

Saltfork Craftsmen Artist-Blacksmith Association

May 2013



Hunter Ogden working to pay the Kings taxes at the Norman Faire. Hunter is the son of Saltfork member Chuck Ogden. Hunter was shown some forging techniques and spent as much time as they would let him, working at the forge. He was even toasted by one of the pirates that had their ship “docked” nearby stating that he had proven his ability to pull his own weight and so was eligible to have a drink with them. He was given a large class of lemonade to drink. When finished he went back to forging.

Saltfork Craftsmen
Artist-Blacksmith Association
Officers and Directors

President/cones:
Byron Doner 405-650-7520
6520 Alameda, Norman Okla.
byrondoner@esok.us

Vice-President/events: 580-688-3555
David Seigrist
P.O. Box 163 Hollis, Ok 73550
dseigrist2004@yahoo.com

Sec-Treas. Dan Cowart 918-440-0653
10380 N. 4010 Road
Wann, Ok 74083
ddcowart@gmail.com

Director/Editor: Diana Davis 580-549-6824
23966 NE Wolf Rd.
Fletcher, Ok 73541
Diana.copperrose@gmail.com

Director/tool box tools:
Mandell Greteman 580-592-4460
Rt. 2 Box 130 Foss, Okla. 73647
mandell01@windstream.net

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

Director: Mark Carter 405-964-5754
34509 Hazel Dell Rd.
McLoud Ok. 74851
mcarteriron@gmail.com

Assignments:

Webmaster:
Dodie O'Bryan
Pawnee, Ok
scout@skally.net

Workshop Coordinator:
Tracy Cowart 918-376-2382
9911 N. 117th E. Ave.
Owasso. Ok
draftsman@cox.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.

Material from this newsletter may be freely copied without permission for non-profit purposes. Please credit the author and this publication.

Visit our Saltfork Craftsmen Website:

From the new President..

For anyone that doesn't already know our club voted in board members, and at the board meeting on Saturday April 20th, I was chosen to be your new president. As usual the person who ran slowest was caught and crowned president! I have spent most of my life fixing broken things, or running along behind the person in control doing "damage control". My point is that I am more of a reacting person and I really feel that the president should be a proactive or aggressive person. Now that I've got that off my chest, I would like to say that I will try to do a good job for the club.

Thank you all for making the picnic a fun get together. We had 68 folks according to the sign in sheet but I think there were more people than that here.

Happy hammering to all.. Byron Doner

Editors ramblings....

April is turning out to be the start of a busy forging season. It started with the Norman Faire the first weekend and will keep going with each month presenting more opportunities to demonstrate for the public. I miss not being able to go to many of the events that I have the privilege to write about in this newsletter and so really appreciate the information and pictures that are sent in by members that do attend or demonstrate. So if I haven't singled you out in a while I'm sorry but please know that I Thank you very much.

Please take a look at the meeting list and if there is a meeting in your area that needs a host, please consider hosting that meeting. You can even pair up and two of you host one together like Omar Reed and Gerald Brostek are doing in May at the Fort Gibson Historic site.

There are some upcoming events that could use demonstrators so take a look at the list and see if you can help.

Don't forget that if you have any ideas for a workshop to let Tracy Cowart know and he will try to get one organized in your area. There are a couple Beginning Blacksmithing workshops in the planning but we can use more.

Diana

May meetings...

- ◇ SE Regional meeting will be hosted by Eddie Horton at Fort Towson Historic site on May 4th. Eddie can be contacted at eddie.h3@gmail.com The trade item is a “critter cooker” Lunch is provided but help out with a side dish or desert. Mr. Wallace will be cooking in the Dutch ovens again so go by and get some pointers on how its done.
- ◇ NE regional meeting is being hosted by Omar Reed and Gerald Brostek on May 11 at the Fort Gibson Historic site. Omar can be contacted at 918-478-4088 and Gerald has an email address of...Gerald.brostek@sbcglobal.net The trade item is anything used in “Campfire Cooking”. Lunch is provided but bring a side dish or desert to help out. There is no burn ban so bring your portable forges and set up under the trees. Gerald will be demonstrating how to make a cooking tri-pod.
- ◇ SC regional meeting will be hosted by Heather Morefield at the blacksmith shop in Medicine park located on east side of water treatment plant on May 18th. Lunch will be provided but bring a side dish to help out. The trade item is a piece of “Yard Art”
- ◇ NW regional meeting will be hosted by Gary Seigrist at the Rout 66 Blacksmith Shop in Elk City (2717 W. 3rd) on May 25th. Gary can be contacted at 1-580-243-8228 Lunch is provided but bring a side dish to help out. The trade item is anything made from a horseshoe.

Elk City museum complex is located on west side of Elk City on 3rd Street.

JUNE MEETINGS...

- SE Regional meeting date is open with no host.
- NE Regional meeting will be hosted by Mike Krukoski on June 8th at 22558 E. 320 Rd in Chelsea Ok.his email address is quadkfarm@yahoo.com or call him at 636-297-0329. his trade item is a garden item. Lunch will be provided so bring a side dish to help out.
- SC regional meeting will be hosted by Larry Mills at his shop on June 15th at his shop at 3510 Charleston Rd. Trade item is any flower or plant, Lunch is being catered by Catering Creations of Norman. You might want to RSVP to help them with a count for lunch. For more information you can email Larry at l-mills@cox.net Directions: Off of Tecumseh Rd. (Approximately 2 miles E of I-35) If familiar with Norman, approximately 1 mile West of Porter on Tecumseh ..south side of Road.
- NW regional meeting will be hosted by Mandell Greteman on June 22nd at his home in Foss Okla. Trade item is anything made from a Rail Road Spike. Lunch is being provided so bring a side dish to help out. Mandel can be contacted by calling 580-515-1292. His home is 2 blocks north of Rail Road tracks, west to dead end.

Election results:

Bill Kendall, Mark Carter and Byron Doner were all elected to another term on the board. Mandell Greteman was voted in to replace Gerald Brostek, who had chosen not to run again at this time.

