

UniFuse™ SS316L 60µm 400W Performance

· Laser Powder Bed Fusion 3D printing

Chemical composition:

Elements	Fe [wt.-%]	Cr [wt.-%]	Mn [wt.-%]	C [wt.-%]	Si [wt.-%]	Ni [wt.-%]	N [wt.-%]	S [wt.-%]	P [wt.-%]
Min	Bal. / Rest	16.0	0.00	0.00	0.00	10.0	0.00	0.00	0.00
Max	Bal. / Rest	18.0	2.0	0.030	1.0	14.0	0.10	0.03	0.045

Powder Properties:

Density (g/cm³)

Tap Density	6.08 g/cm ³ ± 0.15
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Typical properties at nominal density and nominal composition:

Coupon type: ASTM E8-21

Material properties ¹⁾	Symbol	As built
Density [g/cm ³] ²⁾	ρ	7.99 – 8.0
Density [%] ²⁾	%	99.9 – 100.0
Porosity [%] ²⁾	p	0.0 – 0.1
Ultimate Tensile Strength [MPa] ^{3) 4)}	R _{m xy-bar}	699 ± 62
	R _{m z-bar}	670 ± 11
Yield Strength [MPa] ^{3) 4)}	R _{p0.2 xy-bar}	561 ± 50
	R _{p0.2 z-bar}	507 ± 30
Fracture Elongation [%] ^{3) 4)}	A xy-bar	55.7 ± 1.5
	A z-bar	52.3 ± 3.3
Surface roughness in z-direction [µm] ^{5) 6)}	R _a	10.1 ± 1.1

Remarks:

1) Properties are given for the laser melted product printed at 60µm layer thickness. Auxiliary operations, e.g., heat treatments, surface modifications, coating processes, bead blasting, etc. may influence the displayed properties. Error values provided with a +/- are given to one standard deviation for printing within machine and environmental specifications.

2) The indicated density limits are valid for the mean density of a component. For complex and geometrically unfavorable shapes the local segment density can deviate from these limits and therefore materials properties may be affected.

3) Materials properties stated in the table above have been determined on the basis of ASTM E8-21.

4) All mechanical characteristics are typical mean values valid only for the indicated nominal density level, and will vary from printer to printer.

5) Roughness measurement according to microscopy in accordance with DIN EN ISO 4287.

6) Surface roughness value is dependent on the gas flow characteristics of the machine.