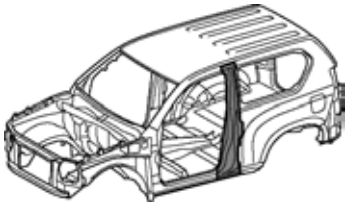
CENTER BODY PILLAR (CUT):

3 Door



F43242A

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.

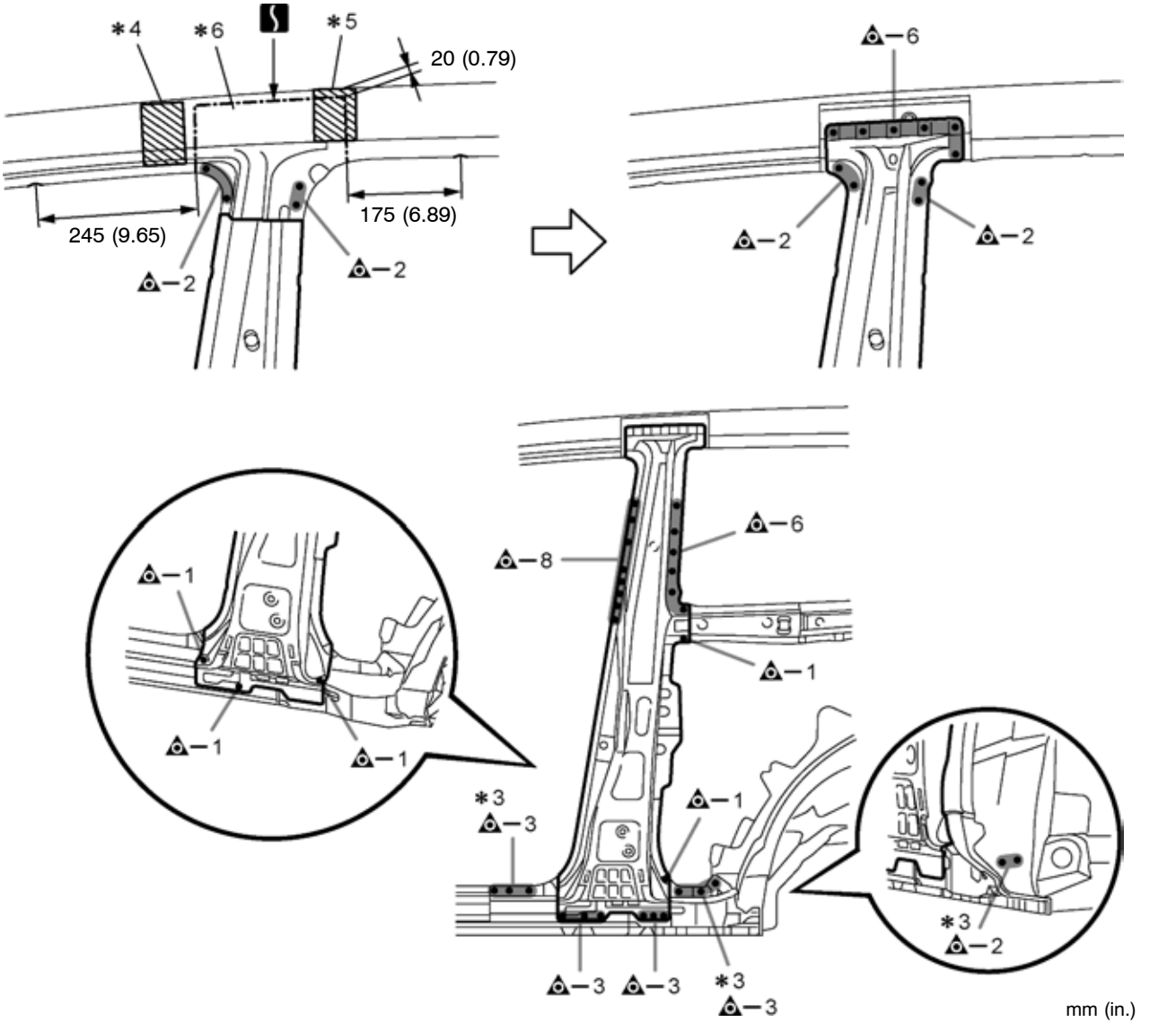
With the quarter panel removed.

