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ELECTRICAL RESISTANCE SPOT WELDING CONNECTION WITH FOUR THICKNESSES



Note, one or more warnings are present in this procedure



Note:



Original welding on four thickness types is very rare. When it exists, it is only the consequence of an assembly problem. Often the panels in the stack are welded two by two and the connection between the inner panels is not done.

1. DISASSEMBLY

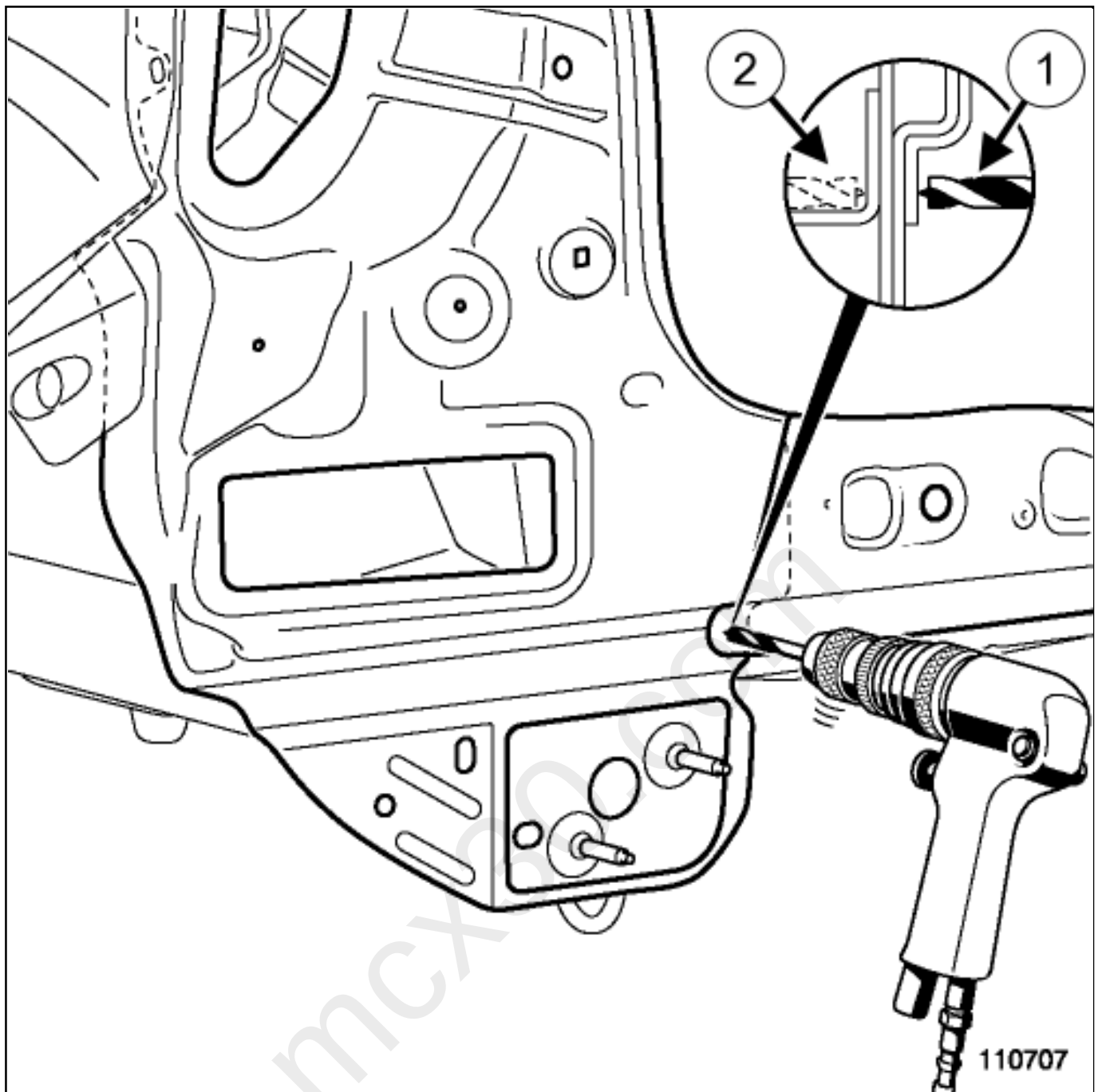
1- SCOURING

If necessary, scour the joint lines to make the spot weld appear on both sides of the joint.

