SLM SOLUTIONS

1.2709

ASTM A646

MATERIAL DATA SHEET

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MATERIAL

Tool steels are (by definition) used for tooling applications and require a high wear resistance, high hardness, and sufficient ductility. Depending on the media being processed, the martensitic 1.2709 adds additional corrosion resistance. Regarding post-processing, a variety of heat-treatments can be performed before machining and polishing. Besides tools and inserts, actual components with excellent strength for aerospace and automotive are main focus of 1.2709.

CHEMICAL COMPOSITION

ASTM A646[1]	Fe	Ni	Co	Mo	Ti	Al	Mn	Si	C	P	S
Min.	Bal.	18.00	8.50	4.70	0.50	0.05					
Max.	Bal.	19.00	9.50	5.20	0.80	0.15	0.10	0.10	0.03	0.01	0.01

POWDER PROPERTIES

Particle Size[1]	20 - 63 µm
Mass Density[2]	≈ 8.0 g/cm³
Particle Shape[3]	Spherical

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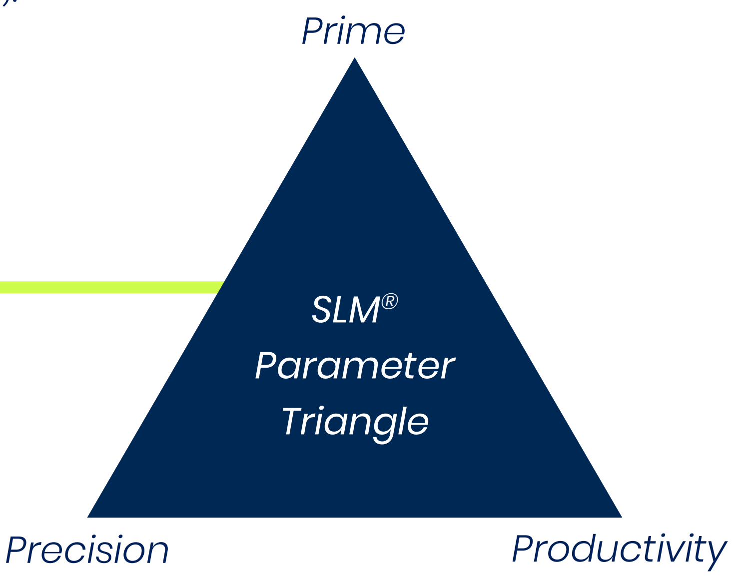
SLM® PARAMETERS

It only takes 3 tools to make you successful with metal additive manufacturing:

1. The **SLM® machine** fitting your needs,
2. The **metal powder** that defines the later purpose and functionality of a part,
3. Precisely engineered **SLM® parameters** as the missing link.

Our open parameters are the result of our vast experience in multi-laser technology and a diligent development and qualification procedure. They are key to produce fully functional parts with properties you can expect and rely on – whether you are new to AM or a large-scale production operator. We offer them in three categories to you: from high-resolution complex details (**Precision**) up to the highest build rates (**Productivity**) or right in between (**Prime**).



MATERIAL QUALIFICATION

As one of the inventors of the selective laser melting process, we impose the most comprehensive test procedures on ourselves: hundreds of samples, multiple systems, various powder batches, numerous heat-treatments, machined vs. near-net-shape tensile specimens, several surface roughness conditions and angles, fatigue behavior, corrosion investigation, creep testing... Did we miss anything? Get in touch with us!

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PRECISION

Parameter Set	1.2709_PREC_MBP3_V1.0 (30 µm, 400 W)
Validated Data Preparation	Materialise SLM Build Processor
Theoretical System Build Rate[4]	10.4 cm³/h
Minimum Relative Density[5]	99.8 %

Mechanical Properties[6]

M: Mean | SD: Standard deviation

Non-heat-treated (NHT)

	Tensile strength R_m [MPa]		Yield strength $R_{p0.2}$ [MPa]		Elongation at break A [%]	
Machined	M	SD	M	SD	M	SD
Horizontal	1190	20	1000	10	14	5
Vertical	1215	20	1080	15	10	2

Heat-treated (HT1)[7]

	Tensile strength R_m [MPa]		Yield strength $R_{p0.2}$ [MPa]		Elongation at break A [%]	
Machined	M	SD	M	SD	M	SD
Horizontal	2040	20	1965	10	8	2
Vertical	2115	20	1940	20	4	2

Hardness[8]

M: Mean | SD: Standard Deviation

	Vickers hardness HV10	
	M	SD
NHT	355	10
HT1[7]	610	5

Surface Roughness[9]

M: Mean | SD: Standard Deviation

	Roughness average Ra [µm]		Mean roughness depth Rz [µm]	
	M	SD	M	SD
As built	7	1	45	5
Corundum	6	2	41	4

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PRIME

Parameter Set	1.2709_PRIM_MBP3_V1.0 (50 µm, 400 W)
Validated Data Preparation	Materialise SLM Build Processor
Theoretical System Build Rate[4]	15.3 cm³/h
Minimum Relative Density[5]	99.6 %

