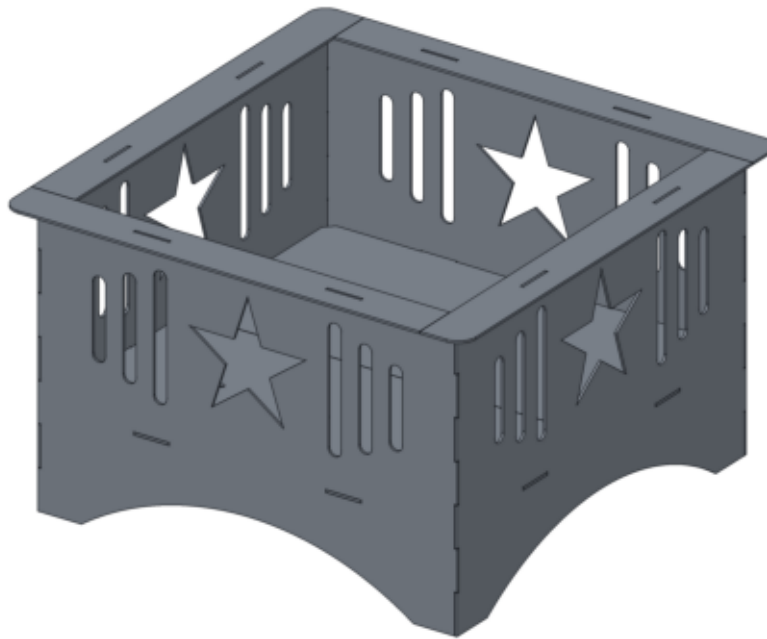
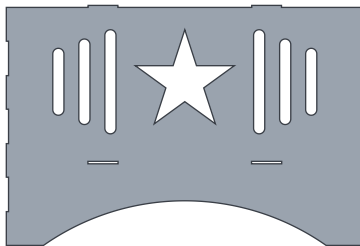


Lone Star Fire Pit, 24 in



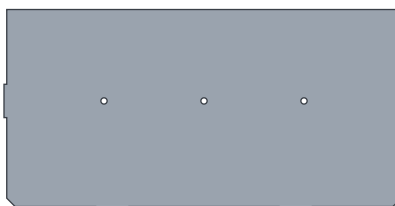
A 24-inch square fire pit you weld yourself. Ten laser-cut 10 ga steel parts lock together with box-jointed corners and tab-and-slot joints, so it squares itself up before you strike an arc.

What's in the box



Side panel x4

Part FP24-01



Floor half x2

Part FP24-02



Rim strip x4

Part FP24-03

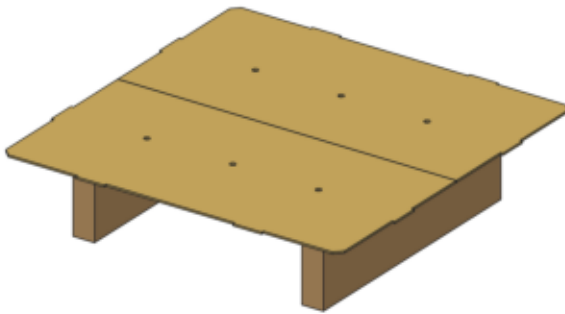
What you'll need

- MIG or flux-core welder (a 120 V machine handles 10 ga)
- Angle grinder with a flap disc and wire wheel
- Four or more clamps (corner clamps or F-clamps)
- Framing square and tape measure
- Rubber mallet and a flat file
- Two 2x6 boards, at least 18 in long
- Welding helmet, gloves, jacket and safety glasses

Lone Star Fire Pit, 24 in

1

Set the floor on two boards



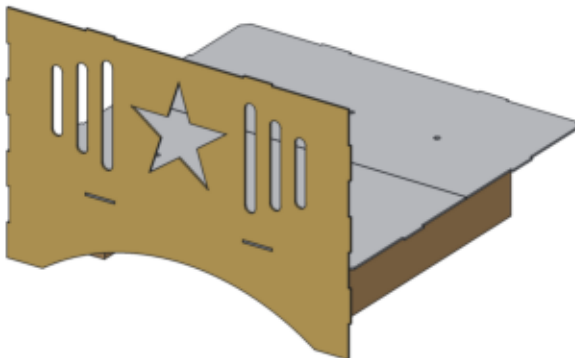
Lay two 2x6 boards on edge about 16 in apart on a flat surface. Standing on edge they hold the floor at its finished height of 5-1/2 in. Set both floor halves across the boards with their straight edges meeting in the middle. The halves are identical; turn one around.

TIP

Work on a flat, level surface; a welding table or smooth concrete floor is ideal.

2

Hang the first panel



Slide a side panel onto the two floor tabs on one side, from the outside. The tabs pass through the panel's two lower slots. The star faces out and the arch is at the bottom.

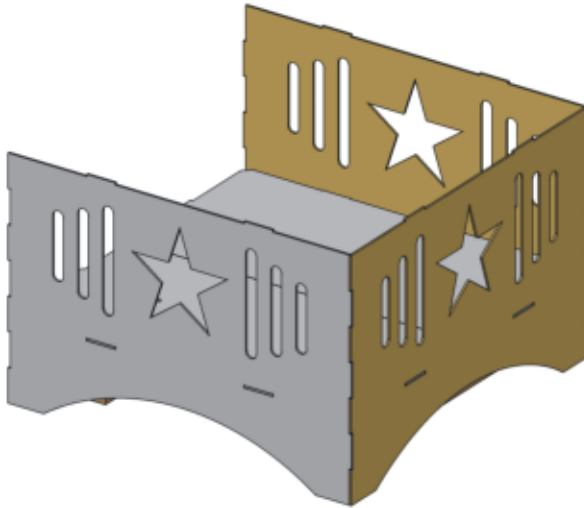
TIP

A rubber mallet helps if a slot is tight. Do not force it; clean the slot with a file instead.

