

【DESCRIPTION】

【Invention Title】

GRAIN-ORIENTED ELECTRICAL STEEL SHEET AND MAGNETIC
DOMAIN REFINEMENT METHOD THEREFOR

5 【Technical Field】

A grain-oriented electrical steel sheet and a method for refining
magnetic domains therein are related.

【Background Art】

Since a grain-oriented electrical steel sheet is used as an iron core
10 material of an electrical device such as a transformer, in order to improve
energy conversion efficiency thereof by reducing power loss of the device, it is
necessary to provide a steel sheet having excellent iron loss of the iron core
material and a high occupying ratio when being stacked and spiral-wound.

The grain-oriented electrical steel sheet refers to a functional material
15 having a texture (referred to as a "GOSS texture") of which a secondary-
recrystallized grain is oriented with an azimuth $\{110\}<001>$ in a rolling direction
through a hot rolling process, a cold rolling process, and an annealing process.

A permanent magnetic domain refining method which shows the
improvement of the iron loss even after a stress relaxation heat treatment above
20 a heat treatment temperature where recovery occurs may be divided into an
etching method, a roll method, and a laser method. Since it is difficult to
control a groove shape because the grooves are formed on the surface of the
steel sheet by a selective electrochemical reaction in a solution, it is difficult to

uniformly secure the iron loss characteristics of the final product in the width direction. In addition, an acid solution used as a solvent has a disadvantage that it is not environmentally friendly.

The method of refining the permanent magnetic domain by the roll is a
5 technology of magnetic domain miniaturization partially generating recrystallized particles under the groove by forming and then annealing a groove having a constant width and depth on the surface of the plate by processing a protrusion shape on the roll to be pressed by the roll or the plate. The roll method is disadvantageous in stability in machine processing, reliability to obtain stable
10 iron loss depending on the thickness, and process complexity, and deterioration of the iron loss and the magnetic flux density characteristics immediately after the groove formation (before the stress relaxation annealing).

As the method of refining the permanent magnetic domain by a laser of a pulse and non-Gaussian mode forms a solidified alloy layer of the groove part
15 only at the side wall or does not uniformly form the groove on the entire surface of the groove when forming the groove, because of causing excessive deformation at the bottom part of the groove, it is difficult to apply to the process before the primary recrystallization process or after the primary recrystallization process and it has a drawback that it shows a deteriorated occupying ratio after
20 a final insulation coating. The grooving method by a continuous wave laser may form the solidified alloy layer entirely or partially, however it has a drawback that it is difficult to control the recrystallized particles' grain size in the heat treatment condition above the stress relaxation annealing through the thickness control of the solidified alloy layer.

【DISCLOSURE】

【Technical Problem】

A grain-oriented electrical steel sheet having an iron loss improvement
5 and a low magnetic flux density degradation rate characteristic after a heat
treatment and a method for refining a magnetic domain therein are provided.

【Technical Solution】

A grain-oriented electrical steel sheet according to an exemplary
embodiment of the present invention includes: a groove formed on a surface;
10 and a solidified alloy layer formed under the groove, wherein the solidified alloy
layer includes recrystallized particles of which an average particle diameter is
from 1 to 10 μm .

A grain-oriented electrical steel sheet according to another exemplary
embodiment of the present invention includes: a groove formed on a surface;
15 and a solidified alloy layer formed under the groove, wherein the solidified alloy
layer includes recrystallized particles of which an average particle diameter is
from 1 to 20 μm after stress relaxation annealing.

A thickness of the solidified alloy layer may be 0.6 to 3.0 μm .

A non-metallic oxide layer formed on the surface of the electrical steel
20 sheet may be further included.

The non-metallic oxide layer may include Mg_2SiO_4 , Al_2SiO_4 , or Mn_2SiO_4 .

An insulating coating layer formed on the non-metallic oxide layer may
be further included.

The groove may be linear and may be formed with an angle of 82° to 98° with respect to a rolling direction of the electrical steel sheet.

A depth D of the groove may be from 3 % to 8 % of the thickness of the electrical steel sheet.

5 A magnetic domain refining method of a grain-oriented electrical steel sheet according to an exemplary embodiment of the present invention includes: preparing a grain-oriented electrical steel sheet; irradiating a laser to a surface of the grain-oriented electrical steel sheet to form a groove; and quenching a portion where the groove is formed with a cooling speed of 400 to 1500 °C/s.

