On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD

INSIDE THIS ISSUE

Gate by Jason H. Anderson

Happy New Year fellow blacksmiths!

I do hope this one is better than the last. We sure are living in interesting times and it's getting harder and harder to not let the real world overwhelm me with the crazy stuff happening out there. Adding to the list, the meeting for February is cancelled. The infection rate is just too high to accept the risk. I know you guys are disappointed, as am I, but we have to err on the side of caution so we all can see the other side of this damn pandemic...

The JCC Folk School has opened up their class schedule for the year with reduced class sizes. I believe they are limited to 6 per class so register early if you want a spot. I have taken around 10 classes up there and I can't recommend it highly enough. I haven't brought it up in a while but for the new members our guild is one of the more generous ones out there in terms of scholarships. If you'd like more information about what we have to offer, email one of the officers on page 11 of this newsletter.

In personal news, I am currently building a new shop! I had a contractor build the outside shell and I will finish the inside. We started this thing back in March but with all the rain and material supply issues I am thankful it's almost done 9 MONTHS later! I currently work 50 hours a week so I am budgeting 2 more months to get the building ready for work. In the future when all this is settled I do hope to be able to hold workshops and private lessons there.

May you all find some time to get out to the forge and make something, be it memories with the kids or a fine art masterpiece! Our new member, Jim Carothers now living in Greenville, has suggested that we have a tong exchange for next December. You have to have made the tongs you wish to exchange, so you might want to practice so that the recipient of your tongs will be excited.

Pray for out sick and infirmed members, especially Past-president Mike Tucker.

New members since the last newsletter are: Bobby and Philip Blackwell, Carter and Matt Heim, and Jack Hurley

Here's to warmer weather and happier times!

All the best!

Jody

Since many of you pay in person at meetings, I know not having a meeting since last February may have affected your remembering to pay dues. There are approx 60 members who have not paid 2020 dues. This newsletter could be your LAST NEWSLETTER if I do not receive 2020 and 2021 Dues before the next newsletter goes to the printer (approx 3rd week of Mar). Look at your address on the last page, next to your name for your dues status Ray Pearre

We published the Robb Gunter anvil repair last year, but here is our new member's report on his anvil repair. Barry

Anvil Repair Jim Carothers

Outlined here is the basic method we used to repair Peter Wright type wrought body hard top anvils. This method is not for cast iron anvils.

Note: There is a lot of good information about anvil repair on the Net and there is even more bad information out there too. I am a pretty fair welder and a 40+ year experienced Mechanical Engineer with a good background in metallurgy and material science. I did not make any changes to Robb's procedure, nor did I let the welding shop hands sell me a different kind of welding rod that "would be just as good". I ordered (and waited for) the Stoody rod outlined in the Robb Gunter / Carl Schuler method.

I did do quite a bit of practicing with these special (expensive) welding rods and made an adapter plate for my automotive engine stand so I could position the anvil for easy welding (it shows up in one of the photos). I also used run-off tabs on the ends of the anvils so that my welds were started and stopped off of the anvil itself. The run-off tabs are removed after all the edge welding and grinding is completed. I've fixed about 5 to 8 anvils for myself and for members of the Saltfork Craftsmen ABA. This is expensive and labor intensive work.

Expect to take nearly a full day to clean (sand blast), grind, preheat, weld, grind, etc. for moderate repairs (like what you see in these photos). If you plan to overlay weld an entire top; it may take several days. I've done one big anvil (entire top) for a friend. We did the first build up one day; let the anvil cool; ground it pretty smooth; and then did the air hardening tool steel weld buildup the next day. The anvil was finish ground the following weekend -- all hand grinding.

Expect now (2012) to spend $8 to $12 per pound for the welding rod. A 10-pound box of each was the minimum I could buy; that purchase cost me about $140 in 2012, but was enough rod to repair several anvils. This is hard work and it's not cheap.

Start: The broken or chipped areas are identified and ground out for repair. Areas to be welded need to be clean; sand blasting works well. This is especially recommended around the hardie and pritchel holes. Sand blasting will clean out pitted areas that can be welded over and reduce initial grinding time. When grinding watch closely for cracks. You need to chase and grind out all the cracks you see. It is OK to grind down into the base, wrought iron, to remove a cracked area. We used 4" and 4-1/2" electric grinders and a sand blaster for the prep work.

