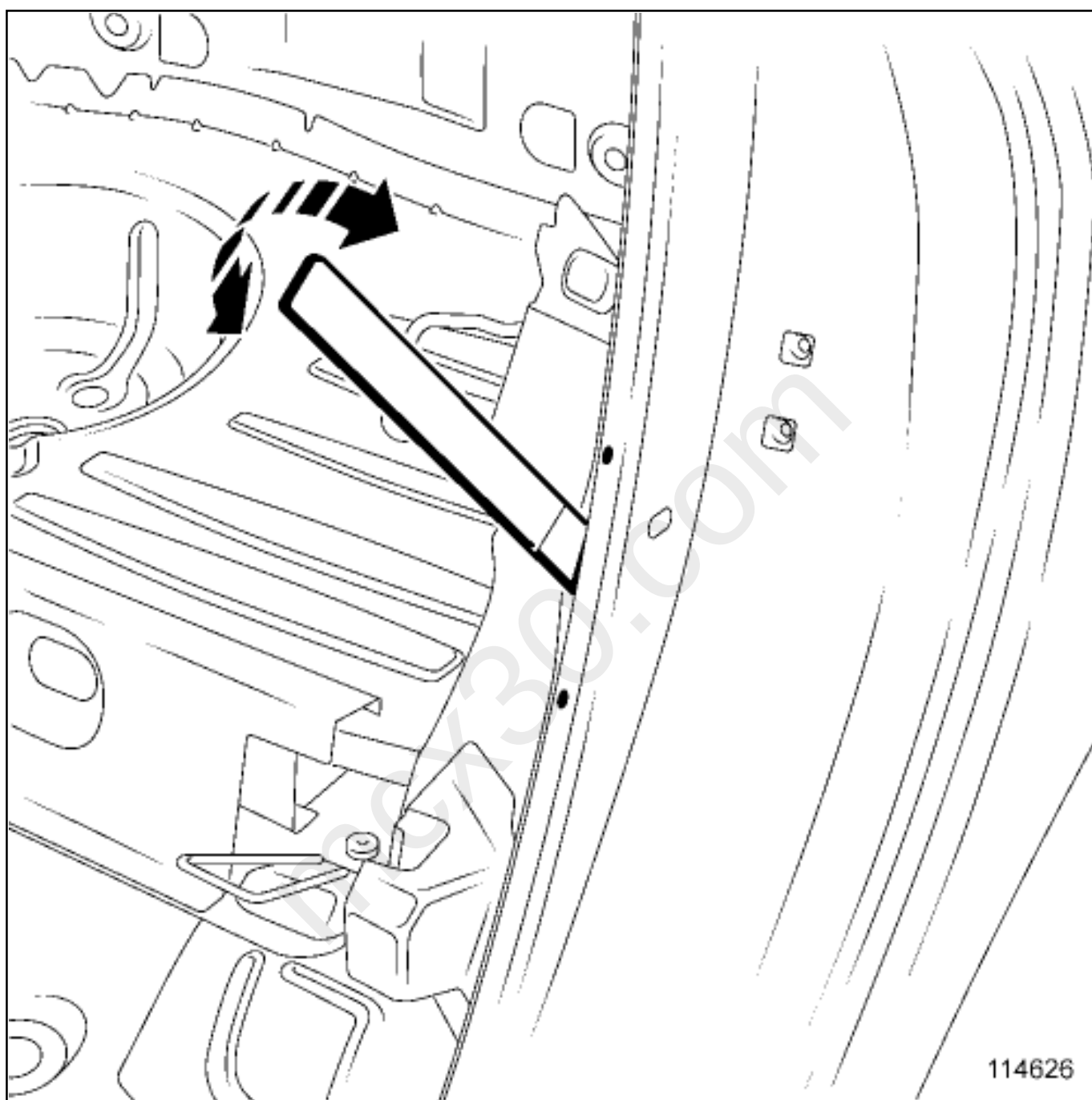


Check the external appearance of the spot on the vehicle to see if it corresponds to that on the test specimen.



