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# 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.
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