The mass of an anvil and the chemistry of the hard steel top plate require preheating before welding. Preheat the entire anvil to 350^F to 400^F before starting. We used propane fired weed burners directed toward the side and base of the anvil. Do not concentrate the preheat fire directly on the face. Heating the face much over 500^F can take out the original temper and reduce the hardness. Plan on taking an hour or so to preheat a 100 to 130 pound anvil. Move the burner(s) around the anvil to get a good uniform (soaking) preheat.

Welding: (Basic Robb Gunter & Karl Schuler Method)

If you have ground into the base (wrought iron) of the anvil, use at least 1 pass of E7018-A1 electrode to butter this area for additional weld metal buildup. I recommend a stringer bead type welding technique with a slight weave to the make a weld metal deposit not over about 1/4 to 3/8" wide.

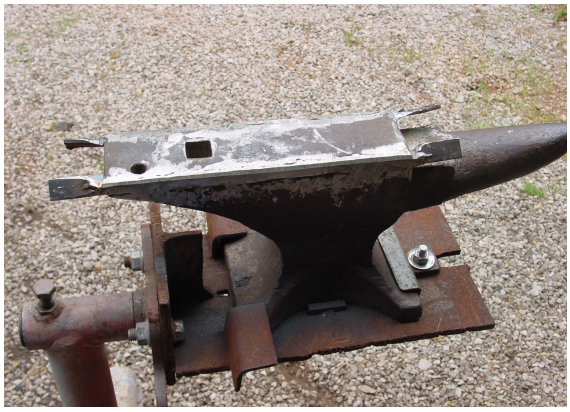
Use a pneumatic powered needle gun, chipper, or heavy wire brush to clean and peen the area between welding passes; do this hot. Heavy air needle gun peening after welding will start the work hardening of the high impact, build-up, weld metal deposit.

Try not to do all the welding in one area at a time; skip around to other areas to be repaired or wait a few minutes before additional buildup. This will help to keep the temperatures down and reduce the chance of drawing the original hardness out of nearby areas.

After the wrought iron area has been buttered with E7018-A1, use Stoody 2110 for additional build up. This is a high manganese, work hardening, build-up rod that also has a high chrome content. It has very good impact / shock resistance and so makes a good base for finishing with a tool steel rod. It runs about like E7018 and build up is very easy. We used 5/32" electrode run at about 160 Amps – DC Reverse polarity. Air needle gun peen and wire brush between passes.

When the repair area is nearly up to finished height – three more passes to have enough for final grinding and clean up. Change to Stoody 1105 electrode – 1/8". This is an impact resistant tool steel rod that is a good match with the original anvil hard top steel and the 2110 chrome / manganese build-up rod. The 1105 rod is more difficult to run; it tends to flow. Running stringer beads with less weaving of the rod helps. I also found it helpful to put soap stone guidelines across the anvil face to keep the width of the deposit down to about 3/8". Try the Stoody 1105 (1/8" size) at about 150 Amps; again, use DC Reverse polarity.

Grind: Finish grinding the anvil while it is still hot. We used a heavy, hand-held, 7", right angle, pipeline grinder. To help keep the anvil face flat, we tried to avoid using the edge of the grinding disk; the disk was kept flat to the anvil face.



Additional build up of small areas, after grinding, can be continued with the 1105 rod – usually the edges. Radius the edges to suit your taste and polish the face with a flapper type grit disk.

It is my opinion that a smith's best money spent is for a new anvil or one in very good shape that does not need welding repairs. Further, an anvil that is not too badly damaged can be used as is with only grinding of the edges or selectively using areas that are still OK.

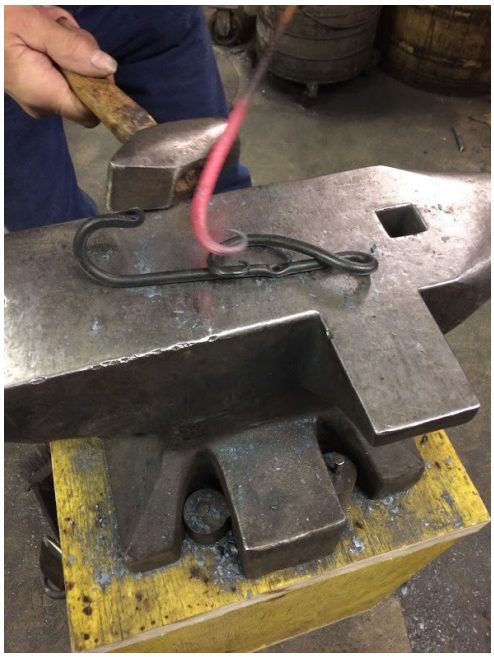
While Jim may not be as good as the guy shown in this **1916** advertisement . His plans and methods add to the Gunter method that has proven to be true and withstand the test of time.

