



UNIVERSITÉ CATHOLIQUE DE LOUVAIN

Study of the stress relieve heat-treatment of additively manufactured AlSi10Mg alloy:

Influence on microstructure and mechanical properties

Dissertation presented by

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"The gem cannot be polished without friction, nor man perfected without trials."

Confucius

Acknowledgements

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List of Abbreviations

AB	As-Built
AM	Additive Manufacturing
CAD	Computer Aided Design
CI	Confidence Interval
DMLS	Direct Metal Laser Sintering
DMP	Direct Metal Printer
HPDC	High Pressure Die Casting
HW	Hydrostatic Weigthing
ICP	Inductively Coupled Plasma
RODIA	Relative Optical Density Image Analysis
SD	Standard Deviation
SEM	Scanning Electron Microscope
SLM	Selective Laser Melting

Symbols

A_0	Initial minimal cross-sectional area	[mm ²]
A_f	Minimal cross-sectional area after fracture	[mm ²]
d_0	Initial minimal diameter	[mm]
d_f	Minimal diameter after fracture	[mm]
D_a	Average particle size	[μm]
E	Young modulus	[GPa]
E_d	Volumetric energy density	[J/mm ³]
F	Force	[N]
h	Hatch space	[μm]
H_v	Vickers hardness	[HV]
\overline{H}_v	Average Vickers hardness	[HV]
L	Extensometer gauge length	[mm]
L_0	Initial extensometer gauge length	[mm]
L_f	Final extensometer gauge length	[mm]
P	Laser power	[W]
p_{O_2}	Oxygen pressure	[mbar]
SD_{HV}	Vickers hardness measures standard deviation	[HV]
$SD_{\rho_{rel}}$	Relative density measures standard deviation	[%]
t	Layer thickness	[μm]
v_s	Scanning speed	[mm/s]
W_a	Specimen dry weight	[g]
W_w	Specimen underwater weight	[g]
ϵ_{eng}	Engineering strain	[%]
$\epsilon_{f,eng}$	Engineering strain at fracture	[%]
$\epsilon_{f,true}$	True strain at fracture	[%]
$\phi_{99\%}$	Laser spot size at the 99% contour	[μm]
λ	Laser wavelength	[nm]
ρ_a	Apparent density	[g/cm ³]
$\rho_{a,rel}$	Apparent relative density	[%]
$\rho_{b,rel}$	Theoretical bulk density	[g/cm ³]
ρ_w	Water density	[g/cm ³]
ρ_{rel}	Relative density	[%]
$\overline{\rho}_{rel}$	Average relative density	[%]
σ_{eng}	Engineering stress	[MPa]
σ_u	Ultimate tensile strength	[MPa]
σ_y	Yield strength	[MPa]

Nous dédions ce travail à nos familles et amis

Chapter 1

Introduction

[This is, with the concluding chapter, a significant portion of memory. This should especially present the context and objectives of the work. Generally, the memory structure (content of chapters) is briefly exposed]

Chapter 2

State of the art

2.1 Selective laser melting technology

Selective laser melting (SLM) - also referred to as direct metal laser sintering (DMLS) - is an additive manufacturing (AM) technique making use of a high power-density laser that locally melts powder materials. When a layer of powder has been melted, a new layer is spread on top of the previous one, and is in turn melted, in order to progressively build a 3D object. The technique is illustrated on figure 2.1 [15]. The materials used include mostly metals but also ceramics and composites. Parts to build must first be drawn in a computer-aided design (CAD) software and broken down in 2D slices, each one corresponding to a powder layer. During the process, the oxygen pressure p_{O_2} must be kept low to prevent the oxidation of the metal. A shielding gas - such as argon - is thus used to fill the build chamber at all time, while p_{O_2} is monitored.

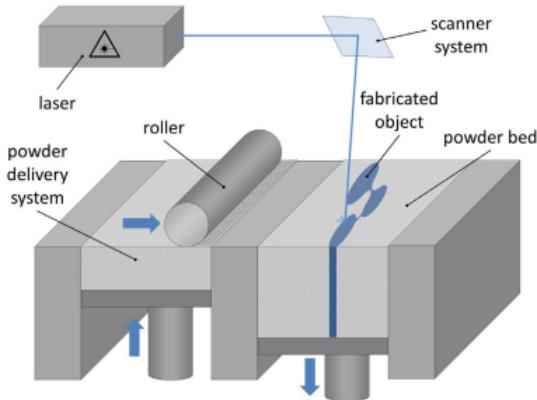


FIGURE 2.1: Selective laser melting technology principle (from Leitz et al., 2017 [15]).

SLM is still a young technology. Its popularity only increased significantly over the last decade, as depicted by figure 2.2. Works concerning AlSi10Mg began to emerge noticeably in 2014. The technique usage spread rapidly in many sectors: biomedical, heat exchangers, aerospace and automotive - to name just a few [30]. This is due to the numerous appeals of SLM compared to the other technologies, including:

- Geometrical flexibility: parts can be designed with thin walls or even with hidden cavities and/or channels. This offers promising prospects regarding light-weight potentials for parts solicited mechanically [17];
- Increased reliability of the parts [10];
- Reduced equipment costs [11];
- Better operational efficiency: the fabrication is quick and easy which reduces time-to-market as well as assembly times and capital tied up in stocks [11];
- Individual production facilitation [10];
- Reduced material waste and better energy usage: the process is environmentally friendly as a whole [10].

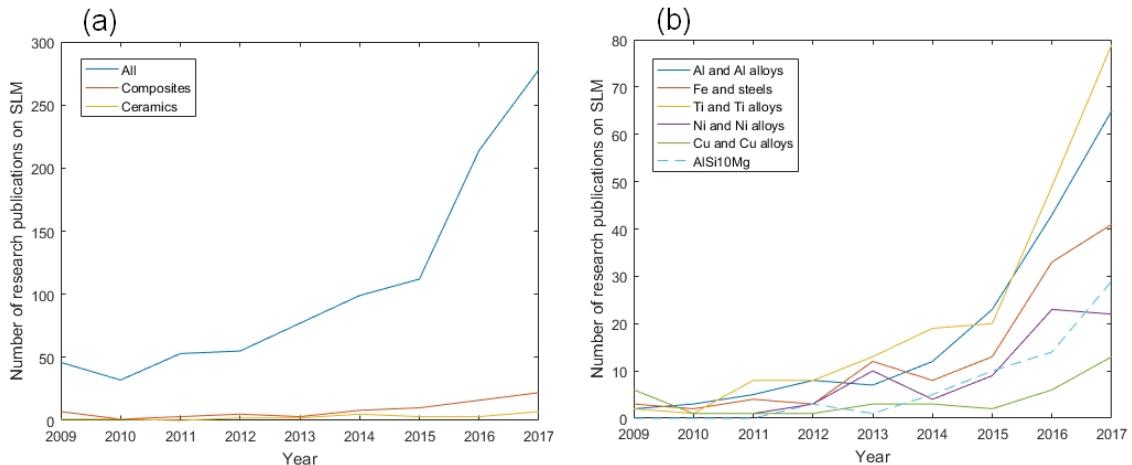


FIGURE 2.2: (a)Research publications on SLM of ceramics, composites and all materials types combined. (b)Research publications on SLM of different metallic materials. Data are derived from the research publications on SLM, LaserCusing and DMLS existing on ScienceDirect website.

The properties of parts produced through SLM stem from the coupled effects of a great deal of parameters (see figure 2.3) [3]. Results are very sensitive to their variations. The process parameters must thus be monitored thoroughly. This complicates the search for their optimisation, still not fully resolved for aluminium alloys.

In recent years, works aiming at facing this challenge multiplied. The minimisation of the porosity is at the center of attention. It is indeed closely related to the quality of the mechanical properties. As porosity contributes to lowering the load-bearing surface, it reduces the apparent material strength. It was also observed to have a critical influence on the fatigue life of the produced parts. Their lifetime is especially diminished if the values of pores amount and size go beyond a certain threshold [6]. Studies investigating the effects of various parameters on the AlSi10Mg fabrication through SLM abound in the literature.

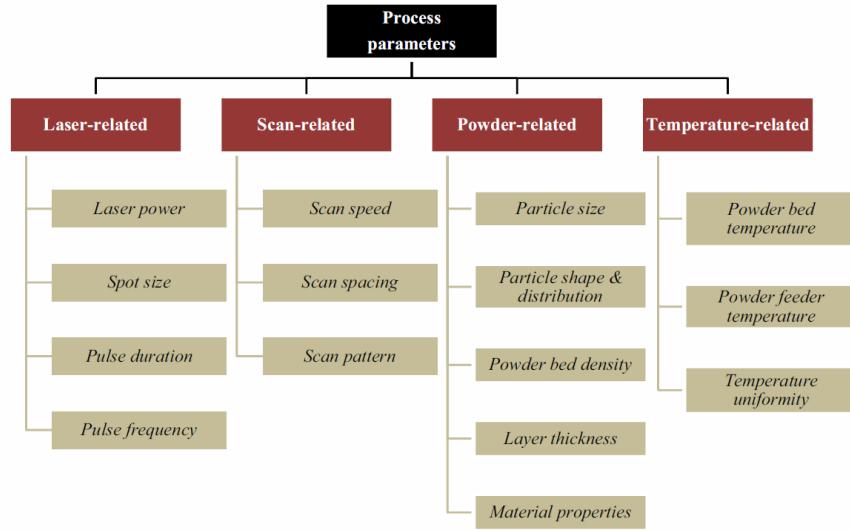


FIGURE 2.3: Parameters involved in SLM (from Aboulkhair et al., 2014 [3]).

2.2 AlSi10Mg alloy

Parler de l'AlSi10Mg; quel est l'intérêt de travailler avec? Difficultés? (reflectivité etc).. Qu'est ce qui existe en coulé, forgé etc

Microstructure homogène, diagramme de phase

Kempen dans "PROCESS OPTIMIZATION AND MICROSTRUCTURAL ANALYSIS FOR SELECTIVE LASER MELTING OF AlSi10Mg ":

AlSi10Mg is a typical casting alloy which is, due to its high strength/density ratio and thermal properties, highly demanded in aerospace and automotive industries [1]. The alloy combination of aluminium, silicon and magnesium results in a significant increase in strength and hardness which might even reach 300 MPa and 100 HBS, respectively, by applying a proper heat treatment [2]

Aluminium as a lightweight material is very attractive for the production of parts that require good mechanical properties in combination with a low weight. The main focus lies on Al-Si alloys, since they are casting alloys that are also suitable for welding. AlSi10Mg, which can be hardened by applying a specific heat treatment, is relatively easy to process by laser applications due to the small difference between liquidus and solidus temperature compared to high strength aluminium-alloys [2]. The AlSi10Mg alloy is frequently used in aerospace, automotive, chemical and food industry. Its composition according to ISO 3522 can be found in Table 1 [4]. Alloying the magnesium to the Al-Si alloy enables precipitation of Mg₂Si which will strengthen the matrix without compromising the other mechanical properties to a significant extent.

2.3 Fabrication process parameters

Let us now investigate the influence of the parameters on the properties of AlSi10Mg parts manufactured with SLM. The analysis of the paired impacts of the laser power P and scan speed v_s provides a first insight. As depicted by figures 2.4 and 2.5, low

P and high v_s lead to an insufficient energy input to melt the powder and re-melt the substrate, which causes the formation of droplets [14]. The opposite leads to good penetration but also to distortions and irregularities. A trend to use both high P and v_s rose in accordance with these findings. Doing so has the advantage to increase productivity. However, it also has multiple downsides including a decrease of the surface quality due to balling, excessive spatter, and an augmented gas induced porosity [19]. Therefore, a trade-off must be found.

A popular approach is to regroup multiple operating parameters into one, the volumetric energy density E_d . It is estimated through the following formula:

$$E_d = \frac{P}{v_s h t}$$

where t is the layer thickness and h is the hatch space. As a rule of thumb, E_d should be chosen in the range between 60 and 75 [$\frac{J}{mm^3}$] [22]. However, the criterion is insufficient and others phenomena, such as melt pools overlapping, should be considered [25]. Very few studies were carried out to optimize h and t independently. Their values lie generally in the intervals [50 ; 200] [μm] and [20 ; 60] [μm], respectively [2, 6, 14, 19]. It was observed that for $t = 30$ [μm], an optimal set of parameters values in terms of density is $P = 200$ [W], $v_s = 1400$ [$\frac{mm}{s}$] and $h = 105$ [μm] [14]. The apparent relative density $\rho_{a,rel}$ was then above 99.5 [%], considering the theoretical bulk density ρ_b to be equal to 2.68 [$\frac{g}{mm^3}$].

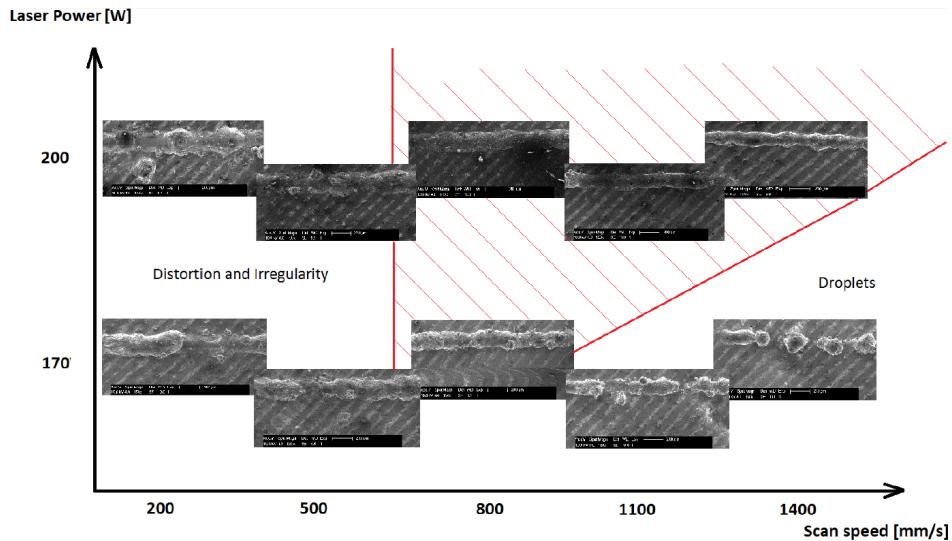


FIGURE 2.4: Process window for SLM of AlSi10Mg, based on the top view of single track scans (from Kempen et al., 2011 [14]).

The other process parameters will be covered for the sake of completeness. Let us first look into the particle-related parameters. The particle size D_a of the powder should be as small as possible to ensure a good flowability and allow for thin layers [14]. Typical values for mean particle size stretch from 15 to 50 [μm] but are more often at around 30 [μm] [6, 14, 20, 26]. The size distribution is more delicate to outline. On one hand, wider distributions often generate better bed density, parts with higher density and better surface finish. On the other hand, narrower ones usually

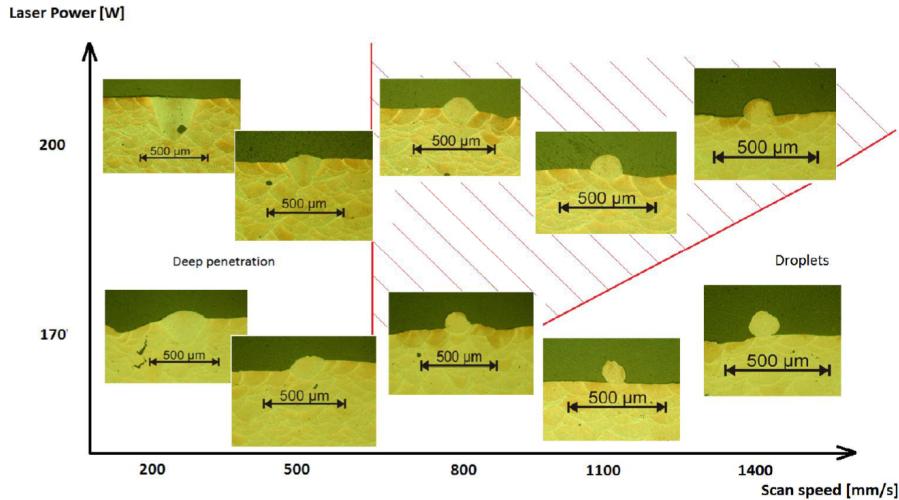


FIGURE 2.5: Process window for SLM of AlSi10Mg, based on the front view of single track scans (from Kempen et al., 2011 [14]).

provide better flowability and parts with better strength and hardness [18]. In most cases, a middle ground between the two should be sought. In SLM applications, powder is often successively recycled multiple times. This leads to their progressive contamination with moisture, which causes an increase of hydrogen porosity in the produced parts [29]. The problem can be overcome by drying the powder or using fresh one. Unfortunately - in the case of aluminium alloys - no findings were made regarding the prediction of a threshold at which one should take action [4].