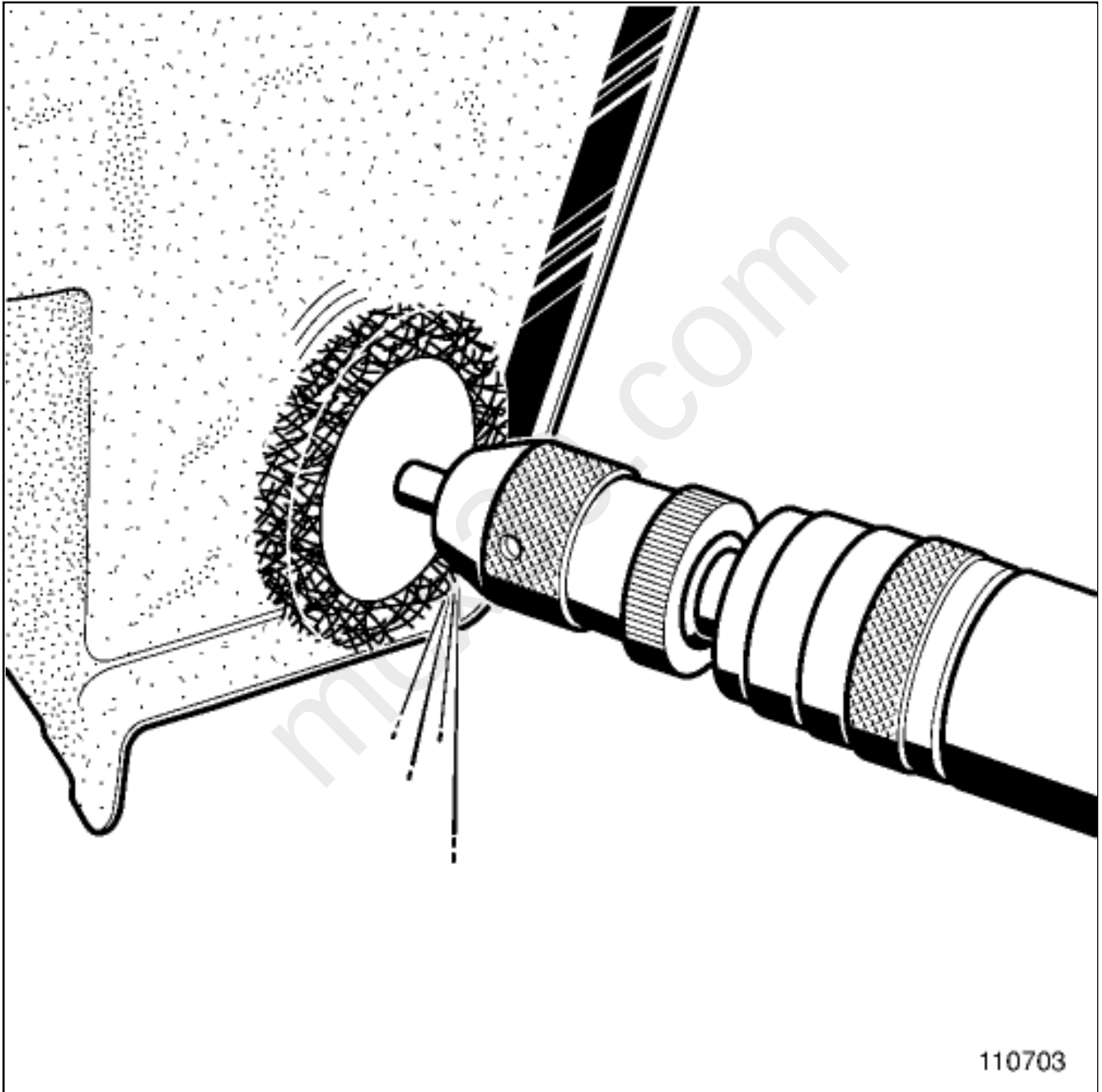
Insert a flat chisel between two spot welds to check the strength of the spots.



