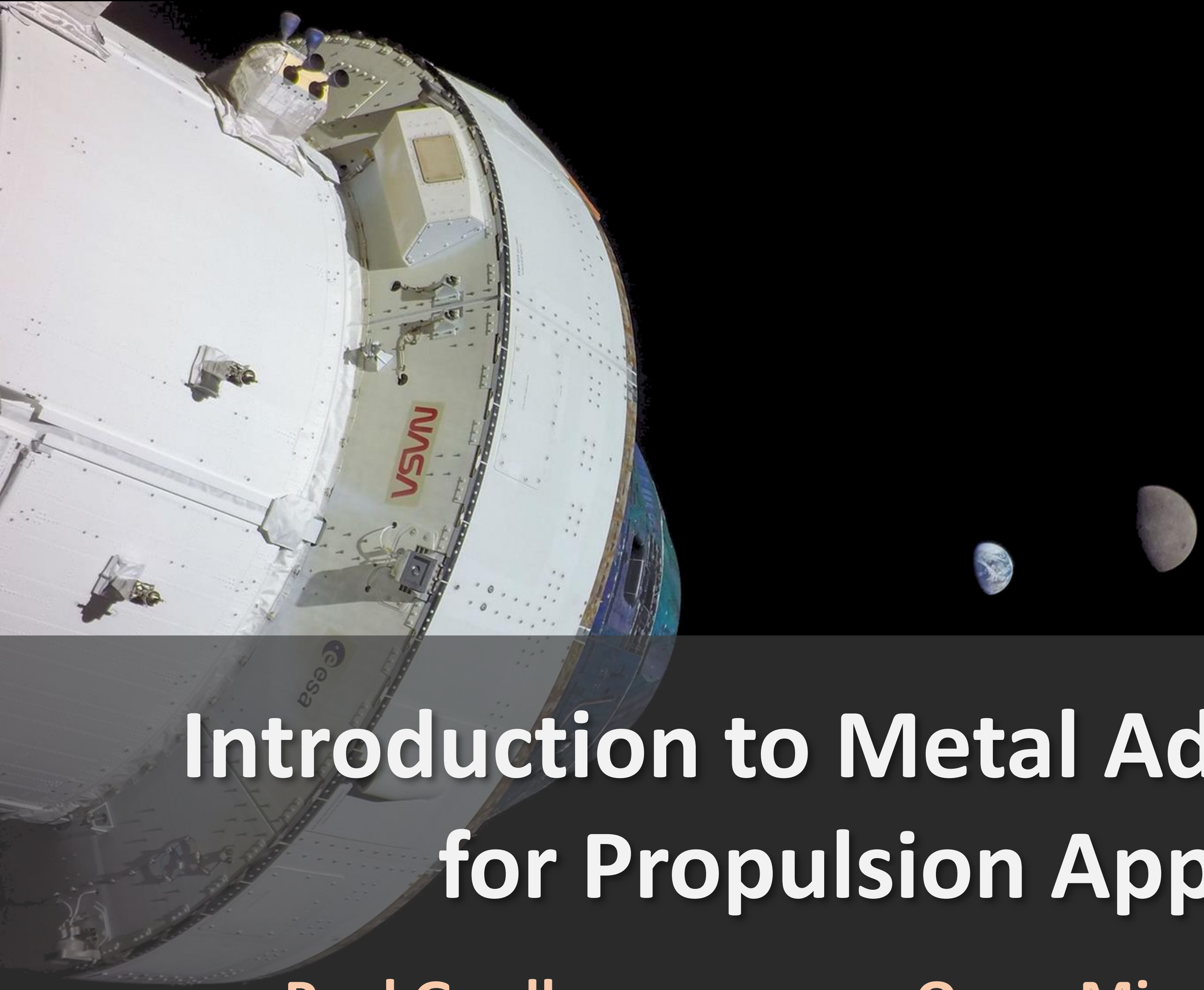

Introduction to Metal Additive Manufacturing for Propulsion Applications: Part I

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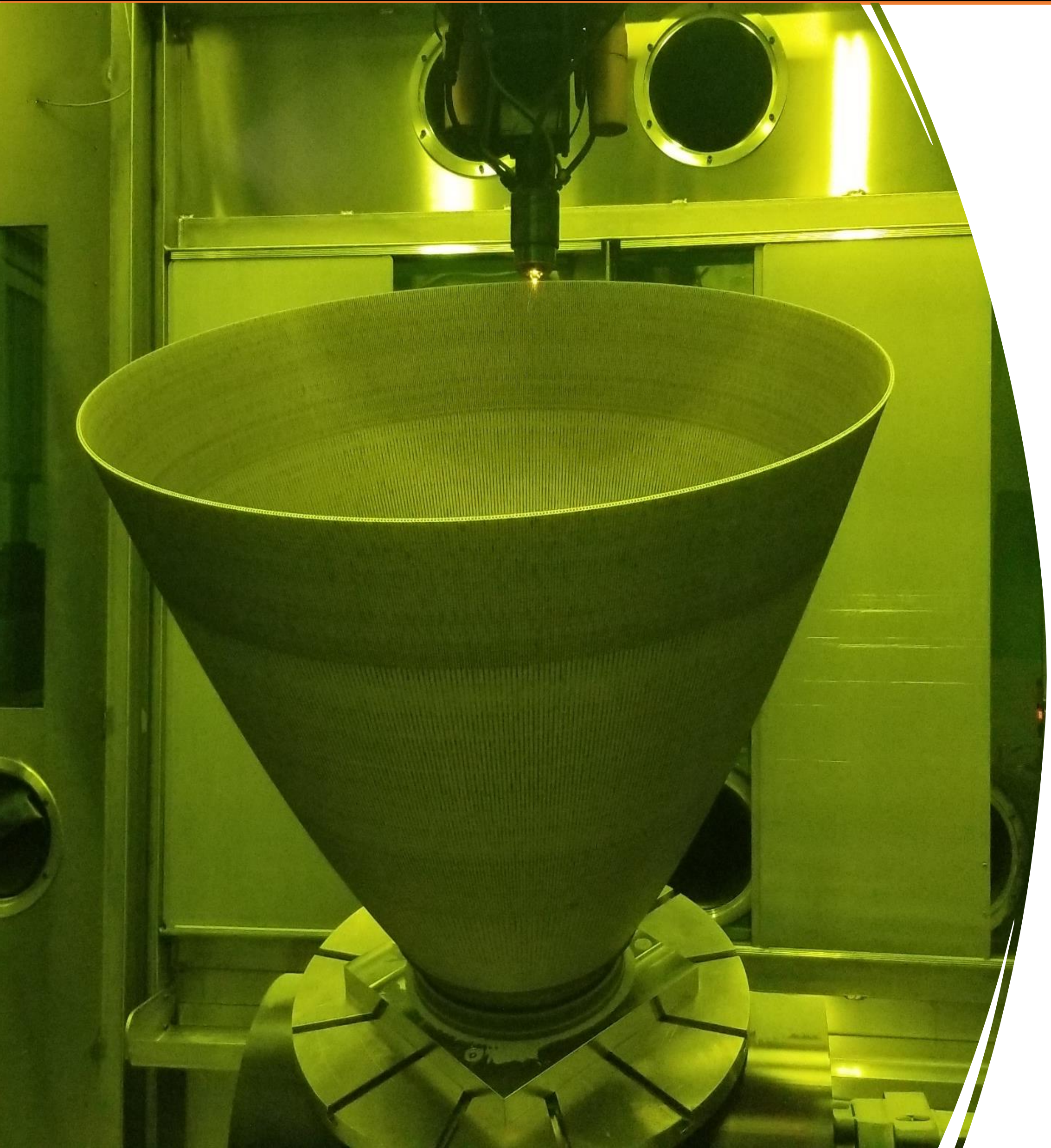
6 January 2025

Ground rules and basic terminology

- This section is focused on <u>metal</u> additive manufacturing
- Examples are all aerospace-based, but process will apply broadly
- Additive manufacturing – may refer to as build, print, AM, grow, fabricate…
- Terminology:
  - AM = Additive Manufacturing
  - DED = Directed Energy Deposition
  - DfAM = Design for Additive Manufacturing
  - PBF = Powder Bed Fusion
  - LP-DED = Laser Powder DED
  - L-PBF = Laser Powder Bed Fusion
  - EB-PBF = Electron beam powder bed fusion
  - LW-DED = Laser Wire DED
  - AW-DED = Arc Wire DED
  - EB-DED = Electron Beam DED
  - AFSD = Additive friction stir deposition
  - UAM = Ultrasonic additive manufacturing

Overview of Presentation



- Introduction / Use Cases
- Metal AM Process Selection
- Overview of AM Materials & Microstructure
- Metal AM Feedstock
- AM Post-Processing
- Design for AM (DfAM)
- Certification of Metal AM
- Case Studies

Part I

Additive Manufacturing Typical Process Flow

Process Parameters

Metal Feedstock

AM Design and Pre-Processing
- Part Design
- Analysis
- Model Check
- Build Layout
- Support Generation
- Model Slicing
- Toolpath

Additive Manufacturing Process

Post-Processing
- Powder Removal
- Heat Treatments
- Support Removal
- Build Plate Removal
- Inspections
- Final Machining
- Welding / Brazing
- Polishing
- Cleaning

Part in Service
- Assembly
- Validation / Testing
- Qualified Metallurgy
- Part Production Plan

Qualification

Proper AM process selection requires an integrated evaluation of all process lifecycle steps

Gradl, P., Tinker, D., Park, A., Mireles, O., Garcia, M., Wilkerson, R., Mckinney, C., 2021. Robust Metal Additive Manufacturing Process Selection and Development for Aerospace Components. Journal of Materials Engineering and Performance, Springer. https://doi.org/10.1007/s11665-022-06850-0

Opportunities for Metal Additive Manufacturing

- High complexity applications
- Rapid prototyping for design iterations (design-fail-fix-cycle)
- Low production volume applications
- Time critical applications
- Maintenance, repair, and operations (MRO)
- Part obsolescence
- Part consolidation
- Performance improvements (heat transfer, packaging, reduced mass)
- Novel alloys not feasible with traditional manufacturing
- Reduced scrap (and lower buy-to-fly ratio)
- Sustainability
- Local manufacturing

Advantages and Disadvantages

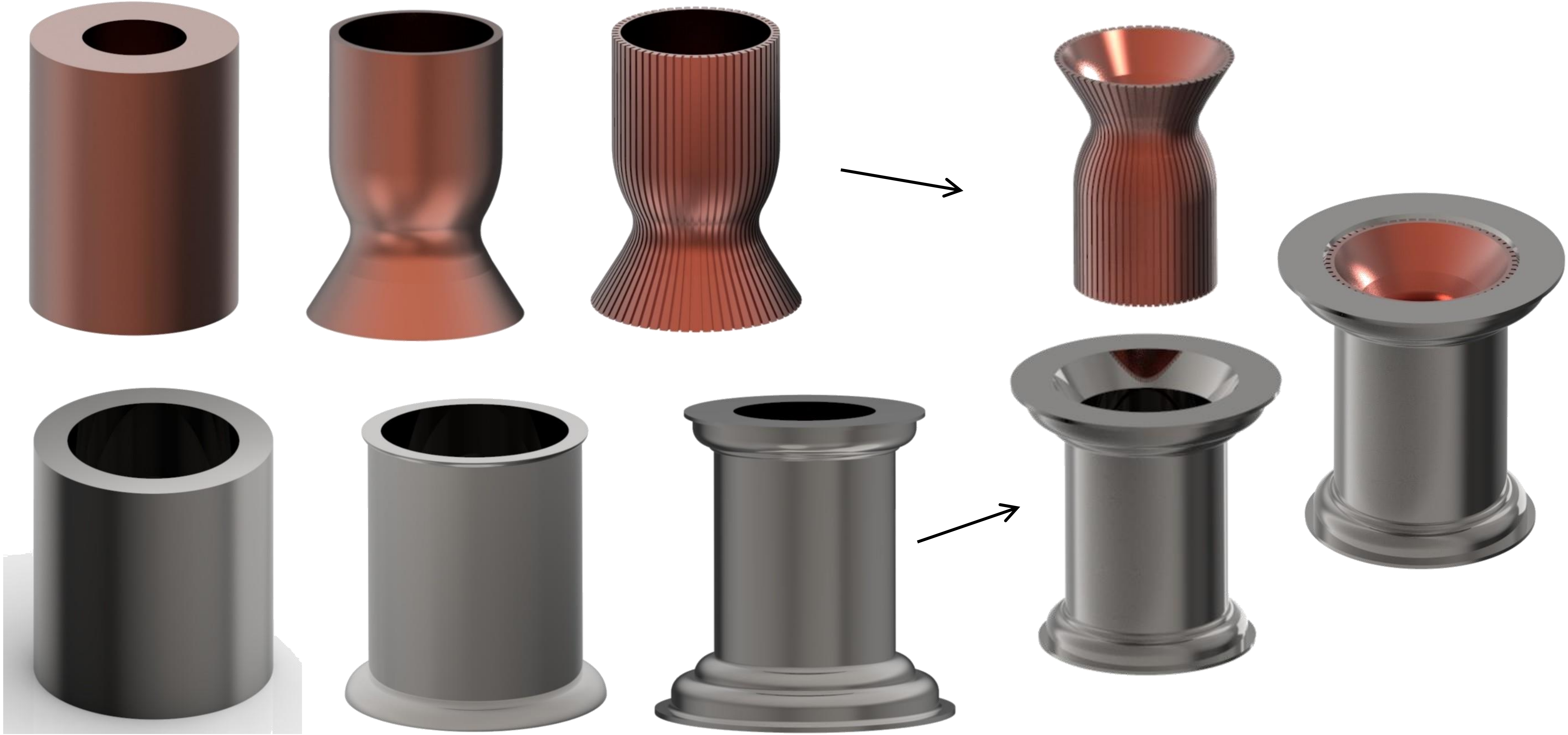
Advantages

1) No or limited tooling is required.
2) Reductions in part count or mass can be achieved through increased design freedom.
3) A broad range of metal alloys can be used.
4) Various sized and featured parts can be manufactured using different methods.
5) Overall processing time and subsequent cost are reduced.
6) Design freedom is increased, as fewer manufacturing constraints are imposed to enhance performance.
7) Production lead time is reduced.
8) New supply chains, such as critical spares, are enabled.

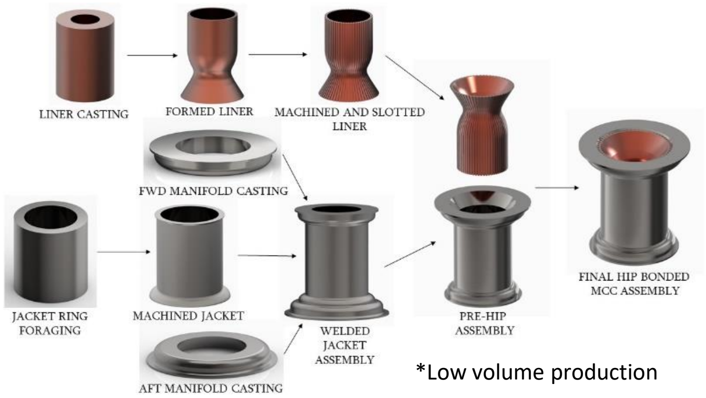
Challenges

1) Production volume and time can be limited.
2) Many metal alloys can be used, but they typically must be weldable and still require a powder or raw material supply chain.
3) Distortion and residual stresses are intrinsic to the melt and solidification process.
4) The entire AM process from design to service application must be understood and considered.
5) Variations occur across different processes.
6) Not all AM machine platforms can build the same part.
7) AM machines represent a significant capital investment and can present a barrier to entry.

Traditional Manufacturing…Forging to final assembly



A rocket combustion chamber case study for AM



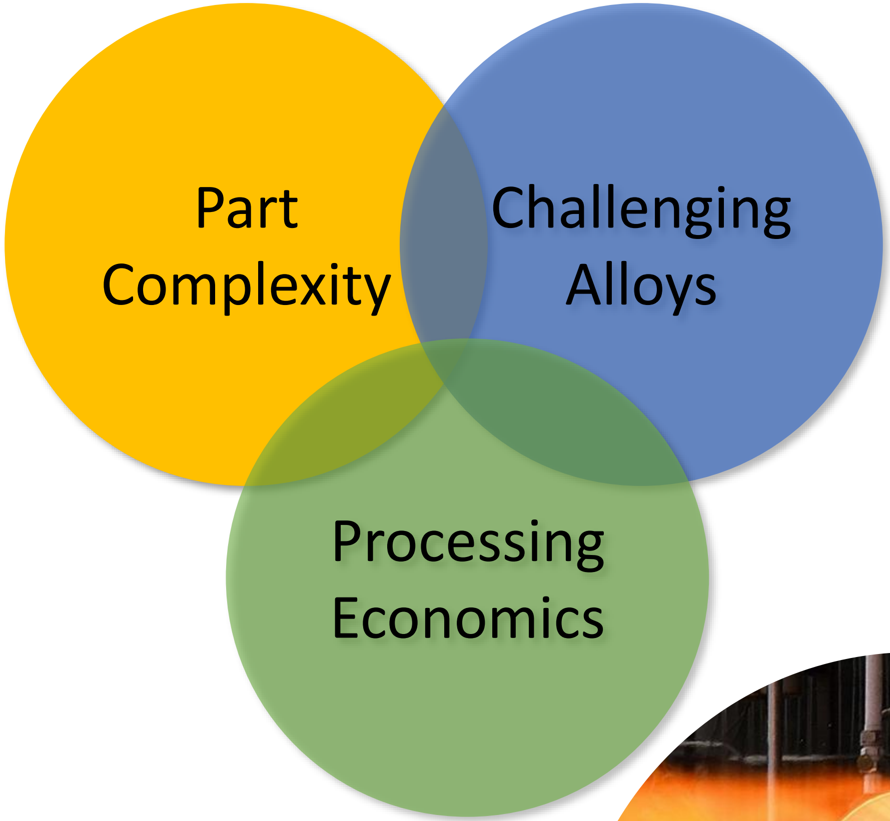
*Low volume production

Category	Traditional Manufacturing	Initial AM Development	Evolving AM Development
Design and Manufacturing Approach	Multiple forgings, machining, slotting, and joining operations to complete a final multi-alloy chamber assembly	Four-piece assembly using multiple AM processes; limited by AM machine size. Two-piece L-PBF GRCop-84 liner and EBW-DED Inconel 625 jacket	Three-piece assembly with AM machine size restrictions reduced and industrialized. Multi-alloy processing; one-piece L-PBF GRCop-42 liner and Inconel 625 LP-DED jacket
Schedule (Reduction)	18 months	8 months (56%)	5 months (72%)
Cost (Reduction)	$310,000	$200,000 (35%)	$125,000 (60%)

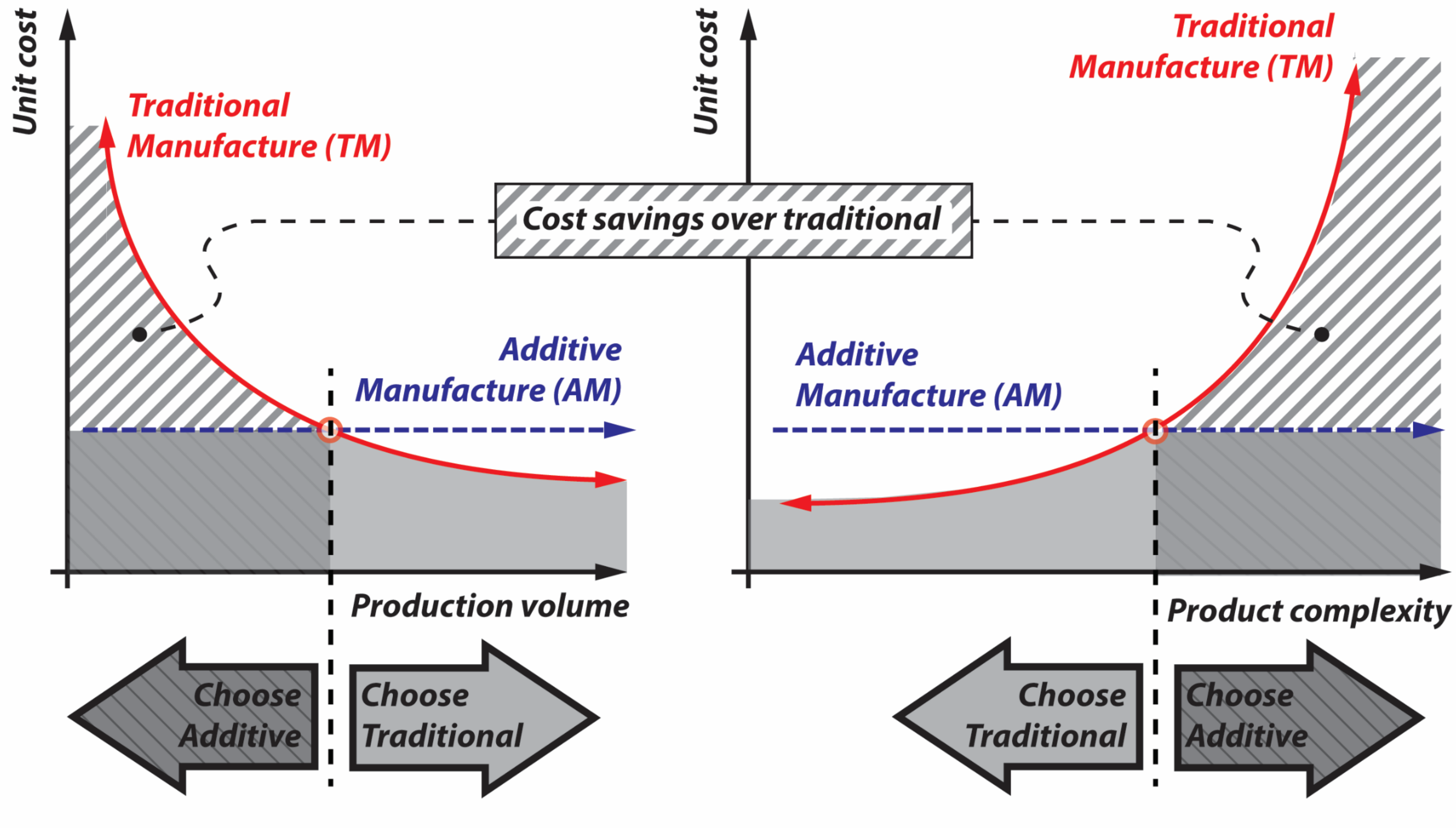
As AM process technologies evolve using multi-materials and processes, additional design and programmatic advantages are being discovered

The Case for Additive Manufacturing in Propulsion

- Metal Additive Manufacturing (AM) can provide significant advantages for lead time and cost over traditional manufacturing for rocket engines.
  - Lead times reduced by 2-10x
  - Cost reduced by more than 50%
- Complexity is inherent in liquid rocket engines and AM provides new design and performance opportunities.
- Materials that are difficult to process using traditional techniques, long-lead, or not previously possible are now accessible using metal additive manufacturing.

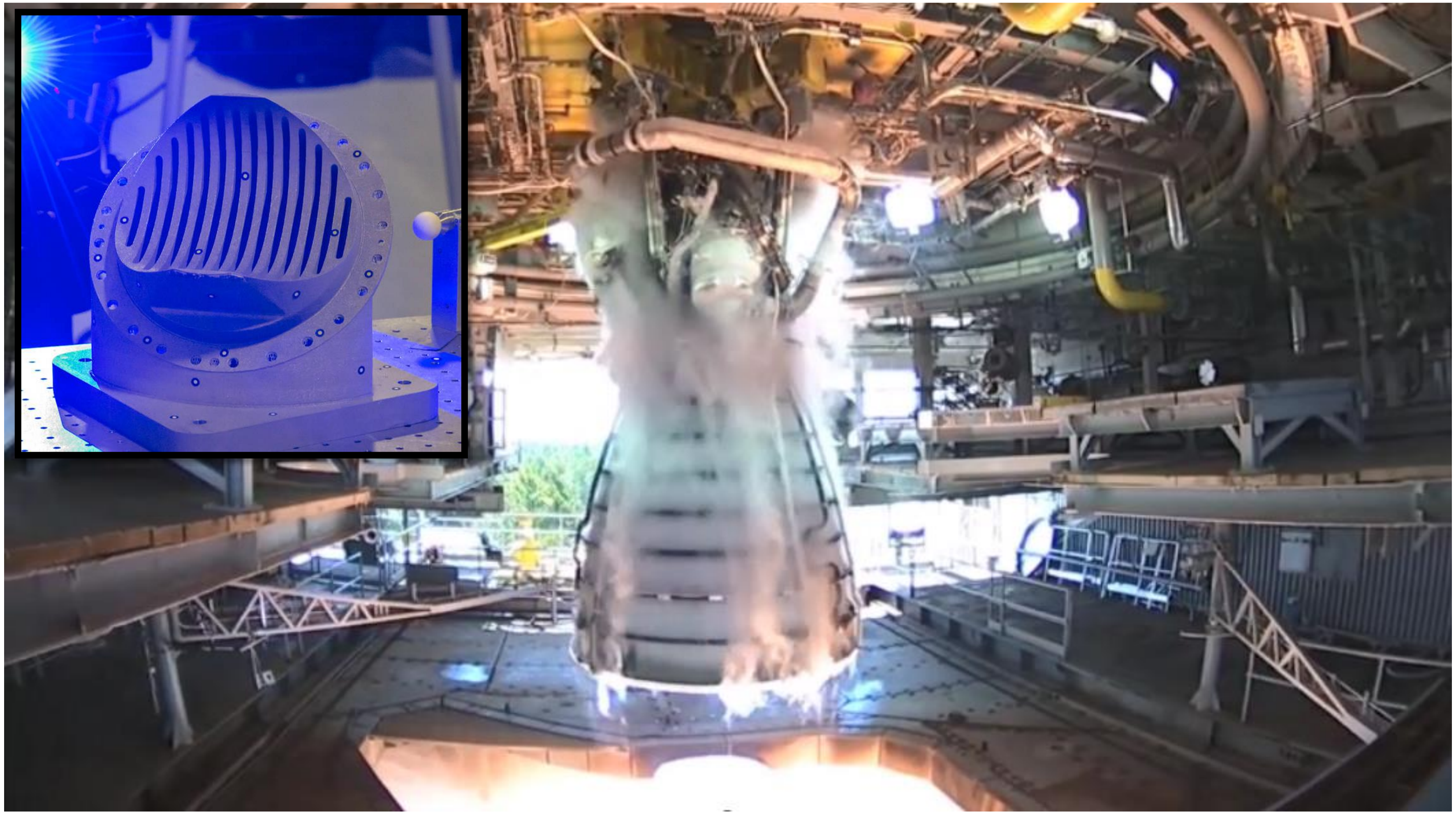


When do we use additive manufacturing?



Paul R. Gradl, Omar R. Mireles, Christopher S. Protz, Chance P. Garcia, 2022. Metal Additive Manufacturing for Propulsion Applications, 1st ed, Metal Additive Manufacturing for Propulsion Applications. American Institute of Aeronautics and Astronautics, Inc., Reston, VA. https://doi.org/10.2514/4.106279

Additive Manufacturing in use on NASA Space Launch System (SLS)



Successful hot-fire testing of full-scale additive manufacturing (AM) Part to be flown on SLS RS-25
RS-25 Pogo Z-Baffle – Used existing design with AM to reduce complexity from <u>127 welds to 4 welds</u>

Ref: Andy Hardin, Steve Wofford/ NASA MSFC

Additive Manufacturing in Flight and Development

Relativity Space

SpaceX

Aerojet Rocketdyne

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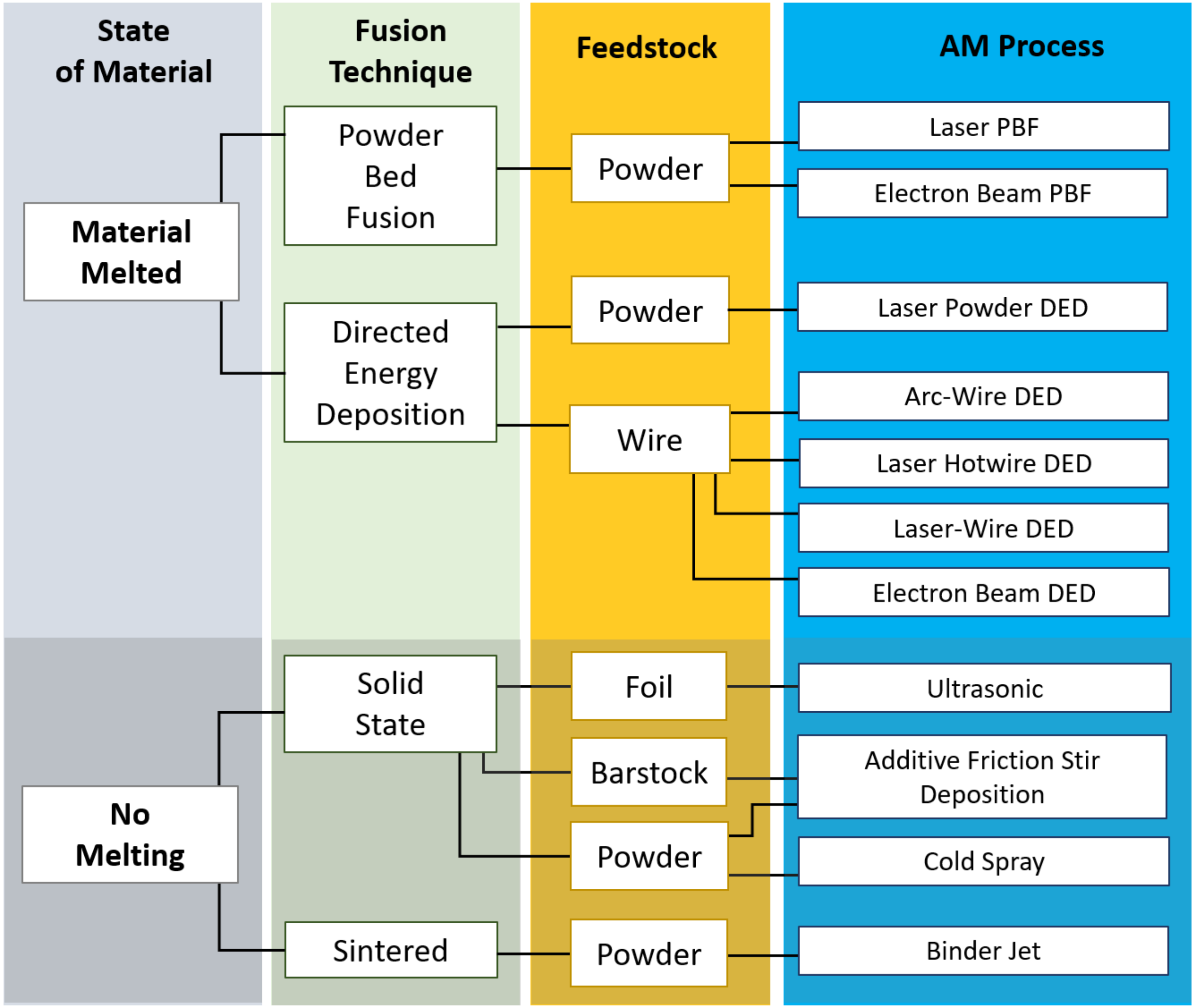
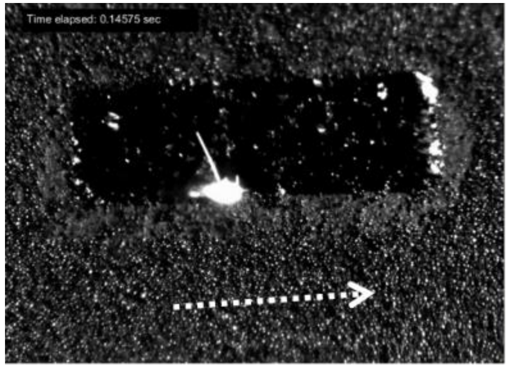
Various Metal AM Processes



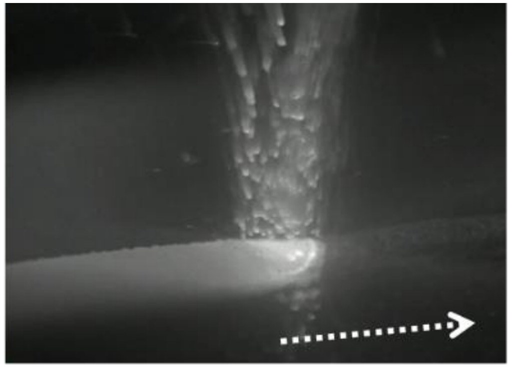
Many AM processes exists and must be traded (along with traditional techniques) to optimize

AM Processes for various applications

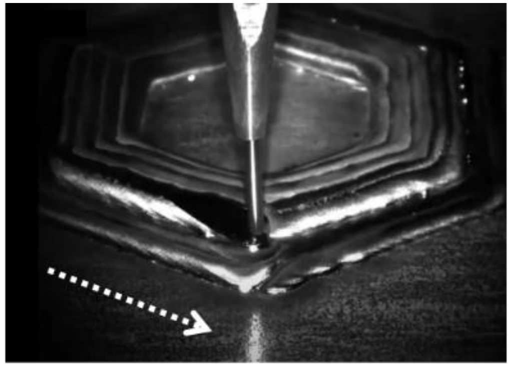


Laser Powder Bed Fusion

Electron Beam Powder Bed Fusion

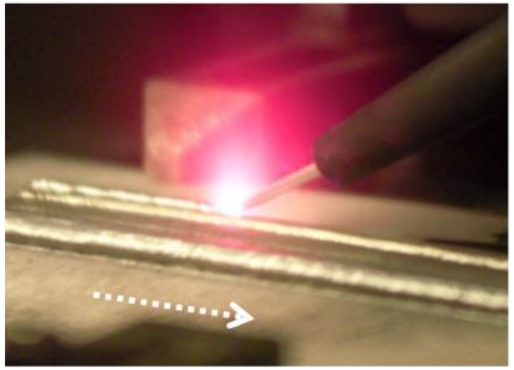


Laser Powder DED

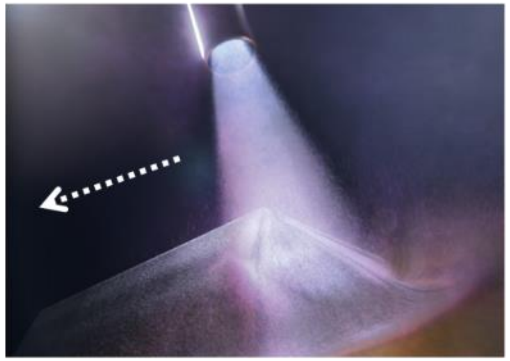


Laser Wire DED

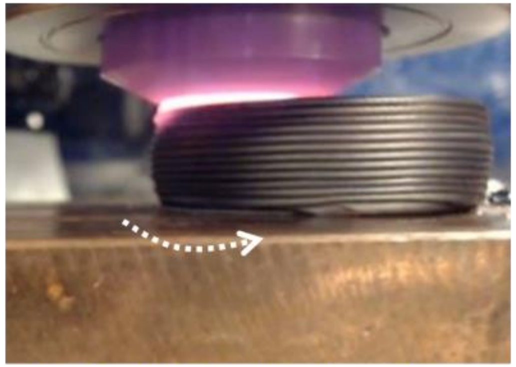
Arc Wire DED



Electron Beam Wire DED



Cold Spray



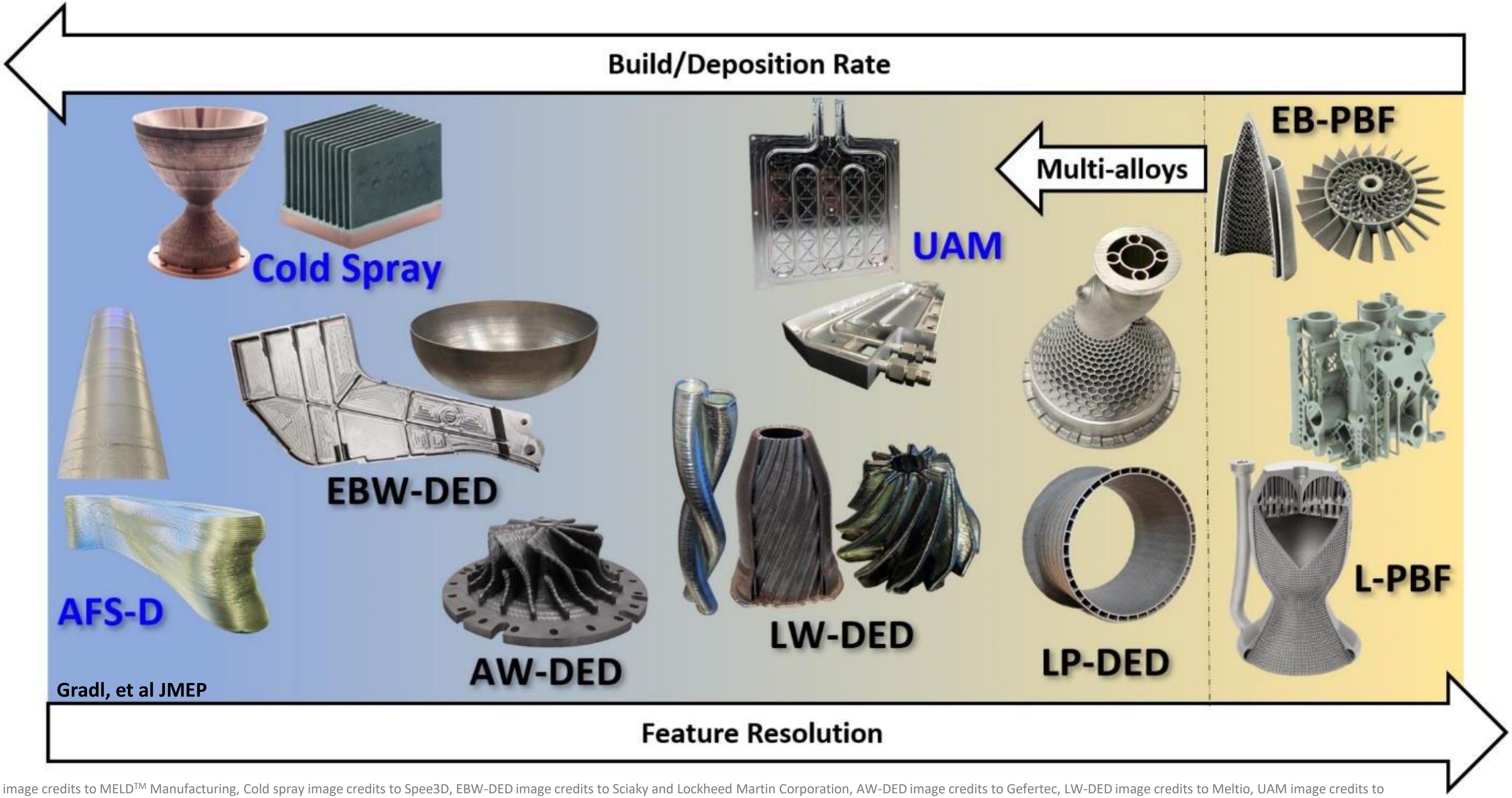
Additive Friction Stir Deposition

Ultrasonic Additive Manufacturing

A) Laser Powder Bed Fusion [https://doi.org/10.1016/j.actamat.2017.09.051], B) Electron Beam Powder Bed Fusion *[Credit: Courtesy of Freemelt AB, Sweden],* C) Laser Powder DED *[Credit: Formalloy],* D) Laser Wire DED *[Credit: Ramlab and Cavitar],* E) Arc Wire DED *[Credit: Institut Maupertuis and Cavitar],* F) Electron Beam DED *[NASA],* G) Cold spray *[Credit: LLNL],* H) Additive Friction Stir Deposition [NASA], I) Ultrasonic AM *[Credit: Fabrisonic].*

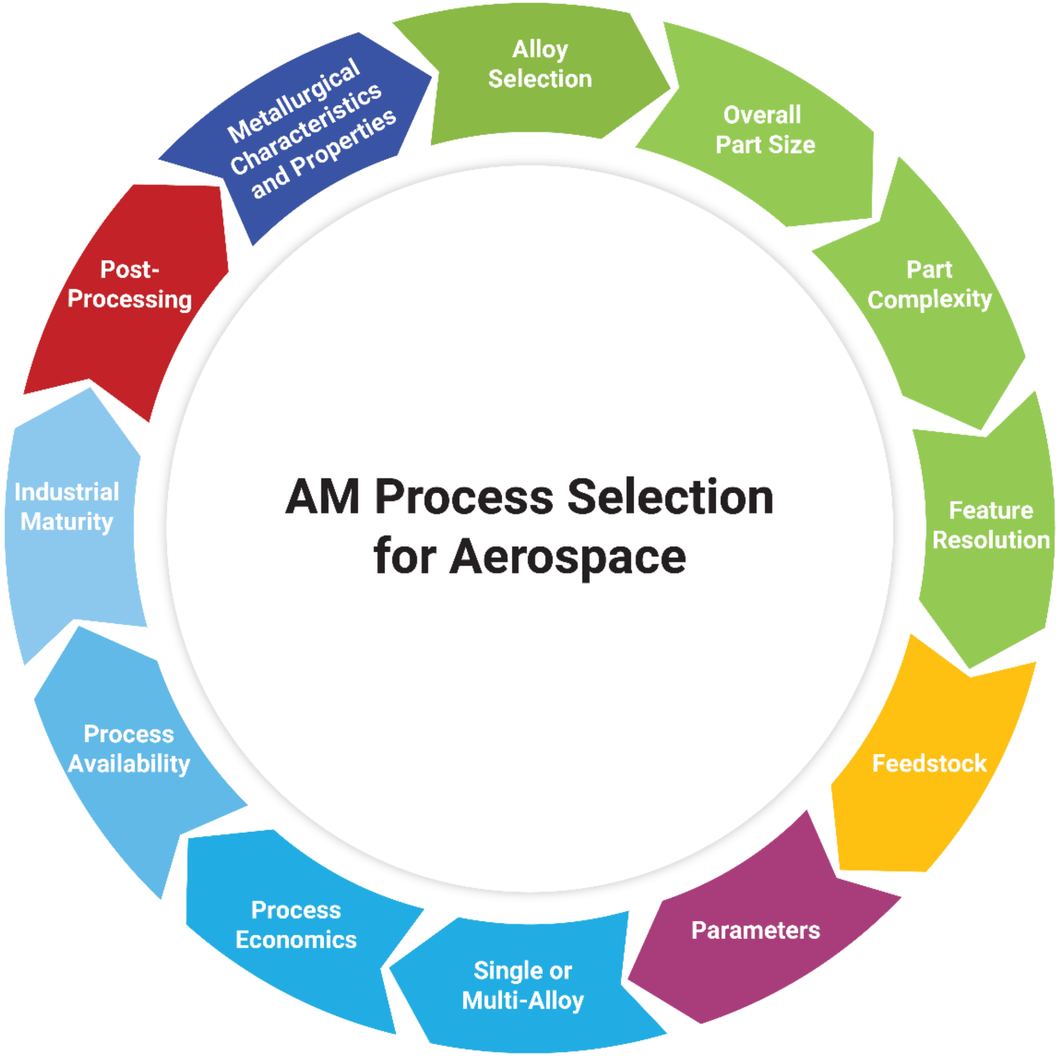
Reference: Gradl, P., Tinker, D., Park, A., Mireles, O., Garcia, M., Wilkerson, R., Mckinney, C., 2021. Robust Metal Additive Manufacturing Process Selection and Development for Aerospace Components. Journal of Materials Engineering and Performance, Springer. https://doi.org/10.1007/s11665-022-06850-0

Criteria and Comparison Various Metal AM Processes



CREDITS: AFS-D image credits to MELD™ Manufacturing, Cold spray image credits to Spee3D, EBW-DED image credits to Sciaky and Lockheed Martin Corporation, AW-DED image credits to Gefertec, LW-DED image credits to Meltio, UAM image credits to Fabrisonic and NASA JPL, LP-DED image credits to DEPOZ project led by IRT Saint-Exupery and Formalloy, L-PBF image credits to Renishaw plc and CellCore GmbH/Sol Solutions Group AG, EB-PBF image credits to Wayland and GE Additive/Arcam.

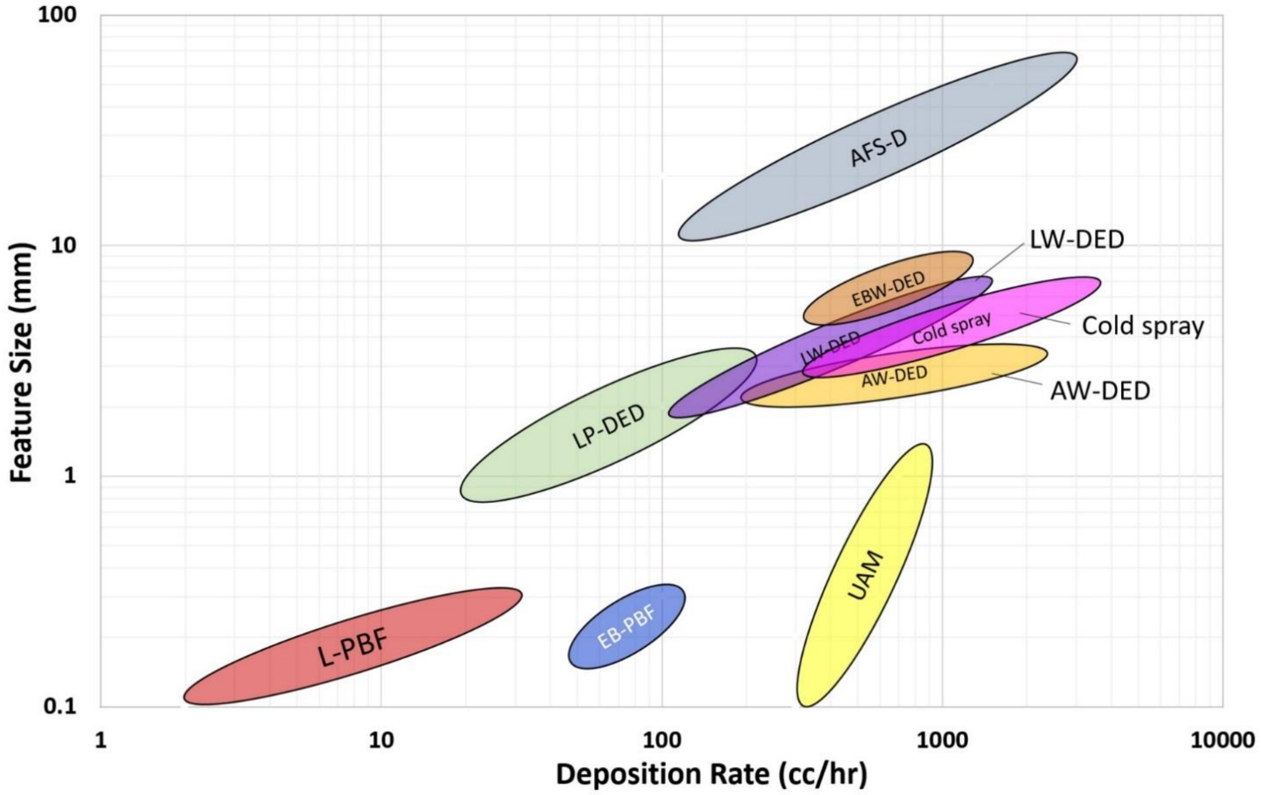
Methodical AM Process Selection

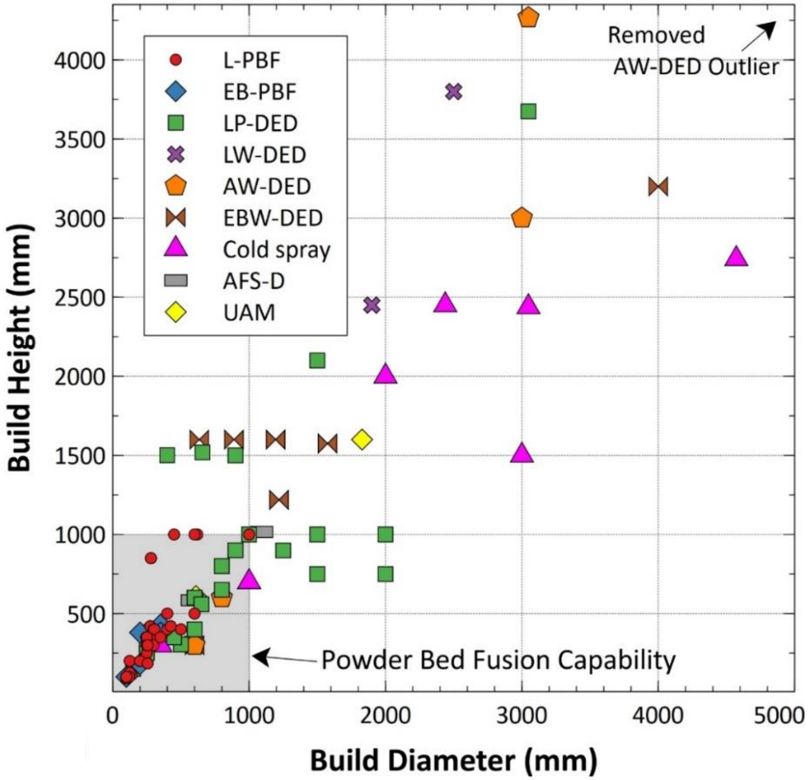


- What is the **alloy** required for the application?
- What is the **overall part size**?
- What is the **feature resolution** and internal **complexities**?
- Is it a **single alloy or multiple**?
- What are **programmatic requirements** such as cost, schedule, risk tolerance?
- What are the end-use environments and **properties required**?
- What is the **qualification/certification** path for the application/process?

