



Precision
Behind Every
Innovation



YOUR RELIABLE GLOBAL PARTNER FOR INNOVATIVE AUTOMOTIVE STEEL TUBES

PRECISION STEEL TUBES

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Website

HEBEI CBIES AUTOMOTIVE PARTS CO., LTD.



PRECISION BEHIND EVERY INNOVATION

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COMPANY OVERVIEW



COMPANY PROFILE

CBIES: Rooted in China, Serving Global Markets

As a key member of Hebei Sinostar Group, CBIES has evolved from a precision tube manufacturer into a trusted partner with systematic development and delivery expertise since 2005. CBIES supports OEMs and Tier-1 suppliers in reducing total cost, accelerating development cycles, and ensuring stable global supply through integrated manufacturing and automotive-grade quality systems.

Guided by our CBIES Trust Equation® [Reliability × Expertise × Agility ÷ Risk], we collaborate with innovators to deliver safer, smarter solutions for the new energy era, fueling sustainable growth worldwide.

Reliability

Stable quality and on-time delivery

Agility

Fast response and flexible capacity

Expertise

Automotive engineering and standards compliance

Risk

Reduced through systems and full traceability

OUR MISSION

Driven by Human and Social Responsibility,
Pioneering Through Innovation



GLOBAL FOOTPRINT

Our offerings span multiple product categories, including Exhaust Systems, Cross Car Beams, Side Impact Beams, Seat Frames, and Battery Pack Brackets, with exports to Europe, North America, Southeast Asia, and beyond.



WHY CBIES

Our Difference

Building ethical, reliable, and long-term partnerships.



Our Partnership

Becoming co-innovation partners in the new energy era.



Our Value

Innovating aligned with industry shifts and client needs.



MANUFACTURING AND PROCESSING CAPABILITIES

Manufacturing Equipment

Equipped with world-class lines to ensure efficiency, stability, consistency, and sustainable manufacturing capacity.



Korean KTM high-frequency welded tube production line

Round tubes: $\varnothing 8 - \varnothing 254$ mm **Square tubes:** $6 \times 6 - 100 \times 100$ mm **Rectangular tubes:** $6 \times 10 - 90 \times 130$ mm
Wall thickness range: 0.6 – 4.5 mm **Materials:** Carbon steel / Low-alloy steel / Stainless steel



Korean HANDUK roller hearth type continuous anaerobic annealing furnace

Tube diameter: $\varnothing 12 - \varnothing 102$ mm **Wall thickness range:** 0.8 – 10.0 mm
Materials: Carbon steel / Low-alloy steel / Stainless steel



Fully automatic high-frequency induction quenching line

Tube diameter: $\varnothing 19 - \varnothing 45$ mm **Length:** 430 – 1500 mm **Wall thickness range:** 1.0 – 5.0 mm
Materials: Boron alloy steel / Medium-carbon and higher-grade steels

SUPPLY CHAIN
MANAGEMENT SYSTEM



Korean triple drawing bench line

Round tubes: Ø10 – Ø90 mm **Wall thickness range:** 0.7 – 7.0 mm

Materials: Carbon steel / Low-alloy steel



Slitting machine

Strip thickness: 0.6 – 4.0 mm **Strip width:** 460 – 1500 mm

Materials: Carbon steel / Low-alloy steel / Stainless steel



Pipe cutting machine

QUALITY MANAGEMENT SYSTEM

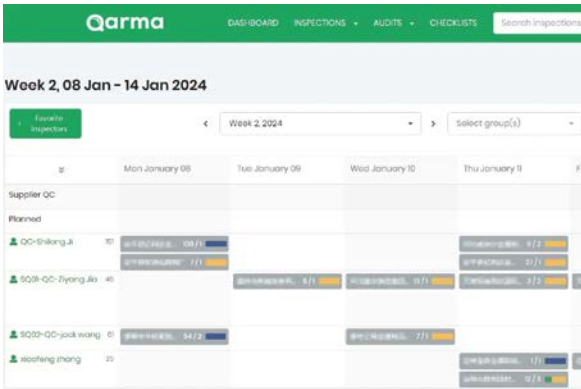
CBIES has established a comprehensive quality management system that includes a series of quality certifications, a variety of testing equipment with corresponding test methods, and the digital quality-inspection tool QARMA.