ELECTRICAL RESISTANCE SPOT WELDING CONNECTION WITH DIRECT ACCESS

1. DISASSEMBLY

1- SCOURING

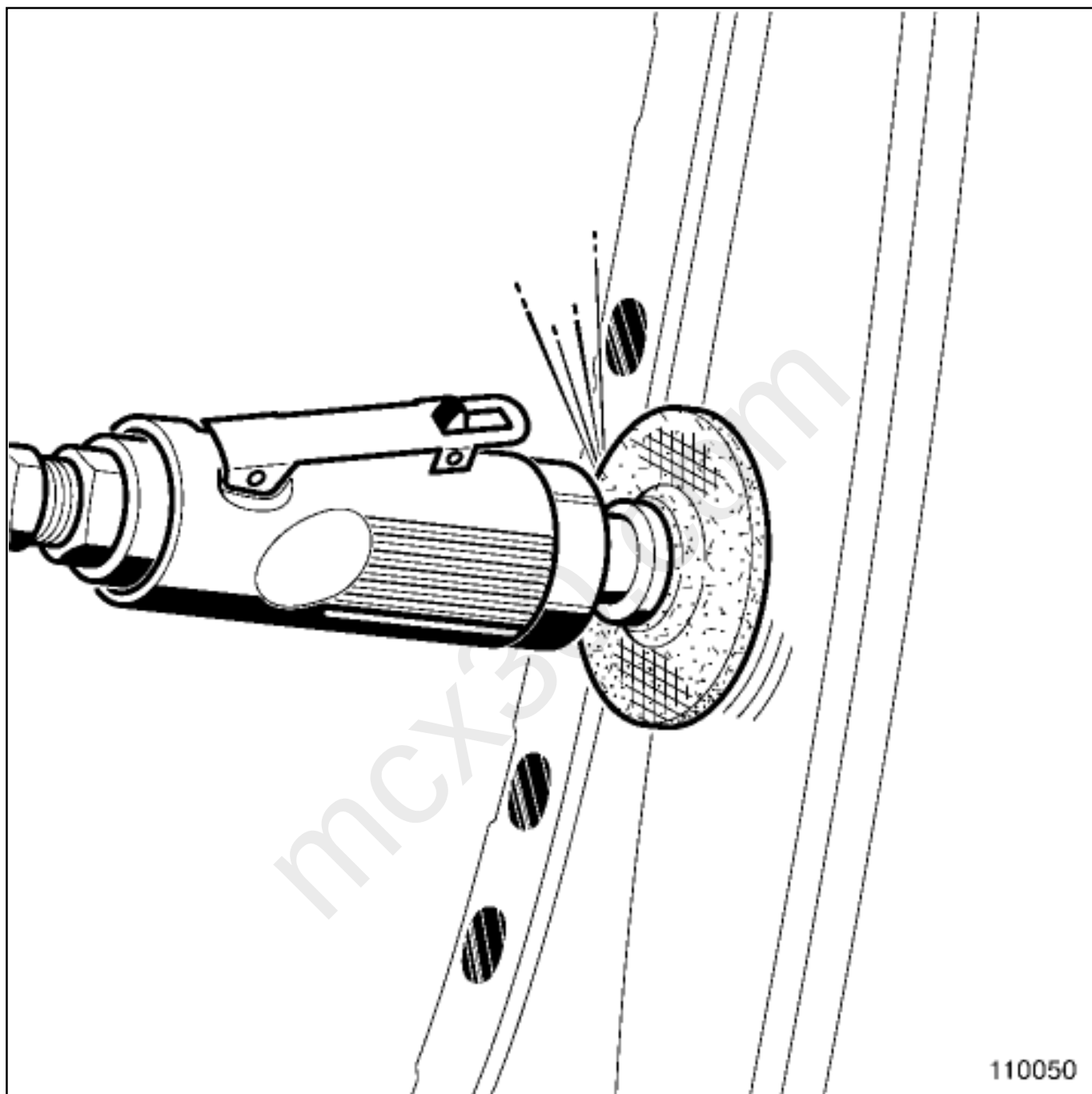


If necessary, scour the joint lines to bring out the spot welds.

(see 05B, Equipment and Tools, Tools for stripping very thick soft mastic: Use)

[\(see 05B, Equipment and Tools, Tools for scraping rigid adhesives and paint: Use\)](#)

2- UNPICKING



Unpick the spot welds using the most appropriate tool depending on the access[\(see 05B, Equipment and Tools, Tools for unpicking a structural component: Use\)](#) .

