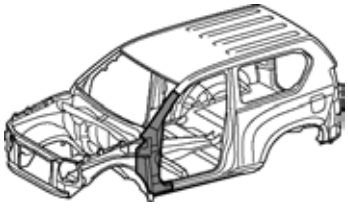
FRONT BODY PILLAR (CUT):
3 Door


F43232A

Weld work for 980 MPa ultra high strength steel

1 Follow the welding conditions below when welding ultra high strength steel to assure sufficient weld strength. (When repairing this model)

*1: When welding 2 panels together including 980 MPa ultra high strength steel.

Spot weld	Pressure	2940 N (300 kgf, 661 lbf)
	Weld current	10000 A
	Weld time	18 Cyc. (0.30 Sec.)
Plug weld	Plug diameter	10 mm (0.39 in.)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

*2: When welding more than 3 panels together including 980 MPa ultra high strength steel. (When plug welding a panel to the welded panels with the weld condition above.)

Plug weld	Plug diameter	Same as the standard method (See the introduction)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

HINT:
Be sure to use Metal active gas (Ar 80% + CO_2 20%) as the shield gas when plug welding.
Sufficient weld strength cannot be assured when using 100% CO_2 shield gas.

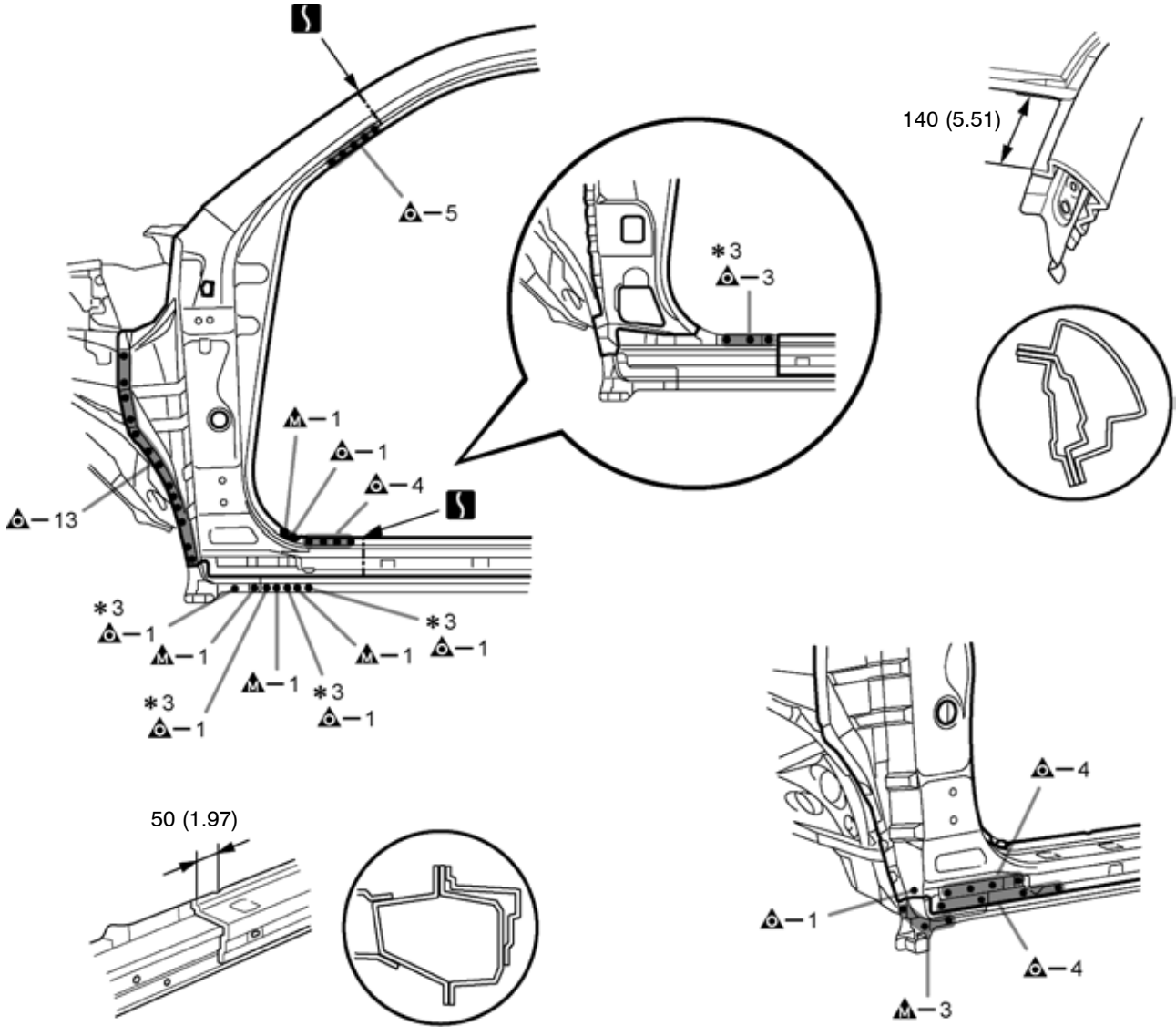
With the cowl top side panel removed.