CBIES is certified to IATF 16949:2016, ISO 9001:2015, ISO 45001:2018, ISO 14001:2015, ISO 14067:2018, ISO 14064-1:2018, and can provide EN 10204:2004 Type 3.1 certificates upon request.

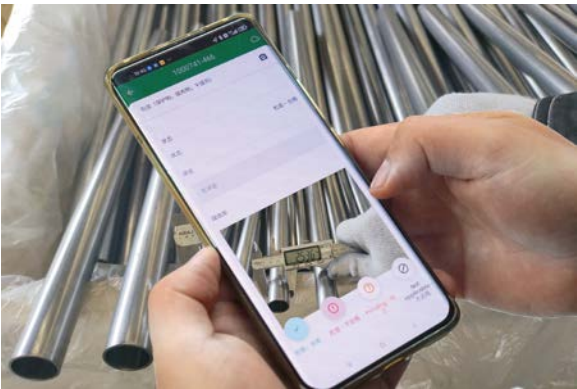


Quality Management System

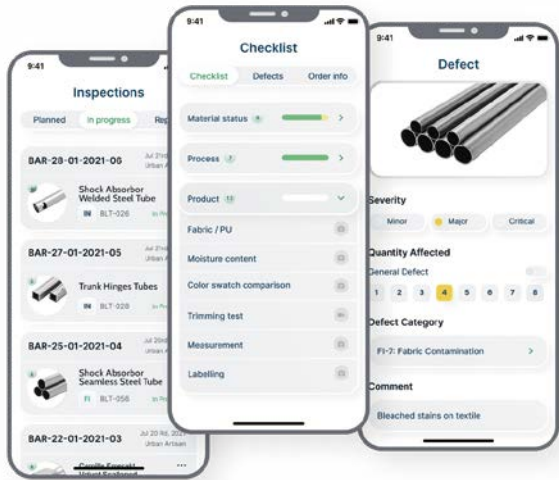
The digital quality inspection tool QARMA, adopted by CBIES, enhances its ability to maintain and uphold the highest standards across all stages of production.



Planning & scheduling for inspector



Generating reports, analytics, and insights



Covering every step of the inspection process

Inspection and Testing Capabilities

CBIES has meticulously implemented a holistic quality management system, fortified by a diverse portfolio of precision testing equipment tailored to the tests required to ensure product excellence.

Inspection & Testing Equipment

- Metallographic microscope
- Metallographic specimen grinder
- Universal testing machine
- Hardness tester
- Roughness tester
- Eddy current tester (ECT)
- Spectrometer (OES)
- Straightness tester
- Flaring tester
- Flattening tester
- Bending tester



STORAGE AND LOGISTICS

CBIES places great emphasis on quality control throughout the entire packaging and transportation process. Our storage team carefully inspects each product prior to packaging to ensure it is in good condition and ready for shipment.

CBIES strictly adheres to international packaging standards to ensure product safety and reduce the risk of damage during transportation. All packaging materials are recyclable and eco-friendly, helping minimize environmental impact.

We offer customized packaging services to meet specific customer needs, including product labeling, marking, folding, and packaging solutions that make it easier to identify and manage inventory. In addition,

we provide comprehensive transportation services to ensure timely and accurate delivery.

Door-to-door services don't stop at the harbor. CBIES has its own logistics department and freight forwarder that has established an efficient logistics infrastructure and organization across most global markets.

Our scale and presence create cost efficiencies in intercontinental shipping as well as in local customs clearance, warehousing, and road transportation services. We take care of last-mile logistics, can invoice on a DDP basis, and also provide 3PL (third-party logistics) services.



PRODUCTS AND APPLICATIONS



WELDED STEEL TUBES

Advantages

Equipment: KTM welding production line with consistent high-precision weld joint height and accommodates necking or expansion processes with a maximum deformation limit of 45%.

Internal tube weld joint residual height: Below 0.1 mm

Tolerance: Outer diameter tolerance is ± 0.1 mm, ellipticity is ± 0.03 mm.

We are skilled in special-shaped tubes and high-strength precision steel tubes.