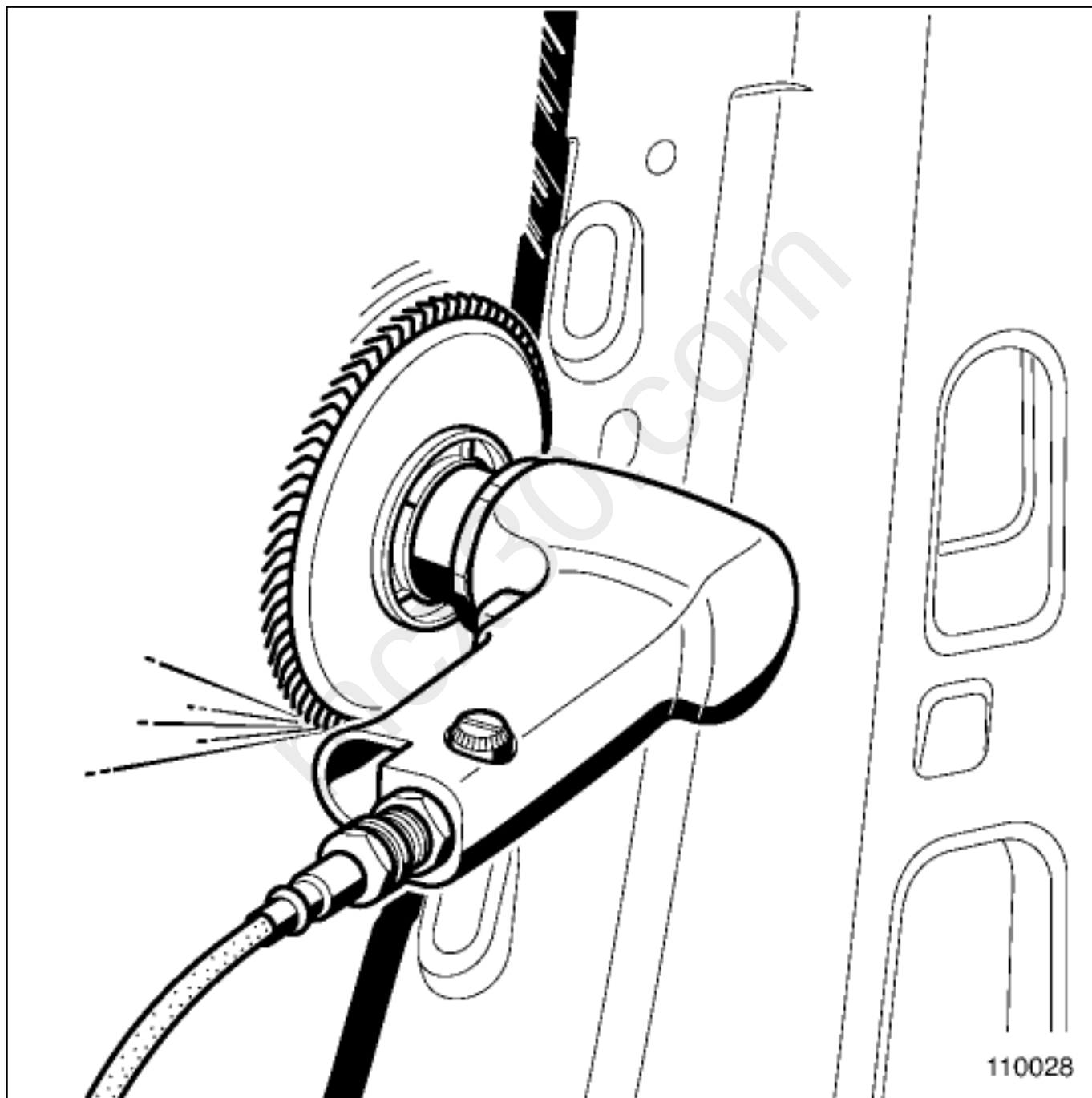
Remove the part to be replaced.



Note:

Do not strike or damage the panel.

3- GRINDING



Grind the welding residue.

(see 05B, Equipment and Tools, Tool for levelling off weld residue: Use)

Put the support face flat so as not to penalise the joint.

2. PREPARATION BEFORE ASSEMBLY

1- POSITIONING AND ADJUSTMENT

Position the replacement part, adjust it and fix it using the locking pliers.

If necessary, reassemble the adjacent components and check the panel gaps.

