(No Model.)

T. MEIKLE.

FAGOT.

No. 411,748. Patented Sept. 24, 1889.

Fig. 1.

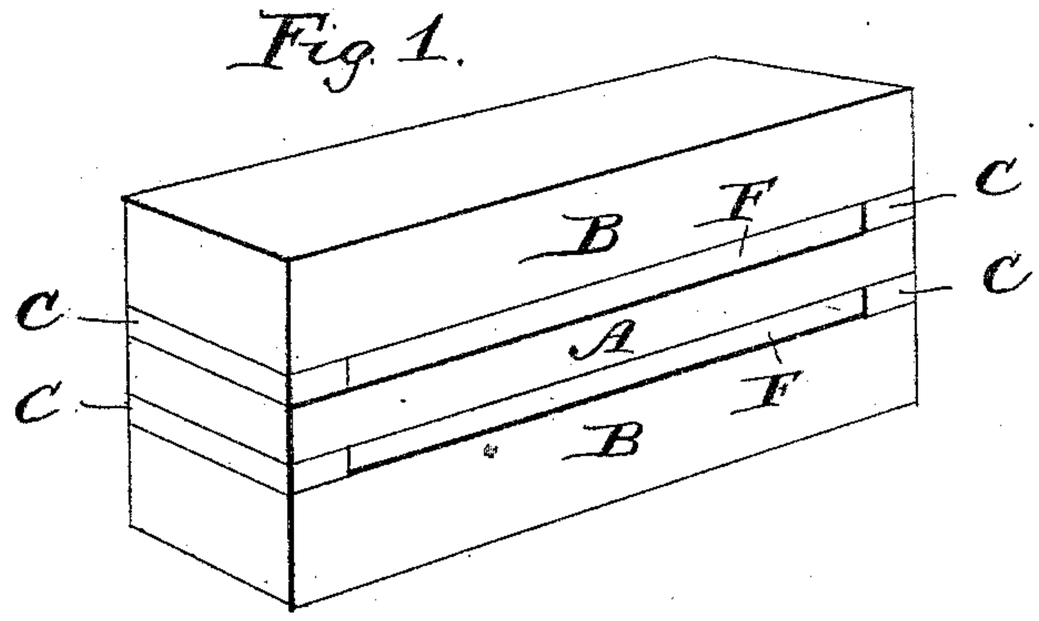


Fig. 2.

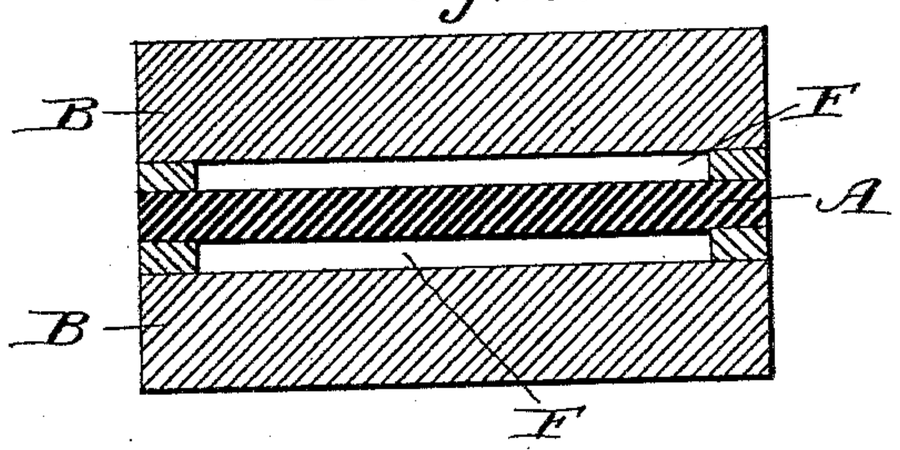
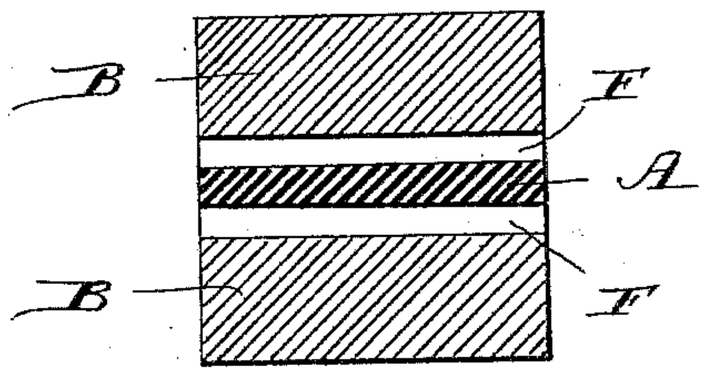


Fig. 3.



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UNITED STATES PATENT OFFICE.

THOMAS MEIKLE, OF LOUISVILLE, KENTUCKY, ASSIGNOR OF ONE-HALF TO HUGH F. MEIKLE, OF SAME PLACE.

FAGOT.

SPECIFICATION forming part of Letters Patent No. 411,748, dated September 24, 1889.

Application filed July 18, 1889. Serial No. 317,896. (No model.)

To all whom it may concern:

Be it known that I, THOMAS MEIKLE, a citizen of the United States, residing at Louisville, in the county of Jefferson and State of Kentucky, have invented certain new and useful Improvements in Billets or Blooms for Forging; and I do declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same.

My invention relates to billets, blooms, or fagots for rolling or forging, which are compound in constitution—*i. e.*, formed of different materials or grades of material; and the object of the invention is especially to produce "soft-center steel" with a sound and perfect weld between the component parts of the plate or piece.

In carrying my invention into effect I take a piece of iron and heat it to a white heat by any suitable means. I then lay a small strip of iron or steel on each end of it, top and bottom, four pieces in all, and place upon or against said strips, above and below the piece of iron, two pieces of steel in such manner that what may be termed "flues" are formed between the iron and steel pieces. The whole is then placed in a suitable furnace and heated to a welding heat, the arrangement of parts above described being such that the heat has direct access to the interior faces of the pieces which are to be welded together. All parts of these surfaces are thus perfectly prepared for the welding operation, and when acted upon by the hammer a sound and perfect weld takes place at all points.

In order to make my invention more clearly nnderstood, I have shown in the accompanying drawings means for carrying the same into practical effect.

In said drawings, Figure 1 is a perspective view of a billet, bloom, or fagot embodying my invention. Fig. 2 is a longitudinal section of the same. Fig. 3 is a transverse section.

Referring to the drawings, A indicates the central iron piece. B indicates the pieces of steel on each side of or above and below the same; and C denotes the strips by which said pieces are separated, forming openings or flues F.

The relative thicknesses of the parts A and B will be determined by the proportion of soft center which is desired in the product.

It will be understood that, if desired, the steel may be placed intermediate between two pieces of iron, giving a product with a hard center and soft exterior; also, that but two pieces may be employed—one of iron and one of steel—giving a product soft upon one side and hard upon the other.

Having thus described my invention, what I claim is—

1. A fagot composed of a plurality of pieces of iron and steel having interposed between them pieces by which the former are separated to produce heating-flues, substantially as set forth.

2. In a fagot, the combination, with the central piece A, of iron, of the exterior pieces B, of steel, and the interposed strips C, arranged to produce flues F, substantially as set forth.

In testimony whereof I affix my signature in the presence of two witnesses.

THOMAS MEIKLE.

Witnesses:
S. C. SHEPPARD,
J. E. RATHBONE.