Standards & Specifications

Round tube outer diameter: 8 – 254 mm

Rectangular tubes: 6x6 – 100x100 mm, 6x10 – 90x130 mm

For detailed standards and specifications, please refer to pages 24 – 26.

Applications

Automotive Seat Frame, Cross Car Beam, Chassis Parts, Motorcycle Frame, Rear Frame, Carrier Front, Fitness Equipment, Machinery, Medical & Healthcare Equipment, etc.

SEAMLESS STEEL TUBES

Standards & Specifications

OD: 6 – 254 mm

Thickness: 0.8 – 15.0 mm

Standard: EN 10305-1, EN 10305-4, DIN 2391, ASTM A519, GB/T3639

Materials: E215, E355, ST35, ST45, ST52, 4130, 4140, 10#, 20#, 35#, 45#

Delivery condition: Cold drawn, stress released, normalizing, annealed

ID tolerance: H8 – H9

Straightness: 0.2 – 0.5 mm/m

Inner roughness: Ra 0.2 – 0.8 μ m

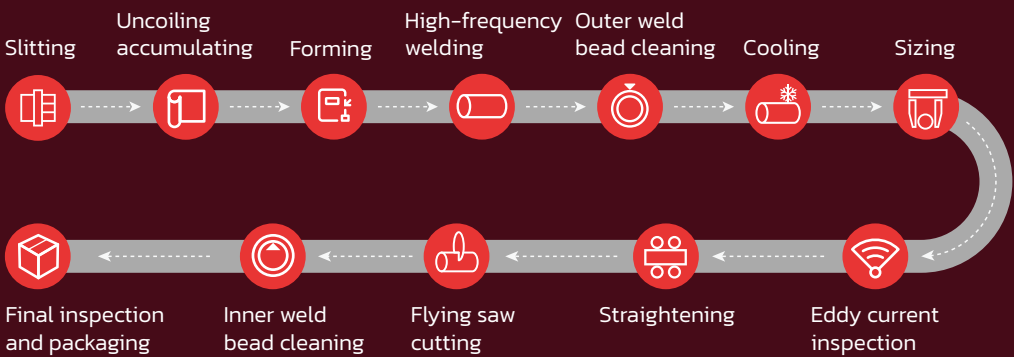
Processing method: Cold rolling, cold drawn-honed, deep hole boring-honed, deep hole boring-rolling



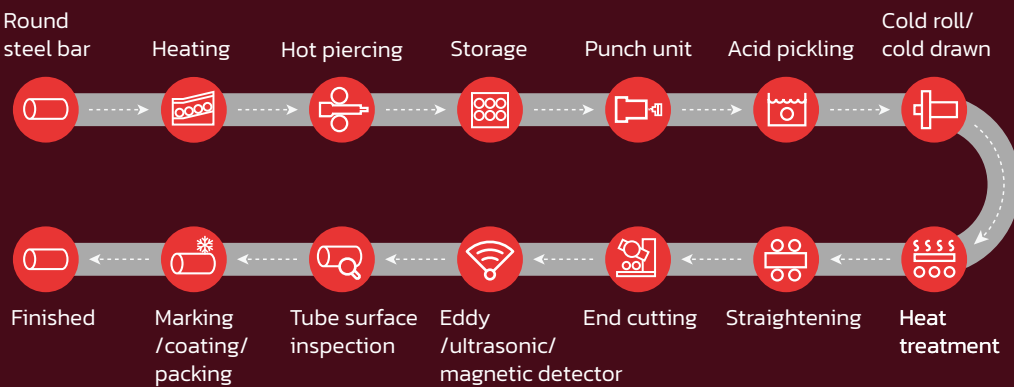
Applications

Automotive Side Impact Beam, Bush, Spring Holder, Hydraulic Cylinders, Pneumatic Cylinders, Mechanical Structure. Customers' special requirements will be upon discussion.

Process Flow



Process Flow



COLD DRAWN STEEL TUBES

Advantages

- Equipment:** Triple-line drawn machine unit
- Interior surface roughness:** Ra ≤0.4 μm
- Tolerance:** Outer diameter tolerance is ±0.03 mm.
- Tube straightness:** Within 0.5 mm/m
- We are skilled in special-shaped tubes and high-strength steel precision tubes.