(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 on each side(1) and (2) of the assembly.

Remove the damaged part.

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



Note:

Use a hardened steel bit to preserve the retained panels.

3- GRINDING

Level off the weld residue on the two faces(1) and (2) .

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

2. PRESENTATION BEFORE ASSEMBLY

1- ADJUSTMENT BEFORE ASSEMBLY

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

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

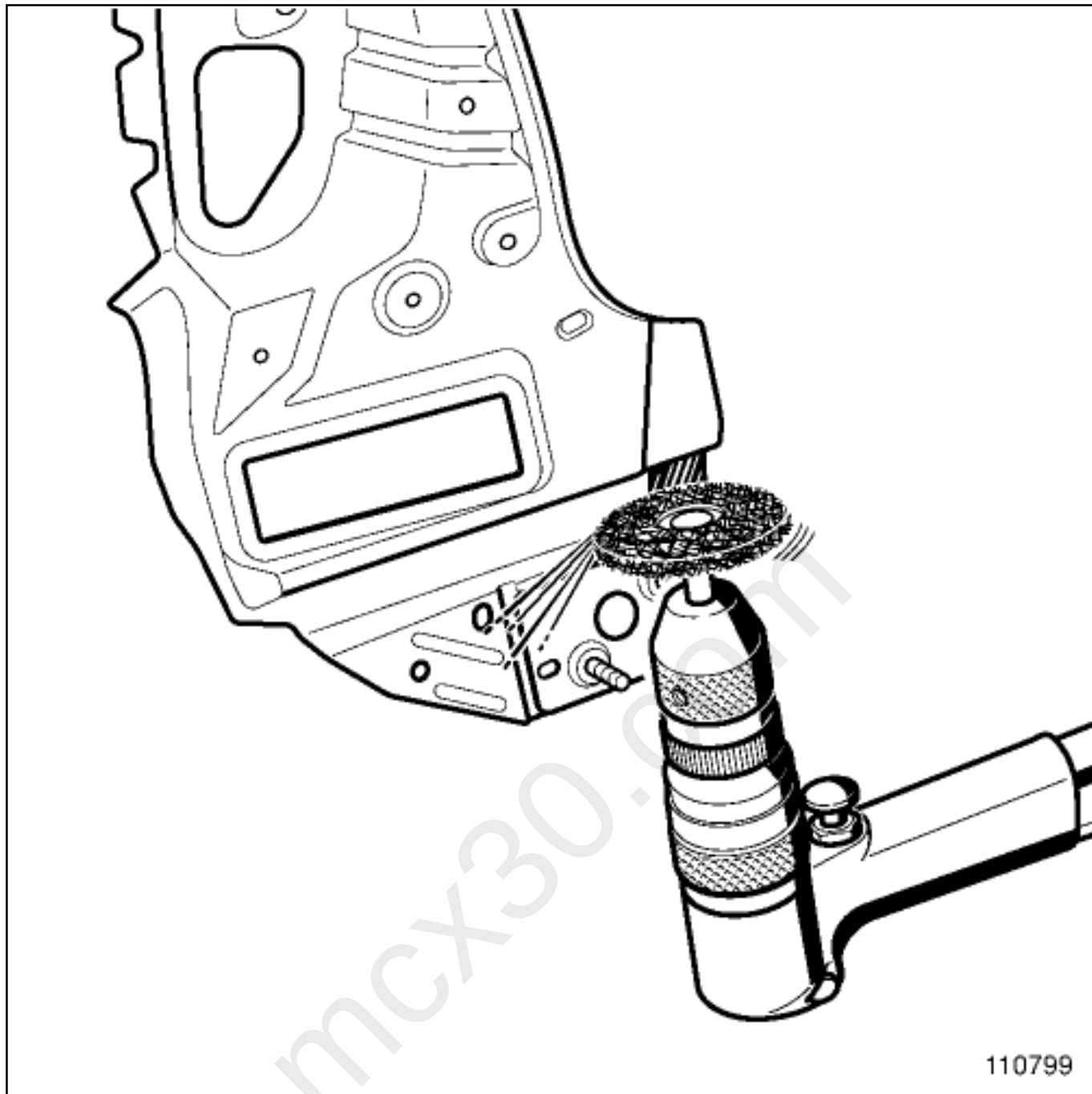
(see 05B, Equipment and Tools, Tools for adjusting and supporting a structural component: Use)

2- MARKING AND IDENTIFYING THE JOINTS

Mark the joint areas, around the drilling holes.

