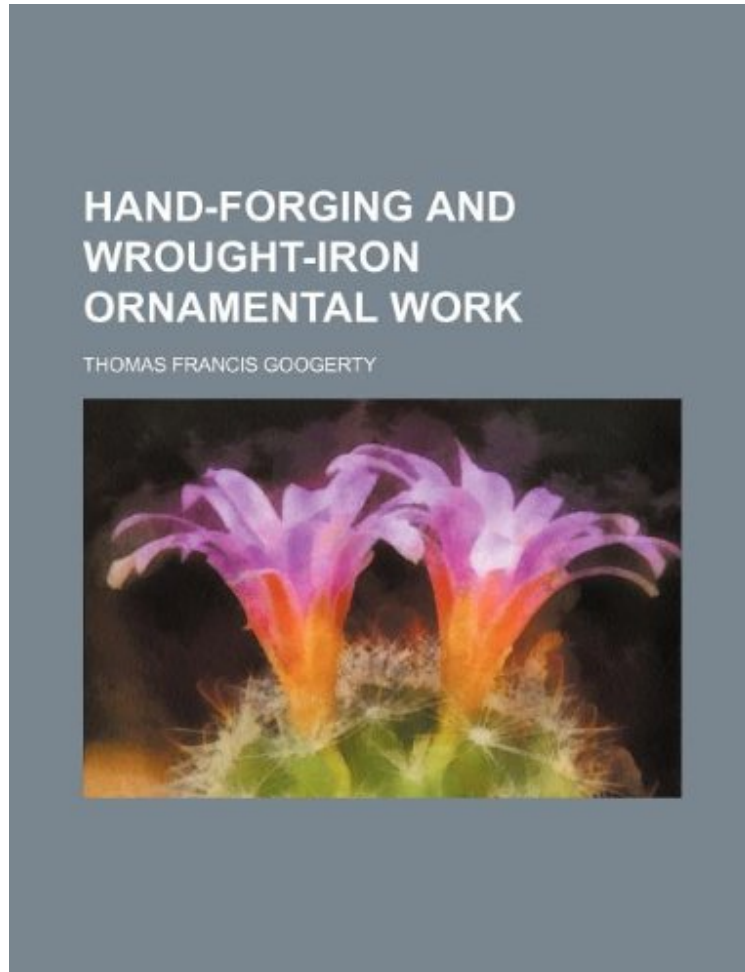


(Library ebook) Hand-Forging and Wrought-Iron Ornamental Work

Hand-Forging and Wrought-Iron Ornamental Work

Thomas Francis Googerty

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This historic book may have numerous typos and missing text. Purchasers can download a free scanned copy of the original book (without typos) from the publisher. Not indexed. Not illustrated. 1911 Excerpt: ...It is best to start at one end of the spiral and continue to the other end, moving each coil that needs it with the tool. Two spirals of this kind may be twisted into one another, afterward welding the stem together. The points may be twisted together also. A spiral of this kind is shown at A in Fig. 53. The Bulb.--Another form in twisting is to weld together a number of round or square rods at their ends, and then twist and swell them in the center in bulb form, as shown in Fig. 54. There are thirteen soft steel rods 14 in. round in the bulb. The length of the rods before welding is 1V-2 in. Soft steel is used because iron will not stand the strain of twisting without danger of breaking. The method of forging the bulb is first to get out two pieces of iron to be welded in the top and bottom, also three short pieces of round to be placed in the center of the rods while welding the ends. These pieces are shown at A in Fig. 55; also the dimensions. At B are shown the top four pieces placed on the inside of the rods. A strong wire is twisted around them, binding the whole firmly. The weld is now made at the top, welding the small rods to the heavy piece of iron on the end. In making this weld some welding-flux must be used. The rods are welded directly on their ends. So the heat must be taken on the heavy piece first, gradually pushing the pieces a little farther into the fire until the heat reaches the end of the small rods. The work, while raising the heat, is held with a pair of round-nose tongs with a ring on the end of handles. The tongs should fit and hold the pieces firmly. In case the piece being heated at the end of the rods should want to drop out, it may be held in place by using a poker that has a short right angle bent at its end, and the rods may...