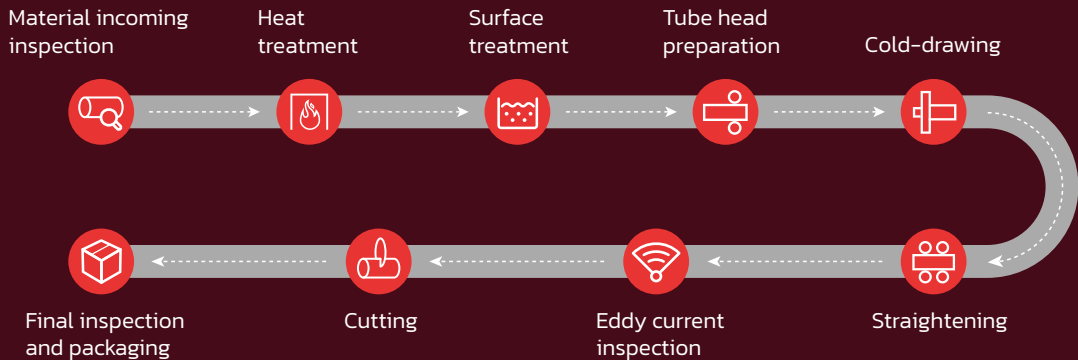
Standards & Specifications

- Round tube outer diameter:** 10 – 90 mm
- Wall thickness range:** 0.7 – 7.0 mm
- For detailed standards and specifications, please refer to pages 24 – 26.

Applications

Automotive Shock Absorber, Headrest Tubes, Gas Spring, Gas Cylinder, Costly Furniture, Motorcycle and Electric Vehicle Shock Absorber, and other precision parts.

Process Flow



HEAT-TREATED STEEL TUBES

ANNEALED TUBES

Process Highlights

- Annealing is performed to refine the microstructure, enhance uniformity, and improve formability and surface finish.
- CBIES adopts controlled-atmosphere furnaces and continuous annealing lines to guarantee stable quality and dimensional precision.



Specifications & Materials

- Tube diameter:** Ø12 – Ø102 mm
- Wall thickness range:** 0.8 – 10.0 mm
- Materials:** Carbon steel / Low-alloy steel / Stainless steel
- For detailed specifications, please refer to pages 25 – 26.

QUENCHED & TEMPERED TUBES

Process Highlights

- The quenching and tempering process integrates rapid cooling and subsequent heating to achieve high strength, fatigue resistance, and long-term stability.
- CBIES uses advanced temperature-control furnaces and real-time monitoring systems to ensure consistent mechanical performance and traceable quality records.

Specifications & Materials

- Tube diameter:** Ø19 – Ø45 mm
- Wall thickness range:** 1.0 – 5.0 mm
- Length:** 430 – 1500 mm
- Materials:** Boron alloy steel / Medium-carbon and higher-grade steels
- For detailed specifications, please refer to pages 25 – 26.



HIGH-STRENGTH PRECISION STEEL TUBES

Advantages

CBIES boasts extensive experience in the production of high-strength precision steel tubes, and covers a range of grades such as HC550/980DP, BR1200HS, BR1500HS, S550MS, 500/780DP, and CR1300T/1030Y.

With a view to meet lightweight requirements, we have designed and optimized the production lines that feature both high strength and precision.

We maintain close collaboration with major Chinese steel mills to supply high-strength steel raw materials that conform to a variety of stringent production standards.

Standards & Specifications

Round tube outer diameter: 20 – 60 mm

Square and rectangular tubes: 16x16 – 50x50 mm, 10x20 – 40x60 mm

Wall thickness range: 1.0 – 2.0 mm

For detailed standards and specifications, please refer to pages 24 – 26.

Applications

Automotive, Construction Machinery, Aerospace, Energy Equipment, and High-End Mechanical Manufacturing where high strength, precision, and reliability are required.



COATED STEEL TUBES

Advantages

Corrosion resistance: Long-term protection against oxidation, salt spray, and chemicals.

Surface quality: Smooth and uniform coating with excellent adhesion.

Processing performance: Excellent weldability, formability, and dimensional stability.

