

Saltfork Craftsmen

Artist-Blacksmith Association

March 2020



Basket Handle Fire Poker by Mark Aspery
A Project to Practice Forge Welding - Part 1 - See Page 22
(This is an Excerpt from Mark's Upcoming Fourth Book!)

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Editor's Notes:

Saltfork Craftsmen 2020 Director Elections:

The terms for four SCABA Directors are up this year. Eric Jergensen, J.J. McGill, Ricky Vardell and Russell Bartling are all up for re-election.

If you would like to run or nominate someone else to be on the Board of Directors, please do so as soon as possible. We will hold elections for these positions at the Annual Picnic in April.

Please send any nominations for other candidates to either the Secretary, any current Board member or the newsletter editor by March 22nd to be on the printed ballot.

-Russell Bartling, Editor

The Saltfork Craftsmen Artist-Blacksmith Association, a non-profit organization 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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www.saltforkcraftsmen.org



President's Notes:

Well another month has rolled along. It sure seems like time flies by to me. Maybe it's because I have to many projects that I want to get done and I don't work hard enough. It seems as though it takes a good boost to get myself to get things done.

Our picnic will be here before you know it. It will be good to see everyone and to see who has the biggest bucket of tales. It means a lot to me to see our new smiths at the gathering and it is a good place to learn new skills and to make new friends.

I hope we have good weather for the picnic and for everyone's meetings this year. I feel as though craftsmen feed off of each other's work. If someone does good work, you will be inspired and work harder to be better yourself.



It seems impossible when you start blacksmithing to get all the tools you want to work with. When you go to other shops, especially ones that have been doing it for a long while, it is easy to be envious of all the tools they have. If you ask them, they have usually been buying things for a long while. And you really don't have to have all those tools to start with. But having them does make it nice. Even with all the junk I have, I always want something else!

Keep your steel hot.

- Mandell

**** SCABA Board of Directors Meeting ****

There is a Board of Directors meeting scheduled for **2:00 PM Sunday, March 22nd, 2020** at Byron Doner's shop in Norman.

Board meetings are open to any member to attend. This is the best place to offer any comments, ideas or criticisms you have on how your club operates. Feel free to attend. If you plan to attend and have an issue that needs addressed, please send your topic(s) to the Secretary, Carol Doner, to get on the agenda prior to the meeting date. - Editor

All Regional Meetings are Free to Attend and are Always Open to Any Member or Guest...

New to Saltfork or just want to check out Blacksmithing but don't know where to start? These meetings are a great place for new members or guests who just want to see what it is all about to come network with like-minded people. If you want some pointers on how to get started, there is always someone happy to help get you started hammering. And guests are always welcomed.

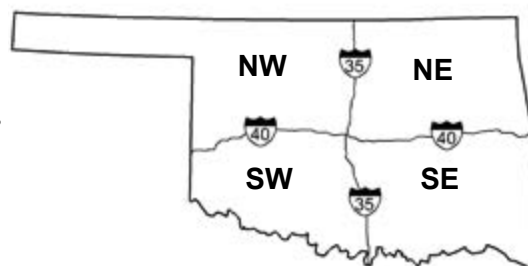
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area, please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the hard copy form in as soon as possible. If you mail a form, please call or e-mail to verify that it is received. E-mail is the most convenient for me but you can also phone in the information if you prefer. The sooner the meeting is scheduled, the more time there is to get the word out to potential attendees. -Russell Bartling 918-633-0234 or rbartling@ionet.net

What's My Region?

The four main regions are currently defined within the state by being separated by I35 and I40. (For example, the NW region is anything north of I40 and west of I35.)

All meetings are encouraged. These boundary definitions and regional meeting dates are a suggested framework to facilitate orderly meeting scheduling, planning and promotion with a minimum of overlaps and a maximum exposure to the greatest number of members. Not all meetings fit precisely within a rigid boundary definition and members in an area may want to hold meetings on a date that doesn't match their physical region or at a location other than their own region. This may be especially true in the center of state for areas that are close to the I35 and I40 boundary crossing. Special events such as shows, fairs, etc. may also dictate adjustments to the meeting dates within a region.

SCABA Regions



The regions are meant to be a simplification and clarification to the regional boundaries rather than a rigid restriction to any meeting scenario. ***Saltfork members all belong to one club.*** Regional boundaries are not intended to imply division within the club, but are intended to help spread distribution and promote monthly meetings.

Safety

Blacksmithing can be an inherently dangerous exercise. There is no substitute for personal responsibility and common sense and no list of safety rules can adequately cover every situation. Every person who attends a meeting, demonstration or event sponsored by the Saltfork Craftsmen Artist Blacksmith Association (SCABA) or its members does so at their own risk and assumes all responsibility for their own safety needs. The SCABA organization, its officers, members, demonstrators, volunteers and guests disclaim any responsibility for any damages, injuries, or destruction of property resulting from the use of any information or methods published or distributed by SCABA or demonstrated at workshops, meetings, conferences or other events. SCABA recommends proper attire and safety gear and standard shop safety procedures appropriate for blacksmithing and shop work during any event where blacksmithing and other related methods are involved. Safety attire includes, but is not limited to, appropriate clothing, eyewear, hearing protection, gloves, and face shields when appropriate. It is every individual's responsibility to provide for their own safety, to determine what safety gear is appropriate for each situation and to provide, maintain and use that gear as appropriate for each individual situation.

SCABA 2020 Annual Picnic!

(April 18th, 2020)

Where: James and Diann Schaefer's Shop
3201 North L. A. Cann Road, Newkirk, OK

When: April 18th

SCABA Family Picnic, April 18, 2020: James and Diann Schaefer will be hosting the annual SCABA picnic at their shop located at 3201 North L. A. Cann Road, Newkirk, OK. Lunch will be smoked sausages, hot dogs and chili. Please bring a side dish and/or a dessert.

Please bring your lawn chairs if you have some.

Contest:

The contest this year will be a two-piece hair barrette forged from 1/4" copper round bar. There will be two gas forges available inside and a single coal forge available outside. Six anvils will be available for use as well. Please bring your favorite hammer and tongs. If you would like to bring your own portable forge setup, feel free. There will be plenty of room. Copper bar will be provided. Contest judging criteria will be posted or announced at the picnic.

The picnic is a family based event for all members and guests so please plan to attend!

Thank You, James Schaefer

2020 Workshop Schedule

Currently no workshops are scheduled.

Have an idea for a workshop or class? If you have an idea for a workshop that you would like to attend (or teach), please let the workshop coordinator know so that details for time and place can be worked out.

**Mandell Greteman is the SCABA Workshop Coordinator.
Contact Mandell at 580-515-1292.**

2020 REGIONAL MEETING SCHEDULE

NE Region (1st Sat)	SE Region (2nd Sat)	SW Region (3rd Sat)	NW Region (4th Sat)
Jan 4th (Open)	Jan 11th (Byron Doner)	Jan 18th (Open)	Jan 25th (Rory Kirk)
Feb 1st (Open)	Feb 8th (Byron Doner)	Feb 15th (Open)	Feb 22nd (Monte Smith)
Mar 7th (Open)	Mar 14th (Open)	Mar 21st (Bruce Willenberg)	Mar 28th (Mandell Greteman)
Apr 4th (Open)	Apr 11th (Open)	Apr 18th (SCABA Picnic)	Apr 25th (Don Garner)
May 2nd (Open)	May 9th (Open)	May 16th (Ricky Vardell)	May 23rd (Terry Kauk)
			May 23rd (SW-JJ McGill Boy Scouts)
Jun 6th (Open)	Jun 13th (Open)	Jun 20th (Jim Obenshain)	Jun 27th (Everett Timmons)
Jul 4th (Open)	Jul 11th (Open)	Jul 18th (Open)	Jul 25th (Open)
Aug 1st (Open)	Aug 8th (Open)	Aug 15th (Open)	Aug 22nd (Open)
Sep 5th (Open)	Sep 12th (Open)	Sep 19th (Ricky Vardell - JJ McGill - Sulphur Tractor Show)	Sep 26th (Ron Lehen- Bauer as Host - Don Gar- ner as Contact Person)
Oct 3rd (Open)	Oct 10th (Conference Setup Work Day)	Oct 17th (Conference Weekend)	Oct 24th (Rory Kirk)
Nov 7th (Open)	Nov 14th (Bill Phillips)	Nov 21st (Open)	Nov 28th (Bob Kennemer)
Dec 5th (Open)	Dec 12th (Open)	Dec 19th (Open)	Dec 26th (Open)

2020 Fifth Saturdays:

February 29th (Tong Making Class in Elk City - See Workshop Schedule)
 May 30 (Open)
 August 29th (Open)
 October 31st (Open)

March 2020

NE Regional Meeting March 7th: Open.

SE Regional Meeting March 14th: Open.