The choice of scan pattern has great importance. There exist a few different strategies. The common ones use unidirectional, bidirectional or islands patterns (see figure 2.6). The scan direction(s) should always be rotated between successive layers to favorise isotropy, especially in the unidirectional case since it causes height variations along a layer [2]. The islands pattern is based on a decomposition in small domains with short scanning tracks. Two usual strategies can be distinguished among this group: the chessboard and the hexagonal one. A study proved the superiority of an island pattern over a bidirectional one in terms of both ultimate tensile stress σ_u and strain at fracture ϵ_f for a 316L stainless steel-Inconel 718 material [31]. It was also shown that it was possible to fabricate pure titanium samples without cracks using an island pattern, and not with a bidirectional one [16]. This is seemingly due to the greater accumulation of internal stresses and to the weaker interlayer bounding in the second case.

Furthermore, dual scanning strategies were proven to be effective. For example, a pre-scan with low E_d can flatten the powder bed before it is consolidated, which leads to a reduction of porosity [19]. It was also shown that scanning the contour of the part being built at lower E_d can better the surface roughness for AlSi12Mg [21]. One should note too that the final properties of the fabricated part can strongly depend on the building direction (see figure 2.7) [8]. Further properties comparison is provided in section 2.4.

Other laser-related parameters - the spot size and the pulse properties - can also influence the process. Only the laser spot size at the 99% contour $\phi_{99\%}$ is frequently

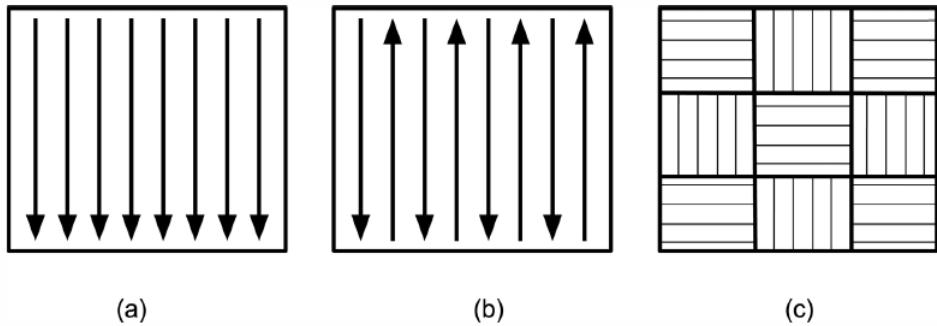


FIGURE 2.6: Schematic representation of scanning strategies commonly used in LSM (a) unidirectional long scan track; (b) bi-directional long scan track, and (c) islands (from Mertens et al., 2017 [19]).

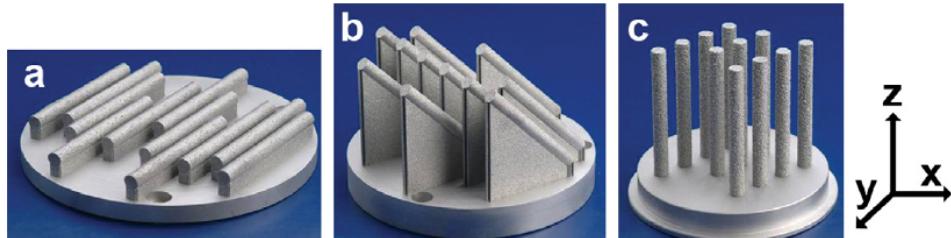


FIGURE 2.7: Samples (static tensile) built in different directions: (a) 0° , (b) 45° , and (c) 90° (from Brandl et al., 2012 [6]).

cited in literature. Its value lies between 20 and 200 [μm] [6, 14, 20]. At this moment, no optimisation study was carried out about this variable. One should expect the optimal value for P , v_s , t , and h to depend on the spot size as it has a direct incidence on E_d .

Finally, the temperature of the powder bed and feeder affect the final properties of the fabricated parts as well. In particular, it was observed that pre-heating the powder at 300°C mitigates the differences of fatigue resistance between tensile specimens built in different directions: it is possible that the operation induces a slower cooling rate which helps reducing the distortions and internal stresses [6].

Once the porosity problem is sorted out, other matters can be addressed such as productivity and surface roughness. The latter is problematic as the surface finish obtained with SLM is typically of such poor quality that all cracks initiate near the surface for a sample with relative density $\rho_{\text{rel}} > 99\%$ [6]. As said before, it is possible to reduce the surface roughness by mean of a dual scan strategy. However, the only options to obtain significantly better surface finish is currently to machine or polish the fabricated parts. This is one of the main weak points of SLM.

2.4 As-built mechanical properties

In a work of Kempen et al., it was concluded that as-built (AB) additively manufactured AlSi10Mg samples can have mechanical properties (Vickers hardness HV , ultimate tensile stress σ_u , fracture strain ϵ_f and impact energy) better or at least comparable to the conventionally casted and high pressure die casted (HPDC) alloy [13]. The tensile specimens built in an horizontal direction (XY) had slightly different characteristics than those built in the vertical direction (Z). The results obtained in the mentioned work are gathered in table 2.1, along with other results and common cast AlSi10Mg properties. The best tensile properties measurements found on the web - both in terms of σ_u and ϵ_f - were obtained by EOS with $\rho_{rel} \simeq 99.85$ [9] (ρ_b considered to be equal to 2.67 [$\frac{g}{cm^3}$]). Unfortunately, the process parameters values were omitted in sources [9] and [13]. The mechanical properties all lie in wide ranges. This illustrates the importance of mastering the process parameters.

Process	E [GPa]	σ_y [MPa]	σ_u [MPa]	ϵ_f [%]	HV [HV]
SLM - XY direction [13]	68 ± 3	-	391 ± 6	5.55 ± 0.4	127
SLM - Z direction [13]		-	396 ± 8	3.47 ± 0.6	
SLM [5]	77 ± 5	268 ± 2	333 ± 15	1.4 ± 0.3	125 ± 1
SLM - XY direction [20]	65.5	227	358	3.9	-
SLM - Z direction [20]	75.4	172	289	2.6	-
SLM - XY direction [9]	75 ± 10	270 ± 10	460 ± 20	9 ± 2	119 ± 5
SLM - Z direction [9]	70 ± 10	240 ± 20	460 ± 20	6 ± 2	
Conventional cast and aged [13]	71	-	300-317	2.5-3.5	86
As built HPDC [13]		-	300-350	3-5	95-105
T6 treated HPDC [13]		-	330-365		130-133

TABLE 2.1: Mechanical properties of SLM built parts and cast + aged parts in literature

Furthermore, Wang et al. observed that preheating the manufacturing plate can have a tremendous impact on the mechanical properties [27]. This is due to the differences in thermal gradients between the substrate and the built samples, which induces residual stresses. Results obtained for a chessboard pattern are shown in table 2.2.

Plate temperature	σ_u [MPa]	ϵ_f [%]	HV [HV]	ρ_{rel} [%]
80°C	385 ± 6	3 ± 1.5	176 ± 6	98.69 ± 0.19
120°C	381.3 ± 3.3	2.83 ± 0.33	257 ± 9	97.39 ± 0.38
160°C	363.7 ± 11.3	5.33 ± 0.67	233 ± 4	97.01

TABLE 2.2: Mechanical properties for different plate pre heating temperatures (from Wang et al., 2018) [27].

Plein de données + fatigue <http://sci-hub.tw/><https://www.sciencedirect.com/science/article/pii>
On the Selective Laser Melting (SLM) of the AlSi10Mg Alloy: Process, Microstructure, and Mechanical Properties

2.5 Residual stresses in SLM parts

Introduire les contraintes internes: pourquoi il y en a? Sont-elles quantifiées dans la littérature? Traction/Comp ? Haut/bas? Techniques de caractérisation? Influence sur les précisions géométriques, sur les propriétés méca (statique & fatigue)? Comment les éviter en cours de process ou supprimer après? =Intro pour section suivante.

2.6 Post treatments

Post-traitements habituels en SLM à expliquer: Shot peening, HIP,... dont traitements thermiques, sur lesquels on se focalise. Expliquer + Propriétés mécas après les traitements

Source que tu peux utiliser:

Trevisan et al, 'On the Selective Laser Melting (SLM) of the AlSi10Mg Alloy: Process, Microstructure, and Mechanical Properties' (AlSi10Mg de manière générale)

Effet sur microstructure et dureté: <http://sci-hub.tw/><https://link.springer.com/article/10.1007/s015-2980-7>

Anne Mertens: 250 deg/2h <https://orbi.uliege.be/bitstream/2268/185421/1/2015-SFFS-Mertens.pdf>

Traitements T6 [5]

<http://sci-hub.tw/><https://www.sciencedirect.com/science/article/pii/S0921509316304890>

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Chapter 3

Materials and methods

3.1 Powder follow-up

3.1.1 Sieving

3.1.2 Grain size and distribution

3.1.3 Composition

3.2 SLM manufacturing

The same direct metal printer (DMP) was used to fabricate all specimens throughout this work. It is a *ProX DMP 200* printer, manufactured by *3D Systems* (see figure 3.1). It uses a laser with a theoretical maximal power of 300 [W] and wavelength $\lambda = 1070$ [nm] [1]. Its actual maximal power is $P_{max} = 273.6$ [W]. [QUEL EST LE SPOT SIZE?] The maximal envelope capacity of the machine (W x D x H) is 140 x 140 x 125 [mm]. Its typical accuracy is +/- 50 [μm] for small parts and +/- 0.2% for large parts. It allows for the set-up of a protection atmosphere. However, it does not integrate any heating feature for the build bed.



FIGURE 3.1: ProX DMP 200 printer (from the user's ProX DMP 200 general instructions document).

In this thesis, argon was used as shielding gas. The composition of the gas environment was monitored so as to keep $p_{O_2} < 500$ [ppm]. Laser compensations were set to take into account the excess energy at the start and end of the scanning vectors (see figure 3.2). These were chosen in accordance with the manufacturer recommendations (figure 3.3). Values for hatch space (h) and layer thickness (t) were respectively set to 100 [μm] and 30 [μm]. The scan speed (v_s) and the laser power (P) were varied in the ranges [900 ; 1500] [$\frac{\text{mm}}{\text{s}}$] and [0.75 · P_{max} ; P_{max}] respectively, in order to optimise of the built specimens (see section 4.2.1). Educated guesses were made based on literature and previous works done at the UCL. The parameters used are resumed in appendix A.1. Batches were named in the format X200-*yymmdd*. The prefix "X200" refers to the DMP used. It is followed by the date of printing (6 digits). Recycled powder was used for every batch except for X200-180222 and X200-180228. Figures with detailed specimens positions, denominations, scanning orders and sintering durations for all batches are available in appendix A.2.

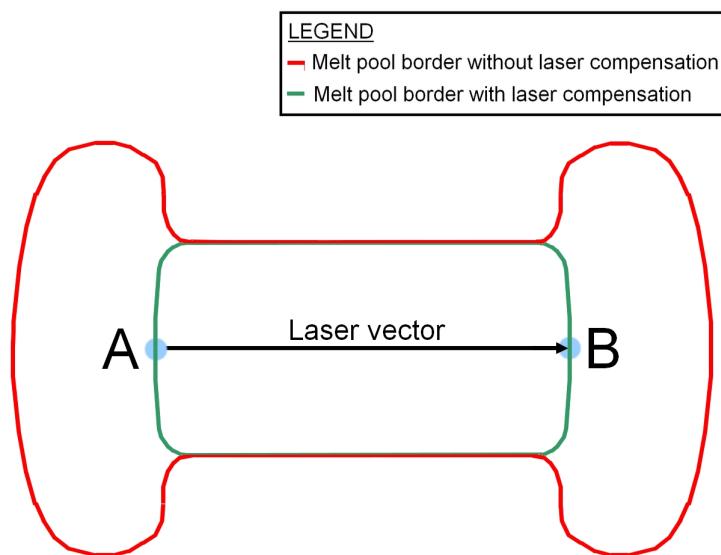


FIGURE 3.2: Melt pool contours with and without laser compensation (exaggeration).

The batches were first prepared on *DMP ProX Manufacturing*, a dedicated CAD software. It enabled to select the values for the parameters previously mentioned, as well as the position of the specimens. For this thesis, all cylinders and tensile specimens were fabricated vertically. The dimensions notations for the samples types and the tensile specimens detailed geometry are gathered on figure 3.4.

An island scanning strategy was chosen on account of research done on the subject (see section 2.3). It is a hexagonal pattern. The replicated hexagon's smallest width is equal to 5 [mm]. An overlap of 100 [μm] was set, as illustrated on figure 3.5. There is a rotation of 90° and a translation of a third of basis vector between two successive powder layers as depicted by figure 3.6. In the case of a contour scanning strategy, the contours were pre scanned for each powder layer with the same P and v_s used for the bulk (see figure 3.7). The scanning order among the samples was automatically chosen.

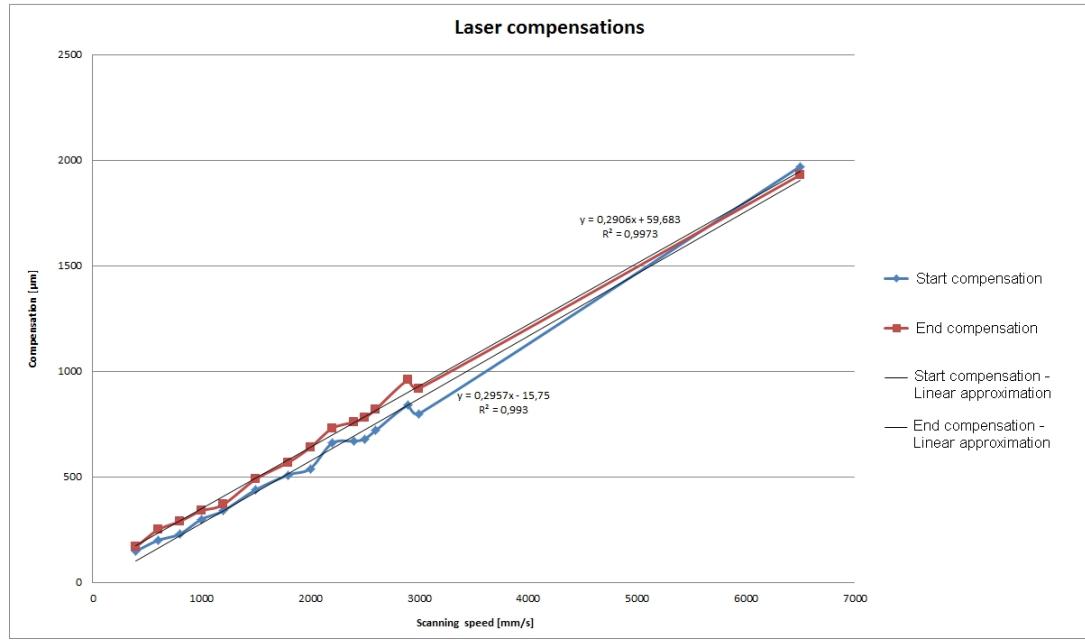


FIGURE 3.3: Laser compensations as a function of the scanning speed
(as recommended by the manufacturer).

