

## 5.1 Ringsizing

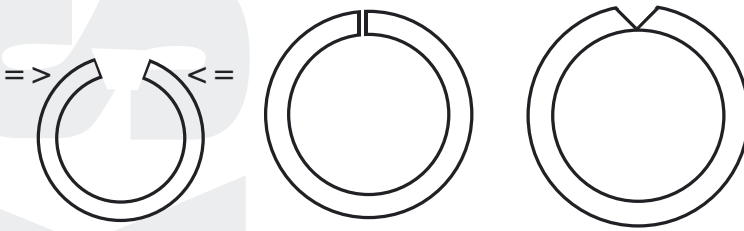
Demonstrated on a wedding ring AU 585

- 1 Re-adjust the ring to the desired size, and file a "V-shaped" groove in it.

(fig. 5.1)

First weld the joint as good as possible from the inside and outside. To prevent the edges from melting away as the joint (seam) is welded, simply hold a wire of the same alloy on the outside edges of the ring. If no wire is available, another piece of metal of the same alloy as the ring, will work just as well. In both cases the wire (or metal) will absorb some of the excess energy when welding.

(fig. 5.2)



- 2 Next lay a gold wire, of the same alloy as the ring, in the "V-groove" that has been filed; the wire should have a max. thickness of 0,4mm. Position the electrode so that it is next to the wire and the electrode tip is under the wire.

(fig. 5.3)



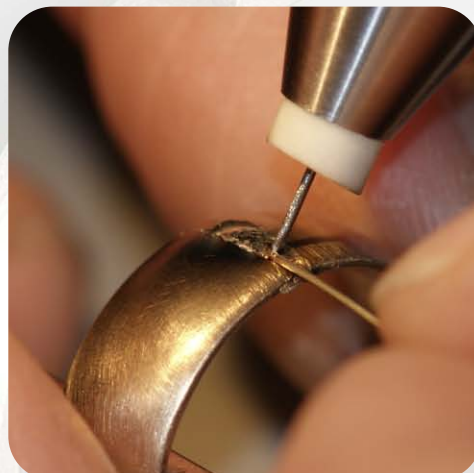
fig. 5.1



fig. 5.2



fig. 5.3



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- 3** Add the welding material (melted wire) in layers, taking care to place it as evenly and compact as possible in the groove.

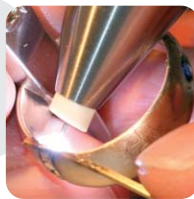
(fig. 5.4)

See workshop #2

- 4** Fill up the groove so that added material extends beyond the surface of the ring by 0,3 - 0,5mm. If necessary, also add metal to the inside face of the ring.



fig. 5.4



- 5** As a next step, the welded joint is smoothed over using the compactor.

(fig. 5.5)

- 6** Set the compactor so that it revolves at high speed, and level off the welded joint, trimming it until as precisely as possible to the desired level.



fig. 5.5

- 7** Clean or polish the seam with a burnisher or an emery file.

- 8** If the above described procedure has been carried out correctly, a stable and pore-free seam will be produced.

(fig. 5.6)



fig. 5.6