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 270 MPa. 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 1200°F (650°C). The heat should be applied a maximum of 2 times, for up to 90 seconds.

• 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.