Symbol meaning

: Remove Weld Points : Cut and Join Location

F43232B

REMOVAL

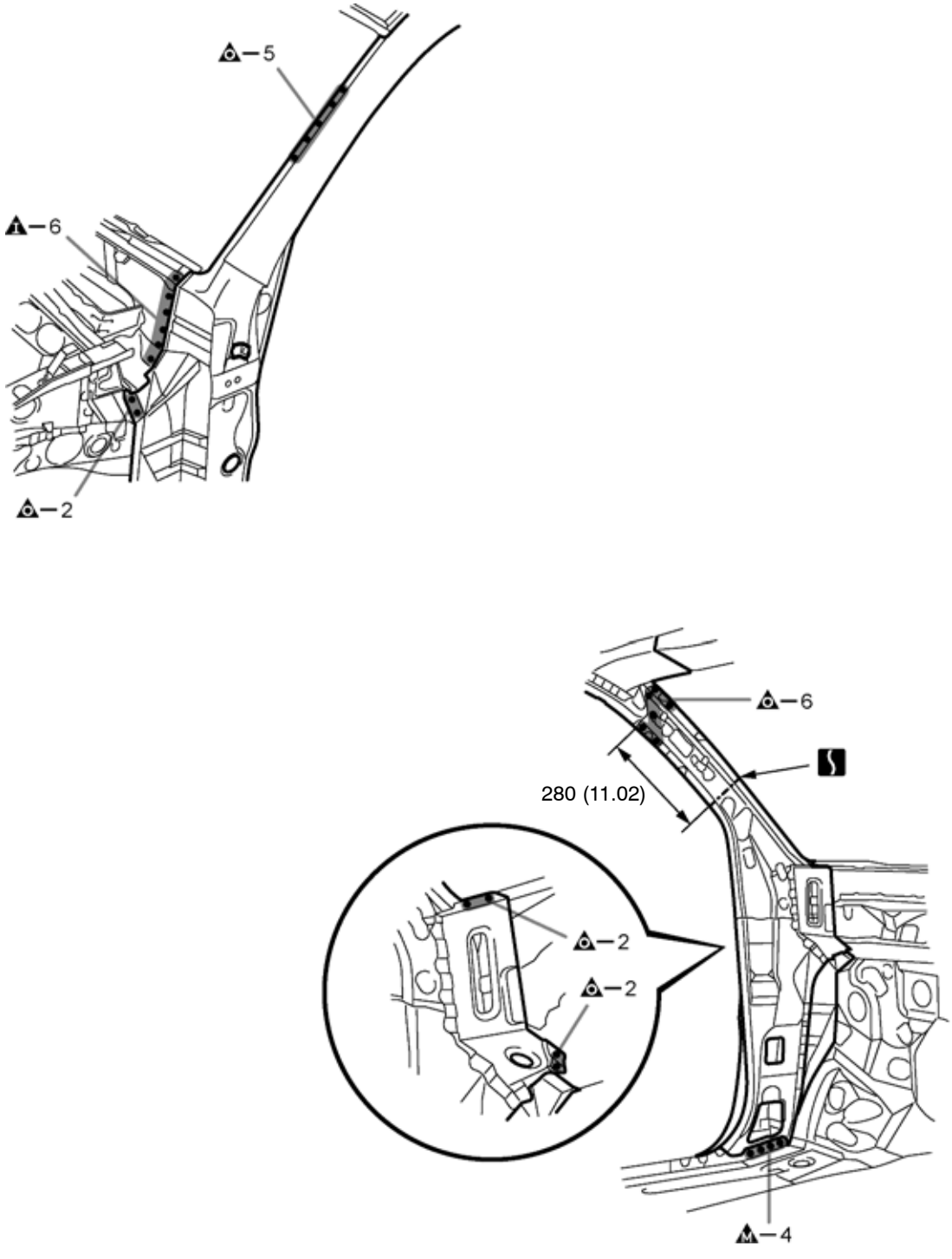


F43232

REMOVAL POINT

1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

2 *3 indicates welds to remove for easier removal.



mm (in.)