10 The quenching may be simultaneous quenching with the groove formation.

Stress relaxation annealing after the quenching may be further included.

In the groove forming, the laser may be a continuous wave laser having a Gaussian energy distribution and an output of 1 kW or more.

15 The laser may be a continuous wave laser that is a TEM₀₀ mode and has a beam quality factor M² of 1.0 to 1.1 and an output of 1 to 10 kW.

Removing a hill-up or a spatter formed on the electrical steel sheet surface after forming the groove may be further included.

20 Preparing the grain-oriented electrical steel sheet may include: forming an oxide layer on the surface of the steel sheet by decarburization-annealing or nitriding-annealing the cold-rolled steel sheet; and forming a non-metallic oxide layer on the surface of the steel plate by coating an annealing separator on the surface of the steel plate on which the oxidation layer is formed.

After forming the non-metallic oxide layer, forming an insulating coating

layer on the non-metallic oxide layer may be further included.

【Advantageous Effects】

According to one embodiment of the present invention, the magnetic flux density degradation due to permanent magnetic domain refining may be reduced and the iron loss improvement rate may be increased.

Also, according to one embodiment of the present invention, it may be used as a stacked iron core transformer and a wound iron core transformer iron core requiring a heat treatment after the final insulation coating.

【Description of the Drawings】

FIG. 1 is a schematic view of a grain-oriented electrical steel sheet according to an exemplary embodiment of the present invention.

FIG. 2 is a cross-sectional schematic view of a grain-oriented electrical steel sheet according to an exemplary embodiment of the present invention.

FIG. 3 is a cross-sectional schematic view of a grain-oriented electrical steel sheet according to another exemplary embodiment of the present invention.

FIG. 4 is a cross-sectional schematic view of a grain-oriented electrical steel sheet according to another exemplary embodiment of the present invention.

【Mode for Invention】

The terms "first", "second", and "third" are used herein to explain various

parts, components, regions, layers, and/or sections, but it should be understood that they are not limited thereto. These terms are used only to discriminate one portion, component, region, layer, or section from another portion, component, region, layer, or section. Thus, a first portion, component, region, layer, or section may be referred to as a second portion, component, region, layer, or section without departing from the scope of the present invention.

The technical terms used herein are to simply mention a particular embodiment and are not meant to limit the present invention. An expression used in the singular encompasses the expression of the plural, unless it has a clearly different meaning in the context. The term 'including' used herein embodies concrete specific characteristics, regions, positive numbers, steps, operations, elements, and/or components, without limiting existence or addition of other specific characteristics, regions, positive numbers, steps, operations, elements, and/or components.

It will be understood that when an element such as a layer, film, region, or substrate is referred to as being "on" or "above" another element, it can be directly on or above the other element or intervening elements may also be present. In contrast, when an element is referred to as being "directly on" another element, there are no intervening elements therebetween.

If not defined differently, all the terminologies including technical terminologies and scientific terminologies used herein have meanings that are the same as ones that those skilled in the art generally understand. The terms defined in dictionaries should be construed as having meanings corresponding to the related prior art documents and those stated herein, and are not to be

construed as being ideal or official, if not so defined.

Hereinafter, exemplary embodiments of the present invention will be described in detail so as to be easily practiced by a person skilled in the art to which the present invention pertains. As those skilled in the art would realize,
5 the described embodiments may be modified in various different ways, all without departing from the spirit or scope of the present invention.

FIG. 1 shows a schematic view of a grain-oriented electrical steel sheet 10 according to an exemplary embodiment of the present invention. As shown in Fig. 1, a plurality of grooves 20 are formed along a rolling direction on the
10 surface of the grain-oriented electrical steel sheet 10.

FIG. 2 shows a cross-sectional schematic view of a grain-oriented electrical steel sheet 10 according to an exemplary embodiment of the present invention. As shown in FIG. 2, the grain-oriented electrical steel sheet 10 according to an exemplary embodiment of the present invention includes the
15 groove 20 formed on the surface and a solidified alloy layer 30 formed under the groove 20, and the solidified alloy layer 30 includes recrystallized particles 31 having an average particle diameter of 1 to 10 μm . In an exemplary embodiment of the present invention, by controlling the size of the recrystallized particles 31 in the solidified alloy layer 30, although a heat treatment above a
20 recrystallization temperature such as a stress relaxation annealing is applied, an improvement effect of the iron loss may be obtained even after stress relaxation annealing as a recrystallized grain is grown in the solidified alloy layer 30 and into the base. The average particle diameter of the recrystallized particles 31 may be 1 to 10 μm . If the average particle diameter of the

recrystallized particles 31 is too small, the magnetic flux density degradation rate is increased due to the increase in the semi-magnetic field. If the average particle diameter of the recrystallized particles 31 is too large, due to the reduction of the semi-magnetic field, the iron loss improvement rate is decreased and the magnetic flux density degradation rate is increased. More specifically, the average particle diameter of the recrystallized particles 31 may be in a range of 2 to 7 μm .