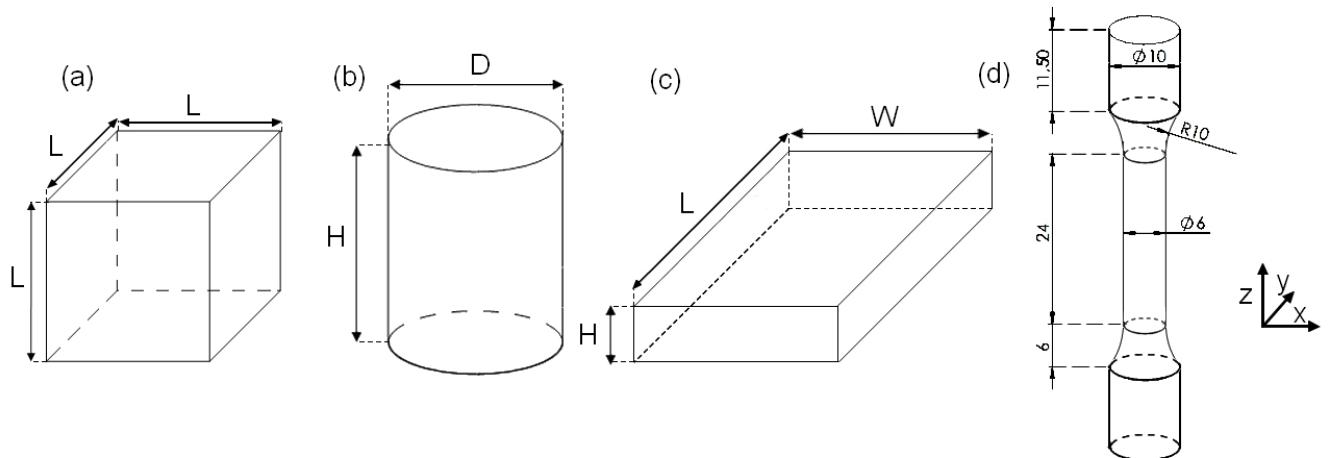


FIGURE 3.4: Dimensions notations for (a) cubic specimens (b) cylindrical specimens (c) parallelepiped specimens (d) tensile specimens with dimensions in [mm]

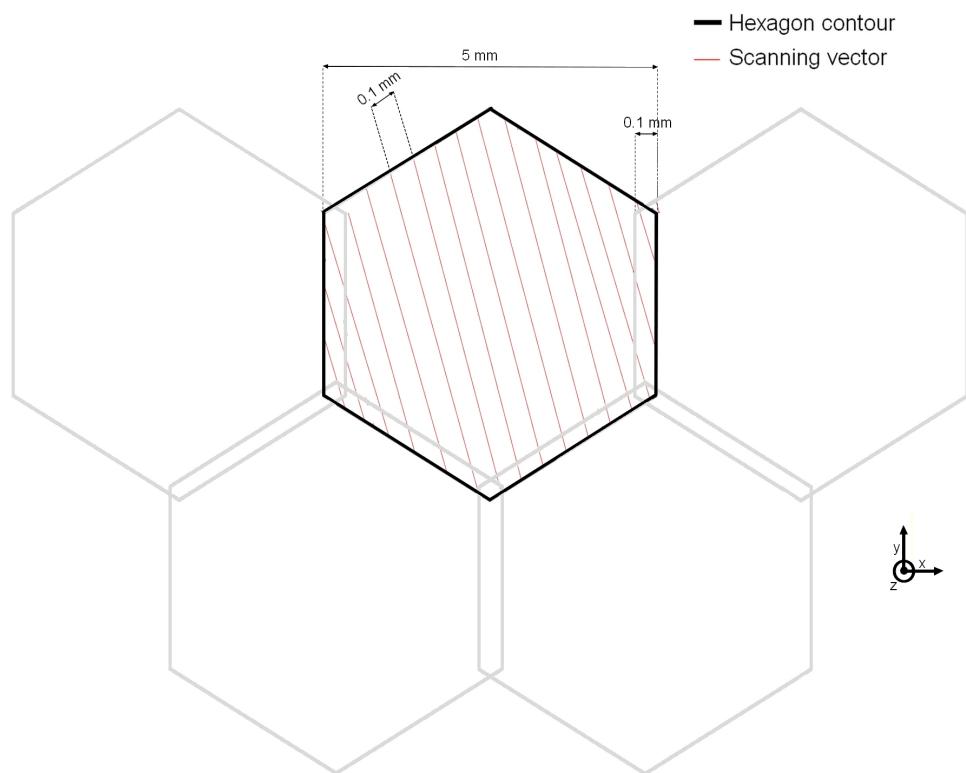


FIGURE 3.5: Schematic representation of the hexagonal pattern scanning strategy

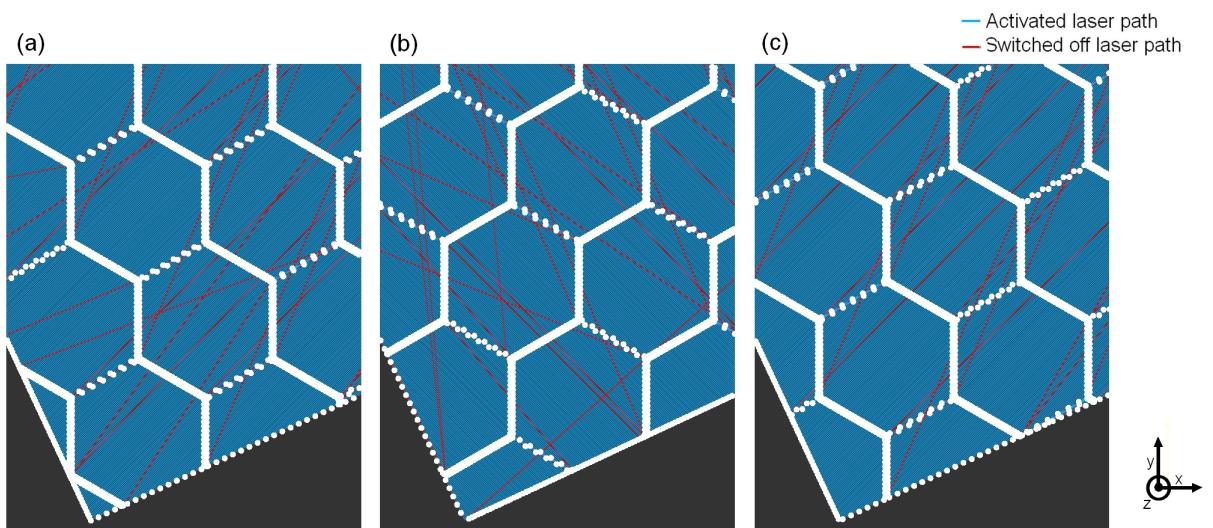


FIGURE 3.6: Laser scanning pattern for a parallelepiped sample: (a) Layer n (b) Layer $n + 1$ (c) Layer $n + 2$

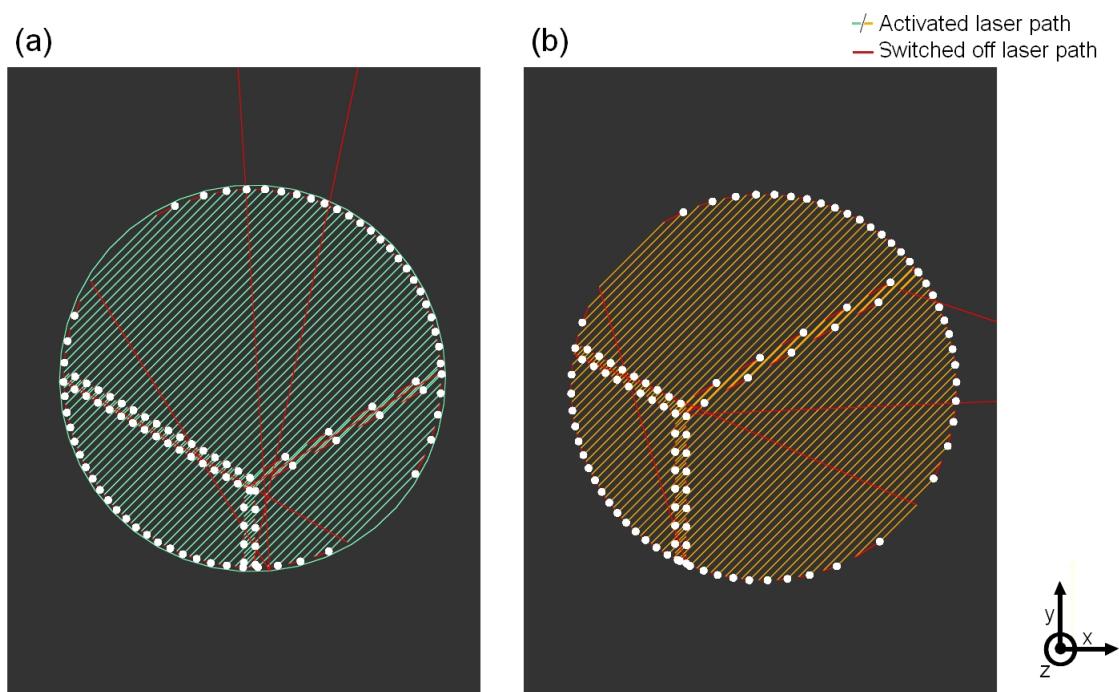


FIGURE 3.7: Screen capture of the laser path for a cylindric sample (a) with contour scanning strategy (b) without contour scanning strategy

3.3 Heat treatments

The heat treatments were conducted inside a unique oven of the VT 5050 EKP model, manufactured by Heraeus, which is able to reach a temperature of 400° C. Samples temperature data was obtained through a thermocouple welded to the sample surface, thanks to a [Méthode de soudage, élévation de la température durant l'opération] The data was displayed and saved every 10 seconds, with a precision of 0.1° C, thanks to a Agilent 34972A LXI Data Acquisition/Switching Unit, connected to the thermocouple (see Fig. for both devices). For unknown reasons, that can not be explained only by thermal inertia, setting the oven to the target temperature proved unable to heat the specimens to the same temperature. After a couple samples for testing, the method applied for following ones was to set the oven at a temperature about 20° C above the target, so that the data acquisition unit connected to the thermocouple displays the right temperature.

Due to the inaccuracy of the oven, maintaining the samples at the exact target temperature has not proved possible. The holding plateaus were thus rather slow increasing slopes. For most of the samples, the theoretical beginning of the holding was set when the specimen reached a temperature 5° C below the target value, so that the sample average temperature for the complete holding was the closest possible to target value.

Samples that were subject to a heat treatment were named in a particular format, to ease distinction between them. They received the name of the batch, followed by "TT-holdingtemperature-holdingtime-specificities". Cubes that were subject to heat treatments were 5 x 5 x 5 [mm³].

The main objective of most of the research about aluminium alloys AM is to obtain parts with properties at least as good as their conventional cast counterparts. To obtain a larger panel of properties, a vast number of heat treatments have been developed for die cast alloys. The classical treatment of stress-relief for aluminium consists of a heating up to 300° C, with a holding of 2 hours, followed by a slow cooling???. This treatment, and variations around him, have been tried on a number of additively manufactured samples, in order to assess their effect on the microstructure and mechanical properties of the parts.

A first series of cubic samples was manufactured using the optimised process parameters from Section 4.2.1, and a different heat treatment was applied to each one of them. The complete list of cubes treated can be found in Table ??.

Specimen	Holding time [min]	Aimed holding temp. [°C]	Max. temp. [°C]
X200-180220-TT150-2	120	150	-
X200-180220-TT200-2	120	200	-
X200-180220-TT300-2	120	300	256
X200-180220-TT300-2-plaque	120	300	281
X200-180220-TT150-2-real	120	150	156
X200-180220-TT200-2-real	120	200	203
X200-180220-TT250-2-real	120	250	255
X200-180220-TT300-2-real	120	300	302
X200-180220-TT300-1-real	60	300	302
X200-180220-TT360-1-real	60	360	371
X200-180220-TT300-5m	5	300	300

TABLE 3.1: List of the heat-treated specimens from batch X200-180220

3.4 Characterisation

3.4.1 Density

Hydrostatic weighing

Multiple methods were considered to estimate the relative density of the fabricated specimens. The first one is hydrostatic weighting (HW), or hydrodensitometry. It is a direct application of the well-known Archimedes' principle, which can be stated as follows: " When a body is (partially or totally) immersed in a fluid, the upthrust on the body is equal to the weight of fluid displaced." [7]. By weighing each pieces in air and in water - giving respectively values of dry weight W_a and underwater weight W_w - one can calculate the apparent density ρ_a [12]:

$$\rho_a = \frac{W_a}{W_a - W_w} \cdot \rho_w$$

where ρ_w is the water density. The apparent relative density $\rho_{a,rel}$ of the specimens can then be calculated with:

$$\rho_{a,rel} = \frac{\rho_a}{\rho_b}$$

where $\rho_b = 2.68[\frac{g}{mm^3}]$ is the theoretical bulk density of AlSi10Mg [23]. All weightings were done with a Sartorius BP121S analytical balance with precision of 0.1 [mg] [24]. Samples were immersed in demineralised water for more than twelve hours before the measurements to impregnate them. The weightings were also done in demineralised water. Water temperature was measured with a precision glass thermometer to compute ρ_w as accurately as possible thanks to tabulated values [28]. Multiple measurements were done for each sample in order to increase the method's reliability.

The technique was employed with "as-built" and polished cubes. For this second option, all six faces of the tested cubes were polished with P320 silicon carbide sandpaper sheets and briefly with P1200 ones. In most cases, the tests were done with samples of volumes $\simeq 1[cm^3]$ and weights $\simeq 2.5[g]$.

Relative optical density image analysis

Another method was used to estimate the relative density of the various samples: the relative optical density image analysis (RODIA). For this purpose, the samples were cut with a micro-cutting machine and underwent the polishing routine detailed in table 3.2. Pictures of the polished sections were then taken under the optical microscope. An *Olympus AX70* microscope was used, with 5x and 10x magnification. The pictures were taken with a smart-phone through the lens of the microscope. The used camera has a resolution of 16 [MP]. A camera is directly connected to the microscope at the laboratory, but it only has 5 [MP] resolution. It was thus chosen not to use it.

With the help of the *ImageJ* software, the surface of both the porosities and the whole surface could be isolated for each analysed image (see figure 3.8). The surface fraction occupied by porosities could then be obtained as the ratio between the areas of the two (in pixels). If we approximate that the porosities surface fraction is equal to the volumetric one, that method gives an estimation of the relative density ρ_{rel} .

