

23
ABSTRACT

The purpose of the present invention is to provide a flux for submerged arc welding that is a fired flux, the flux being exceptional in terms of slab peelability, bead formation, and bead external appearance during high-speed welding in which a high current is used. In this flux for submerged arc welding, the total content amount of CaF_2 , MgO , Na_2O , and K_2O , as well as the content amounts of MnO , FeO , SiO_2 , Al_2O_3 , and TiO_2 , are within prescribed ranges. Furthermore, this flux for submerged arc welding satisfies the relationships $65 \leq (\text{MgO} + \text{SiO}_2 + \text{Al}_2\text{O}_3 + \text{TiO}_2) \leq 75$ and $0.5 \leq (\text{Al}_2\text{O}_3/\text{TiO}_2) \leq 2.0$.