Gradl, P., Tinker, D., Park, A., Mireles, O., Garcia, M., Wilkerson, R., Mckinney, C., 2021. Robust Metal Additive Manufacturing Process Selection and Development for Aerospace Components. Journal of Materials Engineering and Performance, Springer. https://doi.org/10.1007/s11665-022-06850-0

Various criteria for selecting AM techniques





Complexity of Features | Scale of Hardware | Material Physics | Cost | Material Efficiency

Speed of Process | Material Properties | Internal Geometry | Availability | Post Processing

References:

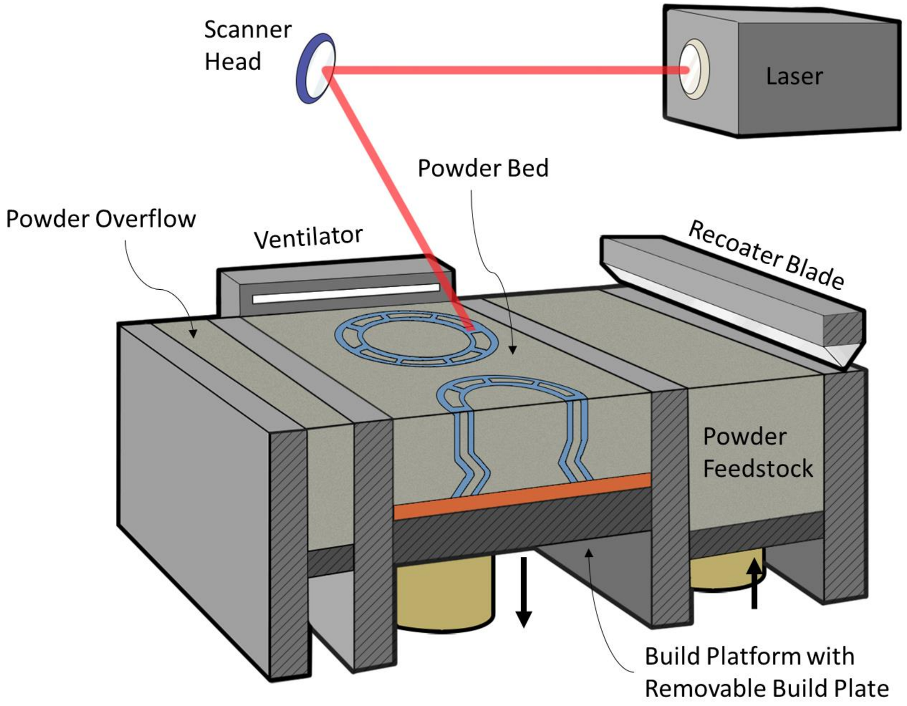
- Gradl, P., Tinker, D., Park, A., Mireles, O., Garcia, M., Wilkerson, R., Mckinney, C., 2021. Robust Metal Additive Manufacturing Process Selection and Development for Aerospace Components. Journal of Materials Engineering and Performance, Springer. https://doi.org/10.1007/s11665-022-06850-0
- Paul R. Gradl, Omar R. Mireles, Christopher S. Protz, Chance P. Garcia, 2022. Metal Additive Manufacturing for Propulsion Applications, 1st ed, Metal Additive Manufacturing for Propulsion Applications. American Institute of Aeronautics and Astronautics, Inc., Reston, VA. https://doi.org/10.2514/4.106279

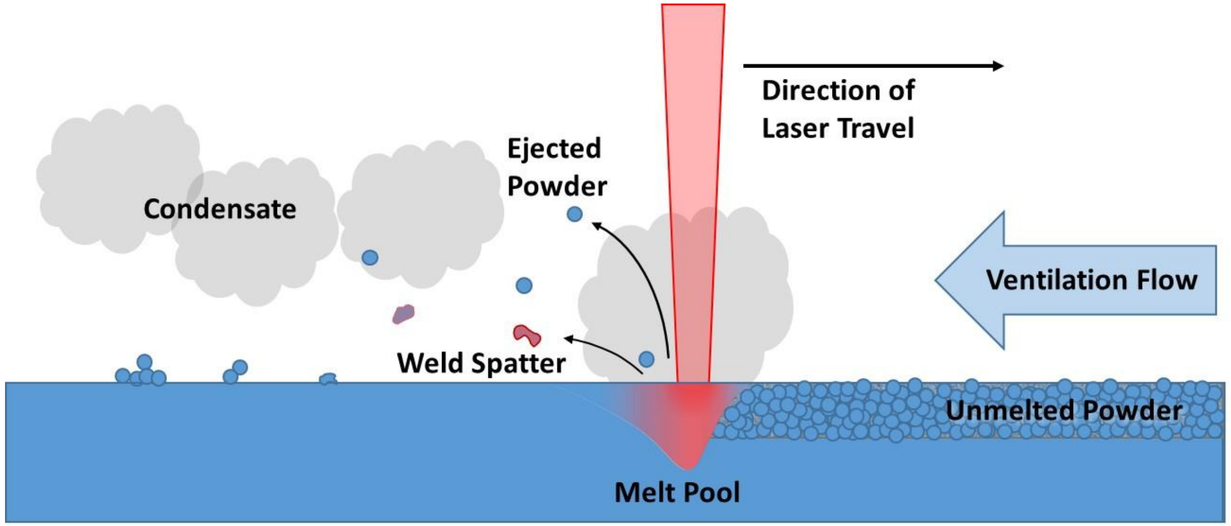
Complexity of Features vs Process

- Complexity of Internal and External Features
  - High Complexity
    - L-PBF
    - E-PBF
    - Binder Jet
  - Medium Complexity
    - Laser Powder DED
    - Ultrasonic AM
    - Laser Wire DED
  - Low Complexity
    - Arc Wire DED
    - Cold Spray
    - Electron Beam DED
    - Friction Stir AM
    - Laser Hot Wire DED

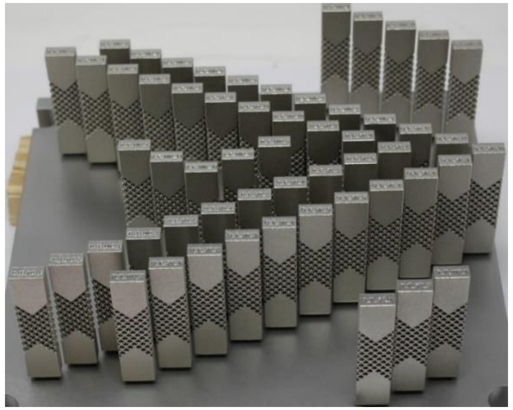
Maturity of Metal AM for NASA Applications

- **Laser Powder Bed Fusion (L-PBF)**
  - Basic Process: Layer-by-layer powder-bed approach where desired features are melted using a laser and solidify.
  - Advantages: High feature resolution, complex internal and external geometric features, the most common and mature AM platform type in service.
  - Disadvantages: Scale limited to machine build envelope, relatively low deposition rate, generally limited to weldable metals and alloys.





L-PBF AM process diagram



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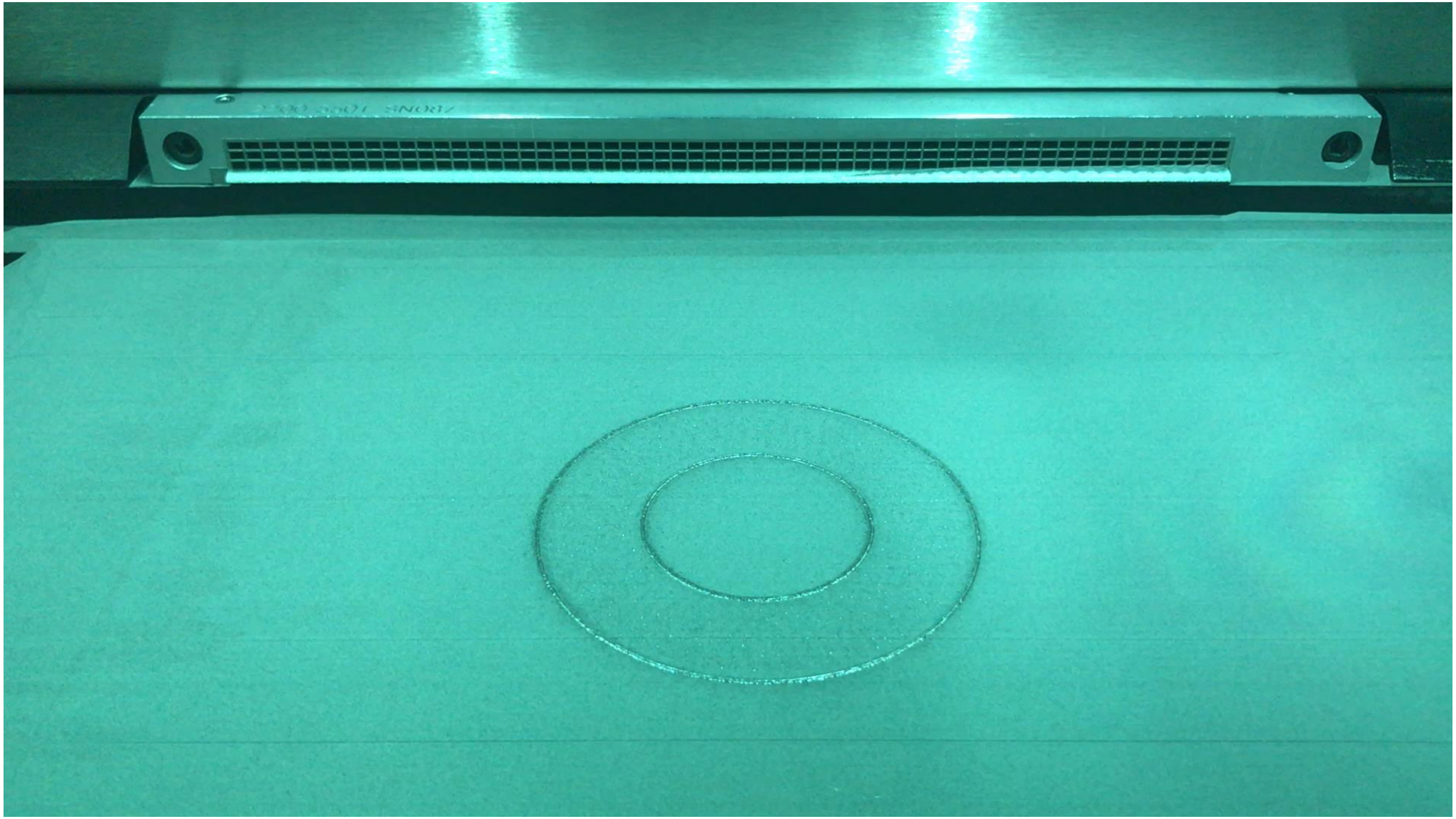
Laser Powder Bed Fusion (L-PBF)

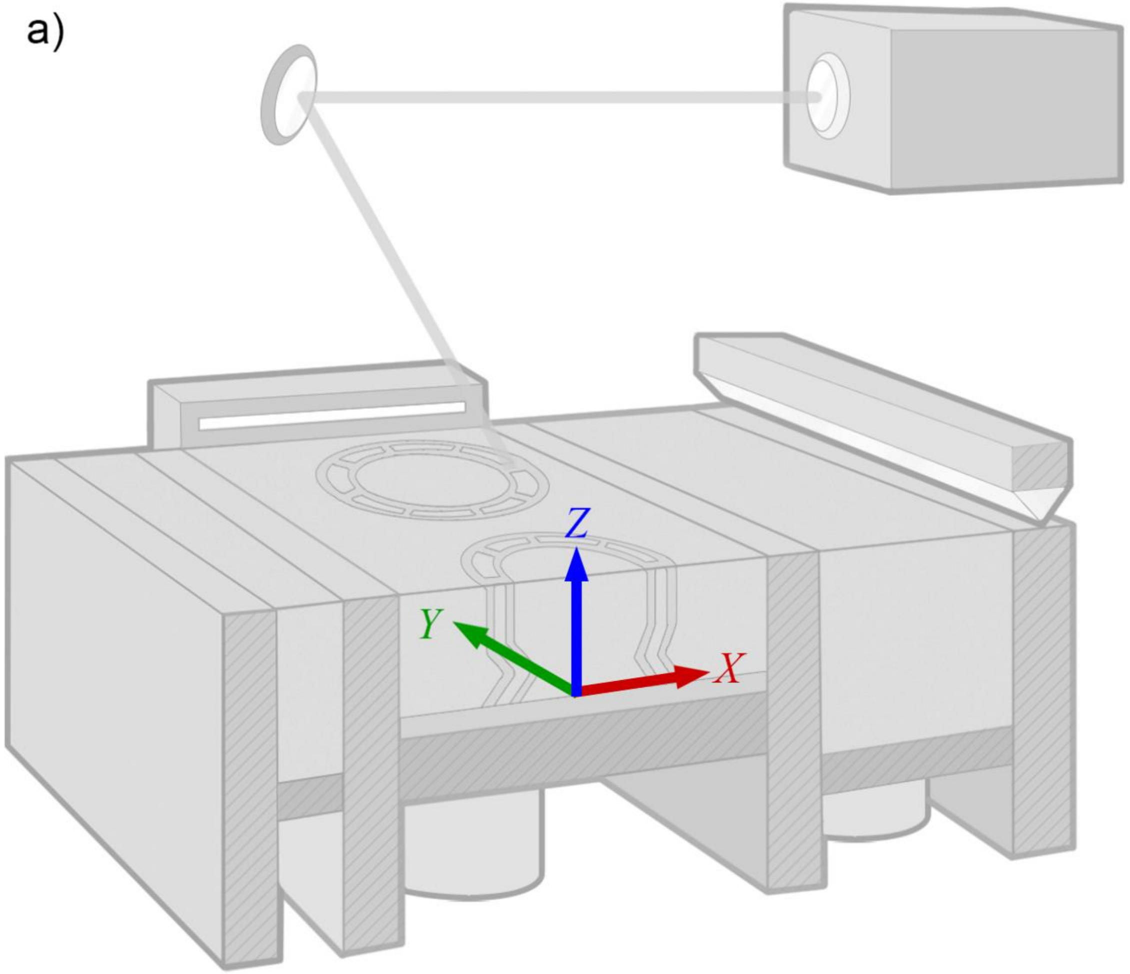


PBF Coordinate System

Machine Coordinate System

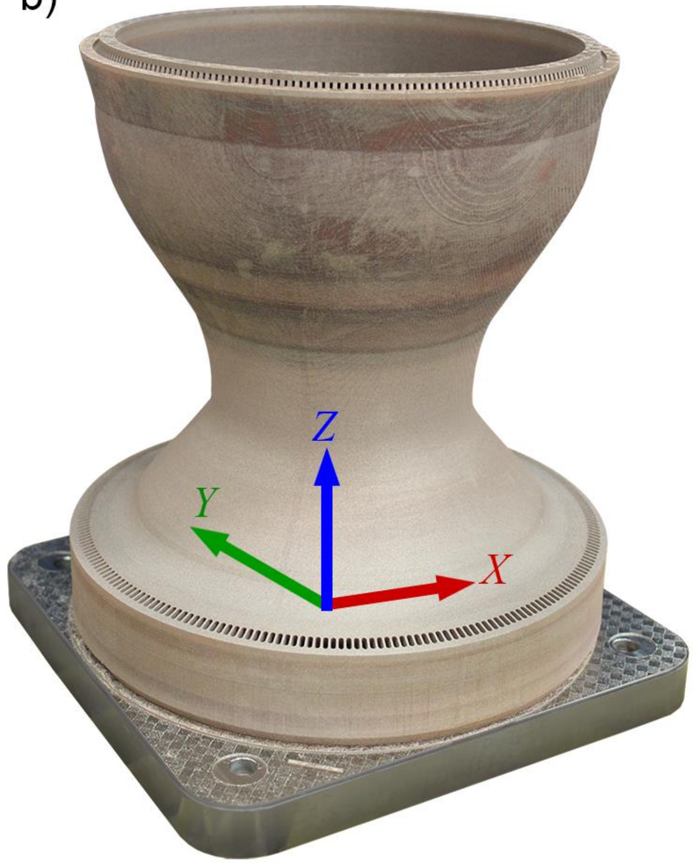
Z is always direction of build

a)

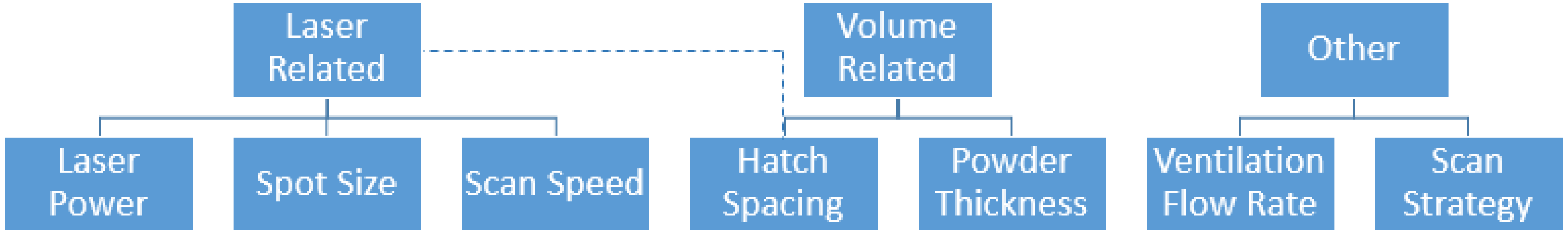


Coordinate system translates directly to part

b)

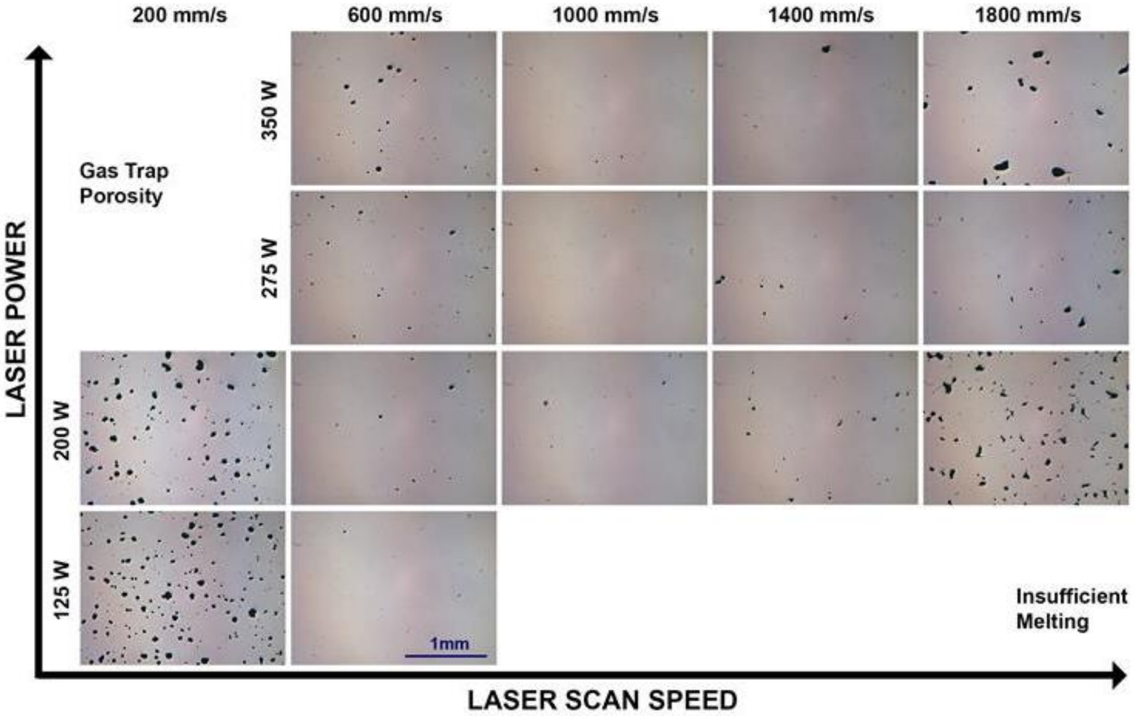


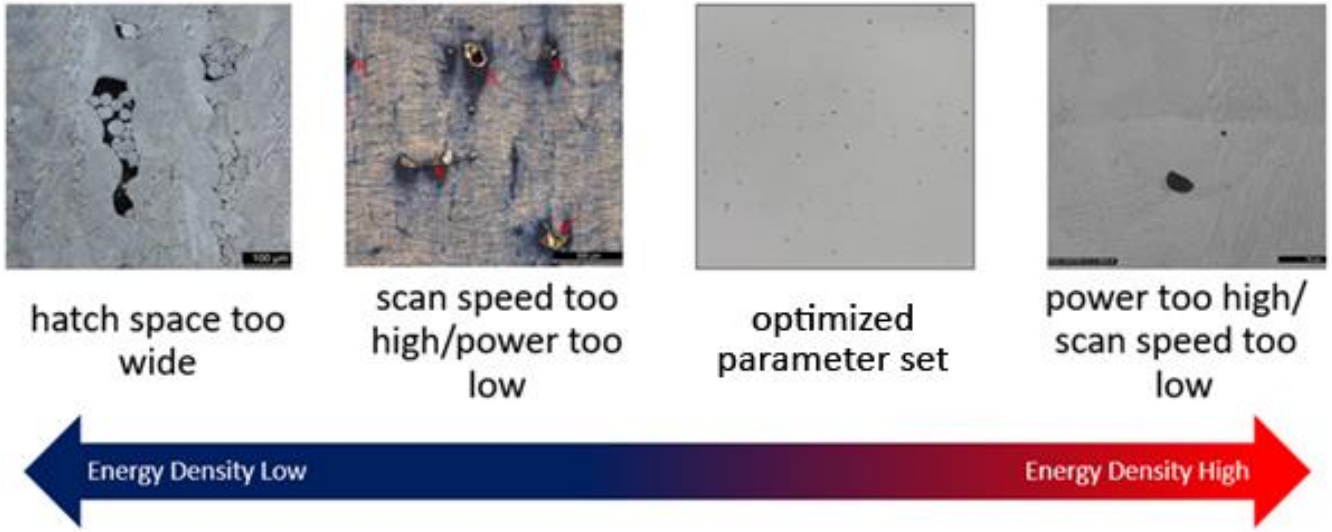
Parameter Development



$$E_v = \frac{P}{VDt}$$

E_v = Volumetric Energy Density (J/mm^3)
P = Power (W)
V = Velocity (mm/s)
D = Hatch Distance (mm)
t = Layer Thickness (mm)





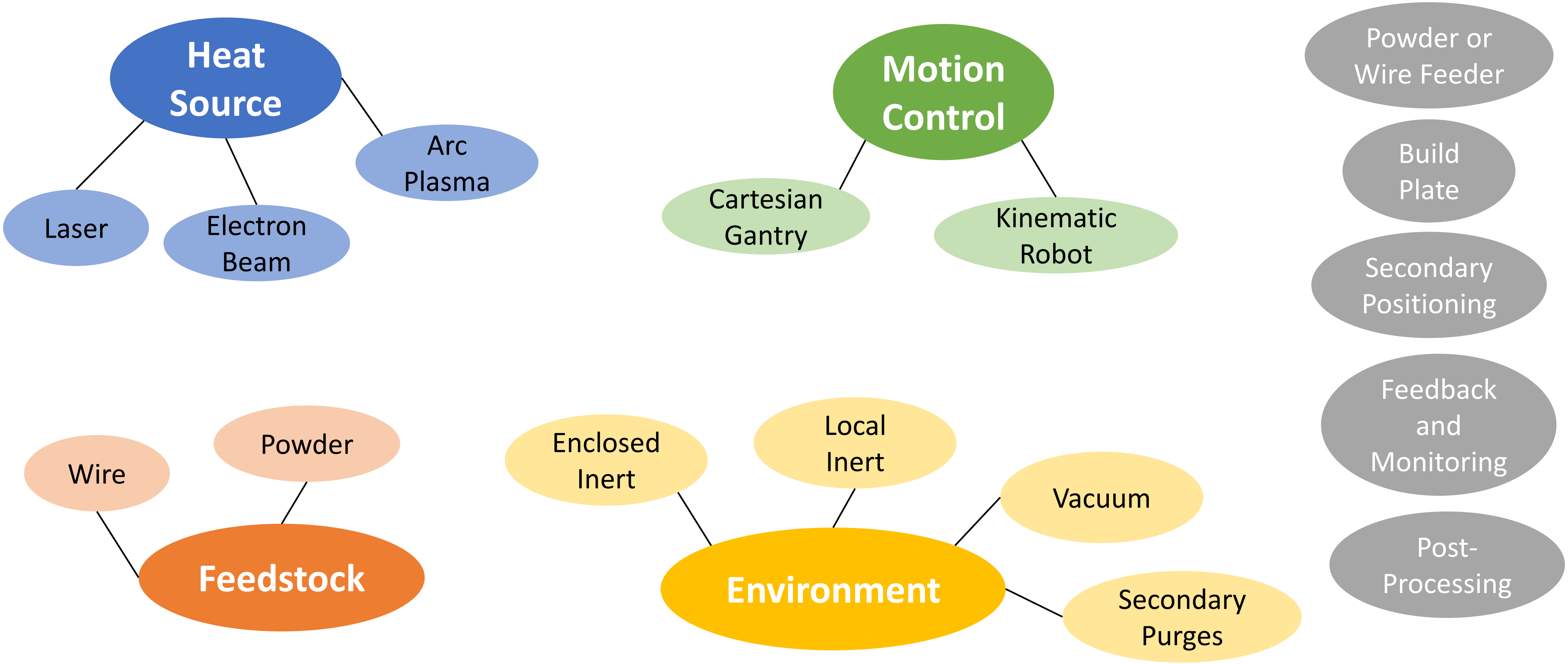
Break for Questions

Photo: NASA/Ben Smegelsky

Why DED?

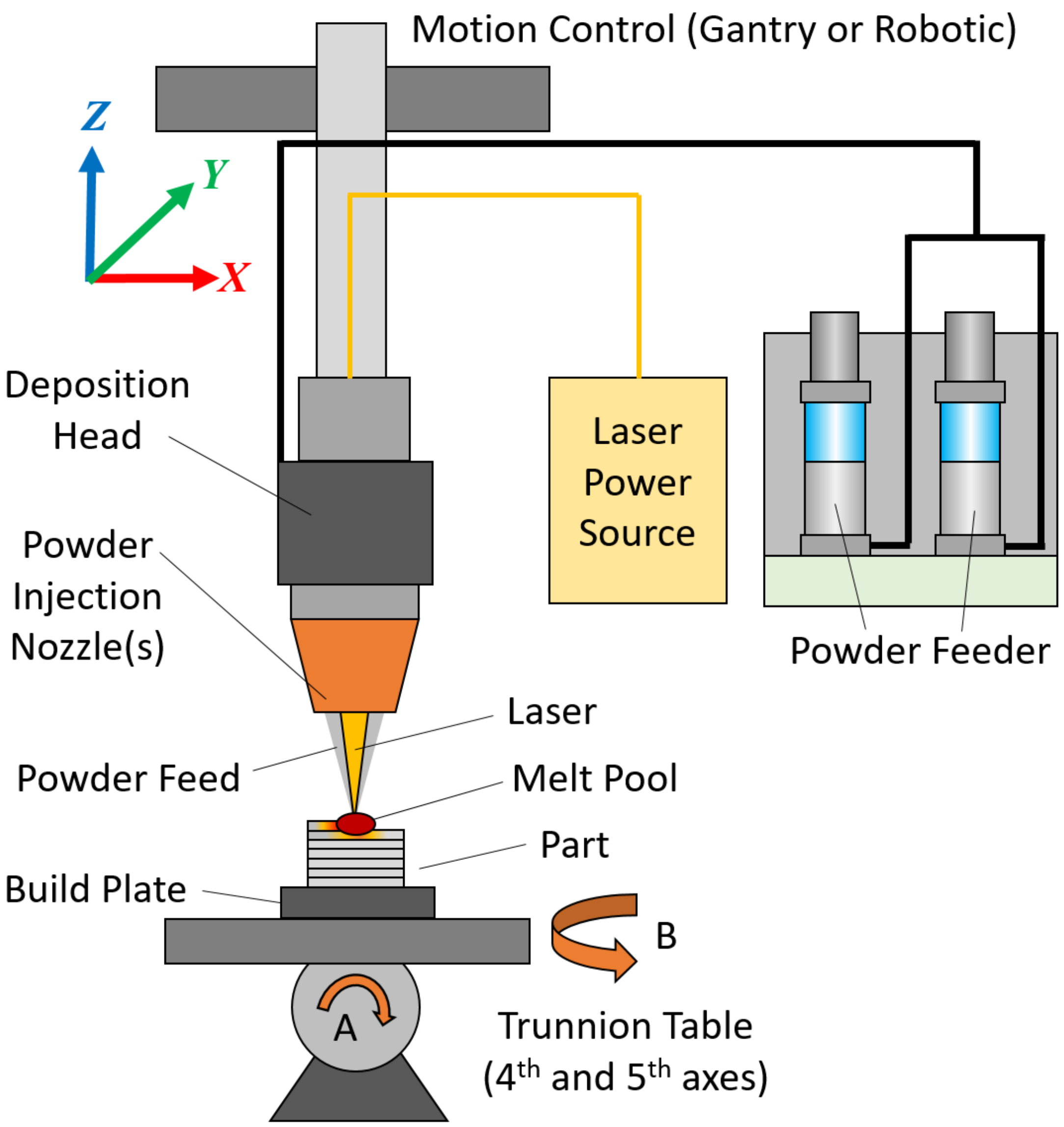
- Each Metal AM process provides advantages and disadvantages
  - Often complementary to each other
- DED offers advantages for various applications
  - Large Scale
  - Multi-axis
  - Use wire or powder feedstock
  - Ability to use multiple materials in same build
  - Ability to add material in a secondary operation
  - High deposition rates
  - Integration of secondary processes (machining)
  - Process feedback and closed loop control
- Disadvantages
  - Residual stresses (more heat input)
  - Lower resolution (less detailed complexity)
  - Higher surface texture (depending on process)

Aspects of AM DED Systems



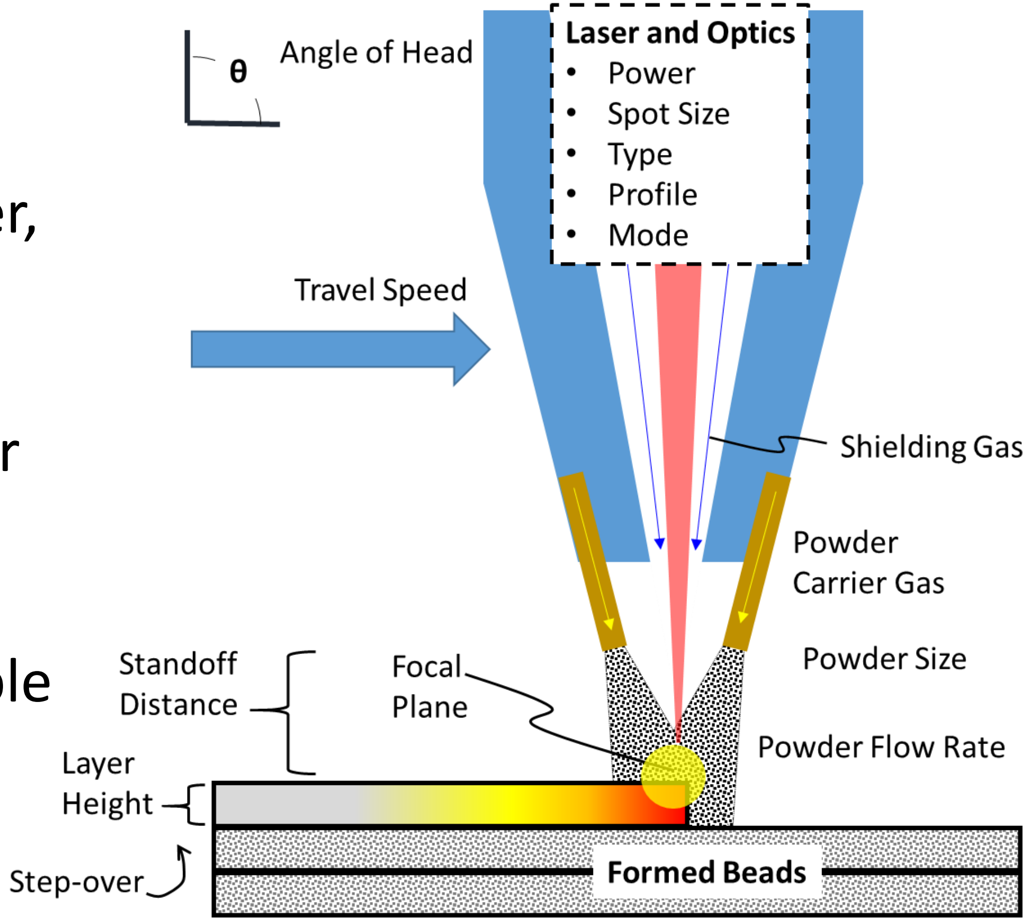
LP-DED Process Overview

- LP-DED system includes laser power source, powder feeder, and deposition head
- Attached to gantry or robotic motion control system
- Deposition head incorporates powder feed nozzle and optical path to focus laser beam and powder.
- A melt pool is created with the laser and powder blown into the melt pool depositing a bead.



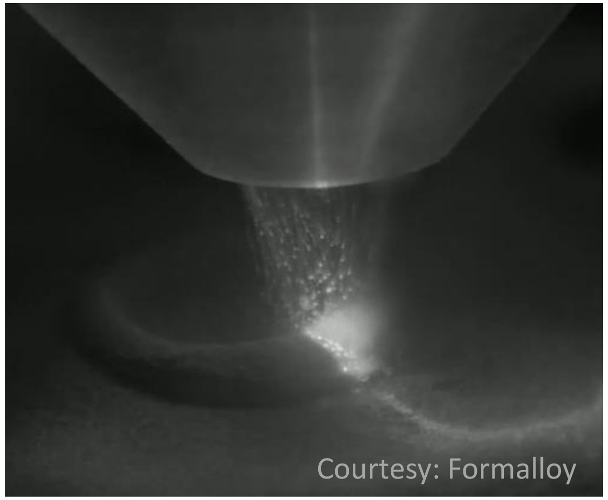
LP-DED Process Overview

- Powder and laser beam path (sometimes optics) integrated into deposition head
- Basic parameters include power, powder feedrate, travel speed, layer height
- Additional geometry control for layer height, step over (hatching), standoff distance, angle of head and trunnion table
- Can vary spot size



AIAA: Metal Additive Manufacturing for Propulsion Systems, Gradl et al (unreleased)

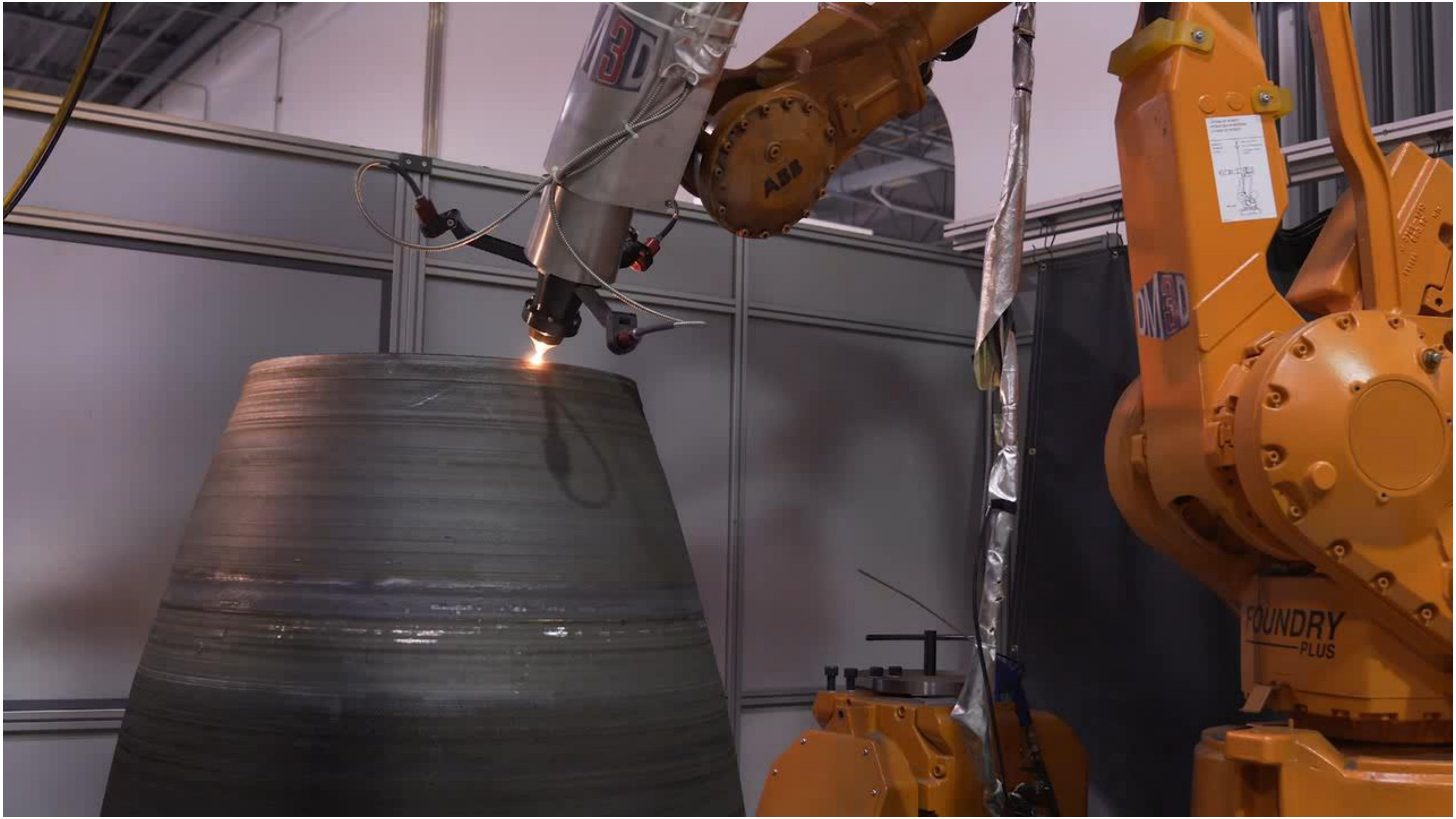
Courtesy: BeAM



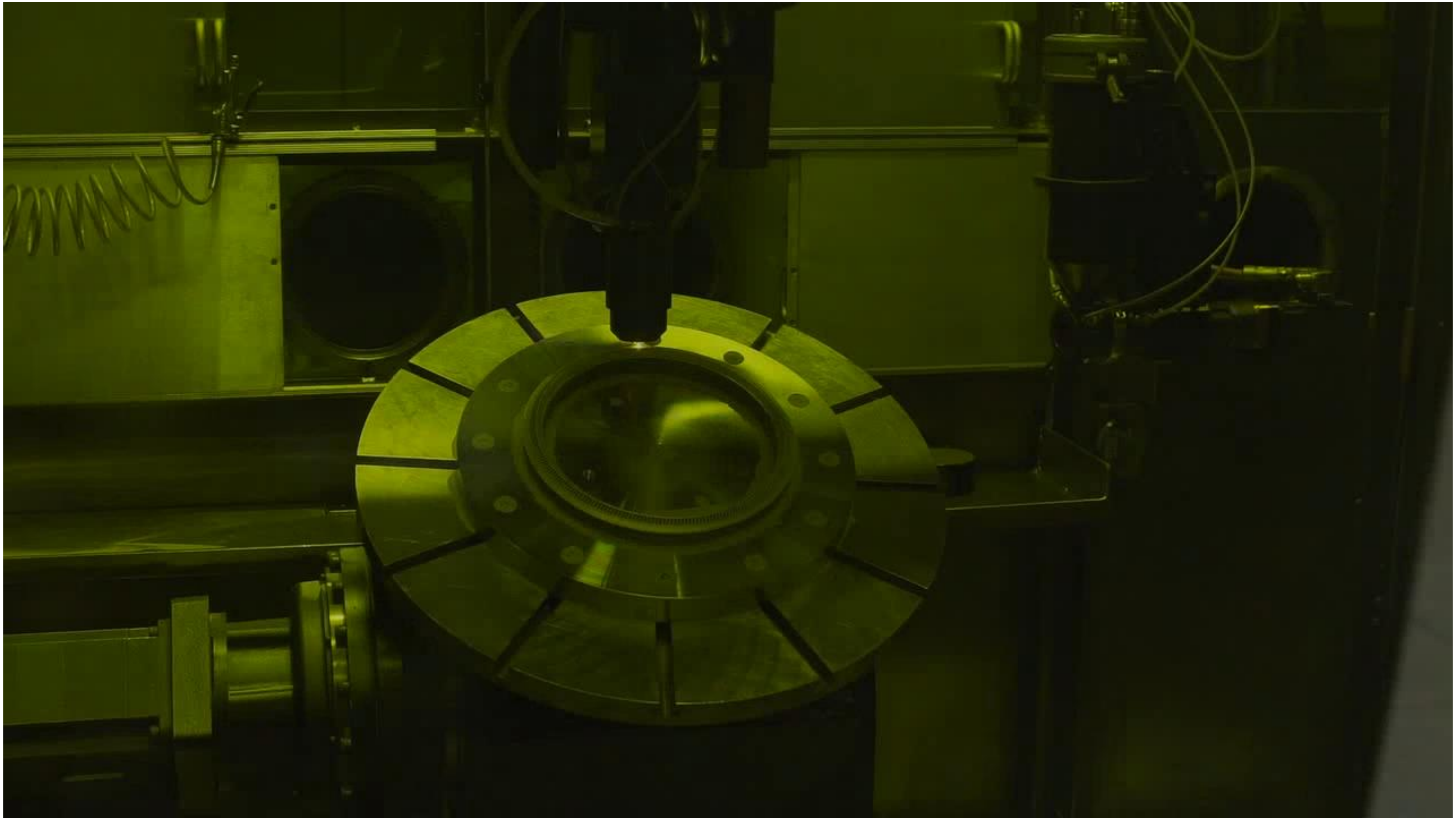
Courtesy: Formalloy

- Gradl, P. R., & Protz, C. S. (2020). Technology advancements for channel wall nozzle manufacturing in liquid rocket engines. *Acta Astronautica*. https://doi.org/10.1016/j.actaastro.2020.04.067
- AIAA Book: Metal Additive Manufacturing for Propulsion Systems, Gradl, Mireles, Protz, Garcia

Laser Powder Directed Energy Deposition (DED)

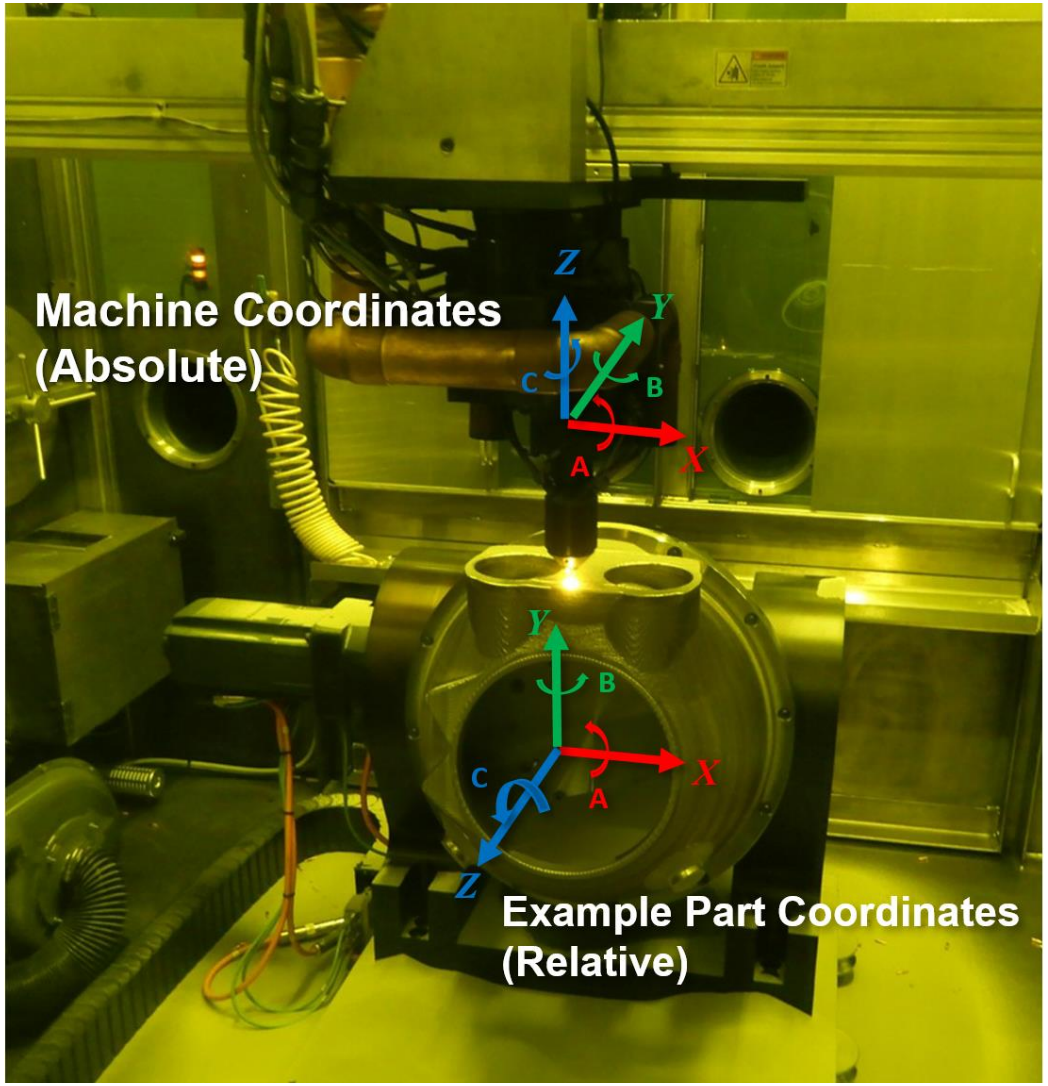


Example of LP-DED with small features

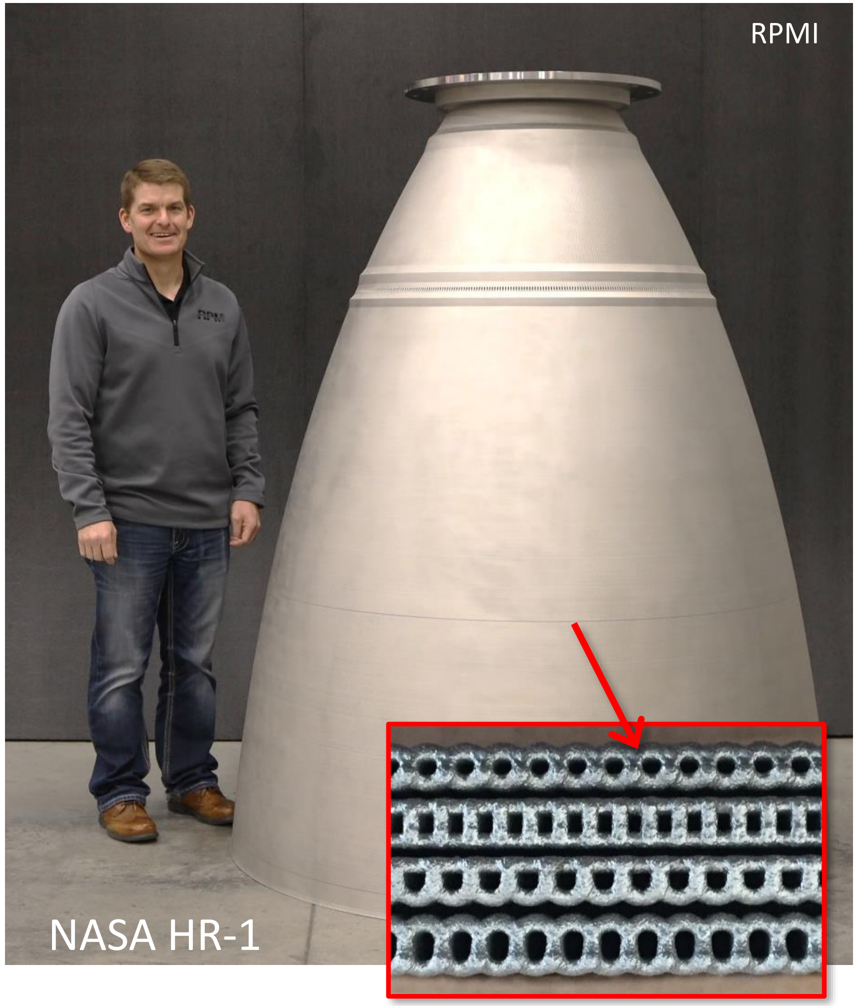


DED Machine Coordinates

- Coordinates defined by ASTM 52921 based on ISO 841
- 3D Cartesian coordinates (X, Y, Z) but includes swiveling and gimbaling
  - Trunion table – **rotate and tilt**
- Z is the build direction
- Similar to traditional CNC machining
- Absolute coordinate system is based on machine coordinates
- Relative coordinate system based on part



Large Scale LP-DED Nozzle Development



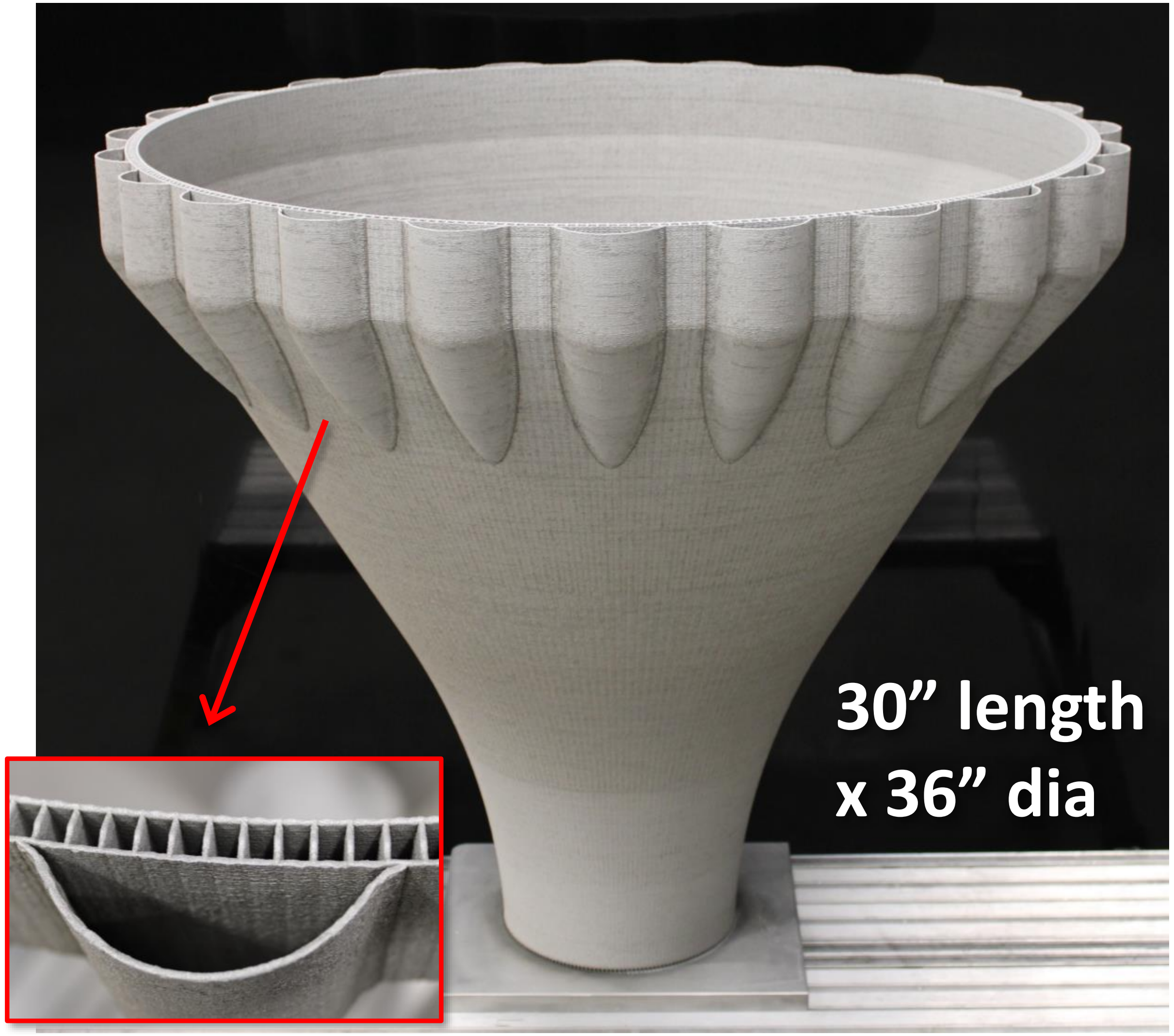
60" (1.52 m) diameter and 70" (1.78 m) height with integral channels
90 day deposition

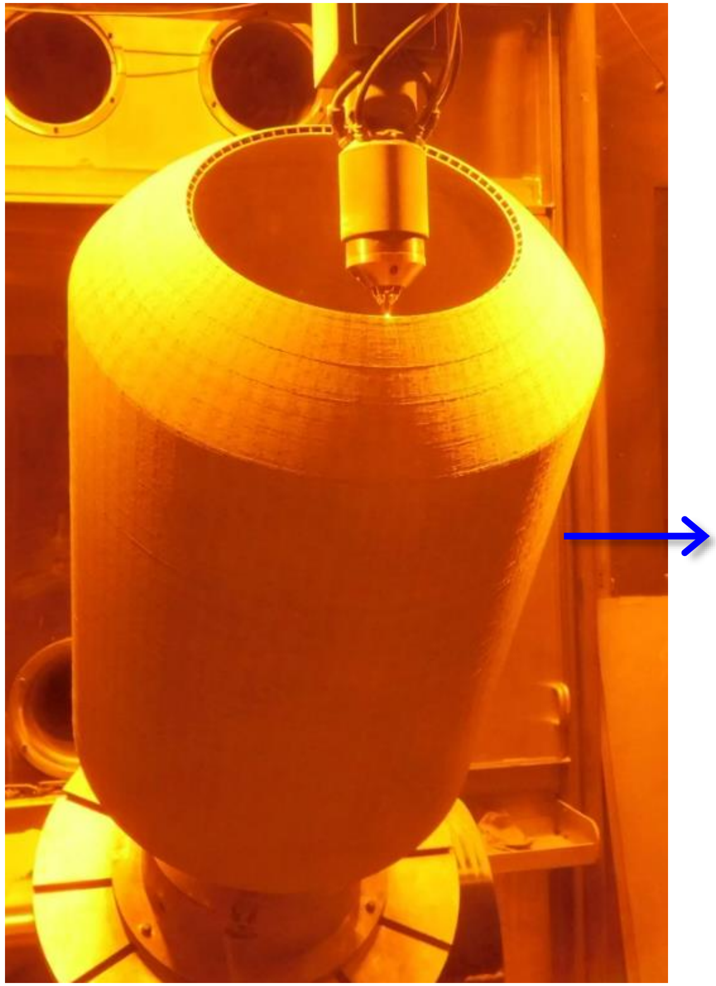
95" (2.41 m) dia and 111" (2.82 m) height
Near Net Shape Forging Replacement

Reference: P.R. Gradl, T.W. Teasley, C.S. Protz, C. Katsarelis, P. Chen, Process Development and Hot-fire Testing of Additively Manufactured NASA HR-1 for Liquid Rocket Engine Applications, in: AIAA Propuls. Energy 2021, 2021: pp. 1–23. https://doi.org/10.2514/6.2021-3236.

