



## Ultra High Strength Dual Phase Steel

This information provides repair recommendations and general guidelines for steel classified as Ultra High Strength Dual Phase Steel (dual phase steel with a tensile strength greater than 800MPa), also known as DPX.

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

**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 classification of steel cannot be used as a backing reinforcement or a sleeve for a sectioning joint, unless a specific procedure is available.

**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.

