



## Material data sheet

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### EOS MaragingSteel MS1

EOS MaragingSteel MS1 is a steel powder which has been optimized especially for processing on EOSINT M systems.

This document provides information and data for parts built using EOS MaragingSteel MS1 powder (EOS art.-no. 9011-0016) on the following system specifications:

- EOSINT M 270 Installation Mode *Standard*  
with PSW 3.3 or 3.4 and default job MS1\_020\_default.job or MS1\_040\_default.job
- EOSINT M 270 Dual Mode  
with PSW 3.5 and EOS Original Parameter Set MS1\_Surface 1.0 or MS1\_Performance 2.0
- EOSINT M 280  
with PSW 3.5 and EOS Original Parameter Set MS1\_Performance 1.0 or MS1\_Speed 1.0

### Description

Parts built in EOS MaragingSteel MS1 have a chemical composition corresponding to US classification 18% Ni Maraging 300, European 1.2709 and German X3NiCoMoTi 18-9-5. This kind of steel is characterized by having very good mechanical properties, and being easily heat-treatable using a simple thermal age-hardening process to obtain excellent hardness and strength.

Parts built from EOS MaragingSteel MS1 are easily machinable after the building process and can be easily post-hardened to more than 50 HRC by age-hardening at 490 °C (914 °F) for 6 hours. In both as-built and age-hardened states the parts can be machined, spark-eroded, welded, micro shot-peened, polished and coated if required. Due to the layerwise building method, the parts have a certain anisotropy, which can be reduced or removed by appropriate heat treatment - see Technical Data for examples.

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### Technical data

#### General process data

Typical achievable part accuracy [1]	
- small parts (< 80 x 80 mm)	approx. $\pm 20 \mu\text{m}$ approx. $\pm 0.8 \times 10^{-3}$ inch
- large parts	approx. $\pm 50 \mu\text{m}$ approx. $\pm 0.002$ inch
Age hardening shrinkage [2]	approx. 0.08 %
Min. wall thickness [3]	approx. 0.3 - 0.4 mm approx. 0.012 - 0.016 inch
Surface roughness (approx.) [4]	
- as manufactured	
MS1 Surface (20 $\mu\text{m}$ )	$R_a$ 4 $\mu\text{m}$ ; $R_z$ 20 $\mu\text{m}$ $R_a$ $0.16 \times 10^{-3}$ inch, $R_z$ $0.78 \times 10^{-3}$ inch
MS1 Performance (40 $\mu\text{m}$ )	$R_a$ 5 $\mu\text{m}$ ; $R_z$ 28 $\mu\text{m}$ $R_a$ $0.19 \times 10^{-3}$ inch, $R_z$ $1.10 \times 10^{-3}$ inch
MS1 Speed (50 $\mu\text{m}$ )	$R_a$ 9 $\mu\text{m}$ ; $R_z$ 50 $\mu\text{m}$ $R_a$ $0.47 \times 10^{-3}$ inch, $R_z$ $2.36 \times 10^{-3}$ inch
- after shot-peening	$R_a$ 4 - 6.5 $\mu\text{m}$ ; $R_z$ 20 - 50 $\mu\text{m}$ $R_a$ 0.16 - $0.26 \times 10^{-3}$ inch $R_z$ 0.78 - $1.97 \times 10^{-3}$ inch
- after polishing	$R_z$ up to < 0.5 $\mu\text{m}$ $R_z$ up to < $0.02 \times 10^{-3}$ inch (can be very finely polished)

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### Volume rate [5]

- Parameter set MS1_Surface 1.0 / default job MS1_020_default.job (20 µm layer thickness)	1.6 mm <sup>3</sup> /s (5.8 cm <sup>3</sup> /h) 0.35 in <sup>3</sup> /h
- Parameter set MS1_Performance 2.0 / default job MS1_040_default.job (40 µm layer thickness)	3 mm <sup>3</sup> /s (10.8 cm <sup>3</sup> /h) 0.66 in <sup>3</sup> /h
- Parameter set MS1_Performance 1.0 / for M 280 / 400 W (40 µm layer thickness)	4.2 mm <sup>3</sup> /s (15.1 cm <sup>3</sup> /h) 0.92 in <sup>3</sup> /h
- Parameter set MS1_Speed 1.0 / for M 280 / 400 W (50 µm layer thickness)	5.5 mm <sup>3</sup> /s (19.8 cm <sup>3</sup> /h) 1.21 in <sup>3</sup> /h

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- [1] Based on users' experience of dimensional accuracy for typical geometries, as built. Part accuracy is subject to appropriate data preparation and post-processing, in accordance with EOS training.
- [2] Ageing temperature 490 °C (914 °F), 6 hours, air cooling
- [3] Mechanical stability is dependent on geometry (wall height etc.) and application
- [4] Due to the layerwise building, the surface structure depends strongly on the orientation of the surface, for example sloping and curved surfaces exhibit a stair-step effect. The values also depend on the measurement method used. The values quoted here given an indication of what can be expected for horizontal (up-facing) or vertical surfaces.
- [5] Volume rate is a measure of build speed during laser exposure of hatched areas. The total build speed depends on the average volume rate, the recoating time (related to the number of layers) and other geometry- and machine setting-related factors.