Symbol meaning

: Remove Weld Points : Cut with Disc Sander etc. : Cut and Join Location

F43242B

REMOVAL

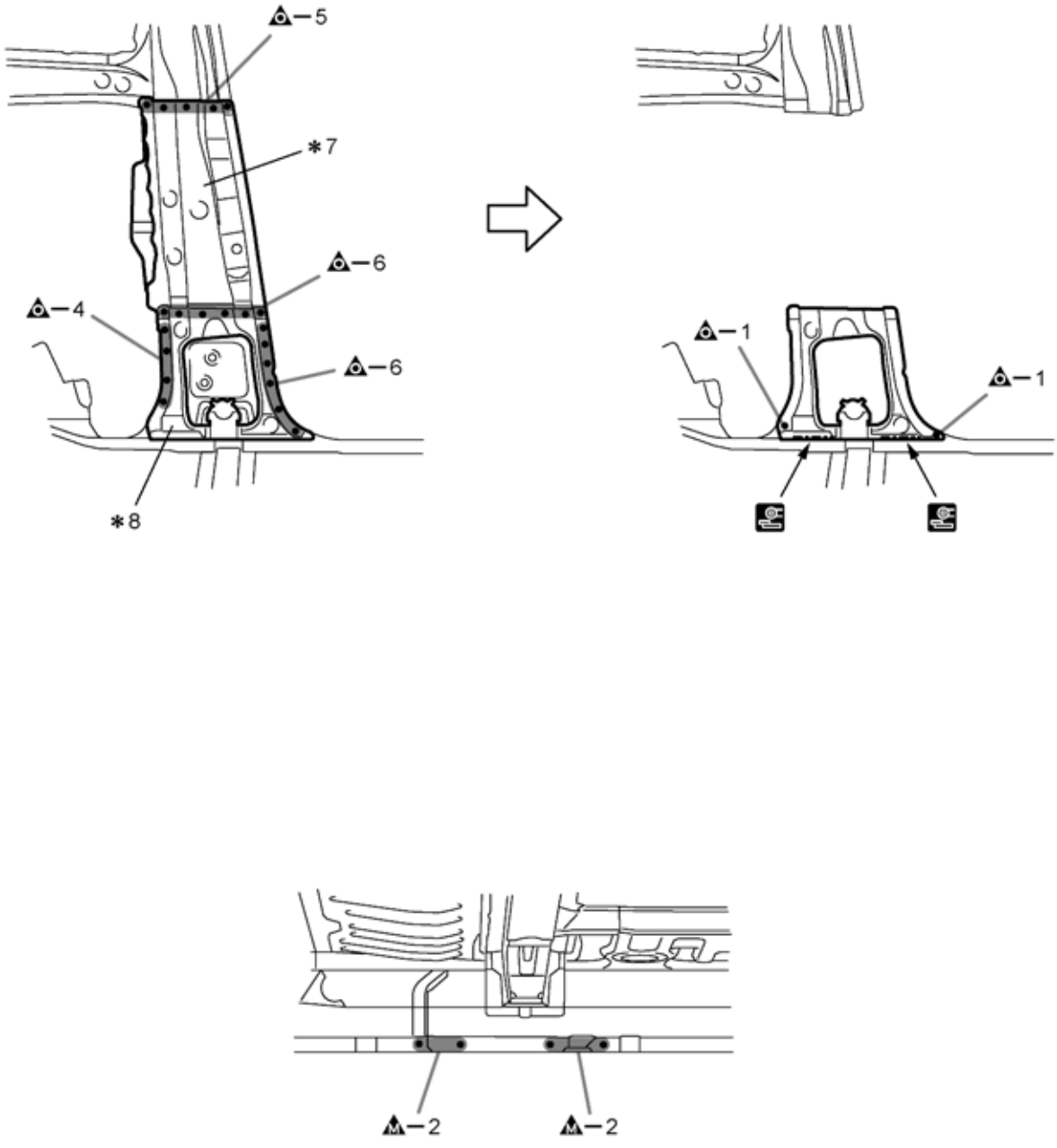


mm (in.)

F43242

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.
3 *4 and *5 indicates the location of the foamed sealing material. Be careful when cutting as the foamed sealing material is located near the cutting position.
4 Remove the remaining foamed sealing material from the vehicles side.
5 *6 is reused.



F43243

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)