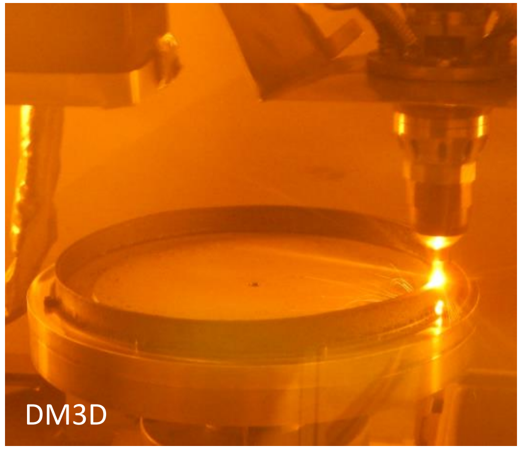
Aluminum Development with LP-DED

6061-RAM2 with 1.5 mm single-bead wall thickness





Component Applications using LP-DED

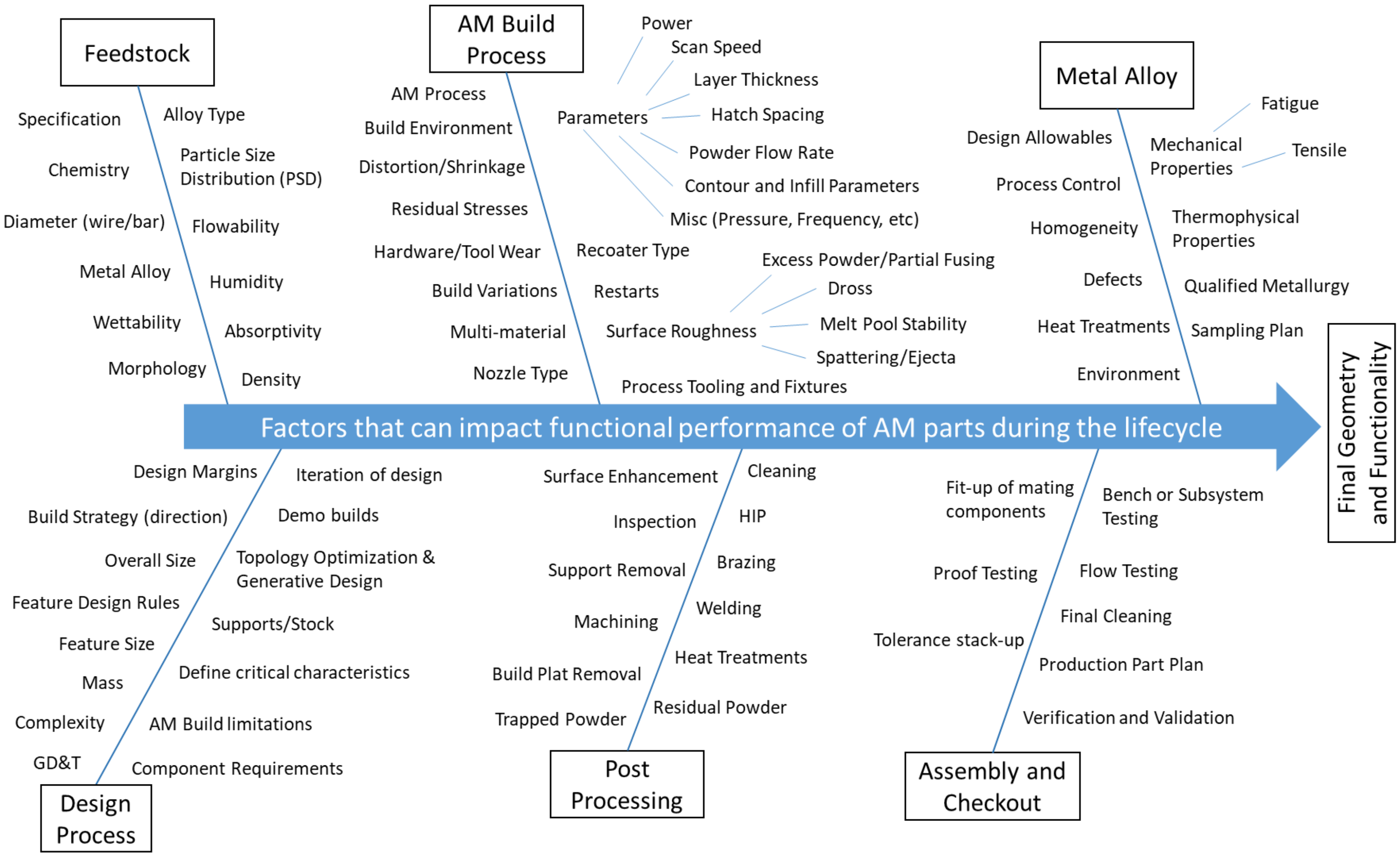


Spot size (Power) and Deposition Rates

Laser Power: 1070 W	Laser Power: 2000 W	Laser Power: 2620 W
Dep. Rate: 1 in.^{3}/h (23 cm^3/h)	Dep. Rate: 3 in.^{3}/h (49 cm^3/h)	Dep. Rate: 5 in.^{3}/h (82 cm^3/h)
Deposition Time: 24 hours	Deposition Time: 11 hours	Deposition Time: 6 hours

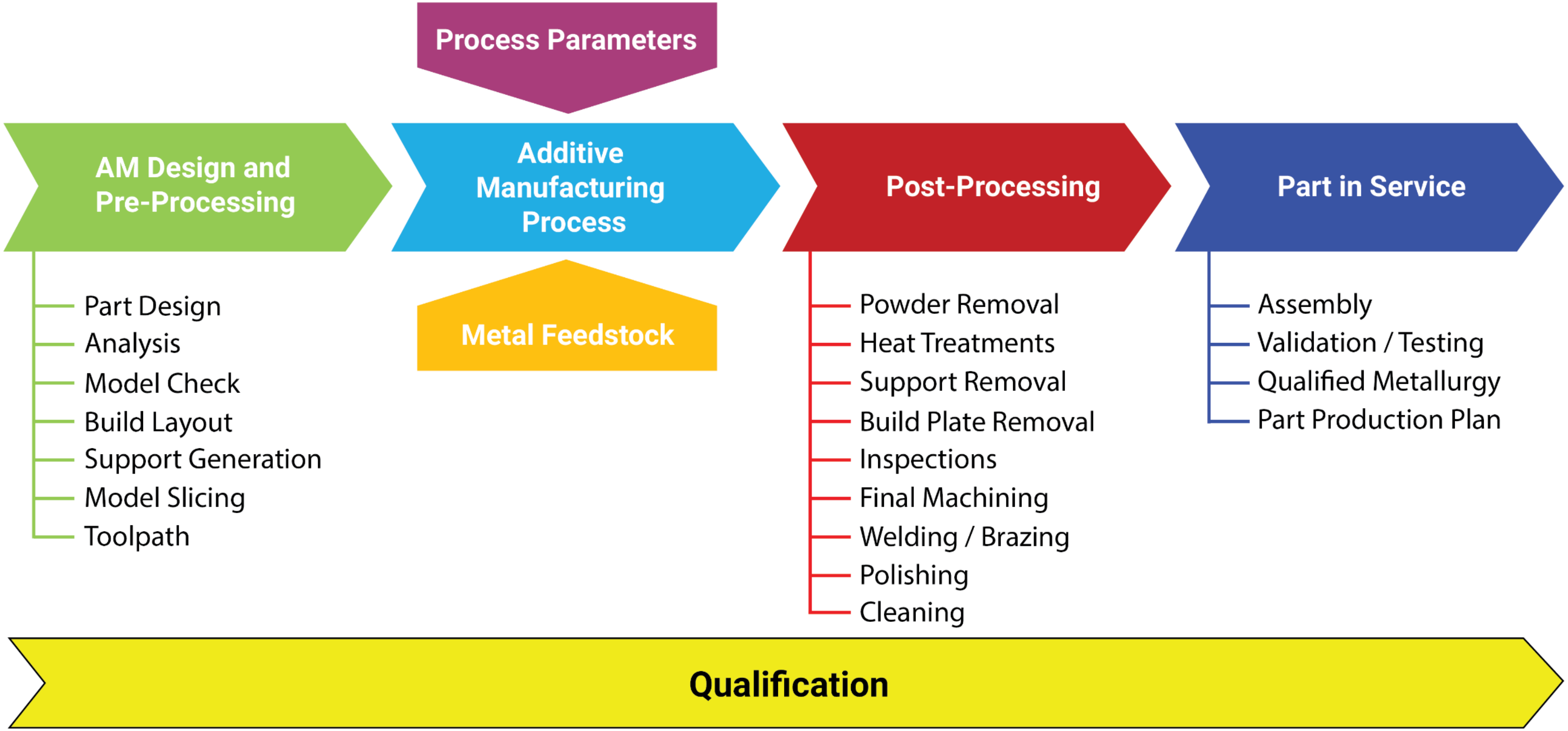
Credit: RPMI

The Challenges with AM Processes



There are a lot of inputs and steps in the AM lifecycle that must go right to meet the expected geometry

Additive Manufacturing Typical Process Flow



Proper AM process selection requires an integrated evaluation of all process lifecycle steps

Gradl, P., Tinker, D., Park, A., Mireles, O., Garcia, M., Wilkerson, R., Mckinney, C., 2021. Robust Metal Additive Manufacturing Process Selection and Development for Aerospace Components. Journal of Materials Engineering and Performance, Springer. https://doi.org/10.1007/s11665-022-06850-0

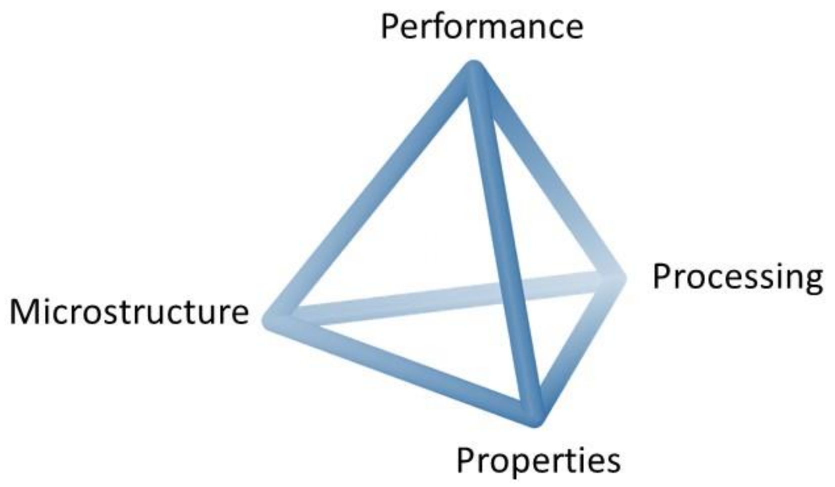
Material Selection

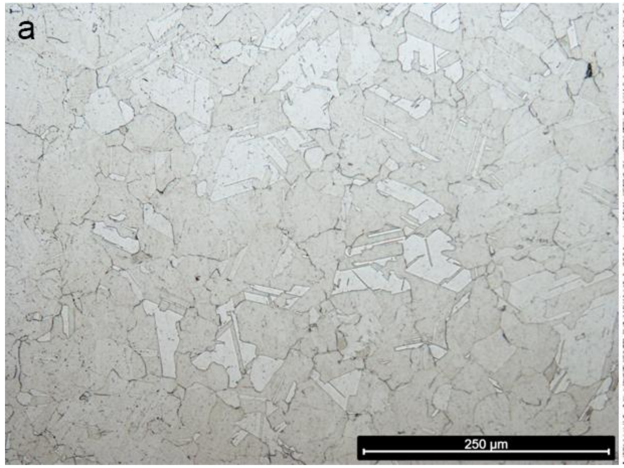
- Extreme environments, combined loads, mass limitations, and processing economics drive selection.
- Understanding the manufacturing technique and all steps required.
- Perform a trade study for each component *(hint: additive manufacturing will not be the best process or most economical for all components.)*
- One of the most frequent reasons for failure in DfAM is lack of attention to metallurgical characteristics from the process.

Material Science Fundamentals

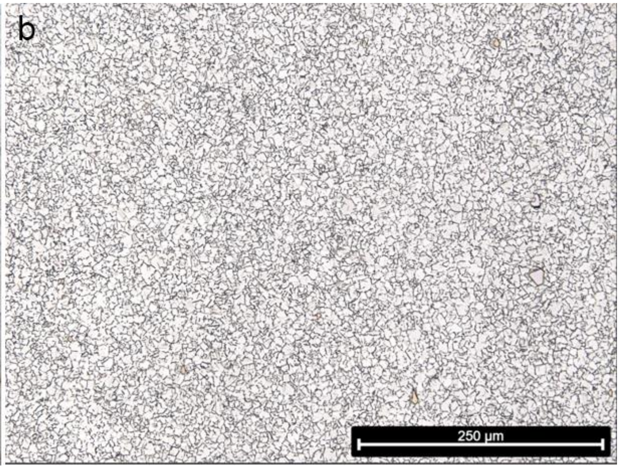
Process → Microstructure → Properties → Performance

- Each manufacturing process forms or modifies a material that establishes a microstructure.
- The properties are dependent on the microstructure and ultimately the end performance.
- AM is no different and each process can result in different microstructures.
- AM is different than wrought, forged material, cast material…
- **Based on AM process, orientation, parameters, geometry.**





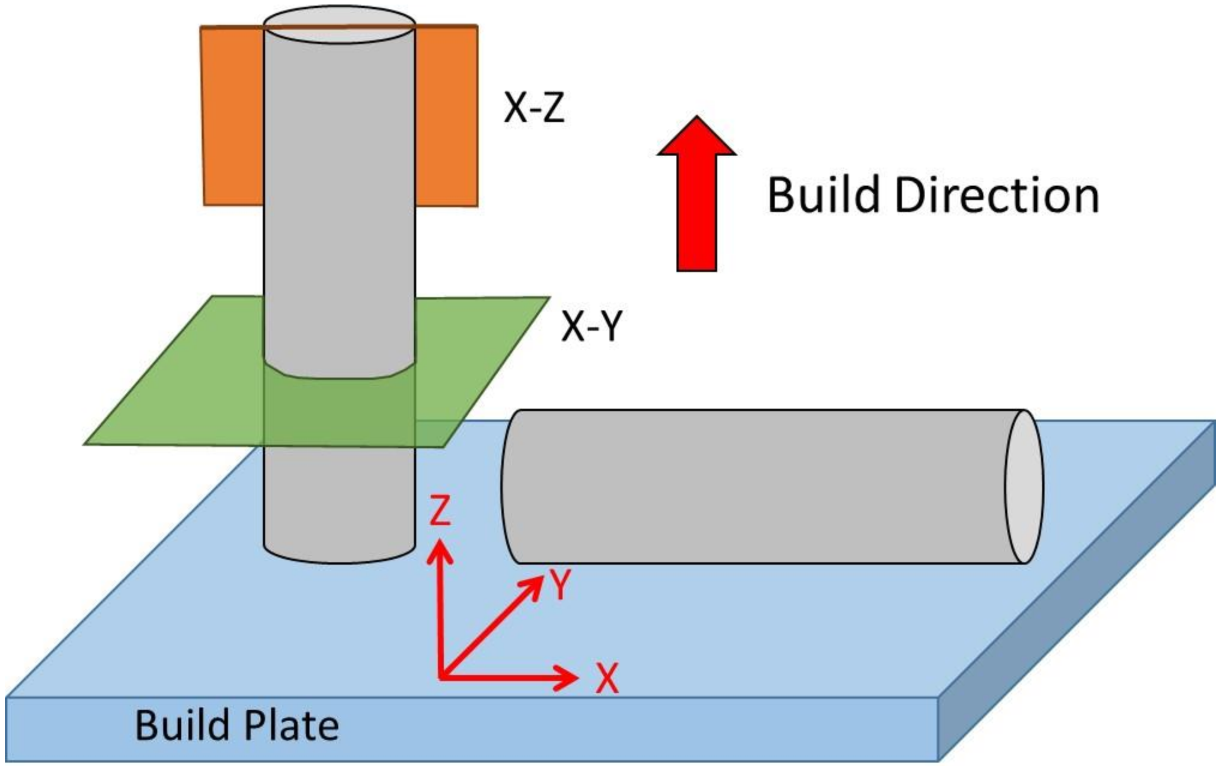
Inconel 718 built using L-PBF (200x)



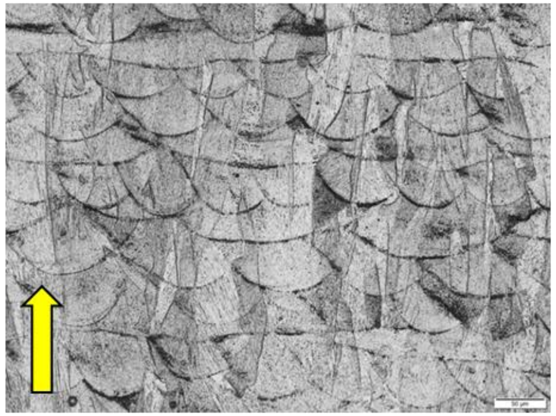
Inconel 718 bar stock (200x)

Coordinate System Reference

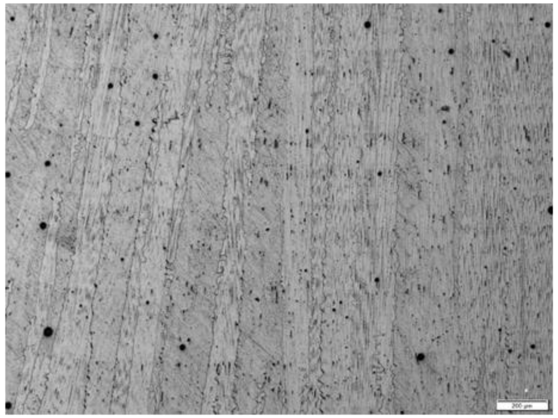
- Build direction (Z) dominates microstructure orientation.
- Anisotropy exists in AM materials, primarily between interlaminar (Z) and intralaminar (XY) directions.
- Variation due to heating and cooling direction and rates.



Microstructure of Various AM Processes
Alloy 625 – As-Built

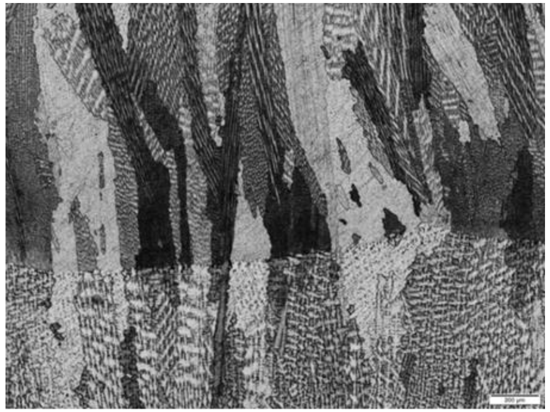


Laser Powder Bed Fusion

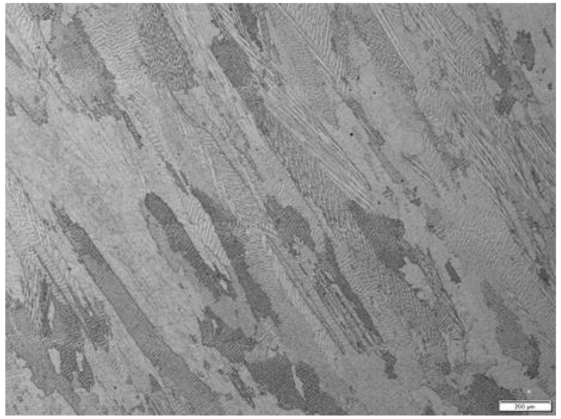


Electron Beam Powder Bed Fusion

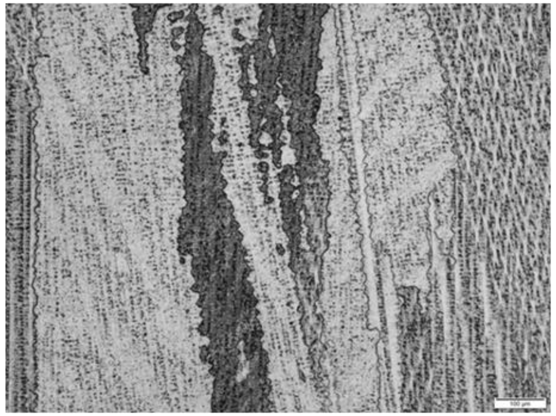
Laser Powder DED (1070 W)



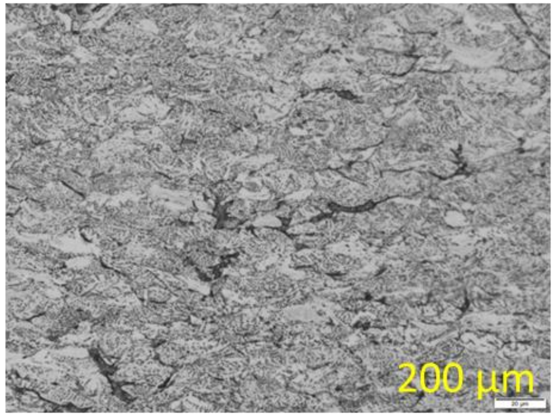
Electron Beam Wire DED



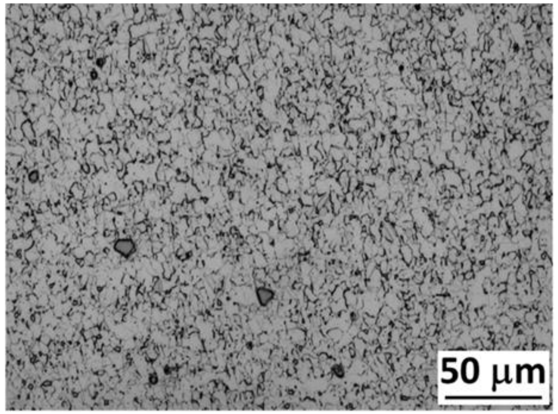
Laser Wire DED



Arc Wire DED



Cold Spray



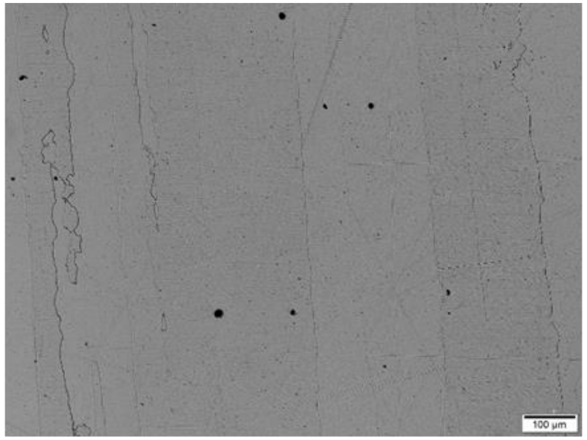
Additive Friction Stir Deposition

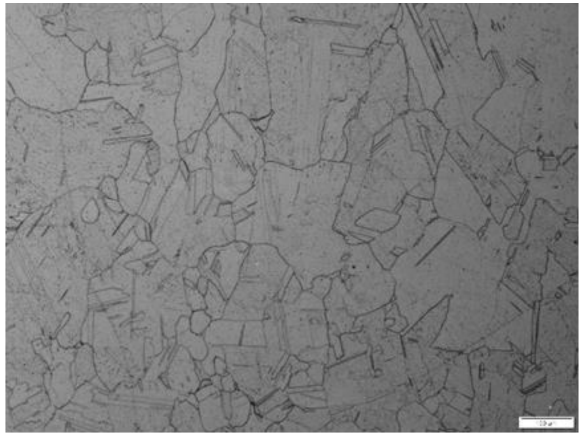
Each AM process results in different grain structures, which ultimately influence properties

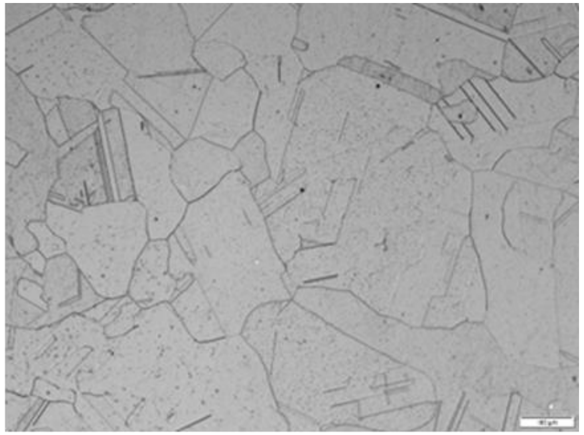
- Gamon, A., Arrieta, E., Gradl, P.R., Katsarelis, C., Murr, L.E., Wicker, R.B., Medina, F., 2021. Microstructure and hardness comparison of as-built Inconel 625 alloy following various additive manufacturing processes. Results in Materials 12. https://doi.org/10.1016/j.rinma.2021.100239
- Gradl, P., Tinker, D., Park, A., Mireles, O., Garcia, M., Wilkerson, R., Mckinney, C., 2021. Robust Metal Additive Manufacturing Process Selection and Development for Aerospace Components. Journal of Materials Engineering and Performance, Springer. https://doi.org/10.1007/s11665-022-06850-0
- Rivera, O. G., Allison, P. G., Jordon, J. B., Rodriguez, O. L., Brewer, L. N., McClelland, Z., ... & Hardwick, N. (2017). Microstructures and mechanical behavior of Inconel 625 fabricated by solid-state additive manufacturing. Materials Science and Engineering: A, 694, 1-9.
- Image from Mark Norfolk, Fabrisonic

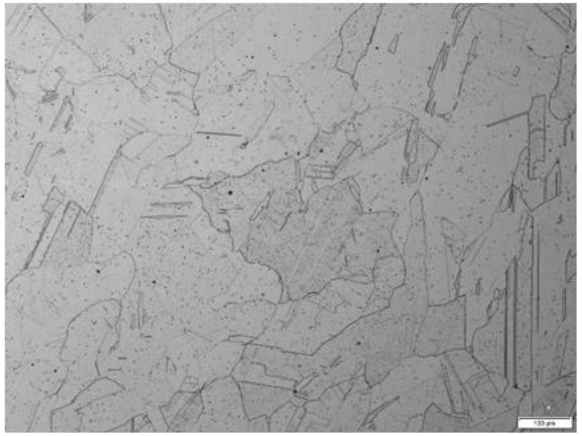
Microstructure of Various AM Processes
Alloy 625 – Stress Relief, HIP, Solution per AMS 7000

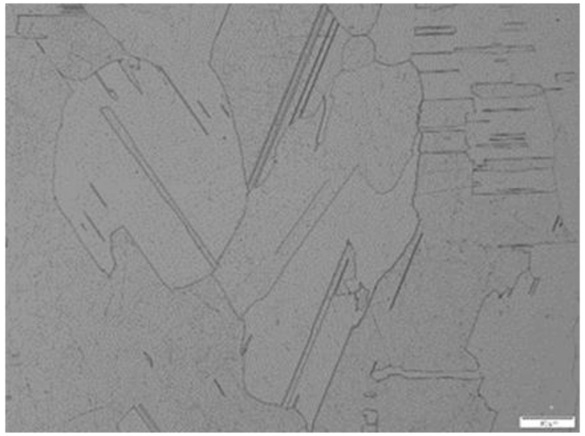

Laser Powder Bed Fusion

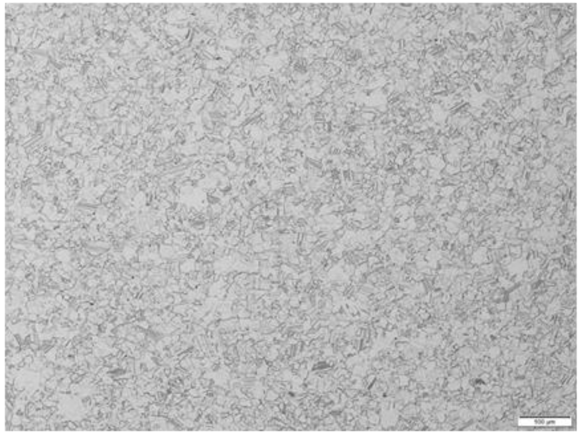

Electron Beam PBF


Laser Powder DED (1070 W)


Electron Beam Wire DED


Laser Wire DED


Arc Wire DED

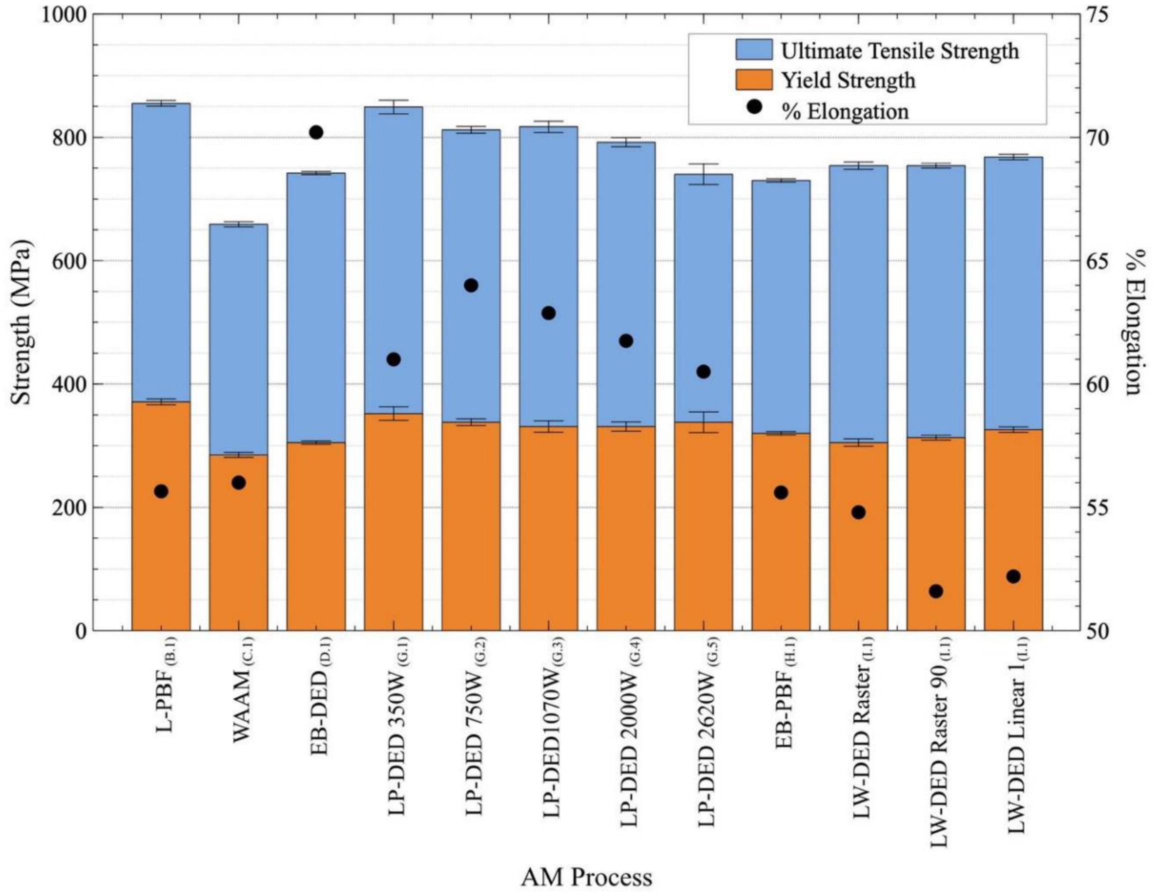

Cold Spray

- Gamon, A., Arrieta, E., Gradl, P.R., Katsarelis, C., Murr, L.E., Wicker, R.B., Medina, F., 2021. Microstructure and hardness comparison of as-built Inconel 625 alloy following various additive manufacturing processes. Results in Materials 12. https://doi.org/10.1016/j.rinma.2021.100239
- Gradl, P., Tinker, D., Park, A., Mireles, O., Garcia, M., Wilkerson, R., Mckinney, C., 2021. Robust Metal Additive Manufacturing Process Selection and Development for Aerospace Components. Journal of Materials Engineering and Performance, Springer. https://doi.org/10.1007/s11665-022-06850-0

Material Properties for Various AM Processes

- Material properties are highly dependent on the type of process (L-PBF, DED, UAM, Cold spray….), the starting feedstock chemistry, the parameters used in the process, and the heat treatment processes used post-build.
- Each AM process results in different grain distributions, precipitates, and porosity, all of which influence final properties.
- Heat treatments should be developed based on the requirements and environment of the end component use.
- Process, parameters, and feedstock should all be stable before property development.

Alloy 625, Heat Treated per AMS 7000 Room Temperature UTS



*Not design data and provided as an example only

Luna, V.; Trujillo, L.; Gamon, A.; Arrieta, E.; Murr, L.E.; Wicker, R.B.; Katsarelis, C.; Gradl, P.R.; Medina, F. Comprehensive and Comparative Heat Treatment of Additively Manufactured Inconel 625 Alloy and Corresponding Microstructures and Mechanical Properties. *J. Manuf. Mater. Process.* **2022**, *6*, 107. https://doi.org/10.3390/jmmp6050107

SOUTHWEST RESEARCH INSTITUTE

AM Alloys Available *(not fully inclusive)*

Ni-Based
Inconel 625
Inconel 713
Inconel 718
Inconel 738
Inconel 939
Hastelloy-X
Haynes 214
Haynes 230
Haynes 233
Haynes 282
Monel K-500
C276
Rene 80
Rene 142
Waspalloy

Fe-Based
SS 17-4PH
SS 15-5 GP1
SS 304
SS 316L
SS 410
SS 420
SS 440
4140/4340
Invar 36
SS347
JBK-75
NASA HR-1

Cu-Based
Pure Cu
GRCop-84
GRCop-42
C18150
C18200
Glidcop
CU110
Monel K500

Co-Based
CoCr/CoCrMo
Haynes 188
Stellite 6, 21, 31

Platinum Group
Ir, Pt, Rh, Ru, Pd, Au, Ag

Refractory
W
WRe
Mo
MoW
MoRe
Ta
TaW
Re
Nb
C103
FS85
High Entropy

Ti-Based
Ti6Al4V
γ-TiAl
Ti-6-2-4-2

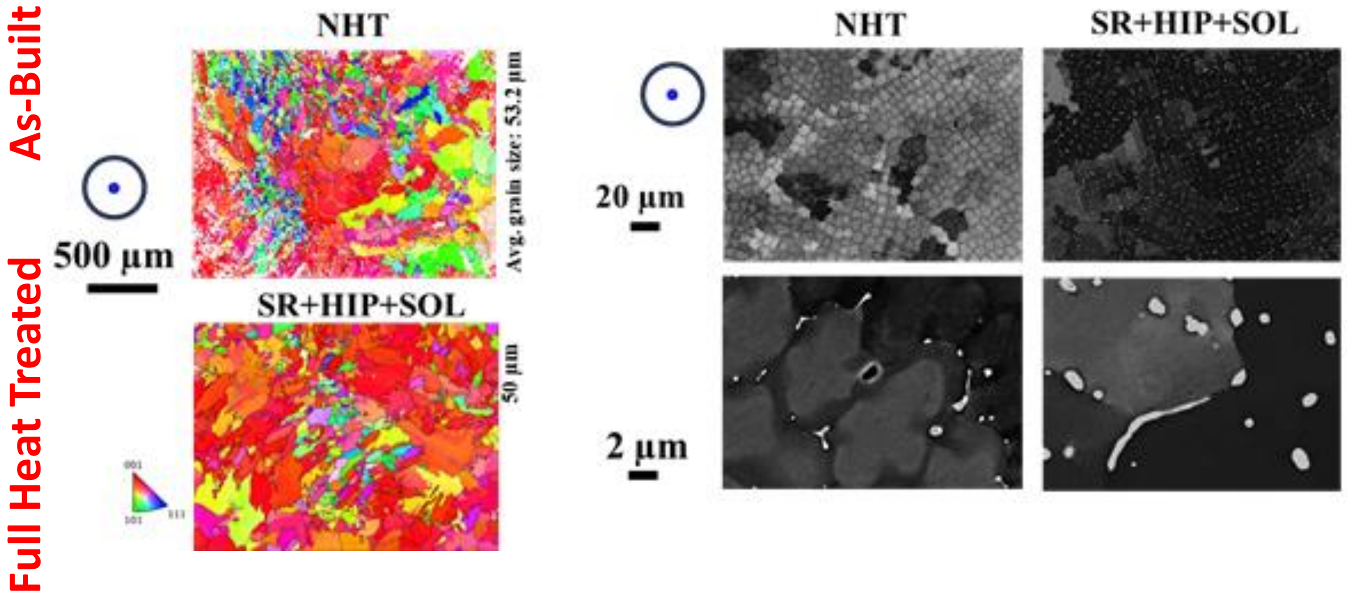
Al-Based
AlSi10Mg
A205
F357
1000*
6061*
2024*
7075*
7050*
Scalmalloy*
7A77*

*Reactive-based AM

Data Example For LP-DED AM Haynes 230

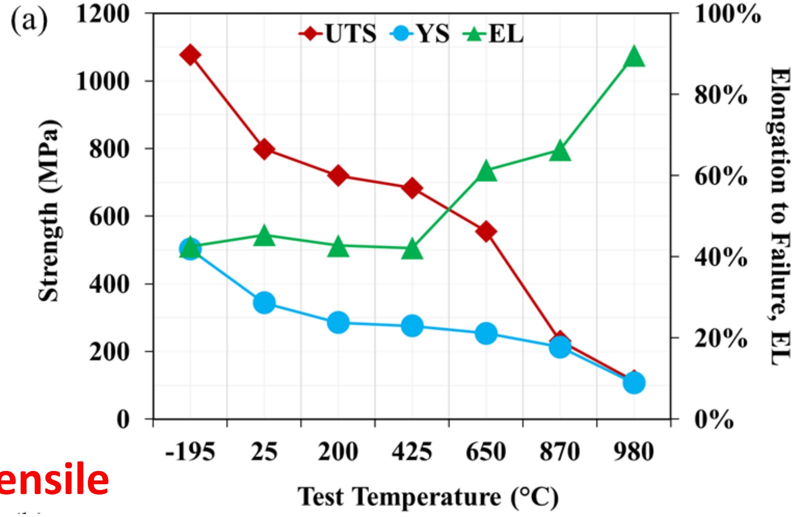
Power (W)	Layer height (µm)	Travel speed (mm/min)	Powder feed rate (g/min)
1070	381	1016	19.10

Procedure (Designation)	Temperature (°C)	Time (hrs)	Cooling
Stress Relief (SR)	1066	1.5	Furnace cool
HIP [2]	1163/103 MPa	3	Furnace cool
Solution Annealing (SOL)	1177	3	Argon quench

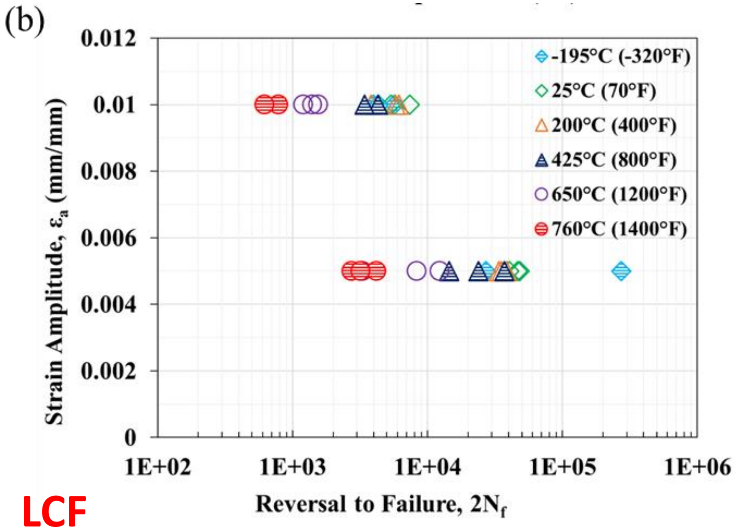


[2] HIP per ASTM F3301

Data from Gradl, Mireles, Protz, Garcia. "Metal Additive Manufacturing for Propulsion Applications", AIAA Progress Series. (2022). Appendix A.