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### Physical and chemical properties of parts

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Material composition	Fe (balance) Ni (17 - 19 wt-%) Co (8.5 - 9.5 wt-%) Mo (4.5 - 5.2 wt-%) Ti (0.6 - 0.8 wt-%) Al (0.05 - 0.15 wt-%) Cr, Cu (each $\leq$ 0.5 wt-%) C ( $\leq$ 0.03 wt-%) Mn, Si (each $\leq$ 0.1 wt-%) P, S (each $\leq$ 0.01 wt-%)
Relative density	approx. 100 %
Density	8.0 - 8.1 g/cm <sup>3</sup> 0.289 - 0.293 lb/in <sup>3</sup>

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### Mechanical properties of parts at 20 °C ( 68°F )

	As built	After age hardening [2]
Tensile strength [6]		min. 1930 MPa min. 280 ksi
- in horizontal direction (XY)	typ. 1100 ± 100 MPa typ. 160 ± 15 ksi	typ. 2050 ± 100 MPa typ. 297 ± 15 ksi
- in vertical direction (Z)	typ. 1100 ± 100 MPa typ. 160 ± 15 ksi	
Yield strength (Rp 0.2 %) [6]		min. 1862 MPa min. 270 ksi
- in horizontal direction (XY)	typ. 1050 ± 100 MPa typ. 152 ± 15 ksi	typ. 1990 ± 100 MPa typ. 289 ± 15 ksi
- in vertical direction (Z)	typ. 1000 ± 100 MPa typ. 145 ± 15 ksi	
Elongation at break [6]		min. 2 %
- in horizontal direction (XY)	typ. (10 ± 4 ) %	typ. (4 ± 2) %
- in vertical direction (Z)	typ. (10 ± 4 ) %	
Modulus of elasticity [6]		
- in horizontal direction (XY)	typ. 160 ± 25 GPa typ. 23 ± 4 Msi	typ. 180 ± 20 GPa typ. 26 ± 3 Msi
- in vertical direction (Z)	typ. 150 ± 20 GPa typ. 22 ± 3 Msi	
Hardness [7]	typ. 33 - 37 HRC	typ. 50 - 56 HRC
Ductility (Notched Charpy impact test)	typ. 45 ± 10 J	typ. 11 ± 4 J

[6] Tensile testing according to ISO 6892-1:2009 (B) Annex D, proportional test pieces, diameter of the neck area 5mm (0.2 inch), original gauge length 25mm (1 inch).

[7] Rockwell C (HRC) hardness measurement according to EN ISO 6508-1 on polished surface. Note that measured hardness can vary significantly depending on how the specimen has been prepared.

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### Thermal properties of parts

	As built	After age hardening [2]
Thermal conductivity	typ. $15 \pm 0.8 \text{ W/m}^\circ\text{C}$ typ. $104 \pm 6 \text{ Btu in/(h ft}^2 \text{ }^\circ\text{F)}$	typ. $20 \pm 1 \text{ W/m}^\circ\text{C}$ typ. $139 \pm 7 \text{ Btu in/(h ft}^2 \text{ }^\circ\text{F)}$
Specific heat capacity	typ. $450 \pm 20 \text{ J/kg}^\circ\text{C}$ typ. $0.108 \pm 0.005 \text{ Btu/(lb }^\circ\text{F)}$	typ. $450 \pm 20 \text{ J/kg}^\circ\text{C}$ typ. $0.108 \pm 0.005 \text{ Btu/(lb }^\circ\text{F)}$
Maximum operating temperature		approx. $400 \text{ }^\circ\text{C}$ approx. $750 \text{ }^\circ\text{F}$

### Abbreviations

typ.	typical
min.	minimum
approx.	approximately
wt	weight

### Notes

The data are valid for the combinations of powder material, machine and parameter sets referred to on page 1, when used in accordance with the relevant Operating Instructions (including Installation Requirements and Maintenance) and Parameter Sheet. Part properties are measured using defined test procedures. Further details of the test procedures used by EOS are available on request. Unless otherwise specified, the data refer to the default job MS1\_040\_default.job or the equivalent parameter set MS1\_Performance 2.0. The corresponding data for the default job MS1\_020\_default.job or the equivalent parameter set MS1\_Surface 1.0 are approximately the same except where otherwise specified.

The data correspond to our knowledge and experience at the time of publication. They do not on their own provide a sufficient basis for designing parts. Neither do they provide any agreement or guarantee about the specific properties of a part or the suitability of a part for a specific application. The producer or the purchaser of a part is responsible for checking the properties and the suitability of a part for a particular application. This also applies regarding any rights of protection as well as laws and regulations. The data are subject to change without notice as part of EOS' continuous development and improvement processes.

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