

ABSTRACT

In a single-sided submerged arc welding method and device for joining two abutted steel plates by submerged arc welding from one surface side using a plurality of electrodes, at least one of the inter-electrode distances between adjacent electrodes is changed in the vicinity of the end side of the steel plates during the submerged arc welding. Thus, the method and device can be applied to steel plates with a wide range of plate thicknesses, rotational deformation suppressed, weld metal cracking at the joint end part prevented, and reworking after welding reduced.