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To: HABA Distribution List

Re: The Newsletter Of The Proposed Houston Area Blacksmiths' Association (HABA)

## INTRODUCTION

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## A NOTE FROM THE PREZ

### Barrington Living History Farm Project

A lot is going on! Heads up! Time is short! Mark your calendar for July 17 and 18! Spread the word to whomever you think is interested!

The big news is that HABA decided to accept the State of Texas invitation to make the hardware for the new Barrington Living History Farm at Washington on the Brazos State Park. HABA also agreed to share this invitation with all the other smiths and smithing organizations in Texas. These decisions were made at the May meeting.

The Barrington Living History Farm needs at least 17 pair of strap hinges in three sizes, 6 hasps and staples in two sizes, many nails in two sizes and a fireplace crane.

The invitation is out to TABA/Balcones, ETBA, NTBA and Pat Cheatham and company in San Angelo. I hope this invitation is getting passed along by anyone who has the ability to do so. Smiths from the Houston, East Texas and North Texas areas already committed to doing some work on this project. This is a great beginning. I am sure many more will get involved as the word gets out.

Celebrate Smithing in Texas! I think this is what we should call the weekend of July 17 and 18 at Washington on the Brazos State Park. July 17 is the Media Day at Barrington Farm. Print and electronic media are being invited to the farm for the sole purpose of letting the public know the smiths of Texas are collaborating with the state to complete the construction of Barrington Living History Farm.

On July 17 smiths already involved in the project or those wanting to get involved will have an opportunity to 'meet the press'. They will also have a weekend to work on the project, share their smithing skills and to learn something new.

The general plan for the weekend is to get some public exposure in the press, complete more of the hardware for the farm, demonstrate for each other and maybe talk about and plan for a regional smithing conference. In short this is a weekend for just the media and the smiths of Texas. Celebrate Smithing in Texas! will take place at the Barrington Farm location and the public is not invited. Washington on the Brazos State Park will allow camping in the park for smiths.

More details about the camping arrangements will be made available upon request and with copies of the final hardware design. See **Celebrate Smithing** in Texas! page 5, below for the latest status of the project.

The June 19 HABA meeting will be held at Tudor Forge. This meeting will focus totally on the Barrington Farm Project. Sample pieces of hardware will be available. You will have a chance pick-up the revised drawings and start some work. So, plan to bring your forge and don't forget your safety glasses with side shields.

### A MOST IMPORTANT ISSUE!

#### THE HABA MAILING LIST

The HABA Mailing List is going to get revised before the next HABA Letter mailing. Three people are looking at the mailing list. If these people do not remember your name because you were not at a meeting in a long time or you have not contacted us, your name will be deleted. **If you think HABA does not remember you, give me a call, send me a post card, a note or an e-mail and let HABA know you would still like to receive the HABA Letter.** It is important to HABA that you get the HABA Letter if you want it. Here is how you can get in touch with me:

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For those of you who will be dropped from the mailing list, we hope you enjoyed the letter and that you will let others know there is a place in the Houston area where they can learn a few things about blacksmithing. More importantly, we hope to see

your name on the HABA list in the future.

### **A HABA Logo**

HABA is looking for a logo. Do you have any ideas? We will talk about and maybe vote on a logo at the next meeting.

If you have an idea, please sketch it out and bring it to the next meeting. Or, just send it to me. The quality of your drawing does not count. The idea you are trying to get across does. Someone can take your rough sketch and turn it into the logo you have in your mind but can't quite get out the end of your fingers.

## **ARTICLE**

### **POWER HAMMER REBUILD**

By Fon Stonum  
Part 1 of 3

I originally purchased a 50# Little Giant power hammer in Albuquerque, New Mexico. Not knowing much more about them than being able to recognize one, I bought this one for \$800.00. My brother and I loaded it into my pick up and hauled it home to Dixie.

On the way I stopped by a high powered car wash and blew off about 70 years of heavy grease and grime to reveal that it truly was a power hammer. I got it home and unloaded from the truck, no small feat without heavy equipment. I then started to disassemble the thing only to find that almost every part and piece was worn slap out. This old baby must have been in use for the whole of its life. Hauled the small pieces off to the sand blaster and got them cleaned down to white metal, revealing more than I wanted, in that all the pin holes were brazed and re-drilled and worn out again.

