

EOS StainlessSteel 316L

EOS StainlessSteel 316L is a corrosion resistant iron based alloy which has been optimized especially for processing on EOSINT M280 systems.

This document provides information and data for parts built using EOS StainlessSteel 316L powder (EOS art.-no. 9011-0032) on the following system specifications:

- EOSINT M 280 / 400 W system with PSW3.6 and Parameter Set 316L_Surface 1.0 -
- EOSINT M 280 / 200 W system with PSW3.6 and Parameter Set 316L_Surface 1.0

Description

The parts built from EOS StainlessSteel 316L have chemical composition corresponding to ASTM

F138 "Standard Specification for Wrought 18Cr-14Ni-2.5Mo Stainless Steel Bar and Wire for Surgical Implants (UNS S31673)". This kind of stainless steel is characterized having a good corrosion resistance and evidence that there are no leachable substances in cytotoxic concentrations.

Material data sheet

This material is ideal in

- Lifestyle/Consumer, e.g. watches, other jewellery, spectacle frames, decorations
- Automotive/Industrial, e.g. non-corroding common material, food and chemical plants - Aerospace/Turbine industry
- Entry-level material for Laser Sintering Technology, e.g. mounting parts, heat exchangers, functional elements in electronic housing and accessories

Parts built from EOS StainlessSteel 316L can be machined, shot-peened and polished in as-built or stress relieved (AMS2759) states if required. Solution annealing is not necessary because the mechanical properties of as-built state are showing desired values (ASTM A403). Parts are not ideal in temperature range 427 °C – 816 °C where precipitation of chromium carbides occurs. Due to layer-wise building method, the parts have a certain anisotropy which could be seen from mechanical properties.

EOS GmbH - Electro Optical Systems

Technical data

General process data

EOS StainlessSteel 316L	
Typical achievable part accuracy [1]	
small parts	approx. ± 20 - 50 µm (±0.0008 – 0.002 inch)
large parts	approx. ± 0.2 %
Min. wall thickness [2]	approx. 0.3 - 0.4 mm (0.012 – 0.016 inch)
Layer thickness	20 µm (0,8 x 10 ⁻³ inch)
Surface roughness [3]	
as manufactured	R _a 13 ± 5 µm; R _a 80 ± 20 µm R _a 0.5 ± 0.2 x 10 ⁻³ inch; R _a 3.1 ± 0.8 x 10 ⁻³ inch

Material data sheet

after shot-peening

Ra $5 \pm 2 \mu\text{m}$; Rz $30 \pm 10 \mu\text{m}$
 R: $0.2 \pm 0.08 \times 10^{-3}$ inch; R: $1.2 \pm 0.4 \times 10^{-3}$ inch

after polishing

Rz up to $< 1 \mu\text{m}$
 Rz up to $< 0.04 \times 10^{-3}$ inch
 (can be very finely polished)

Volume rate [4]

$2 \text{ mm}^3/\text{s}$ ($7.2 \text{ cm}^3/\text{h}$)
 $0.44 \text{ in}^3/\text{h}$

- [1] Based on users' experience of dimensional accuracy for typical geometries, e.g. $\pm 40 \mu\text{m}$ when parameters can be optimized for a certain class of parts or $\pm 60 \mu\text{m}$ when building a new kind of geometry for the first time. Part accuracy is subject to appropriate data preparation and postprocessing.
- [2] Mechanical stability is dependent on geometry (wall height etc.) and application
- [3] 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 vertical surfaces.
- [4] Volume rate is a measure of build speed during laser exposure. The total build speed depends on the average volume rate, the recoating time (related to the number of layers) and other factors such as contour and Up-/DownSkin parameters.

Physical and chemical properties of parts

EOS StainlessSteel 316L

Material composition

Element	Min	Max
Fe	balance	
Cr	17.00	19.00
Ni	13.00	15.00
Mo	2.25	3.00
C		0.030
Mn		2.00
Cu		0.50
P		0.025
S		0.010
Si		0.75
N		0.10

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Relative density with standard parameters	approx. 100 %
Density with standard parameters	min. 7.9 g/cm ³ min. 0.285 lb/in ³

Mechanical properties of parts (at room temperature)

As built	
Ultimate tensile strength [5]	
in horizontal direction (XY)	640 ± 50 MPa
in vertical direction (Z)	540 ± 55 MPa
Yield strength, Rp0.2% [5]	
in horizontal direction (XY)	530 ± 60 MPa
in vertical direction (Z)	470 ± 90 MPa
Young's modulus [5]	
in horizontal direction (XY)	typ. 185 GPa
in vertical direction (Z)	typ. 180 GPa
Elongation at break [5]	
in horizontal direction (XY)	40 ± 15 %
in vertical direction (Z)	50 ± 20 %
Hardness [6]	typ. 85 HRB

[5] Machining and testing of the test bars according to ISO 6892 / ASTM E8M, proportional test pieces, diameter of the neck area 5 mm (0.2 inch), gauge length 4D = 20.0mm (0.79 inch), stress rate 10MPa/s, strain speed in plastic region 0.375 1/min.

[6] Rockwell hardness (HRB) measurement according to EN ISO 6508-1 on polished surface.

Abbreviations

typ.	typical
min.	minimum
approx.	approximately
wt	weight

The quoted values refer to the use of these materials with EOSINT M 280 systems according to current specifications (including the latest released process software PSW and any hardware specified for the relevant material) and operating instructions. All values are approximate. Unless otherwise stated, the quoted mechanical

Material data sheet

and physical properties refer to standard building parameters and test samples built in vertical orientation. They depend on the building parameters and strategies used, which can be varied by the user according to the application.

The data are based on our latest knowledge and are subject to changes without notice. They are provided as an indication and not as a guarantee of suitability for any specific application.

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