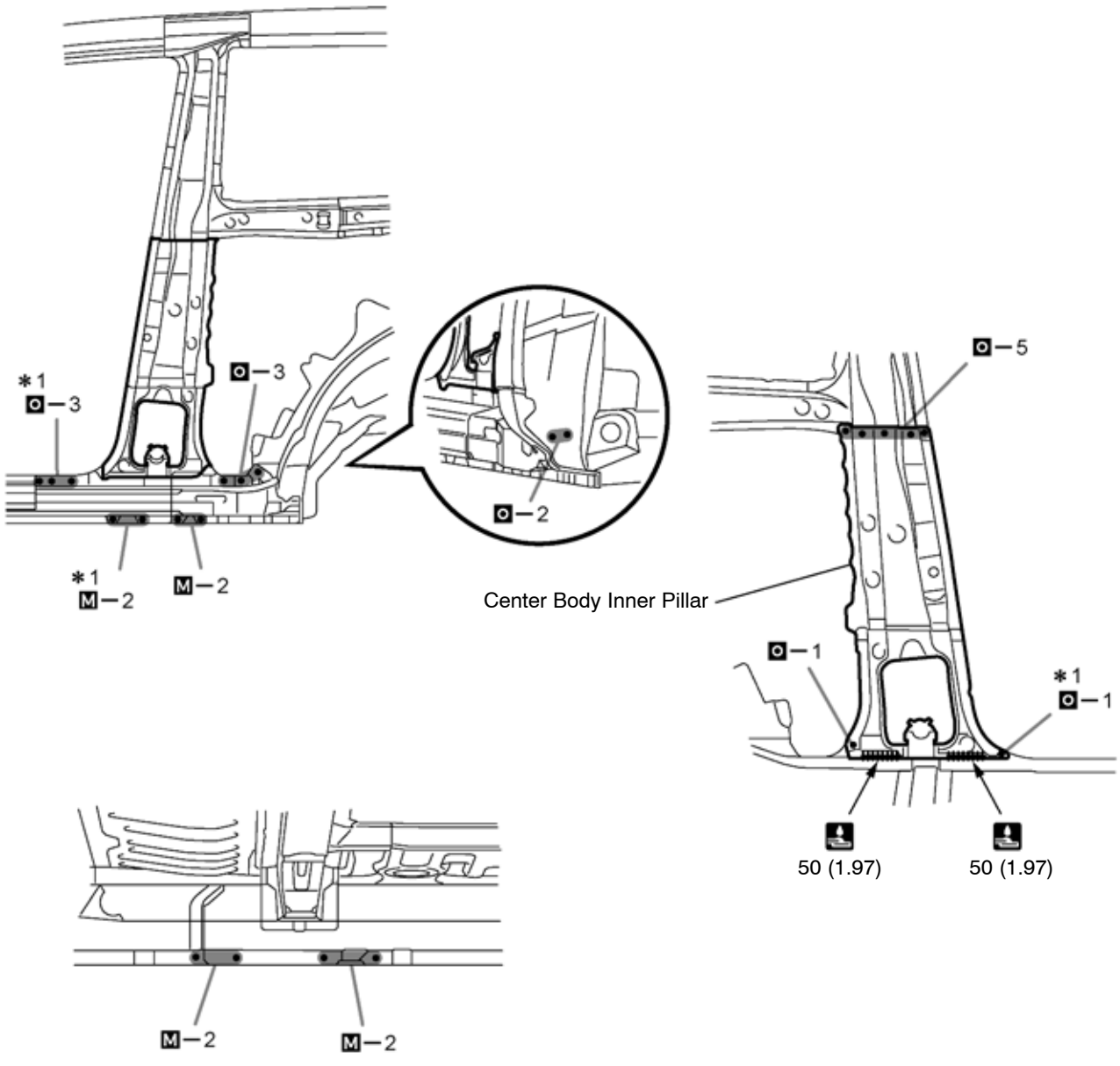
2 After removing the *7, remove the *8.