Tensile



LCF

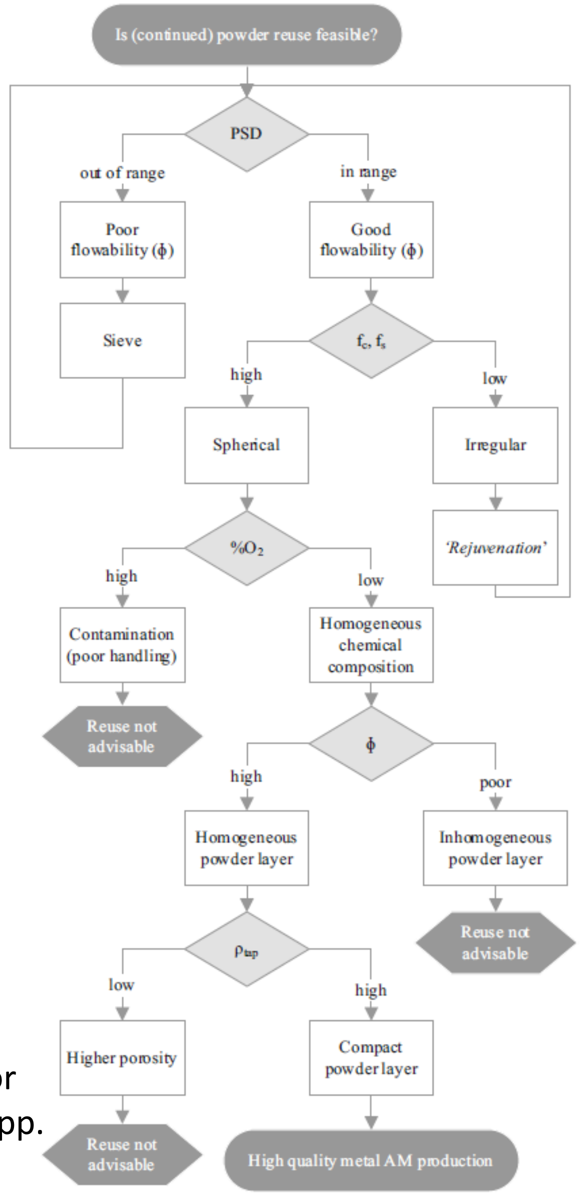
Feedstock Requirements

- Feedstock enables AM
- Powder, Wire, and others
- Responsibilities of the "mill" are passed onto the user
  - Chemistry
  - Cleanliness
  - Pedigree
  - Conformance to other standards

Process[a]	Type of Feedstock	Typical Feedstock Size
L-PBF	Powder	10–45 μm
EB-PBF	Powder	45–105 μm
LP-DED	Powder	45–105 μm
AW-DED	Wire	0.8–2 mm dia
LW-DED	Wire	0.6–1.6 mm dia
LHW-DED	Wire	0.8–1.6 mm dia
EBW-DED	Wire	1.14–3.2 mm dia
UAM	Sheet	Varies
AFS-D	Bar, powder	Varies
Cold spray	Powder	10–45 μm
Binder jet	Powder with binder	3–38 μm

Powder Feedstock Characterization: Reuse

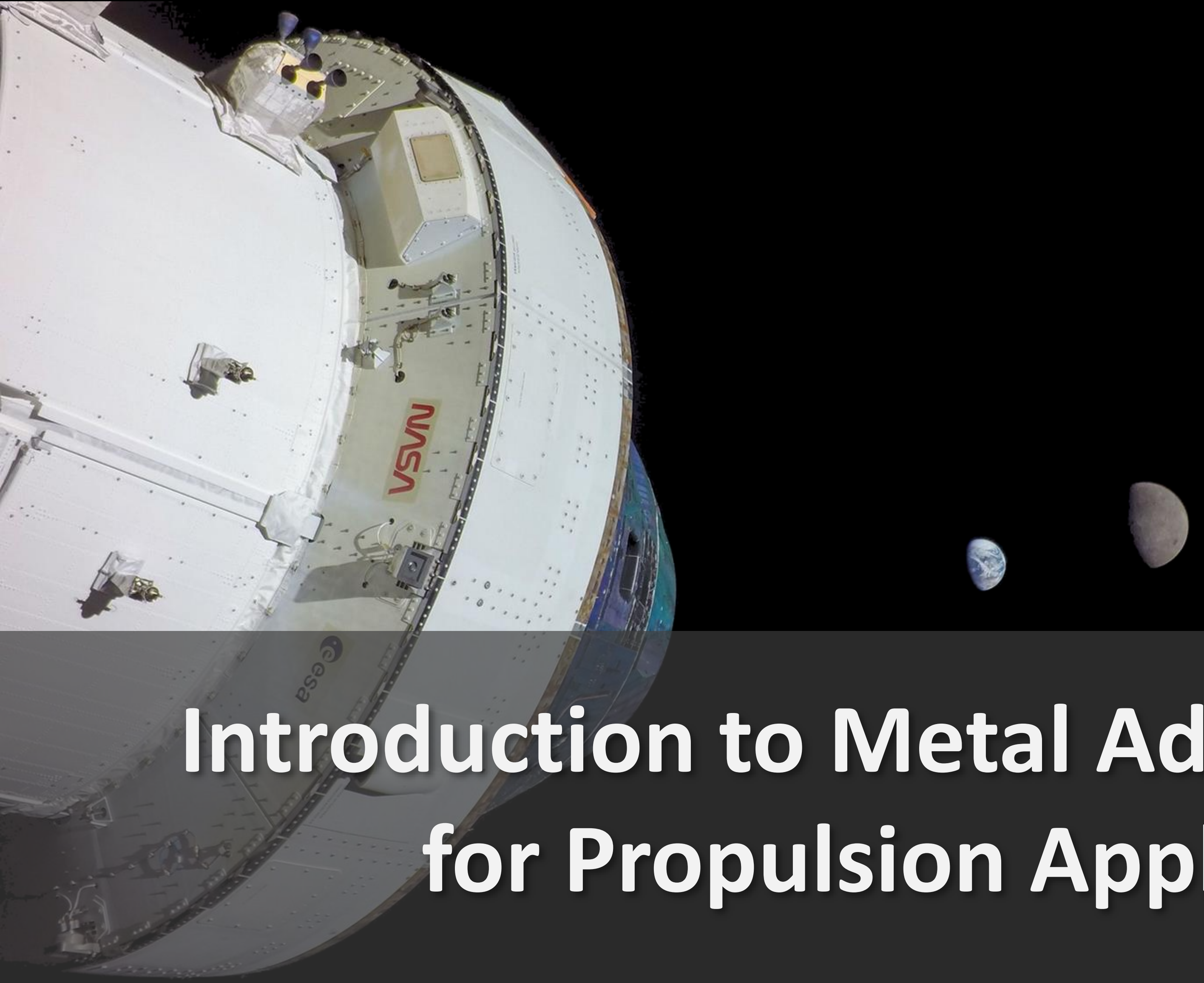
- Powder recycling is an essential aspect to the sustainability and material savings promised by AM
- Most protocols involved blending sieved reused powder with virgin powder.
- Oxygen pickup is the most observed change in reused powder
- Flowability can often be improved with reuse



Cordova, L., Campos, M., and Tinga, T. "Revealing the Effects of Powder Reuse for Selective Laser Melting by Powder Characterization." JOM, Vol. 71, No. 3, 2019, pp. 1062–1072. https://doi.org/10.1007/s11837-018-3305-2.

Break for Questions

Photo: NASA/Ben Smegelsky



Introduction to Metal Additive Manufacturing for Propulsion Applications: Part II

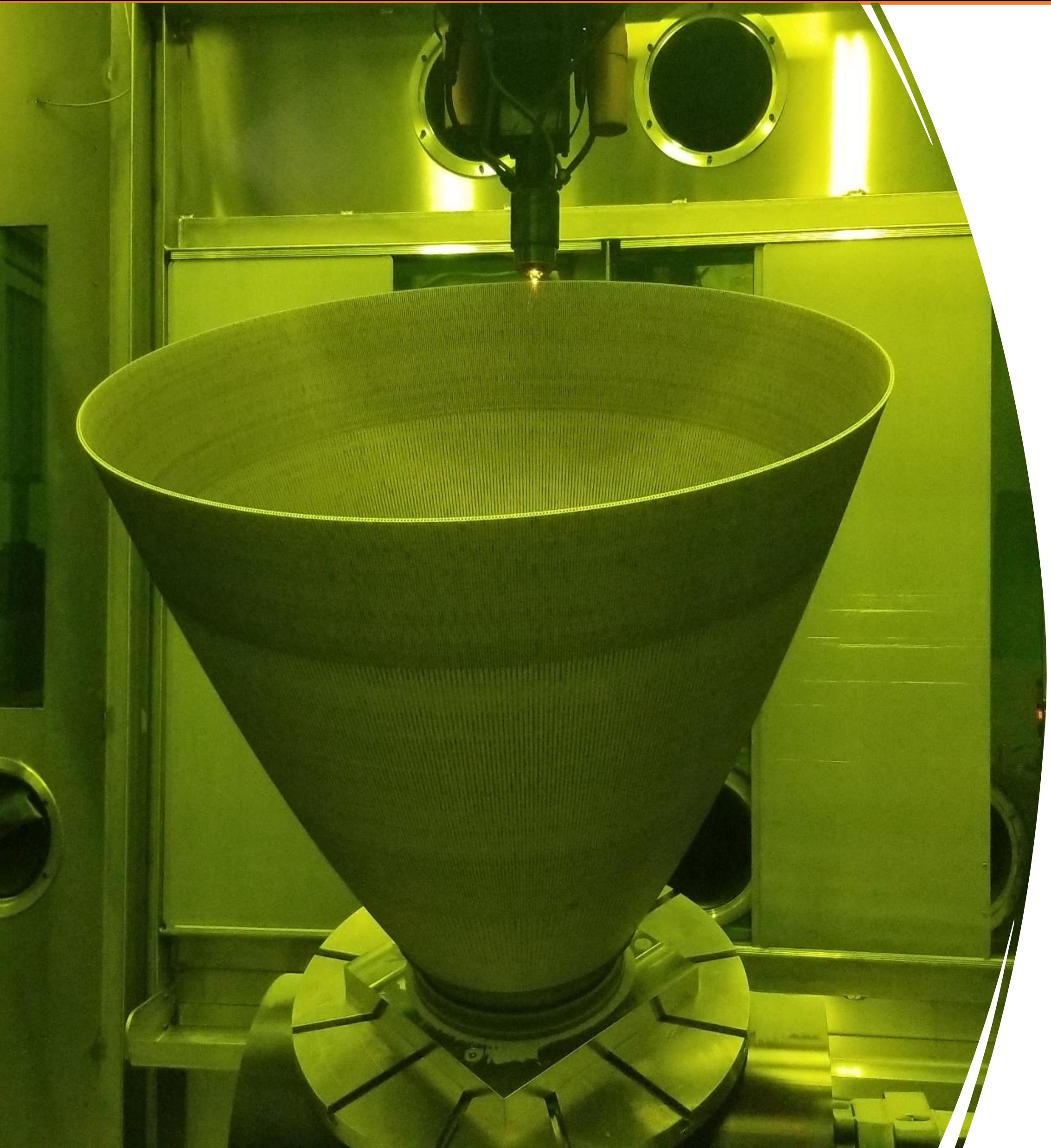
Paul Gradl
NASA Marshall Space Flight Center

Omar Mireles
Los Alamos National Laboratory

Nathan Andrews
Southwest Research Institute

6 January 2025

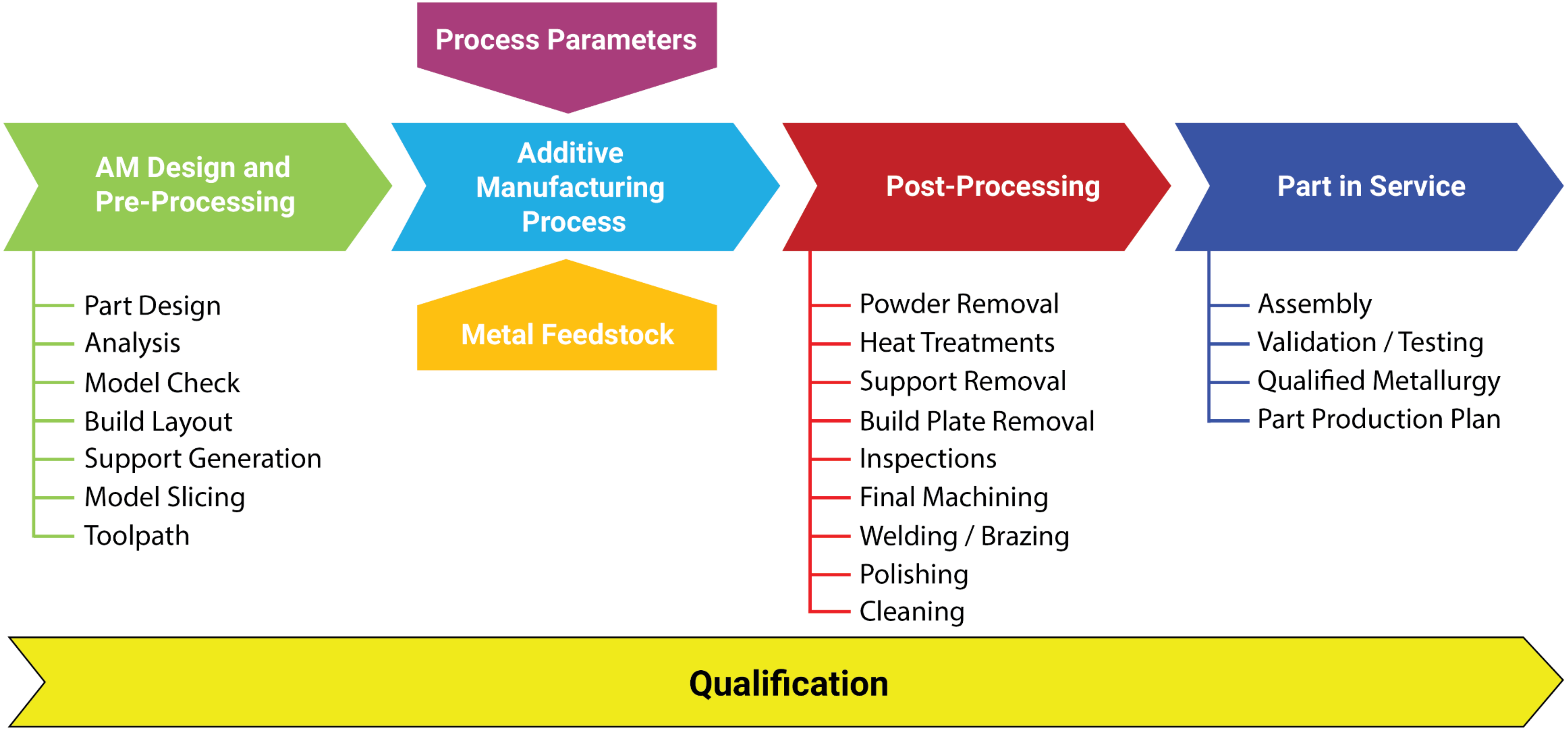
Overview of Presentation



- Introduction / Use Cases
- Metal AM Process Selection
- Overview of AM Materials & Microstructure
- Metal AM Feedstock
- AM Post-Processing
- Design for AM (DfAM)
- Qualification of Metal AM
- Case Studies

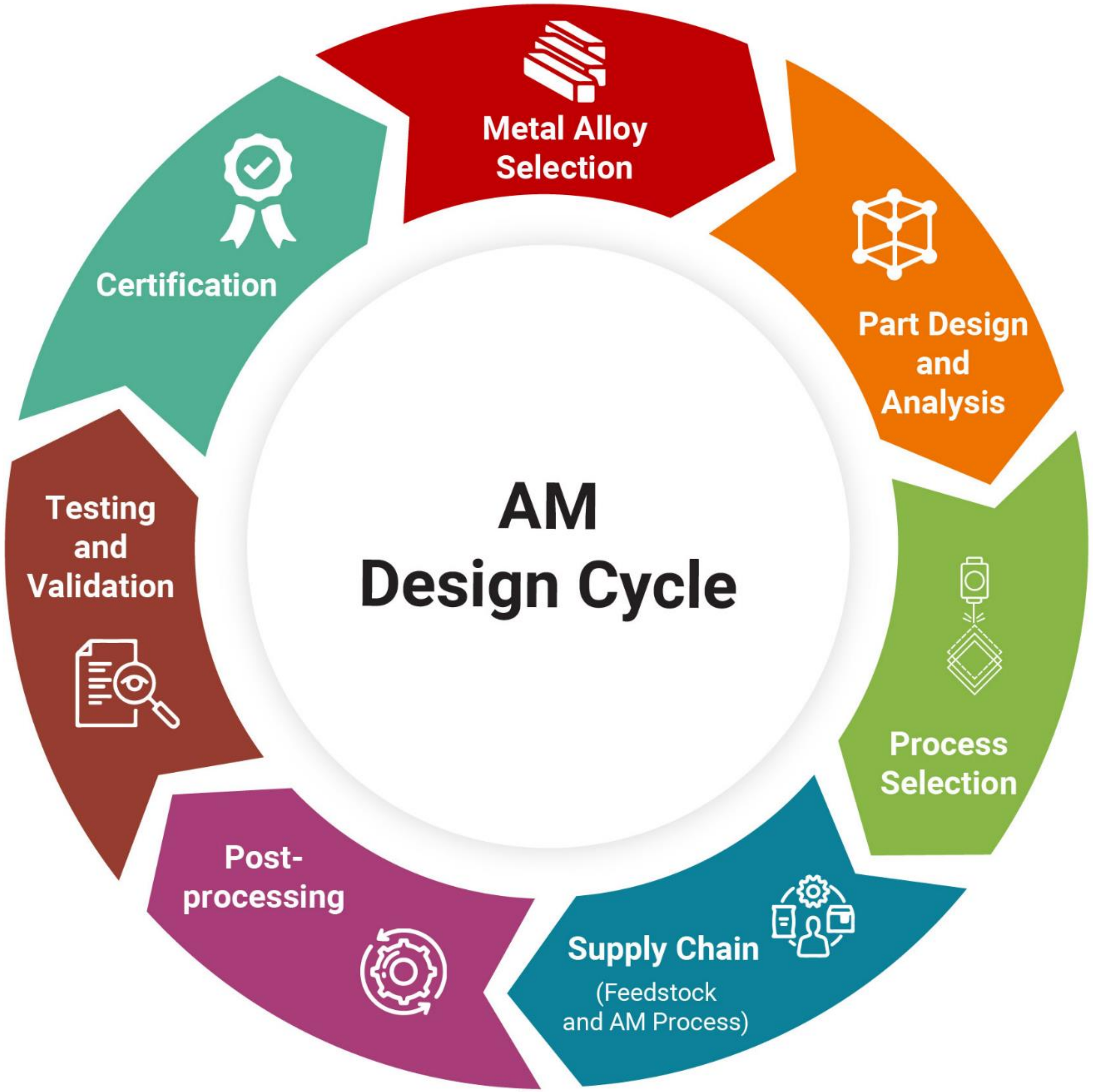
Part II

Design for Additive Manufacturing (DfAM)



Gradl, P., Tinker, D., Park, A., Mireles, O., Garcia, M., Wilkerson, R., Mckinney, C., 2021. Robust Metal Additive Manufacturing Process Selection and Development for Aerospace Components. Journal of Materials Engineering and Performance, Springer. https://doi.org/10.1007/s11665-022-06850-0

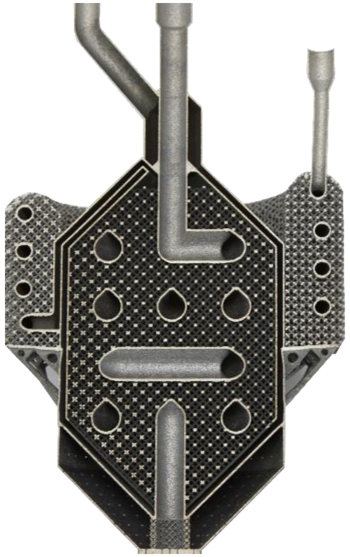
AM Design Cycle



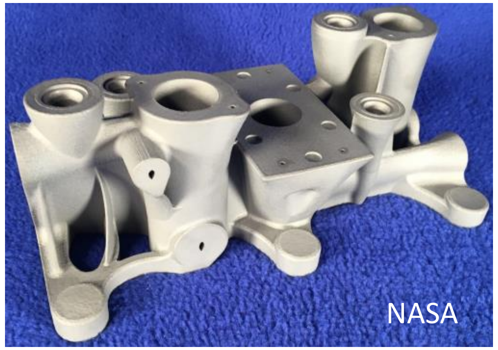
L-PBF DfAM

L-PBF Part Examples

NASA

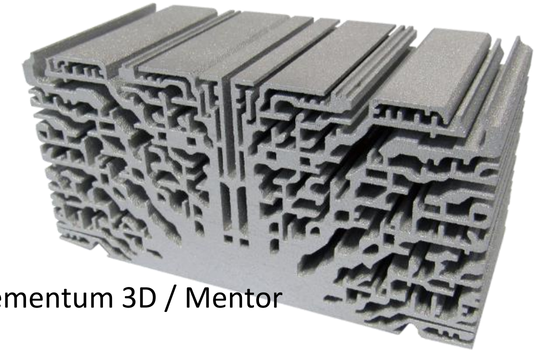


Castheon / ADDman



NASA

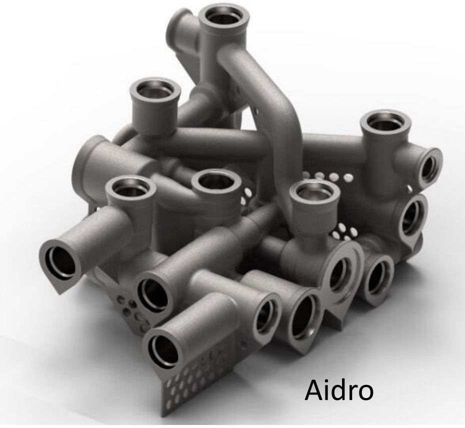
NASA / Aerojet Rocketdyne



Elementum 3D / Mentor

NASA

Cellcore / SLM

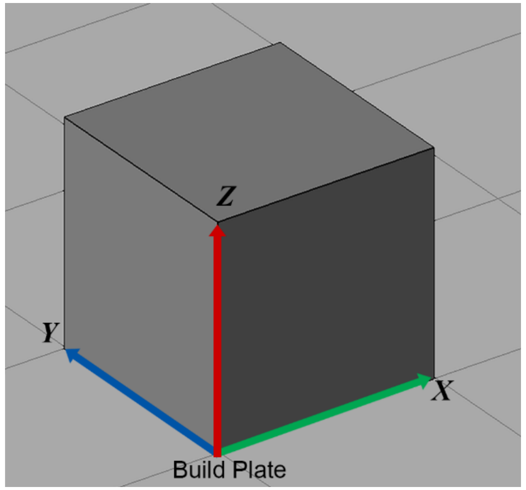


Aidro

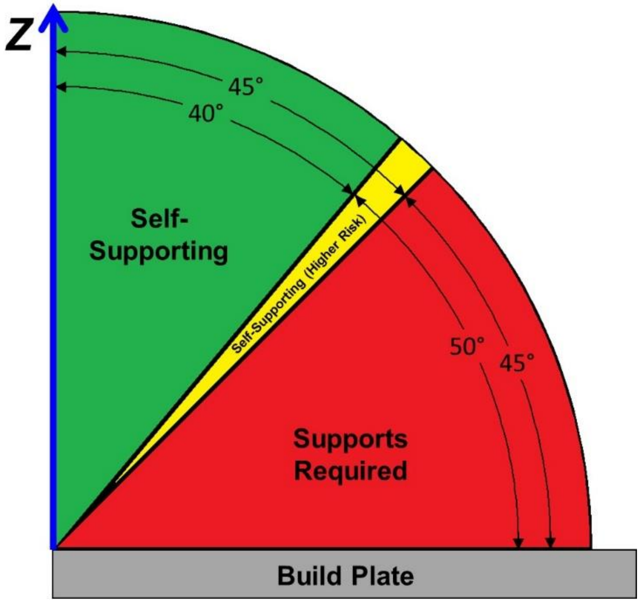
NASA

nTopology

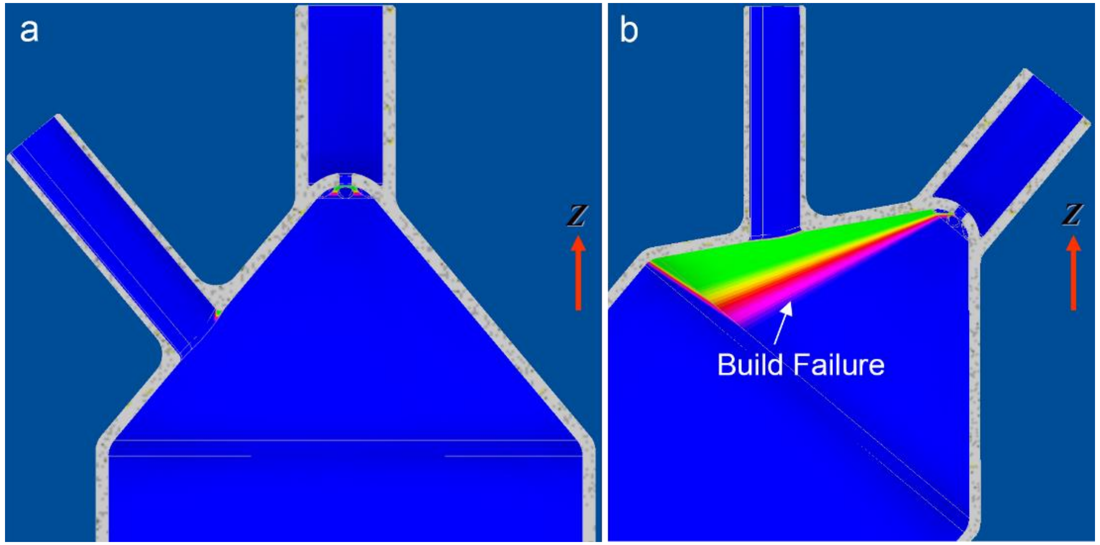
L-PBF DfAM – Coordinates & Overhang Surfaces



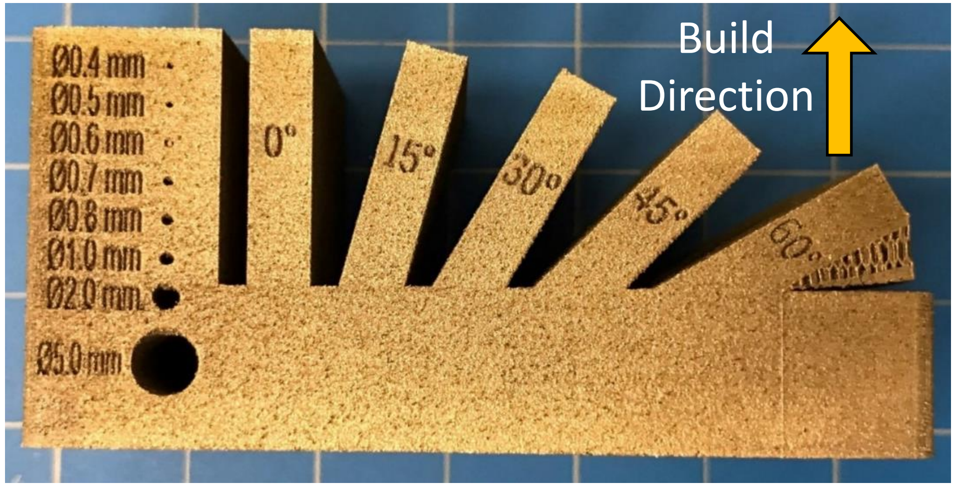
Reference coordinate system



Example of overhang surface region reference to build direction (*Z*)



Unsupported overhang surfaces vs. build direction. a) No unsupported surfaces. b) Unsupported surfaces.

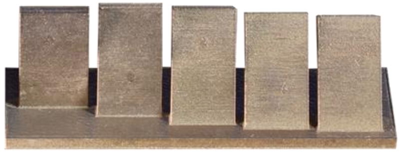


Angle is measured in relation to the build direction, *Z*

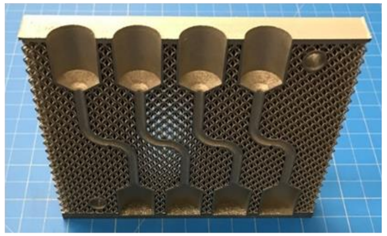
L-PBF Types of AM Features and Standard Build Plates

Test prints are good practice to understand if features feasible


Distance Geometry


Varying Wall Angles

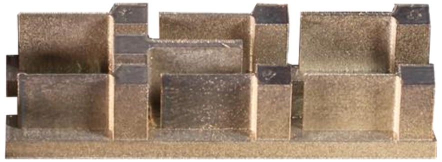

Square Vertical Channels

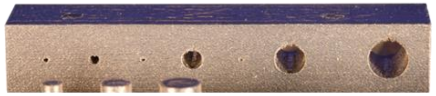

Lattices and Freeform Channels

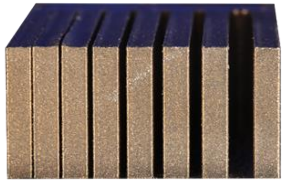

Concentric Hollow Cylinders, Repeating Diameters


Vertical Repeated Holes


Vertical Concentric Holes


Vertical Walls, Varying Thicknesses


Horizontal Holes

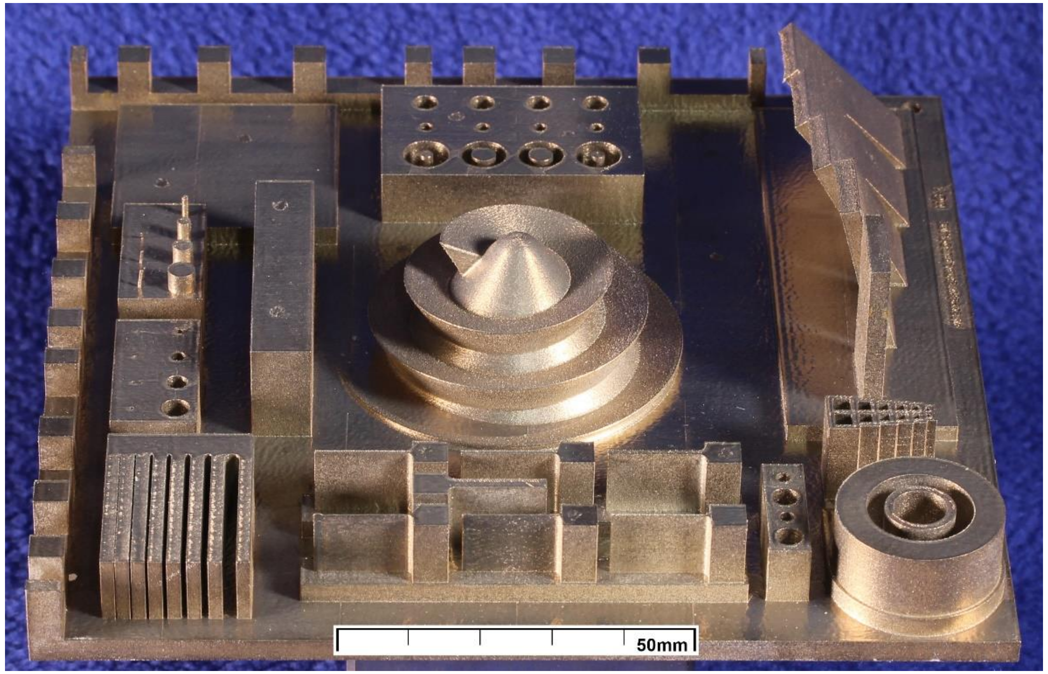

Slot Widths


Vertical Holes

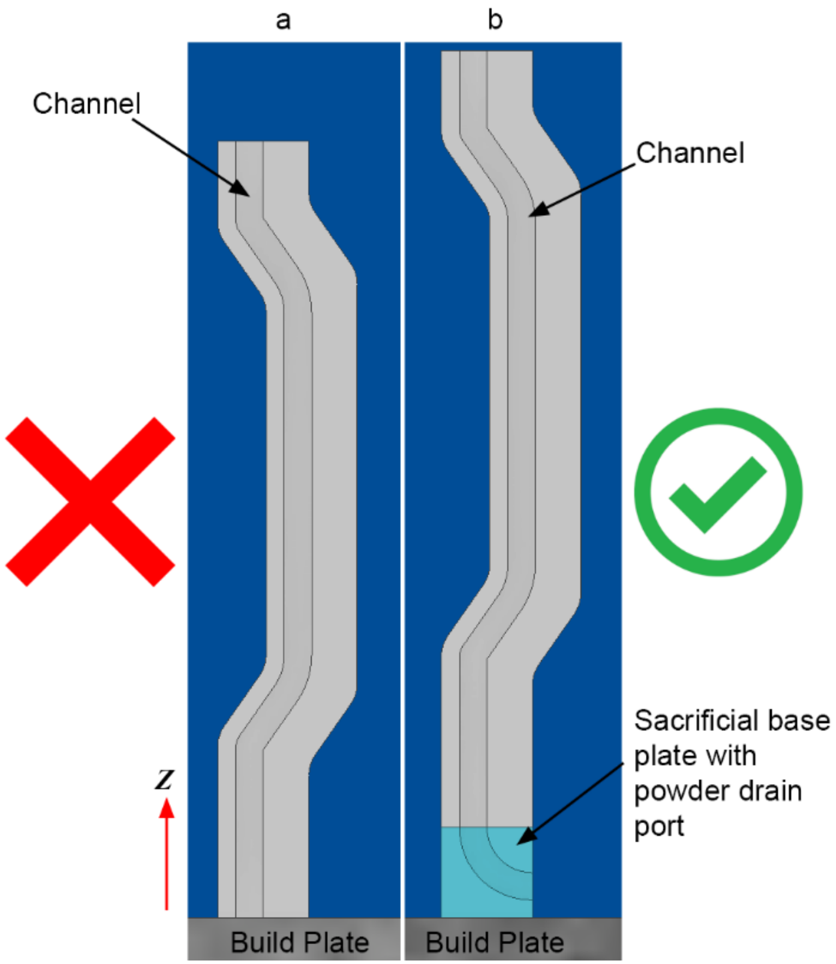

Vertical Protruding Cylinders


Freeform Surfaces

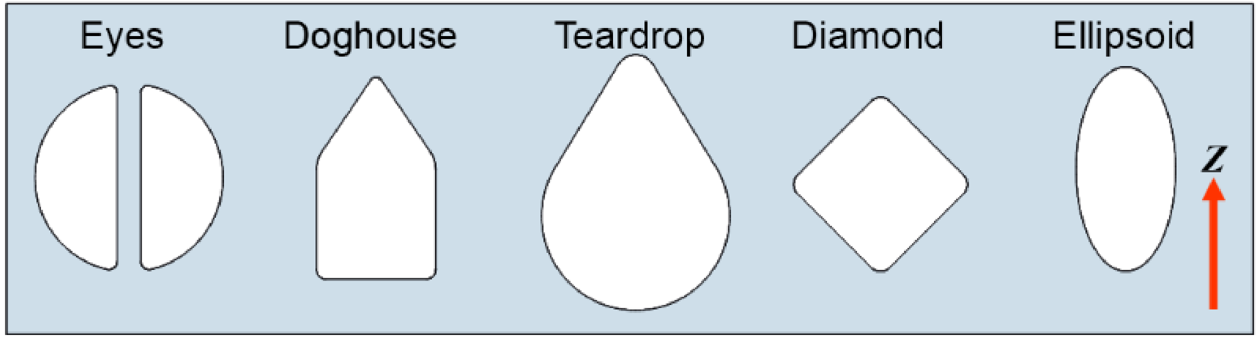

Vertical Repeated Holes



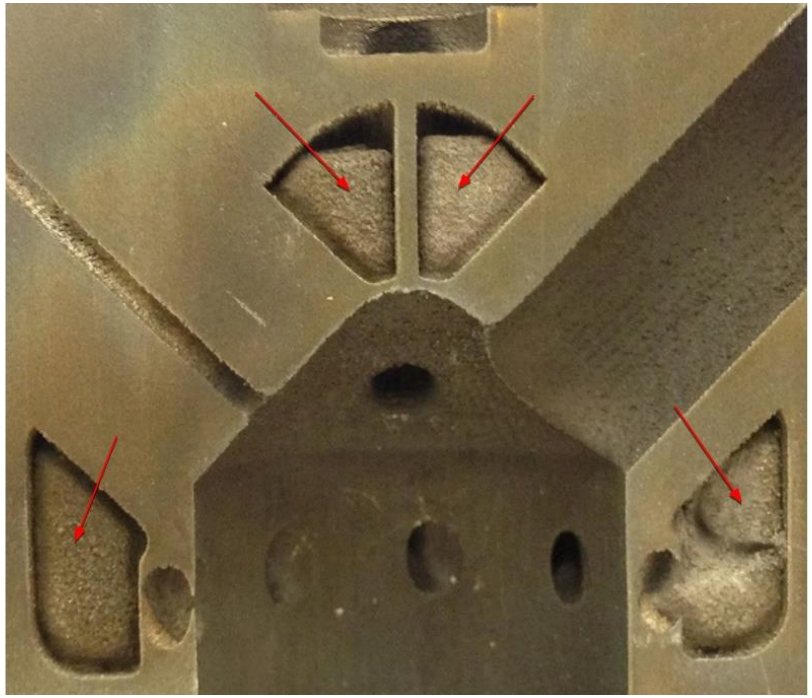
L-PBF DfAM – Holes & Drain Ports



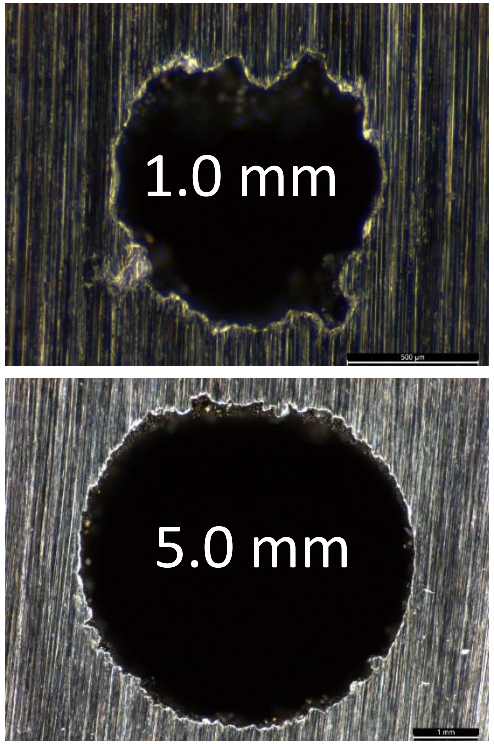
a) Channel terminating at the build plate. b) base plate with powder drain port.



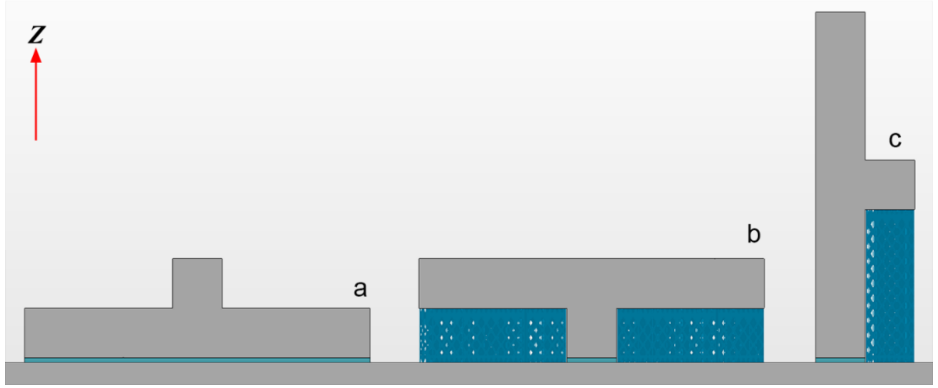
Self-supporting hole geometries.



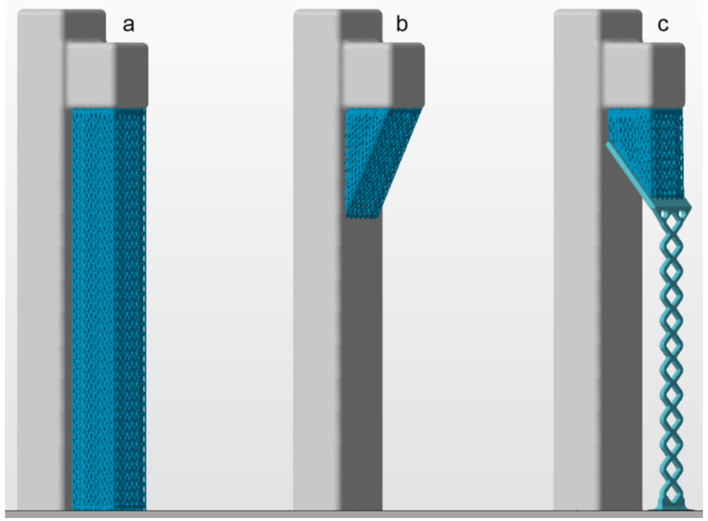
Cross-sectional cut of a part with trapped powder that sintered during stress-relief heat treatment.



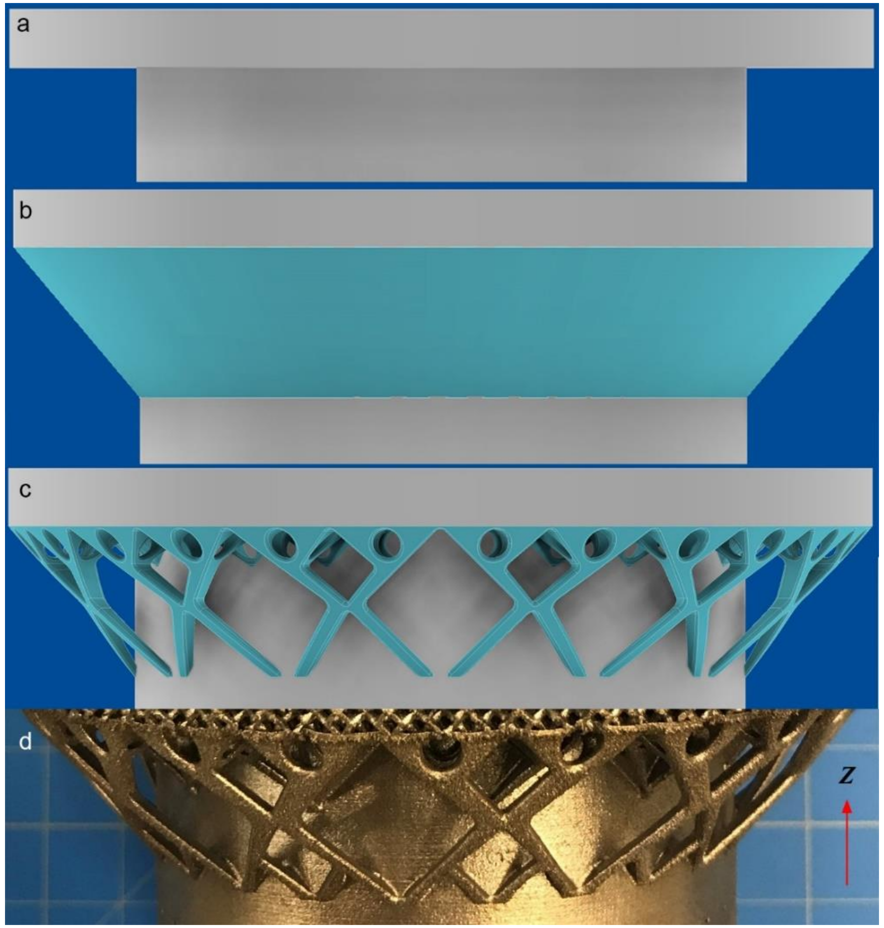
L-PBF DfAM – Supports



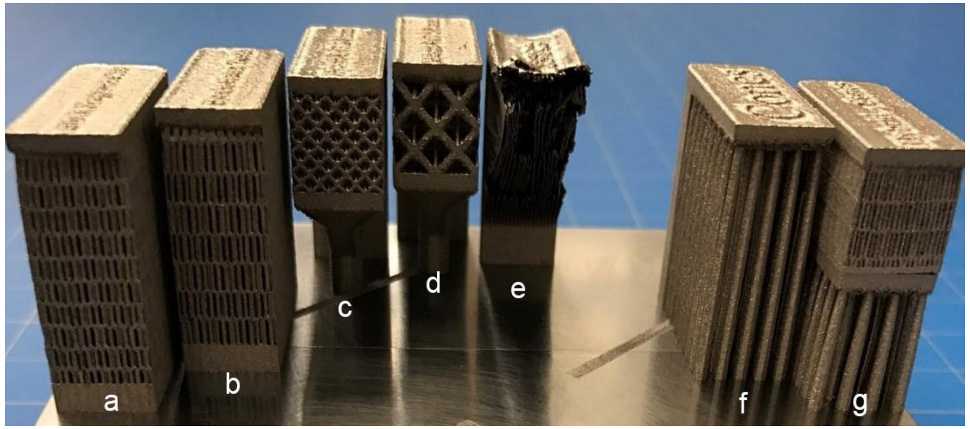
Placement and volume of support structures (blue volumes) are highly dependent on part orientation.



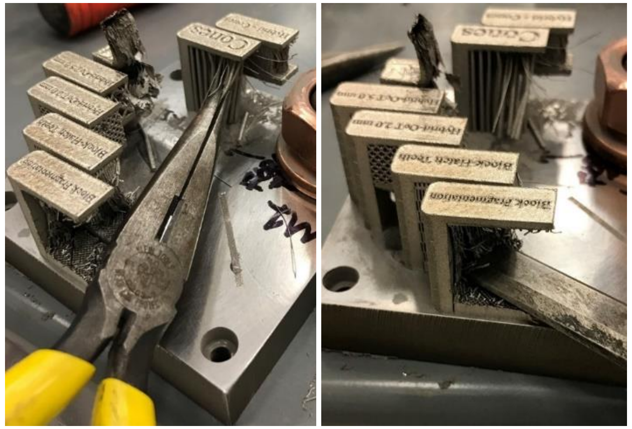
Perforated block supports a) full length, b) 30° angle, and c) projected onto a user designed scaffold.



Comparison of a) unsupported overhang flange, b) 40° sacrificial support, c) crown support, and d) IN718 crown support generated by L-PBF AM.

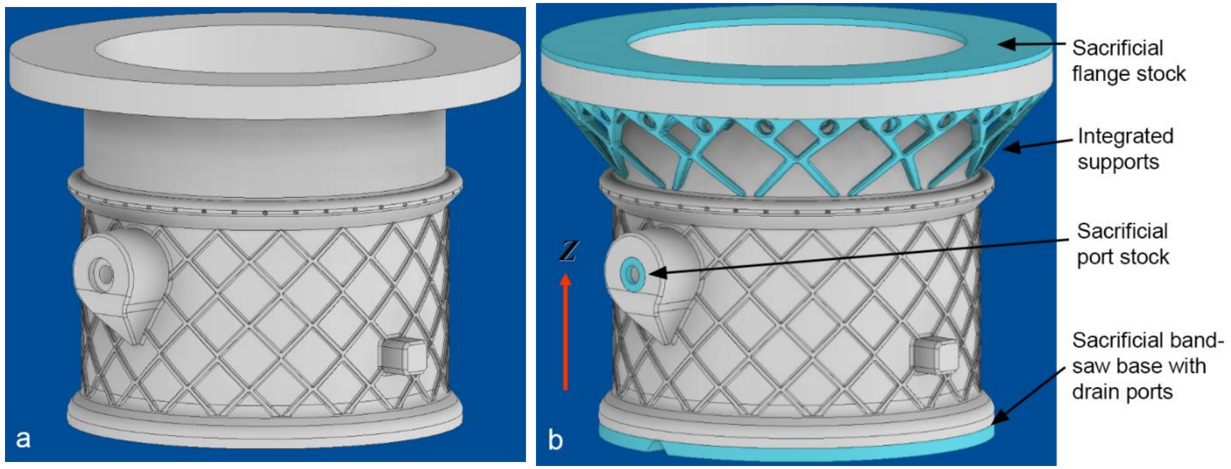


L-PBF AM support structure examples.

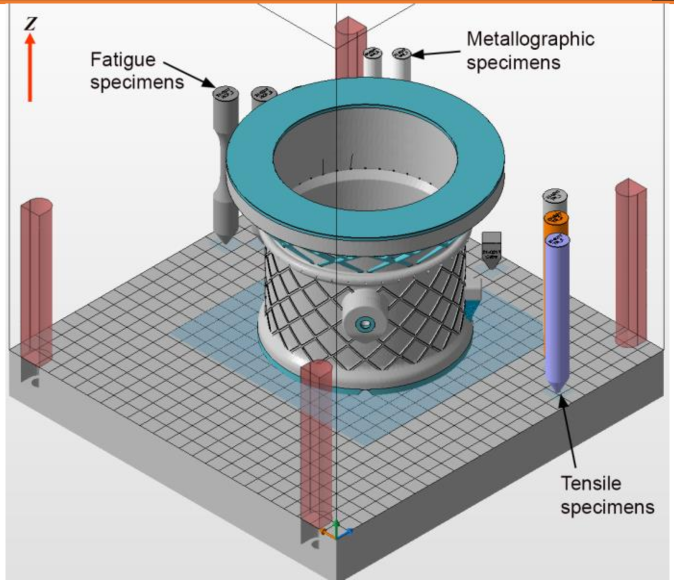


Manual support removal using hand tools.

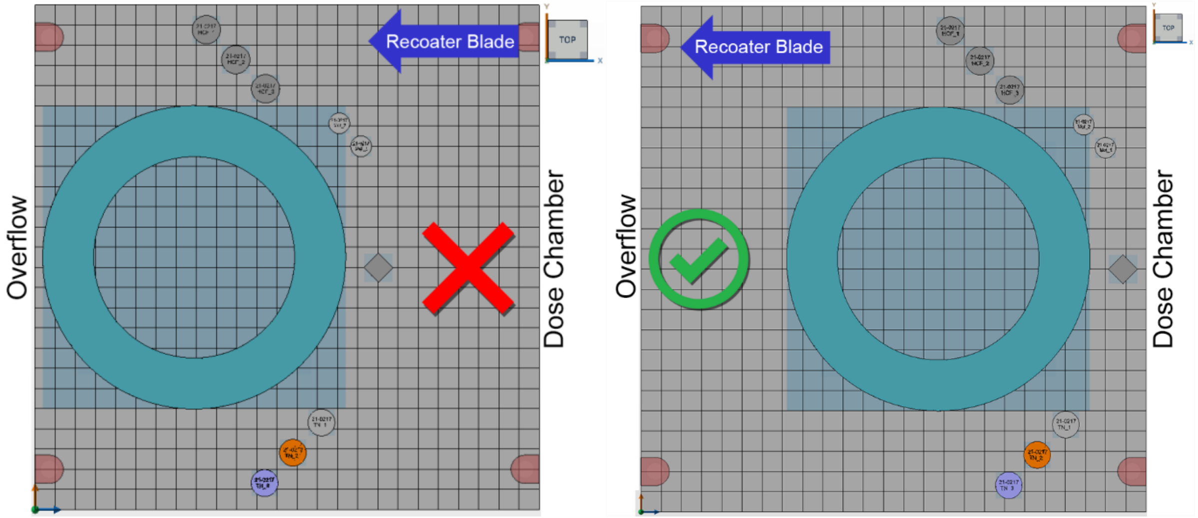
L-PBF DfAM – Case Study



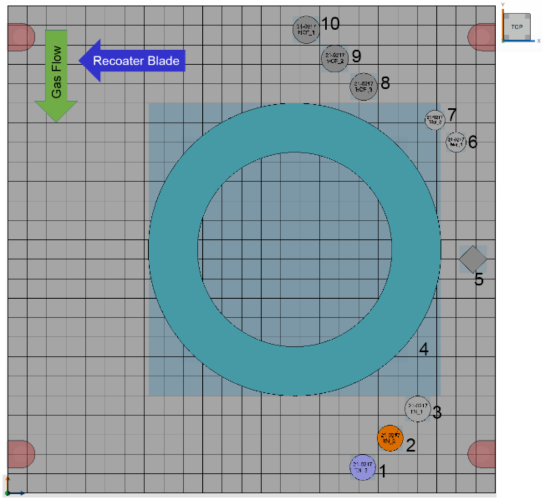
Part a) in final machined condition and b) with integrated supported, stock added to interfaces, and drain ports.



