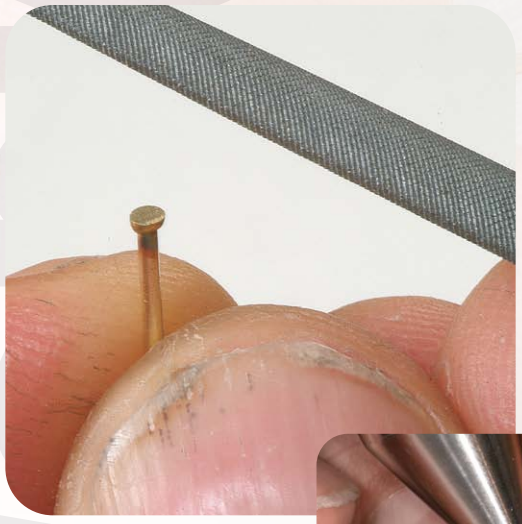
3.1 Weld on an ear post (preparing the welding)

Example ear pin AU 585 with 1,0mm

1 When welding this type of application, it is important to avoid "thin" joints. Therefore, to achieve a solid weld, it is necessary that there is enough metal at the welding joint; this will also increase the stability of the joint.

2 To increase the thickness of metal on the pin, and therefore increase the amount of metal at the joint, hold the pin with the crocodile clip, and place a weld directly on the end of the pin. During welding please place your hands on the work bench (resting position), this will make work a lot easier.



3 Place several other welds on the same place, gradually increasing the power with every weld. Continue until you have produced a small "ball" on the end that is about twice the diameter of the pin itself.

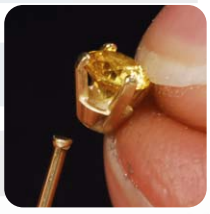
4 The "ball", can now be filed flat; remember not to remove the burr that is produced when filing, as this extra material will add extra strength to the weld. An alternative technique here is to leave the "ball" whole, and mill a small recess for the ball to fit in, exactly at the place where the pin is required.

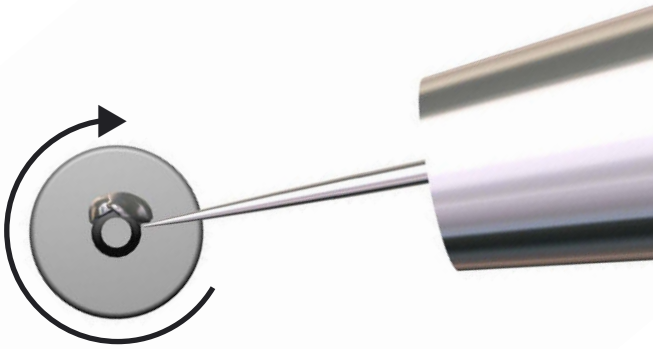
3.2 Weld on an ear post

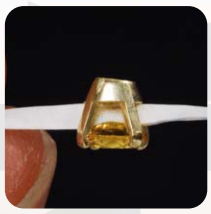
Example ear pin AU 585 with Ø 1,0mm

1 Hold the electrode at a 45° angle to the pin, so that the tip touches the spot where the base of the pin and the work piece meet. Now place a weld here.

(fig. 3.5 & 3.6)







2 After the pin has been tacked from two sides, the electrode tip is placed on the edge of one of the two welds, and a new weld is placed at this point. The weld is then continued in the same manner, until a seam is formed which runs all the way around the pin. This way the welds overlap eachother, creating a very solid join.

3 In this case, a piece of paper is put under the stone to protect it from dirt and soiling.