Bryon Doner was voted in as President by the members of the board.

Other board business:

We have a new shipment of swage blocks and even though they cost more to pour it was decided that an increase in price was not needed.

DVD from the 2012 conference will soon be available.

Next board meeting will be held in conjunction with the NW regional meeting in August. The meeting is being hosted by Cheryl Overstreet at the Historic route 66 museum and blacksmith shop.

This is our meeting to finalize details for the conference. We could use volunteers to step forward at that time and let us know where you want to help during the conference.

Any member is welcome to bring new business before the board at that time.

Mortise & Tenon Workshop

Gerald Franklin

On March 30, 2013, I conducted a Mortise & Tenon Joinery Workshop at my shop near Velma, OK. There were a total of four students in the class. Attendees were Aubrey Washington, Alvin Jeter, Doug Bliss, and Dan Richman. Since some of the students had as much as a three-hour drive to get here, so we didn't start until 9 AM. A good lunch of Miner's Stew and cornbread was provided by my wife, Frankie.

We began with a short safety talk and then we went over the design of the small (10" X 10") grille that we were going to build. The frame of the grille was made from 1/4" X 1" flat strap with 1/4" square mortise & tenon joints at the corners. The central elements consisted of a 1/2" round rod passed through a 1/2" square bar. The round and square elements were joined to the frame with 3/8" round mortise & tenon joints.

The first task was to layout all tenons and mortises on the pre-cut stiles and rails of the frame. Precision (to blacksmith tolerances, anyway) and accuracy were stressed here since small errors tend to make final assembly difficult.

We cut the tenons for the corners of the frame with either a hacksaw or a band saw. I offered the guys the opportunity to cut these tenons with a hot cut but nobody took me up on it. The mortises for the corner joints were drilled on a drill press, heated in a forge, and drifted to 1/4" square.

The 3/8" round mortises for the two interior elements were hot punched with 3/8" punches made from hay rake teeth. The 1/2" pass-through in the center of the 1/2" square bar was slot punched and drifted to 1/2" round.

The shoulders were set for the 3/8" round tenons and then they were drawn out to dimension on each end of the round and square elements. Shoulders were set using a butcher and the tenons were drawn out using dies.

The first step in the assembly phase was determining the actual length of each of the horizontal elements. The longest of the three was used to set the width of a shoulder gauge. The shorter elements were hammered cold to bring them to the length set on the gauge. Nobody had to do much cold hammering since they had taken a great deal of care in the layout phase to get shoulders marked uniformly.

Once all elements were brought to the same length, the final assembly was done by heating the tenons with an acetylene torch and setting them.

I want to thank all the participants for the effort that they put out during this workshop. Everybody worked hard and made an effort to put out a quality product.



Basic Blacksmithing Workshop

By Dan Cowart

Saltfork sponsored a Basic Blacksmithing Workshop for some of its members on March 30, 2013. Aside from the rain, it was very successful. The class was filled to the planned capacity of thirteen smiths. We had more folks who were interested in the class but we just didn't have the space or equipment for more students. We had five forges going.

The workshop was held at Persimmon Hollow 1880's town in Tulsa as guests of Mecca and Chuck Waite. Things got kicked off at 9AM with a class picture. We were doing real good until the rain started in. We had a hard down-pour for about 45 minutes to an hour. We had put up three covers that helped but no one stayed dry.

Tracy Cowart was the instructor with help from Gerald Brostek, Chuck Waite and Dan Cowart. We started out talking about safety and then we went over some basic tools and terms. Once the initial talking was over with, we got to work on S-hooks. Tracy demonstrated and then put everyone to work. Some of the students were a little more experienced and the "old hands" helped the newer smiths get several hooks forged. A lot of time was spent on fire maintenance and getting familiar with different hammer blows.

The sun came out about 10:30 and everyone steamed off and Tracy demonstrated leaves. We forged a basic leaf on the end of a piece of 5/16" round stock, veined it, and then forged out the stem into a key fob. Some of the students made several fobs, some only got through one. As with any class, there was a variety of experience and skill levels and, since it's not a race for production, everyone was allowed to move at their own pace.

After the key fobs were complete, it was time to go and get lunch. Tracy, Pat and Mecca put together beans and cornbread and other goodies. After lunch, we jumped into tool making. We talked about some of the different kinds of tool steels that smiths are likely to use. We also talked about the basics (and why's and why - nots) of heat treatment. Then it was back to the forges to try our hands at forging a hot cut chisel. Gerald Brostek forged a demo piece and then turned the students loose to forge their own chisel. This "stiffness" and overall forging difficulty of the tool steel was an eye - opener to all of the students who had spent all morning forging mild steel. Everybody got their chisel hardened and tempered to a dark straw. By then, it was time for a little break and another question and answer session as we wound down for the day.