Thermal & structural reliability: Aluminium coating for high-temperature systems; zinc coating for structural applications.

Consistency: Automated coating and controlled furnaces ensure uniform thickness and stable performance.

Standards & Specifications

Round tube outer diameter: 8 – 152.4 mm

Rectangular tubes: 6x6 – 100x100 mm, 6x10 – 90x130 mm

For detailed standards and specifications, please refer to pages 24 – 26.

Applications

Automotive Exhaust and Structural Systems, Chassis and Seat Components, Battery Protection and Support Structures, Machinery and Industrial Equipment.



STAINLESS PRECISION STEEL TUBES

Advantages

High-Precision Manufacturing:

Adopts multiple welding technologies such as laser welding and TIG (argon arc) welding, ensuring smooth weld seams, high dimensional accuracy, and excellent consistency.

Material Selection:

Manufactured from premium stainless steel supplied by top-tier steel mills, providing outstanding oxidation resistance, high-temperature durability, and corrosion resistance for stable product performance.

Standards & Specifications

Round tube outer diameter: 8 – 254 mm

Wall thickness: 0.6 – 4.5 mm

Dimensional tolerance: In accordance with relevant production standards

For detailed standards and specifications, please refer to pages 24 – 26.

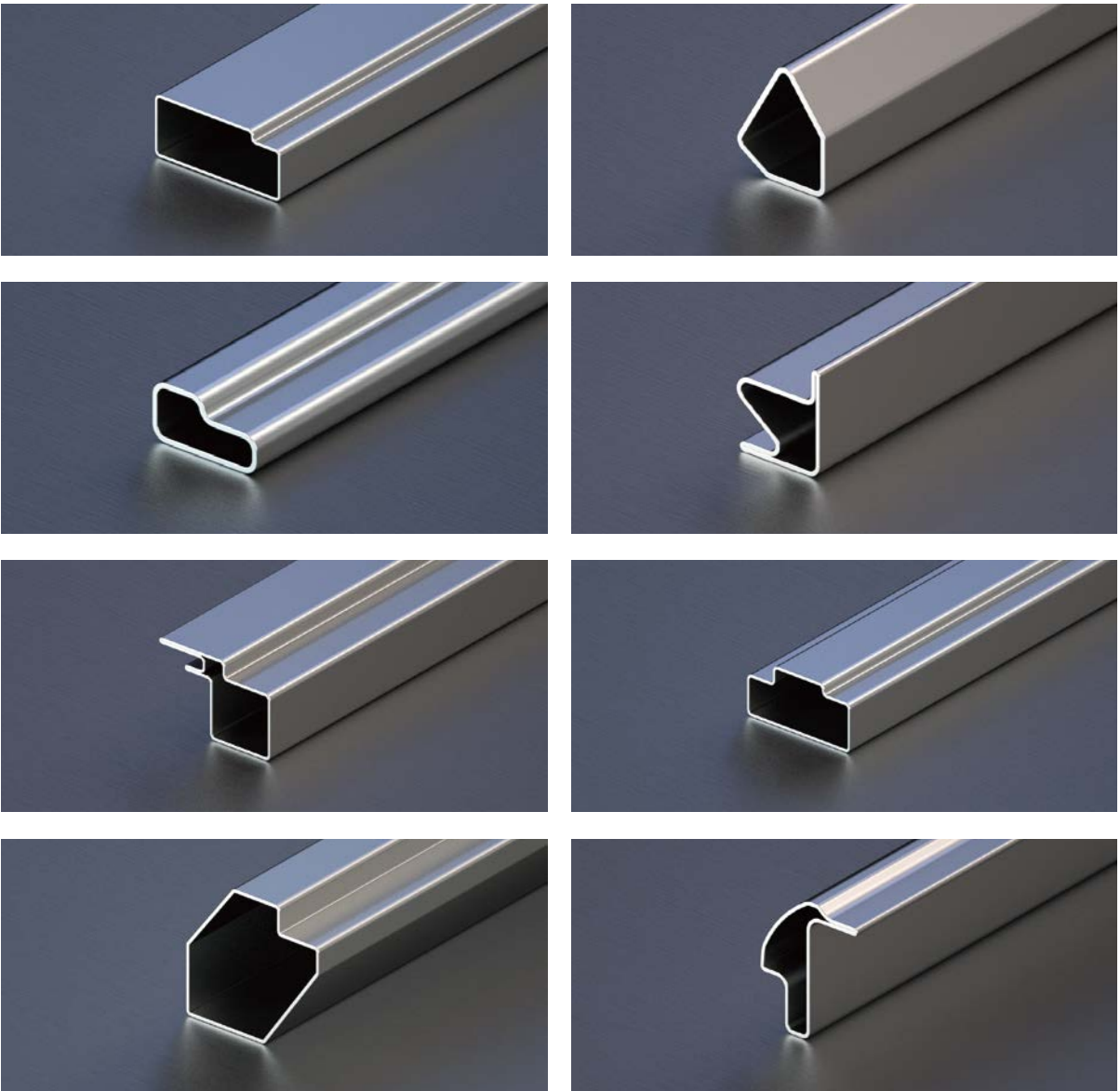
Applications

Widely used in Automotive Exhaust Systems, including Exhaust Pipes, Muffler Components, and Tailpipes.



SPECIAL-SHAPED STEEL TUBES

CBIES incorporates cold forming and cold bending techniques for strip steel, round tubes, and drawn parts into its process design to meet customer-specific requirements.



APPLICATION FIELDS

Mainly used in industries including Automotive, Truck and Bus, Motorcycle, Agriculture, Energy and Renewables, Defense and Aerospace, Electronics and Appliances, Earth-moving Equipment, Construction, Oil and Gas, Medical, Engineering and Industrial Applications, as well as Fitness Equipment.



