LAMPERT.

Masking Tape

In our 28th workshop we are introducing masking tape that protects and prevents damage to stones and other sensitive areas from temporary heat radiation from the welding arc. In addition, the masking tape avoids contamination and adhesion on the gemstone which can be difficult to remove.

1. Application

To illustrate the application method we used a white gold ring with a prong setting as an example. Au/750 Pd welding wire with a diameter of 0,25mm was used for this task.

2. Preparation

First, begin with a well-cleaned work piece. Regardless of the object's alloy, it is necessary to prevent contamination which can deflagrate and adhere to your work piece compromising the weld and its finish.

3. Masking Tape

Affix the masking tape onto the stone and if possible position it under the prong to guarantee optimal protection. Then fasten the tape so that it is in close contact to the work piece.
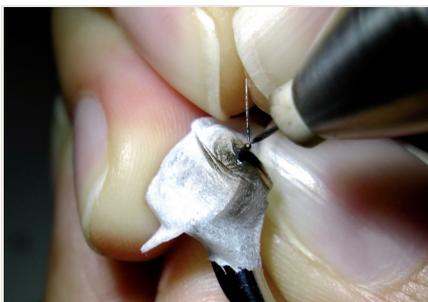
4. Welding wire

It is best to use 0,25mm welding wire to reduce the time and power required for the melting process. Never position the electrode over the gemstone. Approach the welding area from outside the setting, keeping in mind that the wire builds a "barrier" to the gemstone.

5. Parameter

There is already a pre-setting for this kind of application in your PUK4.1 and PUK04. It is the pictogram on the bottom of the display (recommendation: 1.5ms-2ms, 24% power). For all previous PUK models, a shorter time and lower power setting is recommended.

6. Welding

Position the electrode at a 45-degree angle between the wire and the prong. Model the added wire carefully (consult workshop 02) so less finishing will be required.

7. Finishing

After welding, refine the prong and if necessary press it carefully onto the gemstone, then polish.

8. Please note!

The masking tape does not protect from hazards arising as a result of direct contact with melted metal and excessive welding time and power.