



Front Line Advice Bulletin

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Revised: 05/08/2019

Title: Mazda New Zealand Spot Welding Requirement for Panel Repairers

Model(s): ALL

Category: Body

Distribution: Dealer Principal Service Manager Parts Manager Sales Manager

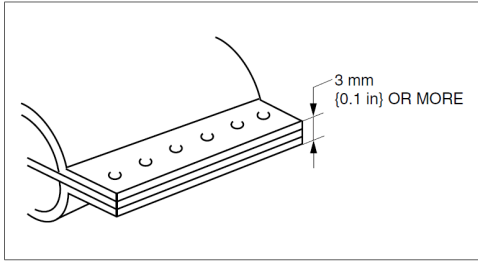
Mazda New Zealand Spot Welding Requirement for panel Repairers

Revised – Clarification that Plug welding is required for panel thickness over 3 mm, & examples where spot welding using STRSW is appropriate in place of plug-welding & additional notes.

The Mazda Body Shop Manual recommends the use of CO2 arc welding (plug welding) in place of the original spot welds where the combined panel thickness or cross-section is greater than 3 mm, as per the following instruction from the Mazda Bodyshop Manual.

Determination of Welding Method

- If the total thickness at the area to be welded is 3 mm {0.12 in} or more, use a gas shielded-arc welder to make the plug welds.



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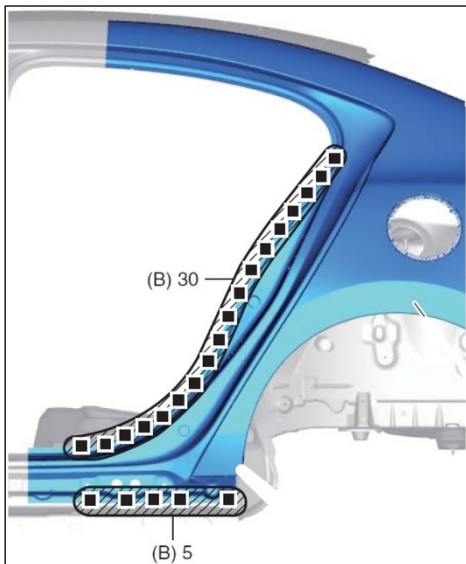
Many Accident or Panel Repairers have invested in Squeeze Type Resistance Spot Welders (STRSW) that can replicate a factory spot weld.

In order to allow repairers who have invested in approved / certified STRSW welding systems use the equipment wherever possible during the repair of Mazda vehicles please apply the following:

Statements

- Where the Mazda Bodyshop Manual specifies Plug Welding and the combined panel thickness is up to 3mm, use of a STRSW is both possible and appropriate instead of the recommended plug welding. However, the spot welder **MUST** meet the standards or requirements specified on Page 2:**
- GMA / MiG Plug welding is the ONLY acceptable welding method where the Panel thickness 3mm or above.**
(Continued on Page 2.)

Rear Fender Panel Installation / Replacement



In cases such as examples (A & B), where “Plug Welding is specified in the Mazda Bodyshop Manual, the use of a STRSW is both possible and appropriate instead of the recommended plug welding; Where the STRSW meets the requirements outlined on Page 2 and the panel thickness is less than 3 mm.

For all repair guidelines, specifications and methods, please refer to the Mazda Workshop and Body shop manuals which can be accessed (by subscription and secure payment) via the following website:- www.mazdamanuals.com.au

Please share this advice with any Panel Repair shop repairing Mazda vehicles.

*This information is valid from **05/08/2019** for 12 Months from the (revised) date of this bulletin.*

Kind regards,

A handwritten signature in black ink, which appears to read 'John Van der Velden'.

John Van der Velden
NATIONAL SERVICE MANAGER