

color and is absolutely waterproof. The writer has taken one of these tiles and raising a border or frame of putty around it, poured water on, allowing it to stand for five or six days. No trace of moisture showed itself underneath any more than it would on a glass or thoroughly vitrified tile. A common roofing tile must be of exceptionally good quality that will not, under such a test, show beads of water on the under surface within an hour.

The silver gray tile is, briefly, a burned clay tile carbonized throughout, the graphite-like carbonization being produced at the conclusion of the burning process, somewhat as salt glazed ware is glazed when the burn is finished. The method of doing this we will now proceed to describe.

The tile may be of any shape or make, hand made, pressed or auger machine made. Very conveniently shaped are the corrugated tile which, when set in the kiln, give only small points of contact and at the same time form a number of tubes, through which the carbonizing vapor (blue smoke) can circulate. But any shape or kind of tile that can be burned can be "blue smoked."

Opinions differ as to the best size for the kiln. One authority, Jacob Buhner, considers the kiln should be small, holding about 8,000 pressed or 10,000 auger machine tile. Though he admits it is very much a question of the amount of heat the clay will bear without falling down, and that kilns should be smaller for ware which burns very easily, while if the clay holds up well the kiln can be larger; but another authority, C. Jungst, contends this, citing the practice of the Freiwaldner works, where the kilns hold 20,000 pressed lock-joint tile and give perfect results.

It is obvious that only tile can be burned in a kiln at one time and it takes two or three burns of ordinary ware before the tar, with which the kiln walls are saturated, is got out, and front, ornamental or glazed brick, can be burned without fear of discoloration. The time occupied in burning a kiln of silver gray tile is about as follows: 1 1/2 days for setting, 3 days for water smoking, 1 1/2 days for full heat burning, 6 to 7 days for cooling, 1 day to empty kiln: total, 13 to 14 days.

It is found an advantage to build the kilns, which are only fired from one side, in pairs back to back and run the two at the same time. These are the smaller kilns as worked by Buhner, and the consumption of fuel (coal) is about four tons each. The chief burner must thoroughly understand his business and know how to raise the temperature to an equal degree throughout the entire mass of the ware. The more equal the temperature, the nearer perfection is the silver gray gloss, which should be alike on every tile in the kiln. It is advisable, and is, in fact, the usual course, to finish up the firing and get a white heat of equal intensity throughout the kiln, with small shingled or split wood, and it is very important that trial pieces be freely used, for without these, mistakes are very likely to be made.

The burning being complete and the chief burner seeing that he has an equal heat throughout the kiln, on the furthest side the same as near the fire, the next operation is to hermetically close the kiln as quickly as possible. Wet or damp sand has been previously heaped up at the fire boxes, as high as the doors. An assistant stands ready on the top of the kiln with a pail of slaking mud and a quantity of damp sand. The burner then throws about eight to ten shovelfuls of slack upon each fire, quickly shuts the doors and calls to his assistant to close the damper. This is done at once, slaked with mud and a layer of about eight inches of sand thrown on.

By this time the burner has completed the closing of the doors with sand; the peepholes in the roof have been closed and covered with sand. All this work must be done very smartly, as it is an advantage to hold the smoke or vapor in the kiln, which comes from the slack just thrown in. The kiln is then allowed to stand for half an hour to an hour and a half, so that the glow of the fire is equally distributed or, as burners say, "the fire settles." The time necessary for this is a matter of experiment and largely depends upon the size of the kiln. As a general rule, one hour is enough; after an hour and a half the heat falls too much.

Everything being ready and there being not an opening or crack or fissure in the kiln by which air can enter, the tar or oil is poured into the kiln. This is put in through siphon-shaped funnels, of which an illustration is given here.

The object of the bent tube is to prevent admission of air at the time of pouring in the oil. Assuming that we use common coal or gas tar, seven pailfuls will be poured in, each pail holding between ten and eleven quarts. The tar or oil must not fall directly on the tile. When setting the ware two spaces are left, one each side of the kiln, and a layer of single brick arranged for the tar or oil to fall upon and vaporize. Two funnels are put into holes provided for them in the roof of the kiln. The joints well luted and further protected by wet sand. Half the blue-smoking material is poured into one funnel, half in the other. In three hours' time another seven pailfuls is poured in; this is done four times in all, so that the total quantity of tar used is about seventy-four gallons. It might be supposed that this great quantity of liquid tar, or oil, would spoil the contents of the kiln, but this is not the case. From the time the oil is first poured in, the sand, with which the roof is covered, is kept wet. If a row of kilns, say ten or twelve, are always used for blue-smoked tile, it is well to have water laid on permanently through an inch or inch and a half iron pipe along the kilns at the height of the roof, with branches at each kiln, upon which a rubber hose can be fixed. Where such an arrangement is not used, water is thrown on the kiln, five pails of water every hour and a half, day and night, for thrice twenty-four hours, then every two and a half hours until the kiln is cool enough to open.

