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SUBJECT:

Approved Use of Weld Through Primers

OVERVIEW:

This bulletin documents the FCA US LLC position regarding the use of weld through primer when using Squeeze Type Resistance Spot Welding (STRSW) and Gas Metal Arc Welding (GMAW) processes when welding steel body panels and structural components.

MODELS:

2011 - Current (ALL) All FCA Group Vehicles

NOTE: This bulletin applies to vehicles within the following markets/countries: North America, LATAM, APAC and EMEA.

DISCUSSION:

Corrosion protection must be restored during a repair anytime the protective coatings have been compromised. All areas that have been subjected to structural pulls, clamping, straightening, welding, or other repair operations that caused damage to the corrosion protection system need to be assessed for reapplication.

The use of Weld Through primer is recommended when corrosion protection such as zinc coatings and e-coat are removed prior to STRSW and MIG/MAG (GMAW) welding processes. Weld through primer is used in between welded steel panels such as flanges to protect them against corrosion before they are welded together.

NOTE:

- Can only be used on ferrous metal components.
- FCA recommends the use of weld-through primer for all mating surfaces when using (STRSW) squeeze type resistance spot welding.
- FCA recommends the use of weld-through primer on all internal flange surfaces / mating surfaces when using GMA Welding processes.
- FCA requires the removal of all zinc weld-through primer completely from the weld zone before the welding process to reduce the possibility of porosity in the weld.
- Weld-through primer is not to be used on mating surfaces where the combination of STRSW and adhesives (Weld Bonding) are being performed.
- Weld through primer must be zinc based.

NOTE: The use of cavity wax is recommended after the welding process. Cavity wax works well in boxed areas such as frame rails and will “creep” into small cracks and crevasses to reduce the chance of corrosion taking place. Cavity wax offers extra protection when used with a weld through primer in and around the weld zone. Please refer to the “Corrosion Protection Restoration” document located in Service Library under “Collision Information - Standard Procedures” for additional information.

REFERENCE WEBSITE

- Additional information can be obtained at <https://www.moparrepairconnect.com> .

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