



制品行业用钢

STEEL USED IN PRODUCT PROCESSING INDUSTRY

太钢产品分行业系列册 Products Serial Catalogs Of Tisco For Different Industries

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太原钢铁(集团)有限公司
Taiyuan Iron & Steel(Group) Co., Ltd.



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太钢简介

BRIEF ON TISCO

太原钢铁（集团）有限公司（简称太钢）是中国特大型钢铁联合企业和全球产能最大、工艺技术装备水平最高、品种规格最全的不锈钢企业。经过70年发展，已具备1000万吨以上钢、铁、材的生产能力，其中不锈钢产能达300万吨。

太钢是中国第一炉不锈钢、第一炉硅钢、第一张硅钢片的诞生地。拥有铁矿石等钢铁冶炼原料的采掘与加工、钢铁冶炼、钢铁材料压力加工、冶金设备及备品备件制造等方面先进技术和装备，主要产品有不锈钢、冷轧硅钢片（卷）、热连轧卷板、车轴钢、合金模具钢、军工钢等。产品广泛应用于石油化工、交通运输、建筑装饰、家用电器、医疗食品等行业及神舟系列飞船、嫦娥一号、“东风”系列火箭等高端领域，进入三峡水利、西气东输、奥运场馆等国家重点工程。

太钢的发展目标是，加快建设全球最具竞争力的不锈钢企业，到2010年，以不锈钢为主的品种、质量、成本、研发、节能、环保、效率、服务等各项指标达到国际一流水平，建设具有国际竞争力的大企业集团。

Taiyuan Iron and Steel (Group) Co. Ltd. (TISCO) is a gigantic steel complex in China and a world leading stainless steel producer with largest capacity, full range of products and state of the art facility. With 70 years development, the capacity of pig iron, crude steel and rolled products increased over 10 million ton, including 3 million tons of stainless steel.

TISCO produced the first heat of stainless steel, first heat of silicon steel and first sheet of silicon steel. It is well equipped for mining and beneficiation (such as iron ores), ironmaking, steelmaking, rolling and manufacture of metallurgical equipment and spare parts. Main products include cold rolled stainless and silicon sheet/coil, hot rolled coil, axle steel, die steel and military steel. They are widely used in petrochemical industry, transportation, construction, decoration, home appliance, medical apparatus and food industry, they are also used for high-end application and national key projects as Shenzhou spaceship, Chang'e-1 Moon Detector, Dongfeng rocket series, Three Gorges project, West-East natural gas transmission project and Olympic games facility.

Our goal in development is to expedite building TISCO as the most competitive stainless steel producer in the world, holding the world leading position by 2010 in terms of range, quality, cost, R&D, energy saving, environment protection, efficiency and service. Our target is to create an international enterprises group of strong competitive edges out of Taigang.



◆ 制品行业用钢概况

不锈钢制品业涉及产品门类广，企业多，是一个既新兴又传统的具有一定技术含量的劳动密集型产业，也是一个与人民生活息息相关的朝阳产业，该行业要求不锈钢有良好的加工性能（深冲性、焊接性、表面抛光性等）。太钢生产的不锈钢产品广泛应用于制品行业的各个领域。工具五金（扳手、钳类、旋具、链刀及手持小型电动工具等）、建筑五金（卫生间五金配件、各种钉、丝、网、阀门、水嘴等）、日用五金（纽扣、刀、剪、打火机、指甲钳等）、燃气灶具、热水器、水槽、厨房设备、锁具、各类锅、碗、盆、刀、叉、吸油烟机、洗衣机、微波炉、电冰箱、烤箱、空调、钟表等。国内市场占有率及出口数量都居全国第一。

除常用的304、430外，根据不锈钢制品行业特点，太钢重点在300系产品上开发304DQ、304DDQ、304DDQS、304J1等系列产品，400系产品上开发了TTS443、439、444、436L、411SS、430J1L系列产品。另外，太钢在国内首家研制生产出铁素体抗菌不锈钢（TKJF系列）和奥氏体抗菌不锈钢（TKJA系列），该产品在家电、餐厨具、医疗器械、食品加工及公共设施领域具有广阔的应用前景。

