



# BaoSteel Automotive Advanced High Strength Steel



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CREATION BEYOND VISION

宝钢汽车板  
Baosteel Automotive Sheet

# Overview of Baosteel Automotive AHSS

BaoSteel has been working on R&D of high-end products. In recent years, to meet the demand of light-weighting of auto-body and environment protection, BaoSteel invested a lot in developing high strength steel, especially advanced high strength steel (AHSS) strengthened by phase transformation as shown in Fig.1. The product line of AHSS is listed below.

1. DP(Dual Phase Steel)
2. TRIP(Transformation Induced Plasticity Steel)
3. CP(Complex Phase Steel)
4. MS(Martensitic Steel)
5. Q&P(Quenching and Partitioning Steel)
6. TWIP(Twinning Induced Plasticity Steel)
7. PH/B(Press Hardening/Boron Steel)

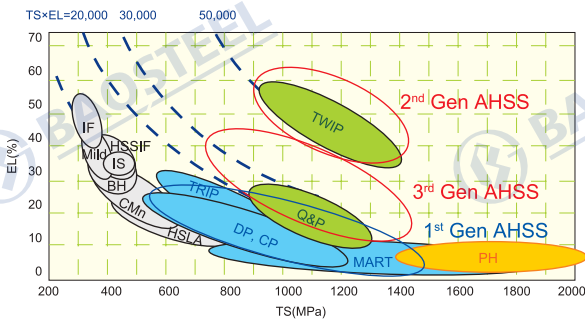


Fig.1 Automotive AHSS Family

AHSS is well suited for automotive structural and safety parts (Fig. 2), contributing to both the weight reduction of car body and the promotion of passive safety and increasing the cost benefit of automotive.



Fig.2 Main applications of AHSS for auto body (Baosteel Car Body)

Commercialized AHSS products are listed in Table 1. The highest strength of cold rolled (CR) products is 1700MPa, for hot-dip galvanized (HDG) ones is 1180MPa, and for electrolytic galvanized (EG) ones is 780MPa.

Table1 The AHSS Products in BaoSteel

Variety	Grade	CR	EG	GI	GA
DP	DP450	●	●	●	●
	DP500	●	●	●	●
	DP590(Low Yield)	●	●	●	●
	DP590(Low Yield)	●	●	●	●
	DP780	●	●	●	●
	DP980(低YP)	●	—	●	●
	DP980(High Yield)	●	—	●	●
	DP1180	●	—	●	●
TRIP	TRIP590	●	●	●	—
	TRIP690	●	—	●	—
	TRIP780	●	—	●	—
Mart	MS980	●	—	—	—
	MS1180	●	—	—	—
	MS1300	●	—	—	—
	MS1400	●	—	—	—
	MS1500	●	—	—	—
Q&P	QP980	●	—	●	○
	QP1180	●	—	●	○
CP	CP780	●	—	●	—
	CP980	●	—	●	—
	CP1180	○	—	○	—
PH	PH1200	●	—	○	○
	PH1500	●	—	○	○
	PH1800	○	—	○	○
TWIP	TWIP950	●	—	○	—

- : Commercialized
- : Under development, consultation needed before placing orders
- : Not available

Note: In the table, even there are differences between BaoSteel products and some similar steel nominated by other standards or companies, they belong to the same grade, and the difference of tensile strength values should be less than 20 MPa. So, please refer to BaoSteel product category in the steel selection, for example, DP590 and DP600 are the same grade so refer DP590 for the product ability. TRIP 780 and TRIP 800 are the same too.

# DP (Dual Phase) Steel

## Technical characteristics

**Microstructure:** The microstructure of these steel is composed of ferrite and martensite. Martensite islands distribute dispersively in the ferrite matrix. Due to the soft ferrite matrix, DP steel exhibits good formability, while the hard martensite islands contribute to its high strength. Products with different yield ratio can be produced for different applications.

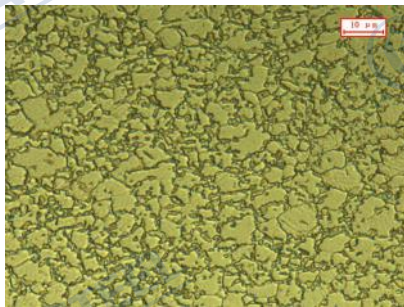


Fig.3 Typical microstructure of DP steel

**Properties:** No Yield point; No room-temperature aging; Low Yield/Tensile Strength Ratio; High strain hardening exponent and high bake hardening value.

**Applications:** DP high strength steel are preferred to manufacture structural parts. It is widely applied to structural components, reinforcement and anti-collision components, such as underbody cross member, track, bumper, bumper reinforcement structure etc.