I found this on the internet someplace and hoped you would find it interesting. Barry

Not seeing the Content you want? Submit requests for the kind of info and articles you are interested in, or better yet, submit an article yourself!

Treble Clef Coat Hook - Demonstrated by Elmo Diaz

A good way to hone your bending skills is to make a Treble Clef Coat Hook. Start with a 5/16" round stock approx. 15" long.



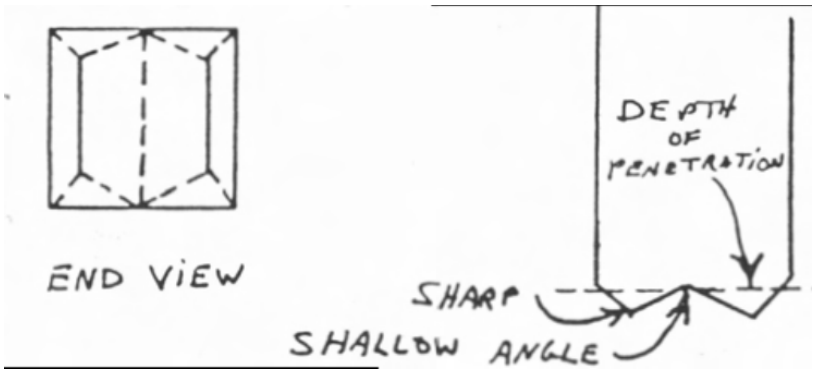
Start by tapering one end down to a dull point. Then start bend-ing to form the bottom curve of the treble clef. Make a sharp curve at the top of the clef keep-ing a nice radius. Then bring the tail of the clef, down behind the clef symbol. The size of the treble clef is approx. 2" wide by 4-1/2" high.

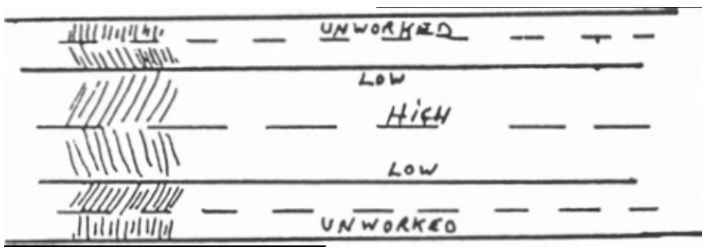
Draw the tail down to a dull point. Make a tight curve backwards over the anvil to form the end of the hook. Bend the stem forward over the anvil to form the coat hook itself.

Reprinted from the Prairie Blacksmiths Association

Silberberg Ornamental Twist

Prepare a square-faced punch 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 *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 forded into a square bar is a good way to see how well the punch will work before you spend time hardening and tempering. ***1/4*** inch from each **edge.** There should be **1/8** to 3/16 inch of un-worked 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. Reheat and rework each side until it looks correct.

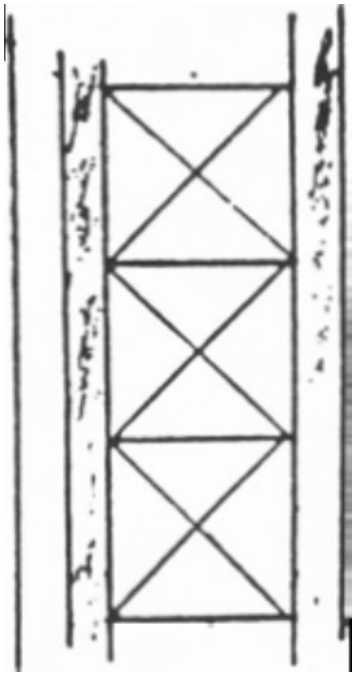




Reheat the bar and start chiseling in marks perpendicular to the previous marks. This should leave shallow pyramid shapes. Do this to all four sides of the bar.