◆ 与行业客户的合作关系

太钢在不锈钢制品行业，坚持走科技领先、质量为本的高端路线。充分发挥先进工艺设备的优势，同国内外知名企业建立了长期合作关系，如IKEA、SIEMENS、富士康、江门日盈、青岛海尔、格兰仕、美的等。另外太钢不锈钢工业园区的加工优势吸引了国内主要从事制品加工用户进驻园区，产品主要定位于电器、厨具、日用五金等中、高档制品行业。

◆ Brief on product processing industry steel

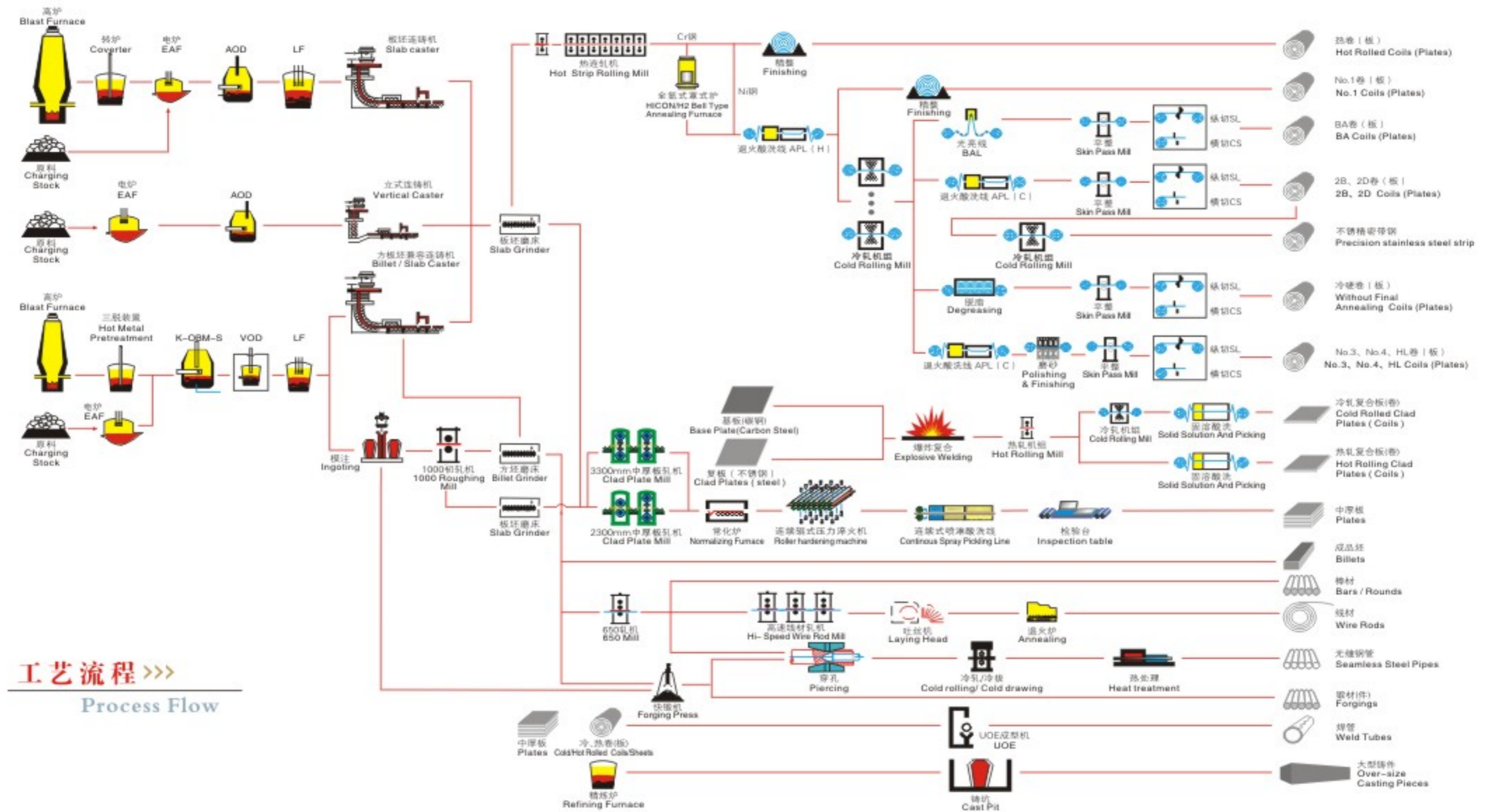
The stainless steel product processing industry deals with wide variety of products and producers. It is an emerging and conversional, labor-intensive and technology involved, sunrise industry closely related to our daily life. The stainless steel used in this industry requires high workability (deep drawing, weldability and surface polishing etc.). TISCO's stainless steel is widely used in the product processing industry, including the tools (spanners, pliers, screwdrivers, files and small electrical tools), construction hardware (sanitary fittings, nails, wires, grids and meshes, valves and nozzles etc.), household hardware (fasteners, knives, scissors, lighters, nail clippers etc.), fuel gas ovens, water heaters, sinks, kitchenware, locks, pans and pots, bowls, knives, forks, range hoods, washing machines, microwave ovens, refrigerators, ovens, air conditioners, clocks etc. TISCO's stainless steel ranks first in the domestic market share and the export share.

