

EOS StainlessSteel SuperDuplex Material Data Sheet

EOS StainlessSteel SuperDuplex

EOS StainlessSteel SuperDuplex is an austenitic-ferritic duplex stainless steel for extreme conditions. The high chromium, molybdenum and nitrogen alloying give excellent corrosion resistance in many difficult environments. The product is optimized for additive manufacturing while maintaining super duplex properties. The optimization of phase balance enables use of the product in as manufactured condition in many use cases.

The general pitting resistance equivalent PREN for EOS SuperDuplex is 41 ($PREN = \%Cr + 3.3 \times \%Mo + 16 \times \%N$).

Main Characteristics:

- Excellent resistance to uniform, pitting and crevice corrosion
- High strength together with high corrosion resistance

Typical Applications:

- Oil and gas industry
- Pulp and paper manufacturing devices
- Mining and off-shore equipment

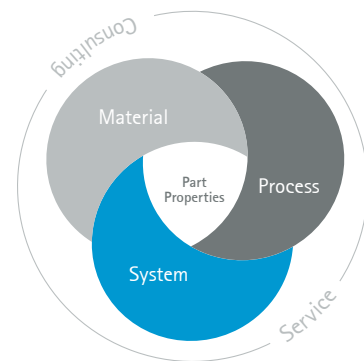
The EOS Quality Triangle

EOS uses an approach that is unique in the AM industry, taking each of the three central technical elements of the production process into account: the system, the material and the process. The data resulting from each combination is assigned a Technology Readiness Level (TRL) which makes the expected performance and production capability of the solution transparent.

EOS incorporates these TRLs into the following two categories:

- Premium products (TRL 7-9): offer highly validated data, proven capability and reproducible part properties.
- Core products (TRL 3 and 5): enable early customer access to newest technology still under development and are therefore less mature with less data.

All of the data stated in this material data sheet is produced according to EOS Quality Management System and international standards.



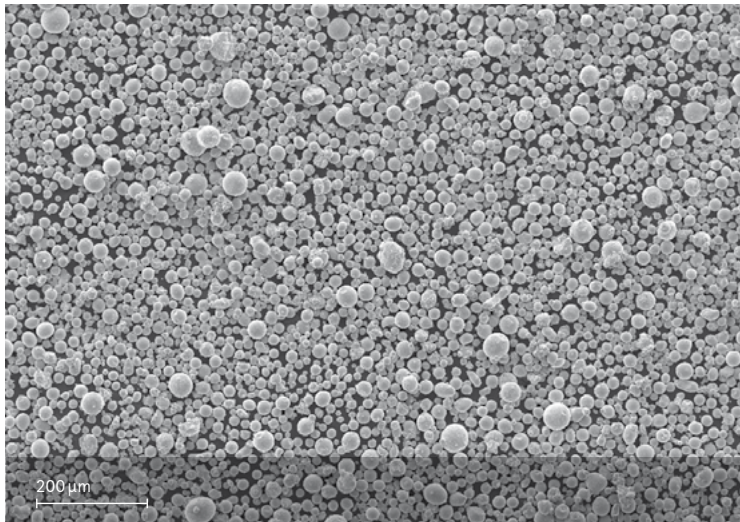
Powder Properties

Powder chemical composition (wt.-%)

Element	Min.	Max.
Fe	Balance	
Cr	22.0	26.0
Ni	9.0	13.0
Mo	3.0	6.0
N	0.15	0.35
C	-	0.03

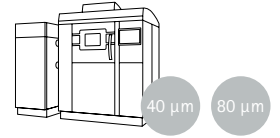
Powder particle size

Generic particle size distribution	20-65 μm
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SEM image of powder