FIG. 3 shows a cross-section of the grain-oriented electrical steel sheet 10 according to another exemplary embodiment of the present invention. When the grain-oriented electrical steel sheet 10 in FIG. 2 described above is heat-treated above the recrystallization temperature such as in the stress relaxation annealing, the recrystallized grain is grown in the inner part of the solidified alloy layer 30, and the base portion and recrystallized particles 32 are formed after the stress relaxation annealing. The recrystallized particles 32 formed after the stress relaxation annealing may have an average particle diameter of 1 to 20 μm .

The solidified alloy layer 30 is formed during laser irradiation for refining the magnetic domain. The thickness of the solidified alloy layer 30 may be between 0.6 and 3.0 μm . When the thickness of the solidified alloy layer 30 is very thin, since the recrystallized particles 31 in the solidified alloy layer 30 are not grown to the base portion in which the secondary recrystallization occurs, the iron loss improvement effect by the recrystallized particles 31 does not occur, and when the thickness of solidified alloy layer 30 is too thick, the recrystallized particles 32 are formed, but the recrystallized particles 32 after

stress relaxation annealing are also formed at the lower portion, the side portion, and the base portion by a heat effect, and accordingly the magnetic flux density deterioration may become remarkable.

As shown in FIG. 4, a non-metallic oxide layer 40 may be formed on the surface of the steel plate 10. When the non-metallic oxide layer 40 is formed, a laser absorption rate is increased by 30 % or more compared to that of the steel plate in which the non-metallic oxide layer 40 is not formed when irradiating the laser, so the grooves 20 may be formed with relatively low energy density, and the linear grooves 20 may be formed with a high irradiation speed.

Accordingly, a laser output required for forming the groove 20 is reduced by 20 % or more for the steel plate on which the non-metallic oxide layer 40 is formed compared with the steel plate on which the non-metallic oxide layer 40 is not formed, thereby increasing the efficiency in improving the iron loss.

In addition, when the non-metallic oxide layer 40 is formed on the surface of the steel plate, the non-metallic oxide layer is physically and chemically solid-bonded to the steel plate surface and is not easily damaged by thermal impact by laser irradiation.

Preferably, the non-metallic oxide layer 40 is formed on the surface of the steel plate with a thickness of 1 to 20 μm . If the thickness of the non-metallic oxide layer 40 is too thin, the effect of increasing the laser absorption rate is low and the non-metallic oxide layer may be destroyed by the thermal impact during the laser irradiation, and if the thickness of the non-metallic oxide layer 40 is too thick, there is drawback that it is difficult to control the process conditions for forming the non-metallic oxide layer 40 and the laser output for

forming the groove 20 is increased.

The non-metallic oxide layer 40 may comprise Mg_2SiO_4 , Al_2SiO_4 , or Mn_2SiO_4 .

5 An insulating coating layer 50 may be formed on the non-metallic oxide layer 40.

The depth D of groove 20 may be 3 % to 8 % of the thickness of the electrical steel sheet. More specifically, it may be 4 % to 8 %. If it is less than 3 %, the groove of an appropriate depth for improving the iron loss is not formed. If it exceeds 8%, a heat affected part may increase and the growth of the Goss
10 texture may have an adverse effect.

In addition, the groove 20 may be formed at 82° to 98° with respect to the rolling direction of the electrical steel sheet. By forming the groove 20 in an oblique shape not including 90 degrees, the semi-magnetic field may be weakened, thereby improving the magnetism.

15 The grooves 20 may be formed intermittently from 2 to 10 pieces in the width direction of the steel plate.

The magnetic domain refining method of the grain-oriented electrical steel sheet according to an exemplary embodiment of the present invention includes: preparing the grain-oriented electrical steel sheet; irradiating a laser to
20 the surface of the grain-oriented electrical steel sheet to form the groove; and quenching the part where the groove is formed at a cooling speed of 400 to 1500 °C/s. Hereinafter, each step is described in detail.