F43233

REMOVAL POINT

1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

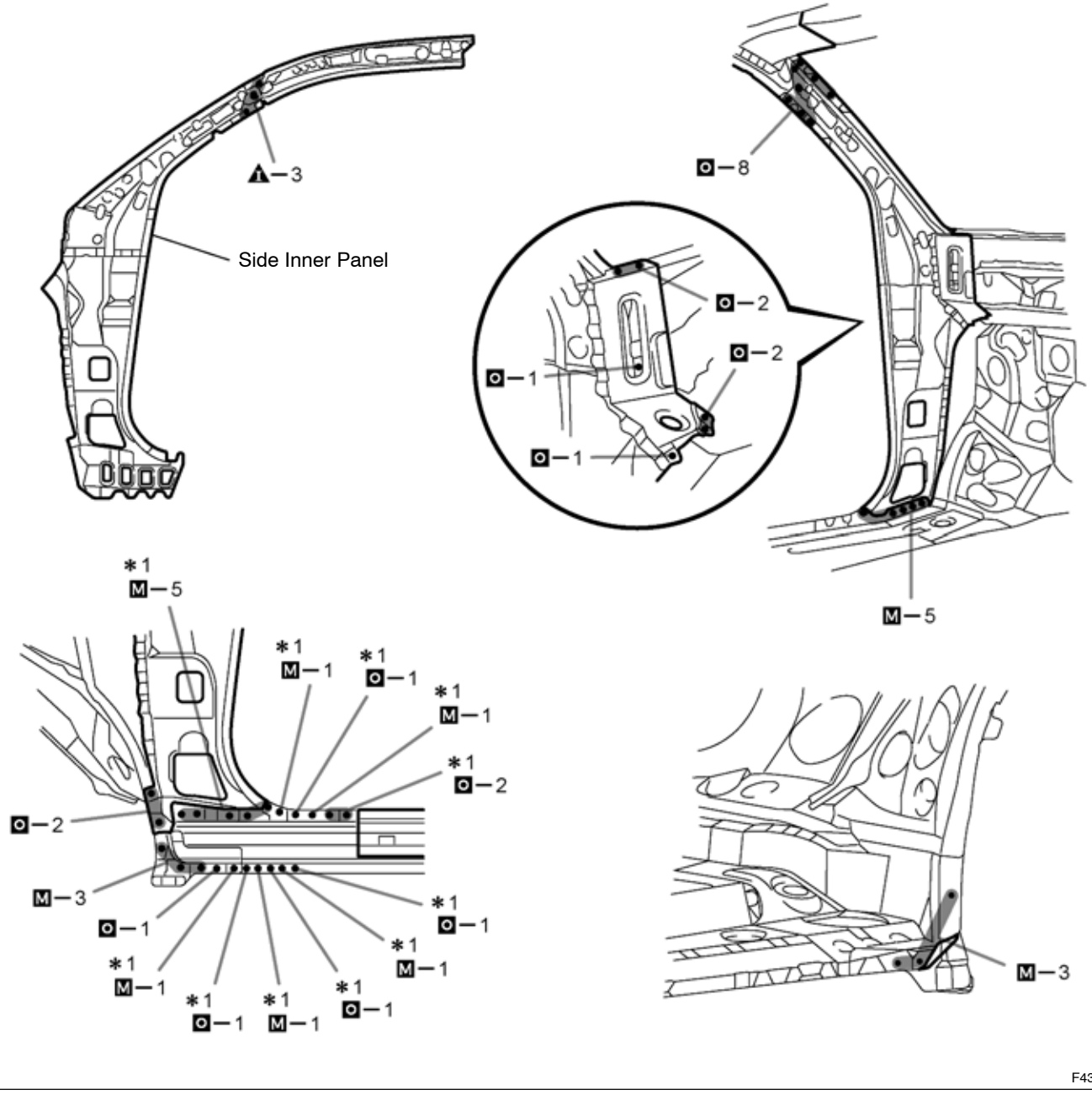
Symbol meaning

: Remove Weld Points : Plug Weld : Butt Weld

: Body Sealer

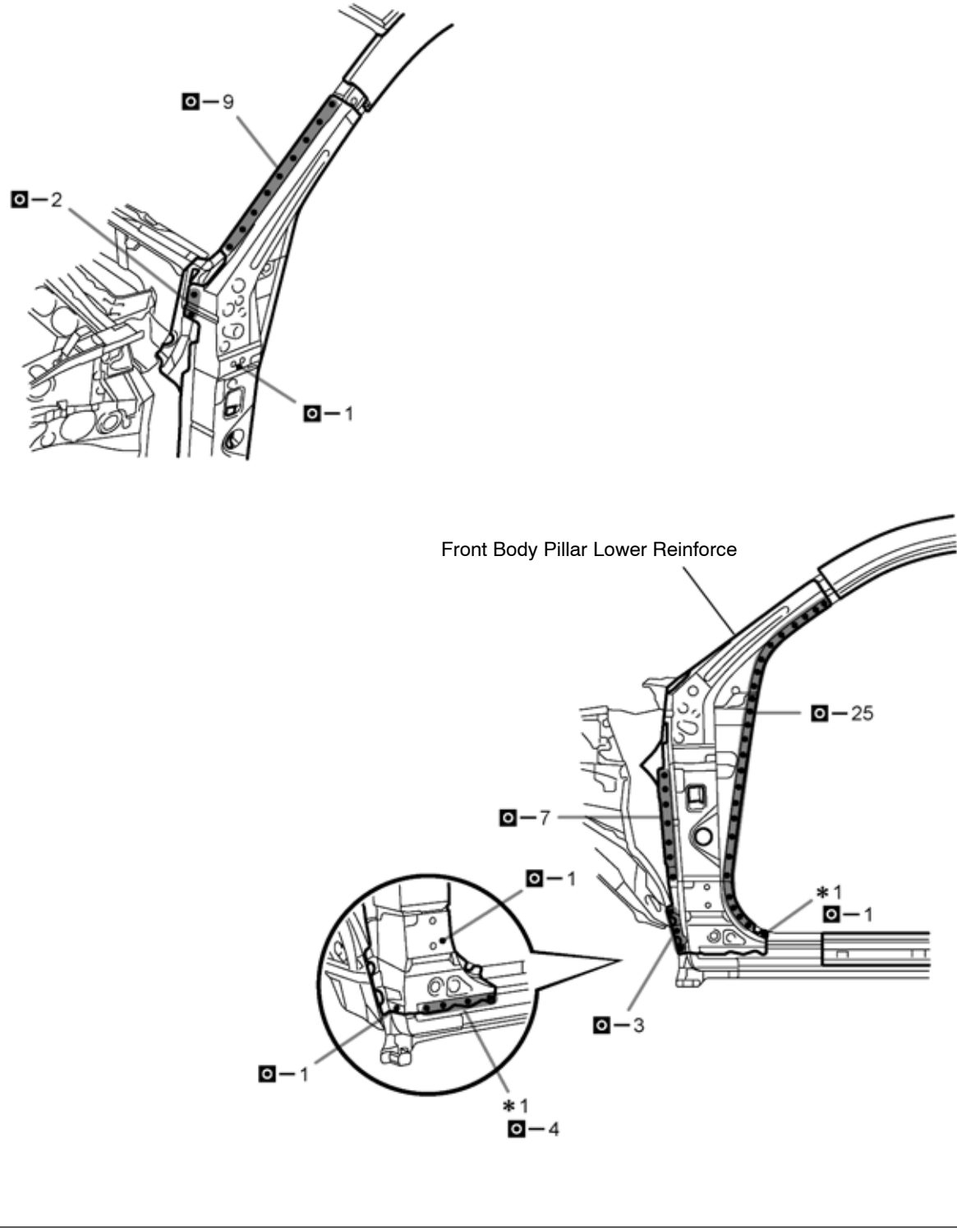
F43234B

INSTALLATION



INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 If the entire supply part is not needed, remove the part of the supply part that is needed.
4 Follow the welding conditions when welding point *1 to assure sufficient weld strength. (See the introduction)