Mechanical Properties[6]

M: Mean | SD: Standard deviation

Non-heat-treated (NHT)

	Tensile strength R_m [MPa]		Yield strength $R_{p0.2}$ [MPa]		Elongation at break A [%]	
Machined	M	SD	M	SD	M	SD
Horizontal	1175	20	965	25	14	5
Vertical	1175	25	970	35	12	2

Heat-treated (HT1)[7]

	Tensile strength R_m [MPa]		Yield strength $R_{p0.2}$ [MPa]		Elongation at break A [%]	
Machined	M	SD	M	SD	M	SD
Horizontal	1940	35	1790	35	6	2
Vertical	2025	30	1980	25	5	2

Hardness[8]

M: Mean | SD: Standard Deviation

	Vickers hardness HV10	
	M	SD
NHT	340	22
HT1[7]	575	10

Surface Roughness[9]

M: Mean | SD: Standard Deviation

	Roughness average Ra [µm]		Mean roughness depth Rz [µm]	
	M	SD	M	SD
As built	9	1	67	5

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PRODUCTIVITY

Parameter Set	1.2709_PROD_MBP3_V1.0 (60 µm, 400 W)
Validated Data Preparation	Materialise SLM Build Processor
Theoretical System Build Rate[4]	24.6 cm³/h
Minimum Relative Density[5]	99.3 %

Mechanical Properties[6]

M: Mean | SD: Standard deviation

Non-heat-treated (NHT)

	Tensile strength R_m [MPa]		Yield strength $R_{p0.2}$ [MPa]		Elongation at break A [%]	
Machined	**M**	**SD**	**M**	**SD**	**M**	**SD**
Horizontal	1170	20	935	25	13	5
Vertical	1095	40	945	55	11	5

Heat-treated (HT1)[7]

	Tensile strength R_m [MPa]		Yield strength $R_{p0.2}$ [MPa]		Elongation at break A [%]	
Machined	**M**	**SD**	**M**	**SD**	**M**	**SD**
Horizontal	1975	20	1890	5	6	2
Vertical	1980	20	1920	20	4	2

Hardness[8]

M: Mean | SD: Standard Deviation

	Vickers hardness HV10	
	M	**SD**
HT1[7]	550	6

Surface Roughness[9]

M: Mean | SD: Standard Deviation

	Roughness average Ra [µm]		Mean roughness depth Rz [µm]	
	M	**SD**	**M**	**SD**
As built	10	2	61	10
Corundum	5	2	35	11

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DISCLAIMER

The properties and mechanical characteristics apply to powder that is tested and sold by SLM Solutions, and that has been processed on SLM Solutions machines using the original SLM Solutions parameters in compliance with the applicable operating instructions (including installation conditions and maintenance). The part properties are determined based on specified procedures. More details about the procedures used by SLM Solutions are available upon request.

The specifications correspond to the most recent knowledge and experience available to us at the time of publication and do not form a sufficient basis for component design on their own. Certain properties of products or parts or the suitability of products or parts for specific applications are not guaranteed. The manufacturer of the products or parts is responsible for the qualified verification of the properties and their suitability for specific applications. The manufacturer of the products or parts is responsible for protecting any third-party proprietary rights as well as existing laws and regulations.

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NOTES

[1] With respect to powder material. Compositions stated as mass or weight percent.

[2] Material density varies within the range of possible chemical composition variations.

[3] According to DIN EN ISO 3252:2001.

[4] Theoretical system build rate = layer thickness x scan speed x hatch distance x number of lasers. The value represents a comparable indicator but remains a theoretical value after all. It does expressively not reflect true build rates, which are influenced by part geometry, ratio between hatch and contour areas, area of exposure, recoating times, and more.

[5] Optical density determination at test specimens by light microscopy according to internal specification. Relative density may vary depending on part geometry, orientation, volume, and other process factors.

[6] Tensile testing was performed in accordance to DIN EN ISO 6892-1:2017 B and conducted at room temperature. Samples are either machined before testing or tested in near-net-shape without any surface finishing (geometry according to DIN 50125:2016-D6x30). Values include overlap samples, i.e. multiple lasers work simultaneously on one specimen. All data is derived from standardized SLM Solutions qualification jobs. Samples are built out of both virgin powder as well as used powder.

[7] Heat treatment: annealing at 500 °C for 6 h, followed by either slow furnace cooling at 2 °C/min or air-cooling.

[8] Hardness testing according to DIN EN ISO 6507-1:2018. Measurement direction "2" according to VDI 3405 2.1. Values include overlap samples, i.e. multiple lasers work simultaneously on one specimen. All data is derived from standardized SLM Solutions qualification jobs. Samples are built out of both virgin powder as well as used powder.

[9] Roughness measurement on vertical walls according to DIN EN ISO 4288:1998; λc = 2.5 mm. Glass bead blasting is an additional post-processing step after corundum blasting. Values include overlap samples, i.e. multiple lasers work simultaneously on one specimen. All data is derived from standardized SLM Solutions qualification jobs. Samples are built out of both virgin powder as well as used powder.