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

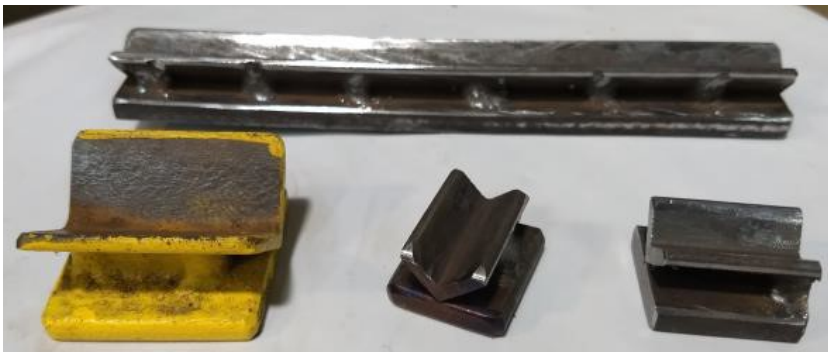
Reprinted from an article by Jan Kochansky in The Newsletter of the Blacksmiths' Guild of the Potomac, Jan./ Feb., 1991.

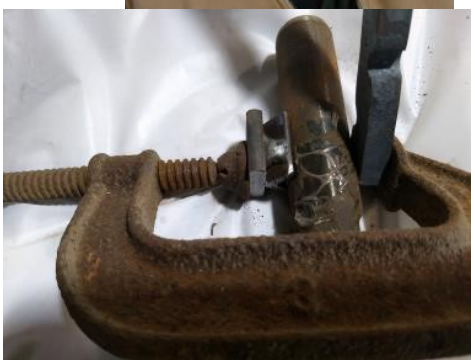


You "C" I Need Help! By Phil Travis

If you know Phil...well, help is on the way! Weld these handy holders together to secure round stock. Safety is always important!

- Angle Iron pieces welded together to flat stock makes a small "V" block.
- Aids in clamping round stock
- Can be superglued to pad(s) of "C" clamp
- Weld length of angle iron to flat stock, then cut off 3/4" to 1" sections
- Typically made of scrap stock, 3/4" to 1" wide X 1/4" thick flat stock and 1/2" to 1" angle iron





A Hold Down That Means It! By Phil Travis

Phil Travis shares this hold-down who's originator he credits to Dan Houston. It sacrifices a few tools you may have in the shop, but they will be recycled into good use. You can use a pipe of a smaller diameter if you choose. The vise grips needs a half nut welded to each jaw to secure the bottom. Try it!

Left: Hold down in place, ready to work!

Center: All parts and tools you need to prepare and sacrifice for this hold-down.

Above: Half nut welded on vise grips.

I have reprinted Phil Travis' shop tips many times in our newsletter. Thanks to Phil and to the ***Pittsburgh Area Artist – Blacksmiths Association*** for allowing me to reprint this article.

Knife Maker Dave Lisch's list of products and sources used and suggested:

• "Personalizer Plus" to etch blades, need a stencil of your desired touch mark. IMG Electro-mark.com sells stencils and machines.

• Black oil paint from an art store to stain Epoxy, use very small amounts.

• Bronze 1/8" pin stock from welding store, anneal if you are going to peen the ends. Make pin holes slightly oversized, #30 drill for 1/8 pins, #52 drill for 1/16th pins. 1/16" stainless 3/4" long pins used to alight guards, spacers and butt caps. Dave's came from Tacoma Screw, they are also easy to find online.

• Shop Rolls of one inch wide abrasive in different grits, use to finish handles. See TruGrit as a source trugrit.com

• Rhynowet Red Line sheets, water proof sandpaper from www.supergrit.com Use "easy-tack" spray adhesive to attach and trim excess; used on soft or hard discs. Also sell a large selection of other abrasives.

• Motors that go two directions, with discs attached. Dave puts variable speed and reverse direction controls on his machines. (*He gave a now, non-existant website. Ed.*), made in Oregon sell belt and disc grinders. Table mount reading lights improve visibility on grinders.

• beaumontmetalworks.com sells belt and disk grinders including KMG belt and disc grinders, and rubber soft backing pad for disc grinders. The belt grinder for the demo came from these folks.

• 3M Rolled Gold sand paper from auto body source, use on a sanding stick, one side stick hard, other soft. Hand sand is fi nal dressing of blade surface, available on Amazon.

