Stephen Balliet and Samuel Helfrich built the furnace and operated it until Helfrich's death in 1830. Balliet operated it until his death in 1854. Cooper and Hewitt were the last owners.

The Crane Iron Company (first called the Lehigh Iron Co.) started its first furnace at Catasauqua in 1840 (pl. 25-B). In it for the first time the substitution of anthracite for charcoal proved to be entirely successful. This is attributed to the skill of David Thomas, who was brought from Wales for this particular purpose. The anthracite was brought from Mauch Chunk by canal boats. Additional furnaces were built in the years 1841, 1846, 1850 (two), and 1921. The last one, with a daily capacity of 400 tons, was the largest. Operations continued only about a year after its erection. This company seems to have smelted more local ores than any of the other companies. For over 80 years the Crane brand of pig-iron was constantly in the market.

The Allentown Iron Co. (also known as the Allentown Iron Works and Lewis Furnaces), with its plant along the Lehigh Valley Railroad in Allentown, started a furnace in 1846. Other furnaces were built in 1847, 1852, 1855, and 1872.

The Lehigh Valley Iron Co. (later the Coplay Iron Co.) operated a furnace at Coplay from 1854 to 1873, producing about 6,000 tons of pig iron a year.

The Thomas Iron Works (later the Thomas Iron Co.) built a furnace at Hokendauqua in 1855 and became one of the principal iron establishments of the county. Six different furnaces were built here between 1855 and 1874. M. S. Henry, in his History of the Lehigh Valley (1860), gives the combined capacity of the first two furnaces as follows:

The largest yield of the two furnaces for any one week was 605 tons and for one furnace in one week 351 tons, an amount unprecedented in the annals of iron making. (p. 300.)

These furnaces continued to operate until 1927.

The Roberts Iron Co. (later known as the Allentown Rolling-Mills Co. and in 1914 acquired by the Aldrich Pump Co.) built two furnaces along the Lehigh Valley Railroad in Allentown, the first in 1864 and the second in 1865.

The Lock Ridge Iron Co. near Alburtis started its first furnace in 1868 and a second one in 1869. This company was acquired by the Thomas Iron Co. and the furnaces were designated as Nos. 7 and 8. They were dismantled in 1923 and 1924.

The Lehigh Iron Co. operated two furnaces at the bend of the Lehigh River in southeast Allentown from 1869 to 1906. The first was started in 1869 and the second in 1872. Both were later rebuilt. They were dismantled in 1909.

The Millerstown Iron Co. (later the Macungie Iron Co.) operated a furnace at Macungie (formerly Millerstown) intermittently from 1874 to 1913. The property changed hands a few times and was sold twice by the sheriff. The Empire Steel and Iron Co. finally acquired and operated it from October 1912 to May 1913. Later it was scrapped.