Norman Medieval Fair 2013

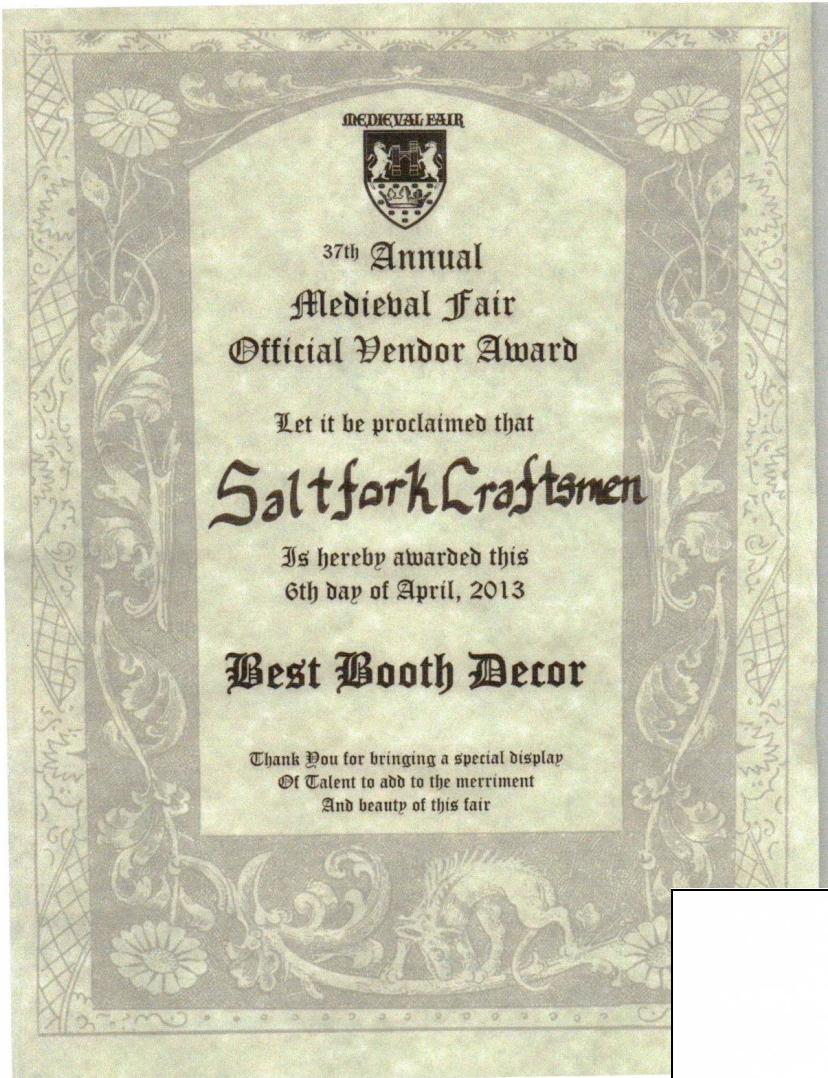
It was as if we were destined to be there. The rain stopped in time for the grounds to dry off enough to bring our vehicles right to our area. The rain stayed away throughout the fair. And in between, nearly 20 Saltfork blacksmiths stayed busy demonstrating the making of everything from tent stakes and bottle openers to roses, knives, grasshoppers and jewelry. And it wasn't as if while we were there no one noticed. We were recognized during the king's court on Saturday night and given an award for best booth décor. That doesn't mean that we had a lot of ribbons and decorations all over the place. We were given the award because, in the opinions of the fair committee, our "blacksmith village" looked more like what one would have expected to see way back in the way back when.

Most of the blacksmiths had done demos there before but, for a couple it was their first time. In the case of Ken F, he started out a little slow and unsure but it wasn't long at all before he was working metal and answering questions from the crowds as if he was an old hand at it. By the end of the fair, the general consensus was that a good time was had by all and most, if not all look forward to doing it again next year.

A special thanks goes out to Chuck Odgen, Chuck Waite, Jeff Cohen, and all of the others that helped me tear down and load up at the end of the fair. After three days of fair and three nights of little sleep, when it came time to load up, I was really dragging low. But, thanks to help from a lot of people, I was ready to roll in short time. That is one of the things that many appreciate about our fellow Saltfork members. Whether we are looking for a part for a forge, or some guidance in doing something for the first time, help is usually readily available.

Steven Knisely





MEDIEVAL FAIR



University of Oklahoma
Medieval Fair Department
1700 Asp Ave., Room 222
Norman, OK 73072

April 16, 2013

Dear Saltfork Craftsmen Artist Blacksmith Association:

I would like to thank you for your participation in this year's Medieval Fair. Your outstanding blacksmithing demonstrations added an important education component to the fair. Every time I passed your area there were large groups of people watching and listening to your blacksmiths. I know that many teachers make it a point to get their students to your area to discover the amazing knowledge and skill of your craftsmen.

Congratulations too on being recognized by the Royal Court as having the Best Booth Décor of the entire Fair. Your authenticity and crowd interaction is truly appreciated and goes above and beyond what any others present at Fair.

We appreciate your contribution in making this year's fair such a success. Our estimated attendance was 350,000-365,000. We look forward to having you participate in next year's fair. Your display and presentations just get better every year!

Sincerely,

Ann Marie Eckart

Ann Marie Eckart
Medieval Fair Coordinator

N E Regional Meeting Report

April N E Regional meeting was held on April 13th at the shop of Ironman McCormack on the outskirts of Morris, Oklahoma. I arrived about 9:30 and found several Blacksmiths standing in a circle, *(looked like a bunch of buzzards hovering over some road kill)*, they had their tongues hanging out and were drooling over a 644 lb. anvil that Ironman had just completed some minor repairs to. I joined the circle and we all examined this anvil to try and find the repairs. Ed did a fine job in repairing it. The Anvil belongs to Glen Stephens. Hearsay has it Glen found it in a garage sale in North Tulsa for \$25.00 *(although I could not confirm this rumor)*. Dan Cowart arrived and as the crowd grew, he was hobbling around passing out Saltfork applications and selling Saltfork Caps. I believe there were 4 or 5 forges going and the smell of coal smoke was like perfume floating on the spring air. The sound of metal being hammered was like listening to a symphony play.



For those who have never been to Ed's place, it's like visiting the Smithsonian Museum. If it was ever made, and if it was made of metal, Ironman has at least one. This in not to mention all the creations he has made over his many years. Folks were crawling around like a bunch of ants looking at all of Ed's collection which is spread out in his yard, house, shop, out buildings, old School site, Family Cemetery, and over an acre or more around the yard.



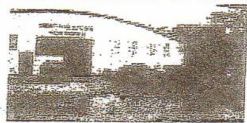
Several Saltfork members came from the Western reaches of Oklahoma, and we were all glad they made the effort to come this Far East to attend this meeting. There was camaraderie everywhere and lots of half truths and many lies being told.

At mid-day the anvils grew quiet, a prayer was said, and the chow lined formed. At this point I had to leave as I had to head for work to earn money to feed my many skinny and hungry children.



Upcoming events to keep in mind...

