Safety

Disclaimer – you are welding at your own risk.
Protect yourself as is appropriate for your metal, environment and circumstance. TheRingLord.com assumes no liability – your safety is up to you!

Welding uses electricity and creates UV, heat, and fumes - steps should be taken to protect yourself from all of these dangers.
We recommend welding gloves and an auto-darkening welding mask.

1. UV – each weld creates a flash of light that is high in UV. Never look at the weld. For the best protection we recommend an auto-darkening welding mask and gloves. For welding for short periods of time closing your eyes at the moment you start the weld may be enough – this is a personal choice – it’s your safety. For long periods of welding you should also use sunscreen on exposed skin and gloves.

2. Heat – each weld will heat up the metal you are welding. This heat will be very concentrated but dissipates very quickly. In most situations you can have bare fingers within ¼ inch of the weld. Note that more conductive metals like silver and gold will get hotter and less conductive metals like stainless and titanium will stay cooler. Be careful what you place freshly welded rings on. Hot rings can scorch table tops, light paper on fire, etc. Again gloves can protect sensitive fingers from these dangers.

3. Electrical safety – Only qualified electrical technician should open the welder.
Note that you will get a shock if you touch the tungsten electrode, or any conductor touching the electrode, at the same time as you touch the grounded plier during a weld. Gloves will help with this as well – but you should avoid this instead of relying on the glove.

4. Fumes – most fumes caused by welding will be the result of oils on the metal being heated. To keep fumes to a minimum wash your rings. It’s also good practice to work in an area with a larger amount of air space – and to of course you need proper ventilation. You should read any MSDS info about the material you are welding. This can be found online with a quick Google search for your exact metal alloy. DO NOT WELD GALVANIZED STEEL – it produces zinc fumes which are literally deadly. Stay Safe!

Welder Specifications:
Input voltage 110 or 220V AC-50-60HZ
Typical current draw 0.8A at 110V or 90W
Fuse F2AL250V – 2A 250V quick blow fuse
What's in the box:
1. The welder – it’s the bright orange/yellow box with all plugs and knobs
2. Weld pencil – It has the red wire attached to it
3. Weld pencil base – the grey circle with a hole in it
4. Electrode – the 6” long pointy wire
5. Ceramic shield – the white cone with a hole through it
6. Weld plier – it’s a plier and it has a black wire connected to it
7. Footswitch – the grey box with the gray wire attached.
8. The power cord – it’s the same style as used on computers and monitors.

Set up (~5 minutes)
1. Screw the weld pencil base to the weld pencil. You may find it helpful to screw this down or weight it to hold it in place while you weld.
2. Insert the electrode into the hole in the screw connector with the pointy end up and lightly tighten the nut onto the electrode.
3. Place the ceramic shield over the pointy end of the electrode and adjust the electrode such that the electrode is recessed in the shield cone very slightly.
4. Plug the weld pencil into the front of the welder in the matching color plug labeled “Electrode” and the weld plier into the matching plug labeled “ground”. Plug the footswitch into the matching 2 prong connector on the front of the welder and the power plug into the back.
5. Set the “Coarse tune” knob to 5 and the “fine tune” knob to 5
6. Plug in the welder and turn in on. You are ready to weld!

Note that the welder needs to have airflow all around it to keep it cool. To allow airflow underneath is should be on a clean hard surface - never cover the welder.

Operation – get your safety gear in place before proceeding. It is your choice what level of UV, Heat and Fume Safety you work with.

1. Turn on the power switch – it will light up when the welder is on.
2. Using the grounded plier, firmly hold the butt of a perfectly closed ring in front of (but not quite touching) the electrode. Note that you should adjust the electrode and shield such that you can rest the ring directly on the ceramic shield and a position gauge.
3. This step is welding – make sure to have your eye protection in place. Quickly press and release the foot pedal. Note that holding the foot pedal down will burn out the welder – never leave your foot holding the switch closed.
4. Check your weld and see if you need more or less power. Note that the fine and coarse adjusts have about the same effect. Adjust settings and repeat your test weld until you are happy with the results.
**Tips**

Rings made from 20g or smaller wire typically take 1 weld, for thicker rings 2 or more welds at different angles are often needed if you want the weld to penetrate the entire thickness of the wire.

Welds will often be slightly discolored. Tumbling the finished piece is recommended as it will also smooth over any imperfect welds.

While welds on titanium rings look fine without gas shielding they are often much weaker than welds made with gas shielding.

**Other uses for the Ring Welder:**

- The welder is excellent for smoothing the ends of wire for piercing jewelry and ear hooks. Hold the end of the wire about a 1/16 inch in front of the electrode, hit the foot pedal and you have a perfectly smooth hemispherical end on your weld.

**Maintenance**

The electrode should remain pointy and clean. Grind as required – the rule of thumb is about a 25 degree angle. Each time you sharpen your electrode make sure the brass contacts on the weld pencil are clean and free of corrosion.

The wiring between your ground plier and the welder is the weak link – as you move the plier you flex the wire and eventually it will break. Typically the break will occur right where the wire connects to the plier. Inspect and repair on a regular basis.
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