SW Regional Meeting March 21st: Will be hosted by Bruce Willenberg at his shop located at 12250 Nelson Lane, Norman, OK 73026. Take Hwy 9 east from Norman to 120th St. Then go south 1.5 miles to Nelson Lane (old country dirt road.) Then go east 200 yards to first drive on the south.

The trade item will be something that makes you think of spring (flowers, fruit or bug). I would really like to see a lot of trade items. It's a lot more fun if the table has lots of trade items from all the different smiths. Everybody bring one!

Lunch will be provided (chili and grilled sausages) but please feel free to bring a side item or dessert to help out.

Contact: Bruce Willenberg at 405-227-4547 or brskw1976@yahoo.com if you have questions

NW Regional Meeting March 28th: Will be held by Mandell Greteman at his shop in Foss, OK.

The trade item is a "hamburger flipper" (spatula.) *(Don't forget to use a food-safe finish. - Editor)*

Lunch will be provided but please bring a side dish or dessert to help out. Contact Mandell at 580-515-1292 if you have questions.

April 2020

NE Regional Meeting April 4th : Open.

SE Regional Meeting April 11th: Open.

SW Regional Meeting April 18th: SCABA Annual Picnic!
(See Page 5 for Details)

NW Regional Meeting April 25th : Will be held by Don Garner at his shop at 23713 E 860 Rd. in Thomas, OK. Directions: Go one mile west, then one mile north of Thomas.

The trade item is a double caliper at least 18" long with a loop for hanging.

Lunch will be provided but please bring a side dish or desert to help out. Contact: Don Garner 580-302-1845 if you have questions.

Around the State...

NW Region January Meeting:

The Northwest region January meeting was held at Elk City's Route 66 museum by Rory Kirk.

We had a good turnout with 29 people showing up. There was lots of forging going on making trade items and other projects as well. We had 12 trade items. All looked very good and I really appreciate all the effort that everybody put into them and it showed they were great. We had a big lunch which was very good. Thanks to everybody who brought food and deserts and thanks everyone who helped set it up and cleaned up afterwards I appreciate all your work.

-Rory Kirk

(Photos by Rory Kirk and LaQuitta Greteman)













SW Region February Meeting: No Meeting was held in February.

SE Region February Meeting: The SE Region February meeting was held by Byron Doner in Norman, OK:

We had good weather so I sure couldn't gripe at the weather folks this time. But I'm still wondering if we should load up a bunch of thugs and go explain to them that they better give us good weather for all the rest of the meetings!

Thanks to all the ladies for helping Carol give us a great lunch! I know she was worried about pulling it off, and making everybody's tummies happy.

We had a great turnout. The sign-in sheet had 36 peoples' names on it, and I think there were a few that didn't sign in. I saw several new faces.

Generally, I get overwhelmed at my meetings by several folks needing to know where something is, or needing me in some other way which is a bit frustrating. But something was different this time, and I had the best time I've ever had at my meetings! I believe there were at least 4 guys that did some forging, and a couple of young boys who made "S" hooks, as well as some hooks and spoons from Horseshoe nails! That's more than usual. We had, I think, 11 trade items.

I don't seem to draw folks from the Northeast like I did in the past. If I've done or didn't do something that has made them mad at me, I'd sure like to know how I can make it up to them.

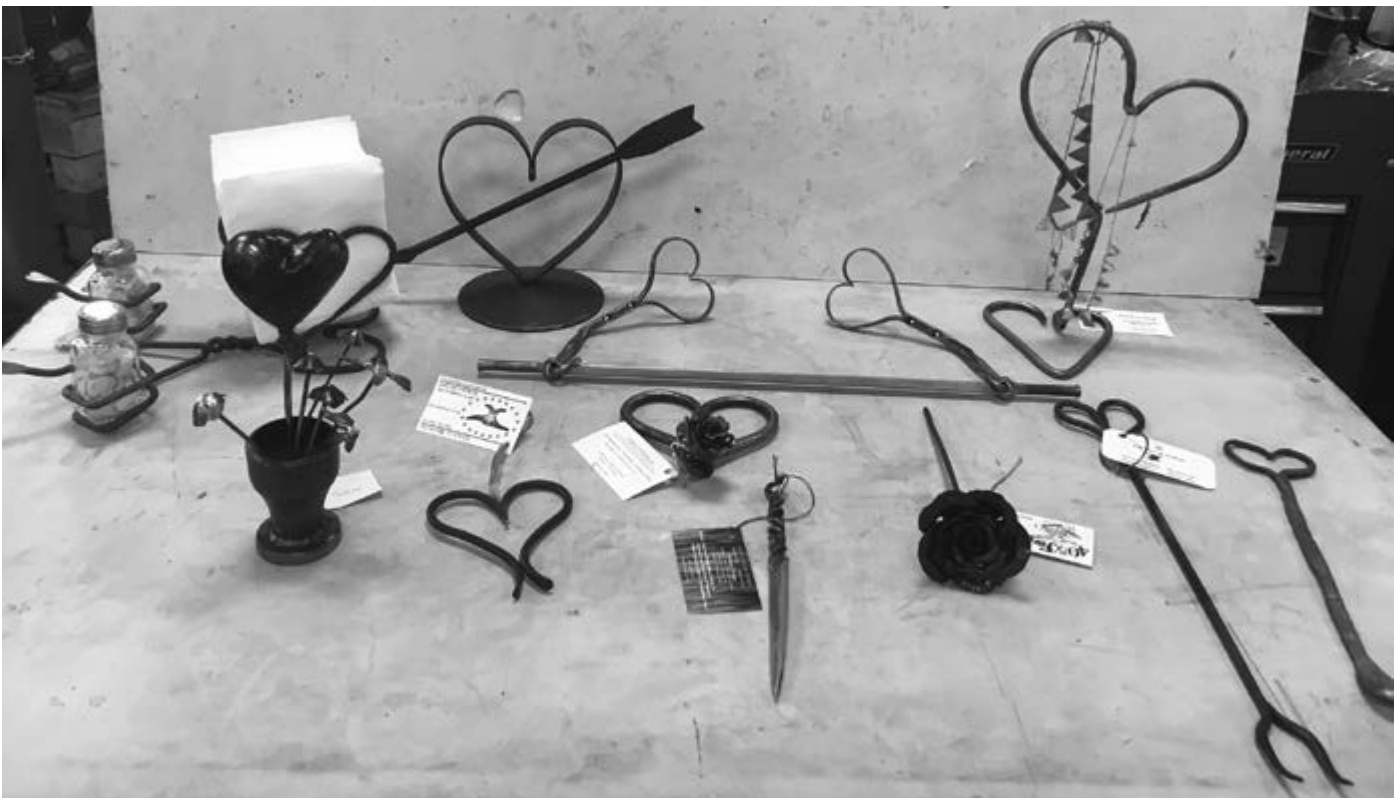
Hope to see you all at the next one! - Byron
(Photos by LaQuitta Greteman)











SW Region February Meeting: No Meeting was held in February.

Member Gallery

HEART OF STEEL by Gerald Brostek

Mild steel branches and leaves. Nickel steel flowers w/colbalt glass centers.
Copper butterflies. 18 X 21 inches.



Member Gallery (Continued...)

Trivet - Designed by Diann and forged by James Schaeffer:



Don't Forget About the Saltfork Gate Project!

This is a new group project that is open to all Saltfork members. The project is a four foot high by sixteen foot long gate to be displayed outside at the Route 66 Blacksmith Shop Museum at Elk City.

Participating members will be given a steel ring that can be filled with any (family appropriate) forged work that will fit in the ring and be permanently attached to it. Each ring is 10 1/4" O.D. and made of 3/8" round. Most of the rings will be connected at the four cardinal direction points (N, S, E, W) by welding. A small spacer of 1" by 3/8" will be placed between the connection points of each ring.

Try to keep the projects inside the rings from projecting more than approximately 4" out from either face. Otherwise, the design and connection methods to the ring are strictly up to you.

There will be a central large ring with a Saltfork Craftsmen title.

Mandell Greteman is coordinating the project and will provide the standardized rings. All of the rings will be provided to ensure they are a standardized size. Once the projects are returned, Mandell will weld them into the gate to be displayed at the museum.

There is space for 56 ring projects in this gate. If there are more participants, additional gates will be made and installed inside the blacksmith shop.

Contact Mandell if you have any additional questions or to find out where to obtain one of the project rings: **Mandell Greteman 580-515-1292.**

Concept Sketch for the Gate Project:

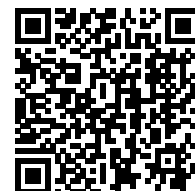


Basket Handle Fire Poker - Part One

by Mark Aspery
A Project to Practice Forge Welding
(This is an Excerpt from Mark's Upcoming Fourth Book!)



Mark Aspery has provided this sneak peak preview out of the long awaited fourth book in his “Mastering the Fundamentals of Blacksmithing” series. If you don’t already have these excellent books, you may want to consider getting them. Each book is full of detailed instruction and clear photography that Mark has become known for producing.