TIME AGAIN FOR THE



**Annual
Southwestern
Ironworks
Tailgate Swap Meet
AND
MODEL ENGINE DISPLAYS**

**SATURDAY MAY 18, 2013
8:00 AM TILL.....**

**ALL HOBBY MACHINISTS, BLACKSMITHS
AND WOODWORKERS
BRING YOUR UNWANTED
TOOLS OR EQUIPMENT
AND BUY -- SELL -- TRADE**

**302 WEST COLLEGE
Guthrie, Okla.**

**FOR MORE INFORMATION CONTACT:
DAVID KING, (405)348-0476 OR BOB PADDACK, (405)634-8353, (405)642-5243
(405) 426-0976**

**DRUMRIGHT DISCOVERY
DAYS**

**Saturday June 8, 2012
10am-3pm**

**Antique Cars, Quilt show, An-
tique tractors, Arts, Crafts and
More
Drumright Community Histori-
cal Museum
301 East Broadway
Drumright Oklahoma**



- ◆ Chisholm Trail Festival in Yukon, Ok on June 1st.
- ◆ Pawnee Bill's Wild West Show, June 15, 22, 29th 3-7pm. The Wild West organizers have invited Saltfork Craftsmen to come and use the Ranch Blacksmith shop during their annual Wild West Show to demonstrate for the public. Jim Carothers has participated in this each year so he can give you more information about what to expect. This is a great opportunity to demo for the public and then go down and watch a reenactment of Pawnee Bill's original Wild West Show. There are three Saturdays available to participate in this event. It is a small shop so space is limited. Jim Carothers (frontiershop@wildblue.net)
- ◆ Annabell's Fun Farm in Welch Okla. Owned by Tim Wright is looking for anyone interested is setting up on a weekend during their fall activities. If you are interested in participating in this fall pumpkin patch/corn maze and other family friendly activities beginning September 21 through November 3rd. Fridays Saturdays and Sundays you can view their website at www.annabellesfunfarm.com

2013 picnic

April 20th

Byron and Carol's home was once again the Place to be for the annual SCABA picnic. The weather was perfect and the turnout outstanding. I didn't get an accurate count but everywhere you looked were members and friends grouped together in conversation. I arrived about 10:00 and there was already a good crowd present. With some help I soon had my gear unloaded from my car and set up inside Byron's shop. I had come prepared to conduct a nail making contest and had headers and a couple of surprise gifts for the 1st and 2nd place winners. We finally got it started and had 6 try their hands at making nails. I think next time we will give each a warm-up session. They all seemed a bit rusty on nail making. I know I couldn't make one today to save my life so guess I shouldn't say a thing...

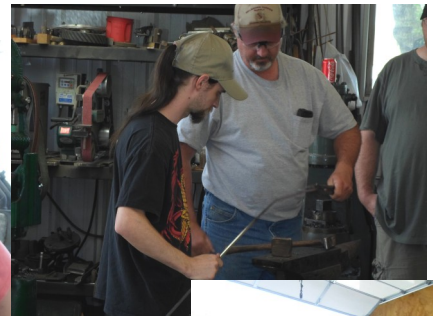
The winners of the contest was Mark Carter who took home three binders of Blacksmith Journals.

We all enjoyed a lunch of hamburgers and hotdogs cooked by Bruce Willenburg using his cooker in the back end of a Honda car. Very unique. Also enjoyed a wide variety of other foods and deserts.

We had four new members join at the picnic and another member rejoin. We want to welcome Ralph and Lisa Upchurch, Joe and Cheryl Denney, Caleb and Shayla Haden, Benjamin Hughes and welcome back Alyssa Lusk. After the nail making contest, several of our members started up the forges and soon a couple of the new guys were trying their luck at some simple forging.

Teresa Gabrish had her fold forming class set up in Carol's sewing room (a new addition to the house if you have not been there to see) and was having another informative class.

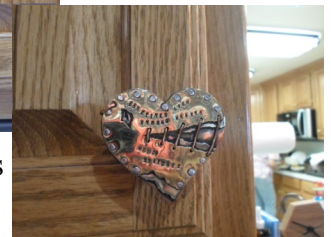
Carol had asked anyone that wanted to make her some drawer pulls for the new addition. I took some pictures of the new ones and some that Byron had already installed. They are all great.



Grapes and leaves made by Ron Lehenbauer and copper roses made by Teresa Gabrish.



She still has a lot of cabinet that need pulls and drawers also.





Charles McDevitt has created us another beautiful tool box for our annual "Tool Box Raffle" that is held at our conference in October. This box is made from Alder wood and has some nice wood burning on all four sides. We have already started to receive tools to put in it. The tickets are on sale now @ 2.00 each. I will be mailing out tickets to each of the members of the board and anyone that has a meeting coming up can request some be sent to them for sales at their meeting. Please give me 30 days notice (if possible) to get you tickets for sales at your meeting.



