

**Travail de fin d'études et stage[BR]- Travail de fin d'études : Fabrication and
characterization of low-alloyed tool steel obtained by Selective Laser
Melting[BR]- Stage d'insertion professionnelle**

Auteur : p249504

Promoteur(s) : Mertens, Anne

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Fabrication and characterization of low-alloyed tool steel obtained by Selective Laser Melting

Author: Elena Filippi

Supervisor: Prof. Anne Mertens

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Faculté des Sciences Appliquées – Metallic Materials Science Team – Université de Liège

Scuola di Ingegneria – Dipartimento di Ingegneria Industriale - Università degli Studi di Padova

The present work explores the capability of fabricating low-alloyed metal parts through the layer-by-layer Selective Laser Melting (SLM) technique. The alloy used was AISI S2, which is a carbide-free tool steel made of 0,49%wt of Carbon. Such kind of steels are not popular as for Additive Manufacturing process due to their unpromising welding properties. However, obtained results demonstrated the feasibility of printing fully dense, defects-free with good surface quality low-alloyed steels. A process map containing the optimum set of parameters for the realisation of the S2 metal parts will be presented. Indications for the use of the same process map in the situations of different process conditions or different manufactured steels will be provided as well. Later, the printed pieces were subject to microstructural investigation under their as-build and heat-treated conditions. The outcomes showed a epitaxial grain growth strongly influenced by the scan strategy. Moreover, the outermost top layer consisted of supersaturated martensite which was characterized in order to gain information about the prior microstructure which was present. Whereas the rest of the cross-sections of the as-built samples were found to have bands of tempered martensite at various degrees of tempering. The cause was related to the complex thermal history of the SLM process. In order to achieve all the results several unique techniques have been used such as reverse Differential Thermal Analysis, post-processing heat treatment and nanoindentation. The latter were used in less common ways to obtain a deeper knowledge of the microstructure of S2 metal parts printed through SLM technique, showing promising results.

The following Figures will be used to explain the most important outcomes obtained in the project.