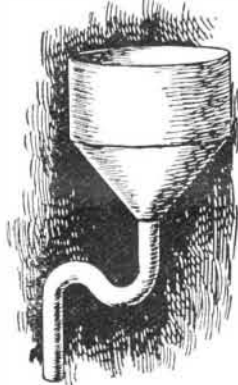
For a set of ten or twelve kilns, each holding from 3,000 to 4,000 tile, two burners and two assistants are enough for day and night service and are able to burn from twenty-three to thirty kilns per month. The assistants, in addition to helping when closing the kiln, wheel the fuel, clear away the ashes, close and open the kiln doors, and keep the sand damp on roof and other places where it is used for sealing all openings.

The pouring in of the oil should, if possible, be done

by the chief burner himself, so that he may be quite certain the right quantity is used, and for this operation of pouring in the oil or liquid tar, a watering can, from which the rose has been taken off, is more convenient than a pail.

As for the cooling of the kiln, the quicker this can be done the better, but we reckon it to take seven or eight days. When it is believed that all the fire is dead, the opening of the kiln is commenced, very carefully and very tentatively at first, for the kiln must absolutely not be opened so long as there is the least chance of the vapor in it igniting, as this would ruin the color and appearance of the tile. The fire doors are opened one at a time and as little as possible, sufficiently to draw out the ashes, for these hold the fire longest. This work should be finished quickly. The burner then goes on the roof, one of the peep holes is opened (there are usually three on a kiln twenty-five feet long). He cannot see into the kiln, in consequence of the vapor which continually rises, but the hole is left open for about five minutes, when, taking a sack he strikes some smart blows with it upon the mouth of the hole, when he will very soon see if there is any fire in the kiln, for sparks will come out of the hole and these can be seen very plainly at night. If sparks appear, the opening must be closed at once, and covered with sand and the fire doors slaked tightly.

In an hour's time this can be tried again, but if no sparks are seen, the further opening of the kiln may be proceeded with. All the view holes are opened and the sand packing is removed from the kiln door and a small hole is broken through the inner door. In three hours' time this hole is enlarged, and after a further six hours the whole of the door can be broken down, so that the setting is seen. Up to this time the fire door and chimney damper remain closed. After waiting another six hours the fire doors can be opened a little, but care must be taken not to open up too quickly, particularly if the clay is of such a nature that it will not bear rapid cooling, for the bottom rows of tile which lie on the flue openings will craze and fly. Six hours later the fire doors can be all quite open, so that after twenty-one hours' cooling, the outer air streams through the kiln; but even then the chimney damper is kept closed, otherwise the draught or current of cold air would be too great and cause chills or cold cracks. The damper should only be opened a few hours before emptying the kiln. This is the usual practice, though there are burners handling much smaller kilns who do not throw water on them, which is of course very trying to the brick work, but wait for seventy-two hours. Then open the fire doors, after



this the kiln doors, beginning at the bottom, are opened by degrees. The kiln stands like this for a time, then the chimney damper is opened. This creates a strong draught, and in about another twenty-four hours the kiln is cool enough to empty. But this plan, it should be observed, can only be adopted with certain kinds of clays.

As to which are the most suitable clays for the blue-smoking process, this, too, can only be determined by experiment. The prevailing opinion that a considerable quantity of iron must be present in the clay is a mistake. The method used at Tegeln, in Holland, which we propose to fully discuss in a future article, possibly requires that iron shall be a constituent, but where the blue smoking is done with liquid tar or oil, iron is not necessary, and it is found that clays containing lime, burning a yellow color, and even pure kaolin, will take the finest silver gray color. This process is specially adapted to clays which, when burned, prove very porous, but we must caution our readers against assuming that any and every clay will do. Tiles made from certain clays, apparently thoroughly sound, with a good ring, and free from craze or crack, have been found unable to withstand the first severe winter. An analysis of the clay will not tell us whether it will give a good tile; experiment alone will do this, and the test is better made by some disinterested and impartial person. A half dozen or so average specimens of the tile can be sent to a chemical laboratory, where the testing of clay is a specialty, and they would be submitted to all the destructive influences which nature would bring to bear in the course of years. If the cost of such a test is objected to, and time is of little importance, the tile maker can carry out his own test by putting up a small roof, which should be in the most exposed position that can be got, and if, after the second winter, the tile is found to be absolutely unchanged, the production of them on a manufacturing scale may be commenced with confidence.

The cost of manufacturing silver gray tile in Germany has been found to be \$1.80 per thousand more than the same tile burned red in a continuous kiln, which is, of course, the very cheapest way of burning. The items are as follows:

Extra cost per M for labor .....	\$0.42
Tar or oil .....	.53
Extra coal .....	.85
	\$1.80

A prime condition of success is the selection of an intelligent and careful chief burner, who knows his business, and who will insure the kiln being absolutely air-tight during the blue smoking process, but he must be given the right materials to work with, or failure

may be due to causes over which he has no control. The oil (we are not now speaking of liquid tar) which is mostly refuse from the oil refineries, may contain injurious constituents producing minute cracks in the tile, cracks so small as to be invisible to the naked eye. The tile may even ring, but it will not last over one severe winter. In one car load of oil there may be some barrels of a more inflammable character and which do not possess the property of quickly deadening the fire; in such case a larger quantity of the oil must be used or the ware will not be perfect. Coal which does not produce a long flame will be found to be unsuitable for the blue smoking process, the more so that the kilns are fired from only one side. Where this is the only fuel obtainable, it has to be supplemented by the use of a considerable quantity of split wood, and the burning must be finished entirely with this wood.