At home I continued to clean and inspect the main frame and discovered after I got the old dies out that the bottom die slot was badly damaged and large chunks under the die had broken out. Worst of all there was a crack running down from the slot about 6 inches towards the floor. A large groan escaped my deflated ego and I wished I had inspected it a lot closer before buying it at this point. The welder inside me said "no problem, grind it out and weld it up", as I've done on countless welded fabrications.

So out comes the Black and Decker "Wildcat" grinder and I proceed to grind out a large "V" groove. When I could not see the crack any more, I got out the dye penetrant and checked for further crack indications. Once finally satisfied that I got it all I was amazed at the size of this new gash in the casting. Checking my welding manuals I found that welding cast iron was no easy task and enormous pre heat is required to the tune of around 600 degrees.

I broke out the trusty "rosebud" heating torch, rescued from an offshore oilrig repair job. It is as big as a beer can on the end. This baby uses so much gas that you need a tube trailer full of oxygen to use it effectively. Checking my home shop size bottles revealed about 3/4 full on both, so I reached for the striker. Once the thing is adjusted and burning it is only slightly less loud than an F-16 taking off, and the flame on the end is about the same size. Using this torch changes weather in local areas. I heated the base until the oil soaked in the casting was burned out and the lead paint was burning off. A Tempil stick indicator said I was close to the desired temp so I shut down the torch. I noticed my oxygen regulator was frozen over pretty good.

I grabbed up my welding gear and went after the gouge with gusto. I thought I would try to weld it with low hydrogen electrodes on the chance they might work. After about 4 passes I cleaned the weld real good and discovered the weld metal had a nice crack line down both sides of the filler metal. Not good. So I gave up on plan "A" and ground out the weld metal. I also noticed that by the time I was welding real well, the pre heat was way down due to the large heat sink of the base. Back to the drawing board.

I read up more carefully on welding cast iron and spoke to several "old hands" I knew. I got the straight skinny on welding cast iron. I needed huge pre heat and nickel electrodes, or a cast iron electrode, made exclusively for cast iron. I went to the welding store and bought the nickel electrodes, which are by no means cheap and a good supply of the cast iron rods too. My real dilemma was how to preheat the casting to get it hot enough and keep it hot enough to weld.

About here I lost the wind in my sails to keep going and the hammer set in this state for nearly two years. I was not going to spend any money on parts and pieces for it until I got the crack repaired and a new die slot made, which would mean a whole lot of welding and rebuilding just to get to the point that I could start rebuilding the rest. I was discouraged.

I spoke to lots of people and got several ideas of merit. The best one was to use a crawfish boiler and propane to get the preheat. I gradually got to the point of having a plan and the material to follow through with it. So I borrowed a boiler from a friend and got the thing jacked up on blocks to get the boiler under it and sifted through my welding rods to find my nickel and cast rods. Once all my stuff was assembled I fired up the boiler torch and then went to lunch while the casting heated up.

After about an hour of pre heating the casting was up to about 250-300 degrees, I then brought the heat up with the "rosebud" again. With the whole casting at an elevated temperature I did not have as much trouble keeping things hot while welding. I touched off with the welding and after each short pass I peened the weld to help control shrinkage. I checked at regular intervals for cracking and found none.

The casting is full of sand pockets and oil so welding is a challenge at any rate. Porosity and splatter are everywhere. I ground out the porosity that was real bad and left the small pores alone. Cleaning regularly to eliminate any slag. Since this is not a pipeline weld or going to hold pressure the quality of the weld does not have to be perfect, but should be as sound as you can get it.

Once I got the crack gouge filled and capped out I started on the large hole in the top. This hole was a result of a casting flaw. The die base is solid cast iron and this one was full of either carbon or casting sand, causing it to crack and break with the impact of hammering. After cleaning out all the sand/carbon that I could, I had quite a hole to fill.

Here I used a rather unorthodox method of welding that borders on casting itself. I gathered up all my rod stubs from the crack repair and inserted a few in the hole and welded over them to increase the filler metal. I also added some mild steel rod, borax. I cranked up the amperage on the machine to melt this. Using the arc as a furnace I melted the steel in with the nickel and cast rods. Since I was filling a hole I was not worried about full fusion as much as I was in the crack repair. This technique worked out fine. I filled the hole up and got excellent results with this technique. No doubt there are some inclusions of slag and porosity, but compared to the original casting I feel the repair is very sound. Keep in mind I am used to nuclear quality welds.