• West System sells a marine grade 5 min. cure time Epoxy, available on Amazon.

• "Pop's knifes and supplies" popsknifesupplies.com belts and other goodies at very competitive prices.

• Rubber tape to give a "soft" back to abrasives. Dave likes the stuff used by glass installers and window repair.

• Knife steel, anhydrous borax, and quench oil, Kelly Cupples, 509-949-5231, will cut steels to specific lengths.

• Travis Weurtz TW-90 Grinder from Weurtz Machine Works, www.travisweurtz.com flips from horizontal to vertical and has a surface grinder attachment.

• Gorilla Brand duct tape, great for taping handles when grinding spacers or butt caps to a close fi t. Tape thickness is your safety margin.

• Camellia Oil keeps cutting tools rust free. Available from knife and wood working sources. Dave advises to not store knives in leather sheaths, leather can be a harmful environment.

Dave had a light duty disk grinder powered by an old washing machine motor. To duplicate, get a small fractional HP, 110 volt motor, mounted on a bench hook style base. Crack the case and cut the wire to the starter assembly, wrap cut end with electrical tape. When plugged in the motor won't turn, you have to give it a push by rotating the grinding disc in the direction you wish. IT WILL TURN EITHER WAY!

To complete the project, Harbor Freight sells two hook and loop disc bases. Both screw into 5/8" X 11 threads. Dave uses the large 7" size on the bench unit and the smaller size (5") on his angle grinder. Adapter unit goes from 1/2" motor shaft to 5/8 Threads. HF also sells the abrasives in 40, 60, 80, 100, 120, 180, 220,240, and 320 grits.

This edited partial article was reprinted from the Hot Iron News, Newsletter of the Northwest Blacksmith Association

Shop Tips

by Albin Drzewianowski

Files: Here is a handy way to clean a hand file. If the normal file card can't get out those two to three stubborn bits of steel stuck in the teeth of your file, take a large bullet casing (brass) and flatten the end so that you have two very sharp points (see photograph). Look for the largest shell casing that you can find. The one in the picture is 4" long. A large casng allows you to have a really firm grip on the tool and makes it easy to manipulate. This tool will allow you to pick out those really stubborn bits of steel in your file. The brass allows you to exert pressure without damaging the teeth of the file. (I cut the primer end off the casing and install a dowel rod into the casing to give a better grip. Barry)

File Cleaning Tool Photo by Albin Drzewianowski

Wire Brushing: This is a double "Shop Tip." At the 2016 Principio Iron Furnace Hammer-In, featured demonstrator Derek Kemper would soak his wire brush in water before he wire brushed the scale off of his work. I have taken to doing this on the final wire brushing when I am trying to get fire scale off my work. The water seems to make the fire scale "pop" off. I use a stainless steel wire brush. This has two advantages: being stainless steel, the bristles do not rust from repeatedly going into the water.

Also, I have heard from a number of different sources that stainless steel wire brushes, both handled and the ones that go on bench grinders do a better job because they are a harder steel and they last longer. They are more expensive, but I think they are worth it.

Reprinted from the **The Upsetter Newsletter of the Michigan Artist Blacksmith Association**

For those of you who are not aware that some of us have formed a knife makers group in the Upstate (for now)

Ben Secrist (ben@fieryiceforge.com) is one of the prime movers in this new group. Contact him if you want to join.

Their next meeting is Feb. 27th in St. Matthews, SC

A BIT ON GLOVES *By Jeff Reinhardt*

Having about 35 years of factory experience with either safety as a second task or as a primary task, lets discuss gloves. I have worn gloves in factories since 1970. I wore them in the military. I wore them skydiving and as a pilot and jumpmaster. I have worn them as a welder. I have worn them as a chemical response worker and as an asbestos abatement worker, last but not least I have worn them as both a blacksmith and in industrial forge shops. I have specified them and bought them for big factories where the budget for gloves was $100,000+ per year. That said, I do have some little experience with gloves. I have worn the terrible-rotten-no-good-worthless gloves that some purchasing manager saved "a ton of money on". I have worn good proper fitting gloves.

Most of the myths about gloves being dangerous came from bad glove choice and ill fitting gloves. I will s ay it is not a myth that one should not wear gloves when running lathes, mills and drill presses. Anything that has that much torque and exposed rotating parts is a glove no go.