First, the grain-oriented electrical steel sheet is prepared.

The preparation of the grain-oriented electrical steel sheet may include:

decarbonizing or nitriding a cold-rolled electrical steel sheet to form an oxidation layer on the surface of the steel plate; and coating an annealing separator on the surface of the steel plate on which the oxidation layer is formed and annealing at a high temperature to form a non-metallic oxide layer on the surface of the steel plate.

Generally, the cold-rolled steel sheet may be produced by subjecting a slab containing 1 to 7 % by weight of Si to hot rolling, hot-rolled sheet annealing, and cold rolling. Since the non-metallic oxide layer is the same as described above, repeated description is omitted.

In an exemplary embodiment of the present invention, the magnetic domain refining may be performed directly on the surface of the steel plate, or the non-metallic oxide may be formed on the surface of the steel plate, magnetic domain refining and then the laser may be irradiated to perform the magnetic domain refining, and an insulating coating layer may be additionally formed on the surface of the steel plate by coating and heat-treating an insulating coating liquid including colloidal silica and a metal phosphate on the non-metallic oxide layer and then the laser may be irradiated to perform the magnetic domain refining. If the non-metallic oxide layer is formed on the surface of the steel plate, this layer may increase the laser absorption rate and form the groove with relatively low energy density.

Next, the surface of the grain-oriented electrical steel sheet is irradiated with the laser to form the groove.

At this time, the laser may be a continuous wave laser having a Gaussian energy distribution and an output of 1 kW or more. This continuous

wave laser is suitable for forming the uniform groove on the electrical steel sheet surface after the secondary recrystallization is completed. More specifically, the laser is a TEM₀₀ mode, and may be a continuous wave laser of which a beam quality factor M2 is 1.0 to 1.1 and the output is 1 to 10 kW.

- 5 Since forming grooves with a gasify only by the laser irradiation does not form the solidified alloy layer, the method of forming the groove using the laser with too high an output is not preferable.

A step of removing a hill-up or a spatter formed on the electrical steel sheet surface after the step of forming the groove may be further included.

- 10 The heel-up means that a fusion material generated during the groove formation has risen to the both tops of the groove, and the spatter is formed by scattering of the fusion material. The hill-up and the spatter may be removed by brushing or pickling.

- Next, the portion where the groove is formed is quenched at a cooling speed of 400 to 1500 °C/s. In an exemplary embodiment of the present invention, the size of the recrystallized particles in the solidified alloy layer may be controlled by controlling the cooling speed. Specifically, the average particle diameter of the recrystallized particles in the solidified alloy layer may be controlled from 1 to 10 μm by controlling the cooling speed from 400 to 1500 °C/s. More specifically, the cooling speed may be adjusted from 500 to 1200 °C/s.
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The quenching method is not particularly limited, and an air cooling method above the laser irradiation may be used. The quenching steps may be done simultaneously with the groove formation.

After the quenching, the stress relaxation annealing may be further included. In case of the heat treatment above the recrystallization temperature such as the stress relaxation annealing in an exemplary embodiment of the present invention, the recrystallized grain grows in the solidified alloy layer and
5 to the base portion such that recrystallized particles are formed after the stress relaxation annealing. The recrystallized particles after the stress relaxation annealing may have the average particle diameter of 1 to 20 μm .

In this heat treatment condition above the recrystallization temperature after the formation of the solidified alloy layer, the recrystallized particle
10 formation after the stress relaxation annealing may achieve an improvement effect of the iron loss of 2 % or more and simultaneously a magnetic flux density degradation rate of 1.0 % or less.

Hereinafter, the present invention is described in more detail through an example. However, this example is merely to illustrate the present invention,
15 and the present invention is not limited thereto.

Example

The grain-oriented electrical steel sheet of the cold-rolled thickness of 0.30 mm is decarburization-annealed to form the oxidation layer, the annealing separator including MgO is coated, and the high temperature annealing is
20 performed to form a forsterite film. Thereafter, the insulating coating liquid containing the colloidal silica and the metal phosphate is coated to form the insulating coating layer.

That laser that is a TEM₀₀ mode and has the beam quality factor of M^2 of 1.0 is irradiated to the electrical steel sheet surface by controlling the output to

1.8 kW. In a case of Comparative Example 2 of Table 2, a pulse laser that is not a continuous wave laser is used. During the laser irradiation, the cooling speed is adjusted as shown in the following table through the air cooling. After the magnetic domain refinement treatment, the stress annealing is performed.

