



## Mild Steel

This information provides repair recommendations and general guidelines for steel classified as Mild Steel. This type of steel normally has a tensile strength less than 270MPa. This includes the common steel names of:

- Mild Steel
- Bake Hardenable Steel (BH)
- Solid Solution Strengthened Steel

General Motors recommends the following when repairing or replacing this type of steel during collision repair.

### Recommended Repairs

- Cold repairs can be performed on this type of steel, unless the damage includes kinks. If the damage includes kinks, the part should be replaced.
- Controlled use of heat can be used to repair damage, if the heat does not exceed 650° C (1200° F). The heat should be applied a maximum of 2 times, for up to 90seconds.
- Sectioning or partial replacement of this type of steel is recommended only at approved locations, in a specific sectioning procedure.
- This type of steel can be used as a sleeve, or backer plate, when recommended in a specific sectioning procedure.
- Squeeze resistance spot welding can be used to replace factory spot welds, where applicable
- MIG plug welding and MIG stitch welding can be used on this type of steel.
- MIG brazing can be used on this type of steel.