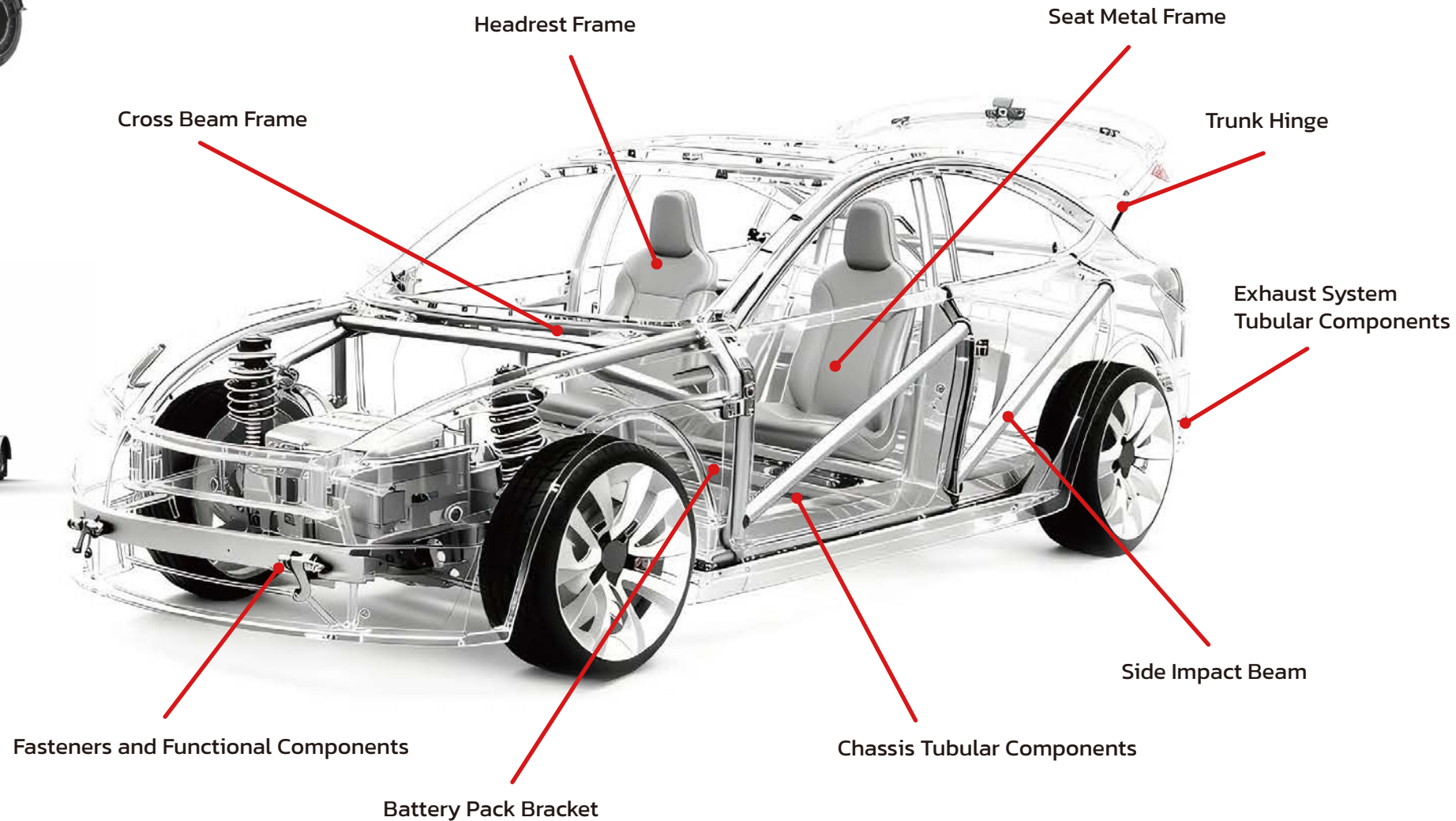
Motorcycle



Truck



Bus



Automotive



Medical



Fitness Equipment



Construction

STANDARDS AND SPECIFICATIONS

PRODUCTION STANDARDS

Standard	Standard Description
GB/T 13793	Steel pipes with a longitudinal electric (resistance) weld
GB/T 3639	Seamless cold-drawn or cold-rolled steel tubes for precision applications
GB/T 40316	Welded high-strength shaped and round steel tubes for automotive structures
EN 10088-2	Technical delivery conditions for sheet/plate and strip of corrosion resisting steels for general purposes
EN 10296-2	Welded circular steel tubes for mechanical and general engineering purposes
EN 10305-1	Seamless cold drawn tubes for precision applications
EN 10305-2	Welded cold drawn tubes for precision applications
EN 10305-3	Welded cold sized tubes for precision applications
EN 10305-4	Seamless tubes for hydraulic and pneumatic power systems
EN 10305-5	Welded cold sized square and rectangular tubes
DIN 2391-1	Seamless precision steel tubes – Part 1: Dimensions
DIN 2391-2	Seamless precision steel tubes – Part 2: Technical delivery conditions
DIN 2394-1	As-welded and sized precision steel tubes – Part 1: Dimensions
DIN 2394-2	As-welded and sized precision steel tubes – Part 2: Technical delivery conditions
ASTM A240 / A240M	Standard Specification for Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels and for General Applications
ASTM A268	Standard specification for seamless and welded ferritic stainless steel tubing for general service
ASTM A519	Standard specification for seamless carbon and alloy steel mechanical tubing
ASTM A513	Standard specification for electric-resistance-welded carbon and alloy steel mechanical tubing
ASTM A554	Standard specification for welded stainless steel mechanical tubing
JIS-G3445	Carbon steel tubes for machine structural purposes
JIS G3446	Stainless steel tubes for machine and structural purposes
JIS G4304	Hot-rolled stainless steel plate, sheet and strip

Note: Grades and standards can be customized upon request.

