

Jump Ring Gauge	Metal Type	Joules (W/S)
26G	Gold - Filled	3-4 Joules
26G	Sterling Silver	3-4 Joules
26G	14K Gold	3-4 Joules
24G	Gold - Filled	4-5 Joules
24G	Sterling Silver	4-5 Joules
24G	14K Gold	4-5 Joules
22G	Gold - Filled	7-8 Joules
22G	Sterling Silver	7-8 Joules
22G	14K Gold	7-8 Joules
20G	Gold - Filled	11-14 Joules
20G	Sterling Silver	11-14 Joules
20G	14K Gold	11-14 Joules

This guide is a reference point. There are variables that can affect the power setting used on each size jump ring and the base material. With or without argon may need to adjust the power setting up or down by one joule. These settings assume a sharp, new electrode on a Helix Permanent Jewelry Welder.



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