Lone Star Fire Pit, 24 in

3

Add the next two panels



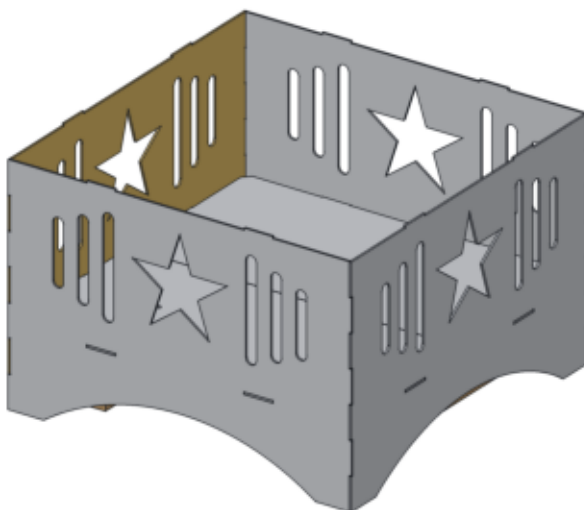
Bring the second panel in at a corner. Push it straight in, square to its face, so its floor tabs enter the slots and the corner fingers interleave. Repeat for the third panel.

TIP

All four panels are identical, so any panel fits any side.

4

Close the box and square it



Push the last panel in square to its face so its fingers mesh with both neighbors. Clamp the corners, measure both diagonals across the top, and tap the corners until the diagonals match within 1/16 in. Tack each corner top and bottom and tack every floor tab. Then lift the pit straight up off the boards (it is open underneath); from here the legs carry the floor.

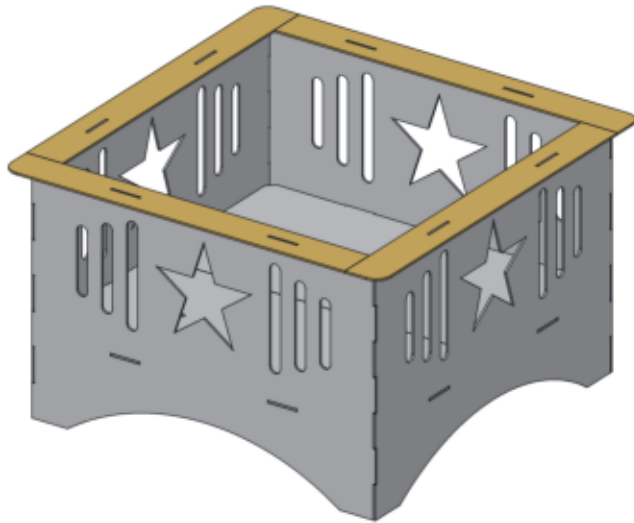
TIP

Keep the boards clear of the arc. Tack lightly near the wood, or move them before welding near the floor.

Lone Star Fire Pit, 24 in

5

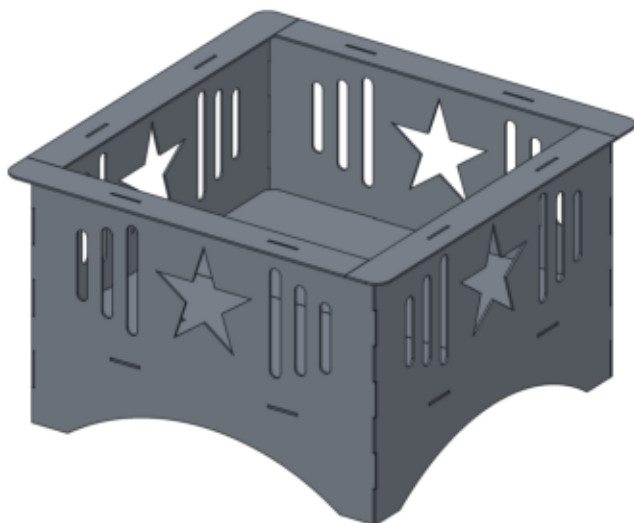
Set the rim strips



Drop each rim strip over the two tabs on top of a panel, rounded corner to the outside. The four strips butt together in a pinwheel at the corners, and the tabs finish flush with the top of the rim. Tack each strip at every tab.

6

Weld it out



Weld each outside corner along the finger joint and the floor seam. Stitch 1 to 2 in welds and move around the pit so the heat spreads evenly. Weld the floor tabs from outside, then the rim tabs and the four rim joints from the top. Grind the rim joints and tabs flush for a clean look.

TIP

Stitch welding (weld 2 in, skip ahead, come back later) keeps 10 ga panels flat.

Lone Star Fire Pit, 24 in

Finishing

- The parts ship bare with a light oil film. Wipe them down with a degreaser before welding.
- Grind off weld spatter, then sand or wire-wheel the outside surfaces you plan to paint.
- Paint the outside with a high-heat paint rated to 1200 F, in two or three thin coats.
- Leave the inside bare. A fire will burn paint off the inside, and bare steel there is normal.
- Or skip paint entirely and let it weather to a natural rust patina.

Fire safety

- Use outdoors only, at least 10 ft from buildings, fences, overhangs and trees.
- Set it on a non-combustible surface such as pavers, gravel or bare soil, never a wood deck or dry grass.
- Check local burn rules and county burn bans before every fire.
- The steel gets hot enough to burn skin. Keep kids and pets back.
- Keep a hose or extinguisher nearby, and drown the fire completely before you leave it.

This is a kit of raw steel parts. You build the finished product, and the quality of your welds and your judgment about where and how you use it are yours. Weld with proper ventilation and protective gear, and never leave a fire unattended.