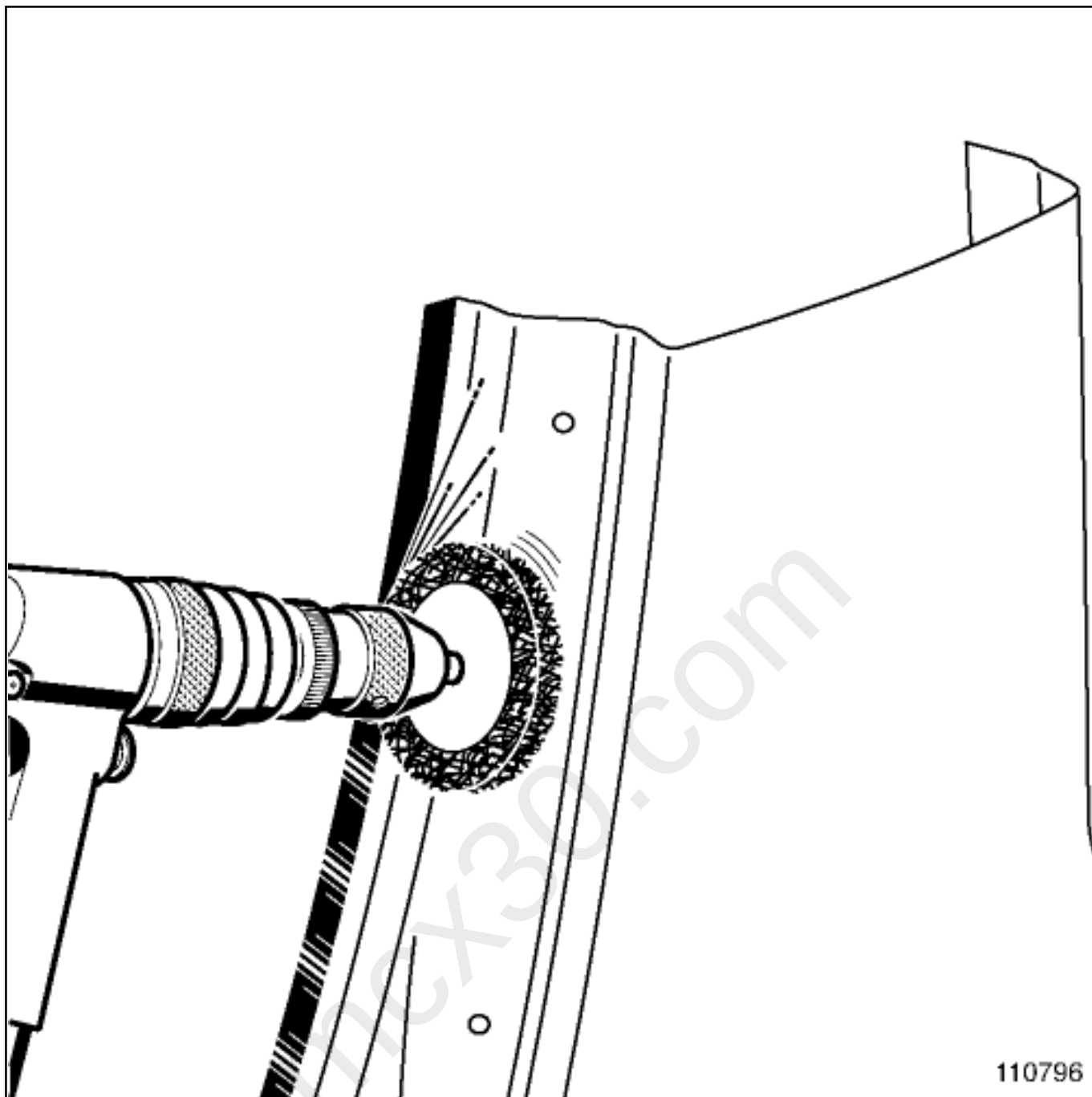
(see 05B, Equipment and Tools, Tools for adjusting and supporting a structural component: Use)

2- MARKING AND IDENTIFYING THE JOINTS

Mark the joint areas.

Remove the replacement part.

3- PREPARATION OF THE JOINTS ON THE REPLACEMENT PART



Scour the internal and external faces around the weld zones.

[\(see 05B, Equipment and Tools, Tools for scraping rigid adhesives and paint: Use\)](#)

4- PREPARATION OF THE JOINTS ON THE VEHICLE

Scour the external mating face around the weld zones.

[\(see 05B, Equipment and Tools, Tools for stripping very thick soft mastic: Use\)](#)

[\(see 05B, Equipment and Tools, Tools for scraping rigid adhesives and paint: Use\)](#)

5- APPLY THE PROTECTION BEFORE ASSEMBLY

Position the acoustic inserts in the hollow sections, if necessary.

(see 04F, Bodywork products and mountings, Soundproofing products before assembly: Use)

Apply the anti-corrosion protection to the internal mating faces according to the type of weld (see 04F, Bodywork products and mountings, Anti-corrosion protection product before assembly: Use) .

3. ASSEMBLY

1- FITTING AND ADJUSTING THE REPLACED PARTS

Reposition the replacement part, adjust it and fix it using the locking pliers.

Reassemble the adjacent components if necessary and check the panel gaps.