5 After welding the side inner panel to the vehicle side, install the front body pillar lower reinforce.



INSTALLATION POINT

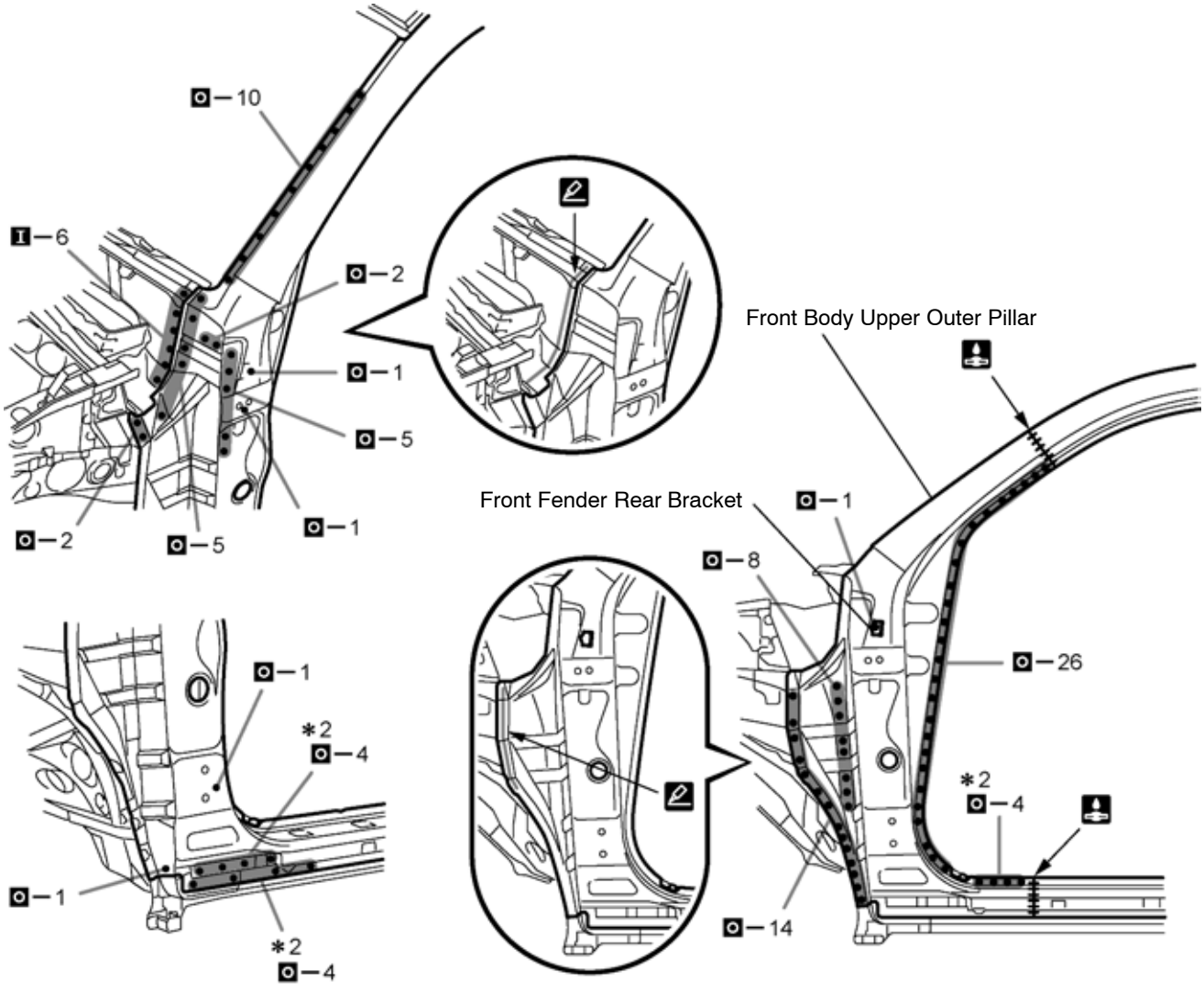
1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions when welding *1 to assure sufficient weld strength. (See the introduction)
4 After welding the front body pillar lower reinforce to the vehicle side, install the front body upper outer pillar.