PRODUCTION SPECIFICATIONS

OD (mm)													
Type		Specification											
Round Tube 	8.00	9.50	10.00	11.00	11.85	12.00	12.30	12.70	13.00	13.50	14.00	15.00	15.90
	16.00	17.50	18.00	18.30	19.00	19.20	19.40	20.00	20.50	21.00	21.30	21.50	22.00
	22.20	23.00	23.42	23.70	23.80	24.00	24.70	25.00	25.40	26.00	26.75	27.00	27.50
	28.00	28.20	28.60	29.00	30.00	30.80	31.00	31.40	31.80	32.00	32.35	32.95	33.00
	33.30	34.00	35.00	35.50	36.00	37.00	38.10	39.00	40.00	41.00	41.30	42.00	42.70
	43.00	43.50	44.50	45.00	47.00	47.60	48.00	48.60	49.00	49.30	50.00	50.80	51.00
	51.20	52.00	53.00	54.00	55.00	57.00	60.00	60.50	61.00	63.50	65.00	68.00	70.00
	72.00	73.00	75.00	75.50	76.00	76.20	80.00	81.50	87.50	88.90	89.00	90.00	96.00
	100.00	101.60	104.00	110.00	114.00	120.00	125.00	127.00	133.00	152.40	177.80	203.20	254.00
Square Tube 	7.6*7.6	9*9	10*10	12.7*12.7	12.77*12.77	13*13	15*15	16*16	18*18	19*19	19.5*19.5	20*20	20.5*20.5
	21*21	21.4*21.4	22*22	25*25	25.4*25.4	28.6*28.6	30*30	31*31	31.75*31.75	33*33	35*35	38*38	40*40
	44.5*44.5	45*45	46*46	47.6*47.6	48*48	50*50	50.8*50.8	53*53	57.4*57.4	60*60	64*64	65*65	70*70
	50.8*50.8	75*75	76.2*76.2	90*90	100*100								
Rectangular Tube 	4*20	6*10	8*20	8.9*34.3	9.5*38.1	10*16	10*17.8	10*20	10*30	12*22	12*30	12.5*25	12.7*25.4
	12.7*31.8	12.7*38.1	12*30	12.7*50.8	13*19	13*26	14*20	14*21	14*24	14*32	14*34	15*25	15*30
	15*25	15.5*34.5	15.8*41.3	16*30	16*40	16.8*42.3	17*34	17*42	18*40	18.3*56.2	19*38	19.05*31.75	19.05*38.1
	20*25	20*30 (R=4.5)	20*35	20*40 (R=5)	20*50	20*60	20*75	20.3*58.2	21.8*47.2	22*32	23*53	24.1*22.4	24.9*20.4
	25*30	25*35	25*38	25*40 (R=5)	25*50	25*60 (R4)	25*62	25.4*31.8 (R3)	25.4*38	25.4*38.1	25.4*50.8	25.4*70	25.4*76.2
	26*40	26*50	27*80	29.5*80	30*40	30*45	30*50	30*55	30*60	30*70	30*80	30*90	31.8*50.8
	32*29	35*57	35*70	35*130	38*89	38*58	38.1*50.8	38.1*63.5	38.1*101.6	40*60	40*70	40*80	40*100
	41.2*46.5	41.5*48	41.5*50.8	44.5*69.85	44.5*50.8	45*50.3	45*75	50*30	50*70	50*75	50*80	50*100	50.8*76.2
	8*16	38.1*76.2	38.1*88.9	60*120	63.5*88.9	31.8*50	62.5*87.5	18*30	31.8*57.2 (R3)	44.5*50.8 (R=12.7)	44.5*101.6 (R=12.7)	90*130 (R=25.4)	
Flat Oval Tube 	10*24	10*25	11*22	12*18	13*36	15*26	15*30.5	15*50	15.5*44.5	15.5*45	16*35	17*40.1	20*40
	20*60	20*100	20*140	24.9*76.2	28*58	30*60	30*70	40*80	40*100	40*137	41.6*70	50*100	50*110
Oval Tube 	9*16	10*17	15*30	20*35	20*40	25*31	25*32	25.4*50.8	35.15*63.1	40.5*63.4	50*100	51.5*73.54	
Special-Shaped Tube	19.7*23.7	73.02*100.6	25.5*43.5	63.5*76.2	Octagonal Tube (two types)	Triangular Tube 60*87	40*76	40*73	25.4*55	25.8*25.8	41.2*46.5	44.5*101.6 (R=12.7)	90*130 (R=25.4)
	Peanut-shaped Tube (one type)	Inner Wrapped Tube (four types)	51.5	64.1	70.5	79.7	P-shaped Tube 50*100 	Baguette-shaped Tube (one type) 50.29*107	Hexagonal Tube (three types)	Corrugated Pipe (one type)	Octagon Tube (four types)	Sector-shaped Tube (one type)	Rounded-edge Square Tube (two types)
D-Shaped Tube	20*40												
Wall thickness range: 0.6–4.5 mm													
Note: Available according to customer requirements.													

GLOBAL SUPPORT CAPABILITIES