Symbol meaning

: Plug Weld : Fillet Weld : Butt Weld

F43244B

INSTALLATION

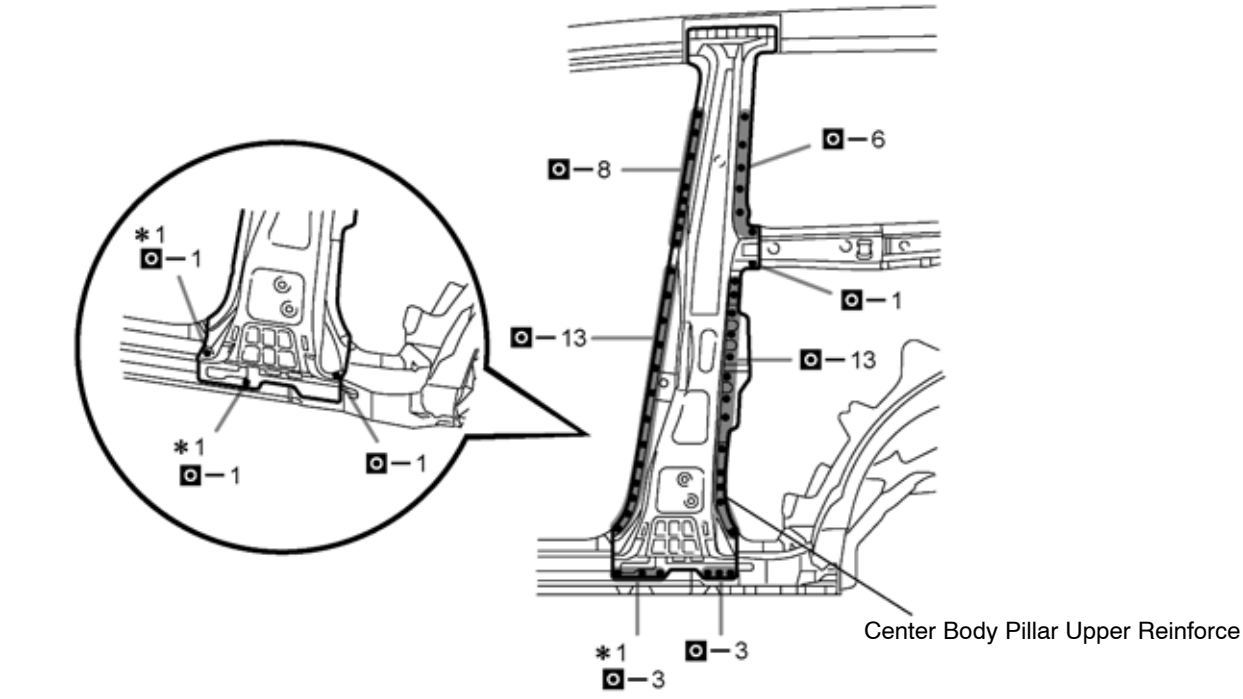


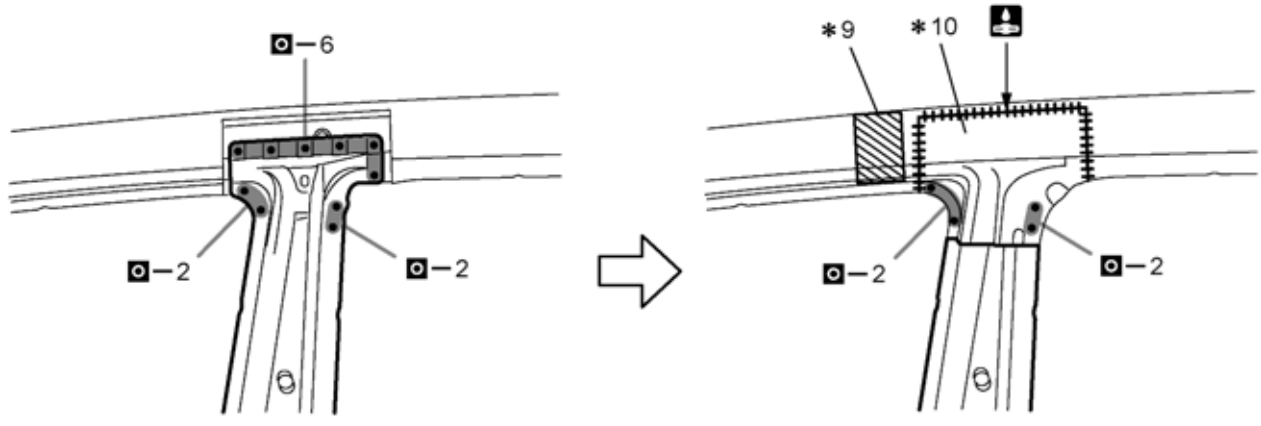
mm (in.)

F43244

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 center body inner pillar to the vehicle side, install the center body pillar upper reinforce.





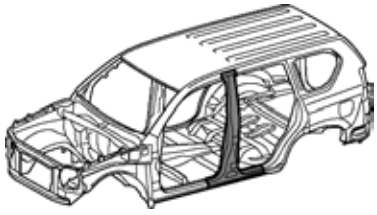
F43245

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 *9 indicates the location of the foamed sealing material. Be careful when welding as the foamed sealing material is located near the area that is cut and joined together.
5 After welding the center body inner pillar to the vehicle side, install the center body pillar upper reinforce and *10.
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.

CENTER BODY PILLAR (CUT):

5 Door


F43246A

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.