Symbol meaning

: Remove Weld Points : Plug Weld : Butt Weld

: Body Sealer

F43234B



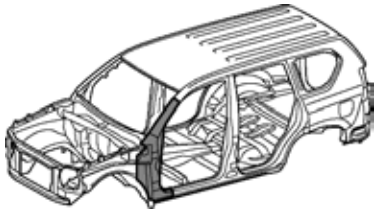
F43236

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions when welding point *2 to assure sufficient weld strength. (See the introduction)
4 After welding the side inner panel and front body pillar lower reinforce to the vehicle side, install the front body upper outer pillar and front fender rear bracket.
5 Before installing a new part, apply body sealer.
HINT:
Apply body sealer in an even, continuous bead.
6 After welding, apply the foamed sealing material to the corresponding parts. (See the paint·coating)
7 After welding, apply body sealer to the corresponding parts. (See the paint·coating)
8 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRONT BODY PILLAR (CUT):

5 Door


F43237A

Weld work for 980 MPa ultra high strength steel

1 Follow the welding conditions below when welding ultra high strength steel to assure sufficient weld strength. (When repairing this model)

*1: When welding 2 panels together including 980 MPa ultra high strength steel.

Spot weld	Pressure	2940 N (300 kgf, 661 lbf)
	Weld current	10000 A
	Weld time	18 Cyc. (0.30 Sec.)
Plug weld	Plug diameter	10 mm (0.39 in.)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

*2: When welding more than 3 panels together including 980 MPa ultra high strength steel. (When plug welding a panel to the welded panels with the weld condition above.)

Plug weld	Plug diameter	Same as the standard method (See the introduction)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

HINT:
Be sure to use Metal active gas (Ar 80% + CO_2 20%) as the shield gas when plug welding.
Sufficient weld strength cannot be assured when using 100% CO_2 shield gas.

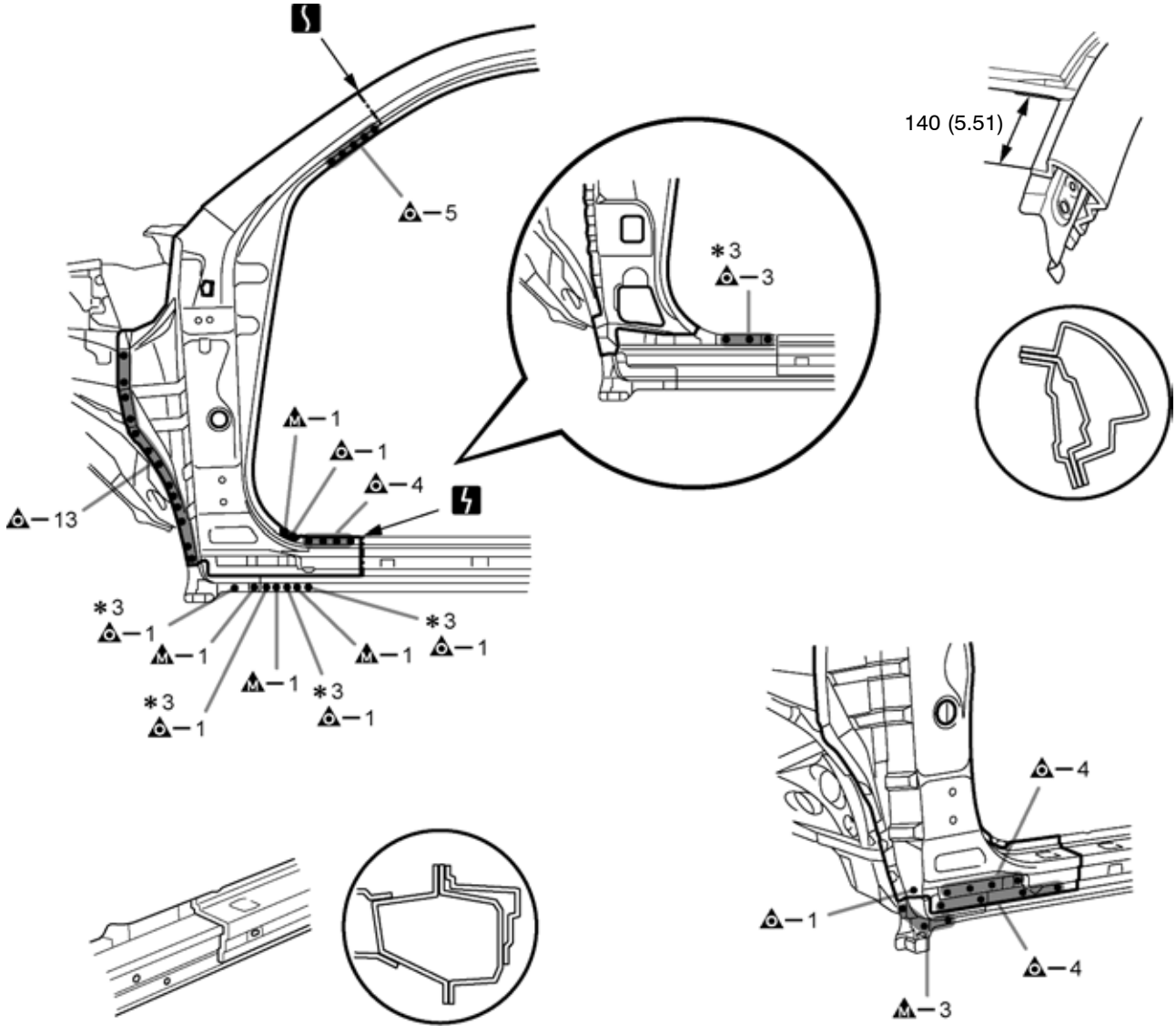
With the cowl top side panel removed.