Lets talk a bit about choices. I see folks wearing latex exam gloves for oily greasy work. Poor choice as they are attacked quickly by many oils and fail and then fail to protect. Nitrile exam gloves would be the choice there. And you can find this info out by googling “glove material chart for chemical compatibility”.

Lets talk about knit gloves. Many gloves are a type called String Knit. These are knit from yarn somewhat like a knit sweater and have that open weave appearance.

While these are a cheaper glove they have no chemical resistance since the chemicals can go straight through the open weave, they can offer a bit of cut resistance. They, even in a high temp material weave would be a poor choice for forge welding as the flux will go right through and if above 800F,and it will be well above 800F for welding steel the Kevlar decomposes and you have a bad burn. Great cut resistance, but no chemical protection. A leather palm on a string knit Kevlar glove is a great cut and abrasion glove. I once worked in a stamping plant where the edges were extremely sharp. The operators wore 3 pair of cotton poly string knit gloves for cut resistance. They tossed them at every break and in so doing used 12 pairs of $0.17/pr gloves a day. The poly melted to them when the got a weld spark, and they were tossing them as they were so cut up after 2 hours the hands were still getting cut. Replaced with a cotton Kevlar "Oven Mitt" that cost just under $3.00 a pair. No more cuts, the cotton content was enough to stop weld sparks before the Kevlar decomposed, and most could get 3 to 5 days wear. Now one hand surgery avoided would have paid for the difference but they lasted so long that they were quickly adopted. Owners were happy as their workers comp cost was lowered and their people were not being hurt. They also liked that several drums of gloves a day were not

going to the landfill. The people liked them as they could now work their shift and not be cut or burned and ohhh...by the way their arms and hands were less tired since they were not trying to grip smooth sheet metal through 3 layers of fluffy gloves. The cotton content also reduced that hand in a plastic bag feeling of straight Kevlar.

Lets talk about welding gloves. Stick welding calls for Gauntlet type gloves and Chrome tanned leather for its resistance to heat and sparks. Now many wear TIG glove of goatskin or pig skin and they are nicely soft and supple.

They also are the wrong material and don't have the insulation to protect from stick welding. They quickly get burn holes. For stick welding, you just spent a ton of money for the equipment and rods, and probably have a nice helmet. Don't buy the cheapest gloves at HF. Buy a name brand, glove that fits and your hands will thank you after a long spell at the welder. TIG gloves are great for that. Light MIG and you TIG gloves are only OK. Heavy MIG at bigger wire sizes/amps and you will be wanting those good stick welding gloves.

By now you are wondering what I am going to say about forging gloves. I advocate a glove on the tong or holding hand for cut and abrasion and scale pop protection. I do not advocate a glove on the hammer hand. Increases you grip requirement, and that is usually the last thing you want on your hammer hand. So what kind of glove for that holding hand. I prefer a leather palm glove.

Gloves, con't...

You can get a decent Leather palm glove for about $1.25 a pair by the dozen. They have a cotton back that will nicely shed scale and flux. The leather palm protects from cuts and a bit against vibration. and gives a heat protection if CHROME Tanned. This is the one place where I recommend cheap gloves and say get them about one size big so when you goof up and grab something very hot you drop the hot steel and sling the glove off as it is shrinking and getting stiff and you will have at most a mild 1st degree burn. Why the cheap ones? so every time they get stiff from a hot metal contact, or a burn on the canvas back or the stitching fails they can be trashed before you get an injury through the hole.

And what kind of glove does a skydiver wear? I was a demo jumper for the military and we jumped smoke grenades mounted to our feet. Sometimes the grenade would melt the can seam and spray pyrotechnical smoke (Very HOT!!!) on your foot or leg. If over open country you cut away the mount and the grenade fell away. Over the crowd, no cut away. So you removed the mount from your foot and held it by the straps as you flew the wing parachute over a safe to drop area. I wore rabbit leather gloves with rabbit fur lining to protect against cold at altitude and heat if... They also had to be supple enough to allow pulling the rip cord and cutting away the main parachute in a malfunction. Lot of conflicting requirements. And when I had that run away grenade over a large crowd, I destroyed those gloves. 2nd to mild thirdish burns to my hands and fingers, but I could not have held that grenade until clear to drop otherwise.

Ruined them and kept my hands. Good trade.