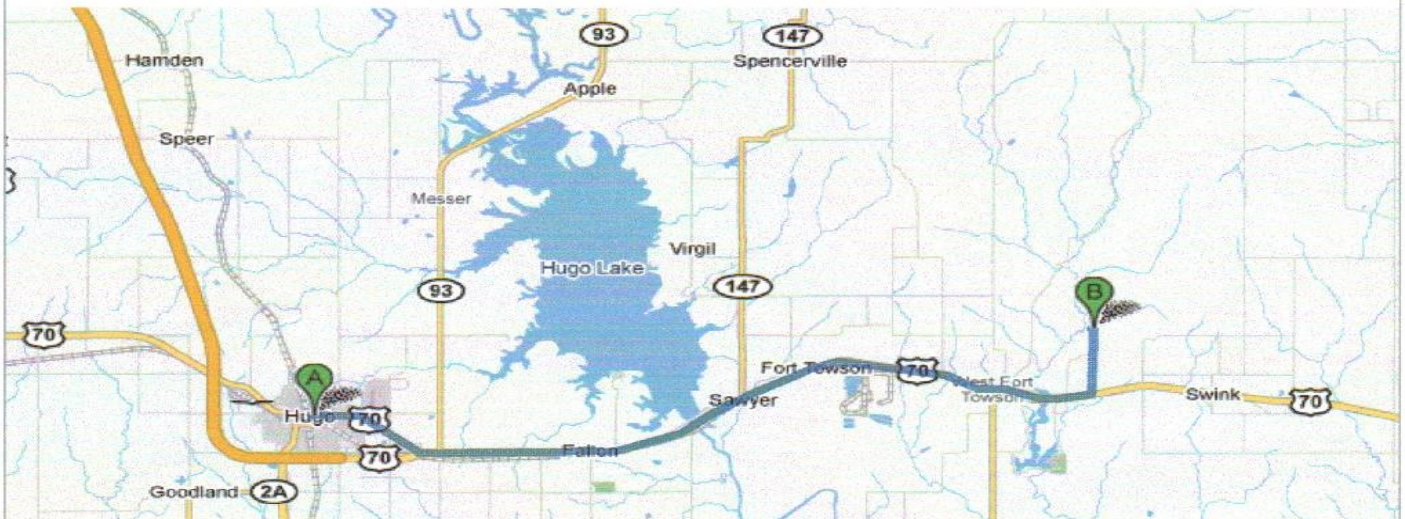
2013 tool box list



| Item | Donated By: |
|--|-----------------------|
| 1. Box | Charles McDevitt |
| 2. Cross Peen hammer | |
| 3. Straight peen hammer | |
| 4. Rounding hammer | |
| 5. Wooden mallet | |
| 6. Handled slot punch 1/2 | |
| 7. Handled slot punch 3/4 | |
| 8. Handled slot punch | |
| 9. Hot rasp | |
| 10. Tongs | |
| 11. 1/4 bolt | |
| 12. 3/8 bolt | |
| 13. 1/4 V bit | |
| 14. 3/8 V bit | |
| 15. 1/2 V bit | |
| 16. 3/4 V bit | |
| 17. 1/4 flat | |
| 18. 3/8 flat | |
| 19. 1/2 flat | |
| 20. 3/4 flat | |
| 21. Farrier's | |
| 22. Scrolling | |
| 23. Side crip | |
| 24. Pick-up tongs | |
| 25. Fire Tools (shovel, rake, poker) | |
| 26. Hot Cut Hardy | |
| 27. Twisting wrench | |
| 28. Treadle/Hand Hammer Tooling | |
| 29. Set of punches and holder | |
| 30. Center punch | |
| 31. Eye punches | Gerald Franklin |
| 32. Chisel (large) | |
| 33. Chisel (small) | |
| 34. Slitting Chisel | |
| 35. Hold down | |
| 36. Flat wire brush with handle | Donated at picnic ??? |
| 37. Set of monkey tools | |
| 38. Rivet setting tool | |
| 39. Hacksaw | |
| 40. Bolter plate | |
| 41. Square | |
| 42. Dividers/compass | |
| 43. Scribe | |
| 44. Bending forks | |
| 45. Spring swage/fuller | |
| 46. Flux spoon | |
| 47. Flux (Iron Mountain) | |
| 48. Metal folding ruler | |
| 49. Soapstone and holder | |
| 50. Ball tool (round blunt nose punch) | |
| 51. Hook ruler | |
| 52. Finish wax | |
| 53. Brass brush/steel brush | Diana Davis |

Save trees. Go green!
Download Google Maps on your phone at google.com/gmm

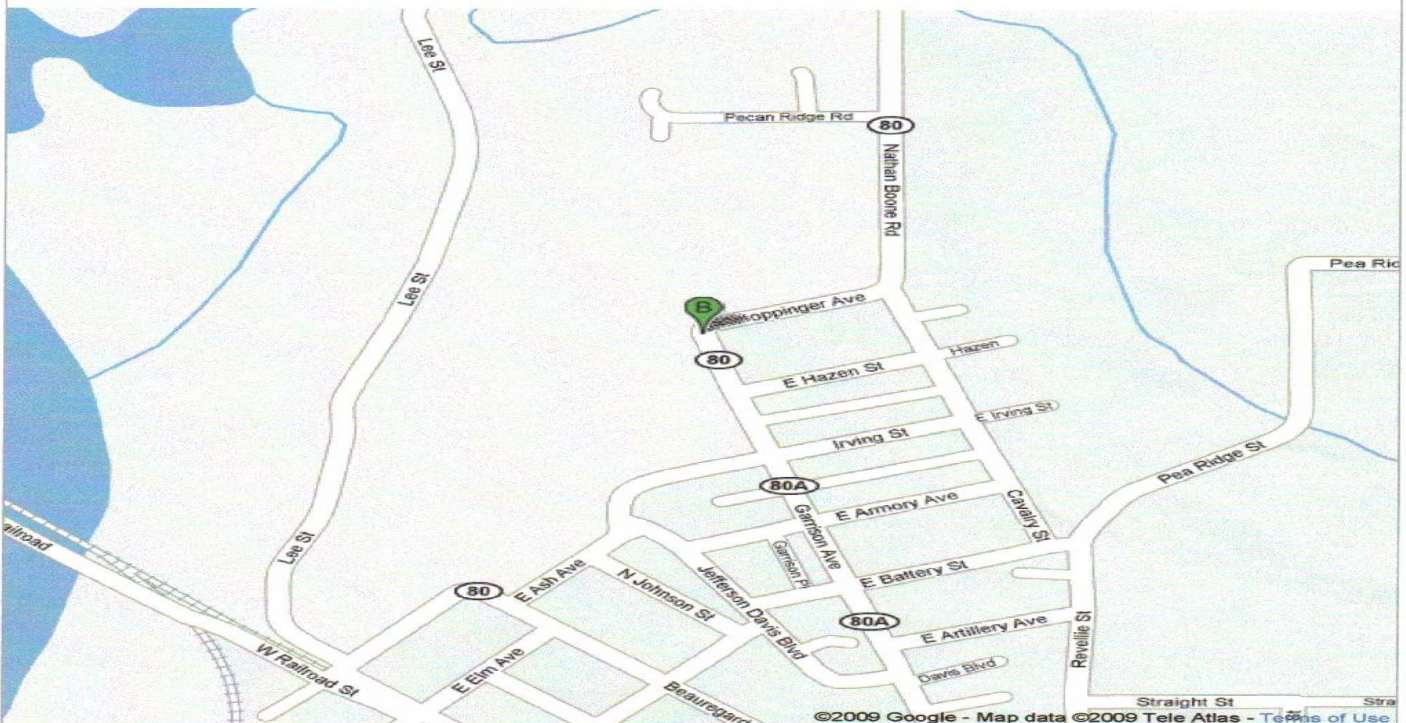
Loading...