Symbol meaning

: Remove Weld Points : Cut and Join Location : Cut Location for Supply Parts

F43237B

REMOVAL

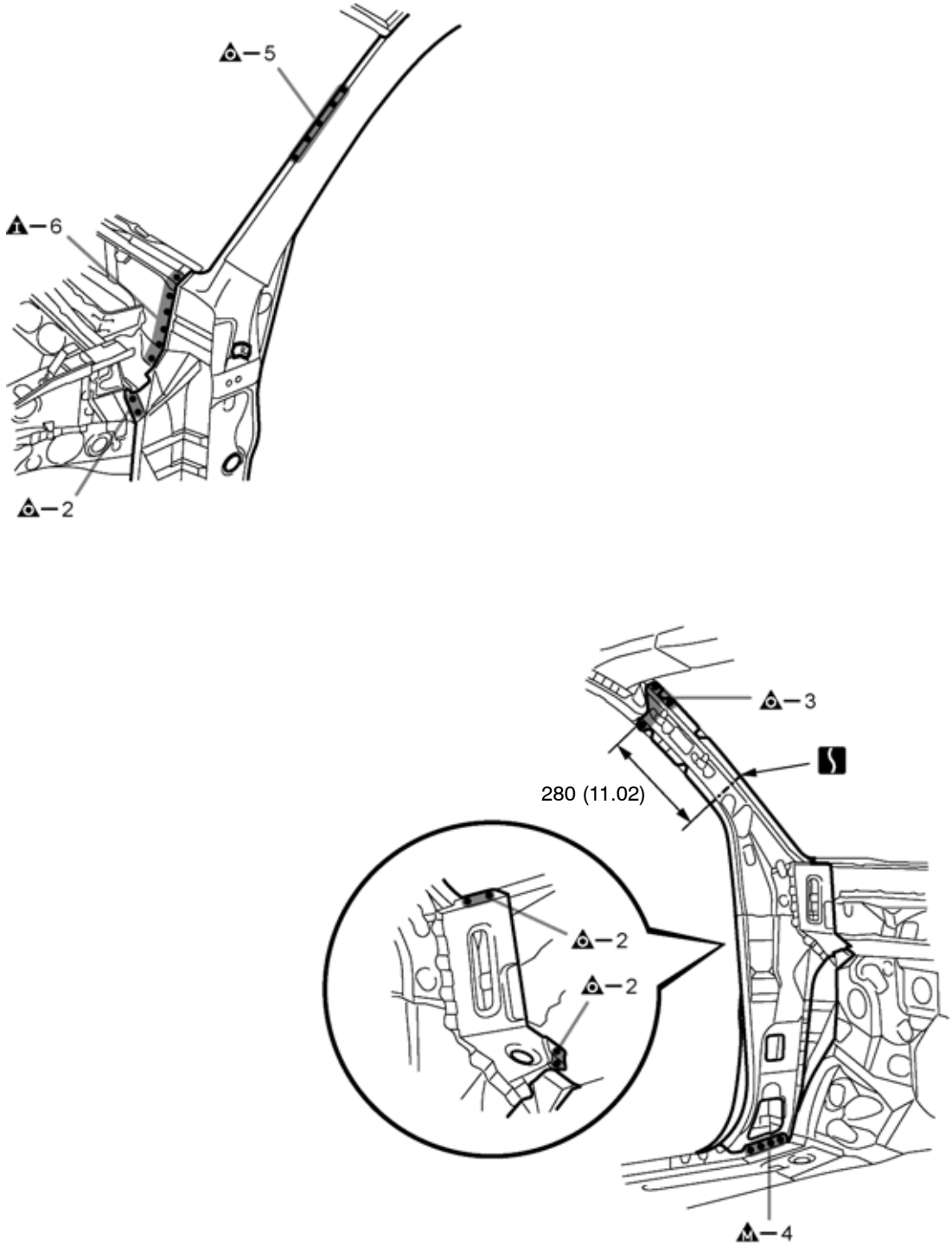


F43237

REMOVAL POINT

1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

2 *3 indicates welds to remove for easier removal.