Remove the replacement part.

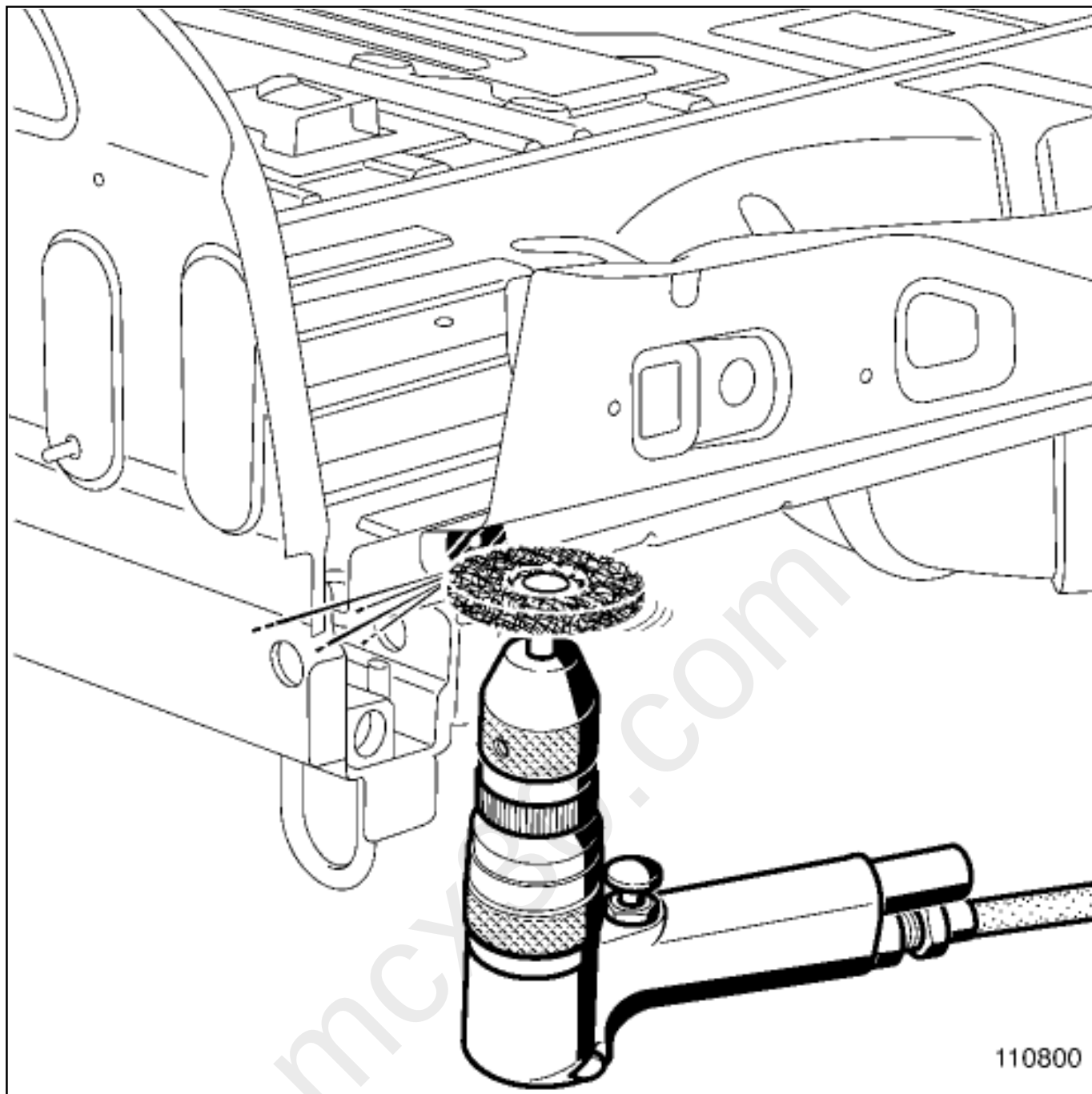
3- PREPARATION OF THE JOINTS ON THE REPLACEMENT PART



Scour the two mating faces.

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

4- PREPARATION OF THE JOINTS ON THE VEHICLE



Scour the two mating faces.

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

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

5- APPLY THE PROTECTION BEFORE ASSEMBLY

Fit the sound insulation inserts into 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.