Now I had the bad part of the repair completed and was ready to move on to the rebuilding of the die slot. By the time I ground out the slot to a straight sided, flat-bottomed slot, it was 3 inches wide and 2 1/4" deep, with 3 pounds of grinder filings on the floor. Rigging up a curtain around the hammer base kept the filings localized and not all over the shop.

I had a block of 2" A-36 stock milled with a dove tail slot as wide as the hammer slot was, and to that configuration. I planned to replace the whole top of the base, but the welding and re-cutting of the slot came out good enough to cut the plate to 3" wide and add a 1/4" plate under it and install in the slot. The plan was to weld in the 1/4" plate at the bottom of the slot, welding it all around and cutting a slot in the middle of the plate to weld it to the center of the slot bottom.

This was all welded with nickel electrodes. The 2" milled plate would then be installed in the same manner and welded in position to the cast iron using the nickel rods and a slot cut in the bottom of the milled groove to weld it to the 1/4" plate and provide that much more welded surface. The slot weld would be done using mild steel electrodes (7018). This should provide a sound die block on the main base and provide years of good service.

The use of nickel electrodes on cast iron works well, as the nickel stretches with the cooling, unlike steel that shrinks and causes cracking in the cast iron heat affected zone. The cast iron electrodes are good too and in some cases better as they tied into the cast iron better than the nickel in the case of areas of high oil absorption. These electrodes are made by All- State and are classed as non-machinable. The nickel is a machinable electrode.

In summary, the phoenix has arisen from the ashes and what I thought could possibly end up a yard monument has started to become a tool once again. Now begins the work to get all the parts and pieces back together and a motor mounted and operational, but that's another story...Now, where does this big round thing go???

## **CELEBRATE SMITHING IN TEXAS!**

Following is a copy of the e-mail sent to officers of TABA/Balcones, ETBA, NTBA and Pat Cheatham in San Angelo. This will bring you up-to-date as the HABA Letter goes to press.

“June 5, 1999 This e-mail intends to update you on the Barrington Farm Project for Washington on the Brazos State Park and asks you to respond to some questions.

The update follows below.

The questions are:

1. Does your organization think it will participate in this project? If yes, what would your group like to do?
2. Would you please send me a press release or short description of your smithing organization?
3. Do you know of any individual members in your respective organizations who would like to make something for this project?

Note: This e-mail probably will generate more questions than it will answer. Please ask any questions you have, the easy ones and the hard ones. Keeping in touch with one another is the difficult part of this project. Making the hardware is the easy part.

#### MEETING - JUNE 2, 1999

A group of smiths met with the Barrington Farm manager, Bill Irwin, an interpreter Kristen Kramer and the architect, Dennis Cordes. The smiths are Tom Lundquist, Larry Newbern, Frank Walters, Jim Wheeler, Charles Heathcock and Dave Koenig. The meeting lasted about 5 hours. During this time we reviewed sample pieces of hardware from HABA, ETBA and NTBA, reached a common understanding of the design and the quality of work the State of Texas would like to receive and inspected each building where the hardware will be installed.

We learned that the quality of the hardware presented was most acceptable. The design of the hardware will be changed a little to fit the site better. For example, the strap hinges for the kitchen and the front gate will have a button. Other hinges will have a more simple design to be re-drawn by Dennis Cordes. All sharp corners on the hardware should be broken with a hammer. We made some decisions about pintle sizes and pads. Any modern welding technique is acceptable as long as it is not obvious. All pieces must be identified by maker(s) and the year. The park would like to have a little bio of each smith along with a description of her or his mark, if a mark is used. Each piece of hardware with more than one component needs to be tagged and bagged together.

Changes to the original drawings are expected from Dennis Cordes the week of June 5. I will get the changes out to you as soon as I receive them.

The Media Day at the Barrington Farm is confirmed for July 17. Any smithing organizations/smith who would like to work on this project at the park is invited to do so. Smiths working on this project are also invited to camp at Washington on the Brazos State Park the weekend of July 17 and 18. The Media Day itself, the 17th, will be the big opportunity to show the people Texas that smithing is alive and well and that this vitality is due in part to the HABA, TABA/Balcones, ETBA and NTBA organizations.