In addition to 304 and 430, TISCO, based on the industrial characteristics, developed 300 series like 304DQ, 304DDQ, 304DDQS, 304J and 400 series like 443, 439, 436L, 411SS, 430J1L and 430D. TISCO developed in the first place the ferritic antibiotic stainless steel (TKJF) and austenitic antibiotic stainless steel (TKJA), which will have broad application in household appliances, kitchenware, medical appliance, food processing and public accommodation.

◆ Cooperative relationship with industrial customers

TISCO persists in the leading technology and high quality of the stainless steel products. With the advanced equipment, TISCO established long-term cooperation with the enterprises well-known in China and abroad, such as IKEA, SIEMENS, FOXCONN, RIYING JIANGMEN, Haier Qingdao, GALANZ, MIDEA etc. In addition, TISCO Stainless Steel Industrial Park has attracted domestic producers of the household appliances, kitchenware, and domestic hardware.





工艺流程 >>>
Process Flow



认证与研发能力 >>>

Certification & Research Development



国家级实验室
National level laboratory



2007年在国家认定的438家企业技术中心中，太钢技术中心排名第4位。
Tisco technology center ranks 4th among enterprise-based 438 technology centers accredited by the state in 2007.



常规产品 >>>

Conventional Products

钢种 Steel grade	牌号 Grade	规格 (mm) Specifications		单重 Weight t	标准 Standard	主要用途 Application
		厚度 Thickness	宽度 Width			
冷轧 Cold rolled 不锈钢卷板 Stainless steel coils	304	0.3-16	300-2100	5-40	GB/T3280 ASTM/ASME JISG4305 EN10088 BSEN10028	由于具有良好的耐腐蚀性和优良的加工性，在制品行业广泛应用。 Widely used in the product processing industry thanks to its high corrosion resistance and workability.
	430				GB/T3280 ASTM/ASME JISG4305 EN10088 BSEN10028 Q/TX3157-2006	有良好的耐腐蚀性和加工性，因为是铁素体不锈钢，经济性好。 Ferritic stainless steel high corrosion resistance, workability and cost effectiveness.
	304DQ				Q/TX3132-2005	适用于深冲性能要求较高的制品。 Suitable for deep drawn products.
	304DDQ					适用于复杂变形的制品。 Suitable for complicatedly deformed products.
	304DDQS					
	304J1				JIS4305	广泛用于深冲制品行业，如家用电器等。 Used in deep drawn product industry, such as housewares.
	304Cu2					新开发的铁素体不锈钢，可在日用制品中替代304，且经济性优于304。 New ferritic stainless steel grade more economic and substitute for 304.
	TTS443				Q/太新012-2007	有良好的抗氯离子腐蚀性能，适用于水箱等。 High chloride corrosion resistance suitable for water tanks etc.
	444				Q/太新013-2007	由于有良好的淬透性和较高的硬度，适用于刀刃五金制品。 High hardenability and hardness suitable for knives.
	0-4Cr13				GB/T3280-1992	430的改进型钢种，深冲性能优于430。 Variant of 430 deep drawability better than 430.
	430J1L					铁素体抗菌钢，用于一般腐蚀介质下的食品制品、医疗器械。 Ferritic antibiotic steel suitable for the food containers and medical appliance in general corrosive environment.
	TKJF-1				Q/太新013-2005	奥氏体抗菌钢，用于较强腐蚀介质下的食品制品、医疗器械。 Austenitic antibiotic steel suitable for the food containers and medical appliance in severe corrosive environment.
	TKJF-2					
	TKJA-1				Q/太新014-2006	