Step	Polishing surface	Abrasive	Grain size	Lubricant type	Rotation speed [rpm]
1	MD-piano 220	Diamond	P220	Water	200-300
2	MD-piano 1200	Diamond	P1200	Water	200-300
3	MD-largo	DP-spray	9 μm	Alcohol	150
4	DP-DAC	DP-spray	3 μm	Alcohol	150
5	DP-NAP	DP-spray	1 μm	Alcohol	150

TABLE 3.2: Polishing routine for Al-Si alloys

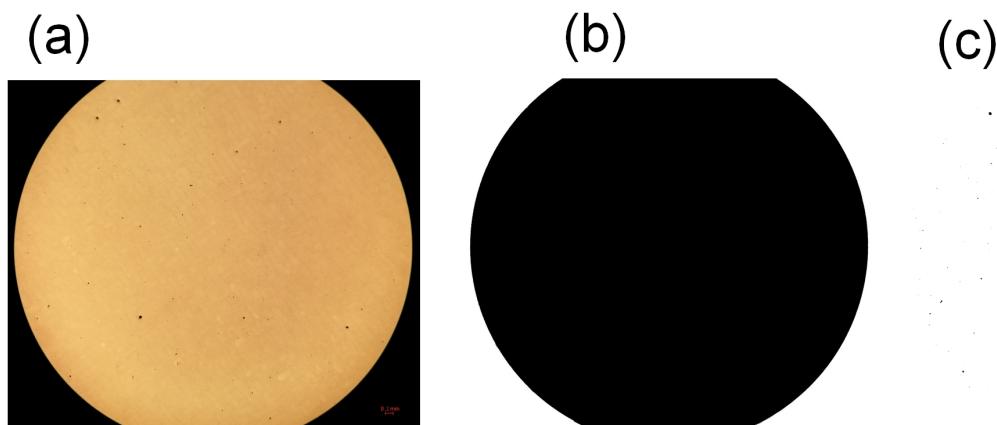


FIGURE 3.8: RODIA procedure for specimen X200-180319-cub 1: (a) Original picture of polished section (b) Whole surface isolation with *ImageJ* (c) Porosities isolation with *ImageJ*.

The images isolations in "foregrounds" and "backgrounds" were done through manual thresholding based on pixel intensity quantifications. An optimal threshold was sought for porosities isolation so as to include only holes, and as many as possible. Particular attention was given to the photography in order to obtain the best

contrast, focus and intensity homogeneity. Between two and five photographs were taken for each specimen to build a representative sample.

3.4.2 Microstructure

Scanning electron microscopy

Optical microscopy

Mesures Taille de bains Densité Autre chose?

3.4.3 Composition

3.4.4 Residual stresses

Measurements of residuals stresses was performed by ..., in ..., Malta. Four parallelepiped specimens were specifically built for these tests. Their dimensions was $x \times x$ [mm³]. After undergoing their heat treatments, they were machined électro-découpage, removing the least matter possible, and shipped to Malta. Machining was done in order to reduce rugosity on the top and bottom faces of the samples, because smooth surfaces are necessary for the correct fixation of the probes.

3.4.5 Mechanical properties

Hardness test

Vickers hardness measurements were made with a *Wolpert Dia-Testor 2RC* tester. All analysed specimens were previously cut with a micro-cutting machine. This permitted the testing of the bulk hardnesses of the samples (at least at a few millimetres from the original surfaces). For each test, a pyramidal indenter (see figure 3.9) was pressed during 10 [sec] onto the material with a load of 10 [kg]. The indentation durations were measured with a digital timer and the tests were stopped manually. The two diagonals lengths of the resulting indents were then evaluated using a ruler on the screen of the machine, which displays the image of the sample's surface that is captured by an embedded optical microscope.

Three to ten tests were made for each sample and the mean diagonal length value was computed for every test. The corresponding Vickers hardness values H_v could then be estimated by means of a conversion table (see C).

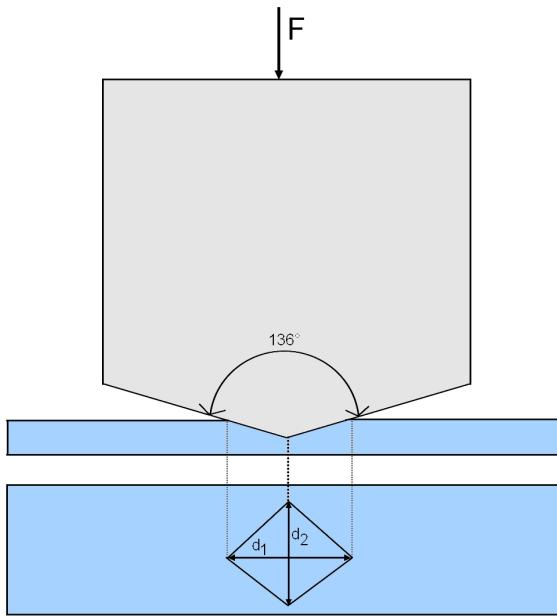


FIGURE 3.9: Schematic representation of the Vickers hardness test

Tensile tests

The tensile tests were performed on a *RetroLine testControl II* screw-driven electro-mechanical testing system manufactured by *Zwick Roell*. It works in the following manner:

- The cylindrical specimen is clamped on its extremities with grips. Both of them are fixed to a cross head (see figure 3.10).
- Parameters are selected thanks to a software connected to the machine: One must enter the extensometer initial gauge length L_0 , the cross head speed and the pre load (used to limit the backlash in the assembly). The initial minimal value d_o for the specimen diameter is also measured with a digital calliper and specified in the program.
- The contact extensometer is placed on the sample. Its purpose is to measure the length change ΔL during the test.
- The lower cross head goes down. This induces a force F and a displacement in the specimen, both of which are saved in an *Excel* file. The test goes on until the fracture of the specimen occurs, unless if it is stopped beforehand.

The tensile specimens used all originated from batch X200-190417. They were fabricated using the optimised set of parameters: $P = 0.75\%P_{max}$ and $v_s = 1200[\frac{mm}{s}]$. Their minimal diameter is equal to 6 [mm]. Further details about their geometry and heat treatments can be consulted respectively in sections 3.2 and 3.3. For each test, the extensometer gauge length was set to 18 [mm]. This is approximately the maximal possible value, given the short length of the specimens. A pre load of 15 [N] was adopted and a cross head speed of $1[\frac{mm}{min}]$ was chosen in accordance with what had been done in a previous work at UCL. It was decided to interrupt the tensile tests of one AB specimen and of two others - that underwent heat treatments at 200°C and

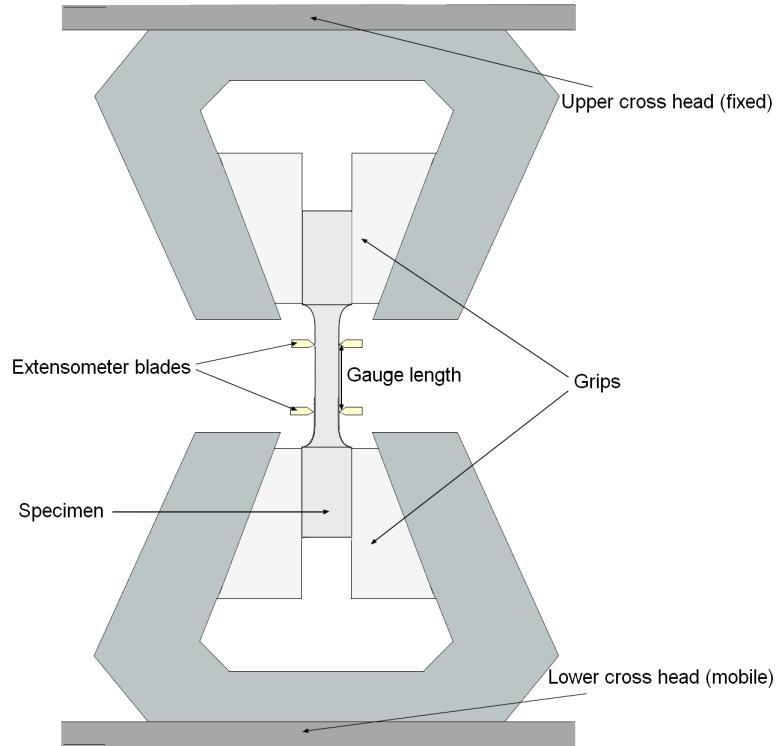


FIGURE 3.10: Schematic representation of the tensile test mounting

300°C. In that way, the damage mechanisms could be observed afterwards. Table 3.3 regroups the strain limits at which the tests were stopped. They correspond roughly to the onset of necking.

Sample	Strain limit [-]
X200-180417-3	0.01
X200-180417-6	0.06
X200-180417-9	0.08

TABLE 3.3: Strain limits for interrupted tensile tests of batch X200-180417 specimens

A tensile test can be used to compute multiple properties. First of all, the engineering stress (σ_{eng}) and strain (ϵ_{eng}) were computed at each time step for every tested samples. The formulas below were used:

$$\sigma_{eng} = \frac{F}{A_0} = \frac{F}{\frac{\pi d_0^2}{4}}$$

$$\epsilon_{eng} = \frac{\Delta L}{L_0} = \frac{L - L_0}{L_0}$$

On the basis of the stress-strain curve, the following characteristics could be computed:

- The Young's modulus E : it is used to characterize the stiffness of a material. The tested specimen first deforms elastically, which corresponds to a linear strain-strain relationship. The slope value for the corresponding part of the curve is E . It is found with:

$$E = \frac{\sigma_{eng}(\epsilon_b) - \sigma_{eng}(\epsilon_a)}{\epsilon_b - \epsilon_a}$$

where strains ϵ_a and ϵ_b are respectively equal to 0 and $\simeq 0.1\%$.

- The elastic limit σ_y : it is the σ_{eng} at which the plastic strain (non-linear) becomes non negligible. The 0.2 [%] criterion was used. In this manner, σ_y is found as the intersection of the stress-strain curve with the line of slope E passing through point $(\epsilon, \sigma)=(0.2\%, 0[MPa])$.
- The ultimate tensile strength σ_u : it is simply the maximal σ_{eng} attained during the test.
- The strain at fracture ϵ_f : in the case of fragile fracture, the value of ϵ_{eng} at the end of the test could be used. However, if the specimen underwent a necking mechanism - as there is strain localisation - the final ϵ does not constitute a good approximation. In that case, the specimen final minimal diameter d_f was measured with a profile projector. The true final strain $\epsilon_{f,true} = \ln(\frac{L_f}{L_0})$ could then be computed using the volume conservation hypothesis:

$$L_0 \cdot A_0 = L_f A_f$$

which implies that $\epsilon_{f,true} = \ln(\frac{A_0}{A_f}) = \ln(\frac{d_0^2}{d_f^2})$. All the properties mentioned above are illustrated in figure 3.11.

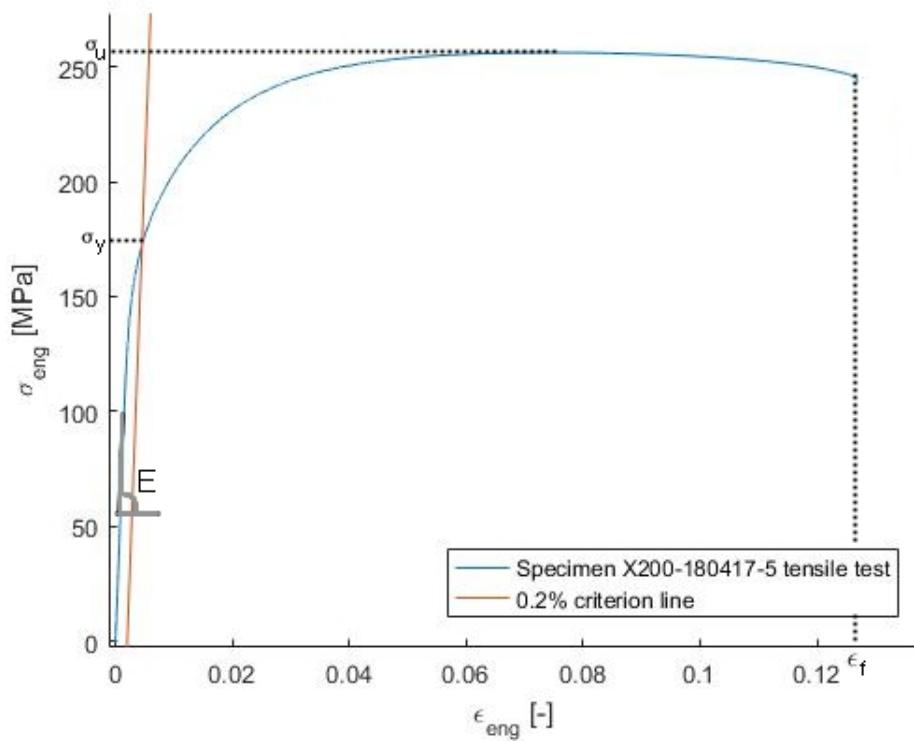


FIGURE 3.11: Tensile stress-strain curve for specimen X200-180417-5
with annotated key features

Chapter 4

Results

4.1 Powder ageing

4.1.1 Grain size and distribution

Fresh powder

Recycled powder

4.1.2 Composition

Fresh powder

Recycled powder

Faire graphe avec barres d'erreurs

Date of sampling	Composition [%wt]			
	Al	Fe	Mg	Si
23/10/2017	89.2	0.12	0.49	10.2
09/01/2018	89.3	0.13	0.48	10.1
12/01/2018	89.4	0.13	0.48	10
21/02/2018	89.1	0.19	0.51	10.3
13/03/2018	89.1	0.16	0.51	10.1

TABLE 4.1: Composition of recycled AlSi10Mg powder as a function of the date

4.2 Density and hardness study

4.2.1 Optimisation of the SLM parameters

The optimisation of the manufactured samples properties was done with respect to $\rho_{a,rel}$ and H_v . For this purpose, twelve cubes were fabricated with P varying from 0.75% P_{max} to P_{max} and v_s from 900 to 1500 [$\frac{mm}{sec}$]. Details about batch X200-171024 are given in appendix A. The goal of this optimisation was to select a single set of parameters values to use in the rest of the thesis. The parameters values were chosen to cover a wide range of E_d . Sets of parameters ($P = 75\%P_{max}$; $v_s = 1200[\frac{mm}{sec}]$) and ($P = 75\%P_{max}$; $v_s = 900[\frac{mm}{sec}]$) gave the best results in terms of $\rho_{a,rel}$ in a previous study done at UCL. It was decided to produce samples with these sets of values in triplicate in order to have a first insight on the process reproducibility. This will be

discussed further in next section. Here, only the mean H_v and $\rho_{a,rel}$ of those samples will be compared to the others'.

Results for the measurements of $\rho_{a,rel}$ and H_v are summarised in figure 4.1 and detailed in appendix A. The 95% confidence intervals (CI) are drawn on the graphs. The methods used to compute them are described in appendix D. All apparent relative density values were obtained through hydrostatic weighing of the unpolished AB specimens.

