

420 Stainless Steel Infiltrated with Bronze



ExOne's 3D Printed 420 Stainless Steel infiltrated with Bronze is a matrix material composed of 60% stainless steel and 40% bronze infiltrant. This material offers good mechanical properties, is available in both an annealed and non-annealed condition, is able to be machined, welded and polished, and offers excellent wear resistance.

Applications

This material system is ideally suited for parts exposed to highly abrasive environments such as pump components, and parts for down-hole drilling and mining equipment. Additional applications include industrial components, molds, tooling, art objects and decorative hardware.



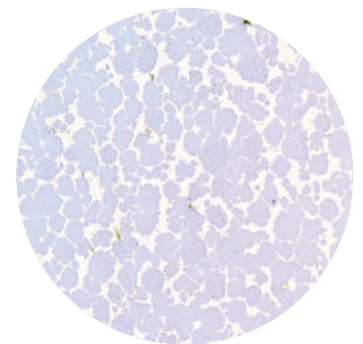
Printed part

Composition

Stainless Steel: Alloy 420
Bronze: 90% Cu / 10% Sn

Printing

Using binder jetting technology, ExOne's state-of-the-art 3D Printing machines produce parts directly from CAD models by precisely controlling the jetting of binder onto a powder bed, and then subsequently spreading new layers of powder. This process is repeated until the part is completed. This 3D Printing process offers increased design flexibility, reduced manufacturing cost and shortened lead times.



420 SS / Bronze

Post Processing

After printing is complete, the parts are cured in an oven, which enables the parts to be handled. After curing, the parts are sintered and infiltrated with bronze above 1100°C. Cool down can be varied to control the machinability and hardness of the material.

Typical Material Properties

Material Properties	Test Method	
Tensile Strength		
Ultimate Strength	ASTM E8	99 ksi (682 MPa)
Yield Strength (0.2% offset)		66 ksi (455 MPa)
Elastic Modulus		21.4 Mpsi (147 GPa)
Elongation		2.3%
Hardness	ASTM E18	97 HRb
Fractional Density	MPIF 42	95%+
Density		0.284 lbs/in ³ (7.86 g/cm ³)
Machinability		Refer to ExOne for recommendations
Weldability		Use silicone bronze rod & TIG weld
Thermal Conductivity	ASTM E1530	13 BTU/hr ft °F (22.6 W/m ² K)
Specific Heat	ASTM E1263	0.114 BTU/lb °F (478 J/kg ² K)
Thermal Expansion Coefficient	ASTM E228	7.4 x 10 ⁻⁶ /°F (13.4 x 10 ⁻⁶ /°K)

Surface Finish

After sintering: ≈ 600 μin R_a (15 μm R_a)
 Bead blasting: ≈ 300 μin R_a (7.5 μm R_a)
 Barrel finishing: ≈ 50 μin R_a (1.25 μm R_a)



Printed part, raw finish



Printed part, polished

ExOne disclaims all warranties and liabilities for the content hereof and makes no representations as to its accuracy or fitness for use for any purpose. Any tradenames, trademarks, or service marks of others appearing herein are used strictly nominatively and are not to be construed as implying any affiliation, connection, association, sponsorship, or approval of the owners thereof for ExOne, its products, or the content hereof.

For information about ExOne systems, materials and applications, contact an ExOne **Production Service Center** or visit www.ExOne.com

The ExOne Company
 127 Industry Boulevard
 North Huntingdon, PA 15642

MIDWEST: +1 877 745 1580

EUROPE: +1 877 745 1580

MID-ATLANTIC: +1 877 773 9663

ASIA: +1 281 931 0011