You can obtain these books at your favorite book seller or directly from Mark's website. (If you buy directly from Mark, you can have the books autographed.):

http://www.markaspery.com/School_of_Blacksmithing/Purchase_books.html

The basket handled poker:

The essence of this project is to practice and improve your forge welding.

There are three types of weld contained within the handle area. A faggot weld, to weld the ¼-inch diameter rods of the basket handle together, a jump or drop-tong weld, to add a shaft to one end of the basket, and a collar weld, to weld on the decorative finial at the end of the basket handle.

I use a Farrier's rounding hammer for this project. I find the ball face helps in moving material around in the weld areas, and aids in sweetening the transitions to the basket from the two welds.

A ¾-inch, half-round bottom swage is necessary for this project. It will help in welding the basket, as well as refining the welded collar.

An 1 ¼-inch half-round bottom swage will help in fitting, closing and the initial welding of the collar, and is nice to have but not necessary.

For a straight forge poker, you're going to jump-weld on a piece of ⅜-inch square bar to the basket handle, and draw it to a taper.

For a wood-fireplace poker, with a spur on the working end, you're going to require both the shaft and a piece of ¾-inch wide by ¼-inch thick flat bar welded to the shaft.

Why a length of ⅜-inch square bar as a shaft? The area of the stack of four, ¼-inch diameter rods is 0.195sq- inches.

The area of a ⅜-inch square bar, upset prior to welding to around 7/16-inch square at the end, is about the same at 0.19sq-inches.

A 7/16-inch round bar is 0.15sq-inches prior to an upset, and would also work as a shaft with a little upset for the weld.

A ½-inch round bar would work, at an area of 0.19-inch with no upset required - but with more work needed to draw it to a taper later on when refining the shaft.

½-inch square bar is too big for the job.

For the basket handle, you will use two 'hair-pin staples' slotted together rather than four individual pieces of material.



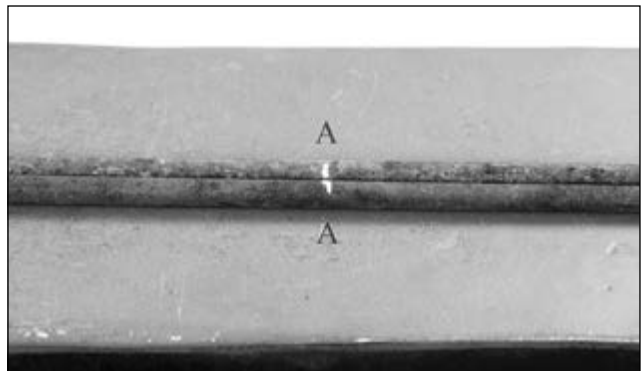
One of the two staples made from ¼-inch round bar required to make the basket handle

Start with two pieces of ¼-inch round bar, each 12-inches long, both bent in the middle to form a staple.

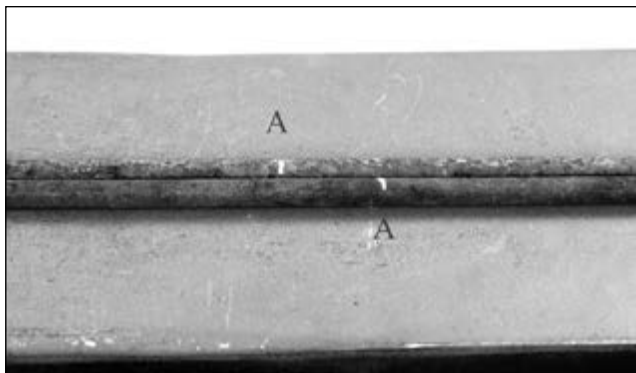
To find center on the ¼-inch round bars, place the bars side by side and make a chalk mark across both. Strive to get about ½-inch from the center.

Getting too close to the middle makes splitting the difference difficult with your soapstone.

Turn one bar over, end for end.



Mark a rough center on two, 12-inch long, ¼-inch round rods or bars. Don't get too precise!

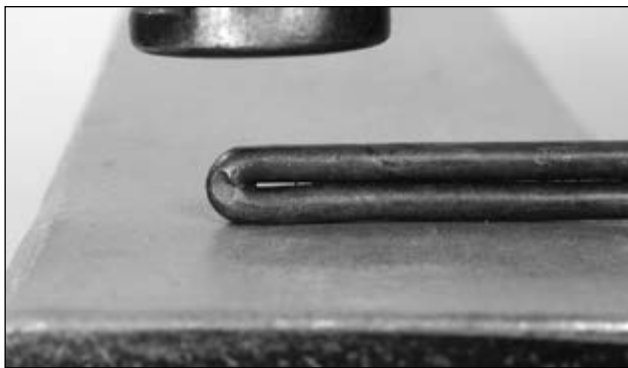


Turn one bar over, end for end. True center is between the two lines. Re-mark for center

The middle of both bars will be between the two chalk marks. Mark center and create a crease in the bar by driving it onto an edge of the anvil.

Bend the bar to create the staple. Work over a round edge of the anvil face to start the bend, preventing any more galling of the bar.

Hold the crease to the side as you bend, this will leave the crease on either the top of the bottom sides of the bend.



Keeping the mark on one side as you bend puts the mark on top of the bend now, making it easier to see

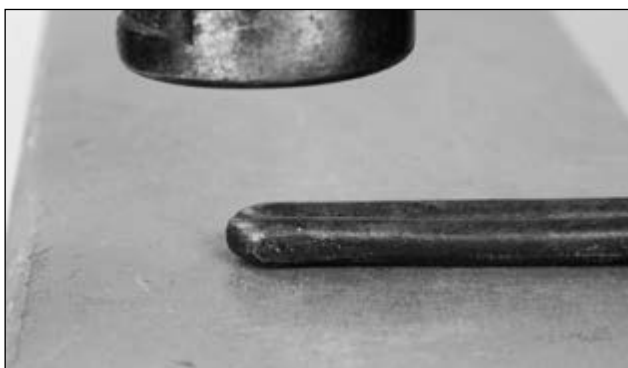
The crease disappears if you start the bend with the crease uppermost.

Both ends must align, side by side. If all goes wrong, trim the longer end. Don't forget to take the same amount of material off the other staple.

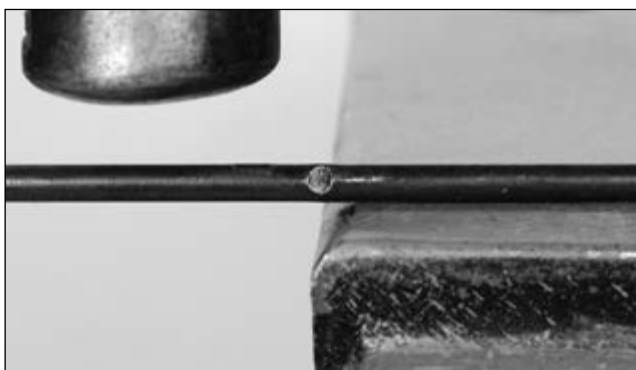
I like to bring the ends of the staple touching together. Tap on the flat side of the bend to open the ends to a gap of 1/4-inch or so at the other end.



Create a mark in the bar by driving the bar into a sharp edge on the offside edge of the anvil



One blow on the closed end will open the legs of the staple, allowing the 2nd staple to be fitted



Bend the bar to make a U-shaped staple. Keep the mark on the bar to one side as you make the bend



Here is the result thus far

Slot the two staples together. Choose your better end and put a pair of ½-inch V-bit tongs on the other, leaving your good end ready for the fire.

Place the bars into the fire with the two free ends on the sides – take a slight heat and then tap the free ends onto the U of the other staple. This will help to prevent the free ends from burning in the fire as you take the welding heats.

Heat the bars to near welding and brush/flux the pieces. Return to the fire and take a forge welding heat.

Heat the bars until the pieces disappear in the bright yellow coals of the fire (read: the pieces are the same temperature as the fire and therefore an appropriate welding temperature).

Pull the bars from the fire and with the free ends top and bottom, make the weld over the face of the anvil. Turn the bar over 180° to make sure that the second free end is welded.



Join the two staples together, open end to open end



The ends should all be equal. If one end is better than another, weld the better end first

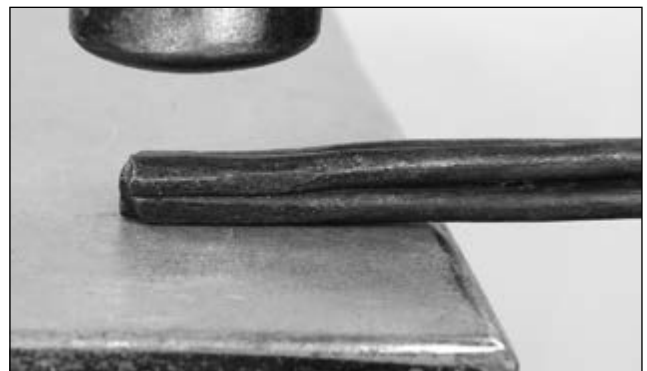


Weld in the two loose ends. I've welding on the anvil, but welding in a half round bottom swage works well

As quickly as you can, turn the bar 45°, so that the bars stack two pieces wide and two tall (a square) and continue to weld.