This article reprinted from- Indiana Blacksmithing Association, The Forge Fire Newsletter,

For Sale

Fire Bricks – Brand New, Industrial Grade. $1 ea. Ed Sylvester 803.414.2487

Tire Hammer plans by Clay Spencer. Send Paypal for $30US to clay@tirehammer.com. Or check/money to 73 Penniston Pvt. Dr.,Somerville, AL 35670. I can mail a copy or email PDFS.

Beverly shear blades sharpened. Remove blades, mail in small Flat Rate box, include check/money order for $50, includes return postage. clay@otelco.net, 256-558-3658 .

Forklift tine sections for striking anvils, $30. Jody Durham, 864-985-3919 ironsmith@gmail.com

Todd Elder is offering Beginning Blacksmithing and Knifemaking Classes. Contact him at (864-978-7232)

Guild Coal: 3 buckets, $30; 6 buckets or 30 gal barrel—$45.00; 11 buckets - 55 gal barrel - $ 60.00; 15 buckets - 1/4 ton - $70.00; 30 buckets - 1/2 ton - $140.00; 60 buckets - 1 ton - $280.00. Contact **Walt Beard 803-464-8483**

Upcoming events:

Griz Hockwalt is demonstrating at the Bart Garrison Agricultural Museum of South Carolina for special events and tours. The museum is located off of highway 76 in Pendleton S.C, across from Tri-County Tech. February 15th is the next demo from 10 to 3. Beginning in March, Griz will be demonstrating the first Saturday of each month.

2021 Meeting Schedule: **April 10, Magnolia Gardens, Charleston, Contact** Ray Pearre
June XXX Roger and Gail Marcengill, Westminster
August XXX Historic Camden

Bob Kaltenbach and Barry Myers are planning a hammer-in on March 27 at the Living History Park in North Augusta. Call Bob at 706-799-4703 if you wish to come. We will be outside and socially distancing, but Bob and I will have had our shots by then…We plan to make butterfly hinges unless there is something you would rather make.

Philip Simmons Artist Blacksmith Guild

http://philipsimmonsartistblacksmithguild.com/

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Membership Application

___ New Member___ Renewal

Name: _____Address: _____

City: _____ State: _____ Zip: _____Phone: _____

email: _____ Sponsor_____

Dues are $15.00 per person/family, per year. **Make checks out to PSABG** Please remit to:

C. Ray Pearre, Jr., 4605 Durant Ave., North Charleston, SC 29405

ACKNOWLEDGEMENT AND ASSMPUMPTION OF RISK

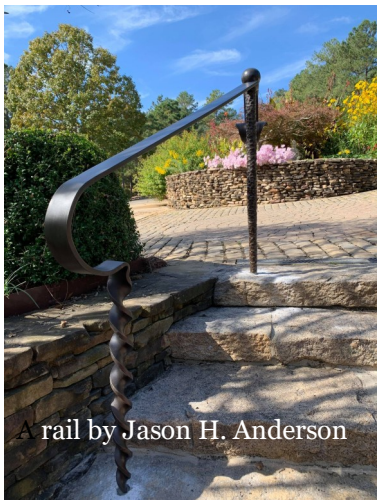
I acknowledge that blacksmithing and related activities are inherently dangerous and involve risks and dangers to participants and spectators that may result in serious injury or death. I have considered these risks and I knowingly assume them. I agree that I am responsible for my own safety during Guild events, including wearing appropriate clothing and protective gear and remaining a safe distance from all dangerous activities. I agree to hold Philip Simmons Artist Blacksmith Guild and guest demonstrators of our craft harmless from liability and expenses arising from of my actions and/or omissions.

When was the last time you paid dues?

There is a note below your address on the last page of our newsletters. It will say something like…

"Dues Last Paid – 2019"or"Dues for 2020" are due" or "Dues paid 2020"

This note is updated for each newsletter. We appreciate your prompt payments.


A rail by Jason H. Anderson

DON'T COME

to the L. C. Paul Living History Farm

February Meeting, 2/12

Our leaders have looked at the increasing number of Covid cases in our state and, after much consideration, have decided that for your safety and theirs, we will not meet again this month.

Everyone wants to meet, but there is just too much risk.

Get your shot and look forward to April.

More bad news!

The SBA Board has decided to cancel the Madison Conference!

Don't come to Madison in May, either….