- Do not attach the ground cable to a chassis spring, otherwise the spring may break.
- Remove the paint coating and dry the area where welding is to be performed.
- To prevent the following components from being damaged by welding spatters or heat, cover them up or temporarily relocate them to somewhere reasonably distant. In particular, if welding any area within 200mm from a fuel tank, remove the fuel tank beforehand.
  - − Plastic parts
  - − Air intake duct
  - − Intercooler
  - − Tire
  - − Rubber parts
  - − Radiator hose
  - − Pipes
  - − Electric harnesses
  - − Radiator
  - − Chassis springs
- To minimize impact of heat on peripheral area and to assure welding quality, select a suitable welding torch and perform welding at suitable welding conditions.
- No weld defect such as undercuts, overlaps, and pin holes.

② After welding

- Welded area must not be rapidly cooled.
- Apply rust-proof paint with the same color, if the paint is removed from chassis frame or cab.
- After welding, put the disconnected electronic units such as control unit connectors and fuses back in place exactly as before. After that, connect negative battery terminal securely.
- Check operation of equipments. Contact ISUZU distributor or ISUZU dealership for checking method.

③ Welding electrode

- Use welding electrode depending on parts in following chart.

Welding part	Details	Recommended welding electrode
High tensile steel	HT540 (ISUZU standard) Tensile strength: 540MPa {55kgf/mm^2}	JIS Z3211 E4916 / AWS A5.1 E7016 or JIS Z3211 E4316 / AWS A5.1 E7016 equivalent
Steel for general frame	JSH440 (ISUZU standard) Tensile strength: 440MPa {45kgf/mm^2} or STKR440 (JIS standard) Tensile strength: 400MPa {41kgf/mm^2}	