

ABSTRACT

LOW HYDROGEN-BASED COVERED ELECTRODE

Provided is a low hydrogen-based covered electrode having excellent cracking resistance, strength and toughness of a weld metal, having good welding performance in all-position welding and having excellent moisture absorption resistance and adhesion of a covering, in welding of a high tensile steel having a 690 MPa or more class yield strength. The low hydrogen-based covered electrode includes a steel core wire coated with a covering, and in the covering, contents of a metal carbonate on a CO₂ basis, a metal fluoride on a F basis, TiO₂, ZrO₂, Al₂O₃, a Li compound on a Li basis, and a total of a Na compound on a Na basis and a K compound on a K basis, each based on a total mass of the low hydrogen-based covered electrode, are specified, and in the low hydrogen-based covered electrode, contents of a total of Mo and Cr, C, a total of Si and SiO₂ on a Si basis, Mn, and Ni, each based on the total mass of the low hydrogen-based covered electrode, are specified.

No Figure