5 The groove depth, the solidified alloy layer thickness, the average particle diameter of the recrystallized particles in the solidified alloy layer, and the recrystallized particle average particle diameter of the stress annealing are summarized in Table 1 and Table 2.

(Table 1)

	Groove depth (μm)	Solidified alloy layer thickness (μm)	Recrystallized particles average particle diameter (μm)	Recrystallized particles average particle diameter after stress annealing (μm)	Before laser irradiation	After laser irradiation	After heat treatment stress annealing	Iron loss improvement rate (%)	Magnetic flux density degradation rate (%)
					$W_{17/50}/B_8$				
Example (continuous wave / cooling)	9	0.6	6	8	0.96/1.92	0.86/1.91	0.83/1.91	3.5	0.0
				9	0.97/1.92	0.86/1.91	0.84/1.91	2.3	0.0
	9	3.0	9	13	0.97/1.92	0.87/1.91	0.82/1.90	5.7	-0.5
				15	0.96/1.92	0.86/1.91	0.81/1.90	5.8	-0.5

speed 500°C /s)	18	0.6	5	9	0.96/ 1.92	0.85/ 1.91	0.81/ 1.90	2.4	-0.5
				10	0.96/ 1.92	0.86/ 1.91	0.82/ 1.91	2.3	0.0
		3.0	7	14	0.97/ 1.92	0.85/ 1.90	0.82/ 1.89	3.5	-0.5
				16	0.96/ 1.92	0.87/ 1.91	0.83/ 1.90	4.6	-0.5

(Table 2)

	Gr oo ve de pth (μ m)	Soli difie d allo y laye r thic kne ss (μm)	Recry stalliz ed particl e avera ge particl e diamet er (μm)	Recry stalliz ed particl e avera ge particl e diamet er after stress	Befo re lase r irrad iatio n	After lase r irrad iatio n	Afte r stre ss ann eali ng heat treat men t	Iron loss impro veme nt rate (%)	Magn etic flux densi ty degra datio n rate (%)	Occ upyi ng ratio (%)
					W _{17/50} /B ₈					

				annealing (μm)						
Example (continuous wave/cooling speed . 500 °C/s)	15	3.0	7.0	11	0.97 /1.9 2	0.85 /1.9 0	0.82 /1.9 0	3.5	0.0	97.2
				12	0.97 /1.9 2	0.85 /1.9 0	0.82 /1.9 0	2.4	0.0	97.1
Example (continuous wave/cooling speed . 1200	15	0.6	2.0	9	0.97 /1.9 2	0.85 /1.9 0	0.81 /1.9 0	4.7	0.0	97.3
				9	0.97 /1.9 2	0.84 /1.9 0	0.80 /1.9 0	5.9	0.0	97.4

°C/s)										
Comp arativ e Exam ple 1 (conti nuous wave/ cooling speed . 300 °C/s)	15	3.5	8.7	21	0.97 /1.9 2	0.93 /1.8 9	0.93 /1.8 7	0.0	-1.05	95.1
				22	0.96 /1.9 2	0.92 /1.8 9	0.92 /1.8 7	0.0	-1.05	95.2
Comp arat ive Exa mpl e 2 (Puls e Las	15	0.3	No format ion	-	0.97 /1.9 2	1.01 /1.8 7	1.01 /1.8 5	0.0	-1.06	94.8
				-	0.96 /1.9 2	0.99 /1.8 6	0.99 /1.8 5	0.0	-0.53	94.7

er/ cooling speed 500 °C/ s)										
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In Table 1 and Table 2, the iron loss improvement rate is calculated by $(W_1 - W_2)/W_1$ by measuring the iron loss W_1 of the electrical steel sheet before the groove is formed by the laser irradiation and the iron loss W_2 after forming the groove by the laser irradiation. The magnetic flux density degradation rate is calculated by $(B_2 - B_1)/B_1$ by measuring the magnetic flux density B_1 of the electrical steel sheet before the groove is formed by the laser irradiation and the magnetic flux density B_2 after forming the groove by the laser irradiation. The occupying ratio as a weight ratio of the steel plate corresponding to an actual volume for a theoretical volume under a 5 MPa pressure is measured by a method of JIS C 2550-2000.

As shown in Table 1 and Table 2, in an example in which the continuous wave laser is used and the cooling speed is appropriately adjusted, it may be confirmed that the recrystallized particles are formed with the appropriate size in the solidified alloy layer, the iron loss improvement rate and the magnetic flux density degradation rate are excellent, and the iron loss and the magnetic flux

density are excellent even after the stress annealing heat treatment.