## Application cases



Fig.4 Kick-down reinforcement, HC550/980DPD+Z (Coating mass: 50/50g/m<sup>2</sup>, 1.4mm×1150mm)



Fig.5 Door beam, HC550/980DPD+Z (Coating mass: 50/50g/m<sup>2</sup>, 1.2mm×1120 mm)

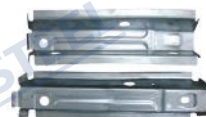


Fig.6 Car seat bracket parts, HC550/980DPD+Z (Coating mass: 50/50g/m<sup>2</sup>, 1.25mm×1120 mm)

## Mechanical properties



The products listed in the tables below can be supplied in accordance with EN, ASTM, JIS, and BaoSteel standards. Ordering according to customer's standard or requirement is also available.

Table 2 CR DP Steel

Steel Grade	YS <sup>a, b</sup> R <sub>p0.2</sub> , MPa	TS R <sub>m</sub> , MPa ≥	EL <sup>c</sup> A <sub>50mm</sub> , % ≥	n <sup>d</sup> ≥
HC250/450DP	250~320	450	28	0.16
HC290/490DP	290~390	490	26	0.15
HC340/590DP	340~440	590	22	0.14
HC420/780DP	420~550	780	15	—
HC500/780DP	500~650	780	12	—
HC550/980DP	550~720	980	9	—
HC650/980DP	650~900	980	8	—
HC700/980DP	700~920	980	8	—
HC820/1180DP	820~1150	1180	5	—

a If the yield point is not pronounced, the values of R<sub>p0.2</sub> apply. Otherwise, the values of R<sub>eL</sub> apply.

b Guaranteed for No.5 tensile specimens according to standard JIS Z 2241. For the tensile axis of specimens, Coated is parallel to the rolling direction, Uncoated is vertical to the rolling direction.

c When the specified nominal thickness is in the range of 0.5~0.7 mm, the minimum value of EL should be reduced by 2%. For thickness less than 0.5 mm, the minimum value of EL should be reduced by 4%.

d n-value should be determined by the strain range of 10-20%. If maximum uniform elongation is less than 20% but more than 12%, n-value should be determined by the strain range from 10% to end uniform elongation. If uniform elongation is less than 12%, n-value shall be reported as uniform elongation equals true strain at uniform elongation. (n<sub>UE</sub> = ε<sub>UE</sub>)

\* Please confirm the specifications of product before official order. The specifications are negotiable.

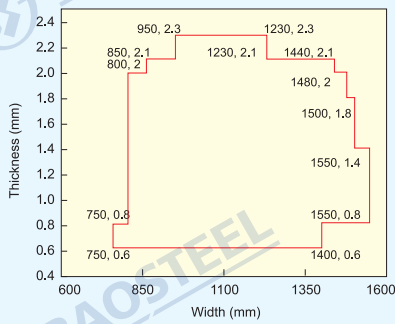
Table 3 HDG DP Steel

Steel Grade	YS <sup>a, b</sup> R <sub>p0.2</sub> , MPa	TS R <sub>m</sub> , MPa ≥	EL <sup>c</sup> A <sub>50mm</sub> , % ≥	n <sup>d</sup> ≥
HC250/450DPD+Z	250~340	450	29	0.16
HC250/450DPD+ZF			27	
HC300/500DPD+Z	290~370	500	27	0.15
HC300/500DPD+ZF			25	
HC340/590DPD+Z	340~440	590	22	0.13
HC340/590DPD+ZF			20	
HC420/780DPD+Z	420~550	780	17	—
HC420/780DPD+ZF			15	
HC500/780DPD+Z	500~650	780	14	—
HC500/780DPD+ZF			12	
HC550/980DPD+Z	550~730	980	10	—
HC550/980DPD+ZF			8	
HC650/980DPD+Z	650~900	980	8	—
HC650/980DPD+ZF			6	
HC700/980DPD+Z	700~900	980	8	—
HC700/980DPD+ZF			6	
HC740/1180DPD+Z	740~980	1180	7	—
HC740/1180DPD+ZF			5	
HC820/1180DPD+Z	820~1150	1180	6	—
HC820/1180DPD+ZF			4	