产品介绍 >>>

Product Introduction

304L: 是奥氏体不锈钢中生产量和使用量最大的牌号之一。具有优良的耐腐蚀性能以及冷加工冲压性能。对氧化性酸（如硝酸）有很强的耐腐蚀性，对碱溶液及大部分有机酸和无机酸亦有一定的耐腐蚀能力。低温性能较好，在-180°C条件下强度、伸长率和断面收缩率都很好。用于制造深冲型的零件、耐酸管道、容器等，也经常用作焊接铬镍不锈钢和铬不锈钢的焊条芯材、非磁性部件以及低温环境下使用的部件等。

304DQ: 在304基础上通过调整成份，使该产品无磁、耐腐蚀、具有良好的成形性，可以一次冲压成接近1:1的成品，也可以多道次冲压成不同形状的产品。

304DDQ: 在304基础上增加镍，较304有更好的冲压性能，由于对成份进行了调整，即保证了深冲成形又保证了产品冲压后不开裂。

304DDQS: 在304基础上添加更高的镍，提高了产品的镍含量稳定了组织，材料成形性好且降低钢中碳氮，变形后不开裂。用于304冲压难以成形的场合如高径比大于2.0的产品。

304: One of the most popular austenite stainless steel grades with high corrosion resistance and cold workability; strongly corrosion resistant to oxidizing acid (e.g. nitric acid), aqueous alkali, most organic acid and inorganic acid; good low temperature performance, high strength, elongation and cross section constringency at -180°C; suitable for making deep drawn parts, acid-resistant pipes and vessels; also used as electrode welding core for Ni-Cr and Cr stainless steel welding, nonmagnetic parts and cryogenic parts.

304DQ: Variant of 304, nonmagnetic, corrosion resistant, good formability, pressing ratio 1:1.

304DDQ: Variant of 304 with additional nickel, better drawing property ensuring deep drawing without cracking.

304DDQS: Variant of 304 with higher nickel, more stable structure, good formability and lower C and N content, no strain cracking, suitable for products of height-diameter ratio>2.0.

304J1: 在304基础上添加铜的冲压用钢，加铜后降低材料的变形抗力，有利于材料成形，广泛用于深冲制品行业，如家用器皿等。

304Cu2: 在304J1基础上进一步增加Cr、Ni、Cu含量，使产品冲压后耐腐蚀开裂，常用于储液槽、温水池、家用热水机等。

411SS: 在410S基础上降碳加铜，提高成形性，可以制作各种餐具、炊具、器皿等。

430: 具有耐蚀性、力学性能以及热导率高的特点，主要用于热交换器、贮槽等，薄板广泛用于建筑内装修、日用办公设备、厨房器具、汽车装饰、气体燃烧器等。

430JL1: 在430基础上添加铌、铜，成形性和抗皱性较430更优，适合于高深冲制品，如保温瓶、洗衣机底板等。

铁素体抗菌不锈钢（TKJF系列）和奥氏体抗菌不锈钢（TKJA系列）对大肠杆菌、金黄色葡萄球菌、铜绿假单胞菌及白念珠菌的抗菌率均大于99%，各系列抗菌不锈钢与同类不锈钢相比综合力学性能、腐蚀性能及加工性能相当。

304J1: Variant of 304 with copper, lower deformation resistance, widely used in pressing application such as housewares.

304Cu2: Variant of 304J1 with higher Cr, Ni and Cu, resistant to corrosion cracking, suitable for liquid tank, warm water pool and domestic water heater.

411SS: Variant of 410S with lower C and additional Cu, used for tableware, cooker and vessels.

430: Corrosion resistant, high mechanical properties and thermal conductivity, mainly used for heat exchanger, storage tank, thin strip widely used for building decoration, office facilities, kitchenware, car accessories and gas burner.

430JL1: Variant of 430 with addition of Nb and Cu, better formability and wrinkle resistance, suitable for deep drawn products like thermos, base plates of washing machines.