Right now the thought is to use the weekend of July 17 and 18 to come together for the following reasons: 1. To present as much completed work as possible to the Barrington Farm. 2. To use the weekend to work-on and complete more of the remaining work for the park. 3. To meet and learn from smiths from different parts of Texas. To create some pieces that are not on the original list of hardware. For example, a pasture gate at the barn needs some kind of sturdy hinge. Making the hardware for this gate that is historically correct and unique is a challenge to any of us who want to accept it.

Bill Irwin would like to see hardware completed in this order of priority: Kitchen, Smokehouse, Slave Quarters, Barn and Gates. All the hardware should be completed in the August/September timeframe.

As a result of the meeting, the following pieces of work are assigned:

Tom Lundquist agreed to make all the nails, 1/4-inch square for H1 hinges and 3/16 Th inch for H2 and H3 hinges.

Larry Newbern agreed to make the fireplace crane, C1.

Frank Walters agreed to make the four surface bolts, L7.

HABA agrees to begin work on all the Kitchen hardware, except the nails and crane.

The next step is to obtain commitments from smithing organizations and individual smiths to make hardware for a particular structure, door, shutter or gate. If your organization or if you know an individual who would like to commit to building some hardware, please let me know. We can talk about particulars later.

Please Note! Work on hinges for everything but the kitchen and front gate should not begin until the revised drawings are

obtained from Dennis Cordes. The size of the H1 hinges and the design of all the other hinges will be changed from the drawings I sent to you earlier.

Please forward this e-mail to other officers in your organization and copy me so I can get their e-mail address.

If your organization intends to participate in this project please let me know. I will also need a press release or short history of your organization. This information will be sent to the media and will probably be used to put together some kind of general press release about smithing in Texas.

I am sure this note is generating a lot of questions. Please ask your questions no matter how simple you think they may be. The only way we are going to get this work done in a timely and enjoyable manner is to communicate. Building the iron will be easy compared to the task of making sure we understand one another.

Any ideas you have about making this project proceed more smoothly are always welcome.

Your ideas about how to make the Media Day weekend as enjoyable and productive as possible are needed too.

Take Care,"  
DAVE

## **HABA MEETINGS**

### **MAY HABA MEETING SUMMARY**

A big welcome to Guido Schindler and Lloyd Miller, new members and two guests Christian Dindlisbacher and Maxine Miller.

The meeting got underway about 9:00. Twenty-two people attended. Larry Hoff, Charles Heathcock, Frank Walters and Dave Koenig had a forge going. The Show-N-Tell area was filled with great things like some big copper leaves Keri Phillips made. Mr. Stallones brought some of his 'Rustic Inept' furniture, a desk, chair and bench. Frank Walters made several copper and iron cooking utensils. Jim Wheeler and Tim Cowden rigged-up a functional forge in the ground in a very short time. The forge used Tim's small bellows. There were a few new books some old forged chain and a forged pot. As usual this part of the meeting area generated a lot of discussion.

The meeting was quite productive. After some discussion, HABA agreed to accept the State of Texas' invitation to make the hardware for the Barrington Historical Living Farm at Washington on the Brazos State Park. After more discussion HABA agreed to invite other smiths and smithing groups in Texas to participate. These decisions resulted in a meeting on June 2 with the park manager and project architect. The specifics of the meeting can be found in the Celebrate Smithing in Texas! section below.

On one hot Sunday afternoon just prior to the meeting at the park, Charles and Sharon Heathcock, Larry Hoff, Jim Wheeler and Dave Koenig met at Tudor forge and made a few additional hardware samples to take to the June 2 meeting. These samples along with the ones from ETBA and NTBA were most helpful. These samples showed we could do the work and were a big aid to make sure we all understood what was required.

Frank Walters reminded everyone about the Oldenberg Hammerfest selling event on October 1,2 and 3. Frank also let everyone know that Traders' Village would like to see smiths demonstrating at some of their events. A smith would not be charged to sell if (s)he demonstrated.

Larry Hoff, Charles Heathcock and Dave Koenig will review the HABA mailing list and cut names of people we have not heard from in a very long time. To stay on the list, people just need to let us know. This will be the last mailing before the cut is made.

