

ABSTRACT

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

A metallic flux-cored wire for Ar-CO₂ mixed gas shielded arc welding includes, 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, 0.1 to 0.2% of C, 0.5 to 1.8% of Si, 1.3 to 3.0% of Mn, 0.05 to 0.45% of Cu, and 0.005 to 0.015% of S, and further includes, in terms of % by mass with respect to the total mass of the wire, in the flux, 0.005 to 0.050% in terms of F in total, 0.01 to 0.20% of SiO₂, 0.02 to 0.15% in terms of Na₂O and K₂O in total, and 4.0 to 10.5% of iron powder.

[No Figure]