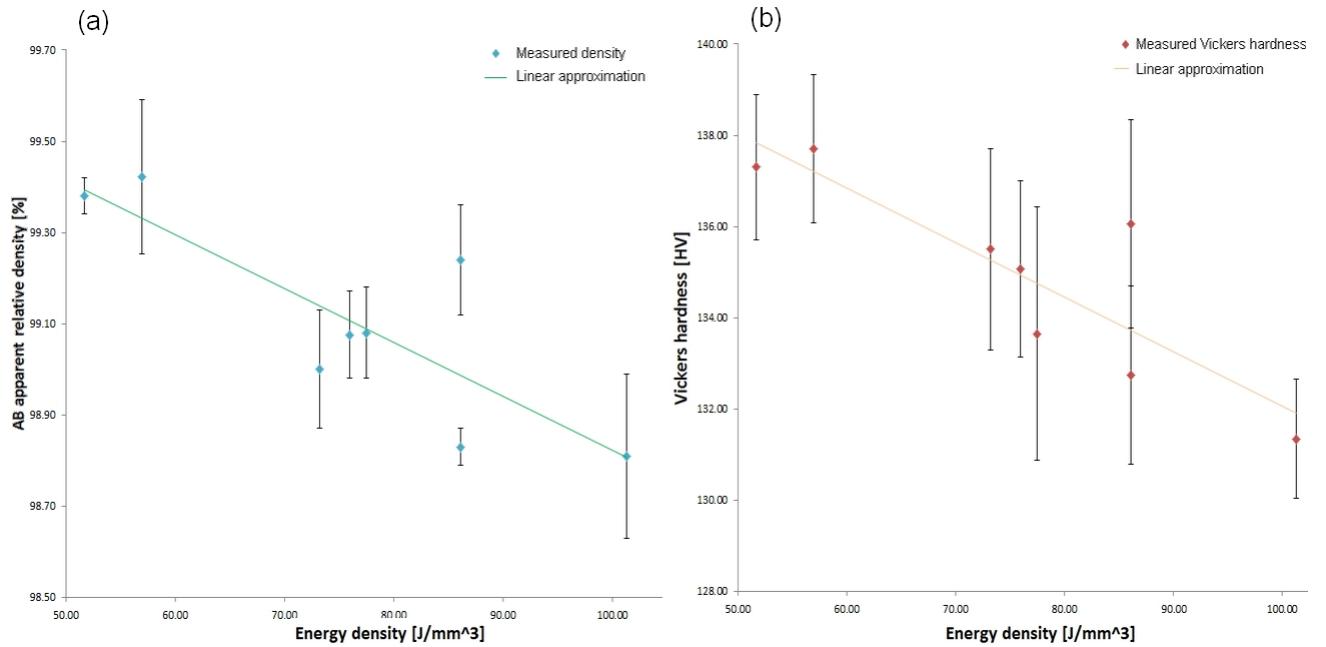


FIGURE 4.1: Batch X200-171024 samples properties as a function of the energy density: (a) as-built apparent relative density (b) Vickers hardness

The graph shows a general progressive decrease of $\rho_{a,rel}$ and H_v for $E_d > 57[\frac{J}{mm^3}]$. The lower density and hardness measures at $E_d \simeq 86.12$ correspond to the parameters values ($P = P_{max}$; $v_s = 1059[\frac{mm}{sec}]$).

4.2.2 Reproducibility

General results

Batch X200-171024 uncovered a reproducibility issue. One sample of type ($P = 75\%P_{max}$; $v_s = 900[\frac{mm}{sec}]$) had a relative density $\simeq 5\%$ lower to the others ($\rho_{a,rel} = 98.77\%$). It was decided to produce a batch of fifteen ($P = 75\%P_{max}$; $v_s = 1200[\frac{mm}{sec}]$) cubic samples and fifteen ($P = 75\%P_{max}$; $v_s = 900[\frac{mm}{sec}]$) others in order to assess the process reproducibility when using a same powder. The two sets of parameters were used to compare the results for optimal and sub-optimal set values. A total of 18 samples were fabricated close to one another (see A.4) to see if the specimens rapprochement has any effect on their final properties. The apparent relative density was once more measured with the unpolished AB samples.

Hardness and apparent relative density results for batch X200-180109 are shown in appendix A. The key information is displayed in tables 4.3 and 4.4. Type ($P = 75\%P_{max}$; $v_s = 900[\frac{mm}{sec}]$) samples exhibited slightly poorer properties than type ($P = 75\%P_{max}$; $v_s = 1200[\frac{mm}{sec}]$) ones in average. However, the former have far better properties to what one could have expected based on previous results (see table 4.2). The highest measured density is 99.54 [%].

Type	$\bar{\rho}_{a,rel}$ [%]	$SD_{\rho_{a,rel}}$ [%]	\bar{H}_v [HV]	SD_{H_v} [HV]
($P = 75\%P_{max}$; $v_s = 1200[\frac{mm}{sec}]$)	99.42	0.08	138	0.4
($P = 75\%P_{max}$; $v_s = 900[\frac{mm}{sec}]$)	99.08	0.27	135	1.3

TABLE 4.2: Standard deviations and average values for apparent relative densities and hardnesses of the specimens of batch X200-171024

Type	$\bar{\rho}_{a,rel}$ [%]	$SD_{\rho_{a,rel}}$ [%]	\bar{H}_v [HV]	SD_{H_v} [HV]
($P = 75\%P_{max}$; $v_s = 1200[\frac{mm}{sec}]$)	99.40	0.09	139.9	0.87
($P = 75\%P_{max}$; $v_s = 900[\frac{mm}{sec}]$)	99.36	0.11	138.3	1.3

TABLE 4.3: Standard deviations and average values for apparent relative densities and hardnesses of types the specimens of batch X200-180109

Type	$min(\rho_{a,rel})$ [%]	$max(\rho_{a,rel})$ [%]	$min(H_v)$ [HV]	$max(H_v)$ [HV]
($P = 75\%P_{max}$; $v_s = 1200[\frac{mm}{sec}]$)	99.24	99.52	138.6	141.4
($P = 75\%P_{max}$; $v_s = 900[\frac{mm}{sec}]$)	99.18	99.54	134.6	140.4

TABLE 4.4: Minimal and maximal values for apparent relative densities and hardnesses of the specimens of batch X200-180109

Sample proximity and position influence

The results are displayed in figure 4.2 as functions of the (x,y) positions of the samples on the manufacturing plate. The coordinates are such that the roll sweeps were done in the positive x direction during the fabrication. Other graphs showing the averaged $\rho_{a,rel}$ and H_v as functions of the x and y coordinates were also plotted. To do so, the samples distanced from less than 1 [cm] along x or y were considered to have the same corresponding coordinate. The graphs are shown in appendix E. No significant trend was observed on these graphs: the variations of hardnesses and relative densities are too small compared to the CI.

A comparison of the results for closely packed samples ($y < 6$) and distant ones ($y > 6$) was also carried out. The details are shown in tables 4.5 and 4.6. Again, no significant distinction could be drawn between the two.

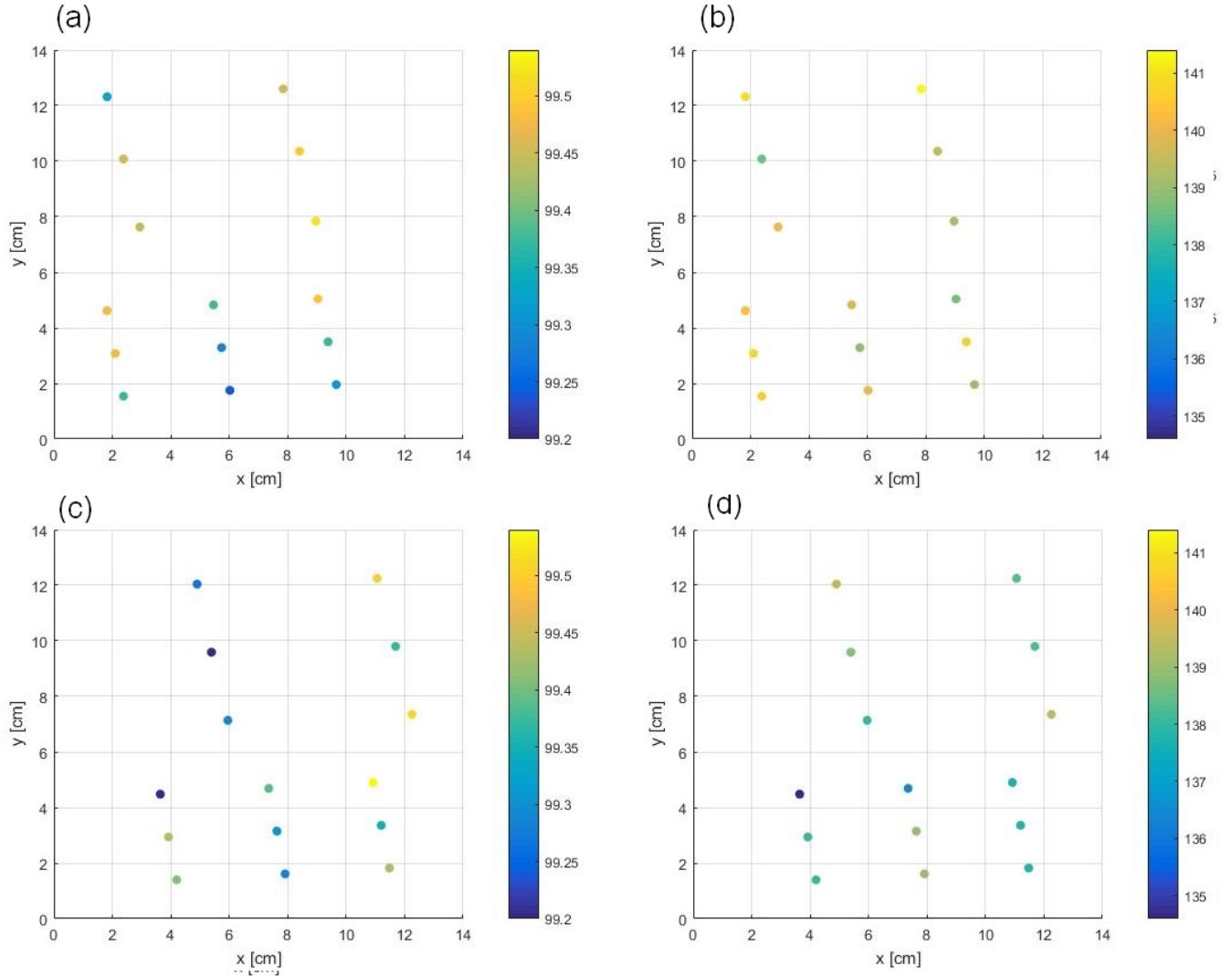


FIGURE 4.2: Batch X200-180109 scatter plots as functions of the (x,y) position on the manufacturing plate: (a) type ($P=0.75 P_{max}$; $v_s=1200 \frac{mm}{sec}$) apparent relative densities (b) type ($P=0.75 P_{max}$; $v_s=1200 \frac{mm}{sec}$) hardnesses (c) type ($P=0.75 P_{max}$; $v_s=900 \frac{mm}{sec}$) apparent relative densities (d) type ($P=0.75 P_{max}$; $v_s=900 \frac{mm}{sec}$) hardnesses

Type	Position	$\bar{\rho}_{a,rel}$ [%]	$SD_{\rho_{a,rel}}$ [%]	H_v [HV]	SD_{H_v} [HV]
$(P = 75\%P_{max}; v_s = 1200[\frac{mm}{sec}])$	y>6	99.45	0.07	140.0	1.1
	y<6	99.38	0.07	139.9	0.7
$(P = 75\%P_{max}; v_s = 900[\frac{mm}{sec}])$	y>6	99.36	0.10	138.7	0.6
	y<6	99.37	0.08	138.0	1.6

TABLE 4.5: Standard deviations and average values for apparent relative densities and hardnesses of types the specimens of batch X200-180109

Type	Position	$min(\rho_{a,rel})$ [%]	$max(\rho_{a,rel})$ [%]	$min(H_v)$ [HV]	$max(H_v)$ [HV]
$(P = 75\%P_{max}; v_s = 1200[\frac{mm}{sec}])$	y>6	99.33	99.52	138.6	141.4
	y<6	99.24	99.49	138.7	140.9
$(P = 75\%P_{max}; v_s = 900[\frac{mm}{sec}])$	y>6	99.20	99.51	138.0	139.5
	y<6	99.29	99.54	134.6	140.4

TABLE 4.6: Minimal and maximal values for apparent relative densities and hardnesses of the specimens of batch X200-180109

Scan order influence

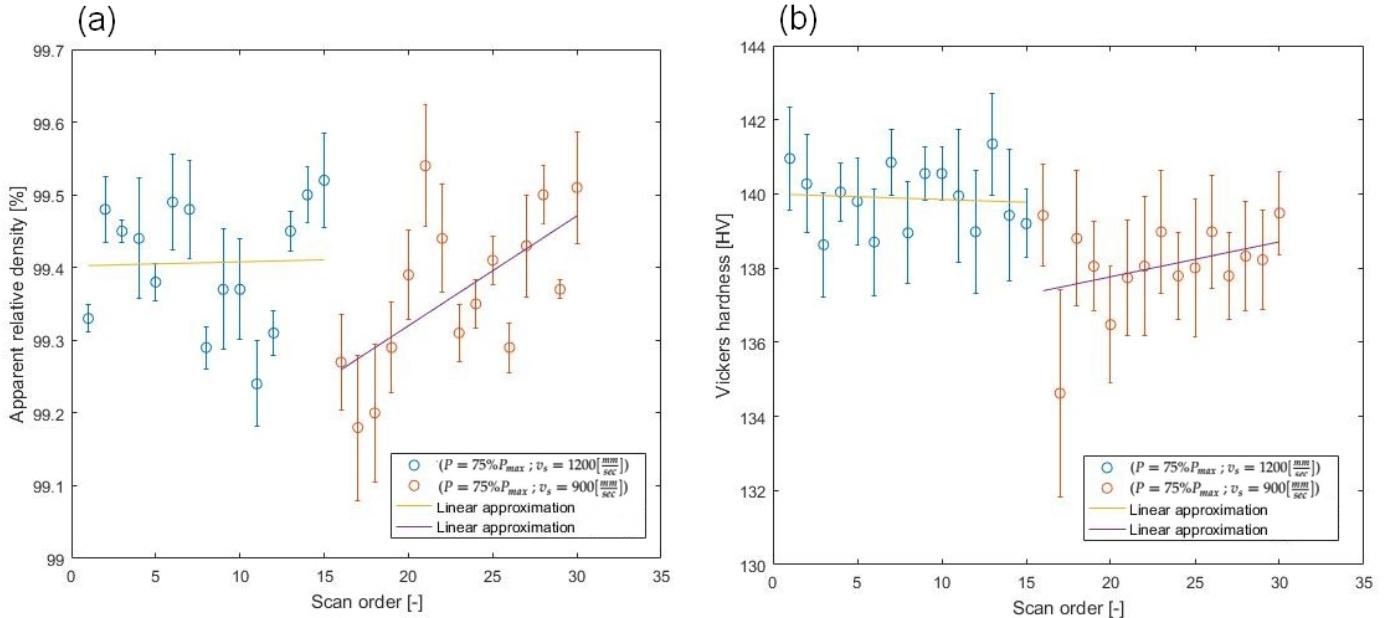


FIGURE 4.3: Batch X200-180109 scatter plots as functions of the scan order of (a) the apparent relative densities (b) the Vickers hardness

4.2.3 Homogeneity

As said in section 3.2, all tensile specimens were fabricated vertically. Their height is significantly greater than the other samples'; respectively 6 [cm], and 1 [cm] or less. It was chosen to cut up specimen X200-180417-25 into slices to measure if the density and hardness were homogeneous along the Z direction in the material. The surfaces analysed were named according to their original Z position in the specimen with

"B", "C1", "C2", "C3" and "T" (for bottom, center and top) and to the test done with a letter "D" or "H" (for density and hardness). The denomination is summarised in figure 4.4.

