

Ford-Recommended Steel Repairability Matrix

Grade	Trade Descriptions	Welding Method			Cold Repairs	Use of Heat for Repair	Temp. Range	Maximum Heat
		MIG	RSW	MIG Braze				
Mild Steel	Mild	Yes	Yes	N/A	Yes**	Yes	Up to 1200°F (650°C)	90 sec. X 2
Laminate Steel	Quiet Steel	No	Yes	No	Yes**	No	N/A	N/A
Bake-Hardened	BH 180, BH 210, BH 250, BH 280	Yes	Yes	Yes	Yes**	Yes	Up to 1200°F (650°C)	90 sec. X 2
Solid Solution-Strengthened		Yes	Yes	Yes	Yes**	Yes	Up to 1200°F (650°C)	90 sec. X 2
High-Strength, Low-Alloy	HSLA 250, HSLA 350, HSLA 550	Yes	Yes	Yes	Yes**	Yes	Up to 1200°F (650°C)	90 sec. X 2
Dual-Phase <= 600 Mpa UTS (particular to 780 and 980 grades)***	DP 500, DP 600	Yes	Yes	Yes	Yes**	No	N/A	N/A
UHSS Martensitic Boron****	Bare Boron USIBOR	Yes* (plug weld only)	Yes	Yes	No	No	N/A	N/A
TRIP	TRIP 590, TRIP 780, TRIP 980	N/A	N/A	N/A	N/A	N/A	N/A	N/A

NOTE: MIG Braze allowed for non-structural applications only.

* Mig Plug Only, NO STITCH WELDING.

** Cold repairs can be performed if damage excludes kinks; may section only if Workshop Manual procedure allows.

*** Dual-phase steels DP 700, DP 780 and DP 980 must be replaced at factory joints; may section only if Workshop Manual procedure allows.

**** Boron components must be replaced at factory joints; no sectioning allowed.