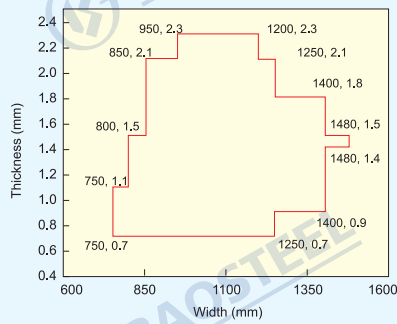
# Product dimensions

## CR DP Steel

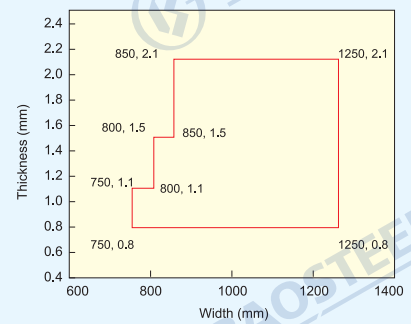
590MPa and below



780MPa

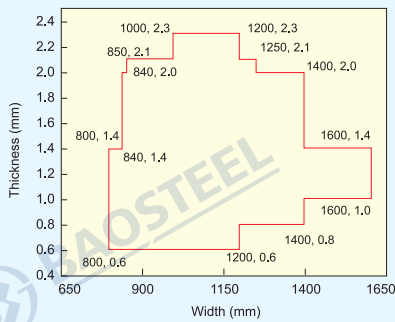


980MPa and 1180MPa

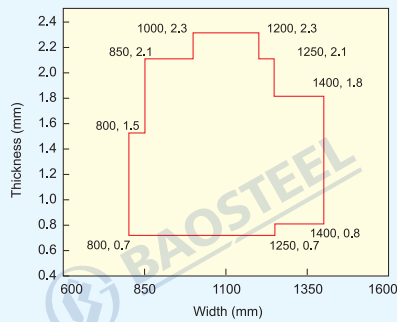


## HDG (GI) DP Steel

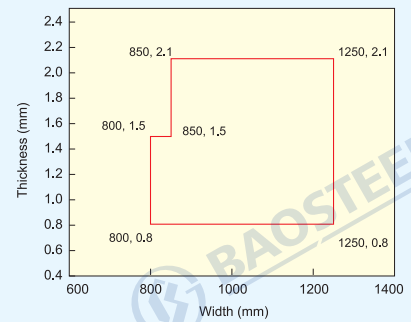
590MPa and below



780MPa

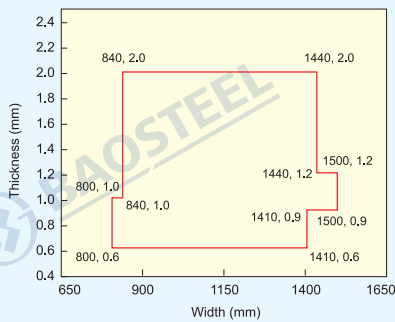


980MPa and 1180MPa

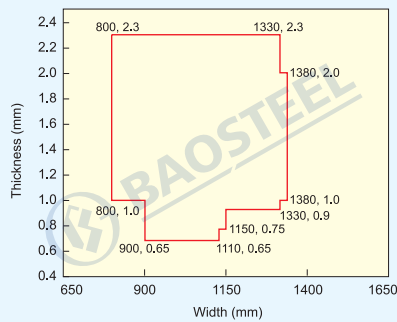


## HDG (GA) DP Steel

590MPa and below

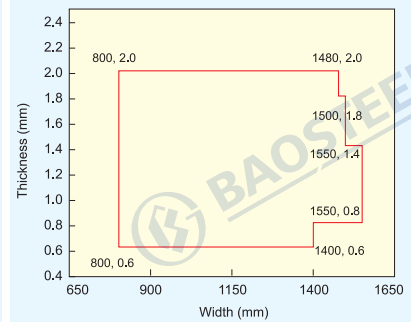


780MPa

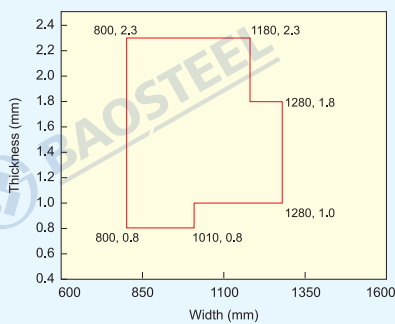


## EG DP Steel

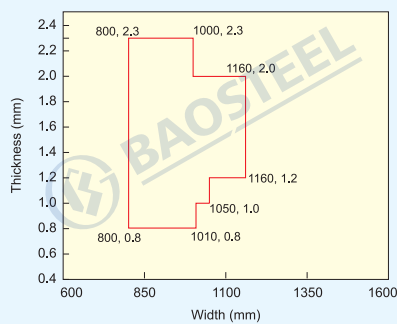
590MPa and below



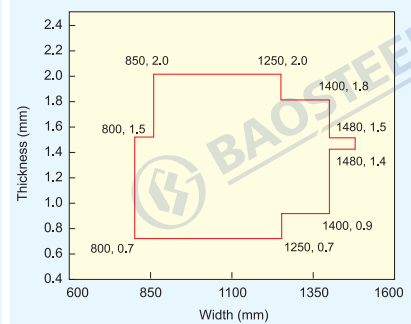
980MPa



1180MPa



780MPa



# TRIP (Transformation Induced Plasticity) Steel

## Technical characteristics

**Microstructure:** The microstructure of these steel is composed of ferrite, bainite and retained austenite with a volume fraction of 7~15%. (Fig.7)

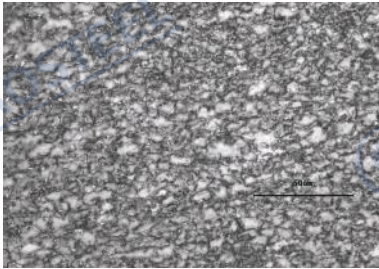


Fig.7 Typical microstructure of TRIP steel

**Properties:** These steel have good formability due to the transformation of retained austenite into martensite during plastic deformation (transformation induced plasticity effect). TRIP steel exhibit good combination of high strength and high ductility. Moreover, TRIP steel show high energy absorption and high strain hardening capacity.