TKJF series and TKJA series: 99% antibacterial ratio to colon bacillus, golden-yellow staphylococcus, pseu domonas and candida albica, comparable mechanical property, corrosion resistance and workability.

产品应用 >>>

Application

制品行业用钢广泛应用于日用五金、厨房用品、家电材料、医疗器械等。
Following products are widely used in daily hardware, kitchen appliance, household appliances and medical instruments.



430冷板
430 Cold rolled strips



443冷板
443 Cold rolled strips



不锈钢水槽
Stainless steel water sinks



厨房用具
Kitchen appliances



卫浴
Bathroom articles



洗衣机
Washing machines

产品成分、性能 >>>

Composition and Property of Product

◆ 化学成份 (典型值) %
Chemical composition (Typical value) %

牌号 Grade	C	Si	Mn	P	S	Cr	Ni	Cu
304	0.07	1.00	2.00	0.035	0.030	17.00	8.00	-
430	≤0.07	≤0.30	≤0.50	≤0.032	≤0.005	16.8	-	-
304DQ	0.051	0.55	1.29	0.030	0.003	18.05	8.17	-
304DDQ	0.042	0.47	1.05	0.029	0.003	18.10	8.61	-
304DDQS	0.039	0.50	0.97	0.029	0.003	18.07	9.21	-
304J1	0.053	1.22	1.16	0.031	0.005	17.52	7.38	1.75
304Cu2	0.050	0.40	1.01	0.027	0.003	18.02	9.03	2.30
411SS	0.013	0.42	0.50	0.031	0.003	13.22		0.92
430J1L	0.007	0.35	0.56	0.031	0.003	16.51		0.4, Nb; 0.38

◆ 机械性能
Mechanical property

牌号 Grade	R _{0.2} , MPa	R _m , MPa	A%	HV
304	205	520	40	200
430	≥310	520	30	145
304DQ	275	580	61.5	162
304DDQ	271	590	70.0	170
304DDQS	255	575	71.5	168
304J1	268	585	61.5	170
304Cu2	230	560	65.0	156
411SS	260	485	28.5	158
430J1L	275	440	41.5	150

◆ 机械性能
Mechanical property

牌号 Grade	IE (mm)	n	r	Δr
304DQ	13.0	0.25	0.98	0.2
304DDQ	13.2	0.26	1.0	0.1
304DDQS	13.3	0.28	1.0	0.1
304J1	13.0	0.26	1.0	0.2
304Cu2	13.2	0.26	1.0	0.1
411SS	10.2	0.22	1.4	0.4
430J1L	10.0	0.21	1.3	0.3
430	9.0	0.18	1.2	0.2

太钢近几年来，针对广东省江门、新兴县不锈钢器皿行业集中地区推广了304DQ、304DDQ、304DDQS、430冷轧产品。用户在试用该产品以来，在加工过程中材料深冲效果优于进口304。国内著名不锈钢制品企业江门日盈已经使用太钢304DQ、304DDQ、430三年多，质量稳定，特别是在材料不退火的情况下可连续三次拉伸，降低了加工成本。

Tisco has supplied 304DQ, 304DDQ, 304DDQS and 430 cold rolled strip to stainless utensil fabrication areas in Jiangmen and Xinxin Counties, Guangdong Province since 2006. The deep punching performance is better than imported 304 material. Jianmeng Riying, a well-known domestic manufacturer has used 304DQ, 304DDQ, 430 from TISCO for more than 3 years. The quality is constant, cost is reduced by eliminating annealing between three drawings.

用户使用指南 >>>

User Instruction

◆ 不锈钢焊接工艺原则
The principle of stainless steel welding

1、奥氏体不锈钢焊接工艺原则

(1) 焊接工艺参数 (2) 焊前预热 (3) 焊后热处理 (4) 焊接接头的坡口形式

2、铁素体不锈钢焊接及焊后热处理工艺原则

(1) 焊接工艺规范 (2) 焊前预热 (3) 焊后热处理

1. The principle of Austenite stainless steel welding

(1) Welding parameter; (2) Preheating before welding; (3) Heat treatment after welding; (4) Bevel of welding joint.

2. The principle of Ferrite stainless steel welding and post-weld heat treatment.

(1) Welding procedure; (2) Preheating before welding; (3) Heat treatment after welding.