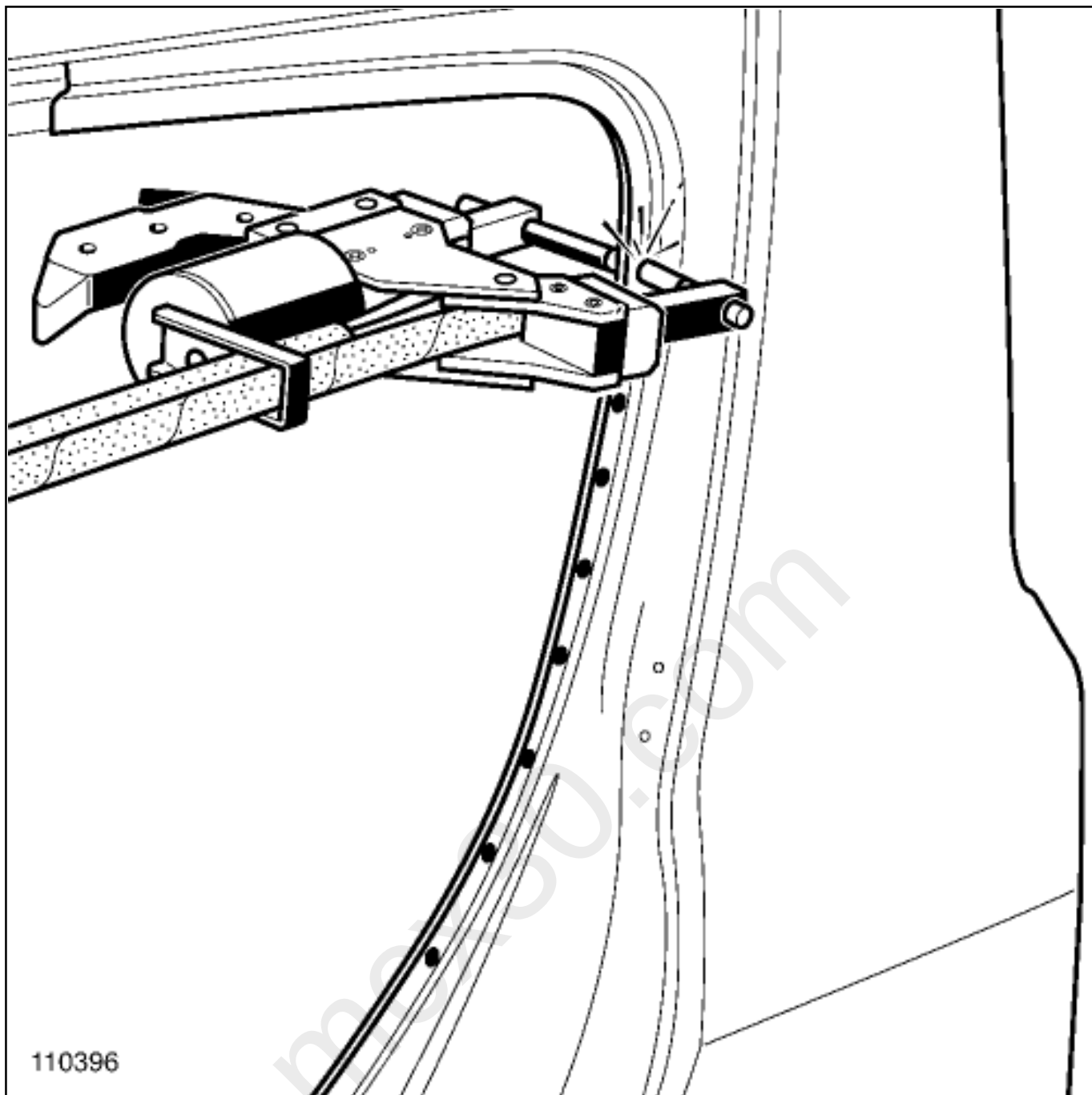
(see 05B, Equipment and Tools, Tools for adjusting and supporting a structural component: Use)

2- ADJUSTING THE WELDER

Before working on the vehicle, follow the procedure below:

(see 40B, Electrical resistance welded connections, Electrical resistance spot welding connection: Precautions for the repair)

3- CARRYING OUT THE WELDING



Weld the panels, holding the electrodes perpendicular to the joint surface.

4- FINISHING

There is no particular finish to be carried out on this type of weld; it must look the same as the original.