www.google.com/maps/@35.3333333,-94.1666667,15z/data=!3m1!1e3!3m2!1s907+N+Garrison+St,+Fort+Gibson,+OK+74434!1s907+N+Garrison+St,+Fort+Gibson,+OK+74434

Save trees. Go green!
Download Google Maps on your phone at google.com/gmm

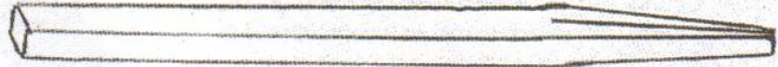
Loading...



Dutch Oven Lid Lifter

By Bob Ehrenberger

Start with about 2 feet of 3/8" sq.
Make a blunt taper on about the first 3".
Mark the center line while at a black heat.



Split the end and forge each point, clean up the cut ragged edge either by filing or forging the ragged edge back into the bar.



Bring the tips back together to protect them while welding.

Fold back about 1.5" of the unforaged bar onto itself.



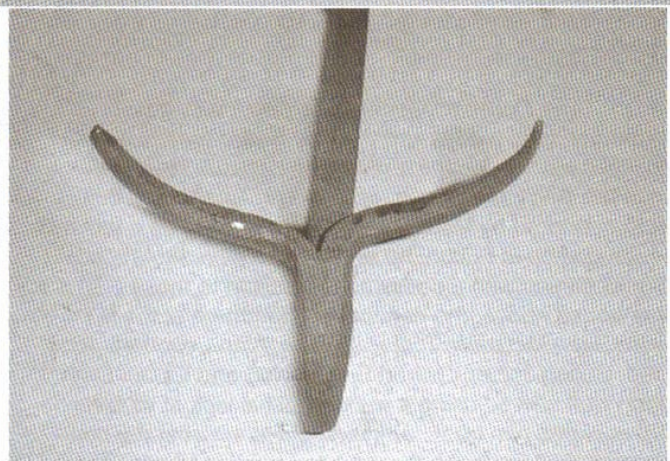
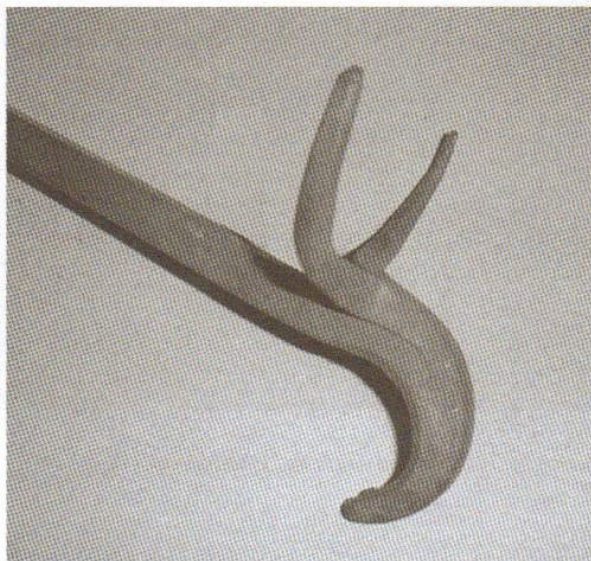
Forge weld the bar to itself and draw to a blunt taper.

Make sure to work the welded area at close to a welding heat. Form the hook. A bending fork in the hardie hole makes this easier and puts less strain on the weld.

Once the hook is finished spread the tines out straight from each other. Curve the tines down so they make contact with the lid when the hook is under the handle.

Each dutch oven lid is different, you should expect to make some adjustments once you have the lid it will be used on.

Forge the other end of the bar to be handle design of your choice.



BLACKSMITH'S QUESTION-TIME

Dear Sir,

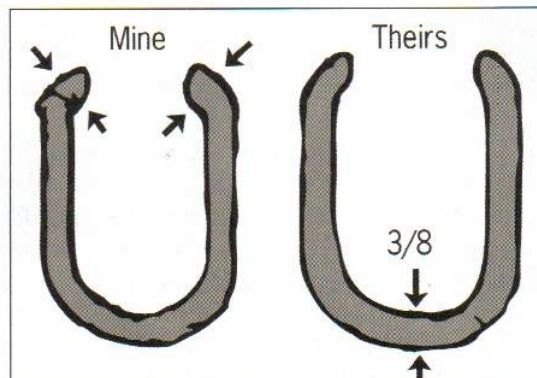
I am trying to follow the lessons in the CoSIRA book, *The Blacksmith's Craft*. I am attempting Lesson #10, "The Chain Link".

When I forge my scarf, I cannot emulate the drawing that the CoSIRA book is showing. Their scarf is shown as the same thickness as the parent barstock; my scarf is wider than theirs.

My joint isn't disgusting, but I don't think that it is right.

Any thoughts that you may have on the subject would be greatly received.

Nick in Minnesota.



Drawing supplied by Nick showing the difference between his scarf and the COSIRA book

Chain Making the CoSIRA Way Jay Close

I am fond of the CoSIRA books. Yet, despite high quality, they occasionally drop the ball. The chain-making exercise in the first smithing book, *The Blacksmith's Craft*, is a case in point: the technical drawing does not accurately show the chain link forged in the photographs; inaccuracy is compounded by ambiguity in the way the scarfs for the weld are depicted; add to that a less-than-helpful text and there is reason for confusion.