Jim Wheeler put together a great lunch of bread, sausage, beans and cold slaw.

Revenues for the day included \$ 45 from the food, \$91 from the HABA Hat and individual donations. After we paid all the

bills the HABA coffers increased \$1.50 to \$608 and a little bigger fist full of change

### **JUNE HABA MEETING**

The June 19<sup>th</sup> HABA meeting will be held at Tudor Forge where the power and light are always free. The light is from the sun and the power is from the people who come.

**Everyone needs to bring something to the June Meeting.** Something includes: a bite to eat, a forge if you have one, a pair of gloves if you would like to forge iron and most importantly, a pair of safety glasses with side shields. Something to raffle off at the end of the meeting would be welcome too. HABA will provide water and soda for the meeting as is customary.

The June meeting will focus on demonstrating how to make hardware for the Barrington Living History Farm Project. This will be an exciting meeting.

#### **Directions To Tudor Forge –June 19**

Take 249 NW from Houston. Travel through the towns of Tomball, Decker Prairie and Pinehurst. At Pinehurst, 249 changes to 1774. Stay on 1774. About three miles ahead on 1774 look for a Texaco station on the west side of the road. One half mile past the Texaco station, turn left or west on Tudor Way. You will find the forge about a mile down the road.

From the intersection of 1488 and 1774 in Magnolia, go south on 1774 about 4 miles. Look for Tudor Way just after the Country Jamboree building. If you see the Texaco station you went too far.

### **JULY HABA MEETING**

The July HABA meeting will be held in conjunction with Celebrate Smithing in Texas! at the Barrington Living History Farm in the Washington on the Brazos State Park. Celebrate Smithing in Texas! will be a two day event to demonstrate that smithing is alive and well in Texas as an art and a craft, to complete some of the hardware for Barrington Farm, meet some new smiths and learn some more smithing techniques. Camping will be available at the park and there are local motels in Navasota, TX. Two motels on highway 6 are: Super 8, 409-825-7775 and Cedar Creek Inn, 409-825-8000. The Vanguard Inn is on Business 6 in town, 409-825-6497.

#### **Directions to Washington on the Brazos State Park, July 17 and 18**

Washington on the Brazos State Park is located in the town of Washington, TX a mile or two south of highway 105 between Navasota and Brenham. From Houston take 290 west. Highway 290 joins with highway 6. Stay on highway 6 all the way to Navasota. Exit highway 6 at 105 west. Take 105 through Navasota about 6 miles. Turn South a mile or so after crossing the Brazos river. There are plenty of signs directing you from 105 to the park.

From 290 west to Benham, do not continue on 290 around Brenham towards Houston. Continue straight ahead. Highway 290 straight ahead becomes West Main through downtown Brenham. On the east side of Brenham, West Main intersects with Embrey Street that is 105 East. Turn left on Embrey and continue east on 105 about 15 miles. Look for the signs along 105 to the park. Turn right from 105 and come to the park.

#### **SPECIAL THANKS**

To Jim Wheeler for preparing almost all the food and demonstrating that a functional forge can be made simply.

To Mrs. Lucy Wheeler for preparing the cold slaw using the original family recipe.

To every one who came to the meeting.

#### **OTHER SMITHING MEETINGS**

### **The Blacksmithing Fellowship – April 1999**

By Keri Phillips

Roger Allen owns The Old Chicken Farm Art Center in San Angelo, TX the location of the annual Blacksmithing Fellowship

put together by Pat Cheatham and co-sponsored by Mr. Allen. A clay master, Roger has experience with just about every other medium as well. At the farm, Roger runs a full production pottery studio, on site gallery, and clay workshops. In addition, the old chicken coops are renovated into excellent artist apartments and studios.

All this makes for an unusual atmosphere. People gathered for an herb luncheon at one of the studios described the "letting the world pass them by" feeling. The community/family feeling went over the top for me when a woman I just met left me her warm coat to wear.

The annual Blacksmithing fellowship thrived in spite of the last minute scheduling conflict and chilly weather. All the die-hard regulars were there. Pat Cheatham, owner of Concho Forge, provides/sets up most of the equipment for the event and feeds us. Pat made things run smoothly and took time out Saturday to demonstrate a 19th century style rush/candle holder.