You are going to have to be a bit creative here, as the bars form more of a diamond than a square cross section. I drag the material from the long axis onto the square face, rotating the stock as I go.

Weld approximately 1 to 1¼-inches of the end of the stack.

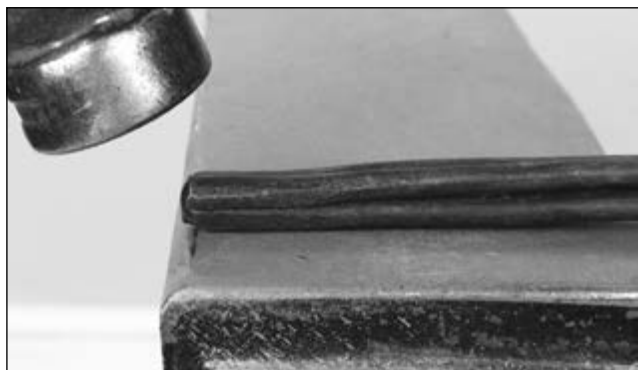


Quickly turn the stack so that two bars are resting on the anvil and forge the bar into a square cross section

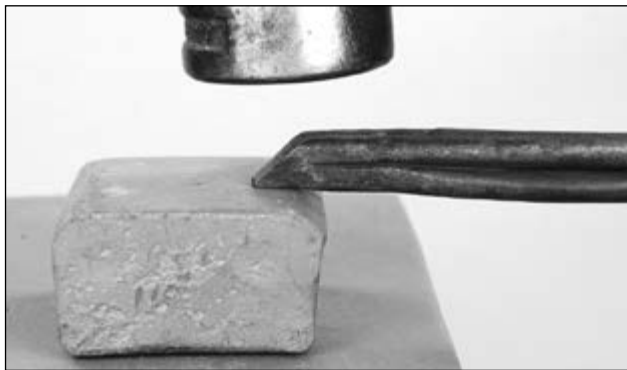
There is no need to take the end to a seam free finish. This end will be scarfed and welded to the ⅜-inch square shaft, giving you an opportunity to finish the weld at that time.

Re-heat the end of the now welded bar, flux and re-heat.

Draw the end down to a short compound taper, with a ⅛-inch square tip.



No need to dress the weld now. As soon as you're sure of the weld, create the scarf for the next weld



Create the step to the scarf and refine the slope to the scarf



Draw the end down to a blunt taper

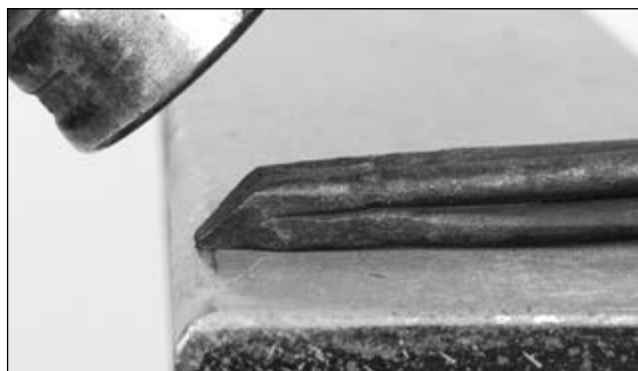
Knock the point over to one side so that it is level with one side of the handle material, leaving you with a three-sided taper.

Move to the nearside round edge of an anvil block (or the anvil if you haven't yet made the block) and create the step to the scarf.

Take the tip of the scarf as thin as you can, making the tip easier to blend in to the rods comprising the handle.



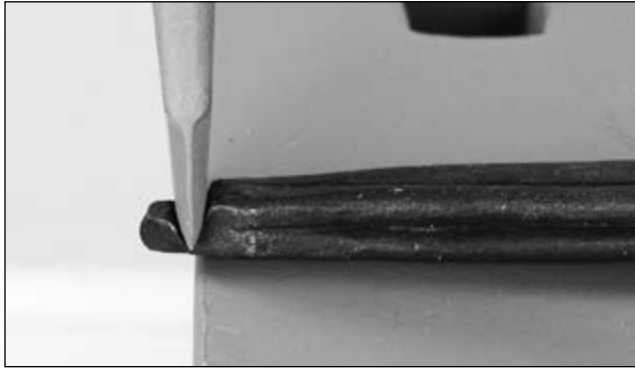
An alternative method is to taper the end slightly, turn 90°, and then cut the stock with your hot-cut chisel



Knock the taper over so that one side of the stock is flat



Hold the chisel vertically as you cut. The angle will change as you create the step and refine the slope



Finish the cut at the edge of the anvil and then move to the block to create the step

At this stage, change gears and focus on preparing the shaft for welding. Ignore the other end of the basket until after you've made the weld to the shaft.

My thinking is three-fold:

1. You already have the heat in that end of the handle so you might as well carry on working there.
2. More importantly, when preparing to wrap the material for the collar you will need the handle as hot as you can – in preparation for welding...and
3. If you're going to have a catastrophic failure, it's going to be at the jump weld, and why waste time & effort in something that might not make it to the sale table.

Upsetting the shaft:

Heat on the end of the $\frac{3}{8}$ -inch bar for a little under 1-inch in length. I find placing the bar at 45° in the fire helps control the length of the heat.

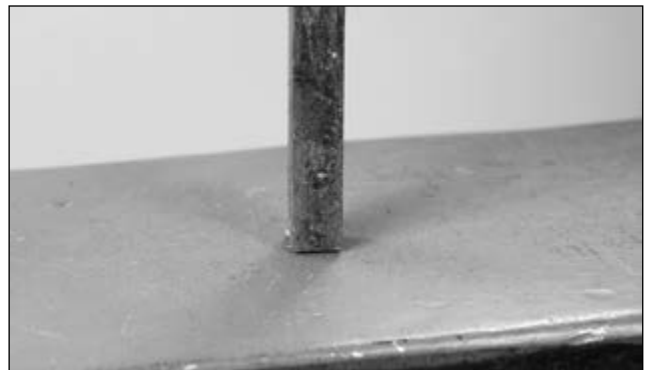
You have a choice as to whether you upset at the anvil or upset at the vise. My preference is at the anvil, but I think that's just because of habit rather than anything grounded in scientific study.

I use an 18-inch to 20-inch+/- long bar and weld a basket on to each end, just to forgo the use of tongs. A large upset helps with blending in the scarfs and aids in the handle to shaft transition.

At the anvil:

I hold the bar with the hot end nearest the anvil, as I like to keep my hand above the heat (and scale) as much as possible. After delivering 4-6 blows, correct for any bending in the bar.

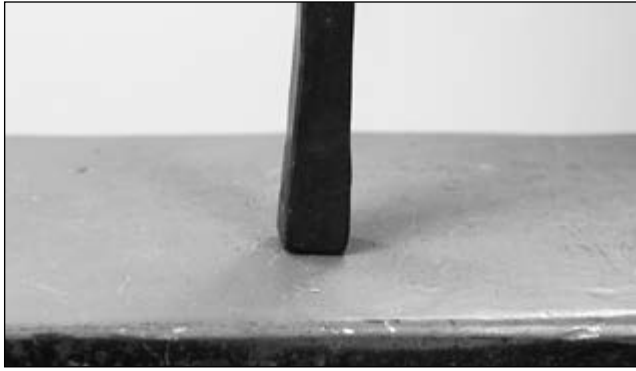
Nothing good ever follows continuing to forge a bent or twisted bar!



Heat about $\frac{3}{4}$ -inch of the end of a $\frac{3}{8}$ -inch square bar and upset the end

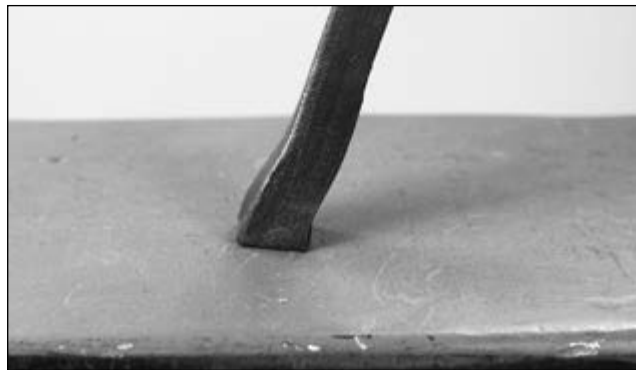


Nothing good ever follows continuing to forge a bent or twisted bar! Take the time to straighten the upset end



For this project, I recommend two upset heats to get a larger than normal upset

Upset the end of the bar with your hand hammer. Just before the bar becomes straight, angle your hammer to the end of the bar, and start to form the slope of the scarf.