**Application:** Structural and reinforcement parts of complex shape, such as B-pillar reinforcement panels.

## Application cases



Fig.8 B-pillar reinforcement, HC420/780 TR (1.8mm×615mm)

## Mechanical properties

The products listed in the tables below can be supplied in accordance with EN, ASTM, JIS, and BaoSteel standards. Ordering according to customer's standard or requirement is also available.

Table 4 CR TRIP Steel

Steel Grade	YS <sup>a, b</sup> R <sub>P0.2</sub> , MPa	TS R <sub>m</sub> , MPa ≥	EL <sup>c</sup> A <sub>50mm</sub> , % ≥	n <sup>d</sup> ≥
HC380/590TR	380~480	590	28	0.20
HC400/690TR	400~520	690	26	0.19
HC420/780TR	420~570	780	23	0.16

a If the yield point is not pronounced, the values of R<sub>P0.2</sub> apply. Otherwise, the values of R<sub>sL</sub> apply.

b Guaranteed for No.5 tensile specimens according to standard JIS Z 2241. For the tensile axis of specimens, Coated is parallel to the rolling direction, Uncoated is vertical to the rolling direction.

c When the specified nominal thickness is in the range of 0.5~0.7 mm, the minimum value of EL should be reduced by 2%. For thickness less than 0.5 mm, the minimum value of EL should be reduced by 4%.

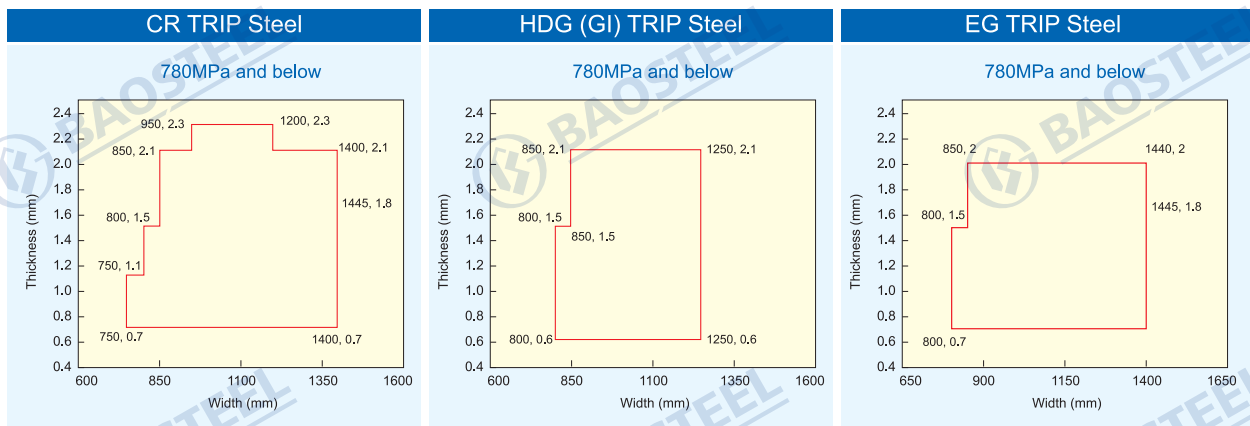
d n-value should be determined by the strain range of 10-20%. If maximum uniform elongation is less than 20% but more than 12%, n-value should be determined by the strain range from 10% to end uniform elongation. If uniform elongation is less than 12%, n-value shall be reported as uniform elongation equals true strain at uniform elongation. (n<sub>UE</sub> = ε<sub>UE</sub>)

\* Please confirm the specifications of product before official order. The specifications are negotiable.

Table 5 HDG TRIP Steel

Steel Grade	YS <sup>a, b</sup> R <sub>P0.2</sub> , MPa	TS R <sub>m</sub> , MPa ≥	EL <sup>c</sup> A <sub>50mm</sub> , % ≥	n <sup>d</sup> ≥
HC380/590TRD+Z	380~480	590	27	0.20
HC380/590TRD+ZF			25	
HC400/690TRD+Z	400~510	690	26	0.19
HC400/690TRD+ZF			24	
HC420/780TRD+Z	420~560	780	23	0.16
HC420/780TRD+ZF			21	

## Product dimensions



# MS (Martensitic) Steel

## Technical characteristics

**Microstructure:** Almost full martensite. (Fig.9)

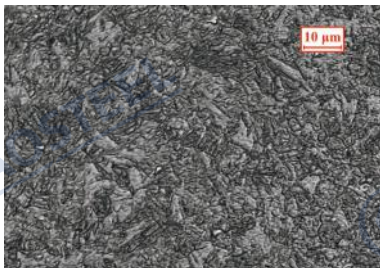


Fig.9 Typical microstructure of MS steel

**Properties:** High Yield/Tensile Strength Ratio; High tensile strength; Relatively low elongation; Delayed fracture should be considered.

