



High Strength Low Alloy Steel

This information provides repair recommendations and general guidelines for steel classified as High Strength Low Alloy Steel, also known as HSLA. This type of steel normally has a tensile strength range from 300–700MPa.

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, during sectioning procedures.
- 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.