Lower your tong hand towards your hammer hand to start creating the slope to the scarf

Once you're happy with your upset, start to lower your 'tong' hand towards your hammer hand, while still delivering hammer blows.

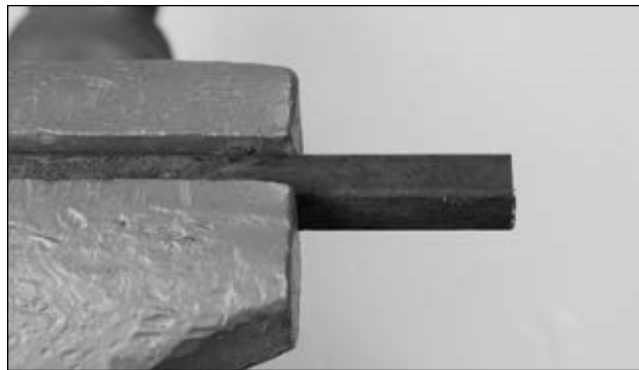
Dropping your tong hand now will help to create the slope to the scarf and create more of an upset.

At the vise:

This is a useful move for upsetting the other end of the shaft material prior to welding on the wood-poker end.

Holding the stock horizontally, leave about 1 1/2-inches of the hot end material protruding from your hammer-hand side of the vise.

Knock the bar away from you – compensating for the slight pulling of material with your hammer towards you as you work.



Heat the end of the 3/8-inch square bar and clamp horizontally in the vise with 1 1/4-inch material protruding



Knock the end of the bar away from you to compensate for the pull of material with your hammer

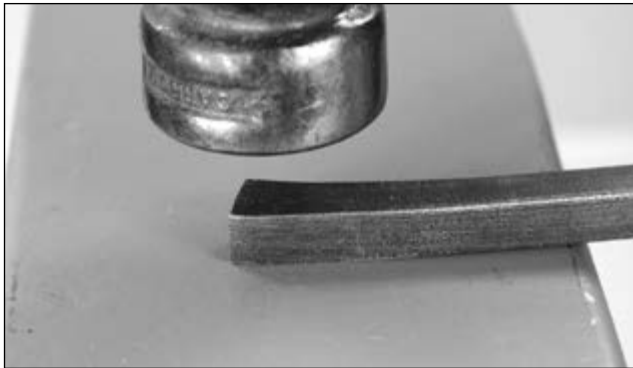


Upset the end and finish by angling your hammer and creating the slope to the scarf

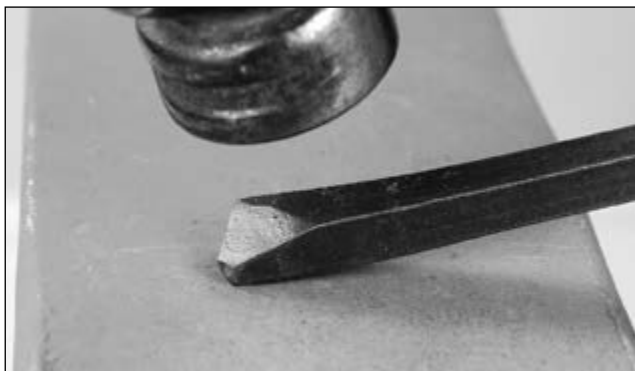
After upsetting:

No matter which method you used for upsetting the end of the bar, dress the edges of the upset back to parent stock thickness, and draw down the toe of the scarf.

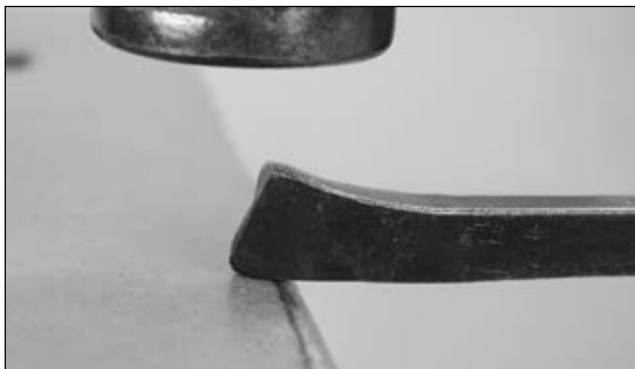
If you have the heat, create the step of the scarf, otherwise re-heat. Take the tip (toe) of the scarf down as thin as you can to help with blending the weld in on the handle.



Dressing the sides now give more vertical material for the weld



Lift the bar slightly and thin the toe of the scarf, keeping the toe centered on the bar



Create the step to the scarf on the nearside edge of the anvil or anvil block. Match the step to your handle scarf



Create the step to the scarf and refine the slope to the toe

The jump weld:

Clean your anvil and place your hammer on the heel with the face that you intend to use for welding, facing away from you. The handle should be hanging in space, off the heel of the anvil.

Return both the shaft and the handle to the fire in readiness for welding. Depending on heat, the handle may need to be lower in the fire initially to bring the heat up to that of the shaft.

The handle material, held in a pair of tongs, will be in your HAMMER hand. The shaft will be in your normal tong hand. Chalk the shaft so that the chalk mark is up when you are going to the anvil to weld (Scarf step down).

You can also chalk the tongs so that the chalk is up as you go to the anvil (Scarf step up). The chalk marks help keep the juggling of the bars to a minimum as you go to the anvil.

Bring both to a near welding heat – bright orange /yellow and after wire brushing, quickly flux each bar in turn. Then return them to the fire.

Keep both scarfs in the same part of the fire with the step up in the fire. Heat for 7-10 seconds and then turn both bars over for 5 seconds (step down in the fire). Another 5 or so seconds with the step up, and you should be ready to weld.

The coals of the fire should be glowing bright yellow around your pieces.

If you're seeing sparks, you've gone too high with the heat. A steady heat is the way to go here, with the welding heat reaching all the way back past the heel of the scarf, to where the toe of the second scarf will land.

Pull the bars from the fire. Welding occurs within a range of heats, but I find that I have more success if my heats are matched within that range.

If things aren't looking good, simply return the bars to the fire and top up the heat on the cooler bar. You may need to re-brush and flux the bar(s).

Aside from matched heats, both scarfed ends must look wet to weld. If one or both bars looks dry and crusty, don't even go to the anvil, brush, re-flux and return the bars to the fire.

Tap both pieces against the side of the forge to knock off any fly-ash that may be stuck to the bars. This is not a major swinging of the bars, just a slight tap on the edge of the fire-pan.

Move to your normal standing position at the anvil and extend your hammer arm (*tongs holding the handle material*) to the offside of the anvil. I have to bend at the waist to do this. Try to avoid moving your body towards the heel of the anvil.

Touch the mid-point of the handle against the offside edge of the anvil –helping to steady the bar and prevent Blacksmith Induced Oscillation.

Touch the shaft material to the nearside edge of the anvil, about 2 or 3-inches back from the scarf – again steadying the bar.

Roll the handle into a position in the middle of the anvil face with the step up.

Roll the shaft material (step down) onto the handle material so that the steps touch.

Put a little pressure onto the shaft material, trapping the handle in place as you withdraw the tongs.



Touch both bars to the sides of the anvil



Roll the handle material (that's in your hammer hand) onto the face of the anvil



Roll the handle material (that's in your usual tong hand) down to trap the handle



Remove and then drop the tongs, picking up your hand hammer

At this stage your hammer hand should be about level with the top of the anvil. Keep your hand open and make a sweep towards the heel of the anvil – hopefully finding your hammer handle.

Pick up the hammer and deliver your first blow to the top of the weld area. Then, I like to use the edge of my hammer to run down the slope of the scarf to the toe, before turning the bar over.

Turn the bar over, and deliver a blow to the top of the weld, then blend in the other scarf. I use the heel of my hammer here.

You will have heard that you use light blows when welding, and I have a toe in that camp – but I'm more in the moderate blows camp. I think that both camps agree, that the blows should not be heavy until after you have *stuck-the-weld*.

If you've got the heat keep working, otherwise return the bar to the fire and re-heat, brush, flux and then finish the weld.



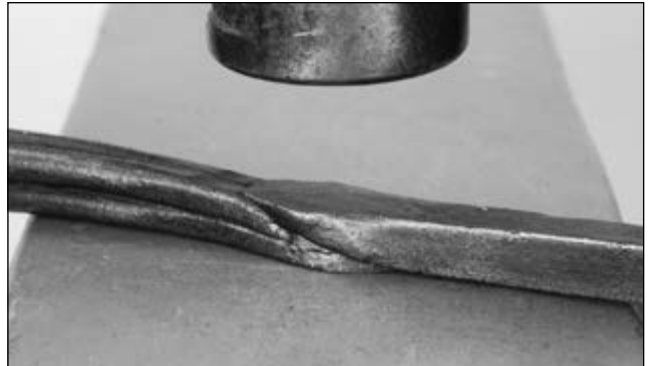
Turn the stack over and give a blow to the top of the weld area



Use the heel of your hammer to weld in the scarf of the handle material



Deliver your first blow to the top of the weld area



Once you have a secure weld, draw the area down to a usable size. Re-heat and flux as necessary



Your next 2 or 3 blows are to weld in the scarf to the handle material



Work the sides and corners of the weld only after you are sure that the weld is good



Draw the weld down to a taper between the handle material and the shaft material

It didn't go so well! What happened?