钢种 Grade	焊接工艺特点 Welding characteristics
304 304DQ 304DDQ 304DDQS	可采用通用的方法焊接。手工电弧焊时，含碳0.04%~0.06%的薄截面尺寸的304可采用奥002焊条。对于厚截面尺寸欲保持焊后的耐晶间腐蚀性能，需进行焊后热处理。 Common welding method can be adopted. Austenite 002 electrode is used for manual welding of thin section 304 with 0.04%~0.06% carbon. Post-weld heat treatment is needed for thick section size to ensure intergranular corrosion resistance.
430	可以焊接，但通常采用小电流，高焊速并使用焊接层次尽量少的焊接工艺。截面尺寸大于6mm的板、管材不宜用作焊接结构件。 Welding should be in low current, high speed. The plate and pipe of over 6mm section size are not suitable for welded structure.

◆ 不锈钢的鉴别方法

Identification of stainless steel

※ 色泽的区别:

经过酸洗的不锈钢的表面色泽: 300系不锈钢色银白, 呈玉色; 400系不锈钢色白, 稍灰, 光泽弱; 200系不锈钢的色泽与300系不锈钢相似, 稍淡。

未经酸洗的不锈钢的表面色泽: 300系不锈钢呈棕白色; 400系不锈钢呈棕黑色; 200系不锈钢呈黑色。

※ 磨花鉴别: 磨花鉴别是把不锈钢在砂轮机上磨, 观其火花。如火花呈流线形, 并有较多较密的节花, 即为含锰较高的200系不锈钢; 如无节花即为300或400系不锈钢。

※ 磁性鉴别: 300系、200系无磁性 (冷加工后未经固溶处理, 有弱磁性), 400系有磁性。

※ 200系专用识别剂: 将溶剂涂抹在钢板表面, 通电后1分钟内溶剂变红为200系, 否则为300系

※ Color

In pickled condition: 300 series: silver white, jade color; 400 series: white, light gray, low luster; 200 series: similar to 300 series, lighter.

※ In unpickled condition: 300 series: brown white; 400 series: brown black; 200 series: black.

※ Grinding spark: grinding by grinder, if the spark is in streamline shape, with more and dense spark, it should be 200 series with high content of manganese.

※ Magnetism: 300 and 200 series: non-magnetic (weak magnetism, without solution annealing after cold work), 400 series: magnetic.

※ Special method for 200 series: put solvent on the plate surface and energized for 1 minute, red solvent for 200 series.

◆ 不锈钢表面清洗方法

Surface cleaning

表面状态 Surface condition	洗涤方法 The cleaning method
灰尘以及一般污垢 Dust and ordinary dirt	肥皂、弱洗涤剂或用温水洗涤 Clean with soap, mild detergent and warm water
标签及贴膜 Label and adhesive film	用温水、弱洗涤剂来擦洗, 粘剂成分使用酒精或有机溶剂 Clean with mild weak detergent, alcohol or organic solvent
脂肪、油、润滑油污染 Grease, oil and lubrication oil	用柔和的布或纸擦干以后用中性洗涤剂或氨溶液或专用洗涤药品来洗涤 Clean with soft cloth or paper, then use neutral detergent, ammonia solution or special cleaning solvent
漂白剂以及各种酸附着 Bleacher and acid adhesions	立即用水冲洗, 用氨或中性碳酸苏打水溶液里浸泡, 后用中性洗涤剂或温水洗涤 Flush with water immediately, immerse in ammonia or neutral carbonated soda water, then wash with neutral detergent or warm water.
有机碳化物附着 Organic carbide adhesion	浸泡在热的中性洗涤剂或氨溶液然后用含弱研磨的洗涤剂洗涤 Immerse in hot neutral detergent or ammonia solution, then wash with fine-abrasive detergent
指纹 Finger print	用酒精或有机溶剂 (乙醚、苯), 用柔软布擦干以后再用水洗涤 Clean with soft cloth, alcohol or organic solution (aether, benzene), then wash with water
彩虹纹 Rainbow line	过多使用洗涤剂或油引起, 洗涤时用温水中性洗涤剂 Excessive detergent or oil, clean with warm water and neutral detergent
焊接受热变色 Welding oxidation tint	用10%硝酸或氢氟酸溶液洗涤以后再用氨水碳酸苏打溶液中和处理然后用清水洗涤 Clean with 10% Nitric acid or Hydrofluoric acid solution, neutralize with Ammonia carbonic soda solution, rinse with clean water
表面污染物引起的锈 Contamination corrosion	--使用硝酸 (10%) 或研磨洗涤剂洗涤 --使用专用洗涤药品 -- Clean with Nitric acid (10%) or abrasive detergent -- Use special abluent