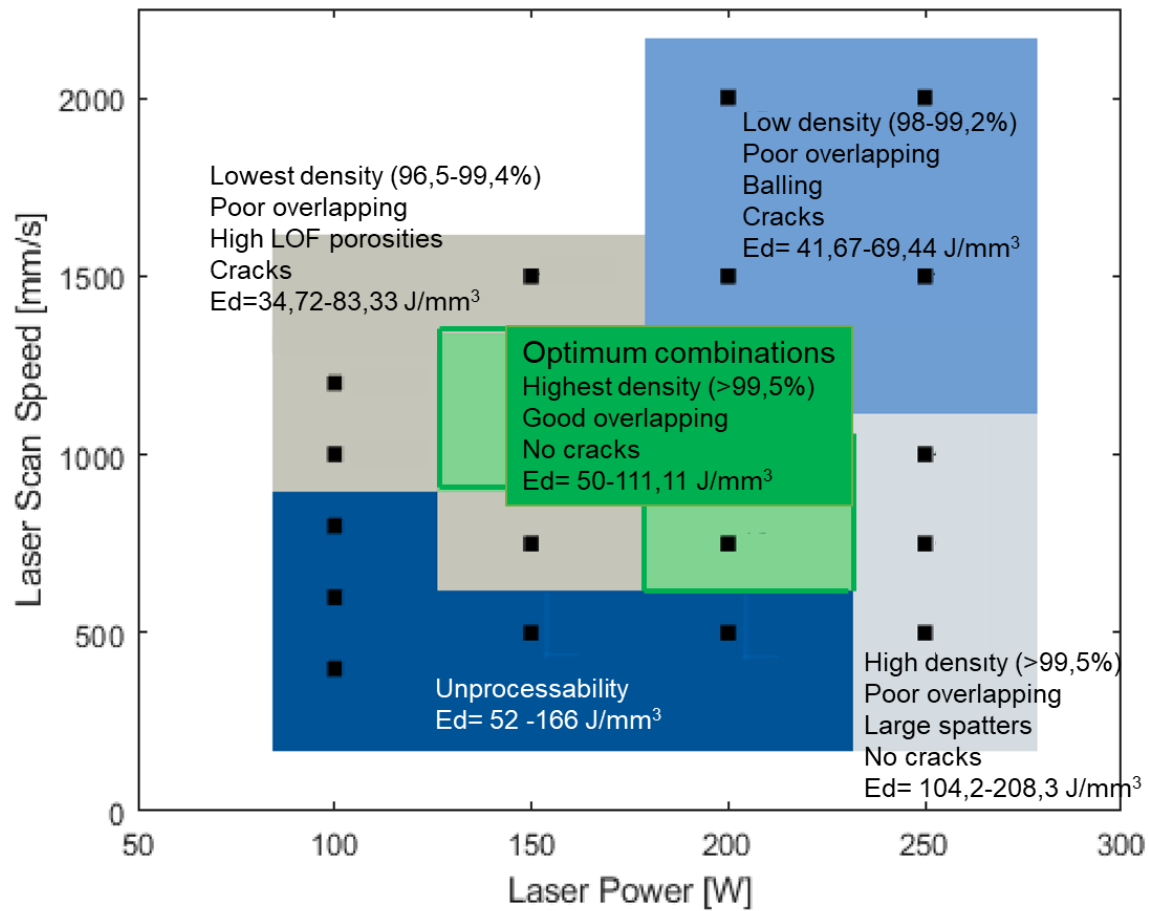


Figure 1: Process map developed with regards to the printing of AISI S2 metal parts through SLM technology. In Green the combinations of parameters which resulted as optimum for the realisation of such steel in such