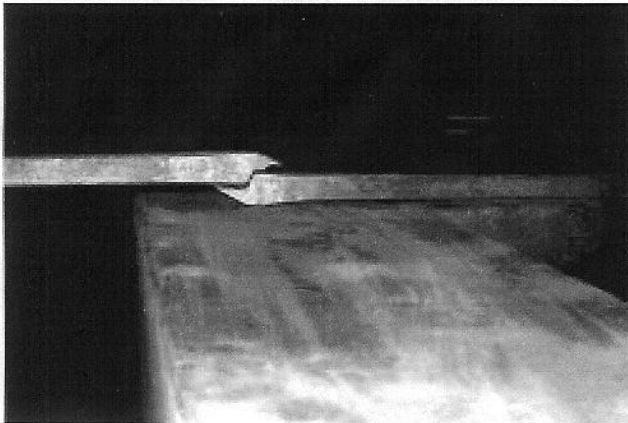


Figure 11

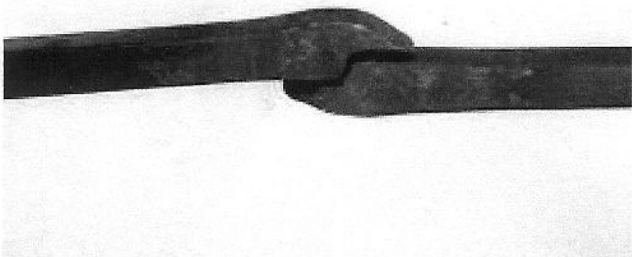


Figure 12

and flux spattered from the forge welding process.

Bring the pieces out of the fire, rotating one piece 180 degrees so that the scarf is facing up. Place the bar with the face up on the center of the face of the anvil, coming in from the far side of the anvil. (This bar should be in your hammer hand.) Place the other bar on the near edge of the anvil, with the scarf off the face, pointing up at about a 45 degree angle. (Figure 10, photo). In a hinging fashion, lower the scarf down onto the opposing scarf, keeping contact with the edge of the anvil to control the accuracy of the placement of the scarf (Figure 11, photo) and press down on the opposing scarf. The heels of the scarves should be placed together as shown. (Figure 12, photo). Press down hard enough so you can release the bar in your hammer hand.

Release the bar in your hammer hand, grab the hammer, and strike firmly in the center of the joint. Forge the entire joint rapidly with six or seven blows. Make sure you forge the thin tip of the scarf as it will cool rapidly. Next, flip the now welded bar 180 degrees to forge the opposite side. Hit six or seven blows on the entire joint and then turn the bar 90 degrees and repeat five or six more blows on the joint. Flip the bar 180 degrees and hit the joint once again five or six blows. Repeat as necessary, never forging colder than a medium orange heat.

*Note:* Dark spots on the joint indicate cooling of the material and will not weld there. This may be caused by too low of a

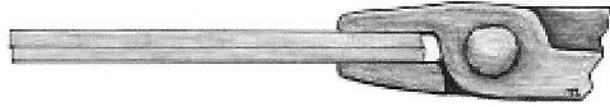


Figure 13: Bars for practice weld—no alignment of scarfs.

heat, or inadequate fluxing. These areas must be fluxed again, returned to a welding heat, and forged to fuse the joint.

While welding, keep in mind that you do not want to forge the cross section of the joint down beyond the parent stock size. Also, be careful not to forge beyond the joint as this will reduce the cross section of the bar beyond the parent stock size.

With a properly executed weld there will not be any "dark spots" or evidence of a scarf. If there is evidence that the weld is not complete, flux the open seams of the joint, and take another welding heat. Remove the bar from the fire, and forge down carefully, so as not to greatly reduce the cross section of the bar beyond the parent stock size.

*Note:* Timing is important. If you take too much time getting the pieces from the fire to the anvil, you may lose too much heat to weld the bars together. To increase your proficiency, you may want to take a few "practice runs" by removing the bars while cold from the fire pit positioning them on the anvil as described in Step Seven. Do this until you are comfortable with the procedure. You will then be able to release the bar from your hammer hand and grasp the hammer without the bar falling to the ground.

*Tips:*

-Some fluxes, such as EZ Weld brand, are very aggressive and may adhere to the metal after the weld has been completed. To remove it, take another welding heat, remove the bar from the fire, and scrub vigorously with a stiff wire brush. Flux is harder than a file, so do not try to file the flux off, as it can ruin your file.

