Honda/Acura Steel Usage and Repairablilty †

Updated August 19, 2019

Steel Strength Strength	Steel Designation	Cold Straighten	Heat During Straightening	MAG Welding Plug	MAG Welding Butt	MAG Wire Use ***	Possible Sectioning See guidelines	STRSW Spot Weld	Auto-Set For STRSW Acceptable	Mig Brazing to 1500Mpa**** *Pulse Welder Required* Single Hole	Mig Brazing to 1500Mpa**** *Pulse Welder Required* 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**

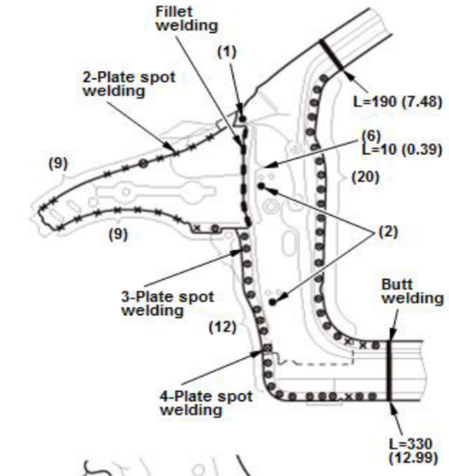
***** Based on strength of weaker panel**

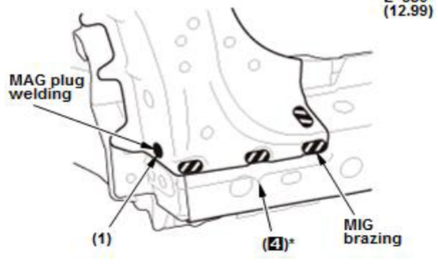
****** MIG Brazing is only performed where indicated in the Model Specific Body Repair Manual**

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 =/> 4.5 x 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

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