

Honda/Acura Steel Usage and Repairability[†]

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**** Pulse Welder Required	
				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

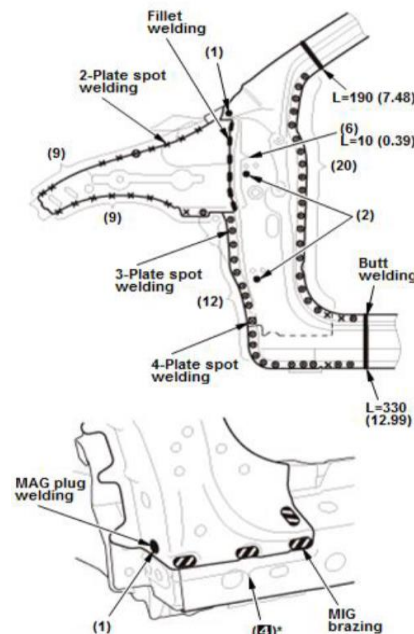
*** Based on strength of weaker panel

**** 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

