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# Ultra High Strength Dual Phase Steel

This information provides repair recommendations and general guidelines for steel classified as Ultra High Strength Dual Phase Steel (Dual Phase Steel with a tensile strength greater than 800 MPa), also known as DPX.

General Motors recommends the following when repairing or replacing this type of steel during collision repair.

## **Important:**

- Repair of this type of steel is not recommended.
- This type of steel should be replaced at factory joints only. Sectioning or partial replacement is not recommended.
- The use of heat to repair damage is not recommended for this type of steel.
- Stitch Welding is not recommended for this type of steel.
- This classification of steel can not be used as a backing reinforcement or a sleeve for a sectioning joint, unless a specific procedure is available.

## **Recommended Repairs:**

- Squeeze Resistance Spot Welding can be used to replace factory spot welds, where applicable.
  - MIG plug welding and can be used to replace factory spot welds.
  - MIG Brazing can be used to replace factory spot welds.
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