This brings us to the question of the most suitable fuel. Our manufacturers in many parts of the country possess exceptional advantages for burning fine ware, such as roofing tile, in a plentiful supply of a most admirable fuel, crude oil.

We have no doubt crude oil would prove the very best fuel for the work described above, combining in itself the advantages of coal and wood, and we anticipate that crude oil would perfectly supply the place of coal tar or the oil refinery refuse used in Germany for the actual blue smoking.

By using fuel oil we should expect, if the burning and blue smoking is properly done and the clay is not very difficult to handle, that it would not be a question of what percentage of good ware could be got from the kiln, but that every tile would be a good and salable article and all be of equal color.

A tile such as is here described would, we feel sure, be a welcome variety to architects and command a ready sale.

We know well that the dark and neutral tinted slate and the subdued tones of old shingle or thatch are the most satisfactory roofing materials, so far as appearance goes, and are a great ornament to a building.

The facade of a house may be rich and imposing, or chastely beautiful, but if the roof be yellowish white or pink or pale red, the value of the whole, as an artistic effort, is diminished.

A dark red tile is far better; but it is undeniable that a neutral tint is the best of all and a roof so tinted is a finish and a frame to the rest of the architectural picture and a neutral color tone is the more desirable if the surface of the roof is broken by turrets, returns or dormers.

SILVER ALLOYS.

By G. J. FOWLER, M.Sc., and P. J. HARTOG, B.Sc.

THE following notes form a record of some experiments undertaken\* for the purpose of obtaining a silver alloy, which should possess the whiteness of silver, without its liability to tarnish, and should also be capable of electro-deposition. Our endeavors proved unsuccessful, but the results obtained are of some interest. Our experiments fall into two divisions:

(I.) The preparation of alloys by fusion of their constituents.

(1.) The deposition of alloys by electrolysis.  
(1.) Some time ago a company was formed for electro-plating with an alloy of silver and cadmium, which was stated to be much less tarnishable than silver. For various reasons the company did not meet with great success, one being, doubtless, that the expectations with regard to the alloy were not realized in practice.

We have found indeed in all cases that the silver alloys we prepared were more easily tarnishable than pure silver; on the other hand, a sulphide stain is in general more easily removed from the alloy than from the metal. We tested the alloys by the following rough but efficient means: two drops of ammonium sulphide were placed on the burnished surfaces of the alloy and of pure silver, respectively, at the same time, and removed at the same time, after an interval of a minute or two. It was then evident in all cases that the stain on the alloy was deeper in color than that on the silver, while it was in general more easily rubbed off with a piece of chamois leather.

It is of course well known that silver sulphide forms a particularly good and tenacious coating on silver; it was to be expected that a heterogeneous mixture of sulphides would be less tenacious. The following lines contain a brief description of the alloys prepared.

1. Silver Zinc Alloys.—The zinc was melted in a crucible under powdered charcoal, the molten silver added, the mixture stirred with an iron rod and poured into a mould.

- (a) Ag 95 per cent., Zn 5 per cent. Color somewhat grayer than that of pure silver, but not easily distinguishable from it.
- (b) Ag 93 per cent., Zn 7 per cent. Color easily distinguishable from that of pure silver.
- (c) Ag 90 per cent., Zn 10 per cent. Still malleable, but grayer.

2. Silver Nickel Alloys.—These were obtained by melting the two metals together in a wind furnace under a layer of charcoal, stirring and pouring into a mould.

- (a) Ag 95 per cent., Ni 5 per cent. Color was good, silver-like, and the alloy takes a high polish.
- (b) Ag 90 per cent., Ni 10 per cent. Color was "steely," the alloy malleable.

Both these alloys tarnish readily, and the stain is not very easily removed from their surface.

3. Silver, Nickel, and Zinc Alloy.—Ag 90 per cent., Ni 5 per cent., Zn 5 per cent. The silver and nickel were melted together and poured on to the molten zinc, the contents of the two crucibles being covered with powdered charcoal. Color too gray, malleable.

4. Silver Aluminum Alloy.—Ag 90 per cent., Al 10 per cent. This alloy was highly crystalline and brittle; it broke to pieces on rolling. The surface was white and highly lustrous, but readily tarnishable.

5. Silver Tin Alloy.—Ag 95 per cent., tin 5 per cent. (by analysis).—According to Horns (Mixed Metals, 320), "the smallest quantity of tin renders silver brittle." This alloy is, however, perfectly malleable, yielding long spiral drillings. It has an excellent color and yields stains which are easily removable. Unfortun-

\* At the suggestion of Messrs. Levetus Bros., of Birmingham.