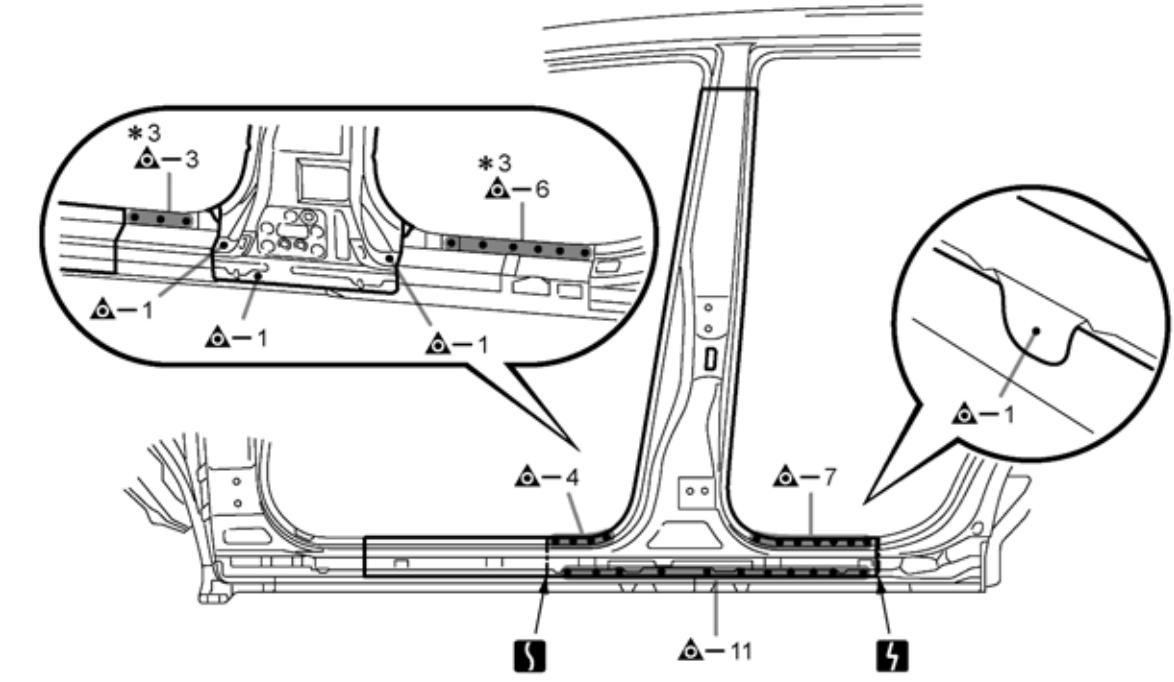
Symbol meaning

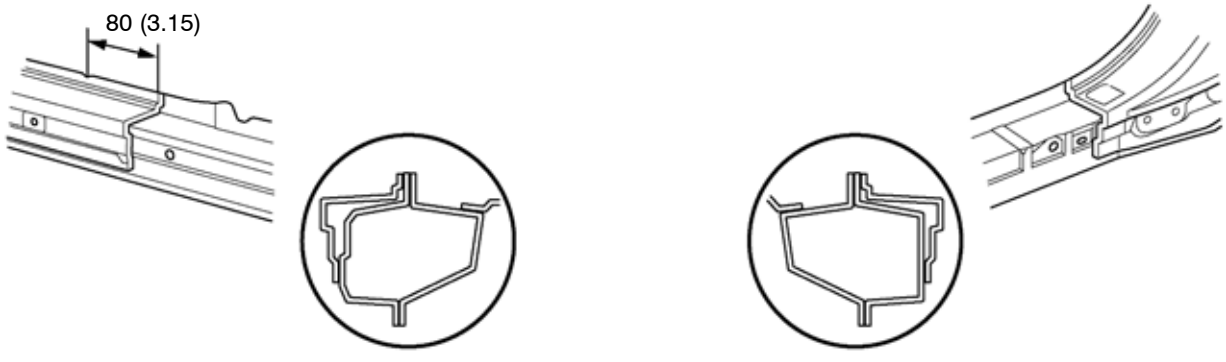
: Remove Weld Points : Cut with Disc Sander etc. : Cut and Join Location

: Cut Location for Supply Parts

F43246B

REMOVAL





mm (in.)

F43246

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)