Although exemplary embodiments of the present invention were described with reference to the accompanying drawings, the present invention is not limited to the exemplary embodiments and may be modified in various ways. Further, it would be understood that the present invention may be implemented in other detailed ways by those skilled in the art without the scope and necessary components of the present invention being changed. Therefore, the embodiments described above are only examples and should not be construed as being limitative in all respects.

10 **<Description of symbols>**

10: electrical steel sheet

20: groove

30: solidified alloy layer

31: recrystallized particles

32: recrystallized particles after stress annealing 40: non-metallic oxide

layer

15 50: insulating coating layer

【CLAIMS】

【Claim 1】

A grain-oriented electrical steel sheet comprising:
a groove formed on a surface of an electrical steel sheet; and
a solidified alloy layer formed under the groove,
wherein the solidified alloy layer includes recrystallized particles of which an average particle diameter is from 1 to 7 μm .

【Claim 2】

A grain-oriented electrical steel sheet comprising:
a groove formed on a surface of an electrical steel sheet; and
a solidified alloy layer formed under the groove,
wherein the solidified alloy layer includes recrystallized particles of which an average particle diameter is from 1 to 20 μm after stress relaxation annealing.

【Claim 3】

The grain-oriented electrical steel sheet of claim 1 or claim 2, wherein
a thickness of the solidified alloy layer is 0.6 to 3.0 μm .

【Claim 4】

The grain-oriented electrical steel sheet of claim 1 or claim 2, further comprising

a non-metallic oxide layer formed on the surface of the electrical steel sheet.

【Claim 5】

The grain-oriented electrical steel sheet of claim 4, wherein
the non-metallic oxide layer includes Mg_2SiO_4 , Al_2SiO_4 , or Mn_2SiO_4 .

【Claim 6】

The grain-oriented electrical steel sheet of claim 4, further comprising
an insulating coating layer formed on the non-metallic oxide layer.

【Claim 7】

The grain-oriented electrical steel sheet of claim 1 or claim 2, wherein
the groove is linear and is formed at an angle of 82° to 98° with respect to a
rolling direction of the electrical steel sheet.

【Claim 8】

The grain-oriented electrical steel sheet of claim 1 or claim 2, wherein
a depth D of the groove is from 3 % to 8 % of the thickness of the electrical
steel sheet.

【Claim 9】

A magnetic domain refining method of a grain-oriented electrical steel sheet,

comprising:

preparing a grain-oriented electrical steel sheet;

irradiating a laser to a surface of the grain-oriented electrical steel sheet to form a groove; and

quenching a portion where the groove is formed with a cooling speed of 400 to 1500 °C/s.

【Claim 10】

The magnetic domain refining method of the grain-oriented electrical steel sheet of claim 9, wherein

the quenching is simultaneous quenching with the groove formation.

【Claim 11】

The magnetic domain refining method of the grain-oriented electrical steel sheet of claim 9, further comprising,

after the quenching,

stress relaxation annealing.

【Claim 12】

The magnetic domain refining method of the grain-oriented electrical steel sheet of claim 9, wherein,

in the forming of the groove,

the laser is a continuous wave laser having a Gaussian energy distribution

and an output of 1 kW or more.

【Claim 13】

The magnetic domain refining method of the grain-oriented electrical steel sheet of claim 12, wherein

the laser is a continuous wave laser that is a TEM₀₀ mode and has a beam quality factor of M^2 of 1.0 to 1.1 and output of 1 to 10 kW.

【Claim 14】

The magnetic domain refining method of the grain-oriented electrical steel sheet of claim 9, further comprising

removing a hill-up or a spatter formed on the electrical steel sheet surface after forming the groove.

【Claim 15】

The magnetic domain refining method of the grain-oriented electrical steel sheet of claim 9, wherein

the preparing the grain-oriented electrical steel sheet includes:

forming an oxide layer on the surface of the steel sheet by decarburization-annealing or nitriding-annealing the cold-rolled steel sheet; and

forming a non-metallic oxide layer on the surface of the steel plate by coating an annealing separator on the surface of the steel plate on which the oxidation layer is formed.

【Claim 16】

The magnetic domain refining method of the grain-oriented electrical steel sheet of claim 15, further comprising,

after forming the non-metallic oxide layer,

forming an insulating coating layer on the non-metallic oxide layer.