EOS StainlessSteel SuperDuplex for EOS M 290 | 40/80 µm Process Information



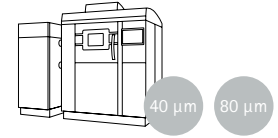
System set-up	EOS M 290
EOSPAR name	SuperDuplex_040_080_CoreM291_100
Software requirements	EOSPRINT 2.8 or newer EOSYSTEM 2.12 or newer
Powder part no.	9030-0009
Recoater blade	Ceramic
Nozzle	EOS grid nozzle
Inert gas	Argon
Sieve	75 µm

Additional information

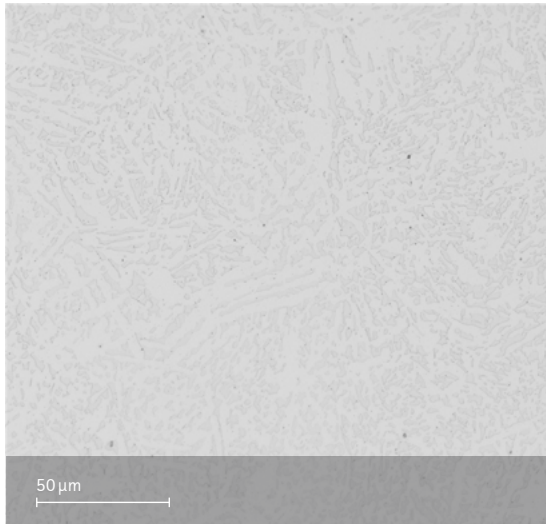
Layer thickness	40 µm, 80 µm Et 40/80 µm Skin
Volume rate*	4.1 mm ³ /s (40 µm), 7.9 mm ³ /s (80 µm), 4.1 - 7.9 mm ³ /s (40/80 µm Skin)

* Volume rate depends on the part dimensions and skin thickness.

Chemical and Physical Properties of Parts



Chemical composition of built parts is compliant to EOS StainlessSteel SuperDuplex powder chemical composition.



Micrograph etched, heat treated state
Etchant: Aqua regia

Defects	Result
Porosity	40 μm / 0.04 % 80 μm / 0.08 %
Density, ISO3369	≥ 7.80 g/cm ³

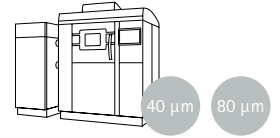
Phase Balance	As manufactured	Heat treated
Ferrite content, 40 μm	60-70 %	20 %
Ferrite content, 80 μm	50-60 %	20 %

Typical mechanical properties

		Yield strength R _{p0.2} [MPa]	Tensile strength R _m [MPa]	Elongation at break A [%]	Modulus of elasticity [GPa]
Heat treated, 40 μm	horizontal	580	870	34	200
	vertical	560	860	34	
As manufactured, 40 μm	horizontal	1170	1260	13	200
	vertical	1020	1180	16	
Heat treated, 80 μm	horizontal	570	870	33	200
	vertical	560	860	35	
As manufactured, 80 μm	horizontal	1030	1130	17	240
	vertical	880	1050	20	

Tensile testing as per ISO 6892-1. Modulus of elasticity testing according to EN ISO 6892-1 Method A, Range 1 (0.00007 1/s).

Heat Treatment



Solution annealing

Hold temperature 1100 °C, hold time 0.5 h when thoroughly heated, water quenching
 Typical dimensional change after heat treatment -0.4 % (40 μm) or -0.8 % (80 μm).