Ignore the technical drawings. Scrutinize the book's photographs. What follows is how I would make the link per the CoSIRA directions.

Bend the round bar to a "U"-shape. Make the ends even and the legs of the "U" parallel. This starting shape is critical. Fig. 1

In welding rings, bands and chain links, a left-pointing horn is most convenient (for the right-handed smith). This is what I show in the following photos:

At a thorough yellow heat, hold the bottom of the "U" in tongs (chain tongs if you have them). Place the inside corner of the left leg on a sharp or slightly rounded edge of the step of the anvil with the other leg off the anvil face. Fig. 2

Hold the "U" horizontally and at about 45 degrees to the anvil edge.

Start the scarf with one half-faced hammer blow to create an abrupt step. Draw the corner material on the anvil face to a taper, either by slightly angling the hammer or slowly walking the material off the anvil. The "scarf walk" often happens naturally as the bar and the hand respond to hammer blows. The goal is to pinch this inside corner to a tapered, feathered edge. Fig. 3

One scarf done, immediately flip the bar and make the second scarf exactly the same way. Aim to get both scarfs done in a single heat if you can.



Fig. 1. Make a 'U' shape in the bar. Keep the ends even



Fig. 2. Hold the link at 45° to the edge of the anvil step



Fig. 3. Rotate the stock as you hammer to draw the scarf

WELDING CHAIN BY JAY CLOSE

If needed, take another heat and bend the scarfs so they overlap. With practice you will be able to do this on your scarfing heat. Note that the scarfs meet and create a peak at the top of the link. Fig. 4

Flux -- if that is your practice (it is mine) -- and put the link back in the fire.

At welding heat place the overlapped scarfs on the anvil face and weld. Do not overwork the seam. Two or three blows are sufficient on the first side; then, without hesitation, turn the link over and seal the scarfs on the opposite side. Fig. 5

Quickly go to the horn while there is still welding heat in the link and forge the corners of the scarf. Hold the link at about 45 degrees and rotate it back and forth on the horn as you hit. Repeat on the other side of the weld. Figs. 6 and 7

Your completed link should exhibit the following characteristics:

- Smooth, even curve on the bottom
- Sides parallel or very slightly bowed out — definitely not peanut-shaped
- Weld area full thickness or very nearly so
- Small peak at the top of the link
- Welded area flat and not hollowed from cold working
- Link is flat and not twisted

To test your weld, allow the link to thoroughly normalize (air cool) and put it in your vise with the weld up. Thread a suitable bar through the link and give the link a 90-degree twist. If it survives that test, it's a pretty good weld. Having work-hardened the link, now try to straighten it out again. Not many welds will withstand that straightening.

POSTSCRIPT: English smiths of the revival were wedded to the use of ball peen hammers. This, despite the fact that all historical references to earlier English trade practice, when their work stood alongside the rest of Europe, illustrate a cross-peen hammer. The ball peen is a specialized tool; its use by English revivalist blacksmiths is a regional and historic anomaly. It is also what forces the use of the anvil edge for scarfing in the CoSIRA chain-making instructions. Try your cross-peen hammer for this. I think you'll like it. It is how I was taught to forge these scarfs ----- but that is a different lesson.

Thanks to Jane Gulden for help with the photography.



Fig. 4. Bend the two ends over the horn so that they overlap



Fig. 5. Weld on the anvil face first. Work quickly and from both sides of the link



Fig. 6. Move to the tip of the horn, hold the link at 45° and continue to weld

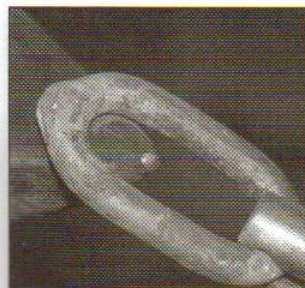


Fig. 7. Rotate the link back and forth around the horn



Fig. 8. Test your weld by twisting it and then straightening it out again



Fig. 9. A chain link in the midst of testing

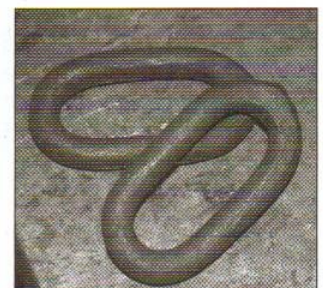


Fig. 10. Two finished links the CoSIRA way

2013 is fast approaching. We need to fill out meeting calendar.

SE Region (1st Sat)

Jan..open
 Feb..Eddie Horton
 March..Bill Phillips
 April.. **Open**
 May..Eddie Horton

June..open
 July..open
 Aug..Eddie Horton
 Sept. **Open**
 Oct. **Open**
 Nov. Bill Phillips
 Dec. **Open**

NE Region (2nd Sat)

Jan..open
 Feb..Bill Kendall
 March..Doug Redden
 April..Ed McCormach
 May..Omar Reed/Gerald
 Brostek

June..Mike Krudoski
 July..Chuck Waite
 Aug. **open**
 Sept. James Maybery
 Oct. **Open**
 Nov. **open**
 Dec. **open**

SC Region (3rd Sat)

Jan. Gerald Franklin
 Feb..Byron Doner
 March..Bob McKelvin
 April..State picnic
 May..Heather Morefield

June..Larry Mills
 July..open
 Aug..Richard Simpson
 Sept. Jim Dyer
 Oct. SCABA Conference
 Nov. **open**
 Dec. **open**

NW Region (4th Sat)

Jan..open
 Feb..Bob Kennemar
 March..Bob Rea
 April.. Don Garner-
 May..Gary seigrist

June..Mandell Greteman
 July..Roy Bell
 Aug. Cheryl Overstreet
 Sept. Dorvan Ivey
 Oct. Don Garner
 Nov. **open**
 Dec. **open**

Saltfork Craftsman Regional Meeting Hosting Form

Region _____ SE _____ NE _____ S/C _____ NW

Date: Month _____ day _____ [correct Saturday for region selected above]

Name _____

Address _____

Phone/email _____

Trade item _____

Lunch provided _____ yes _____ no

Directions or provide a map to the meeting location along with this form.