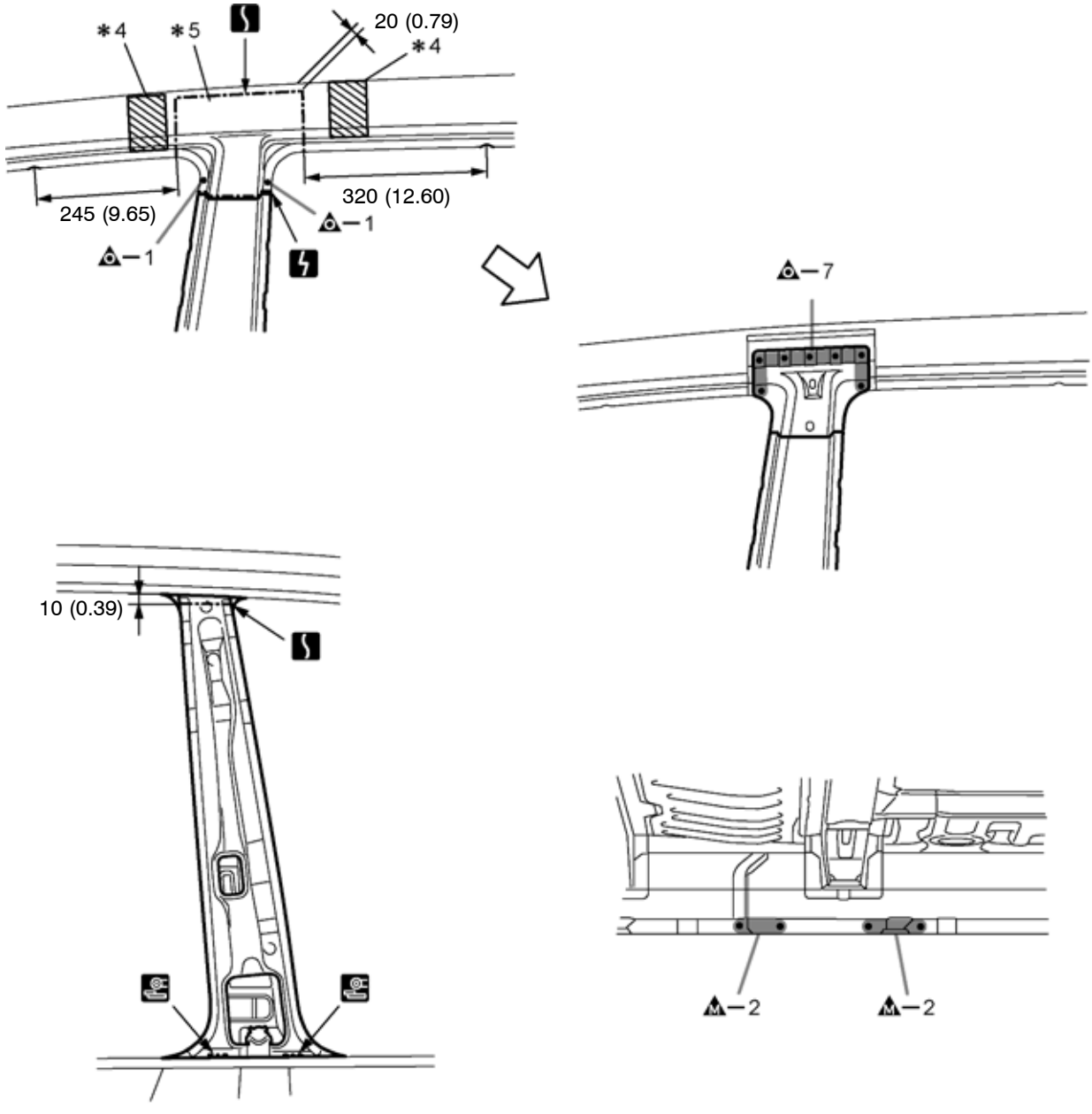
2 *3 indicates welds to remove for easier removal.

Symbol meaning

: Remove Weld Points : Cut with Disc Sander etc. : Cut and Join Location

: Cut Location for Supply Parts

F43246B



mm (in.)

F43247

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 *4 indicates the location of the foamed sealing material. Be careful when cutting as the foamed sealing material is located near the cutting position.

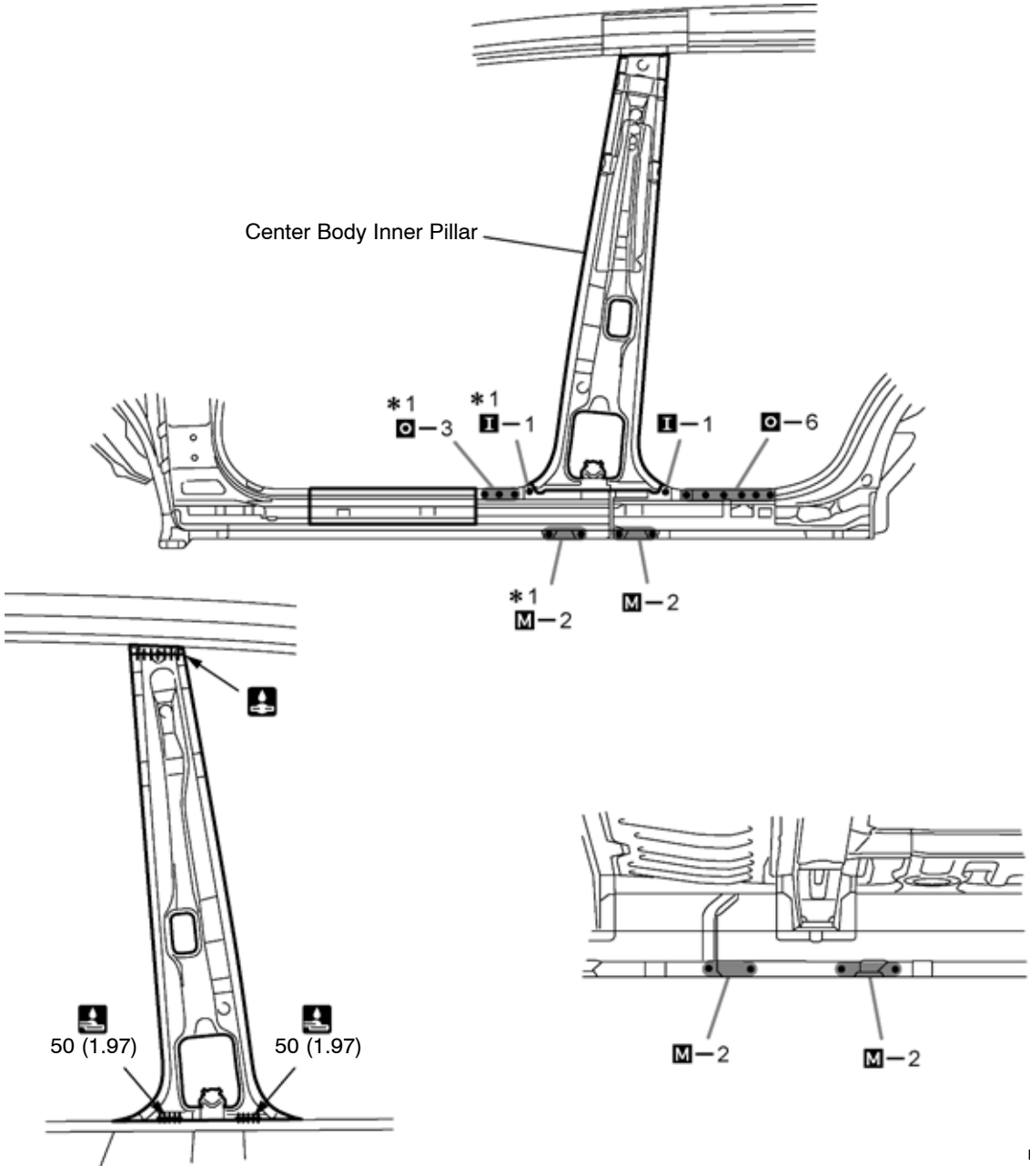
3 *5 is reused.