Joe Jay, a diesel truck mechanic/wild flower lover, put his digital camera to good use recording events. He has experience with scrap materials and explained in detail how to make a tie-rod hot-cut chisel. (A copy will be available at the next meeting). He also explained how to turn a broomstick, a wood screw and a large washer into a handle for a speaker magnet, making it more user-friendly when determining critical temperature.

Wendell Barber, laboratory director of Permian Basin Metallurgical Laboratories in Odessa and owner of The Barber Shop, was very knowledgeable. During the week he works as a kind of metal coroner--investigating why industrial materials fail and evenings/weekends he takes a more hands on approach in his own Blacksmithing shop. He put together a useful booklet covering: steel nomenclature/classification, scrap/composition, and temperature/heat treatment (A copy of the booklet will be auctioned off at the next meeting). Wendell demonstrated several animal head handles (dragon, dog), a tie-rod hammer, a wedge for an old hammer, and a metalsmithing hammer (for me). He had quite a collection of neatly organized hand made punches and ball peens of every size. Wendell highly recommended "sucker rod" for making punches and The Complete Modern Blacksmith as a resource.

Randy Kiser, owner of Kiser Iron Works in Paint Rock, has welded for about 14 years and smithed for the last 7. His photograph portfolio of commissions was so large it looked like the work of several people. Randy brought several masterful candle stands about 18"-36" tall. Constructed from loose corkscrew shaped, tapers with reverse twists travelling upward and discs at the top/bottom, the stands were in perfect proportion. His other work was equally skilled. Randy mentioned the Golden Section rule as an aid for design proportions. The basic idea behind the rule is "a rectangle where the longer side is equal in length to the diagonal of a square the side of which is equal to the shorter side of the rectangle: a 5 to 8 ratio."(Excerpt is from The Artist's Manual). I think many people use this proportion intuitively.

B. W. Burnett, or The Saxon Steelsmith, owns a shop in town and brought examples of armor. He makes quality, partial and full-sets of armor in mild steel and stainless and also carries a selection of chain mail made by a friend. The finger-covers were made two ways, partial (just the top with a leather glove attached) and full articulating joints. It was quite an experience to slip your hand into wearable sculpture. B.W.'s extensive portfolio of finished suits really captured the imagination.

There were many more wonderful people who stopped by to work and hob-knob but unfortunately not enough time to get to know everyone. I was genuinely impressed by the warm welcome we received and plan to become a regular myself.

### **LAMA Gas Forge Workshop**

On May 8, Dave Koenig stopped by a gas forge workshop in Picayune, MS on his way to Atlanta. This was the second workshop Chuck Robinson conducted for the Louisiana Metalsmiths' Association. The workshop was over subscribed and required two sessions.

They were building two different Don Fogg style forges. One was horizontal and the other was vertical. Each forge is big and heavy and functional. Each one has two forced air burners, a cast refractory floor and wool on the walls. Chuck got all the materials together and the new forge owners learned how to put it all together. It seemed that most had a good start when the meeting broke up.

It was really good to meet some new smiths and see Chuck Robinson, Dave Mudge, Fon Stonum, and John Perilloux again.

The real eye-opener during the visit was to see Chuck's six-sided shop with a jib crane right in the center. The shop roof was suspended on the vertical crane post. The roof connects by cable to the six wall posts. When the crane makes a lift, three wall poles are in tension and three are in compression. If you ever get by that way, you might give Chuck a call and see if you can take a look at that unique piece of engineering.

### **Balcones Forge Meeting**

Frank Walters and Dave Koenig attended the Balcones Forge May meeting in Hunt, TX. The meeting was held at Gary Hilton's new shop. Gary was a big help getting HABA started and demonstrated for us last May, just before his move to the Hill Country. He has a beautiful home and shop lay--out on top of a hill.

Gary's demonstration was forge welding. He demonstrated two welds that he uses to make his fireplace sets. He made it look pretty easy. There were a number of good Show-N-Tell items and lots of good conversation. Gary Evensen, Jerry Achtenberg, Lee Catlow, Neil Hastings, Vince Harod and Charles Stolte are a few of the people there some of you may also know.