-A lighter hammer of 1 1/2 to 2 pounds may work better than a larger hammer. With a lighter hammer, the hammer can be swung faster, and more accurately. Also, the chance of forging

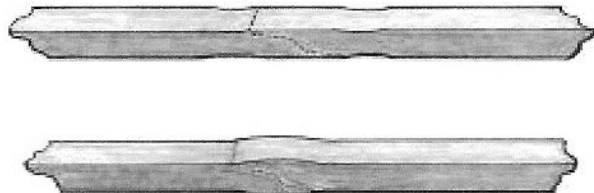


Figure 14: Top—thin areas due to loss of material from burning, too little upset, or over-hammering, must be upset. Bottom—remaining bulge must be drawn down to dimension.

## CONTROLLED HAND FORGING

down beyond parent stock size is reduced with a smaller hammer, as you will not have the heavier force of the larger hammer.

-You may want to first practice a more simple weld to get used to the properties of forge welding. The faggot weld is a simple, crude weld which has no end preparation (no scarves.) Try bending a 3/16" x 3/4" piece in half and weld the last 3/4" of the end of the bars together. (Figure 13, drawing). Be extra careful when performing this type of weld, because the larger surface area causes more molten flux and sparks to fly from the joint.

### Step Eight: Refining the weld (If necessary)

If the cross section of the joint is still larger than the parent stock size, place the bar back in the fire and bring the joint to a welding heat. Remove the bar from the fire, and carefully forge the joint back down to the parent stock size.

#### *Potential problems and solutions:*

If the weld is properly executed, the joint is invisible, the bar has no bulges or "necked in" spots, and has sharp 90 degree corners. (Figure 14, See drawing of bulge and necked in spots). To refine the bulge, proceed as described in Step Eight.

If the bar is necked in it will be more difficult to fix. The portion of the bar where it is necked in is taken to a welding heat, and then upset (refer to Lesson Seven) back to the parent stock size. A poorly executed weld will begin to come apart or fail entirely in the upsetting process.

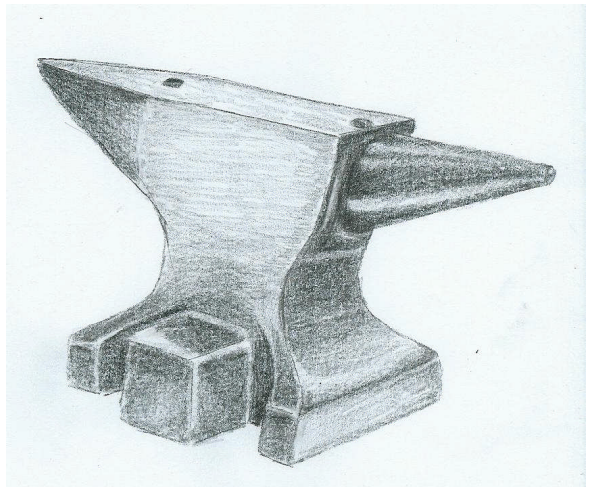
If a parallelogram was formed at the joint, first upset the joint, then take another heat and forge down the acute angles slightly. (As explained in Lesson One.) Then carefully reduce to the parent stock size.

#### *Targets.*

- The scarf is produced in one heat.
- The weld is completed in one to two heats, and the joint returned to the parent stock size.
- The joint is to be square in section with sharp corners, no necked in areas, and no bulges. You can check your accuracy with a pair of calipers. Check for squareness with a steel square.
- The welded bar is to be straight, have no twist, be free of flux residue and the bar should have no visual evidence of a seam.



*More examples of forge welding from Cyril Colnik*



# Saltfork Craftsmen

Artist-Blacksmith Association  
Membership Application  
April 2008 thru March 2009

Please accept my application

Date: \_\_\_\_\_

First Name \_\_\_\_\_ Last Name \_\_\_\_\_

Married?  Yes  No Spouses Name \_\_\_\_\_

Address \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ ZIP \_\_\_\_\_

Home Phone (\_\_\_\_) \_\_\_\_\_ Work Phone (\_\_\_\_) \_\_\_\_\_

E-Mail \_\_\_\_\_ ABANA Member?  Yes  No

I have enclosed \$20.00 for dues to March 30, 2009

Signed \_\_\_\_\_

Return to: Saltfork Craftsmen, 1227 Fourth St. Alva, Ok 73717



Name: \_\_\_\_\_

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Submit check, money order -U.S. Banks only, or by credit card:

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Saltfork Craftsmen Artist Blacksmith Assoc.Inc.  
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