**Applications:** MS steel are suited for simple cold stamped parts and roll formed parts with a relatively single interface, such as bumper, threshold reinforcing plate and the side door anti-collision rod.

## Application cases



Fig.10 Rocker, HC950/1180MS (1.4mm×919mm)

## Mechanical properties

The products listed in the tables below can be supplied in accordance with EN, ASTM, JIS, and BaoSteel standards. Ordering according to customer's standard or requirement is also available.

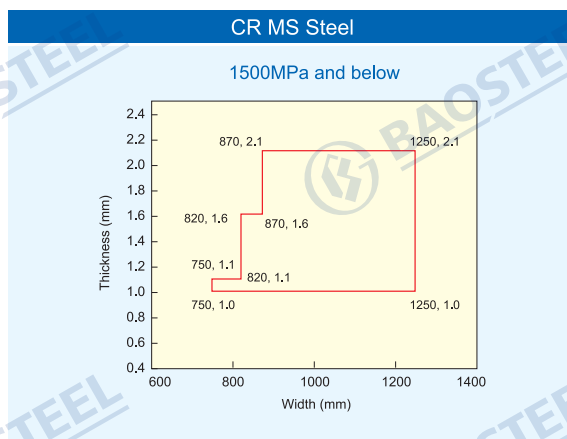
Table 6 CR MS Steel

Steel grade	YS <sup>a, b</sup> R <sub>p0.2</sub> MPa	TS R <sub>m</sub> MPa ≥	EL A <sub>50mm</sub> % ≥	Recommended inner bending radius
HC700/980MS	700~960	980	4	3 times of thickness
HC950/1180MS	950~1200	1180	4	4 times of thickness
HC1030/1300MS	1030~1300	1300	4	4 times of thickness
HC1150/1400MS	1150~1400	1400	3	4 times of thickness
HC1200/1500MS	1200~1500	1500	3	4 times of thickness
HC1350/1700MS	1350~1700	1700	3	4 times of thickness

- a If the yield point is not pronounced, the values of R<sub>p0.2</sub> apply. Otherwise, the values of R<sub>eL</sub> apply.
- b Guaranteed for No.5 tensile specimens according to standard JIS Z 2241 with the tensile axis parallel to the rolling direction.
- \* Please confirm the specifications of product before official order. The specifications are negotiable.

## Product dimensions

In addition, further agreement for trial production can be achieved when the requirements exceed the dimensions (TS > 1500MPa, thickness < 2.3mm).



# CP (Complex Phase) Steel

## Technical characteristics

**Microstructure:** Ferrite/bainite matrix with small amounts of martensite, retained austenite and pearlite. (Fig.11)



Fig.11 Typical microstructure of cold rolled CP steel

**Properties:** An extreme grain refinement is created by retarded recrystallization or precipitation of micro-alloying elements like Ti or Cr. In comparison with DP steel, CP steel show significantly higher yield strength, bendability and hole expansion ratio at the same strength level. CP steel are characterized with high energy absorption and good stretch flanging formability.

**Applications:** Suspension parts, B-pillar, bumpers, seat slide.

## Application cases



Fig.12 Control arm, HD680/780CP (3.2mm×1050mm)

## Mechanical properties



The products listed in the tables below can be supplied in accordance with EN, ASTM, JIS, and BaoSteel standards. Ordering according to customer's standard or requirement is also available.

Table 7 CR CP Steel

Steel Grade	YS <sup>a, b</sup> R <sub>P0.2</sub> <sup>a</sup> MPa	TS R <sub>m</sub> <sup>a</sup> MPa ≥	EL A <sub>50mm</sub> <sup>a</sup> % ≥	λ % ≥
HC570/780CP	570~700	780	11	40
HD680/780CP	680~830	780	10	50
HC780/980CP	780~950	980	7	50
HC900/1180CP	900~1100	1180	6	30