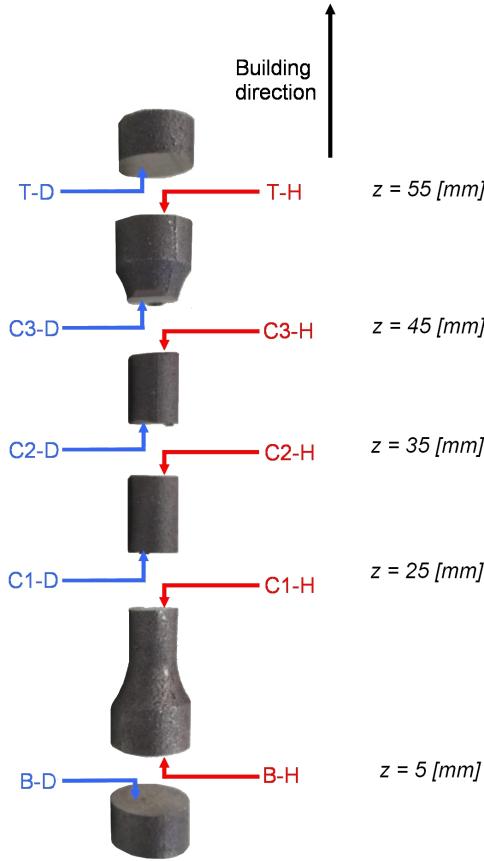


FIGURE 4.4: Specimen X200-180417-25 sub-parts and surfaces de-nomination.

Results are shown in figure 4.5. With regard to hardness, no general trend could be observed. The measured values are high and closely packed except for the "B" surface, which exhibited a significantly lower hardness. Density values are all equal or above 99.75 [%]. The values at the center of the sample were slightly lower to the extremities'. A summary of the results is displayed in table 4.7.

Property	Average value	Minimum	Maximum	Standard deviation
Relative density [%]	99.80	99.75	99.87	0.05
Hardness [HV]	138.0	132.2	141.7	3.5

TABLE 4.7: Relative density and hardness results summary for specimen X200-180417-25 surfaces

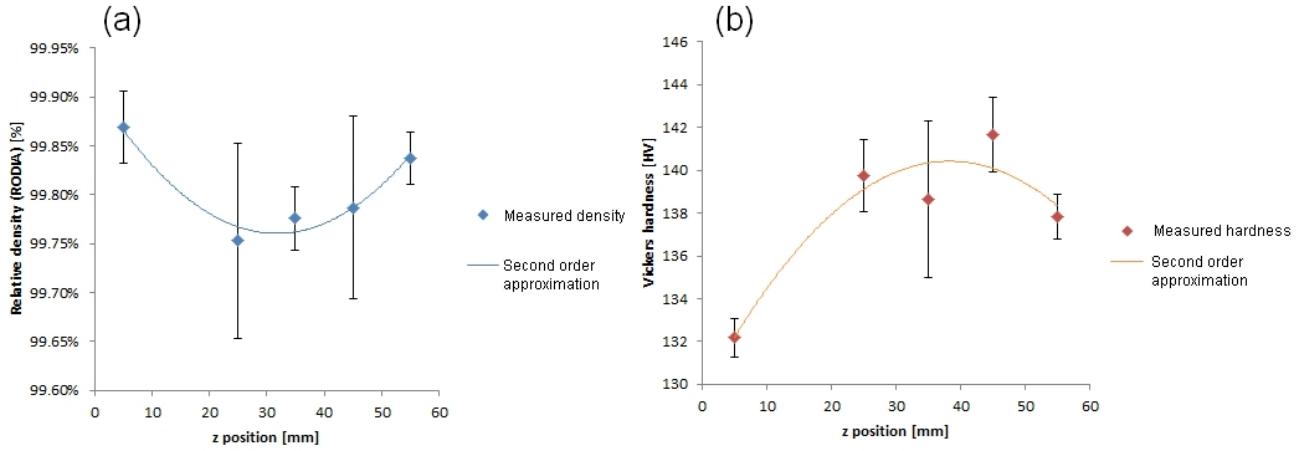


FIGURE 4.5: Scatter plots of the results for specimen X200-180417-25 surfaces as a function of the vertical position: (a) RODIA based relative density (b) Vickers hardness

4.3 Characterisation of the as-built samples

4.3.1 Melt pools sizes and distribution

4.3.2 Microstructure

4.3.3 Residual stresses

4.3.4 Mechanical properties

The average tensile properties of the as-built specimens are displayed in table 4.9. Detailed information may be consulted in appendix B. Very similar behaviours were observed for samples with and without contour scanning strategy. No distinction shall thus be made between the two in what follows. [Critère de considère]

E [GPa]	σ_y [MPa]	σ_u [MPa]	ϵ_f [%]
64.9 ± 3.0	266.6 ± 23.6	381.7 ± 24.7	2.5 ± 0.5

TABLE 4.8: Average tensile mechanical properties of the as-built specimens from batch X200-180417

4.4 Characterisation of the heat-treated samples

4.4.1 Microstructure

4.4.2 Residual stresses

4.4.3 Mechanical properties

Parler de RAMBERG-OSGOOD

HT	E [GPa]	σ_y [MPa]	σ_u [MPa]	$\epsilon_{f,eng}$ [%]	$\epsilon_{f,true}$ [%]
150°C (2h)	68.4 ± 1.9	288.2 ± 1.4	441.7 ± 5.5	5.5 ± 0.8	-
200°C (2h)	72.1 ± 0.4	245.4 ± 0.6	382.0 ± 11.4	4.6 ± 0.3	-
250°C (2h)	70.6 ± 1.0	235.1 ± 7.4	340.9 ± 12.2	8.8 ± 0.2	16.5 ± 0.1
300°C (2h)	68.9 ± 0.6	170.7 ± 1.7	252.9 ± 10.4	13.6 ± 0.5	29.7 ± 0.1

TABLE 4.9: Average tensile mechanical properties of the heat-treated specimens from batch X200-180417

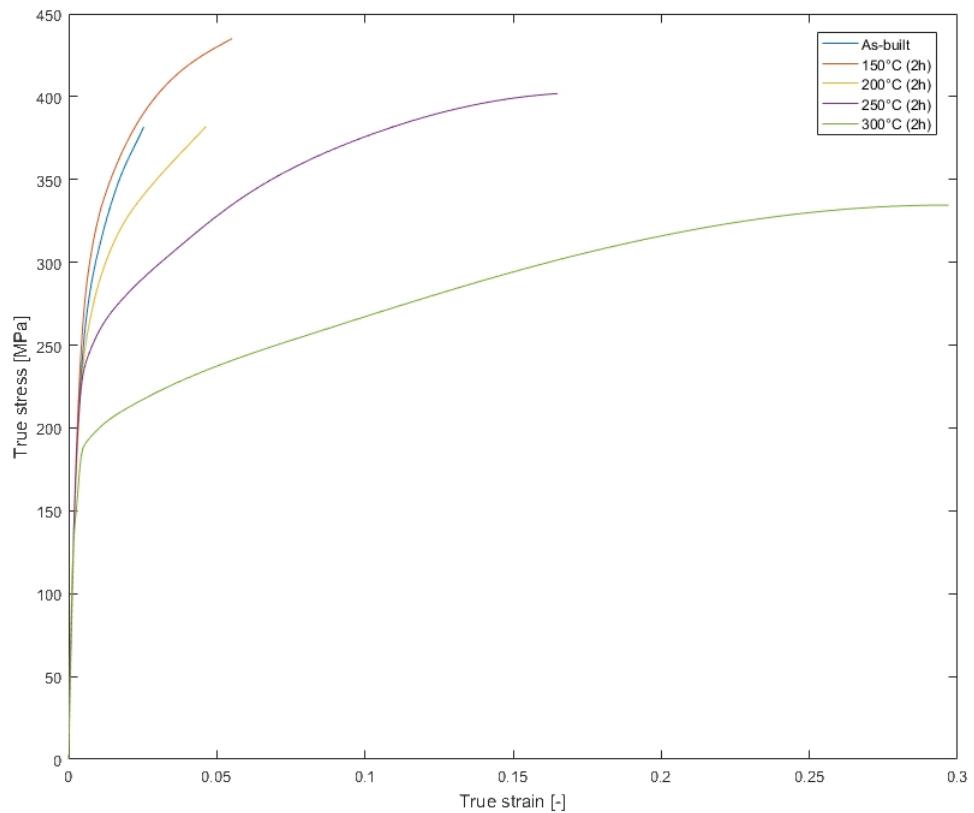


FIGURE 4.6: Average stress-strain curves of the tensile specimens of batch X200-180417.

Chapter 5

Discussion

Que conclure d'après les résultats?

5.1 Powder ageing

5.1.1 Grain size and distribution

5.1.2 Composition

5.2 Density measures assessments

5.2.1 Measures comparison

Several methods were used to measure the densities of the specimens throughout this work: hydrodensimetry (both with and without preliminary polishing) and RODIA. The different techniques were performed on a few specimens in order to draw a comparison of the results and reach a deeper understanding of the methods reliability. The results are gathered on figures

One can expect the first option to reduce the risks of air trapping by the surface roughness during the underwater weighing, which can distort the results (by overestimating the closed porosities volume).

5.2.2 Relative optical density image analysis

The estimation of the relative density through RODIA can be distorted on many grounds. First, the distribution of porosities is inhomogeneous on the analysed surface. Multiple photos must thus be taken with a systematic manner for each specimen to constitute a representative sample.

Second, the quality of the photographs has a critical role. The isolation of the porosities during the thresholding requires a substantial difference of pixel intensity between the holes and the material. Since some porosities and some zones of the material can appear respectively brighter or darker than was expected, there are risks that one isolates spots and/or not actual porosities. Additionally, the thresholding is manual and thus prone to slight human errors.

Most importantly, the finite resolution of the camera implies that sufficiently small porosities are not visible on the pictures.

One can expect the the density measurement through RODIA to be a biased method, due to the discretisation in pixels among other things. Results for pictures

with different magnifications were compared to quantify these effects. For this purpose, a picture was taken under 5x magnification and two under 10x magnification. The former was delimited to match the visible zones on the latter (see figure 5.1). The same two zones - named A and B - were thus analysed for different levels of resolution.

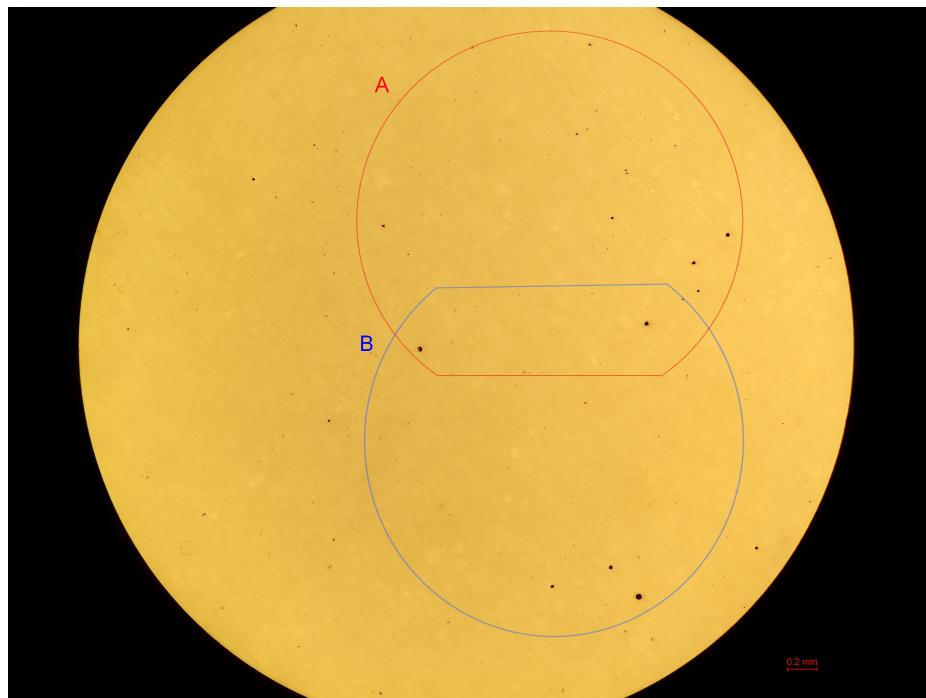


FIGURE 5.1: 5x magnification picture of specimen X200-180319-cub1 and delimitation of the zones A and B

The comparison of figures 5.3 (b) and (d) shows that much more small porosities are isolated if the resolution is refined. This is confirmed by the histograms on figure 5.2. The threshold of porosity area for detection in the case of 5x magnification is $0.5625 \text{ } [\mu\text{m}^2]$ whereas it is $0.14 \text{ } [\mu\text{m}^2]$ for 10x magnification. This area corresponds to a pixel in each case. It is also worth noting that there is an overall tendency to overestimate the areas at lower resolution, which counterbalances slightly the low number of detected porosities.

The RODIA results for zones A and B are outlined in table 5.1. It was observed that pictures with lower resolution have the tendency to lead to the overestimation of the relative density. The order of magnitude of the difference is of few hundredths of percent. The method is thus presumably positively biased. However, the observed effect is minor: this is probably due to the fact that the undetected porosities are the smallest, which influence the less the calculated density value.

Taking pictures at refined magnification could be considered to better the precision of the method. This would, however, require to augment the number of analysed pictures to have a sample of pictures as representative. A picture with doubled

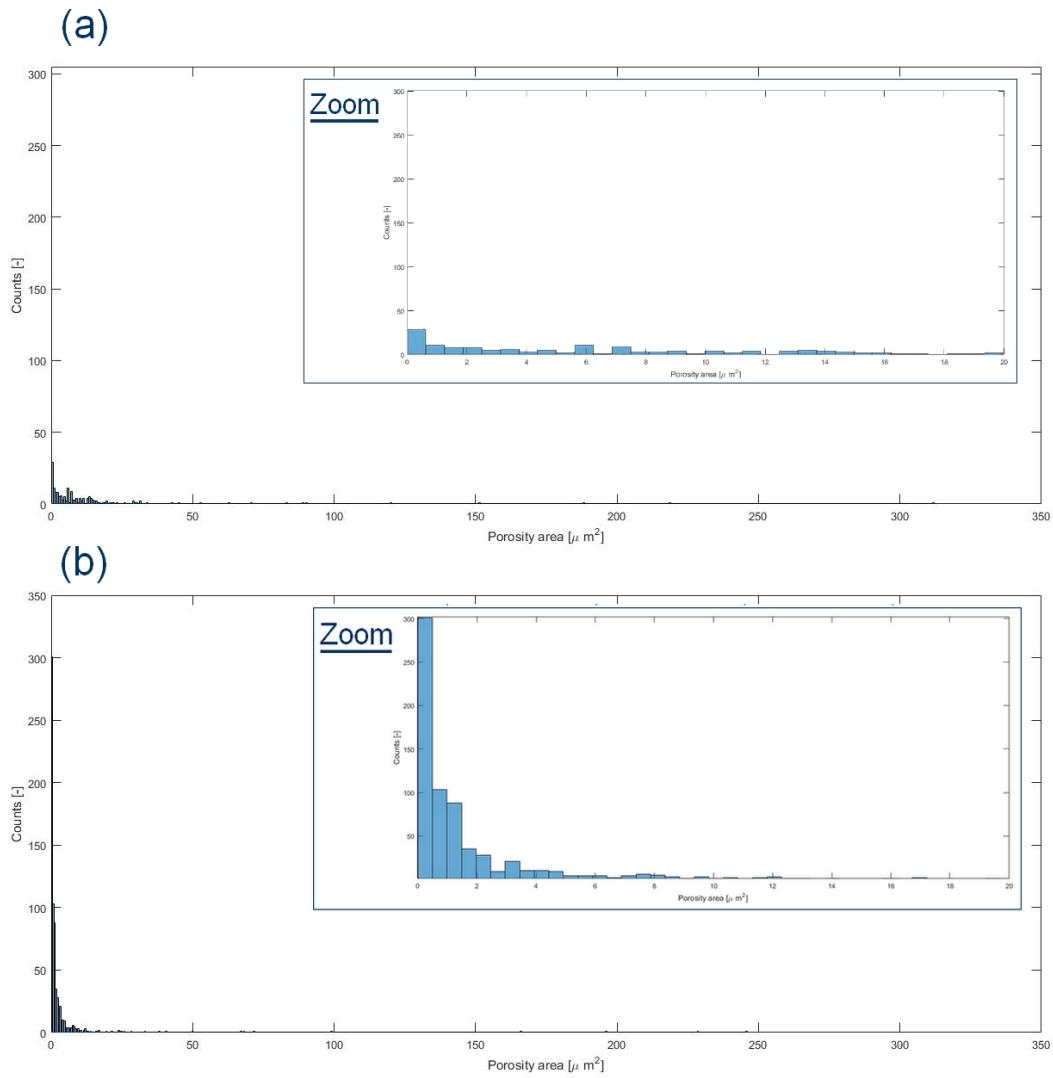


FIGURE 5.2: Histograms of porosities areas occurrences from pictures of specimen X200-180319 on zone A under (a) 5x magnification (b) 10x magnification.

magnification covers indeed four times less surface. The number of analyses should thus be quadrupled to take as much information into account.