conditions and therefore advised to be pursued.

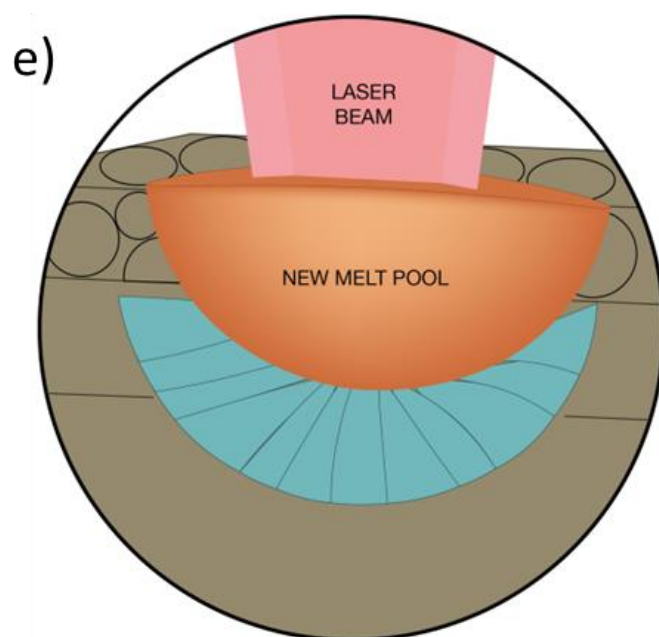
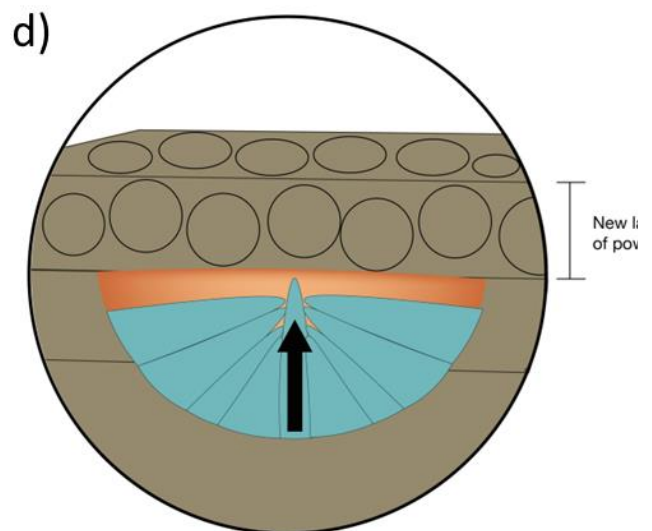
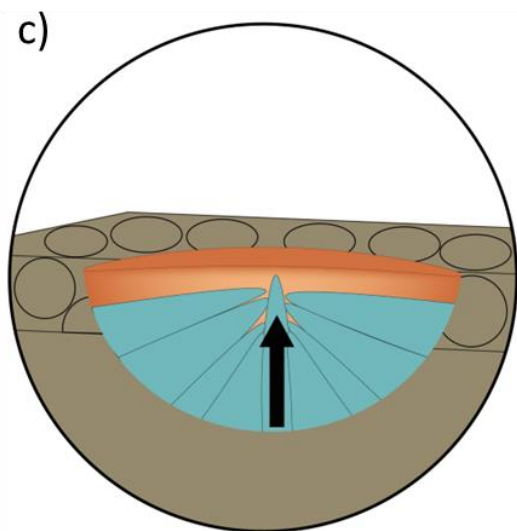
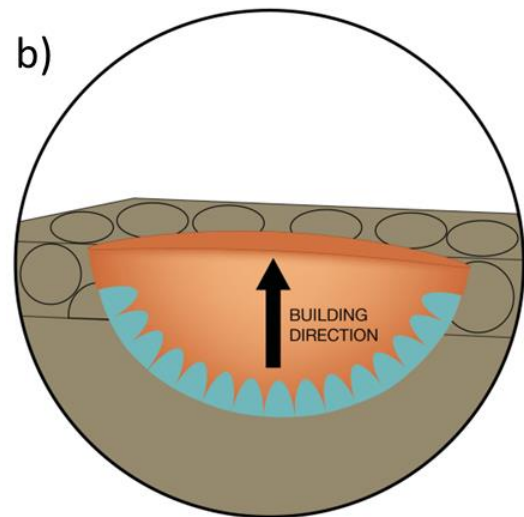
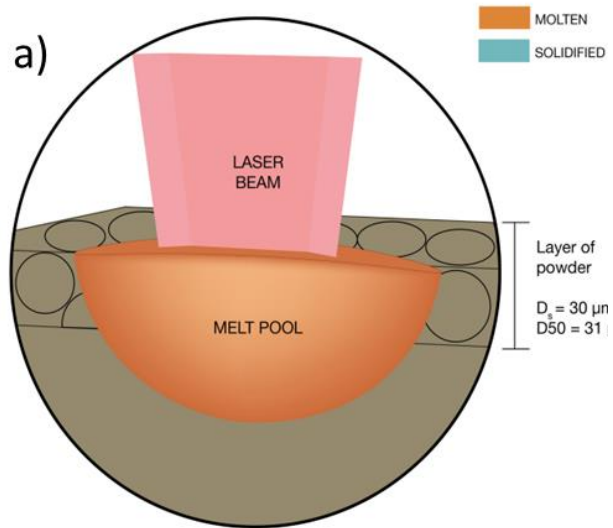


