

## Ultra High Strength Steel

This information provides repair recommendations and general guidelines for steel classified as Ultra High Strength Steel, also know as UHSS. This type of steel normally has a tensile strength greater than 700MPa.

This includes the common steel names of:

- Ultra High Strength Steel (UHSS)
- Martensitic Steel (MS)
- Press Hardened Steel (PHS)
- Boron Steel

**Note:**

- Repair of this type of steel is not recommended.
- This type of steel should be replaced at factory joints only. Sectioning or partial replacement is not recommended.
- The use of heat to repair damage is not recommended for this type of steel.
- Stitch welding is not recommended for this type of steel.
- This type of steel can not be used as a backing reinforcement or a sleeve for a sectioning joint.

**Recommended Repairs**

- Squeeze resistance spot welding can be used to replace factory spot welds, where applicable.
- MIG plug welding can be used to replace factory spot welds.
- MIG brazing can be used to replace factory spot welds.