主要特点 >>>

Main Features

1、发挥太钢超薄、超厚、超宽及剪切、分条的特点, 根据客户个性化需求, 结合在建拟建加工中心, 为客户提供性价比高的深加工终端产品。

2、针对430产品在制品加工行业存在的缺陷, 研发430XT、430CuN等高加工性能产品。

3、发挥太钢独特的精炼技术, 为特殊制品行业及沿海地区开发超高耐蚀性铁素体不锈钢447J1 (日本钢号: JFE30-2), 替代304、316L等300系列钢种。

1. To provide cost effective tailor-made ultra-thin, ultra-thick, ultra-wide cut-to-length and slit strip.

2. To develop variant of 430, such as 430XT, 430CuN, to ensure the performance.

3. To develop super corrosion resistant ferrite stainless steel 447J1 (JFE30-2) for special product industry and coastal area to substitute 304 and 316L.

服务承诺 >>>

Service Promise



- 为客户提供个性化成份、性能、包装、卷重、质保书的设计。
 - 为客户在选材和加工工艺方面提供技术支持。
 - 交货准确及时。
 - 对客户异议，在24小时内答复。
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- Provide for consumers with the personalized designs on composition, properties, package and the quality certificate.
 - Technical support to customers in material selection and fabrication.
 - Accurate and prompt delivery.
 - Response to customer's claim within 24 hours.

合作伙伴 >>>

Cooperative Partner



主要业务部门联系方式 >>>

Contacting Manners of the Main Business Sections

股份公司主要业务部门 Main business department of Co.,Ltd	业务功能 Functions	联系电话 Telephone	E-mail
营销部 Marketing Department	合同管理、订货、异议、 投诉受理及出口贸易 Contract and order management Complaint and claim handing Exports business	0351-3014658 0351-3011432 800-806-1998 +86 (0)351-3017169 +86 (0)351-3017525	bocb@tisco.com.cn Tgyhfwk@tisco.com.cn Tggm@tisco.com.cn
技术中心 Technology center	技术咨询与服务 Technical consultation service	0351-3012213	Tgszxbxg@tisco.com.cn

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太钢东北区销售公司 TISCO sales company in Northeast of China	辽宁太钢销售有限公司 Liaoning TISCO Sales Co. Ltd.	沈阳 Shenyang	电话 (Tel) 024-24220350 邮编 (Post code) 110016	传真 (Fax) 024-24231216
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太钢华东区销售公司 TISCO sales company in East China	无锡太钢销售有限公司 Wuxi TISCO Sales Co. Ltd.	无锡 Wuxi	电话 (Tel) 0510-82407713 邮编 (Post code) 214011	传真 (Fax) 0510-82441187
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	杭州太钢销售有限公司 Hangzhou TISCO Sales Co. Ltd.	杭州 Hangzhou		
太钢山东区销售公司 TISCO sales company in Shandong	青岛太钢销售有限公司 Qingdao TISCO Sales Co. Ltd.	青岛 Qingdao	电话 (Tel) 0532-81101847 邮编 (Post code) 266000	传真 (Fax) 0532-87734796
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太钢华南区销售公司 TISCO sales company in South China	佛山市太钢不锈钢销售有限公司 Foshan TISCO Stainless Steel Sales Co. Ltd.	佛山 Foshan	电话 (Tel) 0757-83315711 邮编 (Post code) 528041	传真 (Fax) 0757-83315716
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太钢西北区销售公司 TISCO sales company in Northwest of China	西安太钢销售有限公司 Xi'an TISCO Sales Co. Ltd.	西安 Xi'an	电话 (Tel) 029-86221507 邮编 (Post code) 710016	传真 (Fax) 029-86231506