The first thing is to avoid stating to the world that *you cannot weld* – you can weld, as we've seen with the welding of the handle pieces or links of chain. It's the juggling that you might be having difficulty with. Practice the juggling.

What happened in the fire? Were the pieces of equal heat as you came out of the fire? Was the heat far enough down the bar so that you had a welding heat where the other scarf would land (plus a little bit)?

Did the bars look wet as you went to weld? Both bars ***must look wet to weld!***

Did you touch the edge of the anvil, or were the bars oscillating in space as you tried to align them? Perhaps a couple of dry runs here, without heat, might be in order.

Did you step towards the heel of the anvil and knock your hammer to the floor?

Were the tongs in the correct hand?

If there is secret to welding, and I don't know that there is other than practice, it's that the scarfs match in character before you go to the welding heat.

If one step is deep and the other shallow, then the scarfs are not going to touch the other bar until after a couple of hammer blows – and that can make the difference between getting or not getting the weld.

Moving on from a successful weld:

Give the handle a good wire brushing to prevent hard scale buildup. Weld the other end of the handle and take it to a round cross section 1/2-inch in diameter. I like to use the half-round bottom swage here, as it helps prevent flat spots.

Weld with the ball face of your farrier's rounding hammer.

You don't need as long of a weld on this end so try to keep it to 3/4-inch or so in length.

Keep as large a diameter of round cross section as you can while completing this weld. You should be looking at something between 7/16-inch and 1/2-inch in diameter in the weld area.

Part Two of this article including a collar weld and the poker end will be continued in the April Newsletter - Editor



Use a 3/4-inch, half-round bottom swage as you weld the other end of the handle together



Take the end to as large a diameter round cross section as you can - aim for 1/2-inch diameter

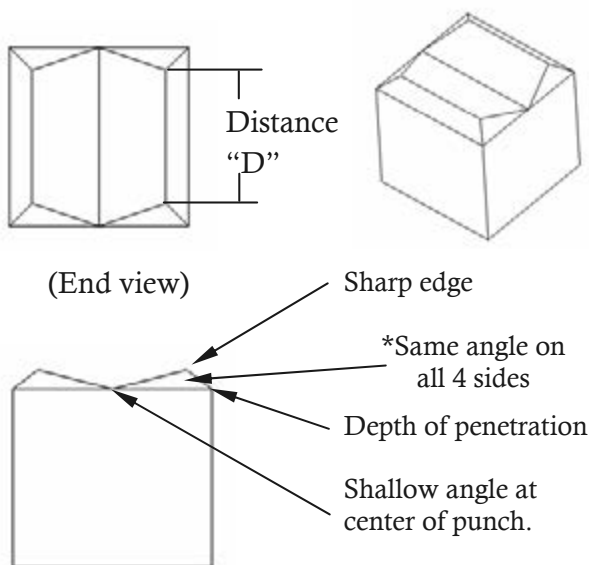


Silberberg Ornamental Twist

By Jan Kochansky
January/February 1991 BGOP
Newsletter

MABA Editors note: Instructional information and drawing were edited from original article.

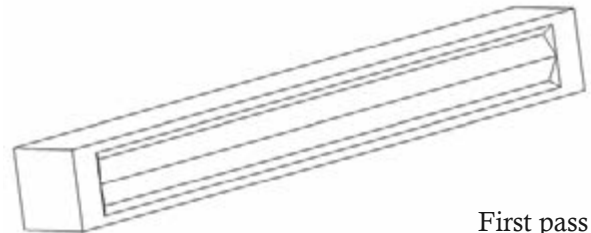
Prepare a square-faced punch made out of a suitable steel. The size of the punch must be appropriate to the size of the bar that will be twisted. If you will twist a 1 inch bar, the punch should be of at least $\frac{3}{4}$ inch square stock, and could be of 1 inch stock. Shape the end as shown in the drawing.



Harden and temper the chisel. Clean and lightly polish the end of the chisel. The two chisel shapes on the punch face should be formed at a shallow angle, but they must be sharp. Check the chisel on a practice piece. Adjust the punch face as necessary.

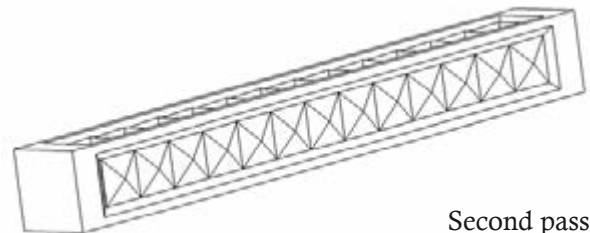
Checking the pattern on a piece of clay formed into a square bar is a good way to see how well the

punch will work before you spend time hardening and tempering. There should be $\frac{1}{8}$ to $\frac{3}{16}$ inch of unworked steel on each side of the pattern. In addition, the punch must go deep enough to leave a sharp center ridge that runs down the center of each side. Don't move the punch any more than distance "D", so the profile is continuous along the length to be twisted. Reheat and rework each side until it looks correct.



First pass

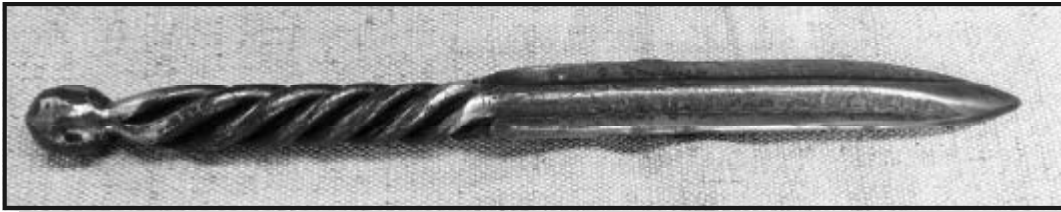
Reheat the bar and start chiseling in marks perpendicular to the previous marks. Move the punch distance "D" after the penetration depth is achieved. This should leave shallow pyramid shapes. Do this to all four sides of the bar.



Second pass

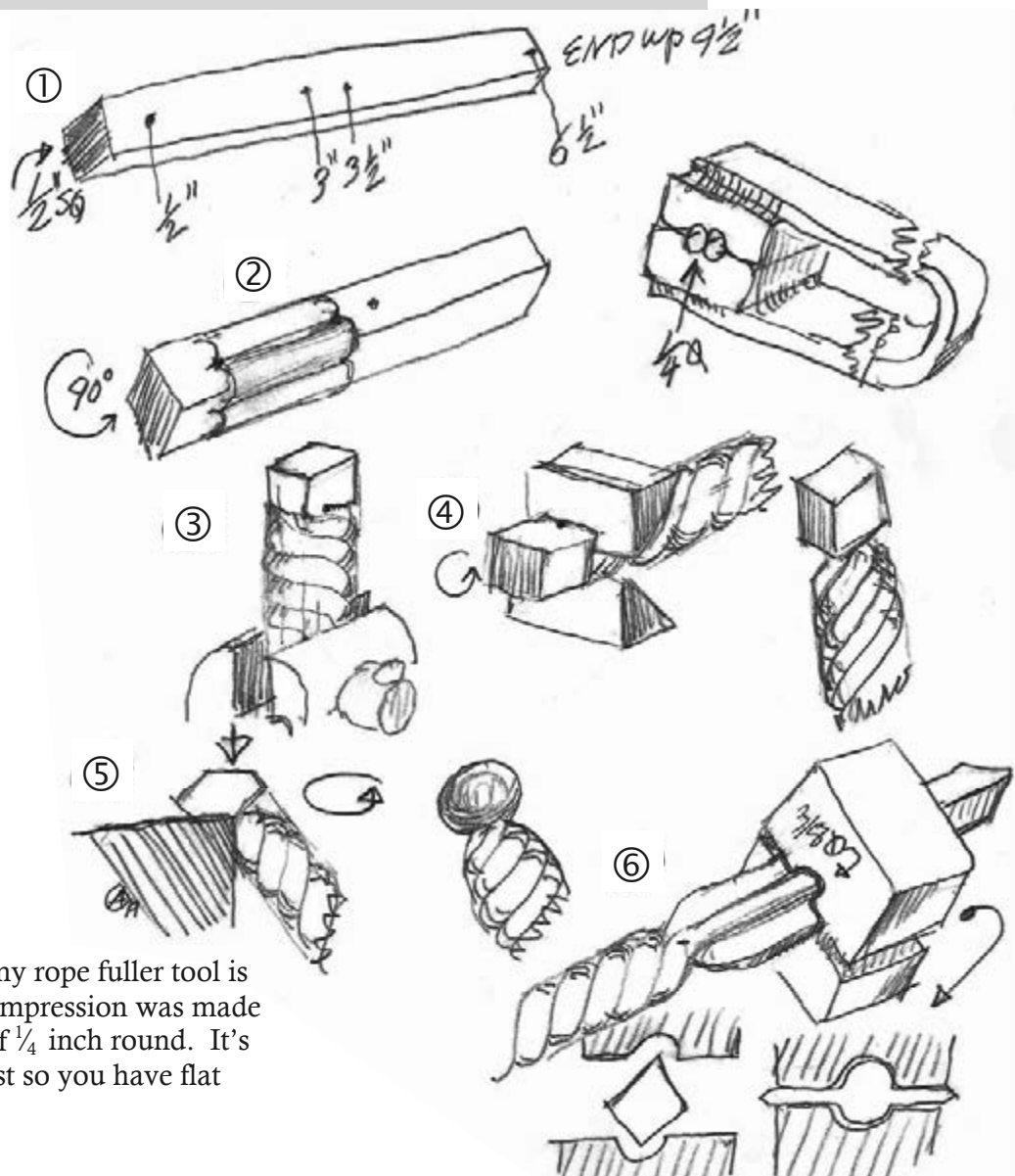
Reheat the bar and twist evenly. The effect is parallel to the long axis. The punch must be driven in deep enough to create two parallel chisel marks. Raised spiral ridges will form with pyramids in between. This is the Silberberg Twist.