After lunch everyone got a real treat. We reconvened at Givens Metalcrafts, a shop just outside of Ingram and a few miles from Gary's shop. Bill Givens, the smith, welcomed all of us like long lost relatives. Bill does some really fine design and fabrication of custom ornamental ironwork. His work is massive and has mostly welded connections. One thing that strikes you is that each weld is cleaned-up. The big bed he had in the shop almost looked like it was forged from one piece of iron.

Bill's shop is a site to see. It is well laid out, and just begs a person to start working.

Frank and I had one more pleasant surprise on the way through Ingram heading home. We stopped at the Guadalupe Forge, at the Y in Ingram. Rick and Sheri Ross were open for business. This was the first time to see Rick in many years. Rick makes and sells a complete selection of hand forged knobs, handles fireplace tools, branding irons, hooks and more from three retail locations. Rick and Shari also have a great collection of travelers that is worth seeing too. The travelers are right next to a round cast iron bellows.

It was quite a treat to see three really fine shops in one day. Each shop is setup and designed to create a different kind of work. It is hard to describe the value visiting other shops and talking to the smiths. Don't pass up an opportunity if you help it.

## ODDS AND ENDS

### Color and Temperature

How hot is a color? Well that all depends on many variables. Disregarding all the variables, below is a description of colors by temperature from *Forge Craft*, a book by Charles Philip Crowe, 1913, reprinted by Lindsay Publications 1993.

Here are the Hot Colors from one chart. All temperatures are in degree Fahrenheit. "Dull Red 1022: Full Cherry - 1292: Light Red - 1562: Full Yellow -1742: Light Yellow-1922: Very Light Yellow-2012: White-2102, p. 111".

Here are the tempering color temperatures for carbon tool steel. Again all temperatures are in degrees Fahrenheit. "No Color - 300: 1. Yellow Colors = Light Straw - 400: Straw - 425: Orange or Gold - 450: Brown With Red Spots - 480: 2. Red Colors = Red - 500: Wine Color With Blue Spots - 530: Purple - 550: Violet or Peacock - 565: blue with Red Spots 580: 3. Blue Colors = Blue - 600: Changes to Gray or Green 625 to 650. Shows Red Heat in the Dark. 750, p. 158".

### Tips for Travelers to the Annual Blacksmith Fellowship, San Angelo, TX

800 miles is a long way to travel for a smithing demo especially without air conditioning.

Texas weather is unpredictable; pack a sweater even in May.

Set up your display table upwind from the forge fire.

Do not stand under tent support poles in windy weather. It hurts when they fall.

Control the urge to over-pack. Pick and pack for only one demo/technique, as there is always more to learn.

A tape recorder would be very handy to catch simultaneous demos.

The drive up Texas highways 290 and 71 is loaded with spectacular wildflowers in May.

## COMING EVENTS

**Celebrate Smithing In Texas! - July 17 and 18, 1999** Celebrate Smithing In Texas! is a weekend of smithing at the

Barrington Living History Farm at Washington on the Brazos State Park. This will be a gathering of smiths to create hardware for the Barrington Farm now under construction. July 17 is also a Media Day at the farm to show and demonstrate to the print and electronic media that the art and craft of blacksmithing is alive and well in Texas. For more information contact Dave Koenig, 281-855-2869

**The Oldenberg Hammerfest** – October 1, 2 and 3, 1999. Blacksmiths around Texas and the U. S. will have an opportunity to sell their wares on a five-acre plot of ground near Oldenberg, TX. This selling opportunity is serendipitous and will take place in conjunction with the Round Top Antique Show. This annual event brings about 200,000 buyers and as many as 1,000 sellers to the Round Top, TX area two times per year.

For more information about this developing event call Frank Walters, 713-896-7566 or Larry Hoff, 281-890-8822.

**Banging on the Bayou – 6**, the Louisiana Metalsmiths' Association annual event takes place on October 2 and 3, 1999. The meeting location is Bogue Falaya Park in Covington, LA. The demonstrators will be Bob Bergman and Jim Hrisoul. Bob Bergman will be demonstrating his KA-75 Air Hammer. Those of you who had to miss the February HABA meeting can see Bob's demo in Covington. Jim Hrisoul, a world-renowned master blade smith, will share some of his secrets.

#### **FOR SALE**

Frank Walters has bees wax for sale. The cost per pound is \$3.25. It will be sold on a first come first served basis. Frank's number is 713-896-7566.

#### **THE FINE PRINT**

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