Table 8 HDG CP Steel

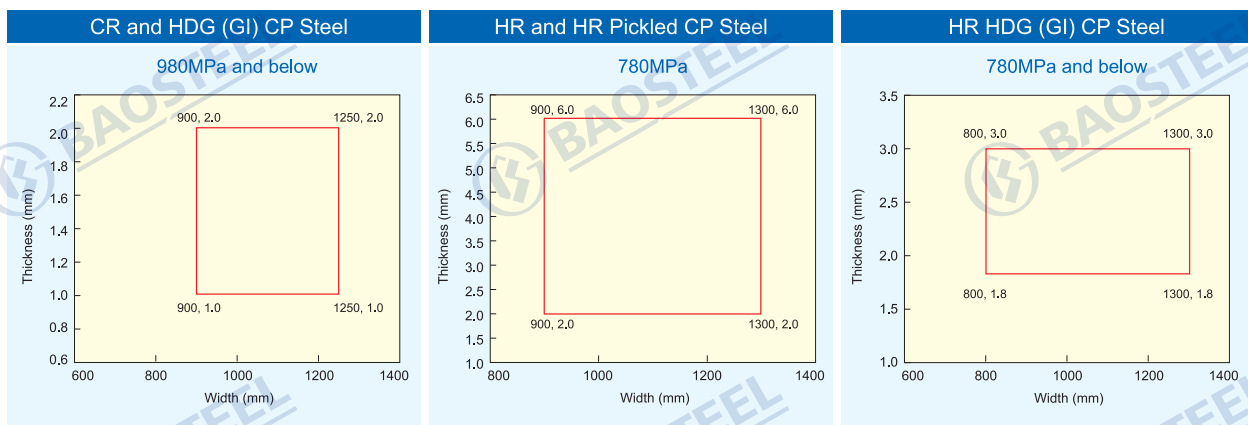
Steel Grade	YS <sup>a, b</sup> R <sub>P0.2</sub> <sup>a</sup> MPa	TS R <sub>m</sub> <sup>a</sup> MPa ≥	EL A <sub>50mm</sub> <sup>a</sup> % ≥	λ % ≥
HC570/780CPD+Z	570~720	780~920	11	40
HC780/980CPD+Z	780~950	980~1140	7	40
HD660/760CPD+Z	660~820	760~950	11	35

a If the yield point is not pronounced, the values of R<sub>p0.2</sub> apply. Otherwise, the values of R<sub>eL</sub> apply.

b Guaranteed for No.5 tensile specimens according to standard JIS Z 2241 with the tensile axis parallel to the rolling direction.

\* Please confirm the specifications of product before official order. The specifications are negotiable.

## Product dimensions



# Q&P (Quenching and Partitioning) Steel

## Technical characteristics

**Microstructure:** The microstructure is composed of ferrite, martensite and retained austenite with a volume fraction of 5~10%. (Fig.13)

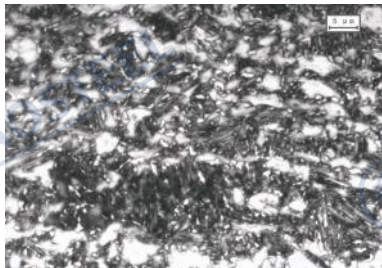


Fig.13 Typical microstructure of Q&P steel

**Properties:** Benefiting from the TRIP effect of retained austenite, Q&P steel exhibit quite high strain hardening capacity, and higher ductility and formability than other UHSS with same strength level.

**Applications:** Q&P steel are suited for the automotive structural and safety parts with complex shapes.

## Application cases



HC600/980QP was a "world first" product of BaoSteel, and now has already commercially supplied to the manufacturing of B-pillar reinforcement used in a domestic self-own brand car. Moreover, Q&P steel are suited for manufacturing structural and safety parts with complex shapes, such as A-pillar inner and hinge-pillar reinforcement .

## Mechanical properties



The products listed in the tables below can be supplied in accordance with EN, ASTM, JIS, and BaoSteel standards. Ordering according to customer's standard or requirement is also available.

Table 9 CR Q&P Steel

Steel Grade	YS <sup>a, b</sup> R <sub>p0.2</sub> , MPa	TS R <sub>m</sub> , MPa ≥	EL A <sub>50mm</sub> , % ≥
HC600/980QP	600~850	980	15
HC600/980QP-EL	600~850	980	20
HC820/1180QP	820~1100	1180	8
HC820/1180QP-EL	820~1100	1180	14

- a If the yield point is not pronounced, the values of R<sub>p0.2</sub> apply. Otherwise, the values of R<sub>eL</sub> apply.  
 b Guaranteed for No.5 tensile specimens according to standard JIS Z2241 with the tensile axis vertical to the rolling direction.  
 \* Please confirm the specifications of product before official order. The specifications are negotiable.

Table 10 HDG Q&P Steel

Steel Grade	YS <sup>a, b</sup> R <sub>p0.2</sub> , MPa	TS R <sub>m</sub> , MPa ≥	EL A <sub>50mm</sub> , % ≥
HC600/980QPD+Z	600~850	980	15
HC600/980QP-ELD+Z	550~800	980	20
HC820/1180QPD+Z	820~1100	1180	8
HC820/1180QP-ELD+Z	820~1100	1180	14

- a If the yield point is not pronounced, the values of R<sub>p0.2</sub> apply. Otherwise, the values of R<sub>eL</sub> apply.  
 b Guaranteed for No.5 tensile specimens according to standard JIS Z2241 with the tensile axis vertical to the rolling direction.  
 \* Please confirm the specifications of product before official order. The specifications are negotiable.