Additional Data

Impact toughness

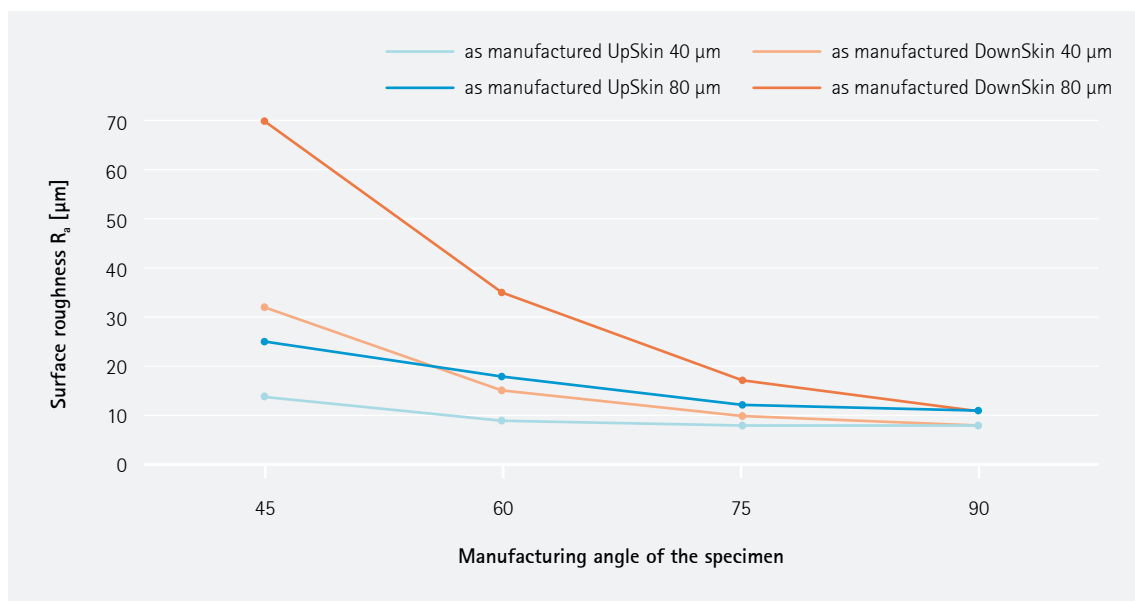
	State	As manufactured	Heat treated
Typical impact toughness [J]	40 μm	110	155
	80 μm	70	140

Testing according to ISO 148-1,
 V-notch at room temperature.

Coefficient of Thermal Expansion ASTM E228

Temperature			25 – 100 °C	25 – 200 °C	25 – 300 °C
CTE	As manufactured	40 μm	10,42*10 ⁻⁶ /K	11,12*10 ⁻⁶ /K	11,51*10 ⁻⁶ /K
	As manufactured	80 μm	11,71*10 ⁻⁶ /K	12,89*10 ⁻⁶ /K	13,48*10 ⁻⁶ /K
	Heat treated	40/80 μm	13,63*10 ⁻⁶ /K	14,81*10 ⁻⁶ /K	15,32*10 ⁻⁶ /K

Surface Roughness



Headquarters

EOS GmbH
Electro Optical Systems
Robert-Stirling-Ring 1
D-82152 Krailling/Munich
Germany
Phone +49 89 893 36-0
info@eos.info

www.eos.info

in EOS

 EOSGmbH

 EOS.global

 EOSGmbH

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Further Offices

EOS France
Phone +33 437 497 676

EOS Greater China
Phone +86 21 602 307 00

EOS India
Phone +91 443 964 8000

EOS Italy
Phone +39 023 340 1659

EOS Japan
Phone +81 45 670 0250

EOS Korea
Phone +82 2 6330 5800

EOS Nordic & Baltic
Phone +46 31 760 4640

EOS North America
Phone +1 877 388 7916

EOS Singapore
Phone +65 6430 0463

EOS UK
Phone +44 1926 675 110

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Cover: This image shows a possible application.

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Important Note

This data sheet specifies the powder properties of the EOS powder type referenced above. If you purchase powder from EOS, EOS will deliver such powder in conformity with the version of this data sheet prevailing at the time of your order. If you purchase powder from any source other than EOS, EOS makes no warranties or representations with respect to powder properties to you whatsoever, and claims with respect to the quality or properties of EOS powder are available only against the seller of such powder in accordance with your agreement with the seller, not against EOS. - EOS data sheets are subject to change without notice. This data sheet does not constitute a guaranty or warranty of properties or fitness for a specific purpose and may not be relied upon as such.