REMOVAL POINT

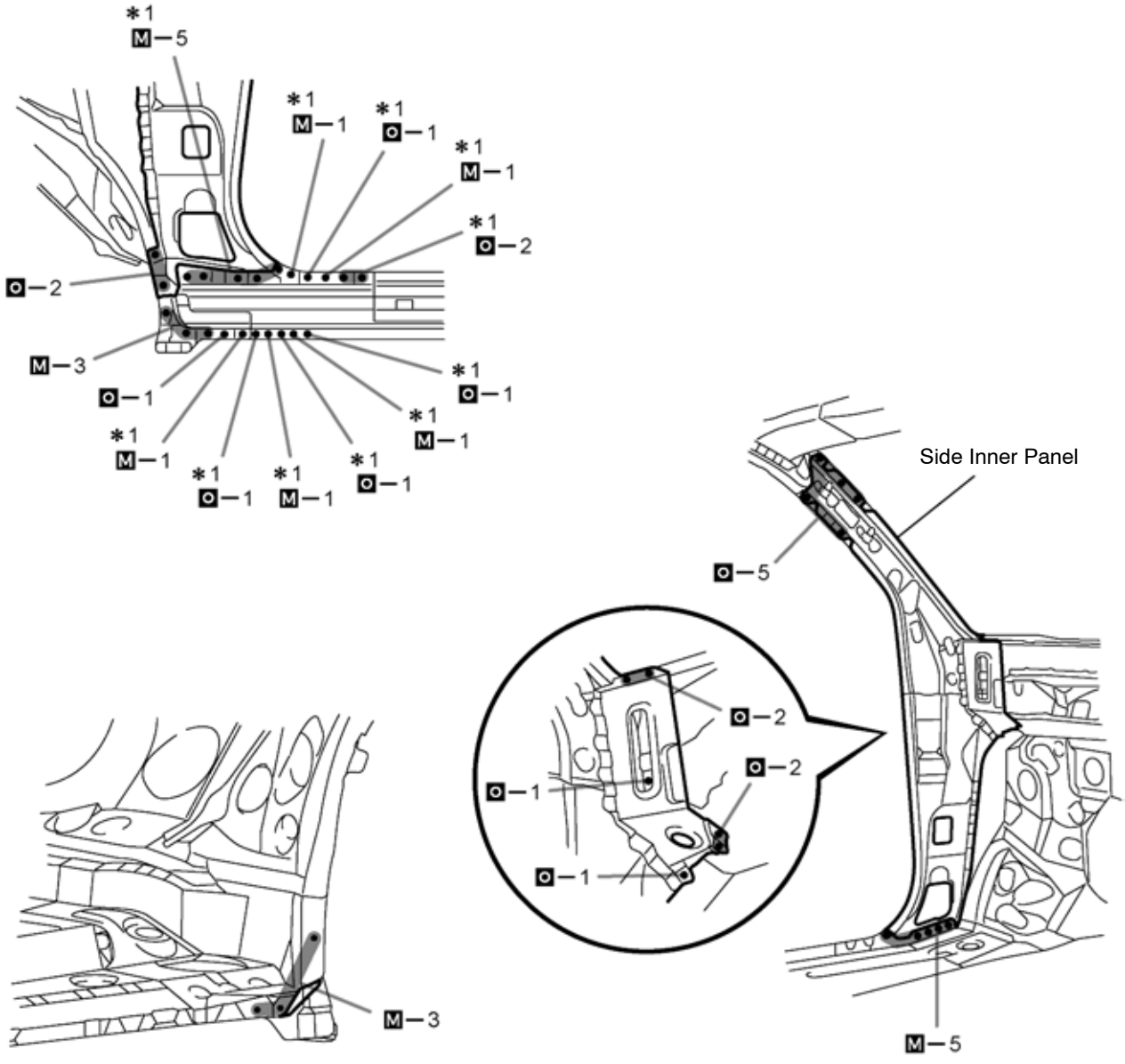
1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

