

# Honda/Acura Steel Usage and Repairability <sup>†</sup>

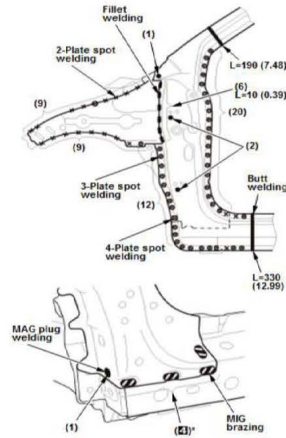
Steel Strength	Steel Designation	Cold Straighten	Heat During Straightening	MAG Welding		MAG Wire Use ***	Possible Sectioning See guidelines	STRSW Spot Weld	Auto-Set For STRSW Acceptable	Mig Brazing to 1500Mpa****	
				Plug	Butt					Single Hole	Double Hole
270	Mild	Yes	Up to 600° C*	Yes	Yes	Er70S6	Yes	Yes w/ Zinc Based Weld-through Primer	Yes	Yes	No
340	HSS	Yes	Up to 600° C*	Yes	Yes	Er70S6	Possible	Yes w/ Zinc Based Weld-through Primer	Yes	No	Yes
440	HSS	Yes	Up to 600° C*	Yes	Yes	Er70S6	Possible	Yes w/ Zinc Based Weld-through Primer	Yes	No	Yes
590	HSS	Yes	Up to 600° C*	Yes	Yes	Approved High-Strength Steel	Possible	Yes w/ Zinc Based Weld-through Primer	Yes	No	Yes
780	HSS	No	No Repairs	Yes	Yes	Approved High-Strength Steel	Possible	Yes w/ Zinc Based Weld-through Primer	Yes	No	Yes
980	UHSS	No	No Repairs	Yes	No	Approved High-Strength Steel	Not Allowed	Yes w/ Zinc Based Weld-through Primer	Yes	No	Yes
1180	UHSS	No	No Repairs	Yes**	No	Approved High-Strength Steel	Not Allowed	Yes w/ Zinc Based Weld-through Primer	NO Manual Setting Required	No	Yes
1500	UHSS	No	No Repairs	Yes**	No	Approved High-Strength Steel	Not Allowed	Yes w/ Zinc Based Weld-through Primer	NO Manual Setting Required	Only to 270	To all HSS/UHSS

\* Heat may be applied with induction heater, copper stamp, heat gun or similar device but NO OPEN FLAME  
 \*\*Only as specified in the Body Repair Manual  
 \*\*\* Based on strength of weaker panel  
 \*\*\*\* MIG Brazing is only performed where indicated in the Model Specific Body Repair Manual

Plug Hole Diameter			
Panel Thickness	< 1mm	1mm - 1.5mm	> 1.5mm
Hole Diameter mm (in)	6.0 (0.24")	8.0 (0.31")	10 (0.39")

Tearout on test plug welds and spot welds should be  $\geq 4.5 \times$  Square Root of the panel thickness

†All information in this document has been compiled from the Honda and Acura Body Repair Manuals and Service Repair Information located at <http://techinfo.honda.com>. Always follow the model specific body repair manuals for detailed repair procedures.



### Replacement

The welding symbols in the removal/installation have these meanings. The welding symbols with dashed lines have a meaning of the spot welding of the part which is not visible.

NOTE: To maintain the original body strength and collision safety performance, carefully follow published welding methods. Do not substitute.

- ⊗ and ⊙: 2-Plate spot welding
  - ⊗ and ⊙: 3-Plate spot welding
  - ⊗ and ⊙: 4-Plate spot welding
  - : MAG plug welding
  - : MAG welding (butt or fillet)
  - ⊗: Double Hole MIG brazing (1500 MPa to HSS/UHSS)
  - ⊙: Single Hole MIG brazing (270 MPa to 1500 MPa)
- L and L\*: Welding length, unit: mm (in)  
 ( ) and ( ): The number of welds