[PARLER AUSSI DE L'APPROX de FRACTION SURFACIQUE DES PORES = A LA VOLUMIQUE]

Zone	Magnification	Measured relative density [%]
A	5x	99.87
A	10x	99.84
B	5x	99.86
B	10x	99.85

TABLE 5.1: RODIA results for zones A and B of specimen X200-180317 with 5x and 10x magnification

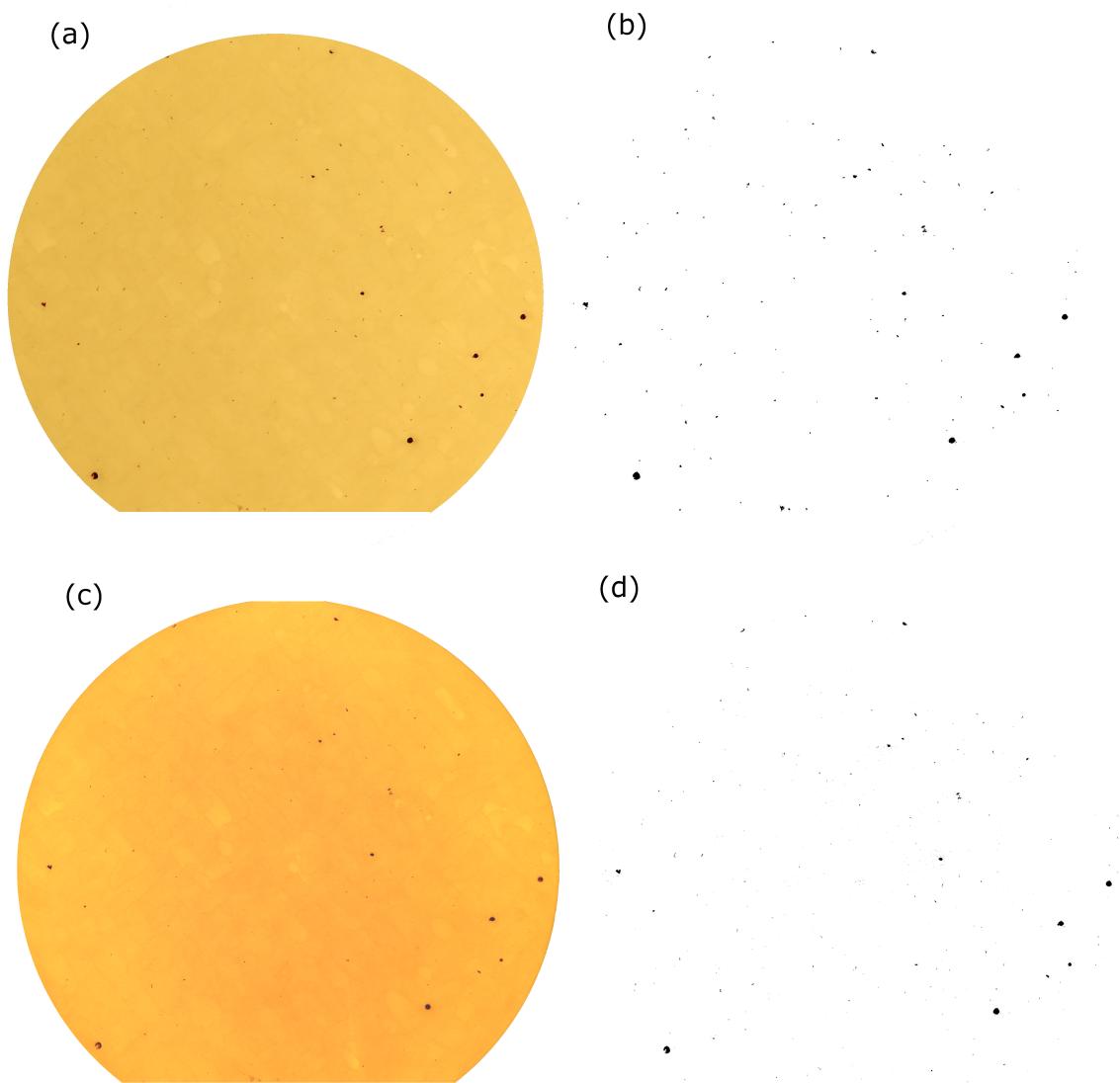


FIGURE 5.3: Zone A of specimen X200-180319-cub1: (a) Delimitation from original picture under 5x magnification (b) Porosities isolation from 5x magnification picture (c) Original picture under 10x magnification (d) Porosities isolation of 10x magnification picture

5.3 Density and hardness study

5.3.1 Parameters optimisation

5.3.2 Reproducibility

5.4 Characterisation of the as-built samples

5.4.1 Melt pools sizes and distribution

5.4.2 Microstructure

5.4.3 Residual stresses

5.4.4 Mechanical properties

5.5 Characterisation of the heat treated samples

5.5.1 Heating process

Quand on chauffe à 300 deg, on chauffe déjà longtemps à plus de 200 deg

5.5.2 Microstructure

5.5.3 Residual stresses

While the usual stress-relief treatment for aluminium alloys -to hours holding at 300° C- does indeed relieve stresses inside the specimen, it also triggers significantly the diffusion of alloying elements, altering the material microstructure.

5.5.4 Mechanical properties

5.5.5 Optimisation

Chapter 6

Conclusion

They incorporate in a synthetic way the main results and compare them with the initial objectives. Generally, this final chapter also presents prospects for the continuation of the work undertaken.

Appendix A

Batches fabrication and hardness/density measurements details

A.1 Process parameters and measured hardness/density properties

All manufacturing set values are gathered in table A.1. Dimensions of the cubic, cylindrical and parallelepiped specimens are noted in accordance with figure 3.4.

Batch name	Contour	Type	Dimensions [mm]	Specimen name	$\frac{P}{P_{max}} [-]$	$v_s [\frac{mm}{s}]$	$E_d [\frac{J}{mm^3}]$	$H_v [HV]$	ρ_{rel}^1	$\rho_{a,rel}^2$	$\rho_{a,rel}^3$
X200-171024	No	Cubic	L=10	1	0.85	900	86.13	135.9	-	99.24	-
				2		1000	77.52	133.7	-	99.08	-
				3		1059	73.20	135.5	-	99.00	-
				4		1500	51.68	137.3	-	99.38	-
				5	1	900	101.33	131.3	-	98.81	-
				6		1059	86.12	132.7	-	98.83	-
				7	0.75	1200	57	137.3	-	99.49	-
				7a				137.9	-	99.33	-
				7b				137.9	-	99.45	-
				8		900	76	135.5	-	99.23	-
				8a				133.7	-	98.77	-
				8b				136.1	-	99.23	-
X200-180109	No	Cubic	L=10	7c	0.75	1200	57	141.0	99.77	99.33	99.77
				7d				138.6	-	99.45	-
				7e				140.0	-	99.44	-
				7n				141.4	-	99.45	-
				7g				139.4	-	99.50	-
				7h				139.2	99.51	99.52	99.32
				7i				140.3	-	99.48	-
				7j				140.9	-	99.48	-
				7k				140.6	-	99.37	-
				7l				139.8	-	99.38	-
				7m				139.0	99.65	99.29	99.48
				7n				140.0	99.51	99.24	99.48
				7o				138.7	99.52	99.49	99.49
				7p				140.6	-	99.37	-

Continued on next page

TABLE A.1: Manufacturing process parameters

Table A.1 – *Continued from previous page*

Batch name	Contour	Type	Dimensions [mm]	Specimen name	$\frac{P}{P_{max}} [-]$	$v_s [\frac{mm}{s}]$	$E_d [\frac{J}{mm^3}]$	$H_v [HV]$	ρ_{rel}	$\rho_{a,rel}$	$\rho_{a,rel}$
				7q 8c 8d 8e 8f 8g 8h 8i 8j 8k 8l 8m 8n 8o 8p 8q		900	76	139.0 139.4 138.8 138.0 138.3 138.2 139.5 134.6 138.0 138.0 136.5 139.0 140.4 138.5 138.7 138.7	- - - - - - - - - - - - - - - - - -	99.31 99.27 99.20 99.29 99.50 99.37 99.51 99.18 99.44 99.41 99.39 99.31 99.29 99.54 99.35 99.43	- - - - - - - - - - - - - - - - - -
X200-180220	No	Cubic	L=5	TT150-2 TT200-2 TT300-2 TT300-2-plaque TT150-2-real TT200-2-real TT225-2-real (?) TT250-2-real TT300-5min-real	0.75	1200	57		- - - - - - - - - - - - - - - - - -	- - - - - - - - - - - - - - - - - -	
								116.6 101.8			

Continued on next page

TABLE A.1: Manufacturing process parameters

Table A.1 – *Continued from previous page*

Batch name	Contour	Type	Dimensions [mm]	Specimen name	$\frac{P}{P_{max}} [-]$	$v_s [\frac{mm}{s}]$	$E_d [\frac{J}{mm^3}]$	$H_v [HV]$	ρ_{rel}	$\rho_{a,rel}$	$\rho_{a,rel}$
				TT300-2-real					-	-	
X200-180222	No	Cubic	L=10	12 13	0.75	1200	57	- - -	- 98.30 98.90	-	-
X200-180228	Yes	Cylindrical	D=6, H=2	1 2 3	0.75	1200	57	- - -	98.87 99.23 -	-	-
X200180313	Yes	Cylindrical	D=6, H=10 D=12, H=10	1 2 3 4	0.75	1200	57	- - - -	99.74 99.77 99.75 99.73	-	-
	No	Parallelepiped	H=10, W=40, L=120	???				- - -	- - -	-	-
X200-180315	No	Parallelepiped	H=10, W=40, L=115	???	0.75	1200	57	- - -	- - -	-	-
X200-180319	No	Cubic	L=10	cub 1 cub 2 cub 3 cub 4 cub 5	0.75	1200	57	139.5 140.8 140.1 138.6 139.9	99.88 99.81 99.79 99.85 99.87	-	99.90 99.80 99.61 99.77 99.68
	Yes	Cylindrical	L=5 D=6, H=10 D=12, H=10	TT300-1-real cyl 1 cyl 2 cyl 3 cyl 4 ???				- - - - -	99.85 99.92 99.85 99.82	-	-
X200-180417	Yes	Tensile	(see section 3.2)	1, ..., 24	0.75	1200	57	- - -	- - -	-	-

Continued on next page

TABLE A.1: Manufacturing process parameters

Table A.1 – *Continued from previous page*

Batch name	Contour	Type	Dimensions [mm]	Specimen name	$\frac{P}{P_{max}} [-]$	$v_s [\frac{mm}{s}]$	$E_d [\frac{J}{mm^3}]$	$H_v [HV]$	ρ_{rel}	$\rho_{a,rel}$	$\rho_{a,rel}$
	No	Cubic	L=10	25 26, 27, 28 A B C				138.0 - 135.9 138.0 134.1	99.80 - 99.64 99.70 99.67	- - - - -	- - 99.44 99.54 99.44

¹Measured by RODIA [%].²Measured by HW (AB specimens) [%].³Measured by HW (polished specimens) [%].

A.2 Specimens positioning, fabrication orders and sintering times

A.2.1 Batch X200-171024



FIGURE A.1: Specimens positions, order of fabrication and sintering times for batch X200-171024



FIGURE A.2: Photography of the manufacturing plate after completion of the fabrication of batch X200-171024

A.2.2 Batch X200-180109

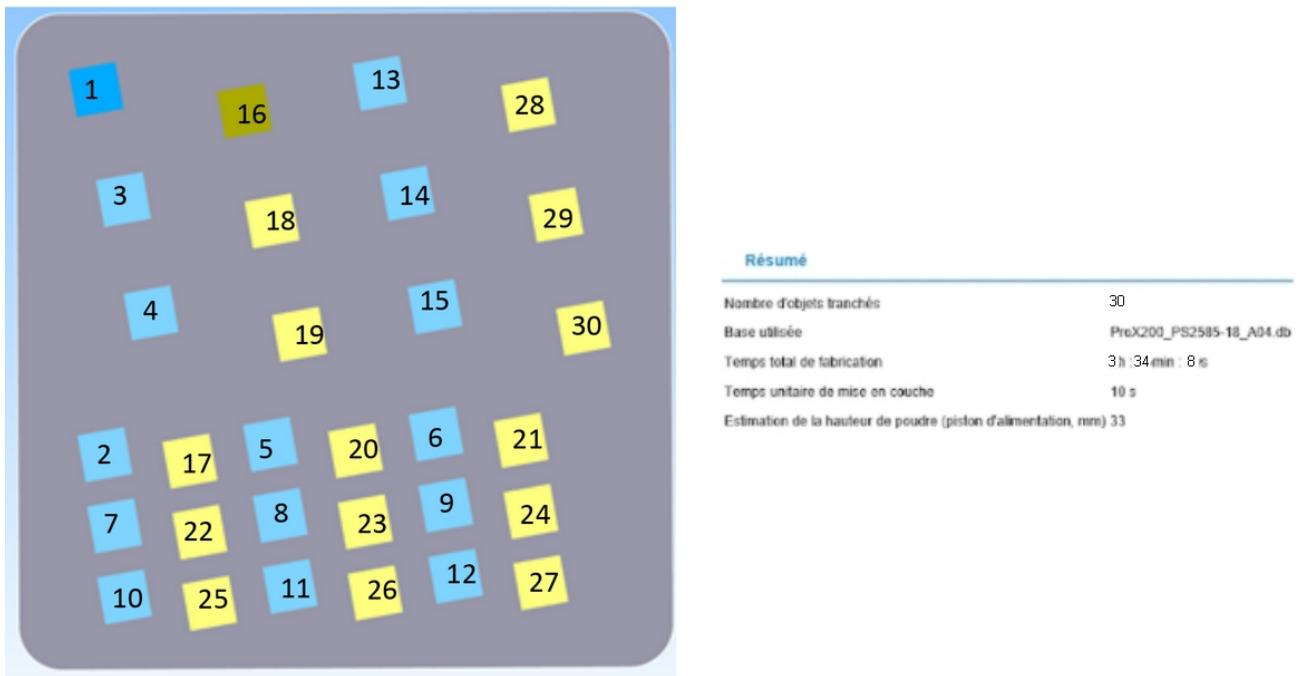


FIGURE A.3: Specimens positions, order of fabrication and sintering times for batch X200-180109

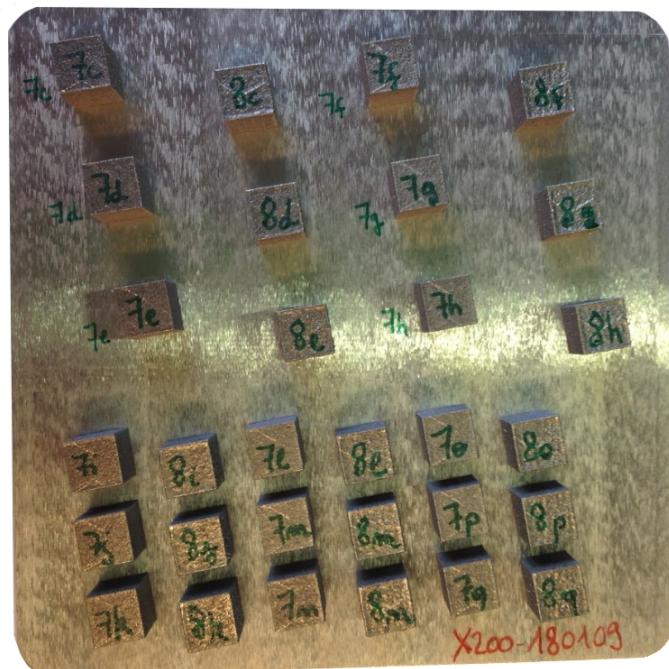


FIGURE A.4: Photography of the manufacturing plate after completion of the fabrication of batch X200-180109

A.2.3 ...Other batches

Appendix B

Tensile properties details

The measured tensile properties for every tested specimens are gathered in this section. Young's modulus values that are in parenthesis were not used in the average computations of sections 4.3 and 4.4, as the corresponding samples slipped between the grips during the tests. A non-linear behaviour was indeed observed.

