

ABSTRACT

Provided is a flux-cored wire for gas-shield arc welding of high tensile steel containing the following compositions in total of a steel sheath and flux, by mass % with respect to the total mass of the wire: 0.08 to 0.16% of C, 0.3 to 0.75% of Si, 1.2 to 2.1% of Mn, 0.15 to 0.45% of Cu, 0.8 to 3.0% of Ni, 0.35 to 0.65% of Cr, 0.2 to 0.6% of Mo, and 0.04 to 0.30% of Ti. The flux-cored wire for gas-shield arc welding of high tensile steel further contains the following compositions in the flux: 0.01 to 0.1% of the total amount of fluorine compound in terms of an F conversion value, 0.01 to 0.2% of SiO_2 , and 0.02 to 0.15% of the total amount of Na compound and K compound in terms of a Na_2O conversion value and a K_2O conversion value.

[No Figure]