Fig.14 B-pillar reinforcement, HC600/980QP (2.0mm×1100mm)



Fig.15 A-pillar inner, HC600/980QPD+Z (1.0mm×950mm)

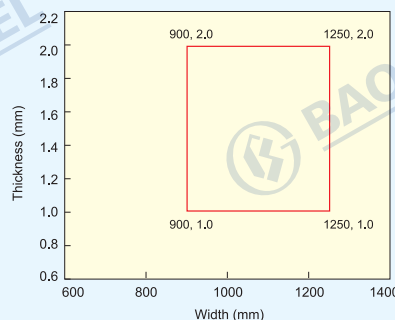


Fig.16 B-pillar inner, HC600/980QP (1.2mm×1200mm)

## Product dimensions

CR and HDG (GI) Q&P Steel

1180MPa and below





# TWIP (Twinning Induced Plasticity) Steel

## Technical characteristics

**Microstructure:** Full austenite (Fig.17)

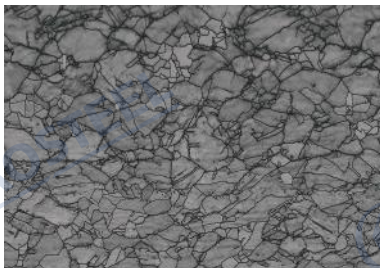


Fig.17 Typical microstructure of TWIP steel

**Properties:** TWIP steel are full austenitic steel with high C, Mn and Al. TWIP steel have very high strain hardening capacity due to dynamic refinement effect caused by the continuous activation of twinning during cold deformation. TWIP steel developed by BaoSteel exhibit an elongation of over 50% with the tensile strength of 1000MPa.

**Applications:** TWIP steel have very good formability and ultra-high strength, which are suited for manufacturing structural and safety parts with very complex shapes.

## Mechanical properties

The products listed in the tables below can be supplied in accordance with EN, ASTM, JIS, and BaoSteel standards. Ordering according to customer's standard or requirement is also available.

Table 11 CR TWIP Steel

Steel Grade	YS <sup>a, b</sup> R <sub>p0.2</sub> , MPa	TS R <sub>m</sub> , MPa ≥	EL A <sub>50mm</sub> , % ≥	n ≥
HC450/950TW	450~600	950	47	0.35

a If the yield point is not pronounced, the values of R<sub>p0.2</sub> apply. Otherwise, the values of R<sub>el</sub> apply.

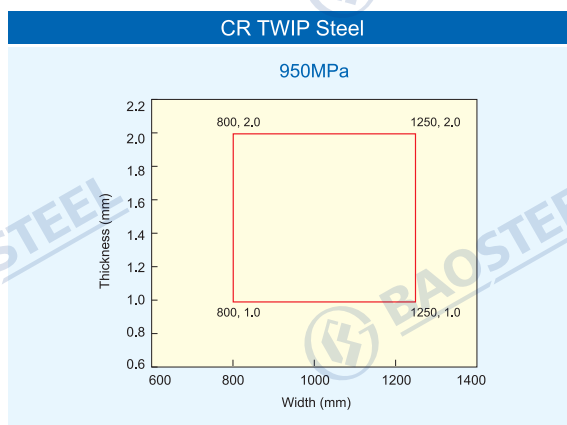
b Guaranteed for P17 tensile specimens according to standard GB/T 228 with the tensile axis parallel to the rolling direction.

\* Please confirm the specifications of product before official order. The specifications are negotiable.

## Application cases

TWIP steel exhibit the combination of ultra-high strength and ultra-high formability, which could lead to remarkable change in auto-part design. According to their properties, TWIP steel could be suited for manufacturing structural and safety parts with ultra-high strength and very complex shape, including bumper and B-pillar.

## Product dimensions



# PH/B (Press Hardening/Boron) Steel

## Technical characteristics

**Microstructure:** Ferrite-Pearlite (before quenching), Martensite (after quenching), as shown in Fig.18.

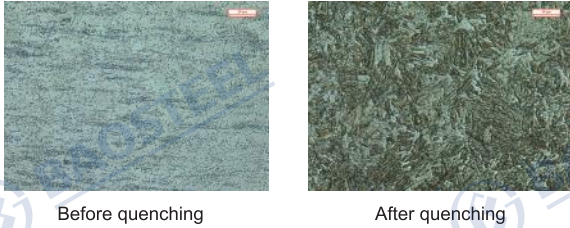


Fig.18 Typical microstructure of PH/B steel

**Properties:** Extra High strength(1500MPa), improved Crash Performance, high light-weighting potential, design of complex shape, good formability; high product dimension accuracy.

**Application:** Structural and safety parts, such as front and rear bumper, A-pillar, B-pillar, floor and roof reinforcements.

## Mechanical properties

The products listed in the tables below can be supplied in accordance with EN, ASTM, JIS, and BaoSteel standards. Ordering according to customer's standard or requirement is also available.

