CLAIMS

1. A low hydrogen-based covered electrode comprising a steel core wire coated with a covering,

wherein the covering contains, based on a total mass of the low hydrogen-based covered electrode,

a metal carbonate: 3.0% to 7.5% by mass on a $CO_2$ basis,

a metal fluoride: 0.9% to 3.0% by mass on a F basis,

$TiO_2 \leq 0.30\%$ by mass,

$ZrO_2$: 0.4% to 1.8% by mass,

$Al_2O_3 \leq 0.15\%$ by mass,

a Li compound: 0.01% to 0.12% by mass on a Li basis, and

a total of a Na compound on a Na basis and a K compound on a K basis: 0.30% to 0.90% by mass, and

the low hydrogen-based covered electrode contains, based on the total mass of the low hydrogen-based covered electrode,

a total of Mo and Cr: 0.06% to 1.20% by mass,

$C \leq 0.06\%$ by mass,

a total of Si and $SiO_2$: 1.5% to 3.0% by mass on a Si basis,

Mn: 0.9% to 2.7% by mass, and

Ni: 1.2% to 3.0% by mass.

2. The low hydrogen-based covered electrode according to claim 1, wherein the covering contains 1.2% by mass or more and 10.0% by mass or less of Fe based on the total mass of the low hydrogen-based covered electrode.

3. The low hydrogen-based covered electrode according to claim 1, wherein the metal carbonate contains a metal carbonate having a particle diameter of 75 μm or less in an amount of from 50% to 80% by mass based on a total mass of the metal carbonate.

4. The low hydrogen-based covered electrode according to claim 2, wherein the metal carbonate contains a metal carbonate having a particle diameter of 75 μm or less in an amount of from 50% to 80% by mass based on a total mass of the metal carbonate.

5. The low hydrogen-based covered electrode according to any one of claims 1 to 4, wherein a value of the following equation (1) is from 5 to 50.

$$(1.22\times[Na]+1.49\times[K])/[Li] \cdots (1)$$

wherein [Na] is a content (% by mass) of the Na compound on a Na basis in the covering, [K] is a content (% by mass) of the K compound on a K basis in the covering and [Li] is a content (% by mass) of the Li compound on a Li basis in the covering.