Build layout of part, support structure, and serialized specimens.



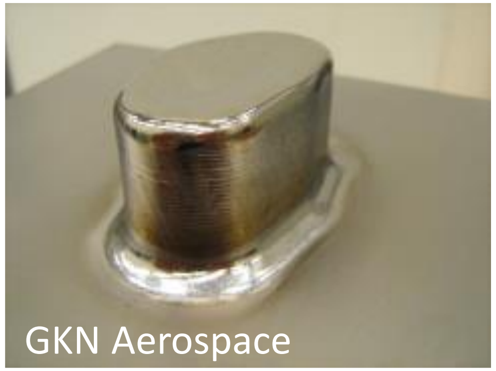
Component placement relative to dose chamber and recoater blade path.



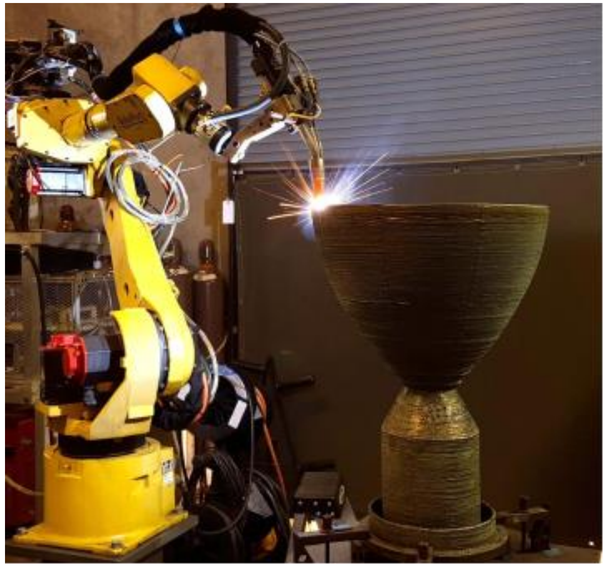
Build layout top view with part positions and scan order optimized.

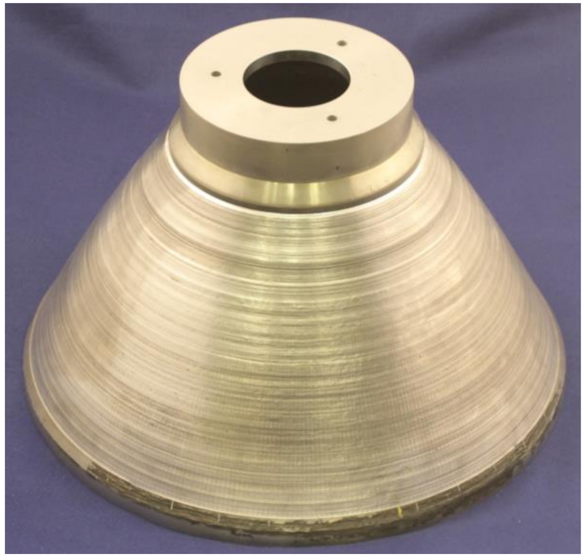
DED DfAM

DED DfAM – Examples of Geometries


GKN Aerospace


DM3D/NASA






RPMI

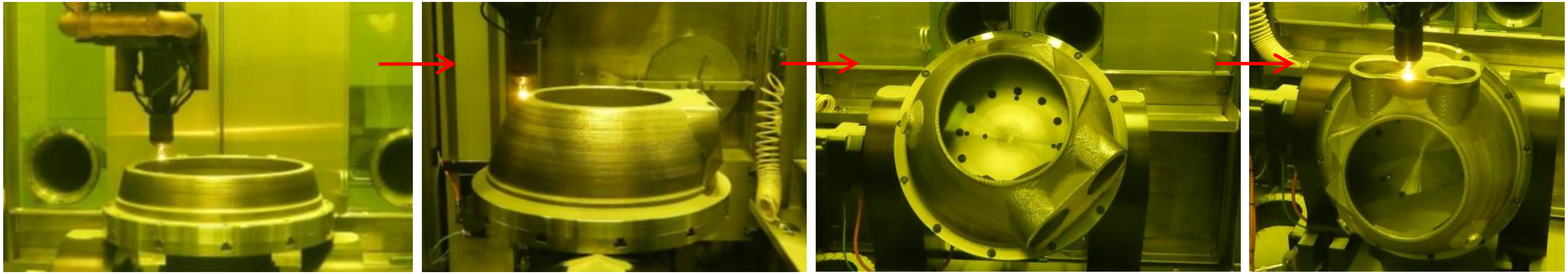

DM3D/NASA

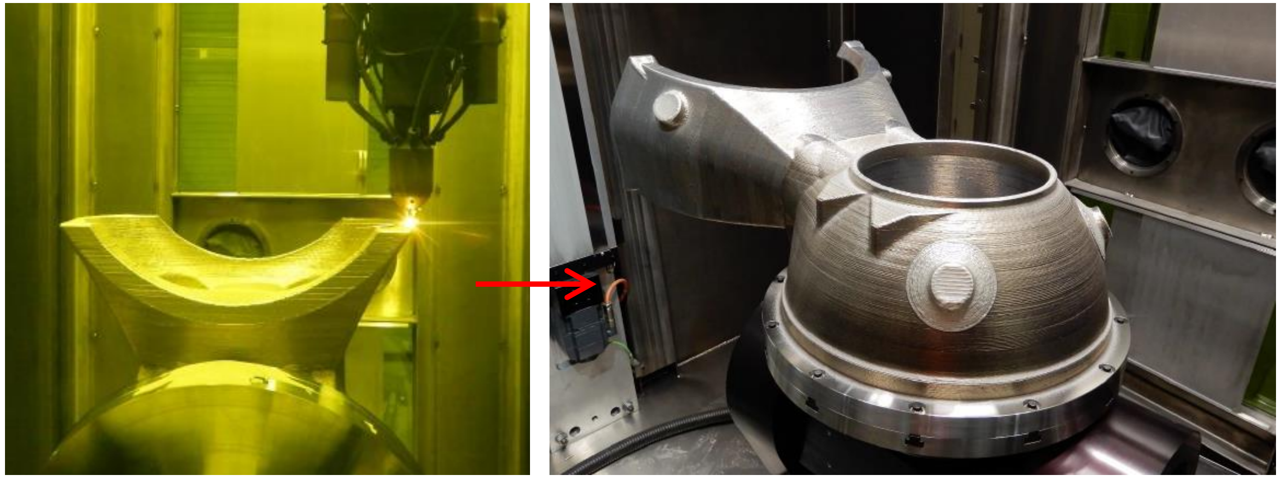

RPMI


RPMI/NASA

Freedom in DED design and deposition strategies

Ability to use multiple axes for complex features fabricated locally





RS25 Powerhead demonstrator using LP-DED under NASA SLS Artemis Program (NASA/RPMI)

Gradl, P.R., Mireles, O.R., Protz, C.S. and Garcia, C.P., 2022. Metal Additive Manufacturing for Propulsion Applications. https://arc.aiaa.org/doi/book/10.2514/4.106279

Design for DED Considerations

Substrate
- Size, Material, Temper
- Integral or Sacrificial?

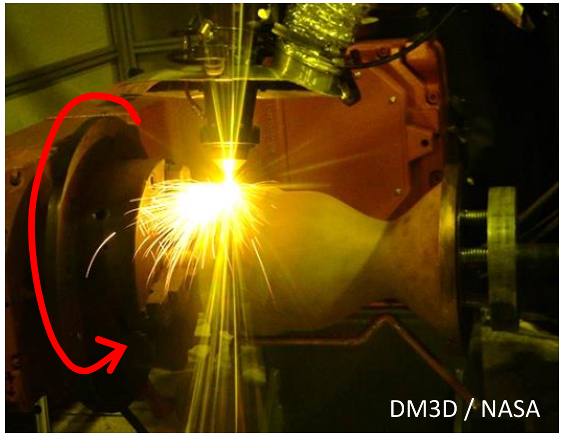
Material
- Chemistry and form
- Material feedstock effect on surface finish

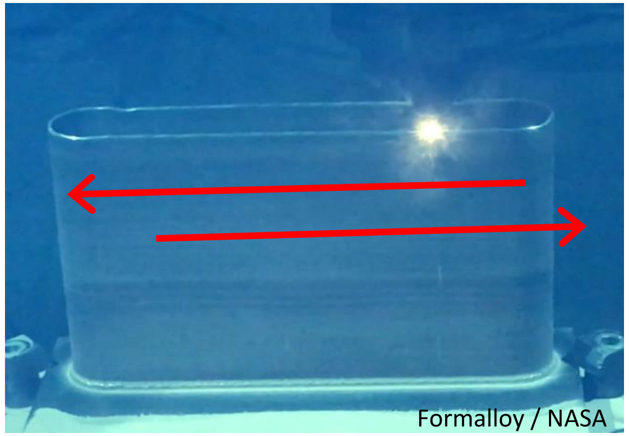
Deposition Strategy and Parameters
- Melt pool size and bead width/height
- Motion platform degrees of freedom and self-supporting angles
- Start / Stop / Transition locations and impact on properties

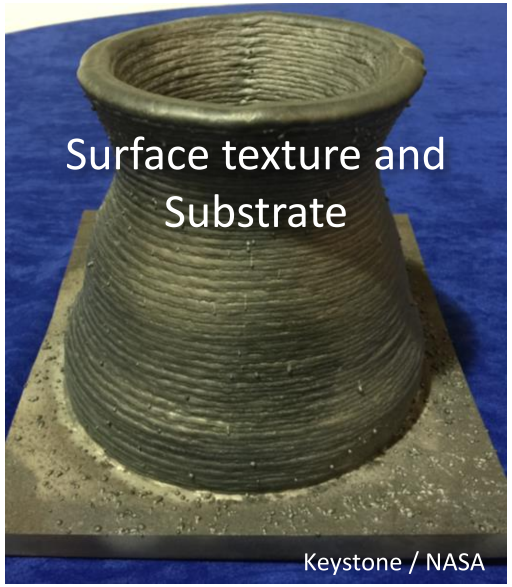
Machining
- Fixturing and datum locations

Inspection
- Surface interface with NDE and/or geometry compatibility

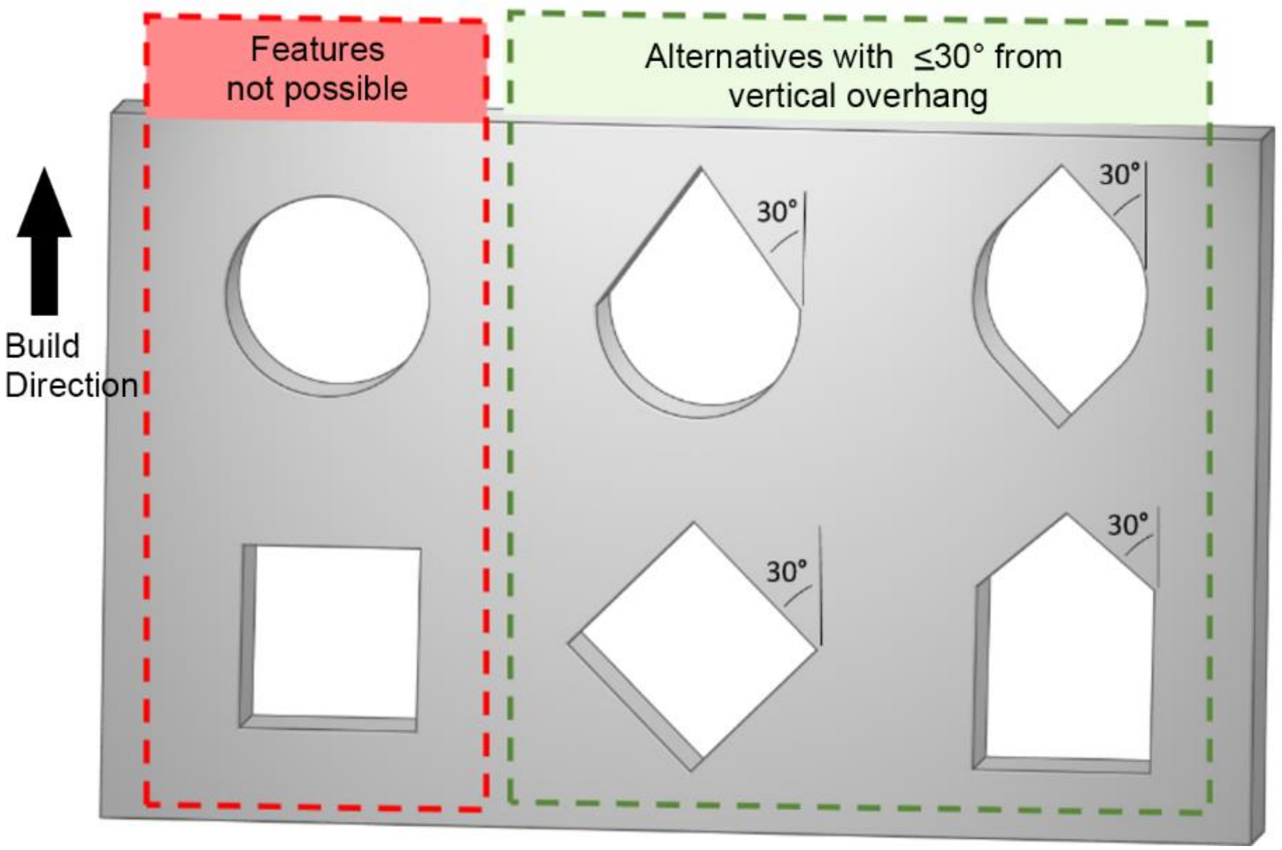
Example: Deposition Strategies

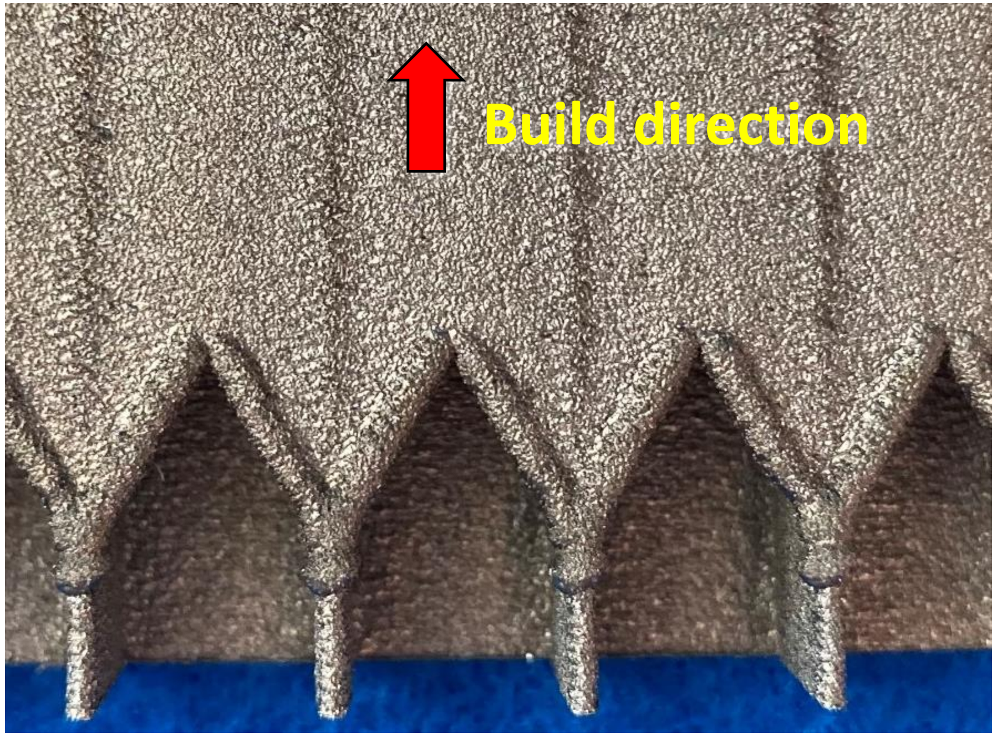




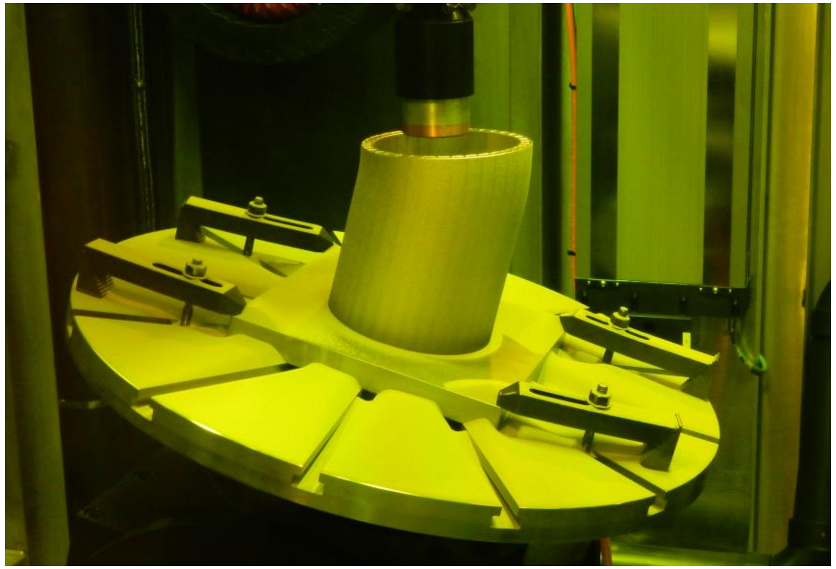


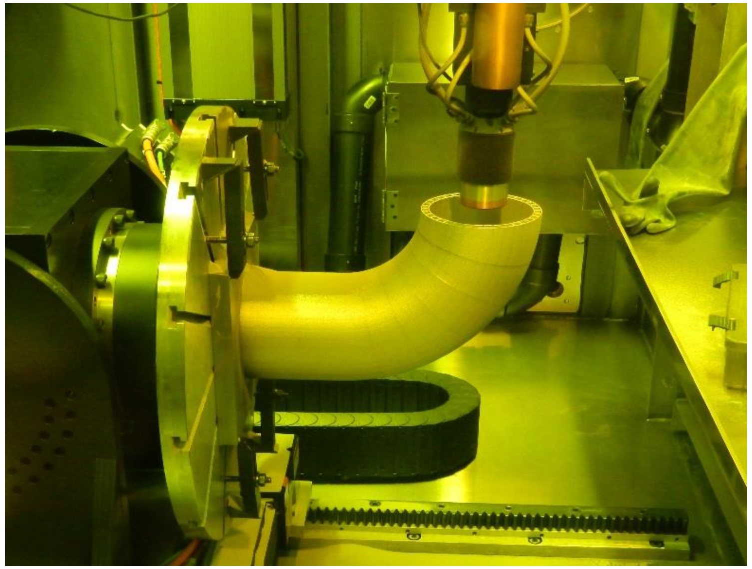
Similar types of holes as L-PBF must be considered when designing for DED

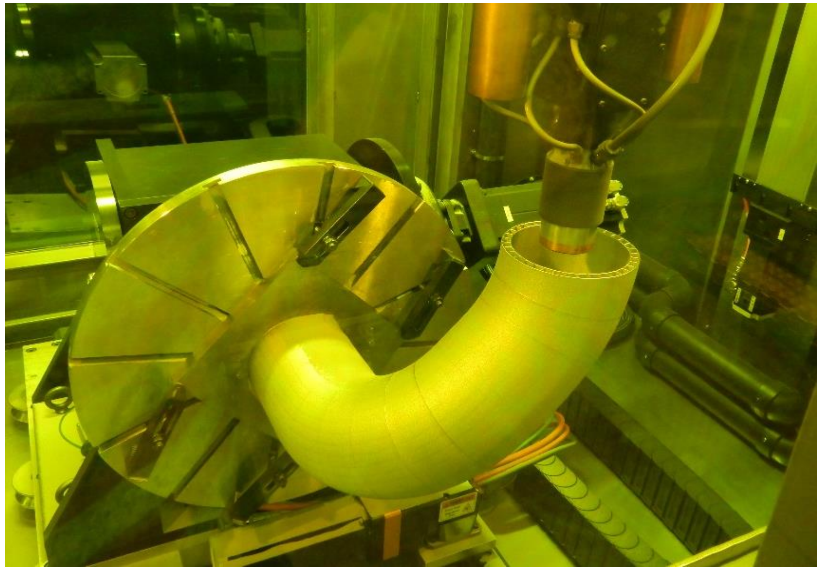




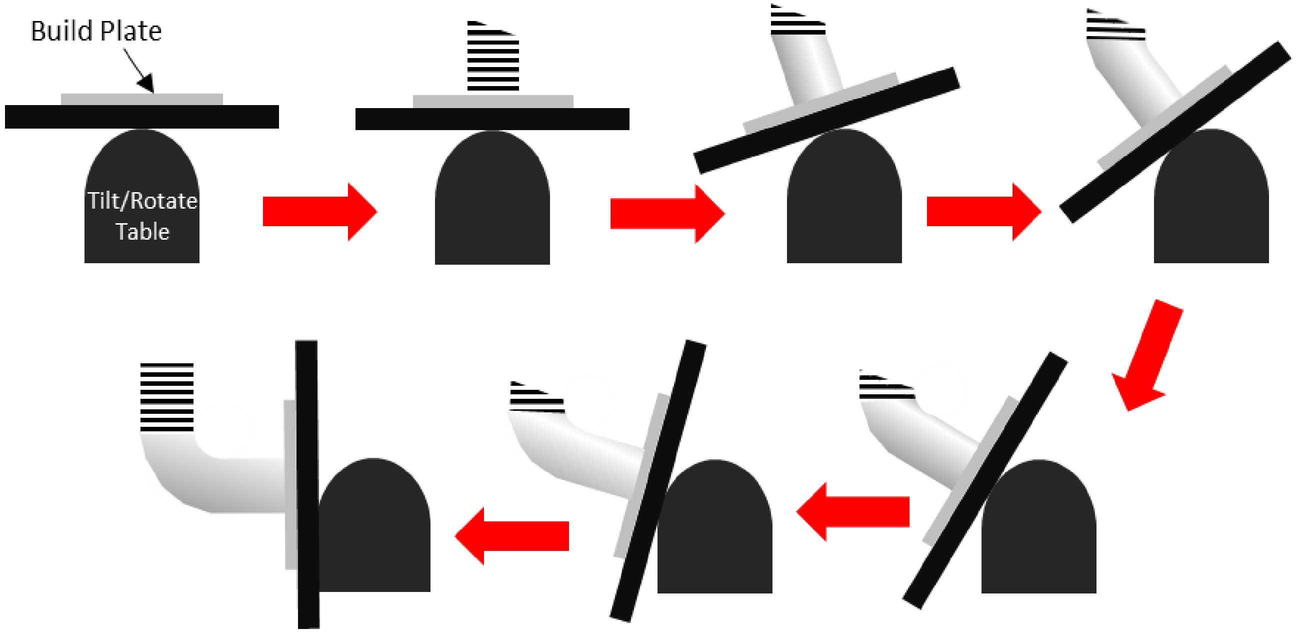
DED DfAM – More axes gives more design freedom





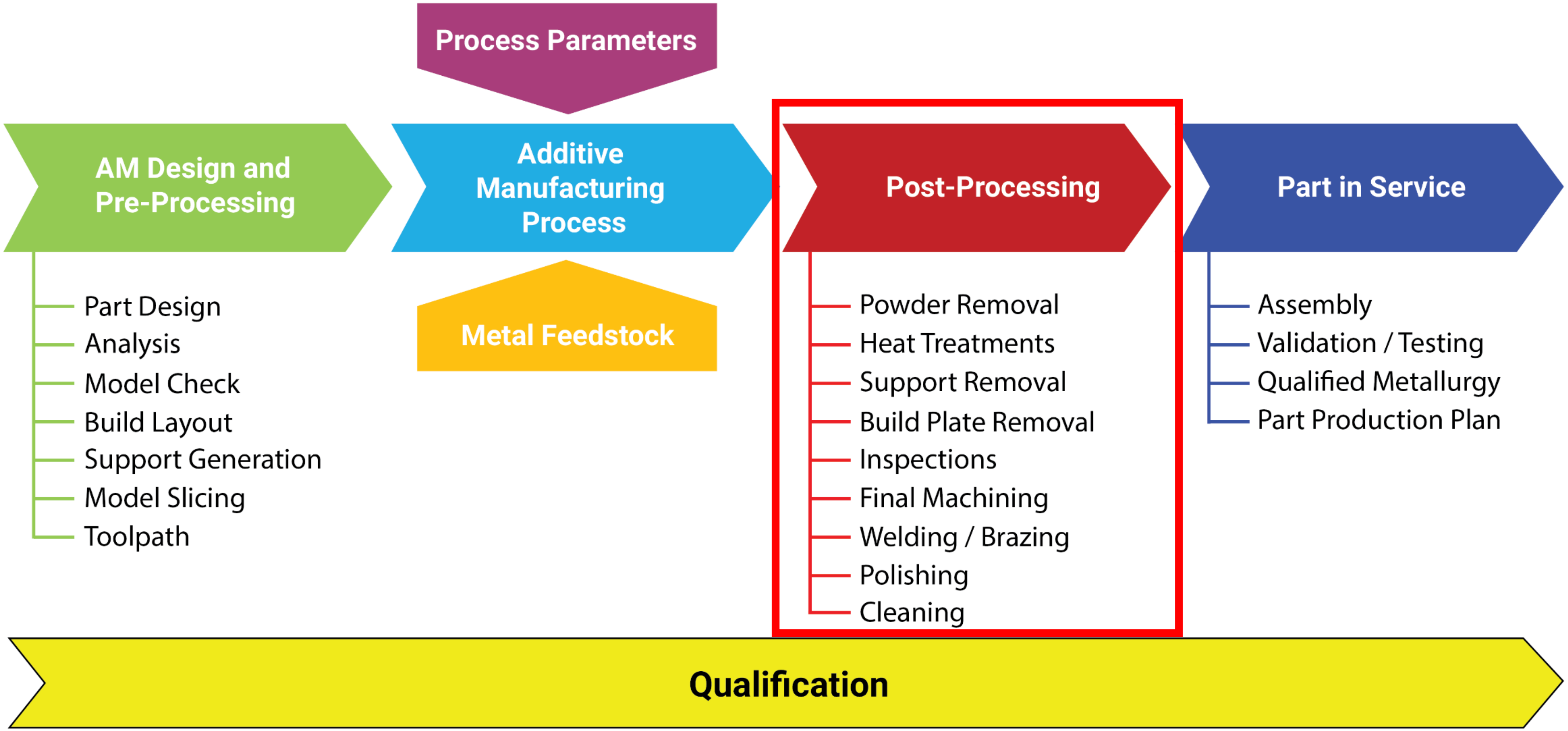


Courtesy: RPMI



Break for Questions

Design for Additive Manufacturing (DfAM)



Gradl, P., Tinker, D., Park, A., Mireles, O., Garcia, M., Wilkerson, R., Mckinney, C., 2021. Robust Metal Additive Manufacturing Process Selection and Development for Aerospace Components. Journal of Materials Engineering and Performance, Springer. https://doi.org/10.1007/s11665-022-06850-0

Post-Processing – General Process Flow

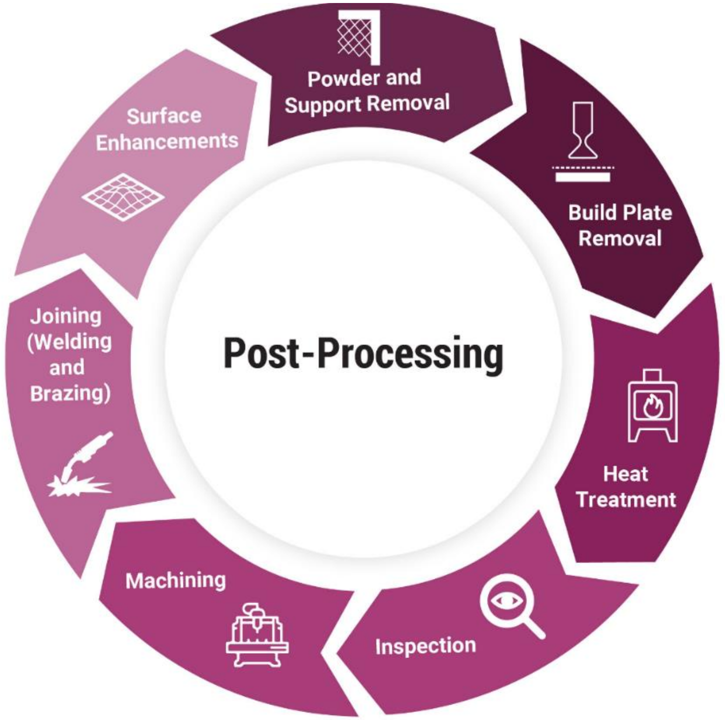
Powder Removal or Part Cleanup → **Support, Build Plate, or Stock Removal** → **Heat Treatments (Thermal Processing)** → **Final Processing and Inspections**

Powder Removal or Part Cleanup
- Powder Removal
- Verification
- Cleaning of Residual Powder

Support, Build Plate, or Stock Removal
- Removal of Supports
- Build Plate Removal
- Excess Stock Removal

Heat Treatments (Thermal Processing)
- Stress Relief
- Hot Isostatic Pressing (HIP)
- Homogenization
- Solutionizing
- Aging

Final Processing and Inspections
- Inspections
- Final Machining
- Polishing
- Welding
- Brazing



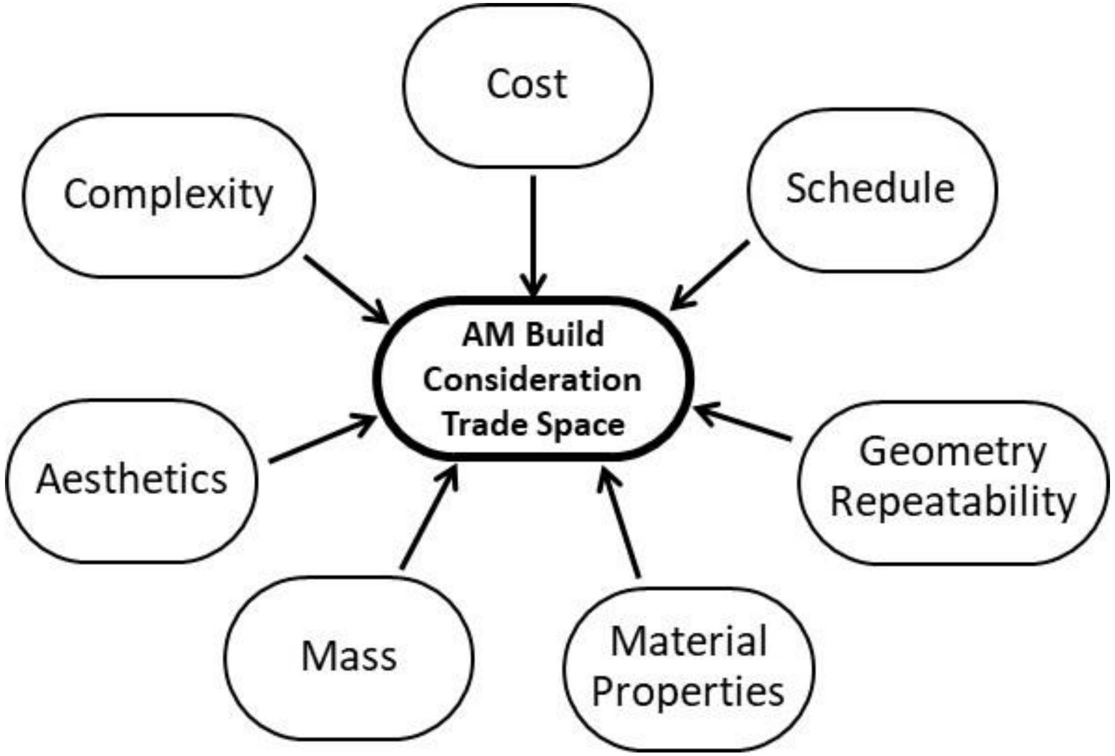
Paul R. Gradl, Omar R. Mireles, Christopher S. Protz, Chance P. Garcia, Metal Additive Manufacturing for Propulsion Applications, 1st ed., American Institute of Aeronautics and Astronautics, Inc., Reston, VA, 2022. https://doi.org/10.2514/4.106279

Some Key Questions for Design and Post-Processing

- Are there internal cavities?
- Does the part have drain ports or openings to allow for powder removal?
- What technique(s) will be used for powder removal?
- How is powder removal verified?
- Will a support structure be used in the build or designed into the part?
- Are there downstream operations that require fixtures or tooling to integrate in the design?
- What type of distortion might be expected from the process and how can one properly design for it?
- How is the part removed from the build plate?
- What forces are being imparted during post-processing operations?
- Are adequate stock and proper datums included for part removal and post-machining?
- What kind of post-process machining, welding, brazing, or assembly needs to occur after the print?
- Does the part incorporate the correct welding or brazing joint design?
- What heat treatments are required, and what risk do they pose to the part?
- What is the proper sequence of heat treatments?
- What material properties are required for the end-use application?
- What inspections (full or partial, volumetric, surface, geometric) are required to verify integrity?
- Is the design conducive to these inspections?
- What surface texture is needed for the final application? [i.e. 2D directional roughness (Ra), average maximum profile height (Rz), average maximum valley depth (Rv), average areal roughness (Sa), surface maximum height (Sz), surface skewness (Ssk), directional waviness (Wa).]
- Are surface finish requirements uniform across the part or limited to specific locations (e.g., interfaces)?

“Post-processing” is really “the process”

To successfully build parts to integrate into a system and meet the properties required, post-processing is required



Post-Processing	Process Step	Resultant Application
Heat Treatment	HIP, Solution, Annealing, Aging	Mechanical properties, thermophysical properties, high density, grain uniformity, etc.
Surface Finishing	Chemical Milling, Abrasive Flow Machining, Chemical Mechanical Polishing, Mechanical Honing	Aesthetics, pressure drop, mass flow alteration, fatigue life, corrosion resistance, etc.
Condition	Final Machining, Joining, Cleaning, Inspection	Geometric dimensioning and tolerancing (GD&T), exposure to environment, integration with subsystem, quality Improvement, etc.

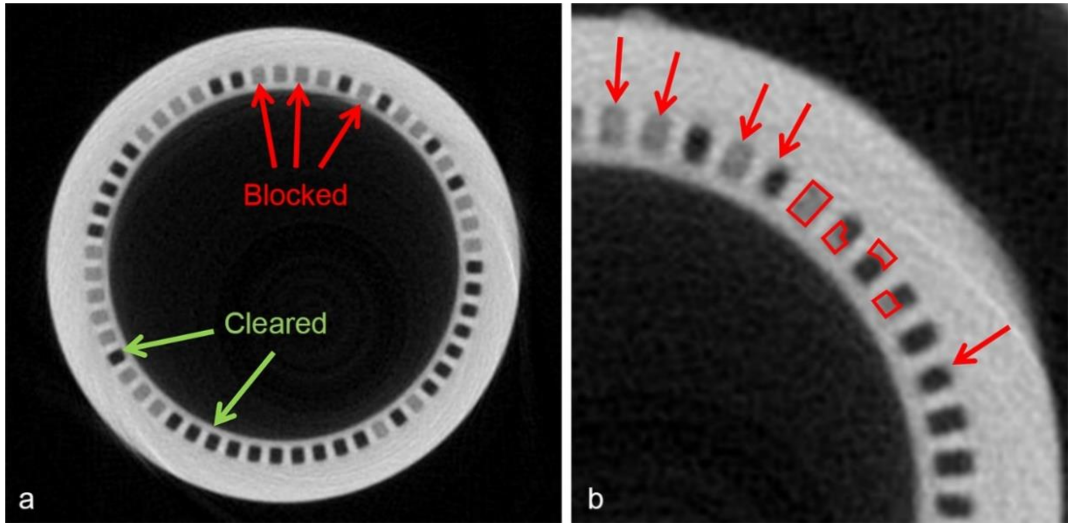
Post-Processing Summary

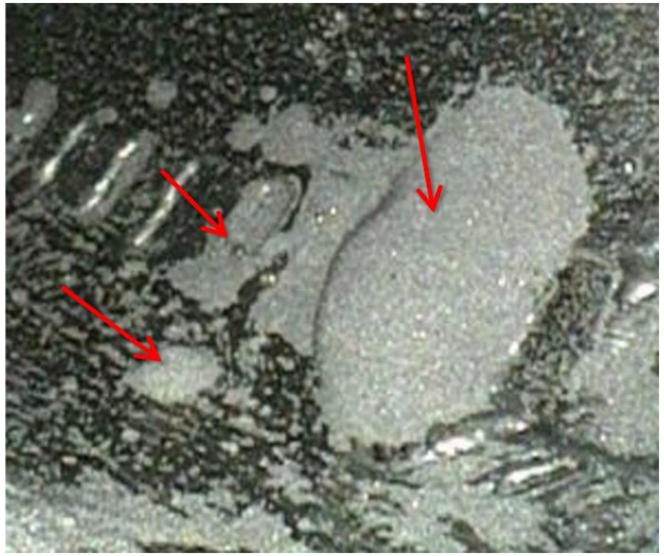
	Powder Removal and Verification	Support Removal*	Stress Relief**	Build Plate Removal	Heat Treatment Required?	Post-Curing	Final Machining ***
Laser Powder Bed Fusion (L-PBF)	Y	Y	Y	Y	Y	N	O
Electron Beam Powder Bed Fusion (EB-PBF)	Y	Y	N	Y	Y	N	O
Blown Powder Directed Energy Deposition (BP-DED)	Y	Y	Y	Y	Y	N	Y
Arc-Deposition DED	N	N	Y	Y	Y	N	Y
Laser Hot-wire DED	N	N	Y	Y	Y	N	Y
Electron Beam DED	N	N	Y	Y	Y	N	Y
Laser Wire DED	N	N	Y	Y	Y	N	Y
Ultrasonic	N	N	N	N	O	N	Y
Friction Stir	N	N	N	N	O	N	Y
Coldspray	N	N	N	Y	O	N	Y
Binder Jet	Y	O	N	N	Y	Y	O

Y = Requires operation
N = Does not require
O = May Require

Is powder removed? ...Are you sure?

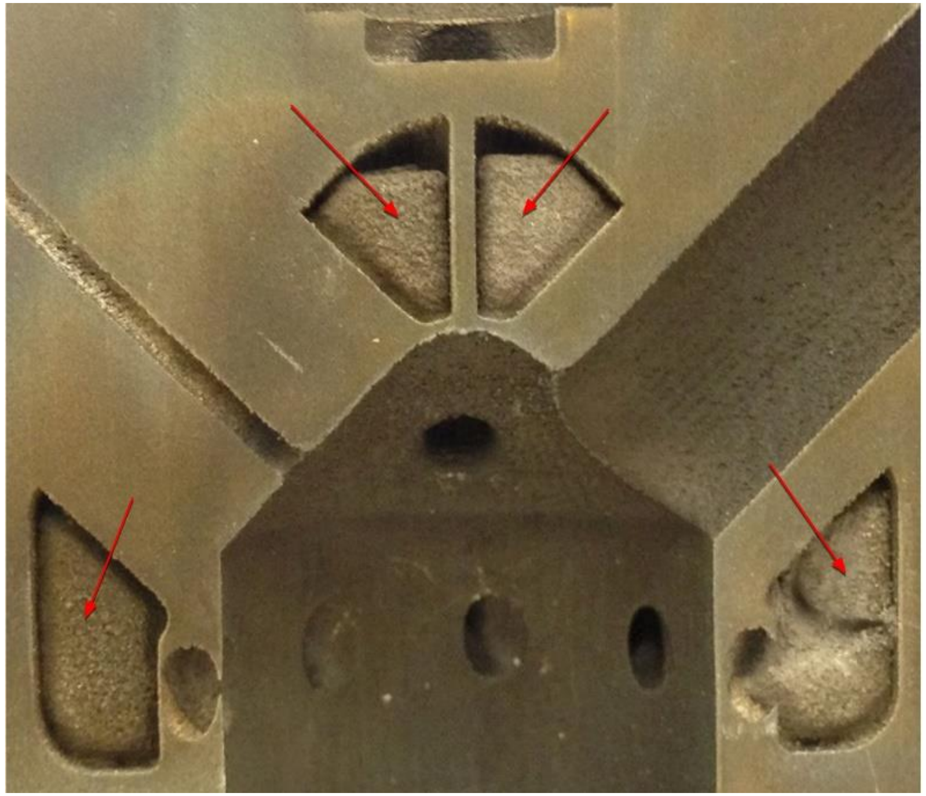
Powder observed in channels after CT





Borescope inspection of internal features

Internal cavities with sintered powder after stress relief – not properly designed for removal



Paul R. Gradl, Omar R. Mireles, Christopher S. Protz, Chance P. Garcia, Metal Additive Manufacturing for Propulsion Applications, 1st ed., American Institute of Aeronautics and Astronautics, Inc., Reston, VA, 2022. https://doi.org/10.2514/4.106279

Table 5.2: NDE Applications and Limitations

+, strong capability; 0, limited capability; -, no capability

Method	Metrology	Surface defects	Volumetric defects	Main strength	Main weakness
Visual inspection	0	0	–	Quick check for major problems	No quantitative measurements
Coordinate measurement machine (CMM)	+	–	–	Allows for dimensional inspections	No internal characterization; does not allow for detailed surface characterization
Laser profilometry	+	0	–	Characterize roughness	No internal characterization
Structured light scanning	+	0	–	Check dimensions, generate three-dimensional model	No internal characterization

(continued)

Paul R. Gradl, Omar R. Mireles, Christopher S. Protz, Chance P. Garcia, Metal Additive Manufacturing for Propulsion Applications, 1st ed., American Institute of Aeronautics and Astronautics, Inc., Reston, VA, 2022. https://doi.org/10.2514/4.106279

Courtesy: Erin Lanigan / NASA MSFC

Nondestructive Evaluation (NDE): Flaws

Table 5.2: NDE Applications and Limitations

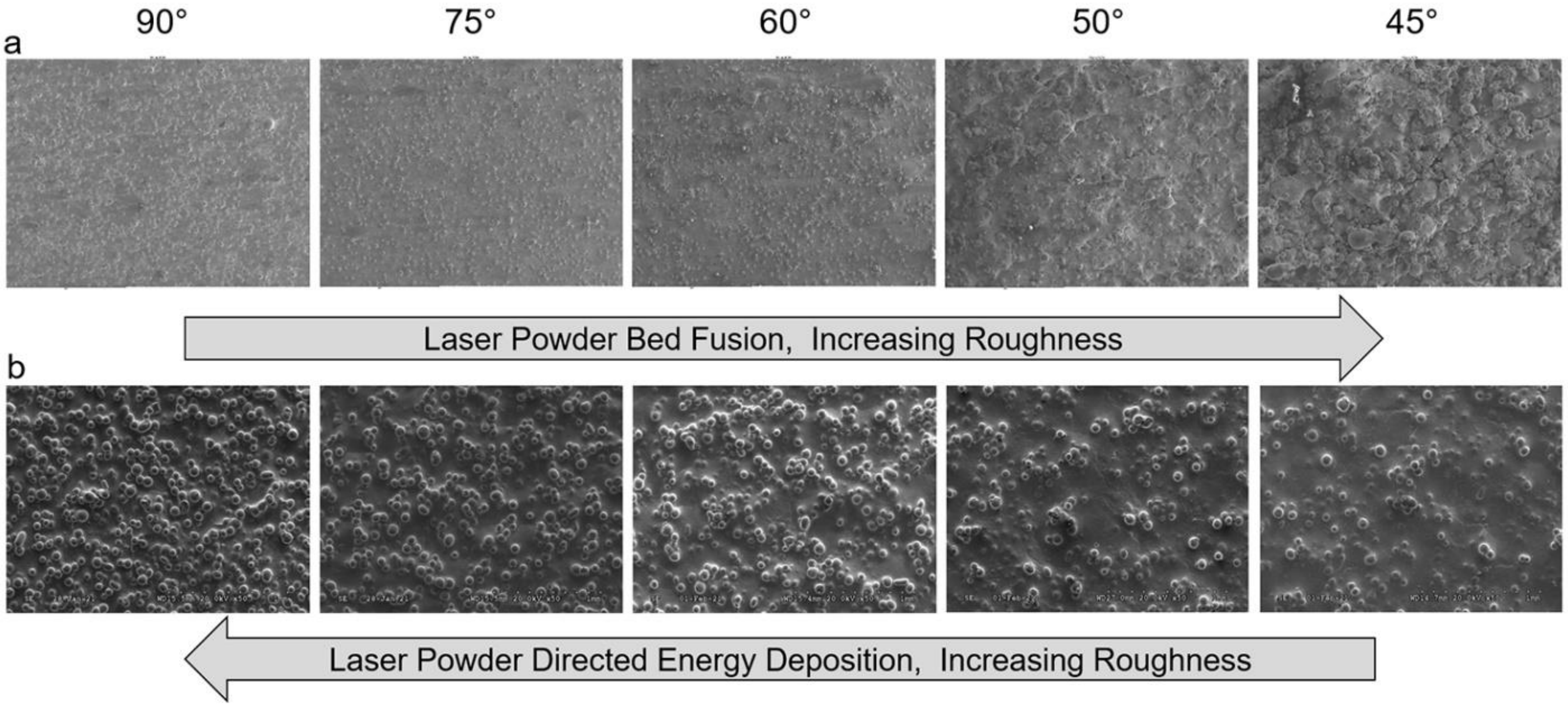
+, strong capability; 0, limited capability; -, no capability

(continued)

Method	Metrology	Surface defects	Volumetric defects	Main strength	Main weakness
Radiography	0	0	+	Volumetric defects, changes in density	Interpreting complexity, detecting tight cracks
CT	+	0	+	Three-dimensional reconstruction of volumetric defects	Characterizing surface, detecting tight cracks
Ultrasonic inspection	–	0	+	Volumetric defects, linear defects	Surface access, quality changes, defect detection varies with depth
Dye penetrant	–	+	–	Surface-breaking defects, cracks	Requires smooth as-built surface or machining
Eddy current	–	+	0	Surface and near-surface (subsurface) defects	Limited to electrically conductive materials
Magnetic particle inspection	–	0	–	Surface defects	Limited to ferromagnetic materials, smooth surface
Thermography	–	0	0	Surface and subsurface defects	Interpreting complexity, limited depth
Resonance	–	0	0	Overall defect state, part comparisons	Locating defects, understanding extent

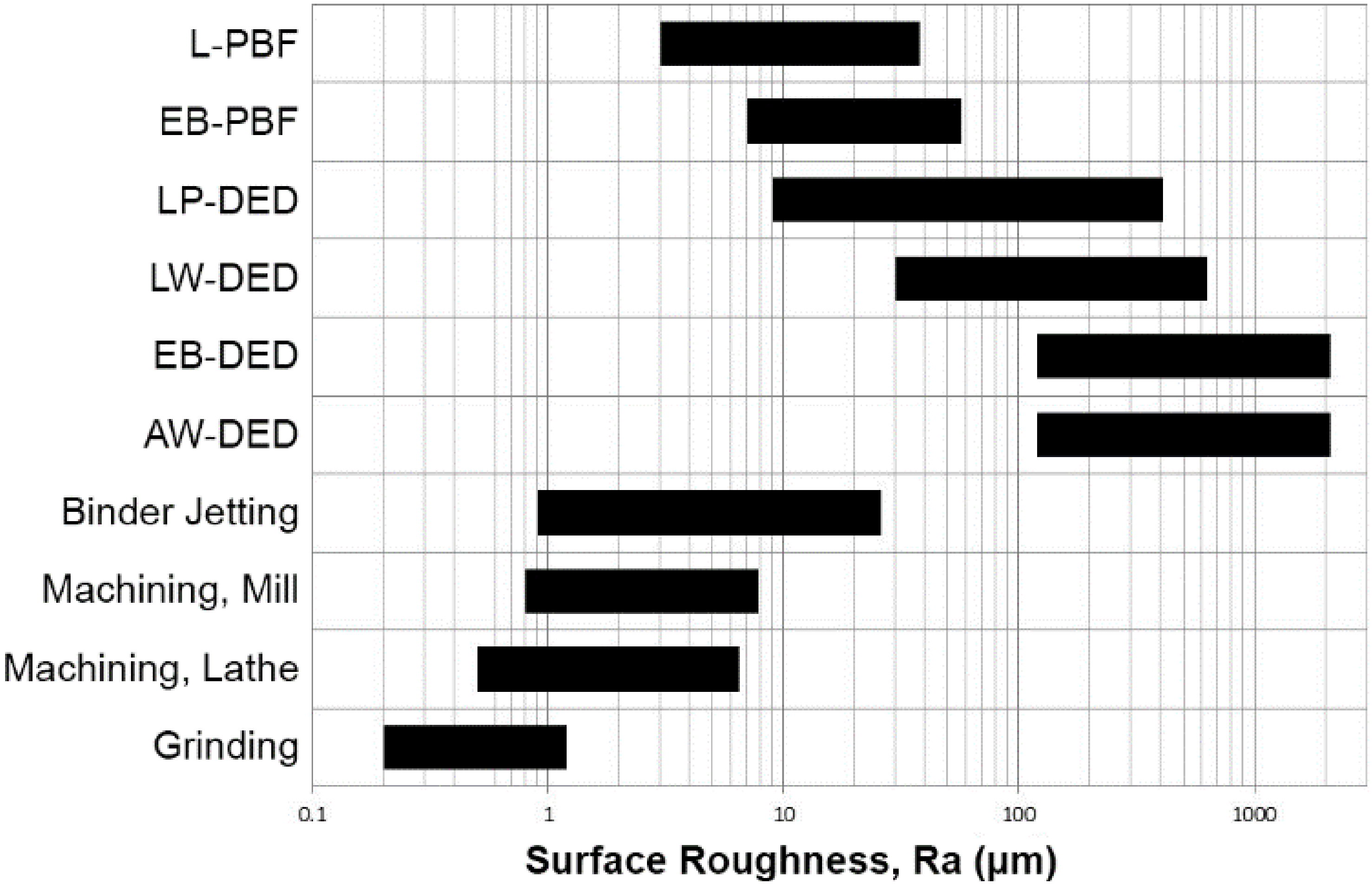
Courtesy: Erin Lanigan / NASA MSFC

Surface texture (waviness, roughness, form) varies based on build process and build orientation



Gradl, P., Cervone, A., Colonna, P., 2023. Influence of build angles on thin-wall geometry and surface texture in laser powder directed energy deposition. Materials & Design 234, 112352. https://doi.org/10.1016/j.matdes.2023.112352

Surface Conditions from different processes



Caveat: Surface condition highly variable based on process, material, parameters, build orientation

Paul R. Gradl, Omar R. Mireles, Christopher S. Protz, Chance P. Garcia, Metal Additive Manufacturing for Propulsion Applications, 1st ed., American Institute of Aeronautics and Astronautics, Inc., Reston, VA, 2022. https://doi.org/10.2514/4.106279

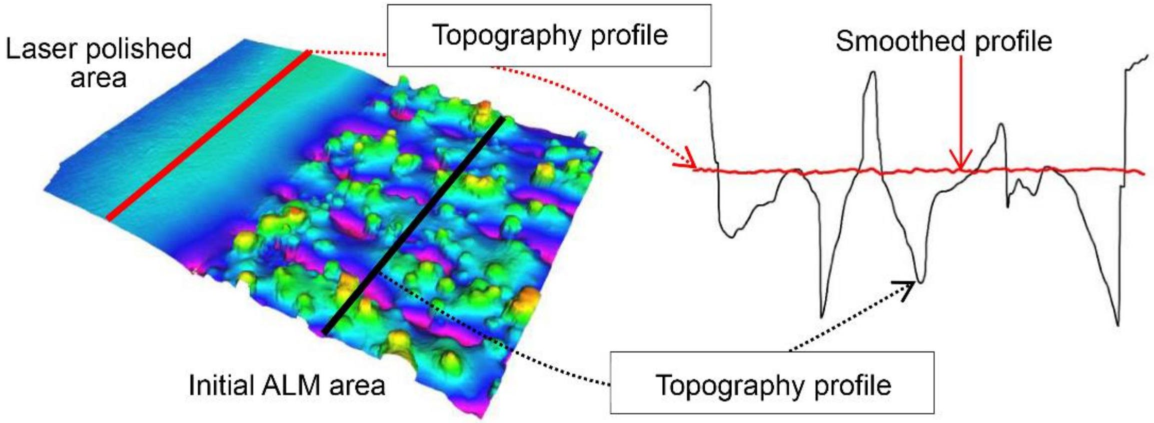
Surface Enhancements and Polishing

	Polishing feature applicability	
Process	**External surfaces**	**Internal surfaces**
In-process smoothing (contours)	+	+
Chemical milling	+	+
Chemical Mechanical Polishing	+	+
Abrasive flow machining	+	+
Media suspension methods	+	–
Dissolvable / surface sensitization	+	0
Powder enhanced slurry plating	0	0
Electrochemical machining (ECM) or electropolishing (EP)	+	0
Secondary laser polishing (in-process or post)	+	–
Manual polishing (honing, buffing, burnishing)	+	–
Grit blasting	+	–
Thermal deburring	–	–
Coatings	+	0
Peening methods	+	–
Magnetic abrasive finishing (MAF)	0	+

Note: +, potential for maturation and/or demonstrated; –, significant challenges exist; 0, unknown and further development required.