## Application cases



Fig.19 Front bumper, HD950/1300HS (2.35mm×1035mm)



Fig.20 B-pillar, HC950/1300HS (1.8mm×1025mm)

Table 12 PH/B Steel

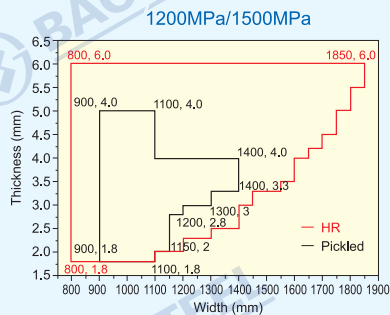
Steel Grade	YS <sup>a, b</sup> R <sub>p0.2</sub> <sup>'</sup> MPa	TS R <sub>m</sub> <sup>'</sup> MPa	EL <sup>c</sup> A <sub>50mm</sub> <sup>'</sup> %
BR500HS	280~450	≥ 430	≥ 20
B500HS	260~420	≥ 410	≥ 25
BR600HS	300~450	≥ 450	≥ 20
B600HS	280~420	≥ 440	≥ 25
BR1200HS	≥ 280	≤ 700	≥ 18
B1200HS	≥ 220	380~700	≥ 22
HD950/1300HS (BR1500HS)	320~630	480~800	≥ 16
HC950/1300HS (B1500HS)	280~450	≥ 450	≥ 20
HC950/1300HS+AS	≥ 300	≥ 500	≥ 17
BR1800HS	≥ 350	≥ 500	≥ 14
B1800HS	≥ 300	≥ 450	≥ 18

- a Guaranteed for No.5 tensile specimens according to standard JIS Z2241 with the tensile axis vertical to the rolling direction.
- b If the yield point is not pronounced, the values of R<sub>p0.2</sub> apply. Otherwise, the values of R<sub>m</sub> apply.
- c When the specified nominal thickness is in the range of 0.5~0.7 mm, the minimum value of EL should be reduced by 2%. For thickness less than 0.5 mm, the minimum value of EL should be reduced by 4%.

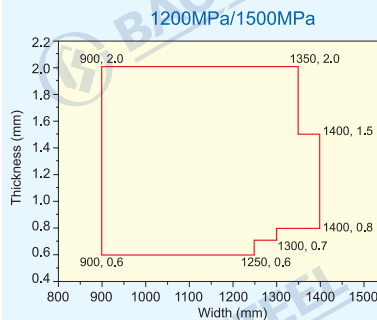
\* The properties after quenching strongly depend on quenching process.  
Please confirm the specifications of product before official order.  
The specifications are negotiable.

## Product dimensions

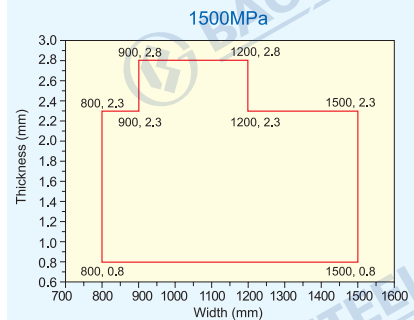
### HR and HR Pickled PH/B Steel



### CR PH/B Steel



### Al-Si Coated PH/B Steel



# Processing and Distribution for UHSS



To satisfy the demand of UHSS processing and ensure the quality and delivery, Baosteel International has already built up an processing and distribution system: there are 35 slitting lines processing 780Mpa and above with a total capacity around 1.42 million tons/y. there are 7 lines processing 980Mpa and above with total capacity of 425 thousand tons/y. there are 10 cutting and blanking lines processing 980Mpa and above with total capacity of 500 thousand tons/y.

Among the first UHSS processing unit, Shanghai HSS Distribution Co.,Ltd started business in 2010 and run a slitting and a CTL line both capable of processing steel up to 1470Mpa. It has planned to improve capabilities up to 1800Mpa within 2018. The capacity in Shanghai will also be lifted to 450 thousand tons/y. since other regional steel service centers can cover processing demand up to 1180Mpa, those higher than 1180Mpa will be covered by shanghai facility.



Parameters of S3	
Slitting Strength Max	1800MPa
Yield Strength Max	1800MPa
Coil Weight Max	30MT
Entrance Width	300-1650mm
Exit Width	30-1650mm
OD Max	2100mm
OD Min	900mm
ID	Ø508 and 610mm
Coil Thickness	0.5-6.0mm
Design Capacity	150000MT

Parameters of L4	
Cutting Strength	1470MPa
Yield Strength Max	1470MPa
Coil Weight Max	30MT
Entrance Width	300-1650mm
Cutting Length	300-6000mm
OD Max	2100mm
OD Min	900mm
ID	Ø508 and 610mm
Coil Thickness	0.5-4.0mm
Stacking Height Max	750mm
Stacking Weight Max	5MT
Design Capacity	150000MT



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