This article is reprinted courtesy of the Michigan Artist Blacksmith Association "The Upsetter" newsletter Mar-Apr 2020. This is an interesting variation. It is obviously not new but I don't recall seeing one of these before. - Editor



Rope Twist Letter Opener

By Steve Alling,
a MABA member



1. Mark stock.

2. Fuller in the rope twist; my rope fuller tool is made of mild steel and the impression was made with a doubled over piece of $\frac{1}{4}$ inch round. It's important to do this step first so you have flat places to do your twist.

3. Make your rope twist.

4. Fuller in behind where the round pommel will be.

5. Form the pommel on the sharp edge of your anvil.

6. With a $\frac{3}{8}$ inch tenon tool run the blade portion through on the diamond, it's very important to be sure to maintain the orientation or the wings on either side won't be equal. This tool also was made from mild steel.

Note: You will see with some careful filing you can make it appear that two of the strands of the rope twist become the center of the blade on either side and the other two can be made to appear to form the edges of the blade. This will take a little creative filing; go ahead and file the end to suit yourself.

This article is reprinted courtesy of the Michigan Artist Blacksmith Association "The Upsetter" newsletter Mar-Apr 2019.

2020 Saltfork Conference Demonstrators

The 2020 Saltfork Conference demonstrators have been selected. Based on demonstrator availability and an online member voting survey implemented by Saltfork Director, Eric Jergensen, this year's demonstrators by popular demand are:

Brent Bailey
(California)



Joey Van Der Steeg
(Netherlands)



J.J. McGill and Eric Jergensen have arranged commitments from both demonstrators for the Conference. As with recent years, both demonstrators will remain after the Conference for workshops with a limited number of participants.

Details of the Conference demonstration and workshop topics will be posted once they are arranged. Stay tuned for more information in upcoming newsletters.

If you are not already familiar with these demonstrators, they both have a strong You-Tube presence. Just look them up by name. - *Editor*

CALIFORNIA BLACKSMITH ASSOCIATION *presents*

BEGINNER TO ARTIST

JOE KOCHES MEMORIAL CONFERENCE • FERNDALE, CA • APRIL 30TH—MAY 2ND 2020

Before Joe passed in September 2019, he brought together a group of world-class artists of the forge to show the scope of contemporary blacksmithing. His show will go on! We will have demonstrations, portfolio presentations, and two galleries,

including Joe's gallery containing one of the finest collections of contemporary ironwork. The CBA instructor team led by Mark Aspery welcomes everyone interested in developing their skills at the forge. Join us in Ferndale for Joe's dream conference.



Monica Coyne



Christoph Friedrich



Claudio Bottero



Pete Braspenninx



Kovarna (Pavel) Tasovsky

MORE INFORMATION AT WWW.CALSMITH.ORG/CBA-EVENTS



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JAMES HUSE

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8:00 AM

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ALL CLASSES OPEN, VENDORS
SET UP, FOOD TRUCKS ON SITE

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FREE FOR CHILDREN UNDER 10

ENTRY DONATION TICKET USED FOR HOURLY
DRAWING FROM 10:00 AM TO 5:00 PM

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BOLSTERS & GUARDS

8:30 PM TO 10:00 AM

DAVE KOENIG

COPPERSMITH

9:30 AM

JIM POOR

**BLACKSMITH
FORGING TONGS**

10:00 AM TO 12:00 NOON

LEE BROTHERS

**STEEPHOLLOW FORCE
POWER HAMMER DEMO
BLACKSMITHING**

1:00 PM

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12:00 NOON SHARP!

LIVE MUSIC

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ABANA 2020 Conference



ABANA 2020 Conference

Washington County Fairgrounds
392 Old Schuylerville Rd.
Greenwich, NY

Information Available at

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We will be featuring 8 disciplines of Smithing with at least three talented Smiths in each.

ART: with Daniel Miller, Zeevick Gotleib, & Ellen Durkan

Historic: with Peter Ross, Dick Sargent, & Bob Valentine

TOOLS: with Patrick Quinn, Jeffery Funk, & Eric Schatzel

KNIVES: with Matt Parkinson, Lin Rhea, & Jeff Helm

POWER: with Bruce Jarrell, Steve Parker, & Randy McDaniel

FARRIERS: with Dave Farley, Roy Bloom, Tom Willoughby

TEACHING: with Mark Aspery, Gerald Boggs, & Randy Augsburger

FARM: with Joel Tripp, Judson Yaggy, Derick Glaser, & Lucian Avery

The Patient Order of Meticulous Metalsmiths with Tom Latane, Peter Renzetti, Carl Close & other exceptional craftsmen.

The lecture series will be featuring such notables such as Albert Paley, Howard Schechter, Doug Wilson, Bill Hochella, Leigh Morrell & members of the demonstrator staff.

There will be a youth teaching venue and family programs for the non blacksmiths.

The raffle will include a BAM box donated by Pat McCarty and a Big Blue power hammer.

The Iron in the Hat is pleased to announce the return of Len Ledet with his special blend of entertainment and wackiness.

The Saturday evening banquet is back with a New England style BBQ.

We will have a beer tent serving a local micro brew and a local distiller will be pouring our own signature Slack Tub bourbon. Collectable laser inscribed 2 liter wood casks can be purchased filled with our special label. See the website for information on the cask which can only be pre ordered and can only be picked up at the conference.

Early registration is now open at :

abana2020.com



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ABANA 2020 Conference

Washington County Fairgrounds
392 Old Schuylerville Rd.
Greenwich, NY

Information Available at

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ABANA Central Office
423-913-1022



Scheduled Activities

Demonstrations all day every day at our 8 demo sites. There will be a riveting lecture series featuring such notables such as Albert Paley, Howard Schechter, Douglas Wilson, Bill Hochella, Leigh Morrell, and others

Join the party at the Blacksmith Arms Pub serving local micro brews. We are proud to announce our own private label Slacktub Bourbon. Available by the glass, bottle or collectable 2 liter wooden cask. See the website for information on pre ordering the laser inscribed cask. These must be pre-ordered.

Breakfast, Lunch, Dinner will be available onsite from a variety of food vendors and food trucks.

There will be extensive tailgating, most under roofs. The northeast is the epicenter of the largest accumulation of blacksmithing equipment in the country. If you can dream of it, it will likely be at this conference

We are inviting all the vendors we have come to expect at an ABANA conference.

There will be nightly competitions organized by Mark Asperry to be held at the Teaching site

Of course there will be Iron in the Hat hosted by Len Ledet. We also will be having a large item raffle featuring a Big Blu power hammer and Pat McCarty is donating a BAM box once again for this event. An added bonus will be it is going to be filled with handmade tools from some of the finest blacksmiths in the country.

We are hoping for a strong outpouring of support for the curated gallery exhibition and hope to have items donated to the live auction of art & craft scheduled for Saturday night.

For this conference the banquet will be revived with a Saturday night BBQ northeast style, included with registration. Come and enjoy the warmth and fellowship of blacksmiths from around the world. This will be a party the likes of which has not been enjoyed at an ABANA conference in some time.

Don't miss what is sure to be an event that will be talked about for years.