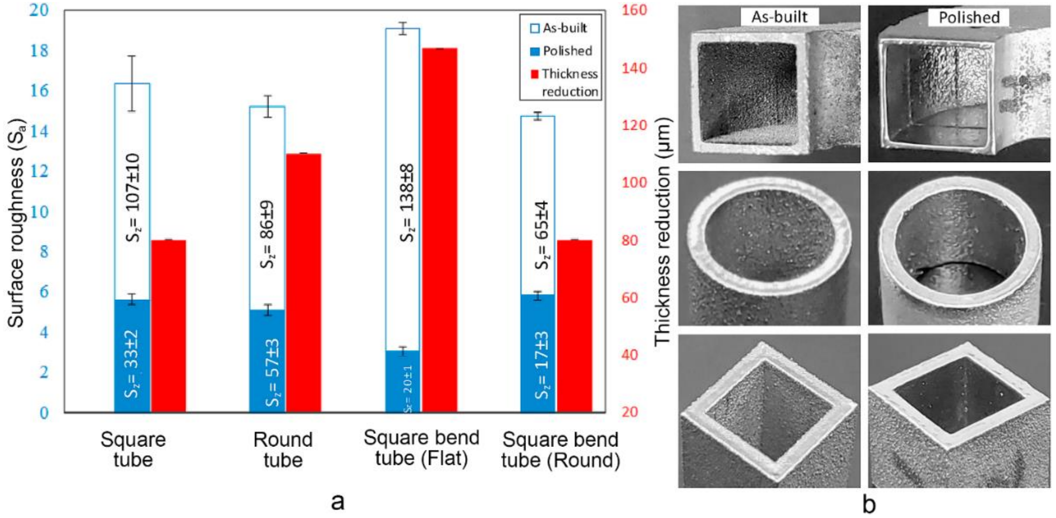
Surface Enhancements

Laser polishing

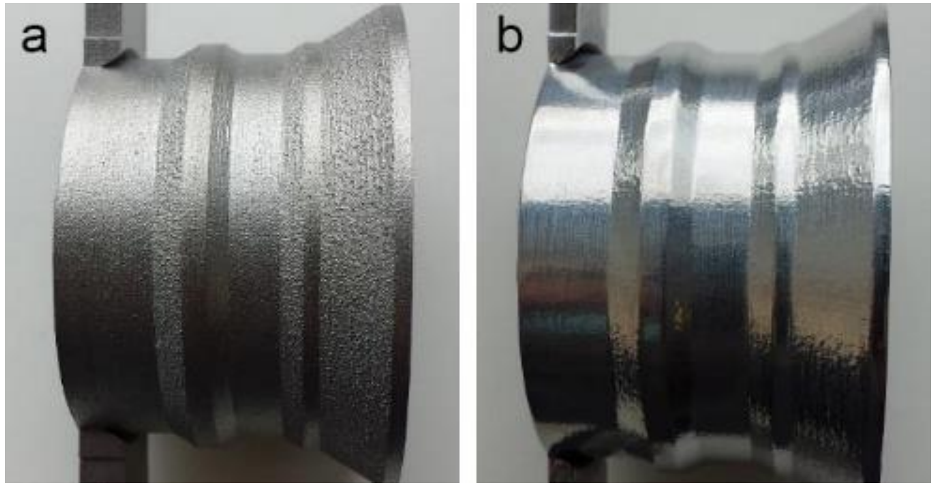


- As-built
- Chemically Milled
- Electrochemical Machining
- Chemical Mechanical Polishing

Electrochemical Polishing



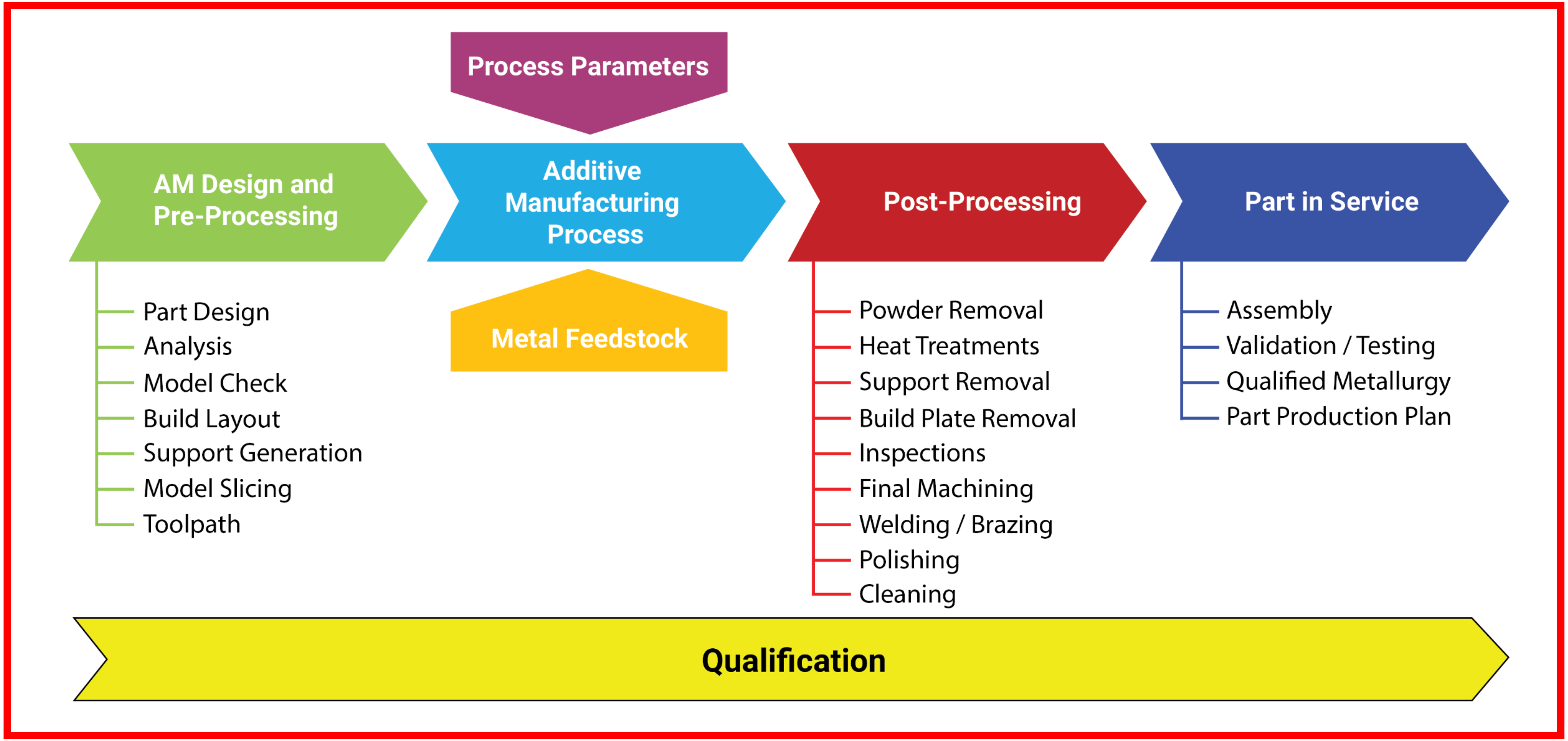
Abrasive Flow Machining



Feedstock and Post-build Processing Summary

- Feedstock is critical and all aspects should be carefully tracked (chemistry, size distribution, flowability, morphology, reuse, etc).
- Post-processing is just part of the process and will be necessary for most all components.
- Post-processing must be planned for in the initial design stage.
  - Powder unpacking
  - Powder removal and cleaning
  - Build plate and support removal
  - Heat treatments
  - Machining
  - Cleaning
  - Joining (Welding, brazing and diffusion bonding)
  - Inspections and NDE
  - Surface enhancements (or polishing techniques)

Qualification



Gradl, P., Tinker, D., Park, A., Mireles, O., Garcia, M., Wilkerson, R., Mckinney, C., 2021. Robust Metal Additive Manufacturing Process Selection and Development for Aerospace Components. Journal of Materials Engineering and Performance, Springer. https://doi.org/10.1007/s11665-022-06850-0

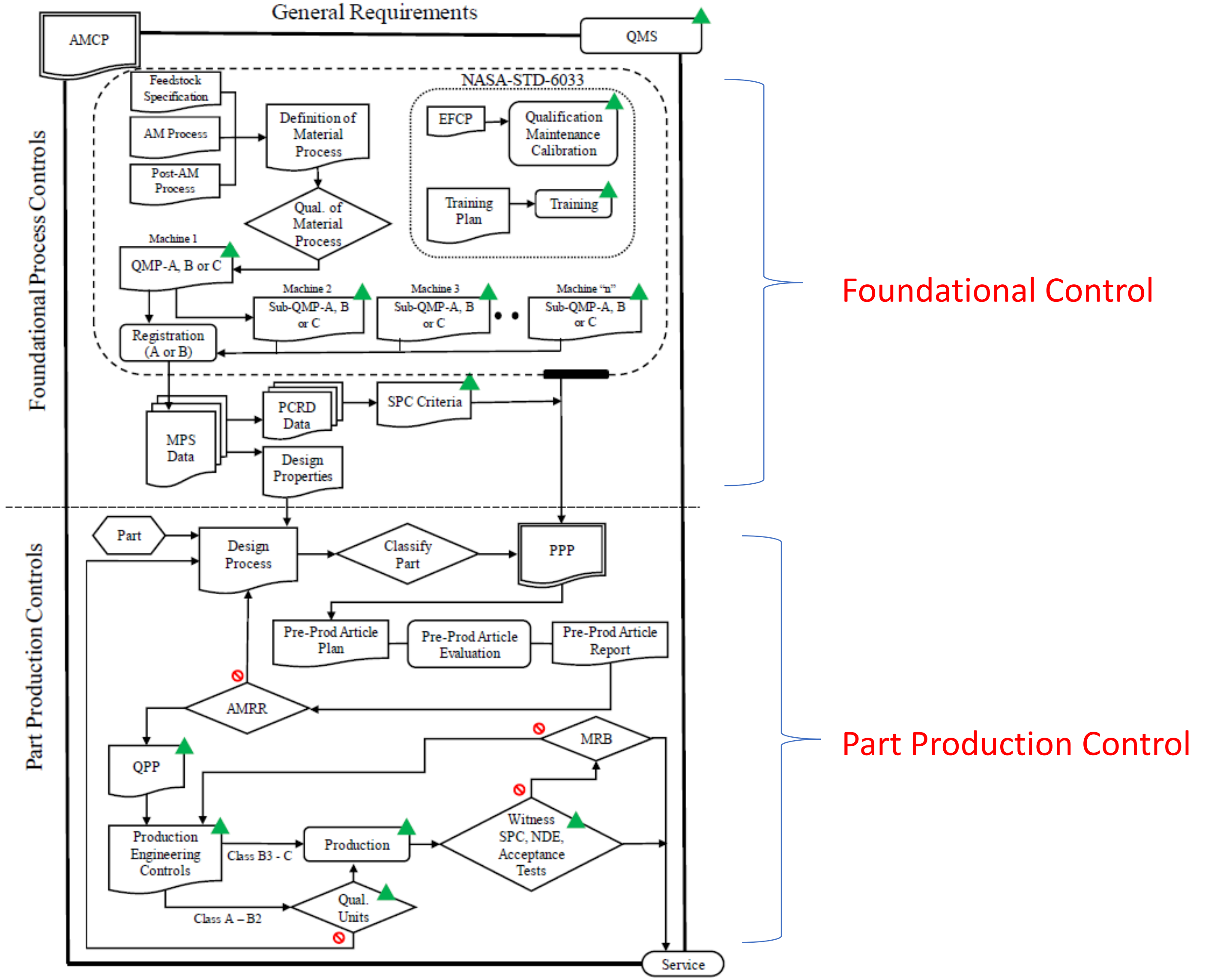
Qualification – Framework of 6030 Requirements

What should I worry about?

How should I define and control them?

Who and When should work them?

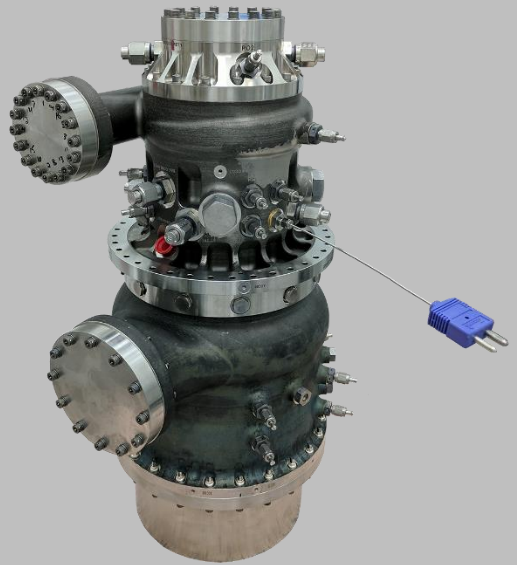
How NASA should be aware and approve of them?

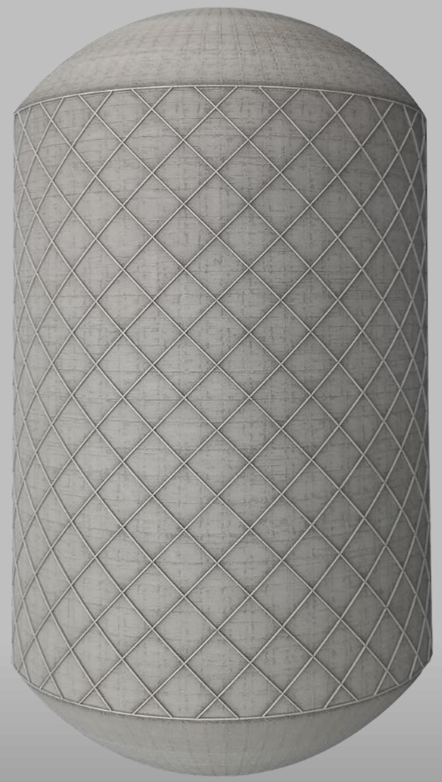


115 "shall" requirement statements in 6030; 31 "shall" statements in 6033

Qualification and Certification (based on NASA)

- Define a manageable, systematic, and consistent approach to AM to allow the Agency to evaluate risk and make consistent decisions regarding the certification of designs and hardware.
- Integrate the AM process in a manner compatible with existing governing Agency standards.
- Enforce discipline and systematic rigor throughout the AM process, from design to part.
- Avoid defining the specifics of AM processes; instead define methodologies for qualifying and controlling the processes.
- Accommodate the use of internal and open industry standards as appropriate.
- Provide NASA with opportunities for insight to gauge quality, completeness, and rigor through a well-defined and predictable set of reviewable products governing the AM process.

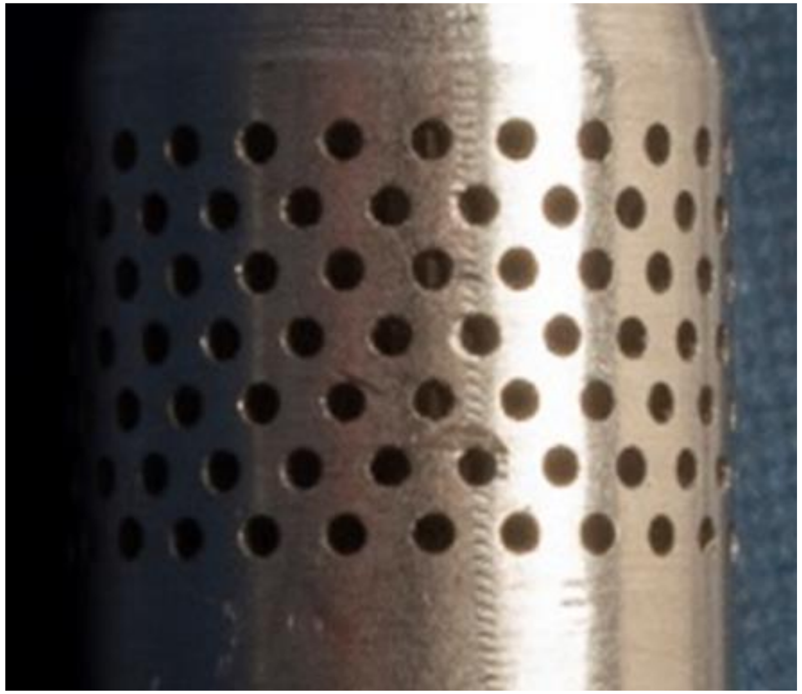




Select Application Case Studies

Case Study #1 – Fine Features

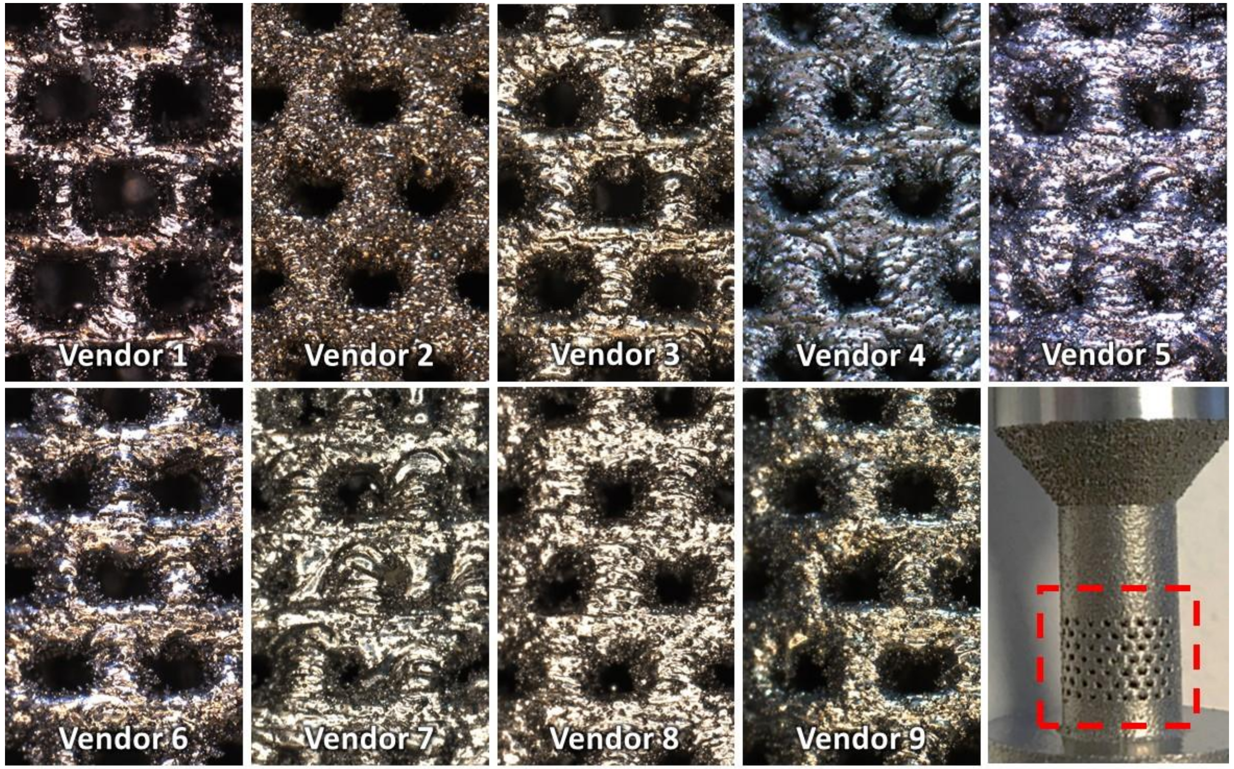
- Single element injector
- 168 small radial filter holes per element
- Built by 9 commercial vendors using the same model in 2019

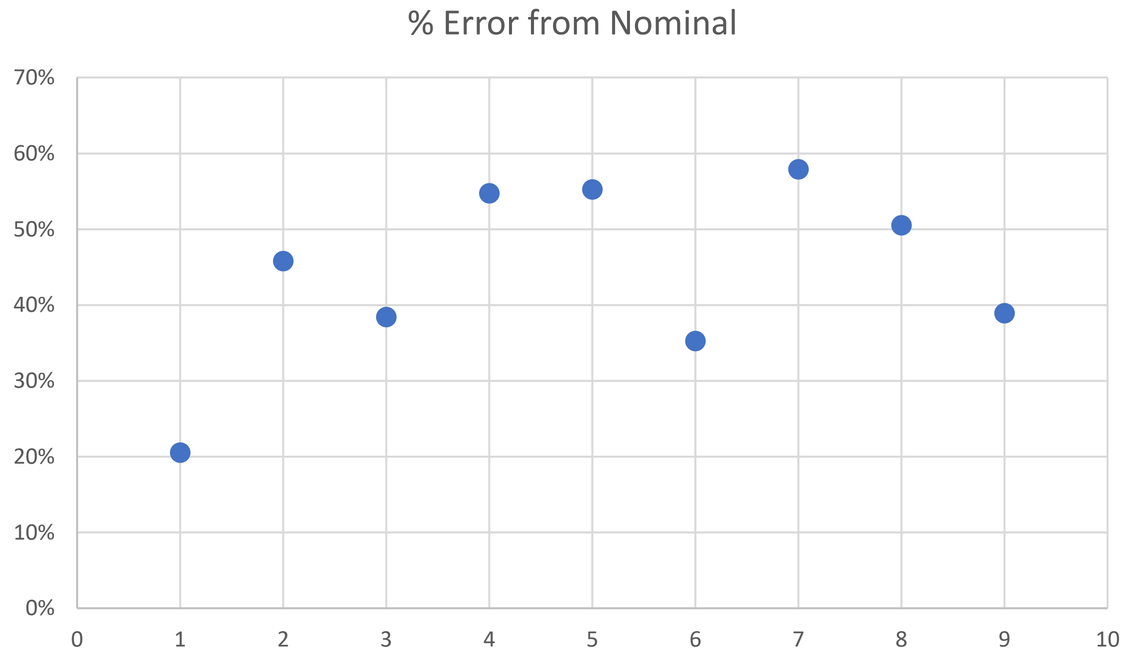


A traditionally machined sleeve filter used as baseline

Case Study #1

Error from nine vendors ranged from 21% to 55%





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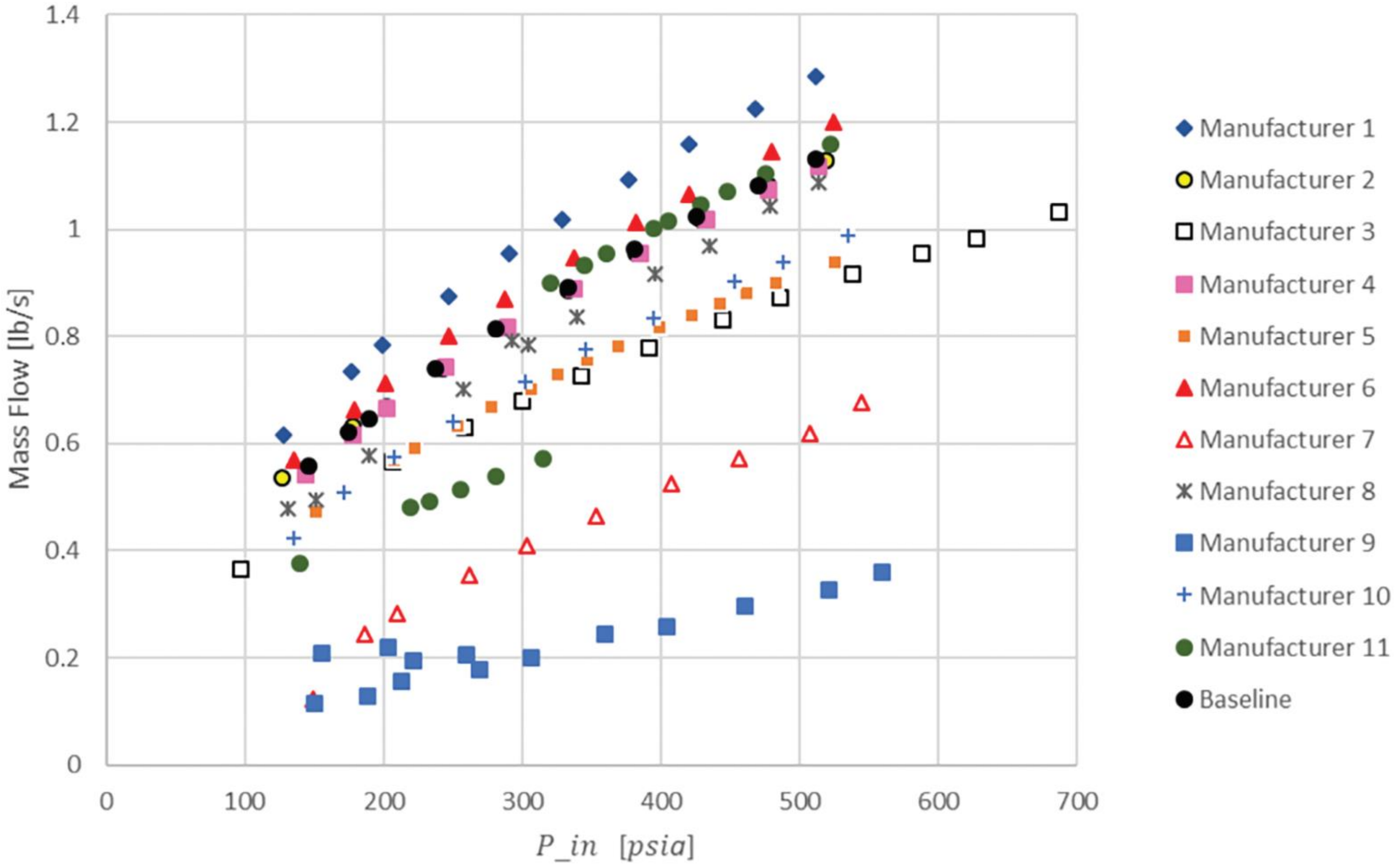
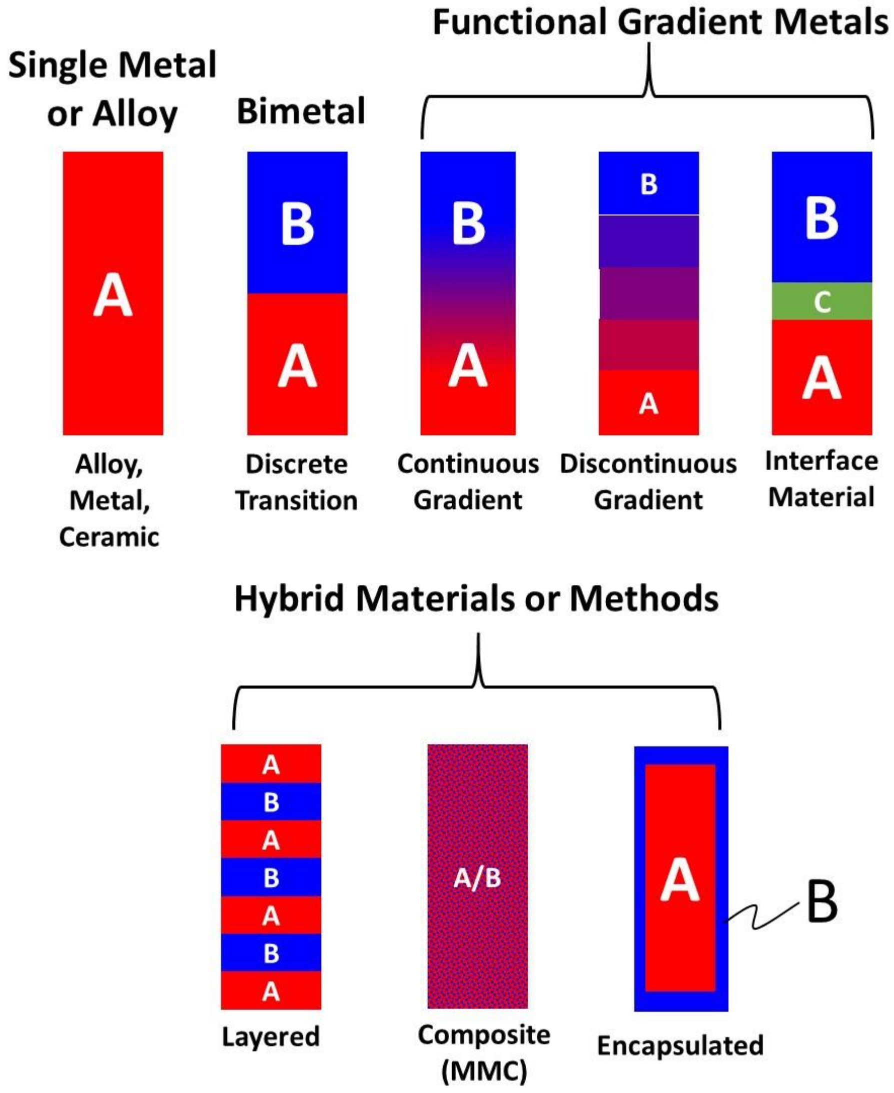
Case Study #1

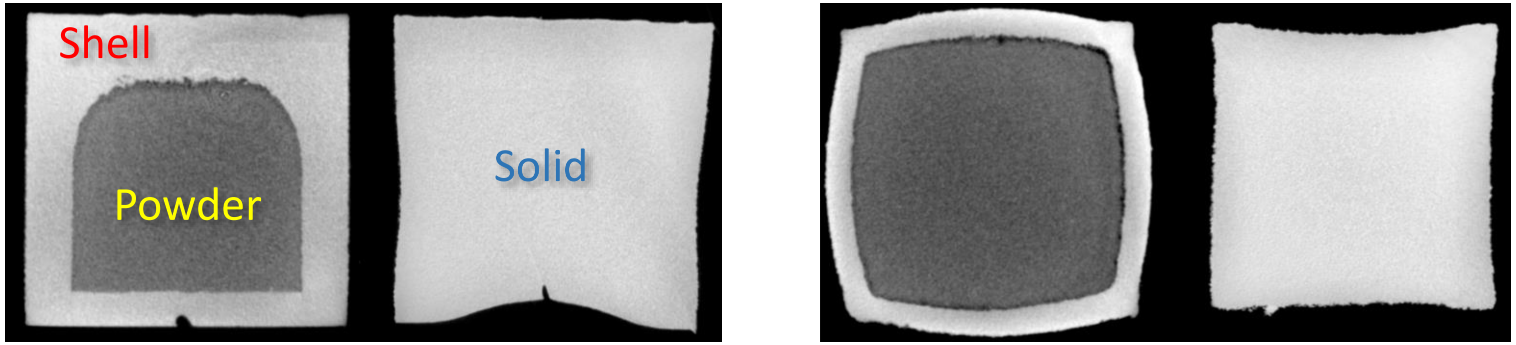
Water mass flow rate of the fuel circuit for 11 AM elements with comparison to baseline injector element



Bimetallic, Multi-metallic, and Hybrid Builds

- Much of AM is focused on single alloys or processes, where further opportunities exist to optimize performance.
  - Weight reduction (higher strength to weight).
  - Use of materials as required locally based on various properties.
- Hybrid methods may include ceramics or unique processing for improved efficiency.





Hybrid Methods -- Encapsulated: shell and powder with HIP consolidation

Du Plessis, A., Yelamanchi, B., Fischer, C., Miller, J., Beamer, C., Rogers, K., Cortes, P., Els, J., and MacDonald, E., "Productivity enhancement of laser powder bed fusion using compensated shelled geometries and hot isostatic pressing," *Advances in Industrial and Manufacturing Engineering*, Vol. 2, May 2021, paper 100031, https://doi.org/10.1016/j.aime.2021.100031.

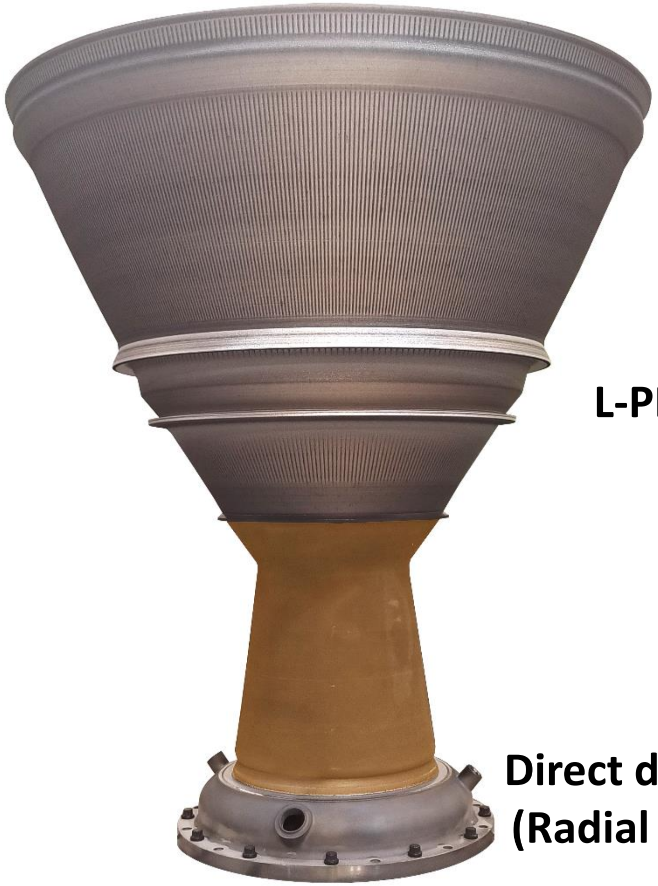
Hofmann, D. C., Kolodziejska, J., Roberts, S., Otis, R., Dillon, R. P., Suh, J.-O., Liu, Z.-K., and Borgonia, J. P., "Compositionally graded metals: A new frontier of additive manufacturing," *Journal of Materials Research*, Vol. 29, No. 17, 2014, pp. 1899–1910.

Multi-metallic and multi-process hardware development

Credit: RPMI / NASA

L-PBF Liner / LP-DED Jacket

L-PBF Liner / Coldspray Jacket



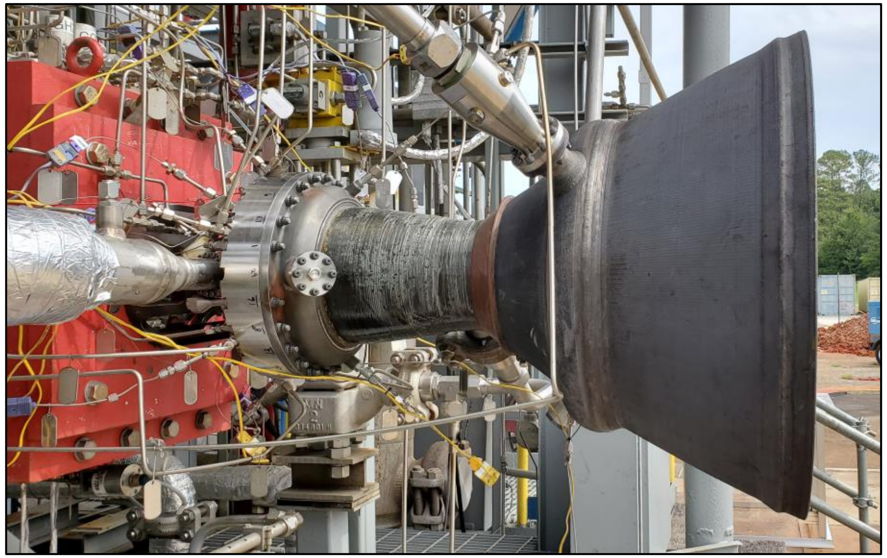
Direct deposit LP-DED nozzle
(Radial and Axial Bimetallic)

L-PBF Liner / EBW-DED Jacket

L-PBF GRCop-42 to Inco 625

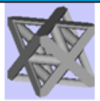
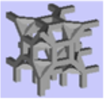
Case Study #2 – Bimetallic AM

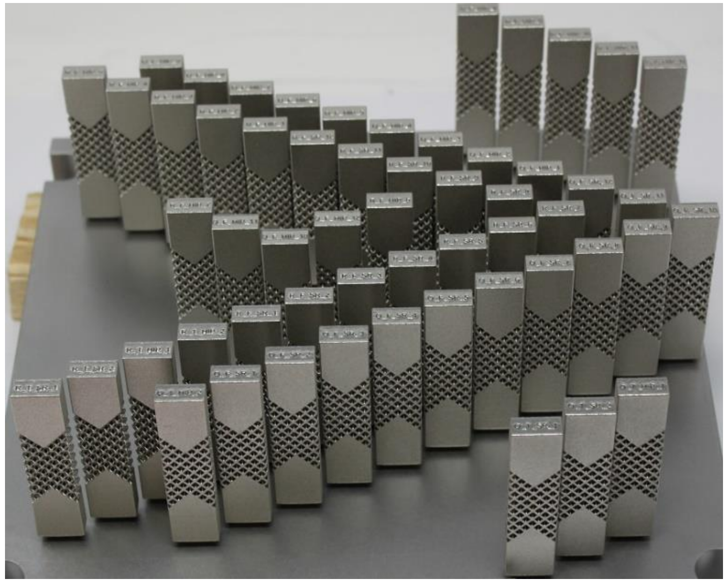
- Implementation of novel AM technologies at 40,000 lbf thrust class TCA testing as part of the RAMPT project
  - L-PBF GRCop-42 chamber liner
  - Radial bimetallic LP-DED NASA HR-1 builds (manifold buildup and cladded structural jackets)
  - Axial bimetallic LP-DED NASA HR-1 nozzle with integral channel wall cooling



Lattice Topology Selection

- Highly dependent on application and operating environment.
- Standard libraries or custom topologies.
- Screening start with file size / generation time then printability.
- Specimen design optimization.
- Characterize desired thermal and/or mechanical properties.

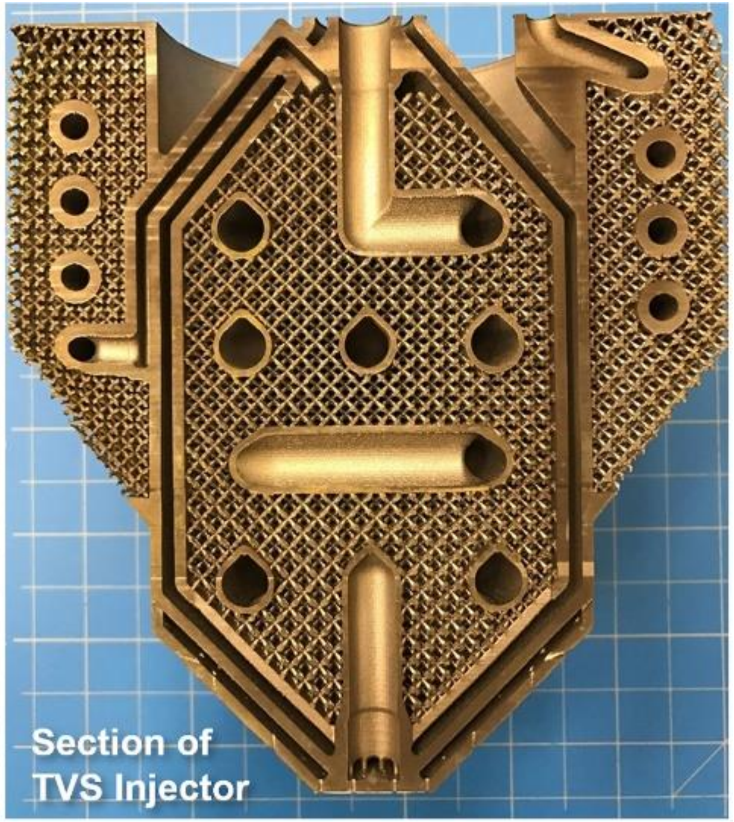
Lattice Topology	Image	Cube Size (mm)	Unit Cell (mm)	Number of Unit Cells	STL Generation Time (s)	STL File Size (KB)	L-PBF AM Trial Outcome	Notes
Octet Truss - 30 %RD		10x10x10	10	1	1	62	Print	Candidate to further evaluation. Pass.
		10x10x10	1	1000	3	22052	Print	Candidate to further evaluation. Pass.
Rhombi Octa Dense		10x10x10	10	1	1	106	Print	Excessive generation time. Disqualifed.
		10x10x10	1	1000	420	51510	Fail	Excessive generation time. Failed print trial. Disqualifed.
Rhombi Octa Light		10x10x10	10	1	1	44	Fail	Failed print trail. Disqualifed.
		10x10x10	1	1000	90	29956	Fail	Excessive generation time. Disqualifed.
Rhombic Dodecahedron - 20 %RD		10x10x10	10	1	1	93	Print	Candidate to further evaluation. Pass.
		10x10x10	1	1000	180	21444	Print	Excessive generation time. Disqualifed.