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

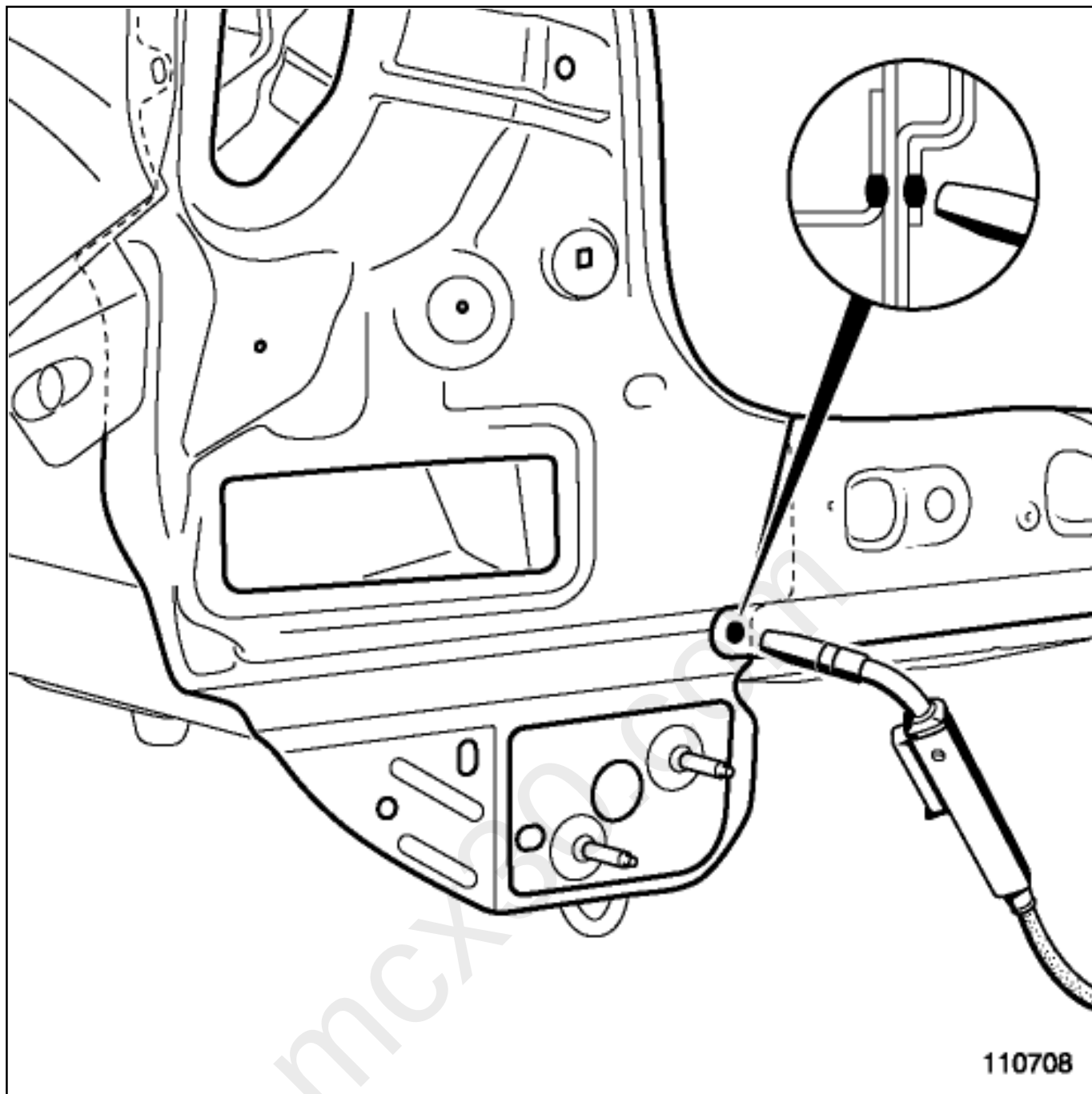
(see 05B, Equipment and Tools, Tools for adjusting and supporting a structural component: Use)

2- ADJUSTING THE WELDER

GMAW joint

(see 40C, Gas metal arc welded connections, Connections by arc welding under shielding gas: Precautions for the repair)

3- CARRYING OUT THE WELDING



Do the plug welds.

[\(see 40C, Gas metal arc welded connections, Connections by arc welding under shielding gas: Description\)](#)

CAUTION



To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the welding machine earth as close as possible to the weld zone (see MR 400).

4- FINISHING