Figure 2: Sketch of the process of melt pool solidification sequence as indication of what was found through the cross-combined analysis results of EBSD, DTA, SEM and OM.. (a) Melt pool with molten powders after the laser travels by; (b) primary nucleated grains following the orientation of the building direction within the melt pool border (c) epitaxial growth with side-branching phenomenon of the nucleated grains (d) addition of a new powder layer (e) the process new step, which affects the microstructure of the layers below.

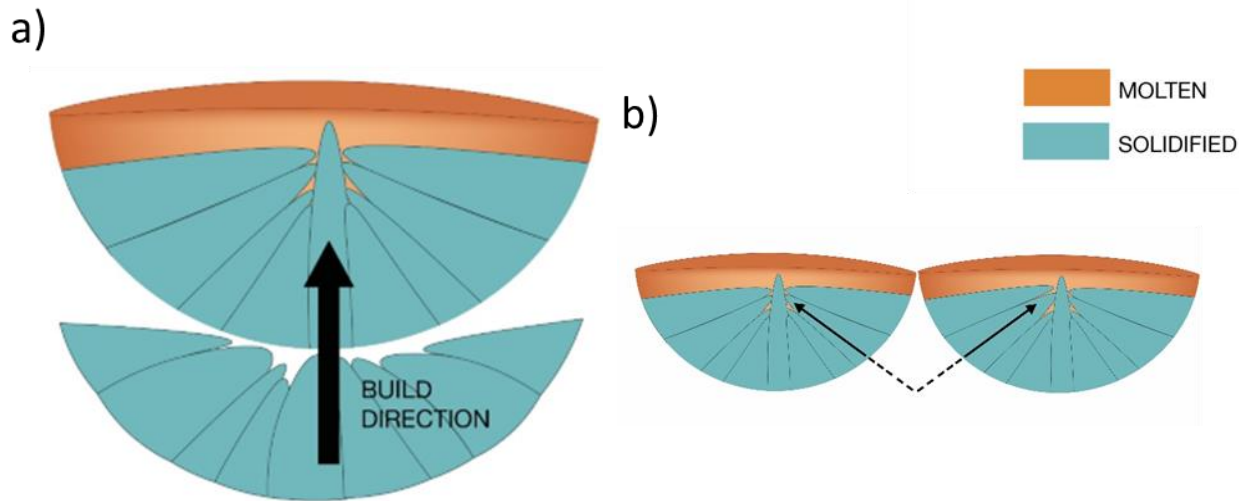


Figure 3: Sketches of two features of epitaxial growth: (a) of columnar grain growth which stays in the same direction along subsequent layers (b) of the side-branching phenomenon between two adjacent melt pools forming a 90° angulation.

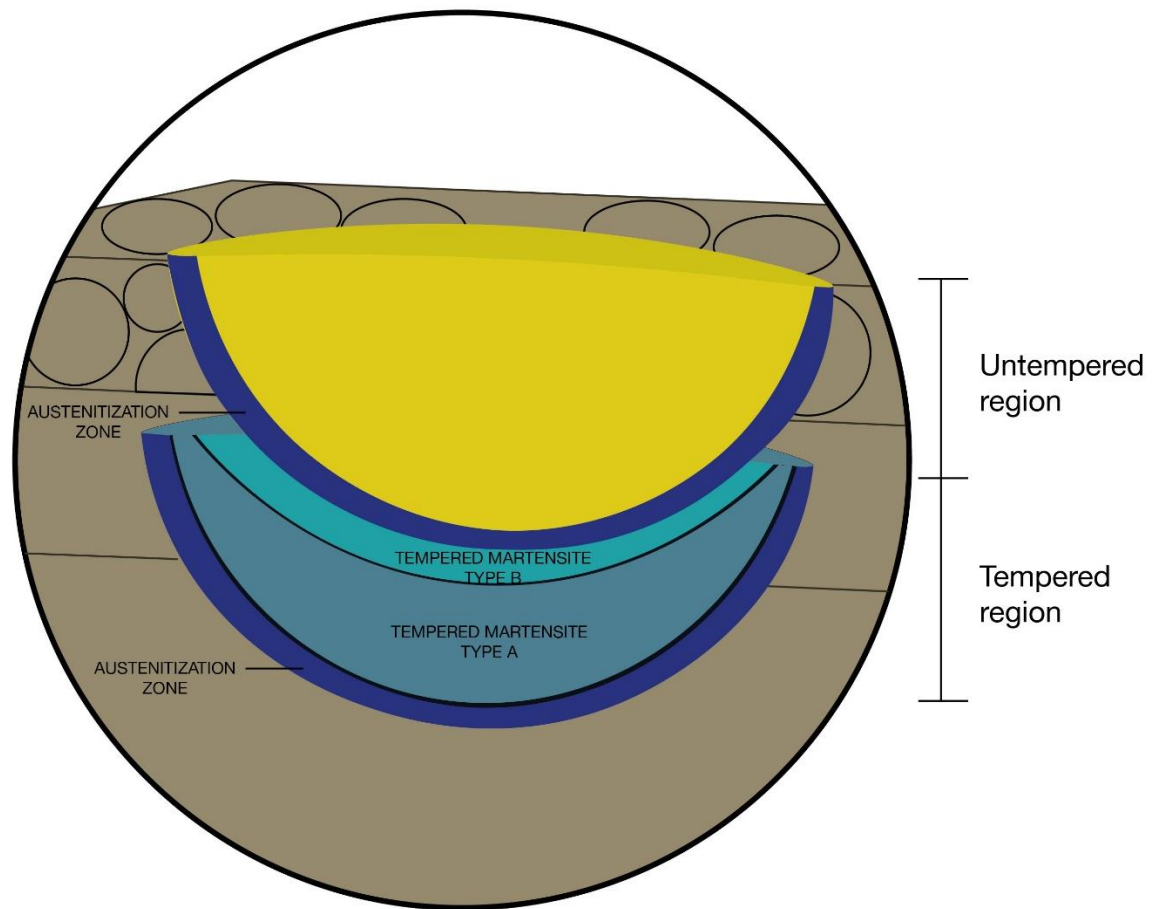


Figure 4: Model of the in-situ tempering effect which was found to develop during the SLM process, generating an untempered state of martensite in the upper layer and bands of tempered martensite in the inner part of the cross-section.