Paul R. Gradl, Omar R. Mireles, Christopher S. Protz, Chance P. Garcia, Metal Additive Manufacturing for Propulsion Applications, 1st ed., American Institute of Aeronautics and Astronautics, Inc., Reston, VA, 2022. https://doi.org/10.2514/4.106279

Case Study #3 – Functional Lattices, TVS Injector

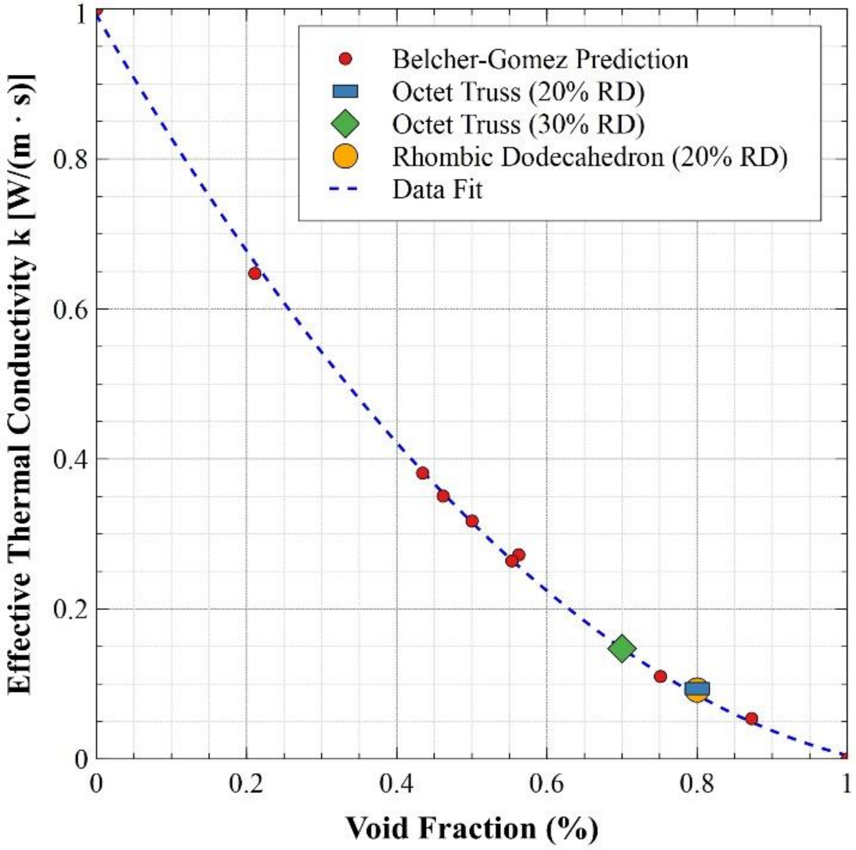
- Thermodynamic vent system (TVS) injector with liquid, two-phase, and gas flow – heat exchanger, injector, and condenser integrated



Paul R. Gradl, Omar R. Mireles, Christopher S. Protz, Chance P. Garcia, Metal Additive Manufacturing for Propulsion Applications, 1st ed., American Institute of Aeronautics and Astronautics, Inc., Reston, VA, 2022. https://doi.org/10.2514/4.106279

Application Case Study – Thermal Isolation using AM

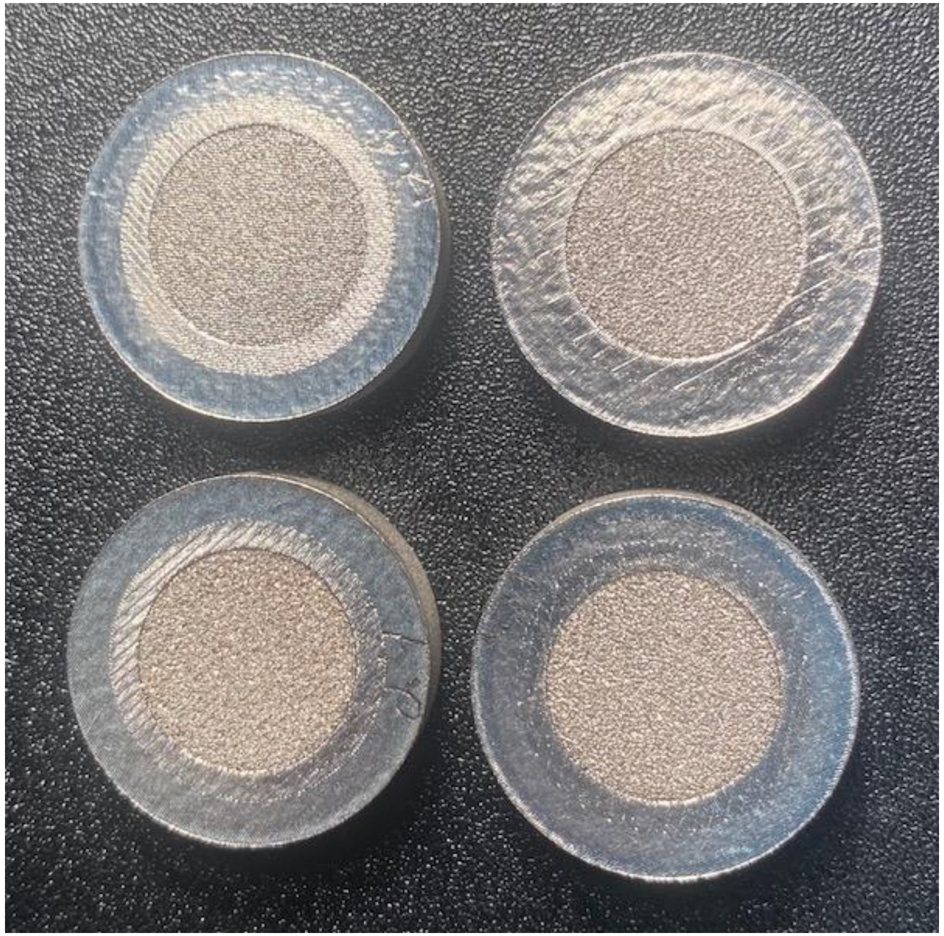
- Minimize conductive heat transfer using various lattice structures.
- Weight reduction of 40% and thermal conductivity reduced to 10% of fully dense designs



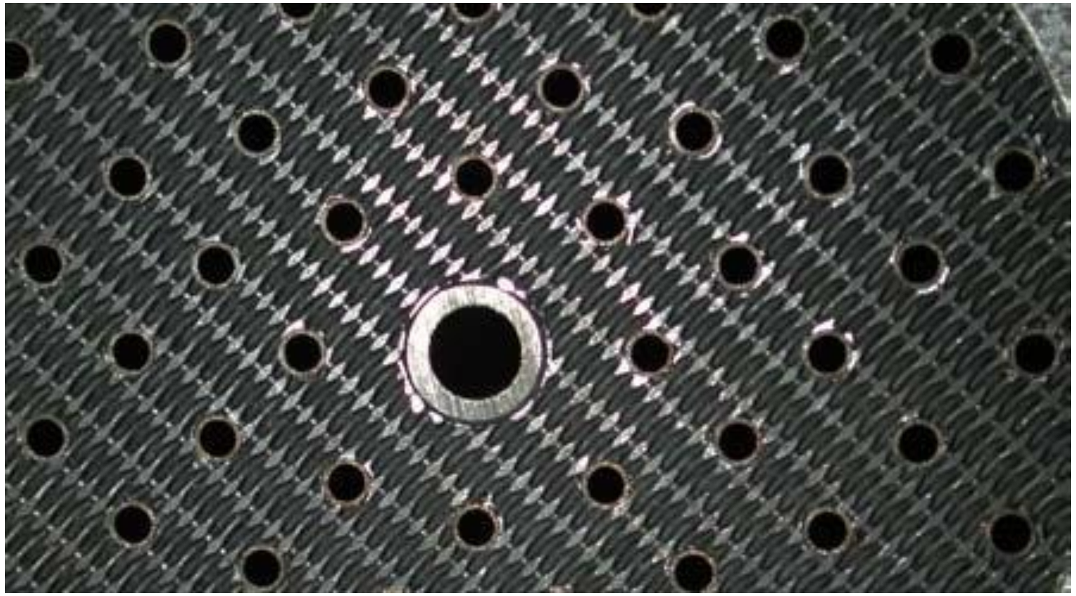
Paul R. Gradl, Omar R. Mireles, Christopher S. Protz, Chance P. Garcia, Metal Additive Manufacturing for Propulsion Applications, 1st ed., American Institute of Aeronautics and Astronautics, Inc., Reston, VA, 2022. https://doi.org/10.2514/4.106279

Case Study #4 – Porous AM

- Porous AM for transpiration cooling of rocket engine components
- NASA SBIR with Masten and several industry developments
- Internal development at MSFC ongoing
- For various build parameters, how do porosity and permeability change
- Pressure drop vs. mass flow rate data
- Structural properties unknown



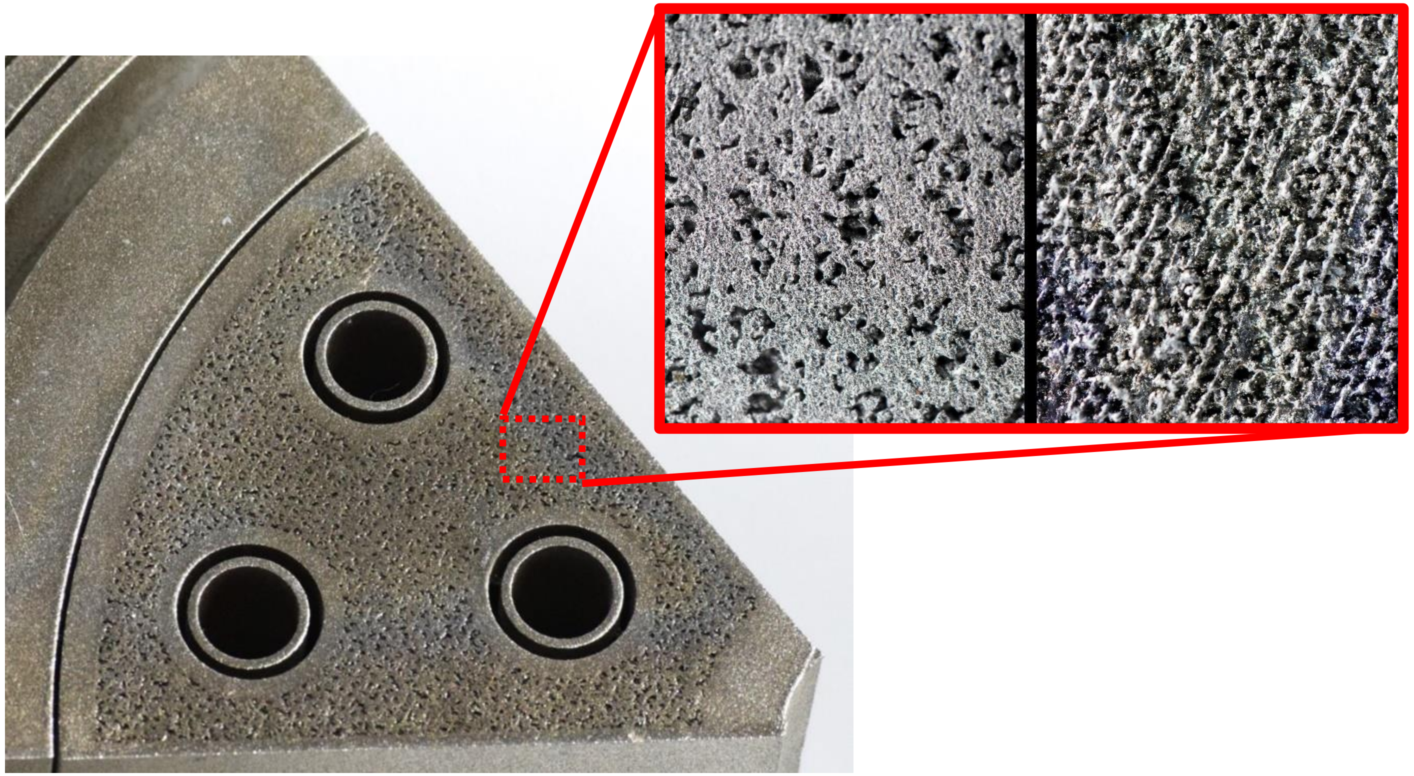
Porous flow sample pucks with solid outer ring for sealing

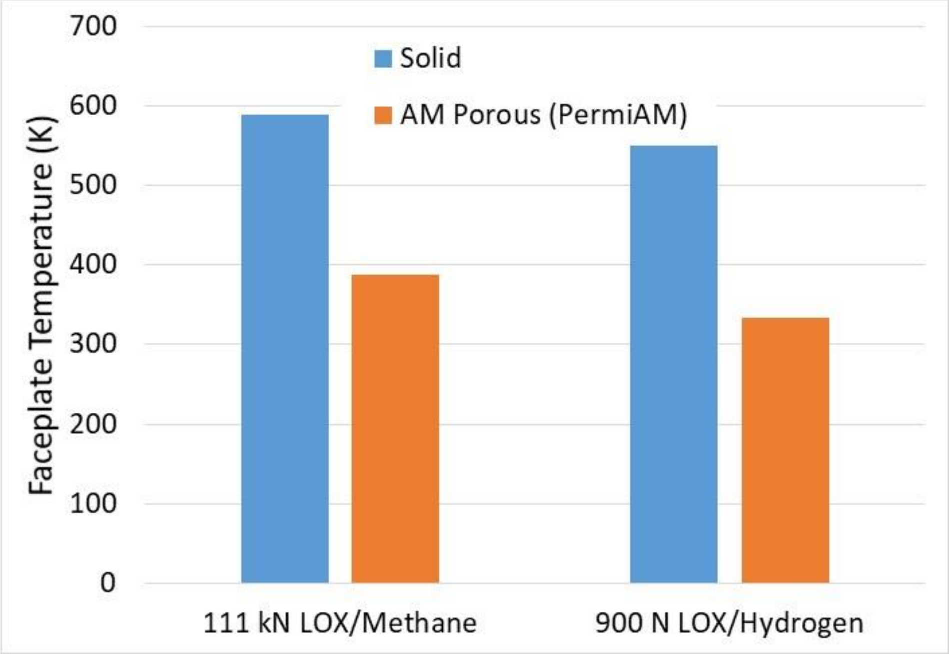


Traditional Rigimesh for faceplate cooling

Application Case Study – Transpiration Cooling

- Creating intentional porosity to allow for transpiration cooling in high heat flux components.
- Replaces solid surfaces or Rigimesh structures with (localized) permeable AM as part of the build.

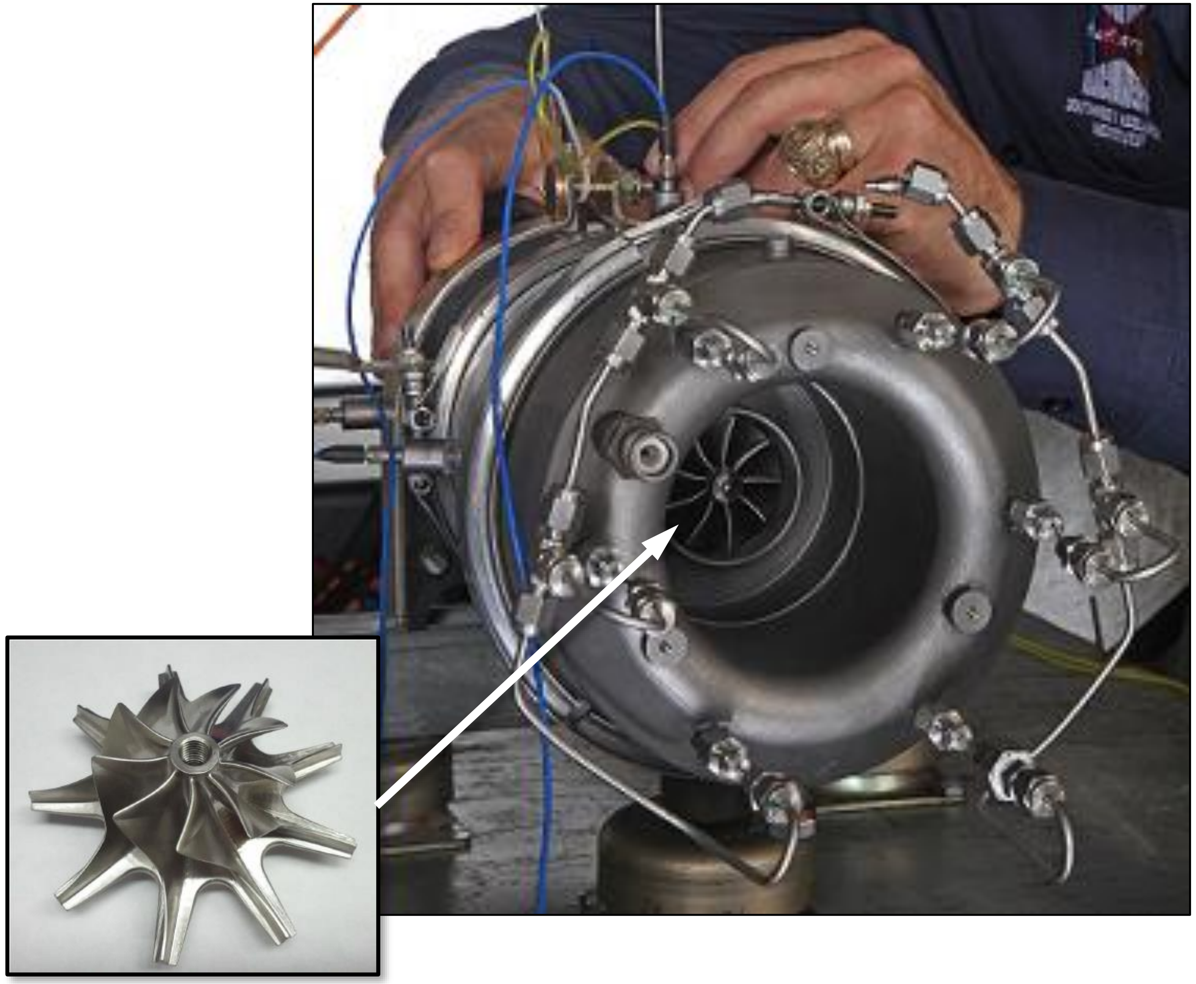


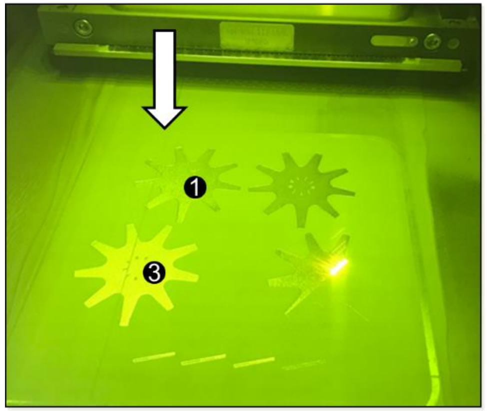


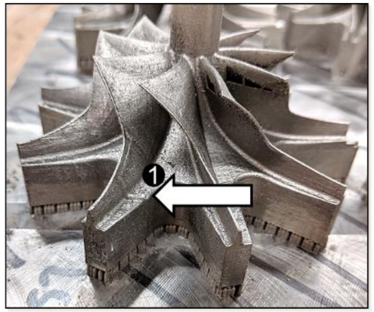
35-40% reduction in wall temperatures

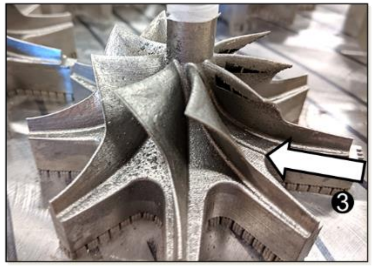
Paul R. Gradl, Omar R. Mireles, Christopher S. Protz, Chance P. Garcia, Metal Additive Manufacturing for Propulsion Applications, 1st ed., American Institute of Aeronautics and Astronautics, Inc., Reston, VA, 2022. https://doi.org/10.2514/4.106279

The AM Process Lifespan









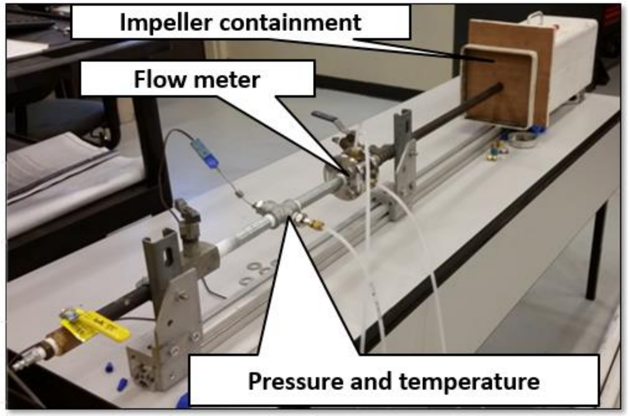
References:

- Bryner, E., Ransom, D., Bishop, J., Coogan, S., and Musgrove, G., “Design of a Small Scale Gas Turbine for a Hybrid Propulsion System,” Vol. 56796, 2015, pp. V008T23A011.
- Cunningham, C. S., Ransom, D., Wilkes, J., Bishop, J., and White, B., “Mechanical Design Features of a Small Gas Turbine for Power Generation in Unmanned Aerial Vehicles,” Vol. 56796, 2015, pp. V008T23A021.
- Krouse, C. R., Andrews, N. F., and Musgrove, G. O., “Geometry and Distortion Evaluations of Additively Manufactured IN718 Internally Cooled Radial Turbines,” 2019, AIAA Propulsion and Energy Forum 2019
- Musgrove, G. O., Smith, J., Smith, E., and White, S., “Design and Testing of an Internally-Cooled Radial Turbine With High Tip Speed,” Vol. 84997, 2021, pp. V006T19A006.
- Andrews, N.A., Cole, J., White, S.H., Smith, E.K., Musgrove, G.O., Smith, J., “Material Evaluation and Overspeed Testing of an Internally-Cooled Radial Turbine with High Tip Speed Designed for Additive Manufacturing”, AIAA SciTech Forum 2024

Successful AM application needs access to all the processes

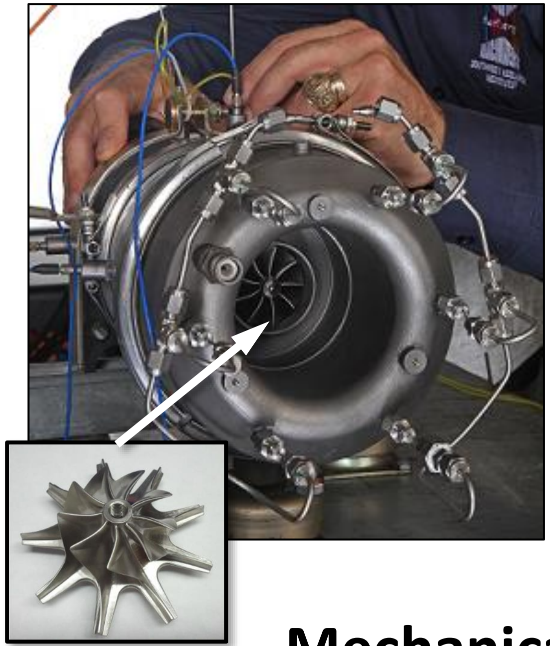
Component Testing: Pressurized Coolant Flow Test Rig

- Shop air (~100 psi)
- Measure pressure drop
- Measure flow rate



Printing Capability: Renishaw AM250

- 273mm x 273mm build area
- IN 718 capable

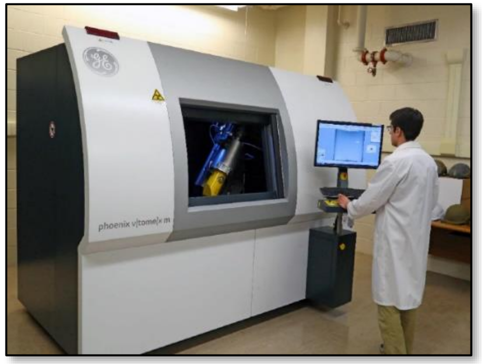


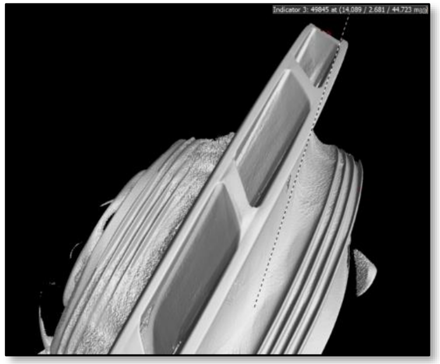
Application: 12.5kW Gas Turbine

- 118,000 rpm
- Material IN718
- 90mm diameter

Inspection Capability: CT Scan

- Non-destructive evaluation of impeller



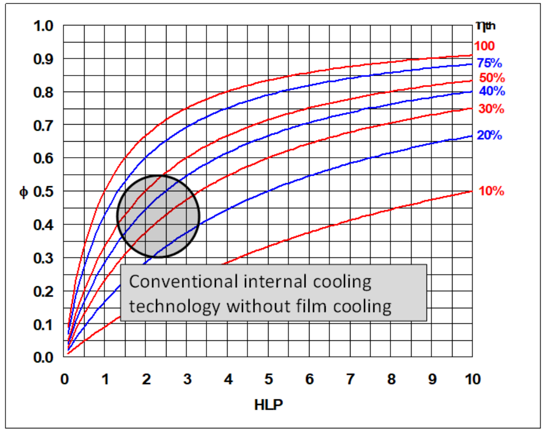


Mechanical Testing & Characterization Lab

- Surface characterization
- Destructive evaluation tests

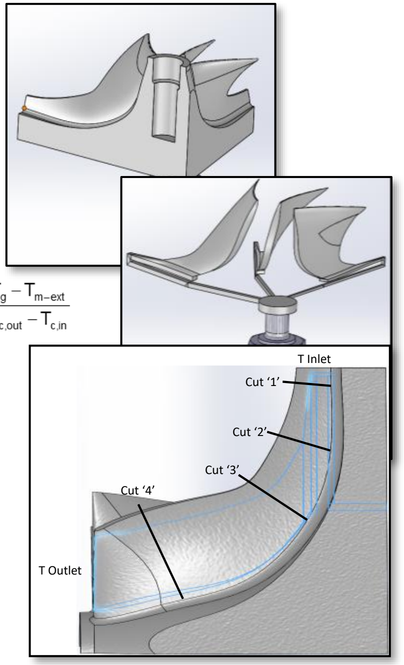
Design was functionally considered for AMB benefits

1D heat transfer analysis to determine passage size to achieve 550°C metal temperature using available compressor bleed air



$$\phi_m = \frac{T_g - T_{m,ext}}{T_g - T_{c,in}}$$

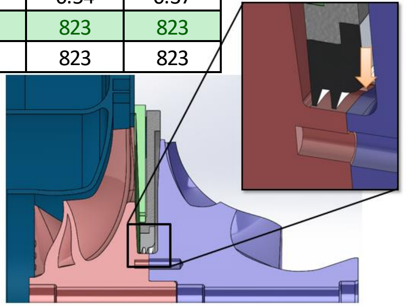
$$HLP = \frac{W_c C_p}{h_g A_g} = \frac{T_g - T_{m-ext}}{T_{c,out} - T_{c,in}}$$

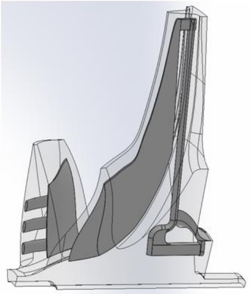


The turbine cooling requirements are defined to achieve conventional cooling effectiveness values

	Case 1	Case 2	Case 3	Case 4
Inlet Channel Width [mm]	0.5	0.6	0.75	1
Cooling Split [%]	0.75%	1.08%	1.35%	1.79%
Flow Check [KPa]	-1	40	121	135
Max Mach # []	0.92	0.93	0.54	0.37
Tm-ext Max [K]	835	823	823	823
Tm-ext Target [K]	823	823	823	823

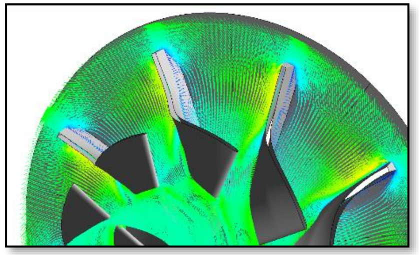
Cooling flow sourced from compressor discharge





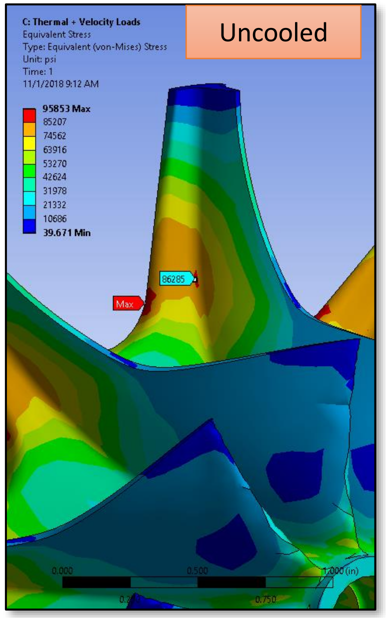
3D heat transfer and mechanical analysis to determine mechanical integrity and life

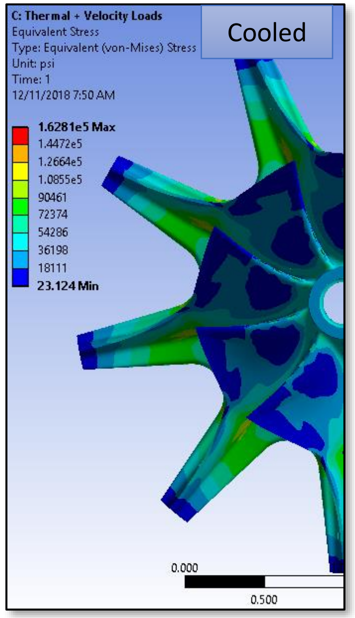
118,000 rpm
Fixed axial displacement
Shaft cylindrical support
Assume 550°C-370°C

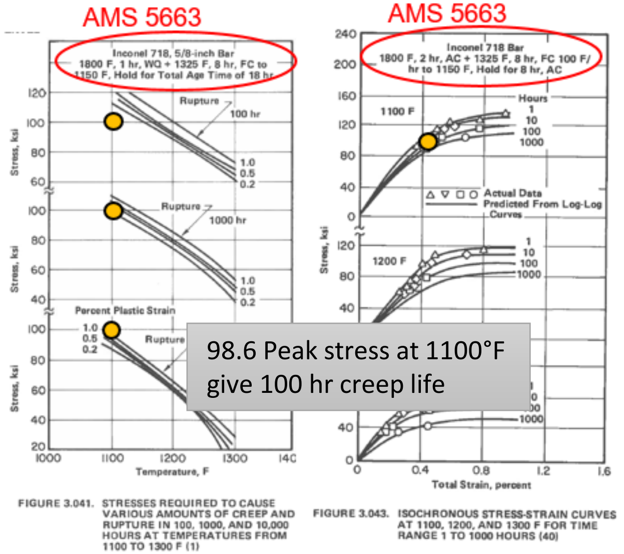


1202°F Property	Wrought	Printed
Modulus Elasticity	3016.8 ksi	2538.1 ksi
Yield Strength	169.7 ksi	161.0 ksi
Ultimate Strength	204.5 ksi	195.8 ksi

Printed material properties for heat treated IN718 from Strobner et al. 2015 and Deng et al. 2017

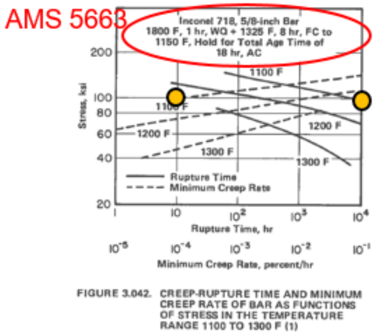






98.6 Peak stress at 1100°F give 100 hr creep life

Ref: 1996, Aerospace Structural Metals Handbook, Purdue University Center for Information and Numerical Data Analysis and Synthesis.



A chronological history of print succession

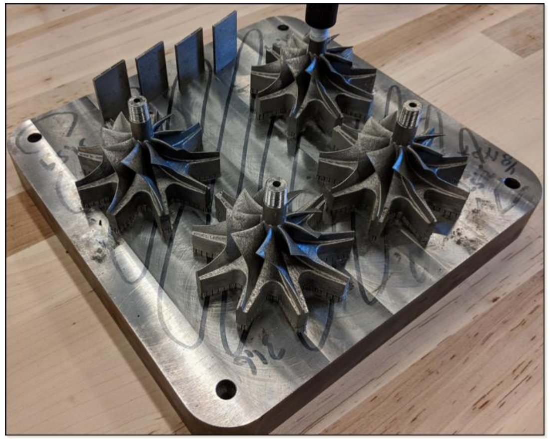
Print 1: Exploratory solid samples

Print 2: Generation 1 cooled samples

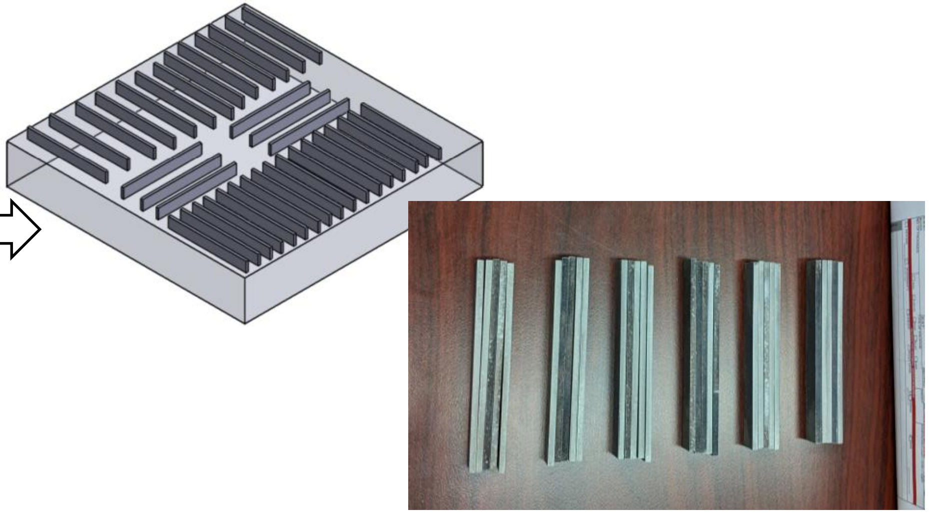
Print 3: Material and channel coupons

Print 4: Generation 2 impellers

Print 5: Generation 3 impellers

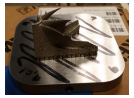
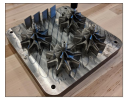
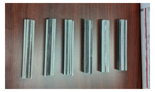


Print 6: Material coupons



Print 7: Exploratory pin fin samples

Each Print has a Unique Purpose in Design Cycle

Print 1	Print 2	Print 3	Print 4	Print 5	Print 6	Print 7
						

Process Parameters

AM Design and Pre-Processing
- Part Design
- Analysis
- Model Check
- Build Layout
- Support Generation
- Model Slicing
- Toolpath

Additive Manufacturing Process

Metal Feedstock

Post-Processing
- Powder Removal
- Heat Treatments
- Support Removal
- Build Plate Removal
- Inspections
- Final Machining
- Welding / Brazing
- Polishing
- Cleaning

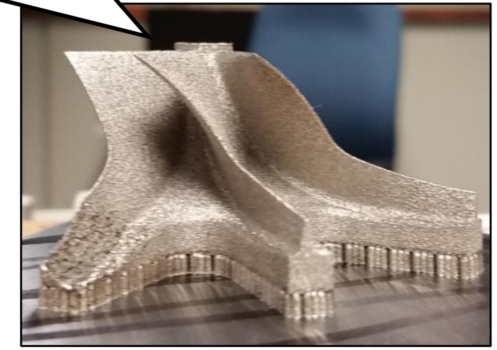
Part in Service
- Assembly
- Validation / Testing
- Qualified Metallurgy
- Part Production Plan

Qualification

Several test prints have been completed to determine AM print capabilities and considerations of the design

Print 1

Quarter geometry for blade angles



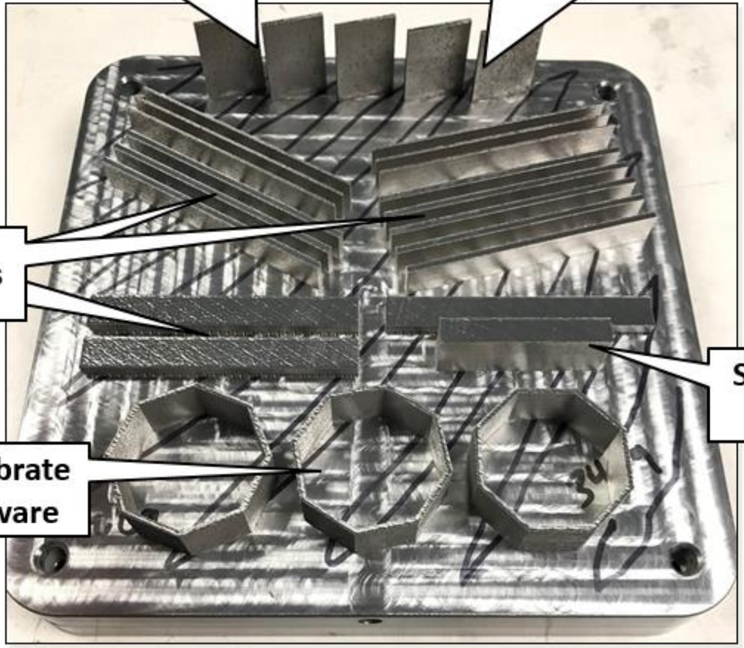
Print 2

Quarter geometry for cooling channel thickness

Print 3

Coupons for channel roughness

Coupons for cooling turbulators



Argon

Recoater

Tensile coupons

Solid block to calibrate distortion software

Polygons to calibrate distortion software

What if we account for build distortions?

What if we make the blades thicker?

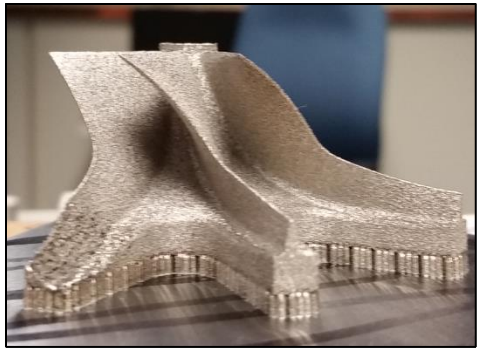
Build CAD geometry using supports (Baseline)

What if we build the impeller directly on the build plate?

Print 4

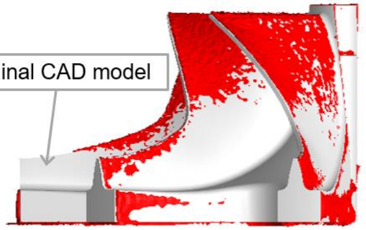
Non-destructive evaluations were used to determine printability of features and expected distortions

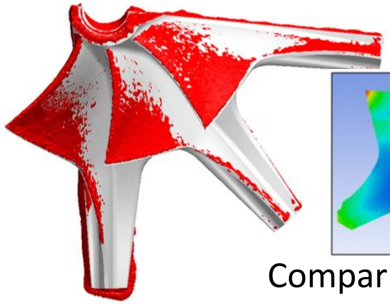
Coordinate Measurement Machine (CMM) inspections show geometric distortions



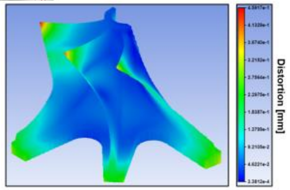
CMM generated model

Original CAD model





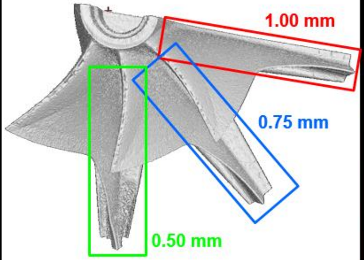
Location	Measured Distortion
1	0.51 mm
2	0.43 mm
3	0.31 mm
4	0.39 mm
5	0.24 mm
6	0.34 mm

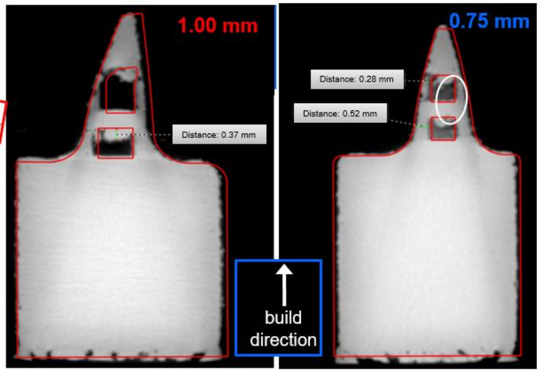


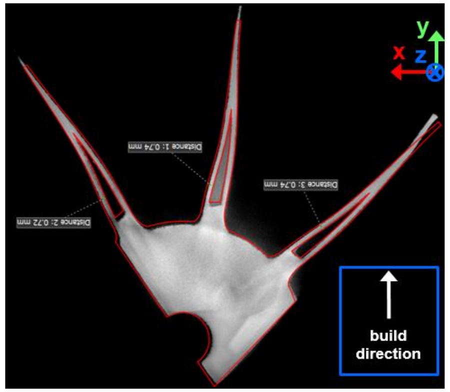
Comparison performed with ANSYS Additive®

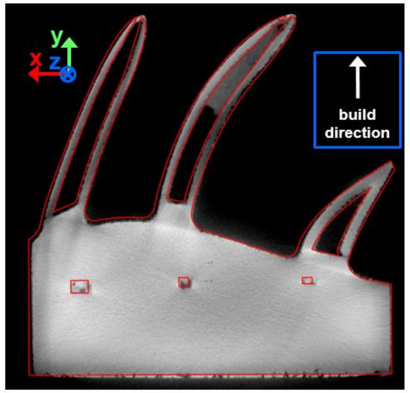
Print 1

X-Ray CT Inspections show 0.75 mm cooling channels are repeatable





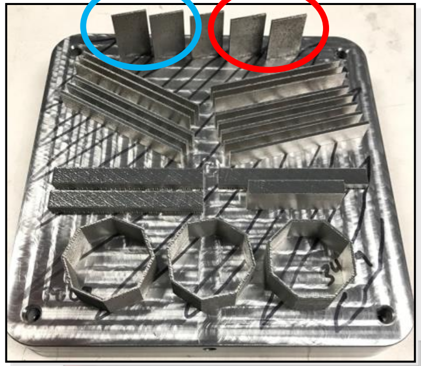


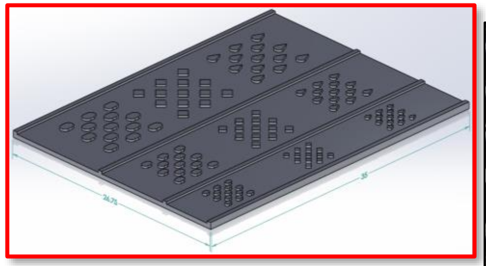


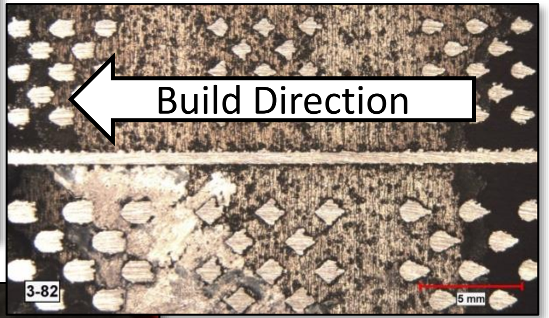
Print 2

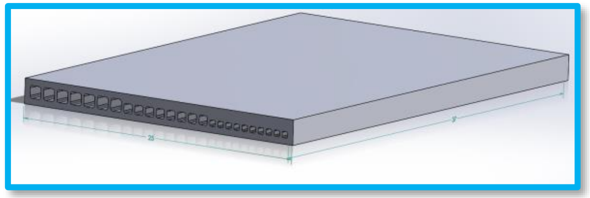
Teardrop-shaped turbulators had the best build resolution, which is also the most aerodynamic, and 0.75 mm was the minimum repeatable passage width

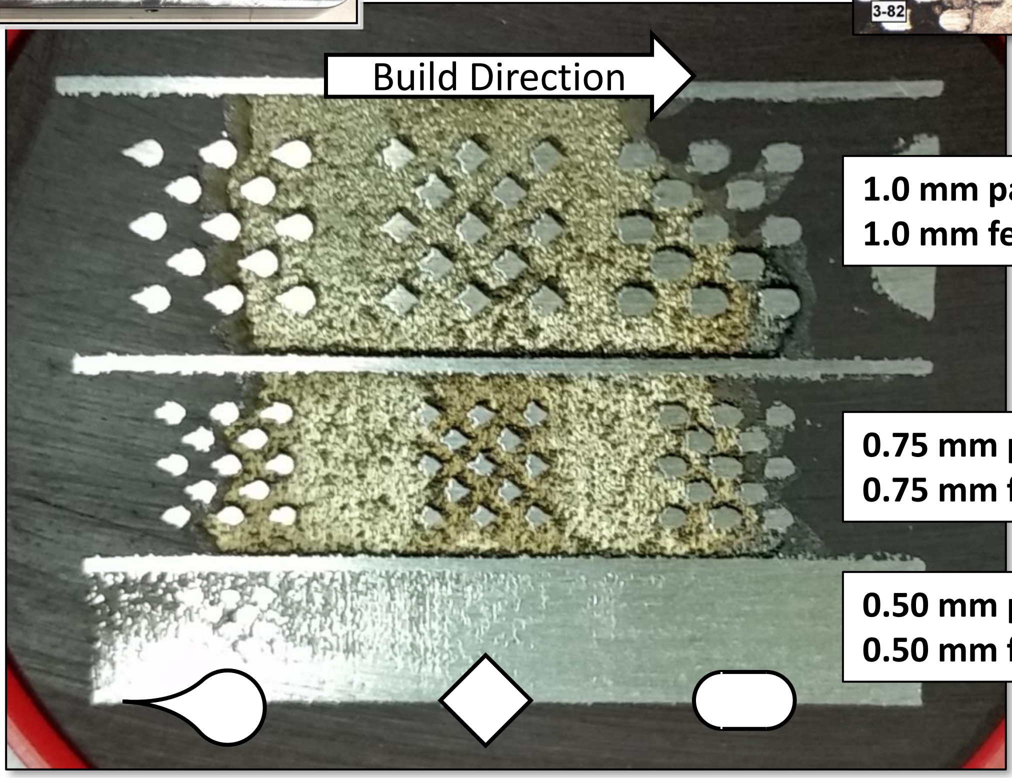
Print 3







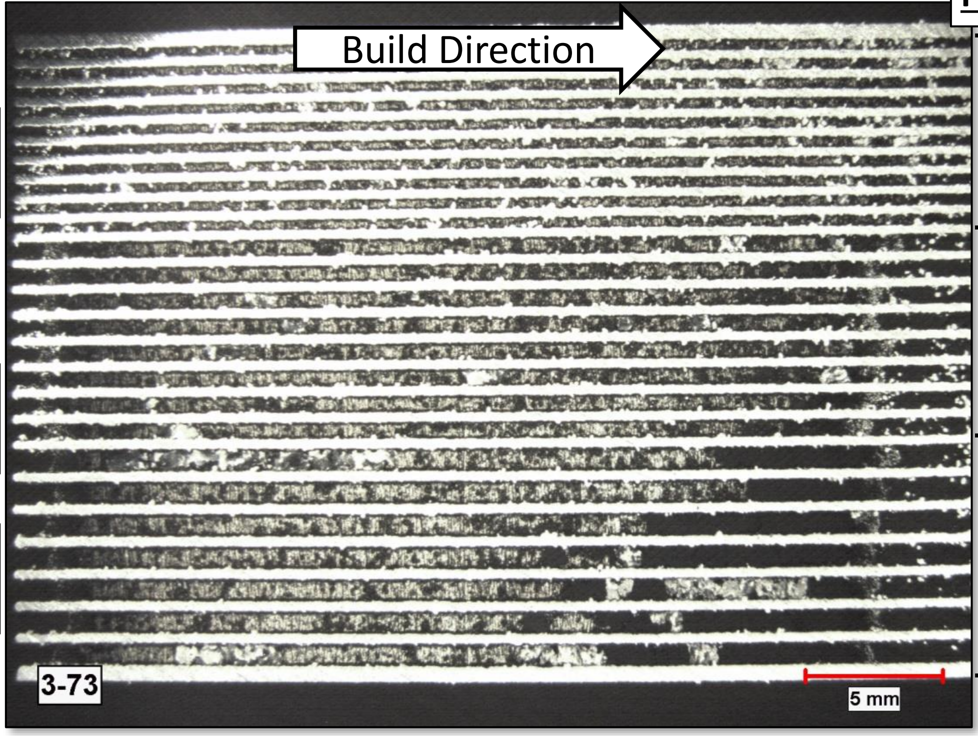




1.0 mm passage height
1.0 mm features

0.75 mm passage height
0.75 mm features

0.50 mm passage height
0.50 mm features



Passage Height:

0.50 mm

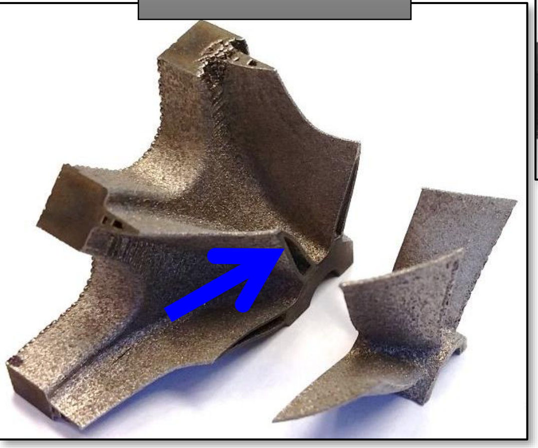
0.75 mm

1.0 mm

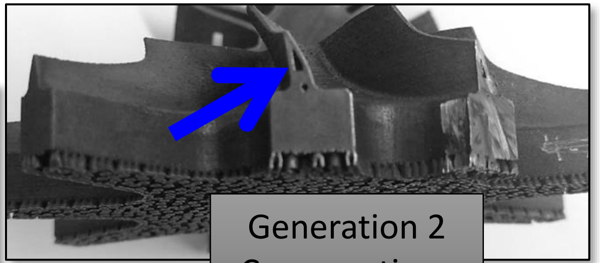
The cooling passages are modified to allow easy removal of powder prior to stress relief

