

HIGH-STRENGTH STEEL (HSS) PARTS

Generally, High-Strength Steel (HSS) is that which has an intensity value of at least 35 kg f/mm², and distinguished from mild steel.

The handling of HSS is the same as for mild steel, but the following should be observed.

1. Panel Hammering; Because HSS is thinner than mild steel, care should be taken to avoid warping during hammering operations.
2. Removing Stop Welds: Because HSS is tougher than mild steel, damage will occur more easily to a regular drill. Therefore, an HSS Spot Cutter is recommended.
Also, use a high-torque drill at low speed, and supply grinding oil to the drill during use.
3. Panel Welding: Panel welding procedures for HSS are exactly the same as for mild steel. Plug welding should be done with a MIG (Metal Inert Gas) welder. Do not gas weld or braze panels at areas other than specified.