Symbol meaning

: Plug Weld : Butt Weld : Body Sealer

F43239B

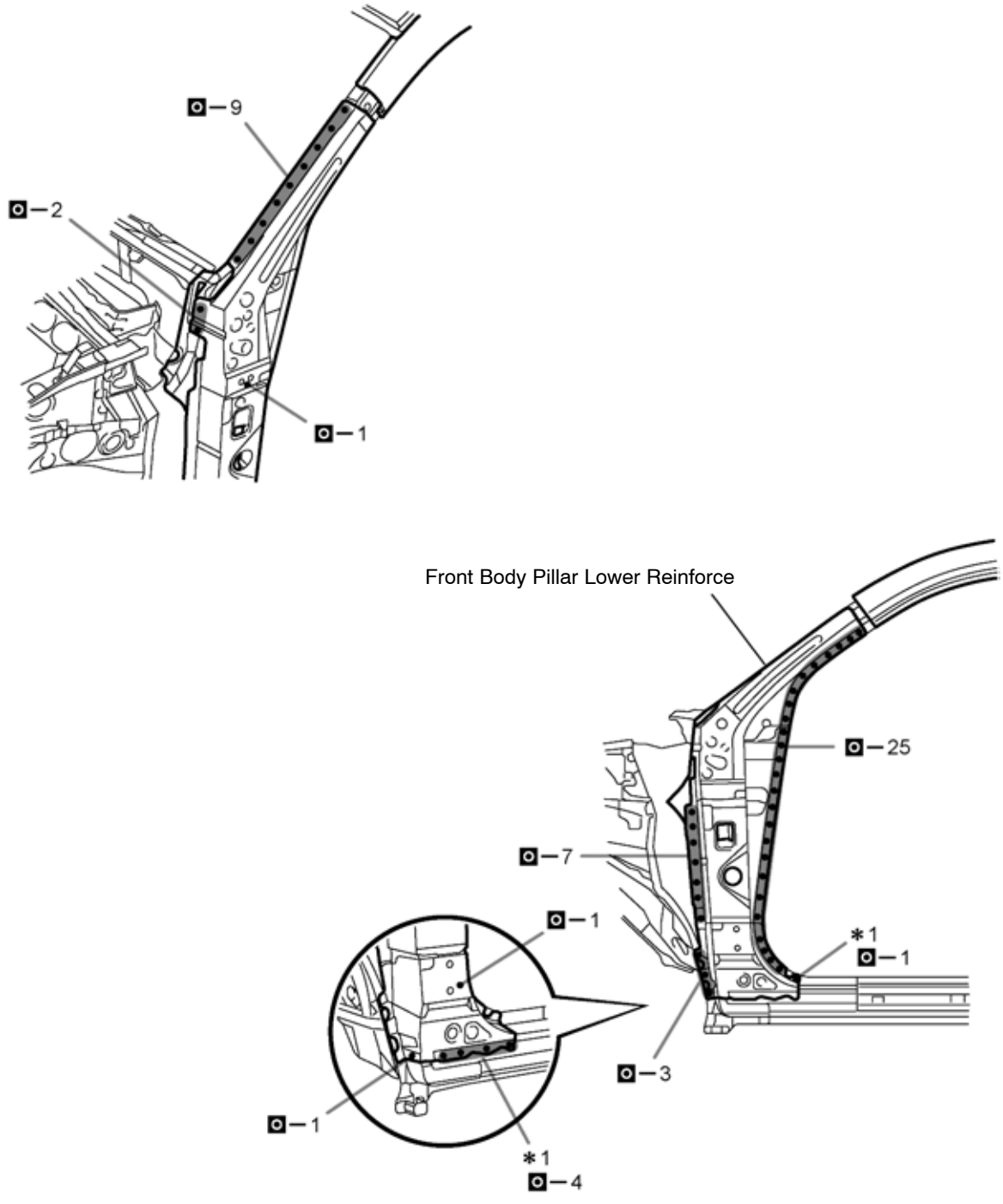
INSTALLATION



F43239

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions when welding point *1 to assure sufficient weld strength. (See the introduction)
4 After welding the side inner panel to the vehicle side, install the front body pillar lower reinforce.



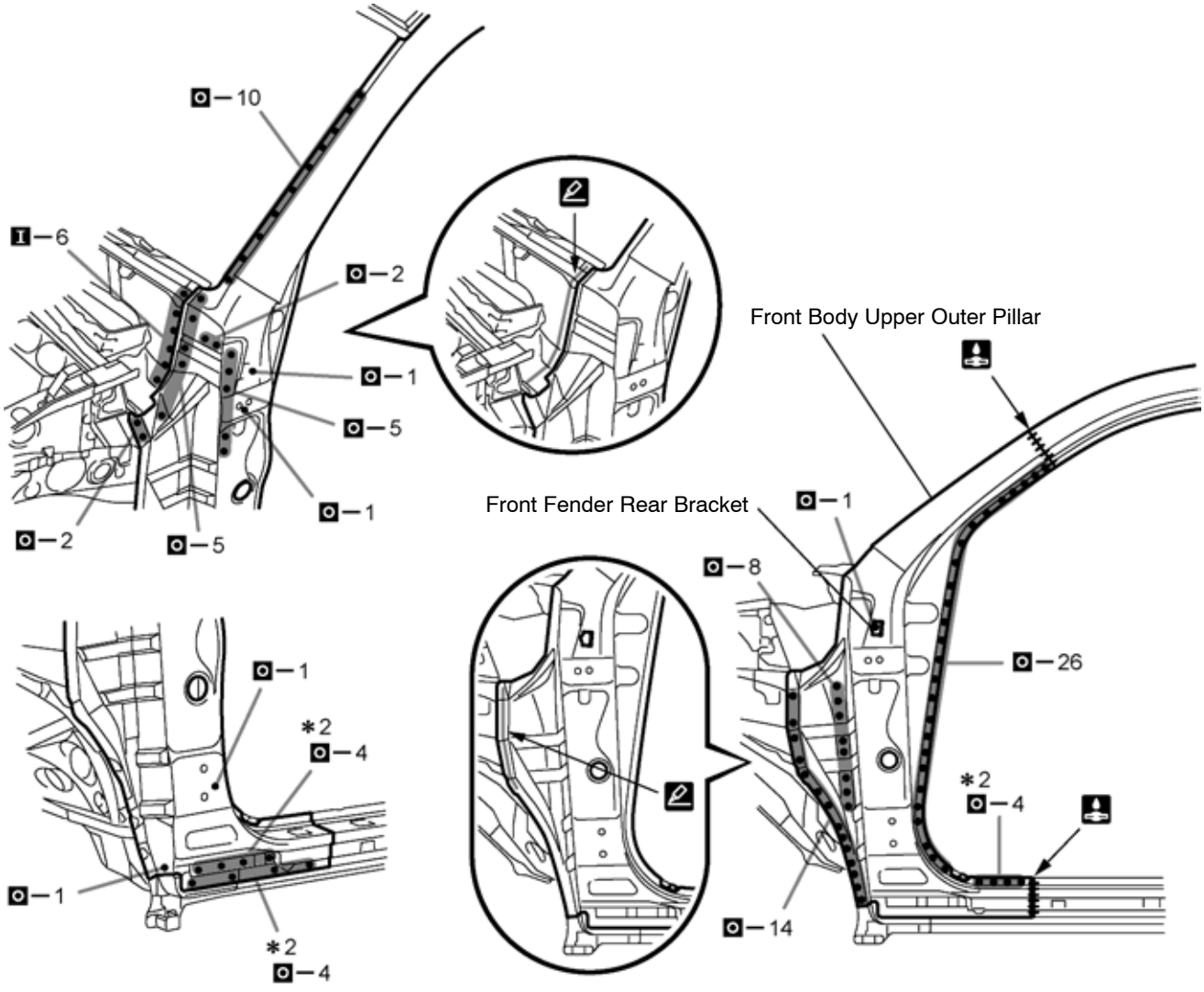
INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions when welding *1 to assure sufficient weld strength. (See the introduction)
4 After welding the front body pillar lower reinforce to the vehicle side, install the front body upper outer pillar.

Symbol meaning

: Plug Weld : Butt Weld : Body Sealer

F43239B



F43241

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions when welding point *2 to assure sufficient weld strength. (See the introduction)
4 After welding the side inner panel and front body pillar lower reinforce to the vehicle side, install the front body upper outer pillar and front fender rear bracket.
5 Before installing a new part, apply body sealer.
HINT:
Apply body sealer in an even, continuous bead.
6 After welding, apply the foamed sealing material to the corresponding parts. (See the paint·coating)
7 After welding, apply body sealer to the corresponding parts. (See the paint·coating)
8 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.