

16.1 Ring with bezel setting

- 1** Instead of setting a stone the classic way, it can also be PUK-welded into place.

In order to do so, the frame is made a little too small, so that only a minimal gap remains between the bezel and the bottom of the setting. This way the frame can be fused while under tension and the stone is held fast.

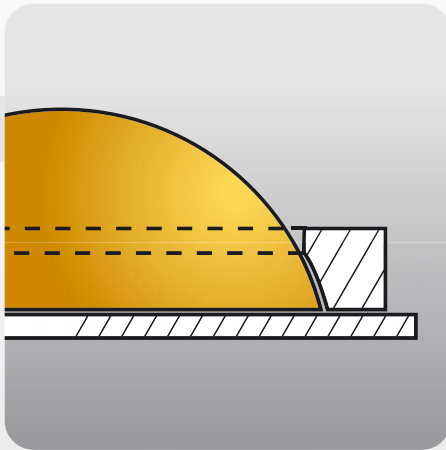
The bottom of the setting has a larger diameter than the frame. The overlapping metal is melted onto the weld too and so adds additional strength to the joint.

(fig. 16.1 & 16.2)



Furthermore the outer edge of the frame that is going to be welded is bevelled with a file, the V-shaped groove produced, allows a deeper weld.

(fig. 16.2)



(fig. 16.1)



(fig. 16.2)



Whilst PUK-welding, the frame is firmly pressed down by hand so that afterwards, the stone is held in place and does not wobble.

First the two parts are fixed with a couple of welding spots; afterwards the rest of the seam is welded.

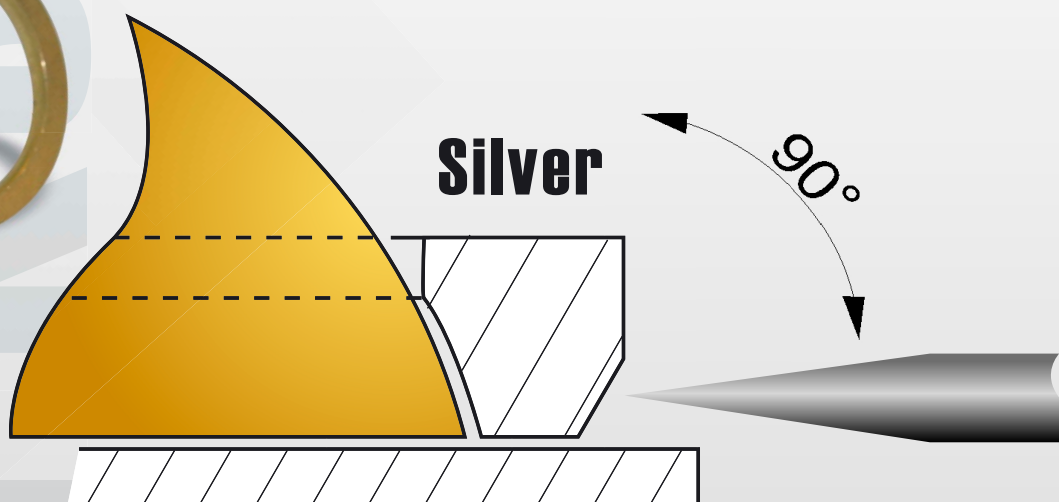
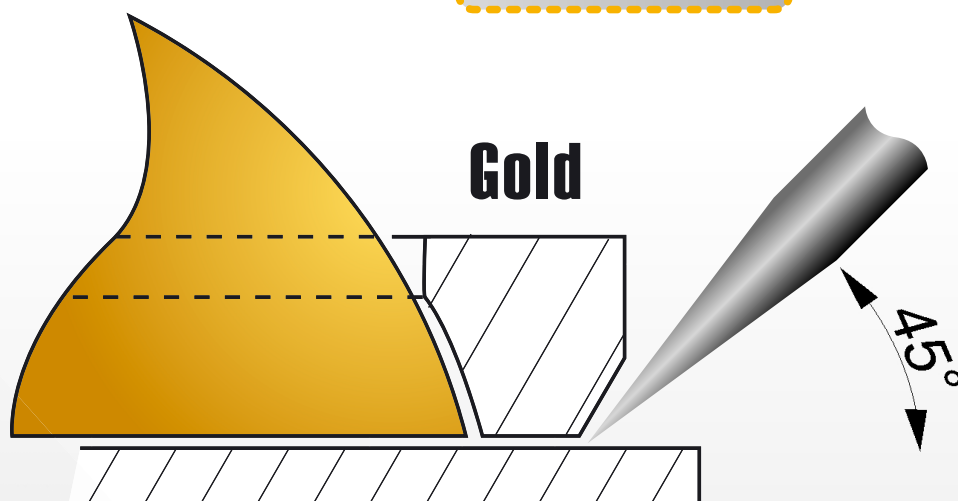
The power should be high enough, so that the overlapping edge of the bottom of the setting is melted down onto the frame.

16.2 Ring with bezel setting

- 2** Depending on whether the piece is made from silver or another precious metal, the electrode has to be held at the appropriate angle to the frame.

If the stone is very heat sensitive, or if the frame is very thin, make sure to choose the shortest possible impulse when welding.

 4 ms 30 %



Read more about Silver welding in our previous Workshop No.10, the theme of "Welding silver"