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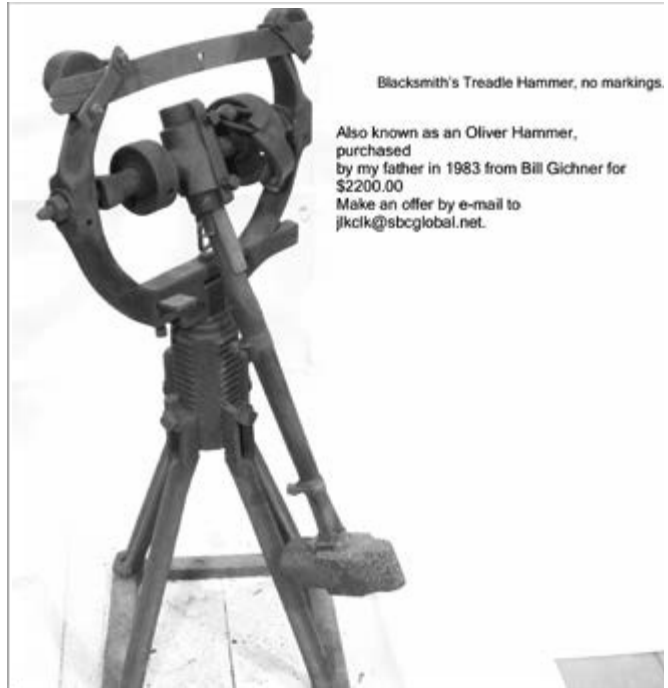
For Sale by James L. Kirkland, Jr. Contact by E-mail if interested.



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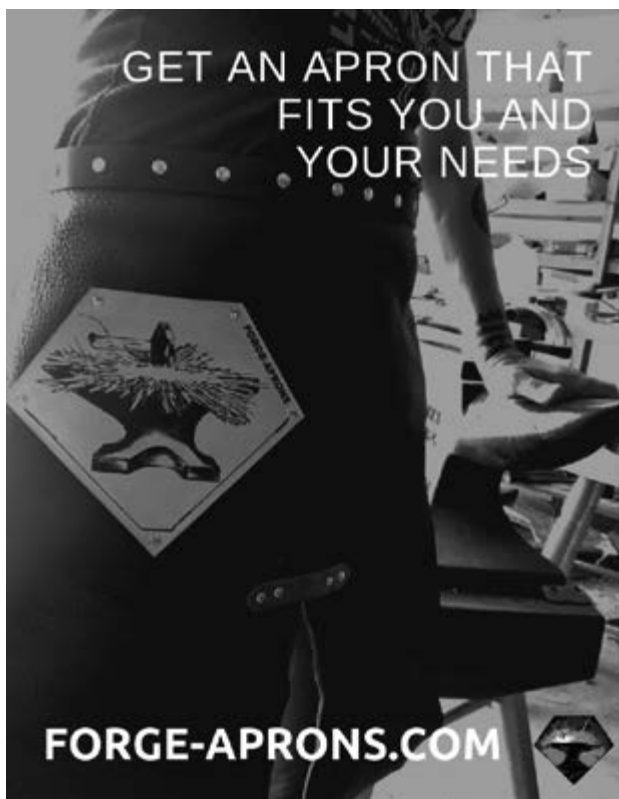
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This DVD is now available to members for a minimal cost (cost of DVD's is minimal to cover reproduction and shipping if applicable.) Contact the SCABA Librarian, Don Garner, if you would like to get a copy of this DVD.

Don Garner: 580-302-1845

(Call or Text. If you get voice mail, Please leave a message.)



For Sale:

Tire Hammer Plans by Clay Spencer

Send a check or money order for \$30 US to Clay Spencer, 73 Penniston Pvt. Drive, Somerville, AL 35670-7013. Or send \$32 US to Paypal.Me/ClaySpencer. E-mail me at clay@otelco.net. PDFs will be e-mailed outside US. Phone 256-558-3658

Beverly shear blades sharpened

Remove your blades and send in USPS small flat rate box with check for \$41 US to 73 Penniston Pvt. Drive, Somerville, AL 35670-7103.

For Sale: I have numerous old tools and collectible items of various kinds including blacksmith related tools and equipment. Too many tools to list them all. Inventory is always changing. Contact: Craig Guy (SCABA Member), Piedmont, OK
Cell Phone: 405-630-7769 (Call or Text)

SCABA Shop and Swap

SCABA Library DVD's Available:

This is a partial list of the DVD titles available to members from the SCABA Library. Contact the Librarian (Don Garner) if you would like to obtain a copy of any listed title or if you have questions on any other titles that may be available. Additional titles are listed on the website. DVD's are available for a very minimal cost to offset the blank disc and cases or sleeves. Shipping cost applies if you need these delivered by mail.

- Robb Gunter Basic Blacksmithing parts 1,2,3 and the controlled hand forging series
- Clay Spencer SCABA conf.2013 pts. 1,2 and 3
- Jerry Darnell 18th century lighting, door latches and hinges
- Brent Baily SCABA conf. 2011
- Mark Aspery SCABA conf. 2011
- Robb Gunter SCABA conf. 1998
- Robb, Brad and Chad Gunter 2009 joinery, forging, repousse, scrollwork, etc.
- Bill Bastas SCABA 2002 pts. 1 - 6
- Jim Keith SCABA conf.2007
- Power hammer forging with Clifton Ralph pts. 1 - 5
- Doug Merkel SCABA 2001
- Bob Alexander SCABA 2008
- A. Finn SCABA 2008
- Bob Patrick SCABA 2004
- Gordon Williams SCABA 2010
- Daryl Nelson SCABA 2010
- Jim and Kathleen Poor SCABA 2001
- Ed and Brian Brazeal SCABA 2006
- Ray Kirk Knives SCABA 2002
- Frank Turley SCABA 1997
- Frank Turley SCABA 2003
- Bill Epps SCABA 2003
- M. Hamburger SCABA 2007

Librarian: Don Garner 580-302-1845 (Cell)
Call or Text. If you get voice mail, please leave a message.

Have an Item for Sale? Item Wanted?

If you have any items that are appropriate for Blacksmiths that you would like to list in the Shop and Swap section (or items you are looking for), please send me your description, contact info, and any photos that you have.

SCABA Swage Blocks

\$200.00 plus shipping.
(Same price to members and non-members.)



SCABA Floor Cones

\$200.00 plus shipping.

(Same price to members and non-members.)

To order swage blocks or cones, contact our distributor:

**Nolan Walker at
Nature Farms Farrier
Supply in Norman,
OK.**

405-307-8031



SCABA Shop and Swap

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 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.

NW Region Coal Pile in Thomas:

Don Garner now has a new pile of club coal available for sales to SCABA members. The shop is at 23713 E 860 Rd in Thomas, OK. (One mile west, then one mile north of Thomas.) Contact Don at 580-302-1845 (Cell Phone) to arrange details for purchases.

NE Region coal location:

****NOTICE****

Charlie McGee is no longer hosting the coal pile in the NE region. If you would be interested in hosting a location in NE, let one of the SCABA Board members know.

S/C region coal location: Club coal is now available at Norman at Byron Doner's place. Call Byron to make arrangements to come by and get coal.

SCABA T-Shirts!

2018 Saltfork Collector T-shirts are available with the 2018 Conference Logo. \$20.00 (plus shipping if applicable.) Contact Josh Perkins to check sizes and quantities that are still available.



Legacy SCABA T-shirts and long sleeve denim shirts are also available on clearance while supplies last. T-Shirts are \$5.00 and Denim Shirts are \$10.00. (Plus shipping if applicable.) Contact Josh Perkins to check sizes and quantities that are still available.

If you would like to purchase shirts, contact Josh Perkins (918) 269-3523.



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SCABA Membership Application

For Annual Membership

(Please Print Clearly!)

Date _____

New Member _____

Renewal _____

First Name _____ Last Name _____

Married? _____ Yes _____ No _____ Spouse's Name _____

Address _____

City _____ State _____ Zip _____

Phone (Best Number to Contact) (_____) _____

e-mail _____

ABANA Member? _____ Yes _____ No _____

I have enclosed \$30.00 for dues for one year membership from the date of acceptance.

Signed: _____

Return to: Saltfork Craftsmen, 6520 Alameda, Norman, OK 73026

Note: Registration online by Paypal OR credit card is available from the website.

www.saltforkcraftsmen.org

You do NOT need a Paypal account to use your credit card and registration/renewal is immediate.



Saltfork Regional Meeting Hosting Form

Region: _____ NE _____ SE _____ SW _____ NW

Date: Month _____ Day _____ Year _____

Name: _____

Meeting Address: _____

Host Phone (Best Number to Contact) (_____) _____

Host e-mail _____

Trade Item: _____

Lunch Provided: _____ Yes _____ No

Please provide detailed directions and/or a map to meeting location if possible. Meetings are scheduled on a first come basis.

Return to: Saltfork Craftsmen Regional Meeting Coordinator, Russell Bartling

70 N 160th W Ave

Sand Springs, OK 74063

You can also send the information in an e-mail or text or fill out the online form available on the website in the top banner of the Calendar Tab: www.saltforkcraftsmen.org/Calendar.shtm

Saltfork Craftsmen Artist Blacksmith Assoc. Inc.
6520 Alameda
Norman, OK. 73026

Non Profit Organization
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Oklahoma City, Ok
Permit #2177

Address Service Requested