****All meeting are scheduled on a first come basis. Completely filled out form MUST be received by editor no later than the 23rd of the month TWO months PRIOR to the meeting month.**

Completed forms can be mailed or emailed.

You will receive a conformation by email or postcard.

A form must be filled out for each meeting.

SCABA Shop and Swap

For Sale:

6" round nosed pliers (great for putting scrolls on small items) \$5.00 each. Brooms tied, \$25.00 on your handle **(extra charge if I have to make handle longer)**

Contact Diana Davis at Diana.copperrose@gmail.com

For Sale:

24"(wide) x 1"(thick) Ceramic fiber blanket (similar to Kao-wool) \$1.00 per inch of length. Twisted solid cable 1/2" diameter \$2.00 per ft.

Contact Larry Roderick at 940-237-2814

Wanted:

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

Club Coal

Saltfork Craftsmen has coal for sale. Coal is in 1-2" size pieces The coal is \$140.00/ton or .07 /pound to members **No sales to non-members.**

NW Region coal pile is located in Douglas, OK. If you make arrangements well in advance, Tom Nelson can load your truck or trailer with his skid steer loader for a fee of \$10 to be paid directly to Tom. Tom has moved his skid steer and must now haul the loader to the coal pile to load you out, hence the \$10 charge. You may opt to load your own coal without using Tom's loader. The coal can be weighed out at the Douglas Coop Elevator scales. Contact Tom Nelson (580-862-7691) to make arrangements to pick up a load. Do not call Tom after 9 PM!! Bring your own containers and shovels. Payment for the coal (\$.07 per pound) should be made directly to the Saltfork Treasurer.

NE Region coal location: Charlie McGee has coal to sell. He lives in the Skiatook, Oklahoma area. His contact information is:

littleironworks@gmail.com or
(home) 918-245-7279 or (cell)
918-639-8779



Show your pride in SCABA.

License plates for \$5.00 each.

We have coffee cups for \$9.00 with two images on them and We have a new shipment of caps for \$10.00. There will be caps at the SC meetings and-Dan Cowart has cups and caps for the picnic.

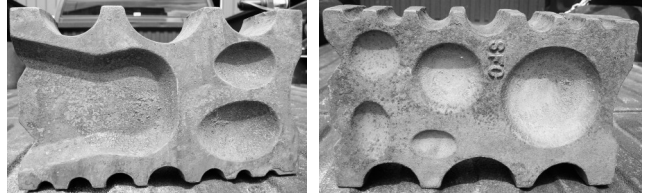


SCABA swage blocks

\$100.00 plus shipping to members. (1st block)

\$120.00 plus shipping to non-members

Contact Bill Kendall for more information



SCABA Floor Cones are now available from Bill Kendall, Byron Donor and Gerald Franklin. The price is \$200 plus shipping and handling.

Sell and Repair Power Hammers (Little Giant) in Tioga Texas. 1-940-580-0032 Ask for Pierre

For sale: 2- 25# Little Giant

1- 50# Little Giant

All new parts, Call for prices...1-940-580-0032 ask for Pierre

SCABA membership application

New _____ Renewal _____

January 2013—March 31— 2014_

Please accept my application

Date: _____

First Name _____ Last Name _____

Married? ___ Yes ___ No Spouses Name _____

Address _____

City _____ State _____ ZIP _____

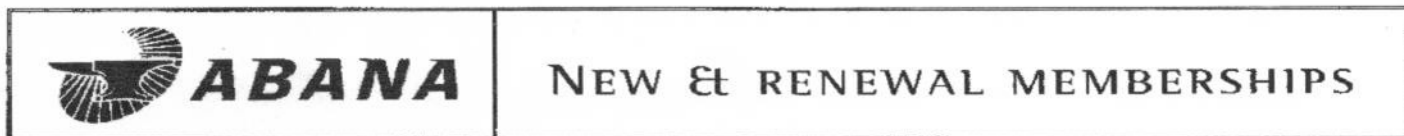
Home Phone (____) _____ Work Phone (____) _____

E-Mail _____ ABANA Member? ___ Yes ___ No

I have enclosed \$20.00 (per year) for dues to March 30, 201_

Signed _____

Return to: Saltfork Craftsmen Membership, Diana Davis 23966 NE Wolf Rd. Fletcher, Okla. 73541



Name : _____ Membership ID # _____
(For renewals. Optional but very helpful)

Business Name (optional) : _____

Street : _____

City : _____ State/Prov : _____

Zip/PC : _____ Country : _____

Phone : _____ Fax : _____

E-mail : _____ Website : _____

Membership Type: New Renewal

| | | |
|--|--|---|
| Regular (US, Mexico, Canada) | One Year – <input type="checkbox"/> \$55 | Two Years – <input type="checkbox"/> \$105 |
| Senior Membership (65+, US, Mexico, Canada,) | One Year – <input type="checkbox"/> \$50 | Two Years – <input type="checkbox"/> \$95 |
| Full-time Student (US, Mexico, Canada) | One Year – <input type="checkbox"/> \$45 | Two Years – <input type="checkbox"/> \$85 |
| Foreign | One Year – <input type="checkbox"/> \$65 | Two Years – <input type="checkbox"/> \$125 |
| Contributory Membership <i>(amounts above \$55 / year may be tax deductible)</i> | One Year – <input type="checkbox"/> \$150 and up – \$_____ | Two Years – <input type="checkbox"/> \$295 and up – \$_____ |
| Public Library (US, Mexico, Canada) | One Year – <input type="checkbox"/> \$45 | |
| Educational Institution | One Year – <input type="checkbox"/> \$250 | |

Saltfork Craftsmen Artist Blacksmith Assoc.Inc.
10380 N. 4010 Road
Wann, Okla.74083

U S Postage Paid
Non Profit Organization
Permit #8
Sterling Ok.
73567

Address Service Requested