Symbol meaning

O M I : Plug Weld : Fillet Weld : Butt Weld

F43248B

INSTALLATION



mm (in.)

F43248

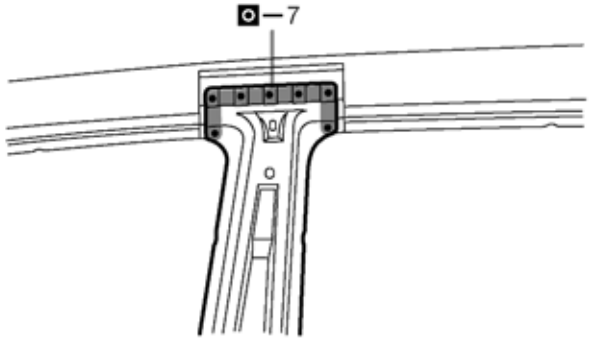
INSTALLATION POINT

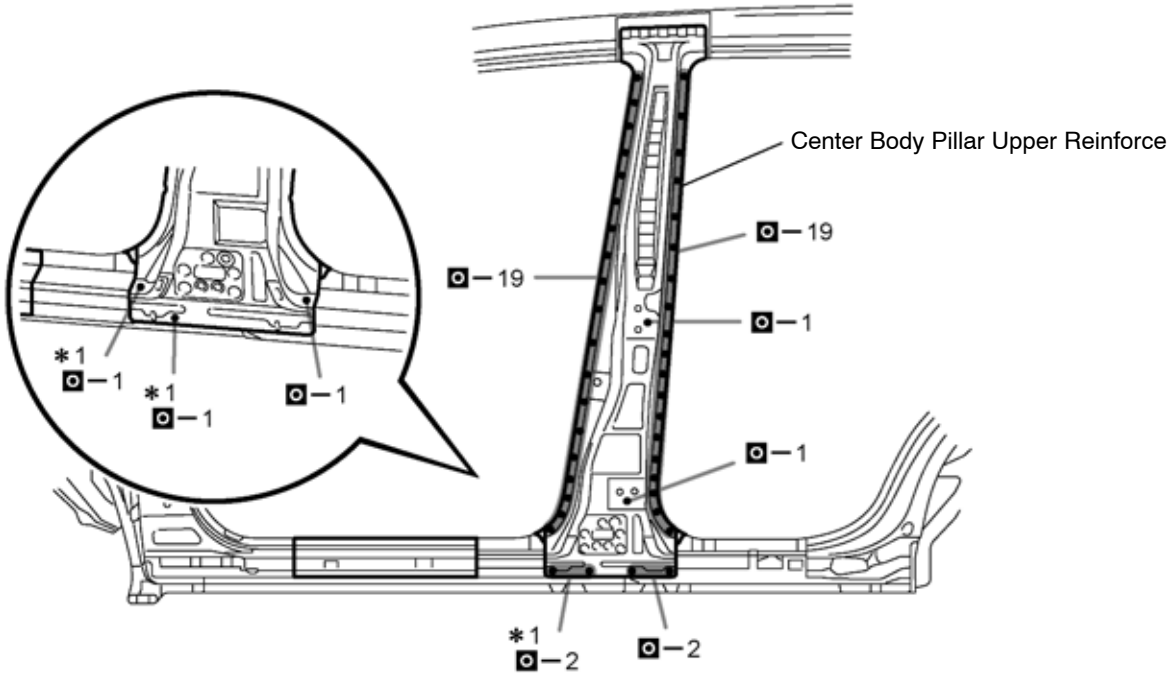
1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions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

