

EOS Aluminium AlSi10Mg for EOSINT M 270

EOS Aluminium AlSi10Mg is an aluminium alloy in fine powder form which has been specially optimised for processing on EOSINT M systems

This document provides information and data for parts built using EOS Aluminium AlSi10Mg powder (EOS art.-no. 9011-0024) on the following system specifications:

- EOSINT M 270 Installation Mode *Xtended*
with PSW 3.4 and default job AlSi10Mg_030_default.job
- EOSINT M 270 Dual Mode
with PSW 3.5 and Original EOS Parameter Set AlSi10Mg_Performance 2.0

Description

AlSi10Mg is a typical casting alloy with good casting properties and is typically used for cast parts with thin walls and complex geometry. It offers good strength, hardness and dynamic properties and is therefore also used for parts subject to high loads. Parts in EOS Aluminium AlSi10Mg are ideal for applications which require a combination of good thermal properties and low weight. They can be machined, spark-eroded, welded, micro shot-peened, polished and coated if required.

Conventionally cast components in this type of aluminium alloy are often heat treated to improve the mechanical properties, for example using the T6 cycle of solution annealing, quenching and age hardening. The laser-sintering process is characterized by extremely rapid melting and re-solidification. This produces a metallurgy and corresponding mechanical properties in the as-built condition which is similar to T6 heat-treated cast parts. Therefore such hardening heat treatments are not recommended for laser-sintered parts, but rather a stress-relieving cycle of 2 hours at 300 °C (572 °F). 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.

Material data sheet

Technical data

General process and geometrical data

Typical achievable part accuracy [1]	$\pm 100 \mu\text{m}$
Smallest wall thickness [2]	approx. 0.3 – 0.4 mm approx. 0.012 – 0.016 inch
Surface roughness [3]	
- as built, cleaned	Ra 15 – 19 μm , Rz 96 – 115 μm Ra 0.59 – 0.75 $\times 10^{-3}$ inch Rz 3.8 – 4.5 $\times 10^{-3}$ inch
- after micro shot-peening	Ra 7 – 10 μm , Rz 50 – 60 μm Ra 0.28 – 0.39 $\times 10^{-3}$ inch Rz 1.97 – 2.36 $\times 10^{-3}$ inch
Volume rate [4]	4.1 mm^3/s (14.7 cm^3/h) 0.9 in^3/h

- [1] Based on users' experience of dimensional accuracy for typical geometries. Part accuracy is subject to appropriate data preparation and post-processing, in accordance with EOS training.
- [2] Mechanical stability dependent on the 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 horizontal (up-facing) or vertical surfaces.
- [4] The volume rate is a measure of the building speed during laser exposure. The overall building speed is dependent on the average volume rate, the time required for coating (depends on the number of layers) and other factors, e.g. DMLS settings.

Material data sheet

Physical and chemical properties of the parts

Material composition	Al (balance) Si (9.0 – 11.0 wt-%) Fe (\leq 0.55 wt-%) Cu (\leq 0.05 wt-%) Mn (\leq 0.45 wt-%) Mg (0.2 – 0.45 wt-%) Ni (\leq 0.05 wt-%) Zn (\leq 0.10 wt-%) Pb (\leq 0.05 wt-%) Sn (\leq 0.05 wt-%) Ti (\leq 0.15 wt-%)
Relative density	approx. 99.7 %
Density	2.67 g/cm ³ 0.096 lb/in ³

Material data sheet

Mechanical properties of the parts

	As built	Heat treated [8]
Tensile strength [5]		
- in horizontal direction (XY)	445 ± 20 MPa 64.5 ± 2.9 ksi	335 ± 20 MPa 48.6 ± 2.9 ksi
- in vertical direction (Z)	405 ± 20 MPa 58.7 ± 2.9 ksi	325 ± 20 MPa 47.1 ± 2.9 ksi
Yield strength (Rp 0.2 %) [5]		
- in horizontal direction (XY)	275 ± 10 MPa 39.9 ± 1.5 ksi	225 ± 10 MPa 32.6 ± 1.5 ksi
- in vertical direction (Z)	230 ± 10 MPa 33.4 ± 1.5 ksi	220 ± 10 MPa 31.9 ± 1.5 ksi
Modulus of elasticity		
- in horizontal direction (XY)	approx. 70 ± 5 GPa approx. 10.2 ± 0.7 Msi	approx. 70 ± 5 GPa approx. 10.2 ± 0.7 Msi
- in vertical direction (Z)	approx. 65 ± 5 GPa approx. 9.4 ± 0.7 Msi	approx. 65 ± 5 GPa approx. 9.4 ± 0.7 Msi
Elongation at break [5]		
- in horizontal direction (XY)	(6.5 ± 2) %	(11 ± 2) %
- in vertical direction (Z)	(3.5 ± 2) %	(7 ± 2) %
Hardness [6]		
	120 ± 5 HBW	
Fatigue strength [7]		
- in vertical direction (Z)	97 ± 7 MPa 14.1 ± 1.0 ksi	

[5] Mechanical strength tested as per ISO 6892-1:2009 (B) annex D, proportional specimens, specimen diameter 5 mm, initial measured length 25 mm.

[6] Hardness test in accordance with Brinell (HBW 2.5/62.5) as per DIN EN ISO 6506-1. Note that measured hardness can vary significantly depending on how the specimen has been prepared.

[7] Fatigue test with test frequency of 50 Hz, R = -1, measurement stopped on reaching 5 million cycles without fracture.

[8] Stress relieve: anneal for 2 h at 300 °C (572 °F).

Material data sheet

Thermal properties of parts

	As built	Heat treated [8]
Thermal conductivity (at 20 °C)		
- in horizontal direction (XY)	approx. 103 ± 5 W/m °C	approx. 173 ± 10 W/m °C
- in vertical direction (Z)	approx. 119 ± 5 W/m °C	approx. 175 ± 10 W/m °C
Specific heat capacity		
- in horizontal direction (XY)	approx. 920 ± 50 J/kg°C	approx. 890 ± 50 J/kg°C
- in vertical direction (Z)	approx. 910 ± 50 J/kg°C	approx. 900 ± 50 J/kg°C

Abbreviations

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.

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.

EOS[®], EOSINT[®] and DMLS[®] are registered trademarks of EOS GmbH.

© 2011 EOS GmbH – Electro Optical Systems. All rights reserved.