B.1 As-built samples

Specimen	Contour	E [GPa]	σ_y [MPa]	σ_u [MPa]	ϵ_f [%]
X200-180417-1	Yes	(74.6)	271.8	366.4	2.2
X200-180417-2	Yes	68.2	291.4	388.3	2.4
X200-180417-3	Yes	64.7	276	-	-
X200-180417-16	Yes	64.7	259.3	368.0	2.3
X200-180417-17	Yes	66.1	255.4	406.4	3.0
X200-180417-A	No	62.0	255.3	379.2	2.8

TABLE B.1: Tensile mechanical properties of the as-built specimens from batch X200-180417

B.1.1 Heat treated samples

Specimen	Contour	HT	E [GPa]	σ_y [MPa]	σ_u [MPa]	ϵ_f [%]
X200-180417-13	Yes	150°C (2h)	70.9	290.2	436.2	5.1
X200-180417-14	Yes	150°C (2h)	67.9	286.8	442.7	5.2
X200-180417-B	Yes	150°C (2h)	66.5	287.6	446.2	6.3
X200-180417-10	Yes	200°C (2h)	72.5	245.9	393.4	4.9
X200-180417-11	Yes	200°C (2h)	71.7	244.8	370.6	4.3
X200-180417-7	Yes	250°C (2h)	71.3	231.1	334.5	16.6
X200-180417-8	Yes	250°C (2h)	69.6	239.2	347.4	16.4
X200-180417-9	Yes	250°C (2h)	71.0	227.7	$\simeq 328.7$	-
X200-180417-4	Yes	300°C (2h)	(81.6)	168.9	249.6	29.6
X200-180417-5	Yes	300°C (2h)	68.3	172.4	256.24	29.8
X200-180417-6	Yes	300°C (2h)	69.5	168.5	$\simeq 242.5$	-

TABLE B.2: Tensile mechanical properties of the heat treated specimens from batch X200-180417

Appendix C

Extract of Vickers hardness conversion table (HV10)

Diagonal length [mm]	0	1	2	3	4	5	6	7	8	9
0.34	160	160	159	158	157	156	155	154	153	152
0.35	151.4	150.5	149.7	148.8	148.0	147.1	146.3	145.5	144.7	143.9
0.36	143.1	142.3	141.5	140.7	140.0	139.2	138.4	137.7	136.9	136.2
0.37	135.5	134.7	134.0	133.3	132.6	131.9	131.2	130.5	129.8	129.1
0.38	128.4	127.7	127.1	126.4	125.8	125.1	124.5	123.8	123.2	122.6
0.39	121.9	121.3	120.7	120.1	119.5	118.9	118.3	117.7	117.1	116.5
0.40	115.9	115.3	114.8	114.2	113.6	113.1	112.5	111.9	111.4	110.9
0.41	110.3	109.8	109.3	108.7	108.2	107.7	107.2	106.6	106.1	105.6
0.42	105.1	104.6	104.1	103.6	103.1	102.7	102.2	101.7	101.2	100.8
0.43	100.3	99.8	99.4	98.9	98.5	98.0	97.6	97.1	96.7	96.2
0.44	95.8	95.3	94.9	94.5	94.1	93.6	93.2	92.8	92.4	92.0
0.45	91.6	91.2	90.8	90.4	90.0	89.6	89.2	88.8	88.4	88.0
0.46	87.6	87.3	86.9	86.5	86.1	85.8	85.4	85.0	84.7	85.3
0.47	84.0	83.6	83.2	82.9	82.5	82.2	81.8	81.5	81.2	80.8
0.48	80.5	80.2	79.8	79.5	79.2	78.8	78.5	78.2	77.9	77.6
0.49	77.2	76.9	76.6	76.3	76.0	75.7	75.4	75.1	74.8	74.5
0.50	74.2	73.9	73.6	73.3	73.0	72.7	72.4	72.1	71.9	71.6
0.51	71.3	71.0	70.7	70.5	70.2	69.9	69.6	69.4	69.1	68.8
0.52	68.6	68.3	68.1	67.8	68.5	67.3	67.0	66.8	66.5	66.3
0.53	66.0	65.8	65.5	65.3	65.0	64.8	64.5	64.3	64.1	63.8
0.54	63.6	63.4	63.1	62.9	62.7	62.4	62.2	62.0	61.7	61.5

TABLE C.1: Extract of Vickers hardness conversion table (HV10)

Appendix D

Procedure for the confidence intervals computation

D.1 Apparent relative density

The hydrostatic weighting method requires to weight the analysed samples two times; once in air and once in water. The measurements data of the two weightings are subjected to a certain spreading - especially large in the case of underwater measurements. Both of the tests imprecisions must thus be taken into account when computing the confidence intervals (CI) for $\rho_{a,rel}$. The following procedure was followed:

- Computation of the standard deviation SD_x for the two data samples of observed mass values $\{x_1, x_2, \dots, x_N\}$ with the formula below:

$$SD_x = \sqrt{\frac{\sum_{i=1}^N (x_i - \bar{x})^2}{N - 1}}$$

where N is the sample size and \bar{x} is the mean of the observed values.

- Determination of the CI range at a 95 [%] confidence level for each data sample with the following formula:

$$CI = \bar{x} \pm 1.96 \frac{SD_x}{\sqrt{N}}$$

- Use of the mean values incremented by the extreme values of the CI for both W_a and W_w in the formula:

$$\rho_a = \frac{W_a}{W_a - W_w} \cdot \rho_w$$

so as to maximise the absolute value of the difference with \bar{x} . This difference is then equal to the CI half length for a 95 [%] confidence level. One should note that the following hypotheses were made: the method is unbiased and the tests are depending one on another. The latter hypothesis maximises the CI. It is used for reasons of caution. The validity of the hypotheses is discussed in section 5.2.

D.2 Vickers hardness

Hardness measurements of a given sample are also prone to having a certain variability. CI must thus be computed to assess the method precision. The CI is first calculated for the data sample composed of the mean diagonals length of the indents. For this purpose, one follows the same two first steps as for the hydrostatic weighting. The CI range is then multiplied by 800 to find the hardness's one. This is done in accordance with the observation that the maximal hardness variation for a change of 0.001 [mm] is 0.8 [HV] in table C.1 for $H_v < 147.1$ [HV].

Appendix E

Reproducibility study additional plots

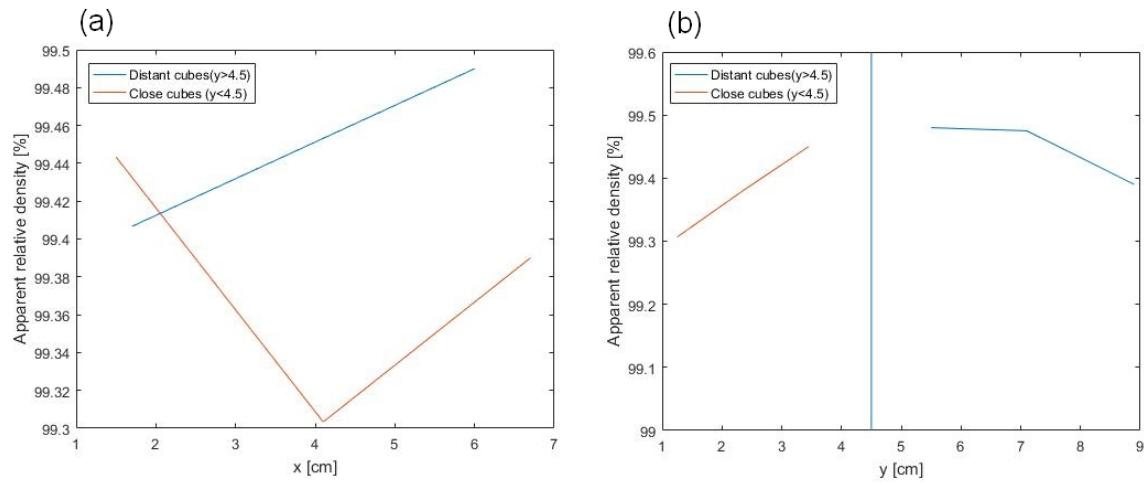


FIGURE E.1: Apparent relative density of batch X200-180109 type ($P=0.75\text{ }P_{max}$; $v_s=1200\frac{\text{mm}}{\text{sec}}$) samples as a function of the (a) x coordinate (b) y coordinate

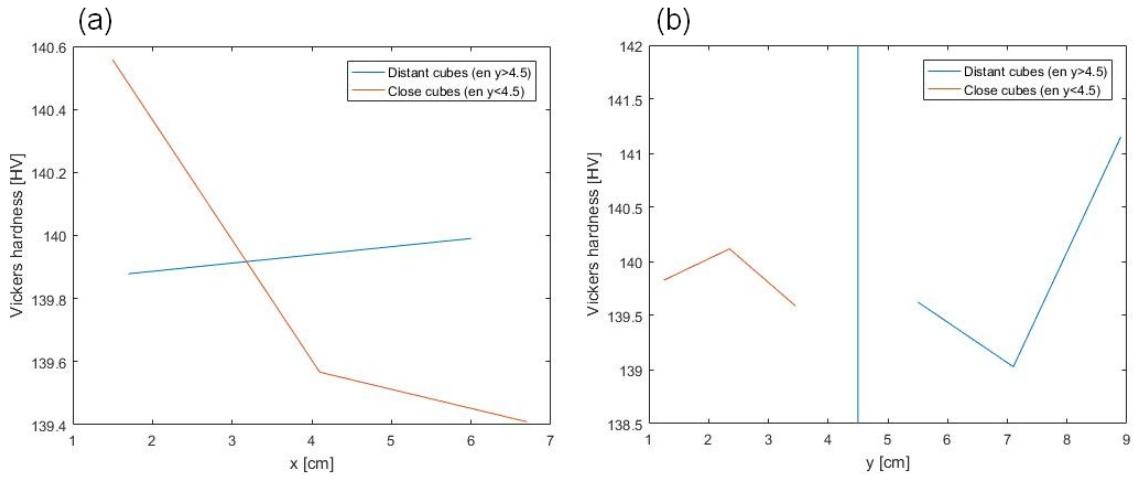


FIGURE E.2: Vickers hardness of batch X200-180109 type ($P=0.75$ P_{max} ; $v_s=1200 \frac{mm}{sec}$) samples as a function of the (a) x coordinate (b) y coordinate

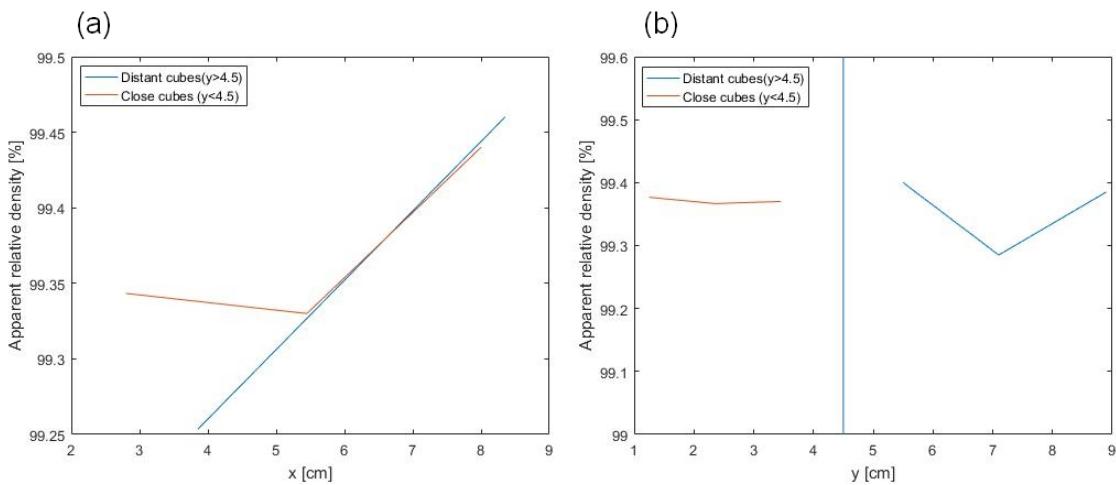


FIGURE E.3: Apparent relative density of batch X200-180109 type ($P=0.75$ P_{max} ; $v_s=900 \frac{mm}{sec}$) samples as a function of the (a) x coordinate (b) y coordinate

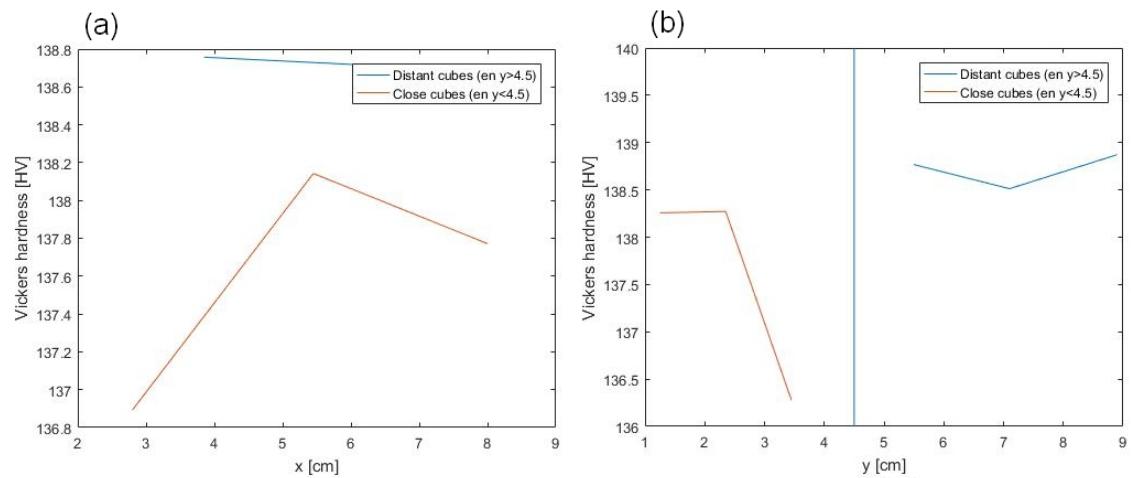


FIGURE E.4: Vickers hardness of batch X200-180109 type ($P=0.75$ P_{max} ; $v_s=900 \frac{mm}{sec}$) samples as a function of the (a) x coordinate (b) y coordinate

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