Symbol meaning

: Plug Weld : Fillet Weld : Butt Weld

F43248B

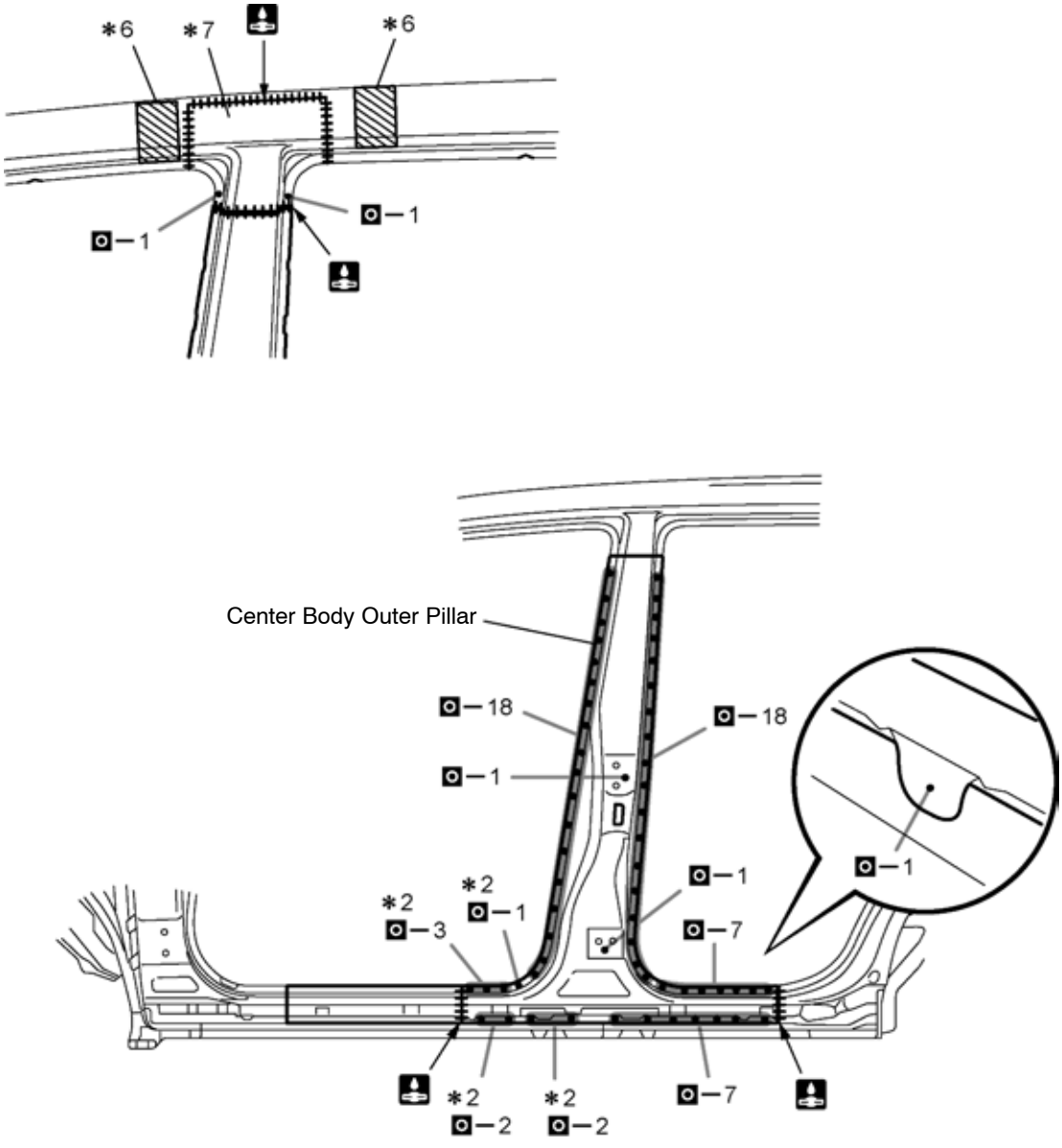




F43249

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 center body pillar upper reinforce to the vehicle side, install the center body outer pillar.



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 *6 indicates the location of the foamed sealing material. Be careful when welding as the foamed sealing material is located near the area that is cut and joined together.
5 After welding the center body inner pillar and center body pillar upper reinforce to the vehicle side, install the center body outer pillar and *7.
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.