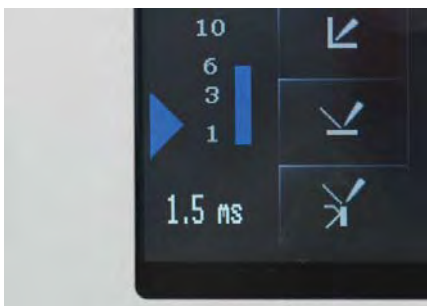


Repairing claws and bezel-setting rims

When working directly next to stones, it is very important to always use the shortest possible impulse time!



1. Impulse

When working directly next to stones, it is very important to always use the shortest possible impulse time! In the Micro mode, the PUK 3 and 3s can be set to work down to 4 and 3 milliseconds (msec.).

With PUK04 a impulse duration between 1 and 3 ms is recommended.



2. Power

Naturally, the welding energy (Power) that is selected, should also not be too high. When using a welding wire of 0.25mm thickness, 12 – 15% power is sufficient.



3. The electrode

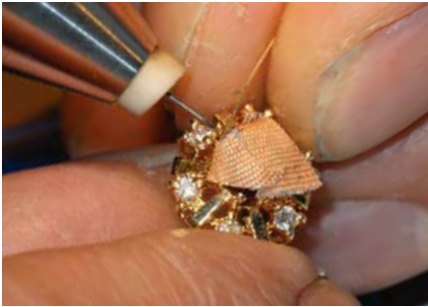
Here, it is vital to welding success that the electrode is well sharpened. Whilst working on this type of application, it is advisable to change the electrode very often!



4. The weld

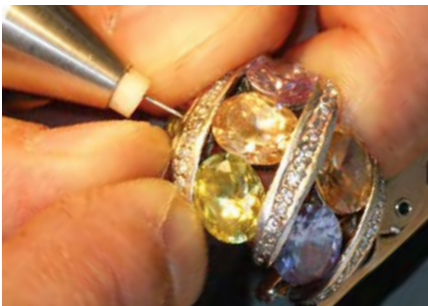
Place the wire on the claw so that it touches both the claw itself, and the stone. This way, it will lay between the electrode and the stone, creating an additional protection for the stone.





5. Protecting the stone

Because small amounts of soot are sometimes produced during welding, it can be helpful to protect the stone from dirt using a small piece of paper, or a strip of tape.



6. Practice makes perfect

The aim here to start with, is simply to add some new metal to the claw. At this stage the result does not have to look "pretty", though with a little practice results very quickly start to look better.



4. Cleaning up the welding area

Clean up the work piece in the usual manner.

