

ABSTRACT

FLUX-CORED WIRE FOR Ar-CO₂ MIXED GAS SHIELDED ARC WELDING

A wire including, in terms of % by mass with respect to a total mass of the wire, as a total in a steel outer skin and a flux, 0.03 to 0.08% of C, 0.1 to 0.6% of Si, 1.2 to 2.5% of Mn, 0.01 to 0.5% of Cu, 0.5 to 1.5% of Ni, 0.05 to 0.5% of Ti, 0.002 to 0.015% of B, and 0.05% or less of Al, and further including, in the flux, 4 to 8% in terms of TiO₂, 0.1 to 0.6% of in terms of SiO₂, 0.02 to 0.3% in terms of Al₂O₃, 0.1 to 0.8% of Mg, 0.05 to 0.3% in terms of F, 0.05 to 0.3% in terms of Na and K in a fluorine compound, 0.05 to 0.2% of Na₂O and K₂O, and 0.2% or less in terms of ZrO₂.

[Figure 1]