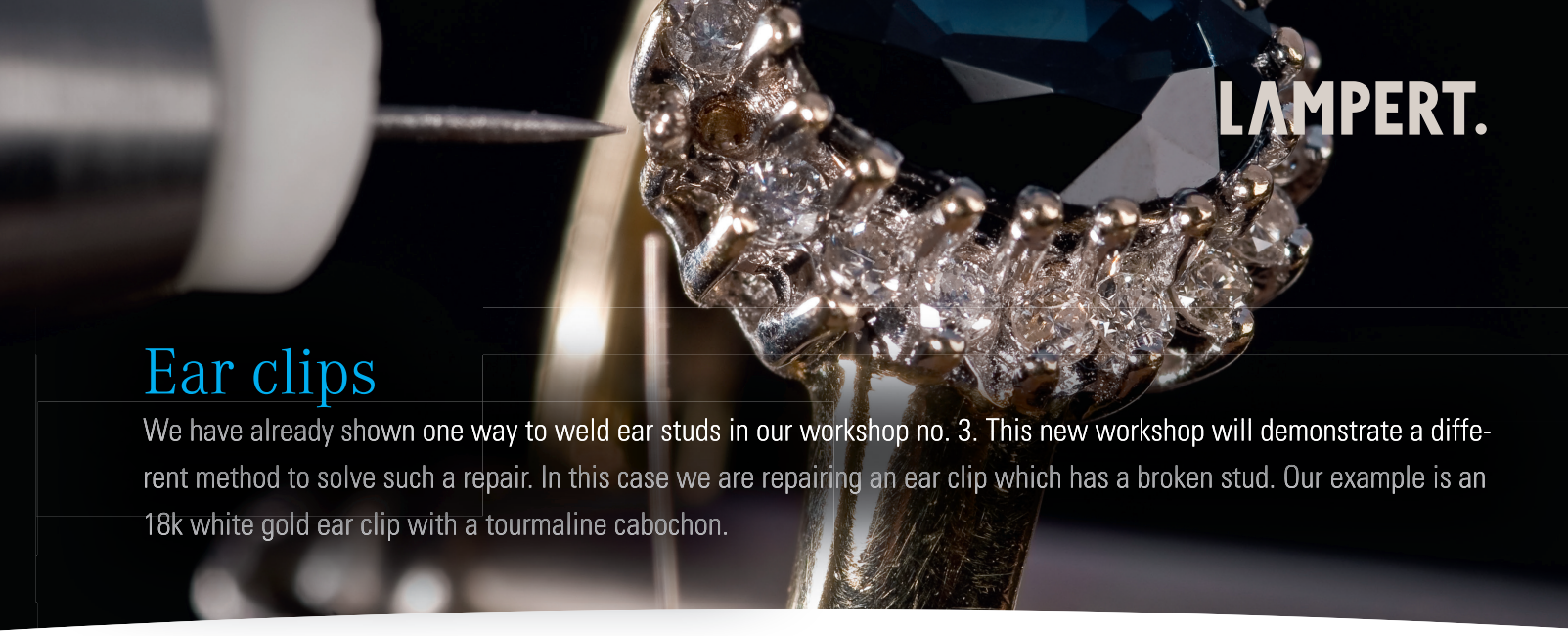


Ear clips

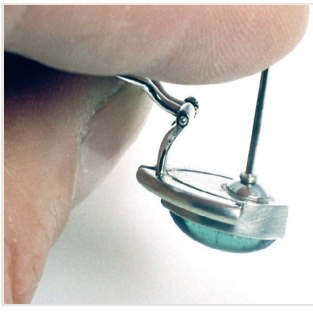
We have already shown one way to weld ear studs in our workshop no. 3. This new workshop will demonstrate a different method to solve such a repair. In this case we are repairing an ear clip which has a broken stud. Our example is an 18k white gold ear clip with a tourmaline cabochon.

Preparation on the ear clip

It is important to remove solder completely to a get a good welding base. Solder will burn explosively while welding and leaves holes inside the metal. File the area where the pin will be placed or drill a hole in the disk - if possible - to get a better position for the stud. Preparation and cleanness is extremely important to achieve a strong and stable result.

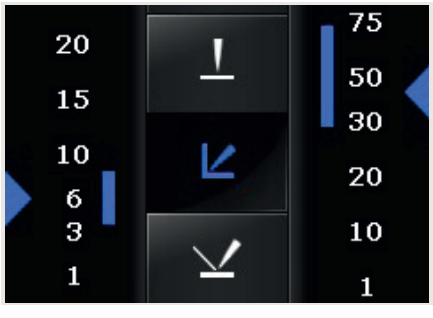
Preparation of the ear pin

Make the pin in the usual manner and take care to get the correct length. You will need a jump ring which fits perfectly around the pin. If you have drilled a hole in which to position the pin, allow some extra length beyond the jump ring, for the depth of the hole. Without the hole you do not need the extra length. just position the jump ring on the end of the pin. Finally solder the jump ring around the pin.



Preparation of the weld

In this case the excess length of the pin is positioned inside the hole. Now fix the crocodile clamp for example on the clip or use the flexible band to avoid leaving scratches on the polished surface.



Choose the Welding Parameter

The third down welding position – in the appropriate metal menu (here: gold) - is recommended for this application. It shows an angle situation on the pictogram. PUK3 users could use the gap mode instead. This mode has a special welding curve which makes it easier to weld especially in narrow spaces or in angles. Short welding times are also advisable.

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Welding

Position the electrode in an angle of 45°. Weld completely around the pin to get a strong connection and a good weld between the pin and the ear clip. For working with silver it is recommended to position the electrode as parallel as possible to the stud.

Mold

If necessary mold the material around the pin to reach a nice and shiny result. Therefore position the electrode in different angles and pull or push the metal to the desired place (q.v.: WS 2/ 2.2). If you work like this you can reduce final finishing. Please note: gold, platinum and all other metals are pulled to the electrode while silver is pushed from the electrode.

Finish

If you take your time molding the material you usually do not have to spend too much time on finishing. You added enough material to get a strong and stable weld so you could easily buff the welded area - if necessary - and polish it afterwards. You will get a really stable repair with a strong connection if you choose this procedure for broken ear studs.

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