Print 2

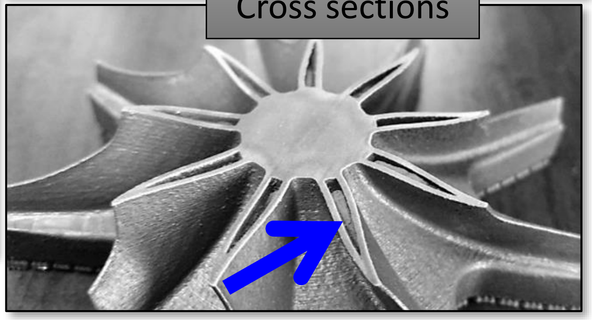
Generation 1
Cross sections



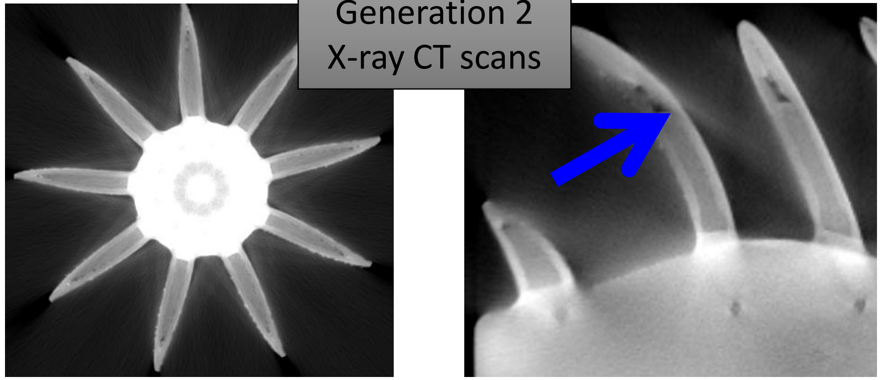
Print 4



Generation 2
Cross sections



Generation 2
X-ray CT scans

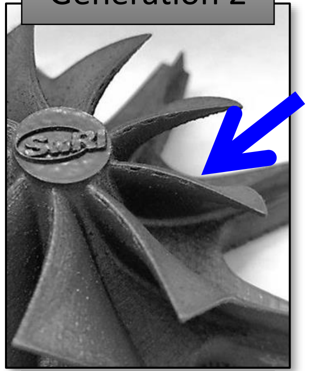


Print 2

Generation 1

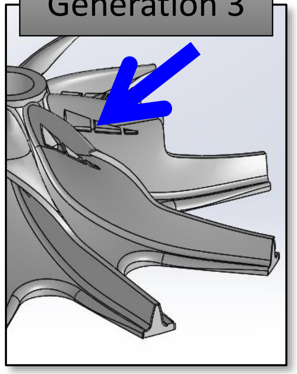
Print 4

Generation 2



Print 5

Generation 3



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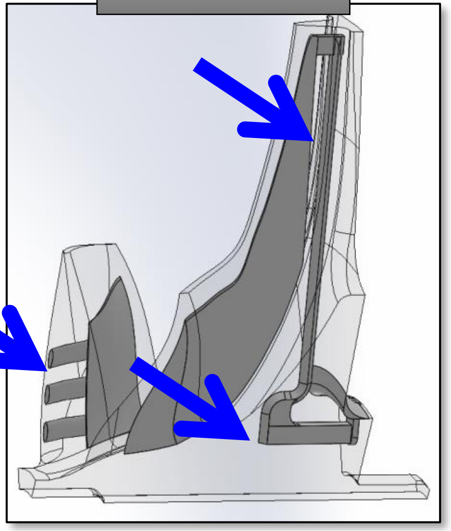
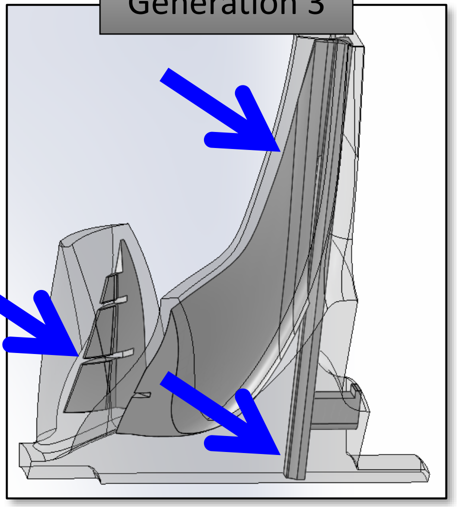
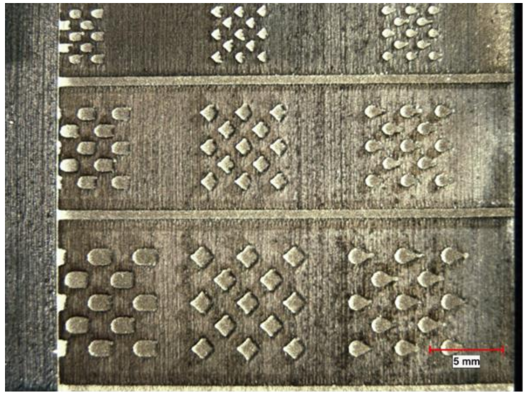
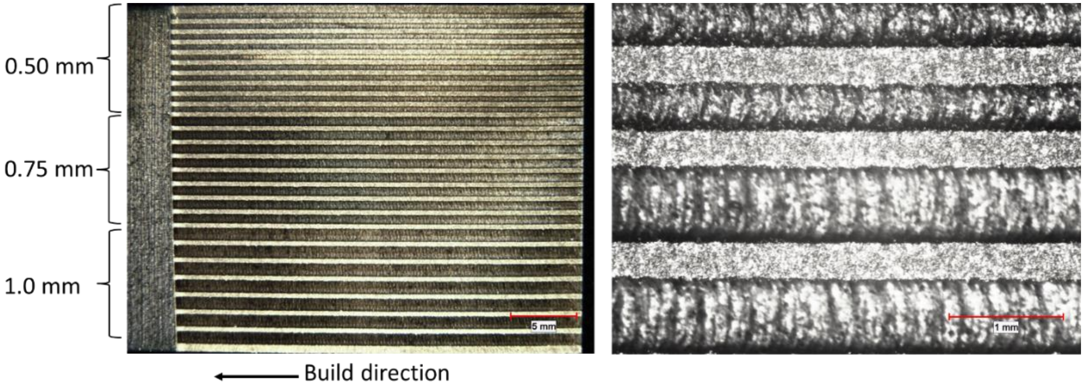


Generation 3

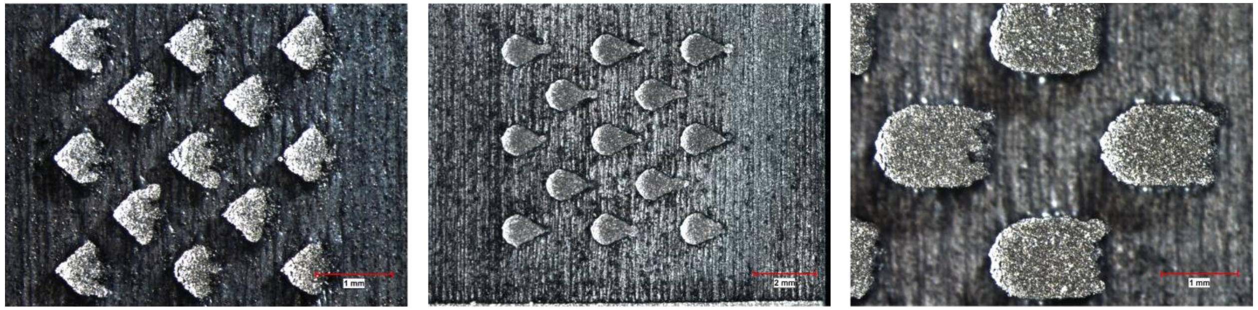


Improved powder remove processes revealed cleaner and more precise capabilities



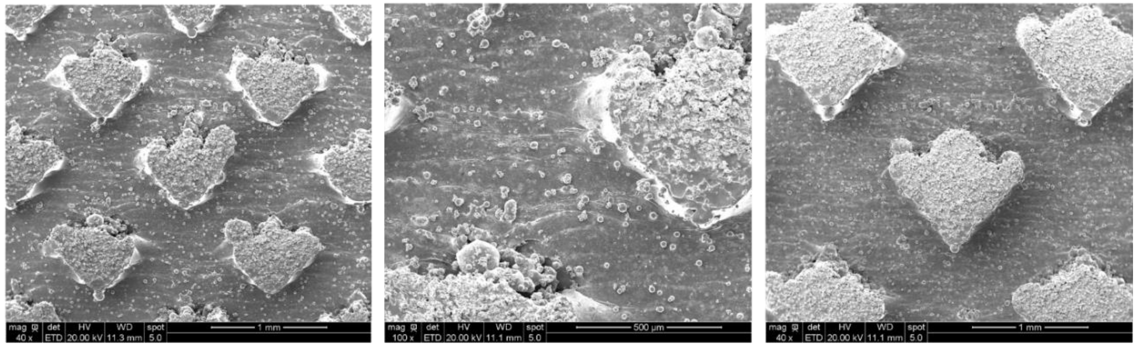


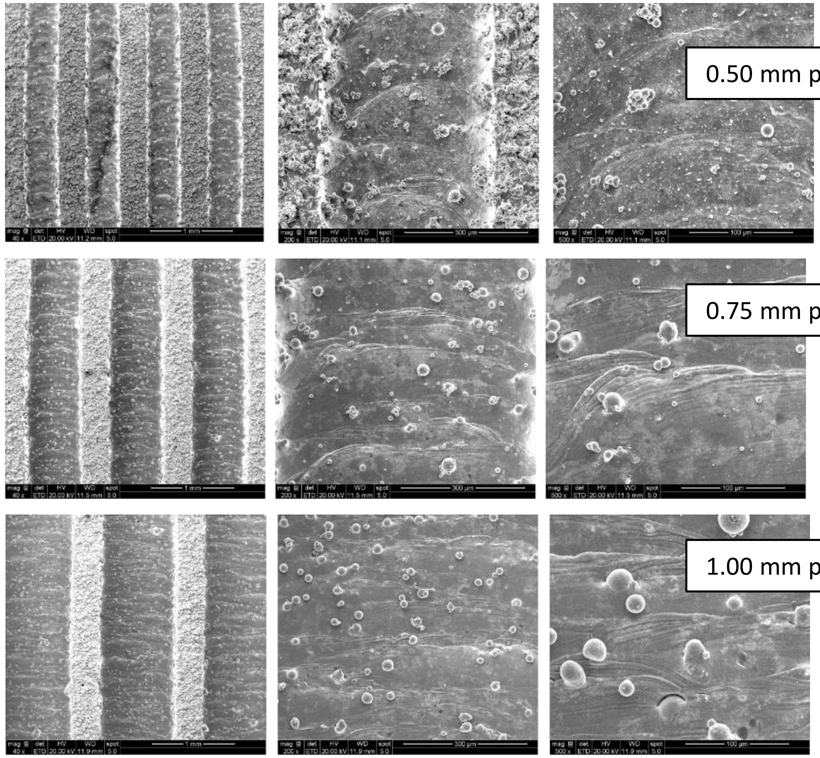
Build direction



Build direction

Build direction





0.50 mm passages

0.75 mm passages

1.00 mm passages

Print 5

Full impeller prints for first and final generation

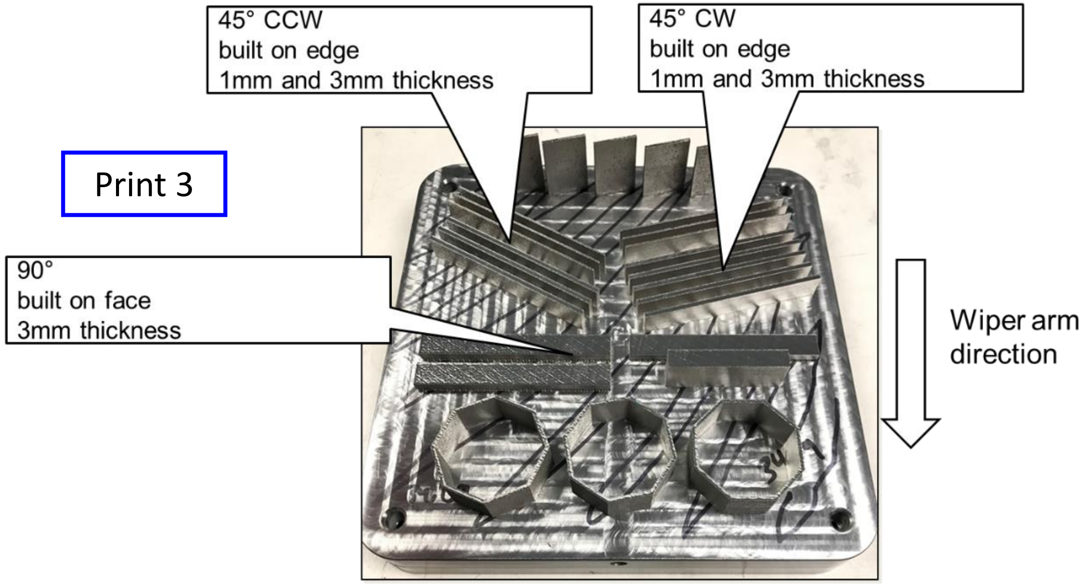
Print 4

Generation 2

Print 5

Generation 3

Material samples set #1 (Print 3): Two separate heat treatments and different build orientations studied

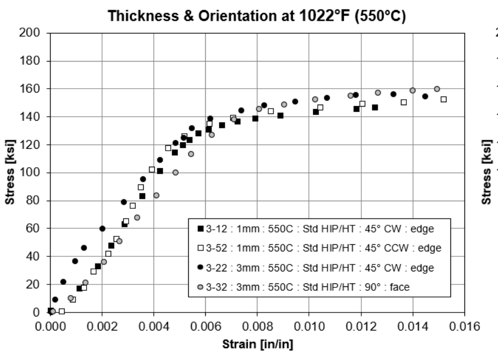


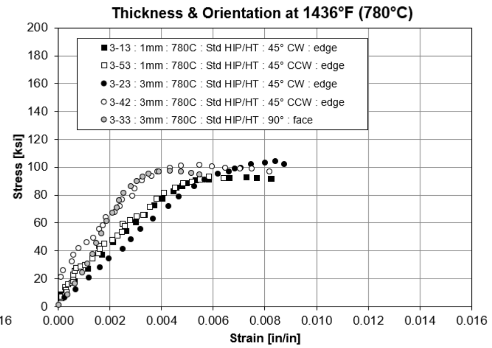
Process	#1	#2
Description	Combined HIP and Heat Treat	Separate HIP and Heat Treat
HIP Process	ASTM F3055-14a	ASTM F3055-14a
Heat Treat Application	Immediately following HIP at HIP vendor	AMS 5663N at second vendor
HIP process	>14.5 ksi @ 2050°F-2165°F ±25°F for 4h ±1h hold in inert atmosphere; Cool below 800°F	
Solution Heat Treat	1725°F-1850°F hold within ±25°F for time commensurate with cross-sectional thickness. Cool at a rate equivalent to air cool or faster.	
Aging Heat Treat	1325-1400°F ±15°F hold for 6 hours; Cool 100°F ±15°F per hour to 1150-1200°F; Hold ±15°F for 2 hours and air cool.	1325-1400°F ±15°F hold for 8 hours; Cool 100°F ±15°F per hour to 1150-1200°F; Hold ±15°F for 8 hours and air cool; May cool in furnace at any rate provided the time at 1150-1200°F is adjusted to give 18 hours total

ID #	Part Description
3-11	1mm thick tensile coupon, built on edge 45deg CW Rotation
3-12	1mm thick tensile coupon, built on edge 45deg CW Rotation
3-13	1mm thick tensile coupon, built on edge 45deg CW Rotation
3-21	3 mm thick tensile coupon, built on edge 45deg CW Rotation
3-22	3 mm thick tensile coupon, built on edge 45deg CW Rotation
3-23	3 mm thick tensile coupon, built on edge 45deg CW Rotation
3-31	3 mm thick tensile coupon, built on face No Rotation
3-32	3 mm thick tensile coupon, built on face No Rotation
3-33	3 mm thick tensile coupon, built on face No Rotation
3-41	3 mm thick tensile coupon, built on edge 45deg CCW Rotation
3-42	3 mm thick tensile coupon, built on edge 45deg CCW Rotation
3-43	3 mm thick tensile coupon, built on edge 45deg CCW Rotation
3-44	3 mm thick tensile coupon, built on edge 45deg CCW Rotation
3-45	3 mm thick tensile coupon, built on edge 45deg CCW Rotation
3-51	1mm thick tensile coupon, built on edge 45deg CCW Rotation
3-52	1mm thick tensile coupon, built on edge 45deg CCW Rotation
3-53	1mm thick tensile coupon, built on edge 45deg CCW Rotation

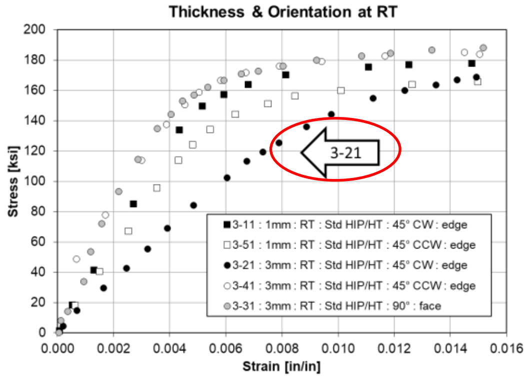
Orientations and heat treatments do show some sensitivity

17 total samples, at various orientations, temperature, and heat treat combinations.



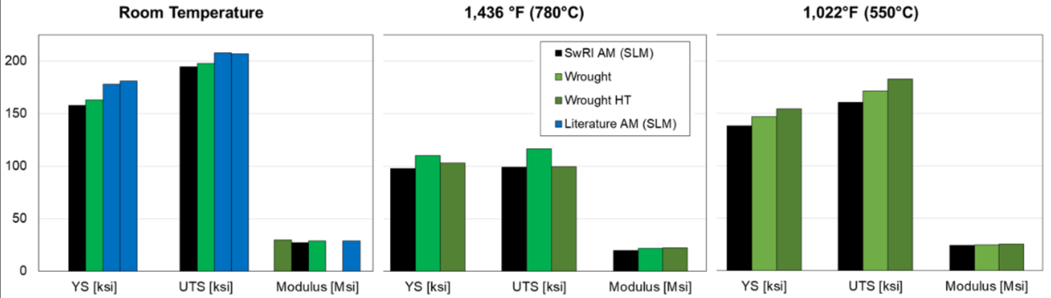


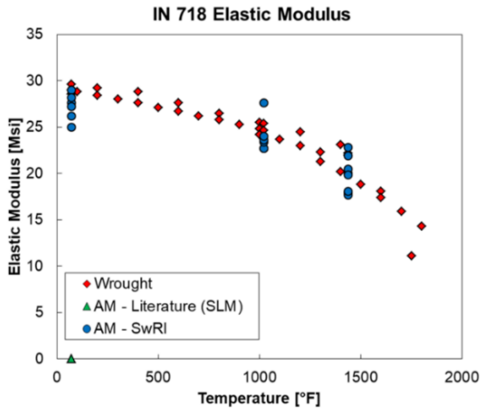
Effects of build orientation and thickness can be neglected at elevated temperatures.

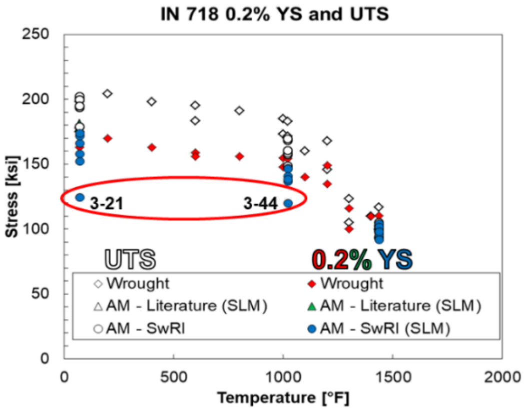


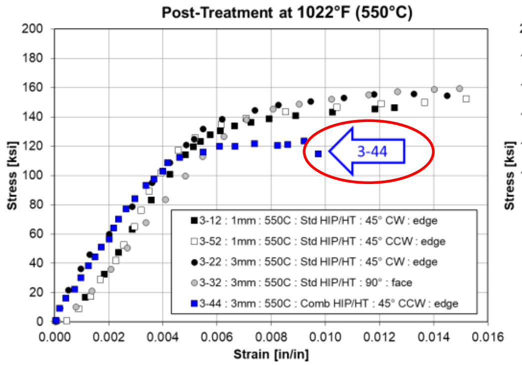
Room temperature properties inconclusive;

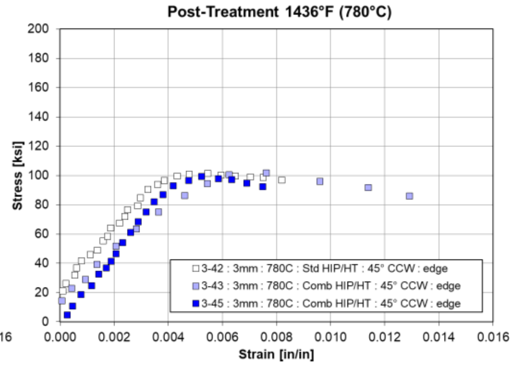
Coupon set #1 of AM printed materials are typically within 10% of wrought properties for all temperatures.









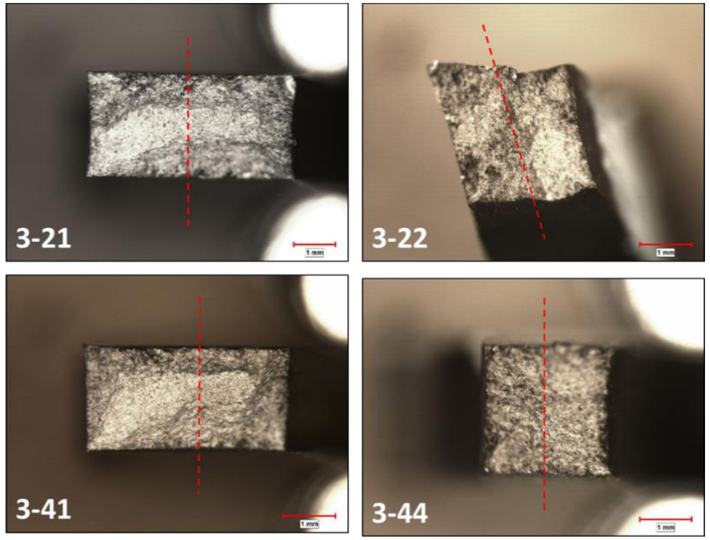


Print 3

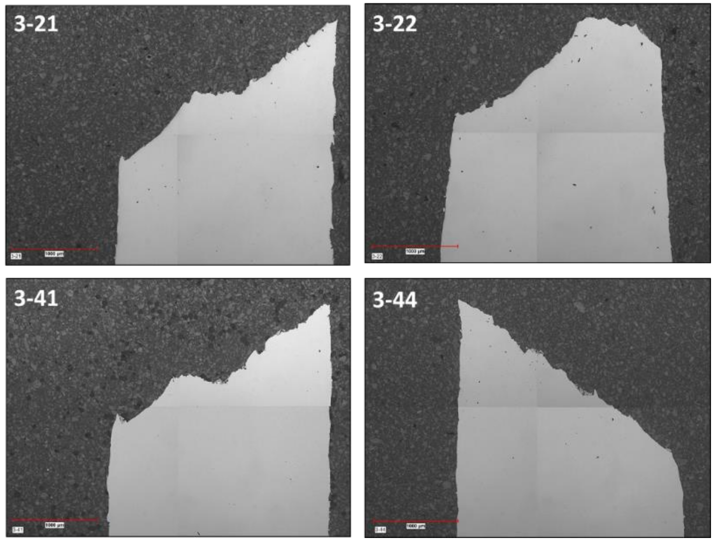
The effect of post-build HIP and heat treat is not conclusive because there appears to be a lower yield stress for the combined HIP and heat treat process at 1022°F, but similar material response at 1436°F.

More detailed investigation undertaken to understand anomalies

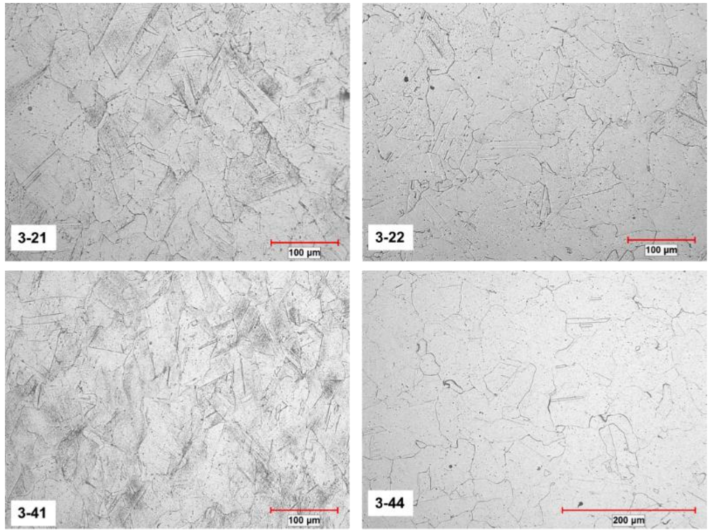
Additional investigations to examine anomalies



The specimens were sectioned at the fracture location for analysis.



3-41 has least porosity.

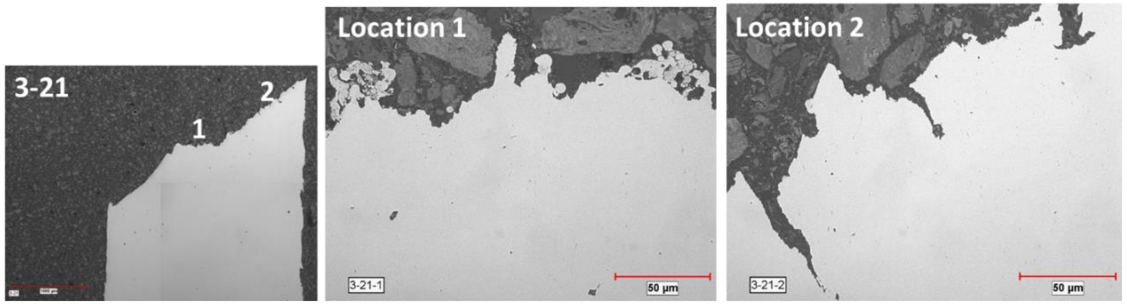


No significant differences in microstructure were observed in the specimens.

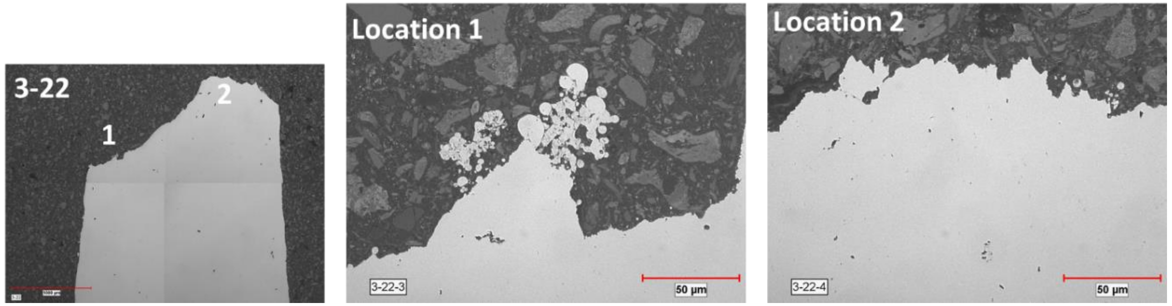
Print 3

Obtained Microhardness Values (HRC)				
Drop	Specimen			
	3-21	**3-22**	**3-41**	**3-44**
1	50.12	47.53	50.87	44.34
2	49.70	48.72	49.70	43.91
3	49.20	47.44	51.14	42.60
4	49.95	47.85	49.12	44.51
5	49.95	47.70	49.04	43.33
Average	**49.78**	**47.85**	**49.97**	**43.74**

Microhardness indicates <u>3-44 may have bulk property issues</u>.



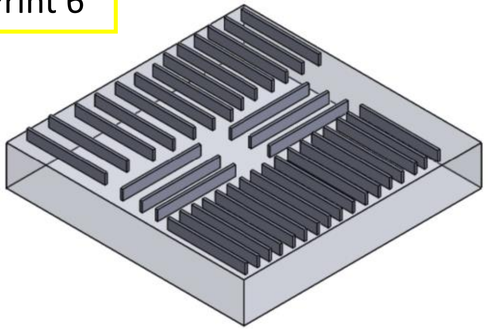
Specimen 3-21 exhibited areas of melting and partial fusion along the fracture surface. <u>Local effect may have caused failure.</u>

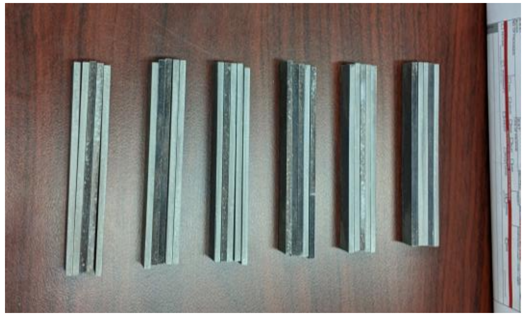


Enhanced images of the fracture surface of specimen 3-22, 3-44, and 3-41 did not indicate significant secondary cracking.

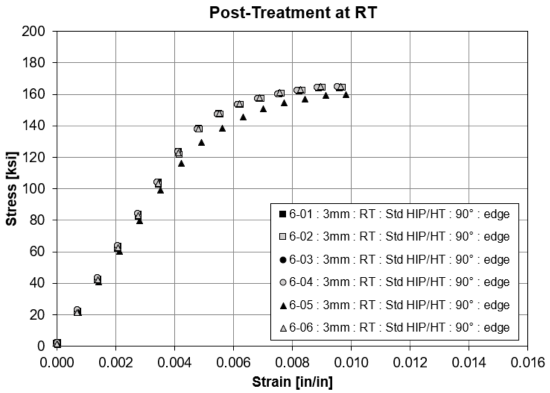
Material samples set #2 (Print 6): Additional tensile and some creep coupons

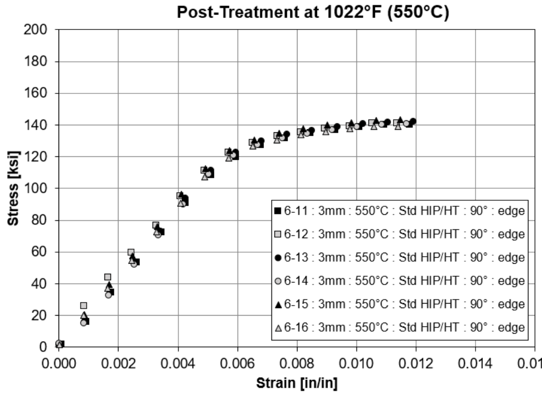
Print 6

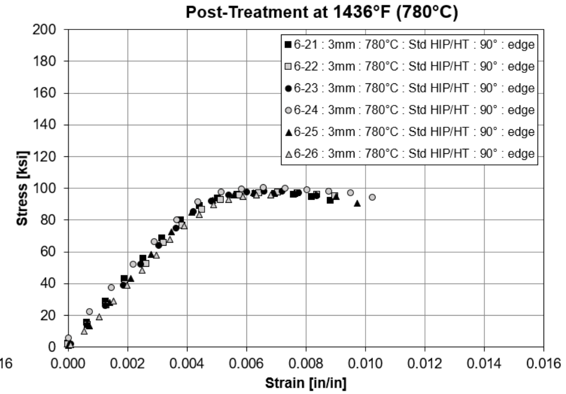


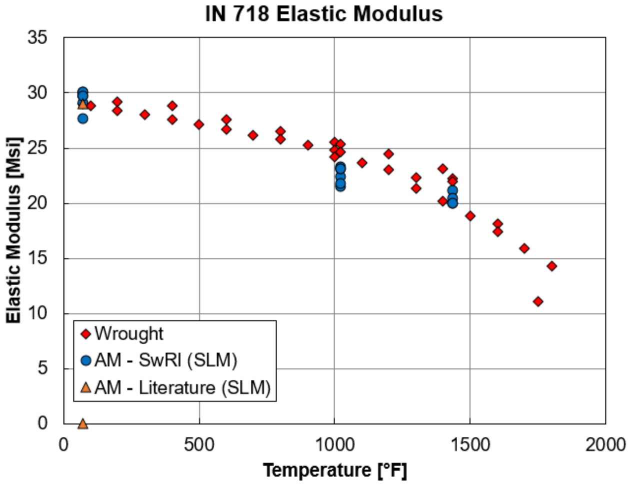


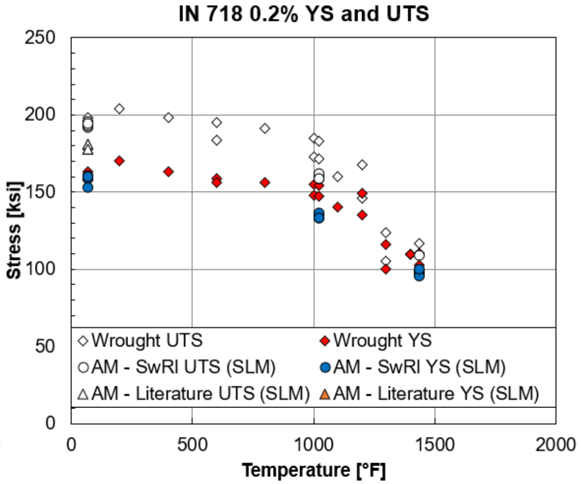
18 tensile coupons
12 creep coupons
All specimens were 3mm thick, built on their edge, at an angle of 90° from the wiper arm direction, and went through the separate HIP and heat treatment post processing operations.





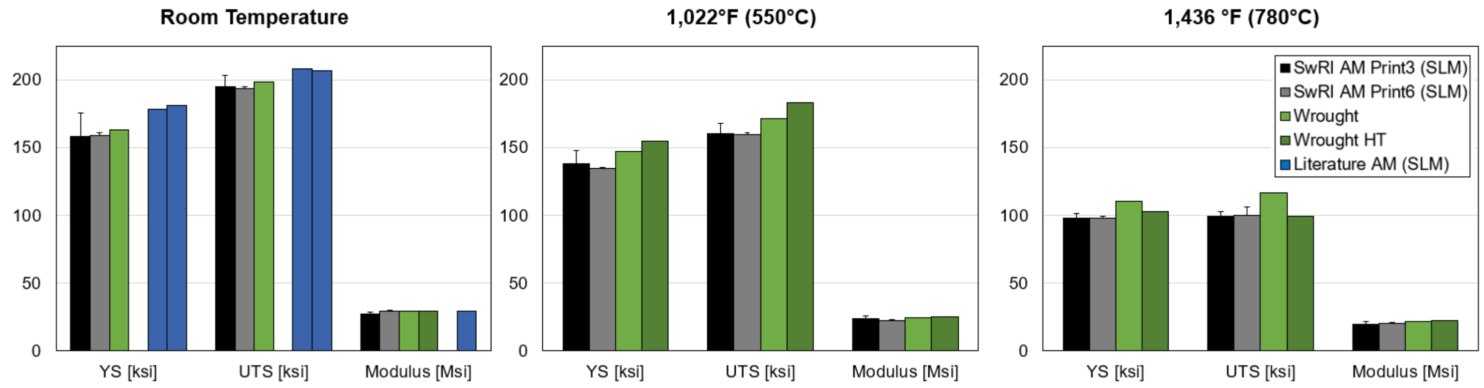






Final comparison of printed versus literature tensile data

Print 6



Comparison of SwRI AM Printed Materials To Published Properties

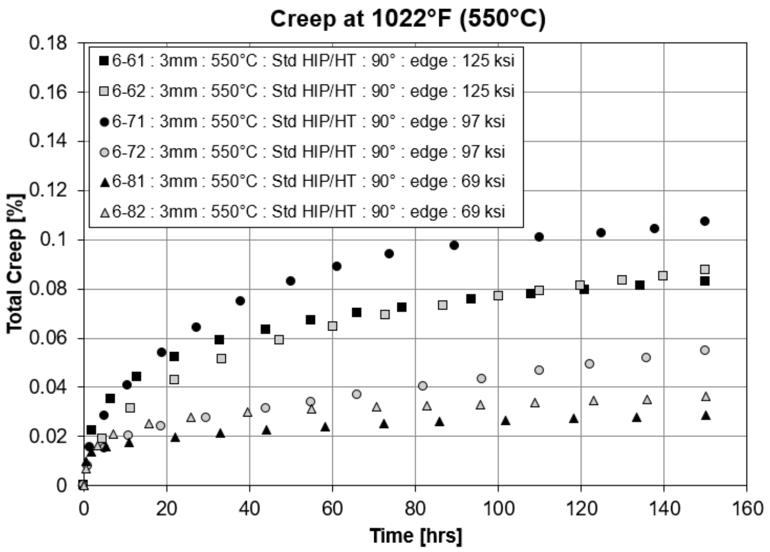
Temperature	Source	0.2% YS [ksi]	UTS [ksi]	Modulus of Elasticity [Msi]
Room Temperature	SwRI AM Print 3 (SLM)	157.88	194.94	27.20
	SwRI AM Print 6 (SLM)	158.58	193.80	29.42
	Wrought	163	198	29
	Literature AM (SLM)	178	208	N/A
	Literature AM (SLM)	181	207	29
1022°F (550°C)	SwRI AM Print 3 (SLM)	138.34	160.36	24.00
	SwRI AM Print 6 (SLM)	134.57	159.70	22.53
	Wrought	147.12	171.57	24.668
	Wrought HT	154.34	183.13	25.39
1436°F (780°C)	SwRI AM Print 3 (SLM)	97.90	99.14	19.84
	SwRI AM Print 6 (SLM)	97.65	100.05	20.40
	Wrought	110.24	116.84	21.94
	Wrought HT	102.98	99.56	22.2

References:

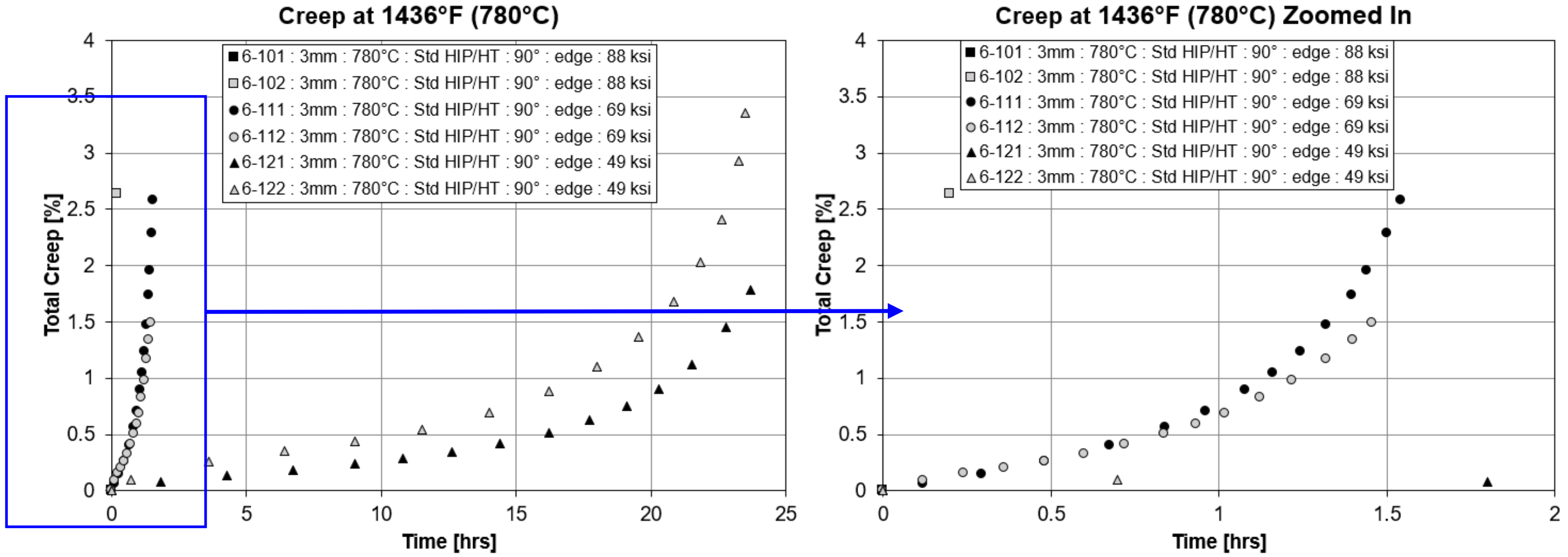
- "Inconel 718 Tech Data." Retrieved 11 December 2023. https://www.hightempmetals.com/techdata/hitempInconel718data.php
- Corporation, S. M., "Inconel Alloy 718," Publication Number SMC-045, New Hartford, NY, 2007.
- Deng, D., Peng, R. L., Brodin, H., and Moverare, J., "Microstructure and Mechanical Properties of Inconel 718 Produced by Selective Laser Melting: Sample Orientation Dependence and Effects of Post Heat Treatments," *Materials Science and Engineering: A*, Vol. 713, 2018, pp. 294–306.
- Strößner, J., Terock, M., and Glatzel, U., "Mechanical and Microstructural Investigation of Nickel-Based Superalloy IN718 Manufactured by Selective Laser Melting (SLM)," *Advanced Engineering Materials*, Vol. 17, No. 8, 2015, pp. 1099–1105.

Material samples set #2 (Print 6): Creep data

Print 6



No failures at 150 hours. Tests stopped.
6-71 unexpectedly high creep.



6-101 failed prematurely.

Rupture at similar times for coupons at same stress levels.

Total creep percentage varied temporally as observed in tests at same stress levels.

Don’t forget to update analysis predictions with the new data!

Print 2 → Print 3 → Print 5

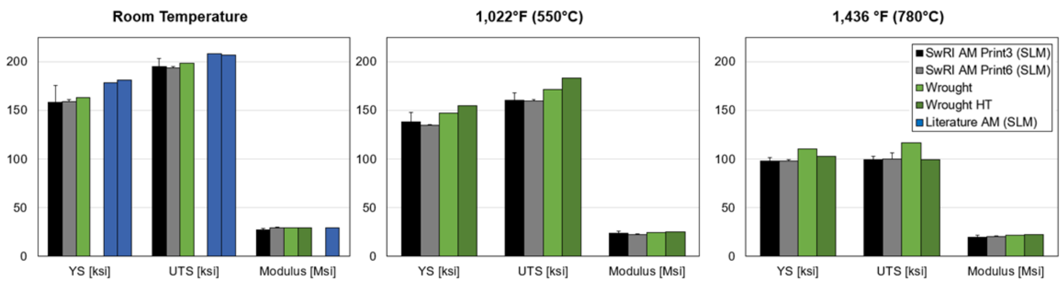


Table 4. Comparison of SwRI AM Printed Materials To Published Properties

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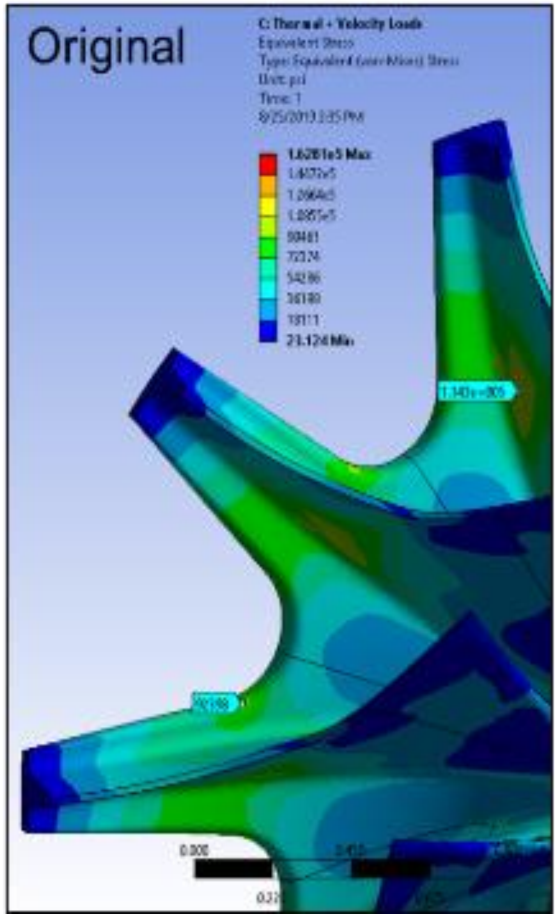
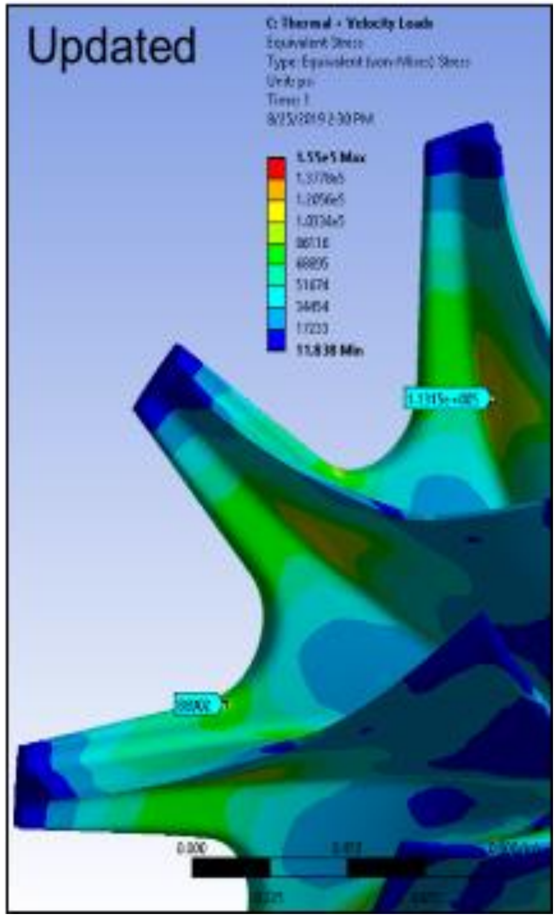
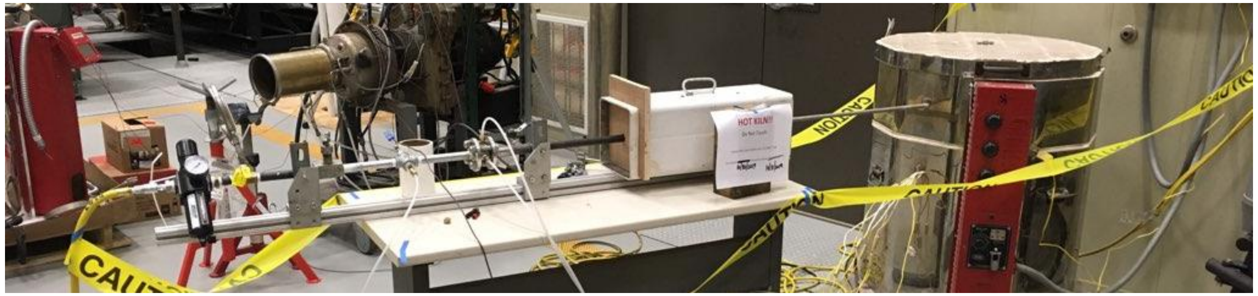




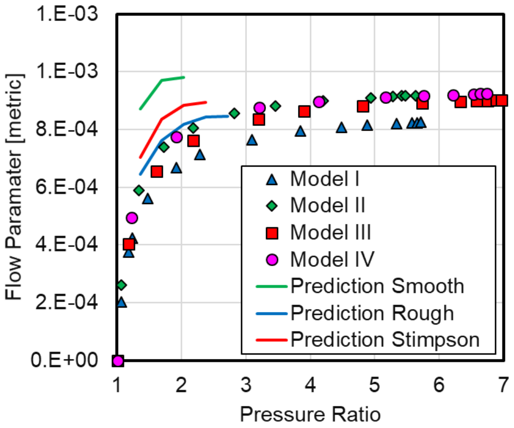
Application testing confirms form, fit and function

Print 5

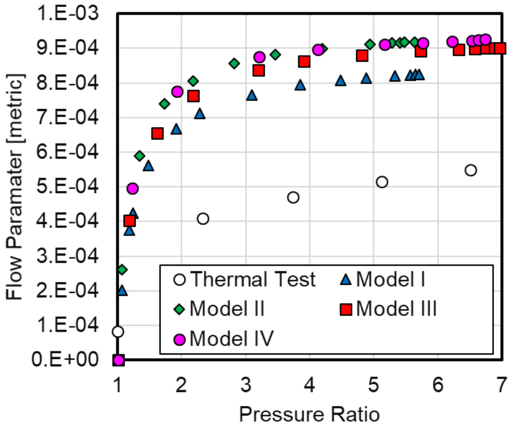


Flow rig set up for pressure drop testing and cooling testing, shown in series with kiln

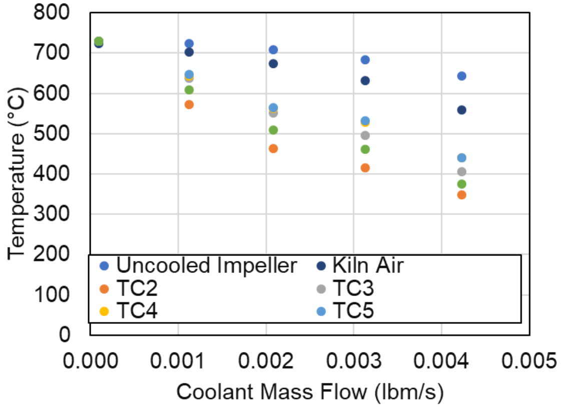
One impeller was cooled while the other impeller in the kiln served as a baseline.



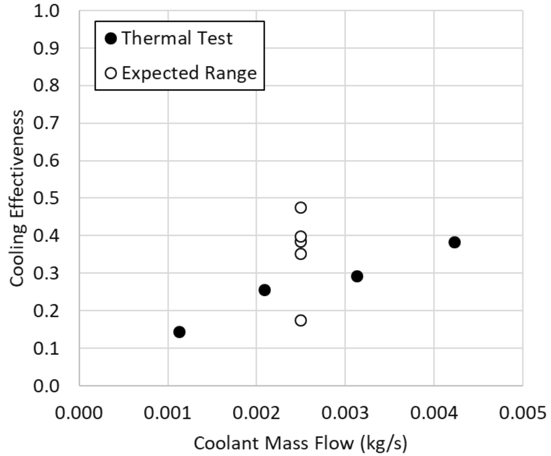
Impeller models II through IV had good flow agreement and all impeller tests indicated higher than expected surface roughness.



The flow in the thermal test was much lower than measurements recorded while the impellers were on the build plate.



Increasing the mass flow lowered the temperatures of both impellers, as expected.



The cooling effectiveness measured in the thermal test is within the expected range of the one-dimensional thermal design calculations.

Room temperature overspeed testing at 136,000 rpm (115% design) also passed without failure.

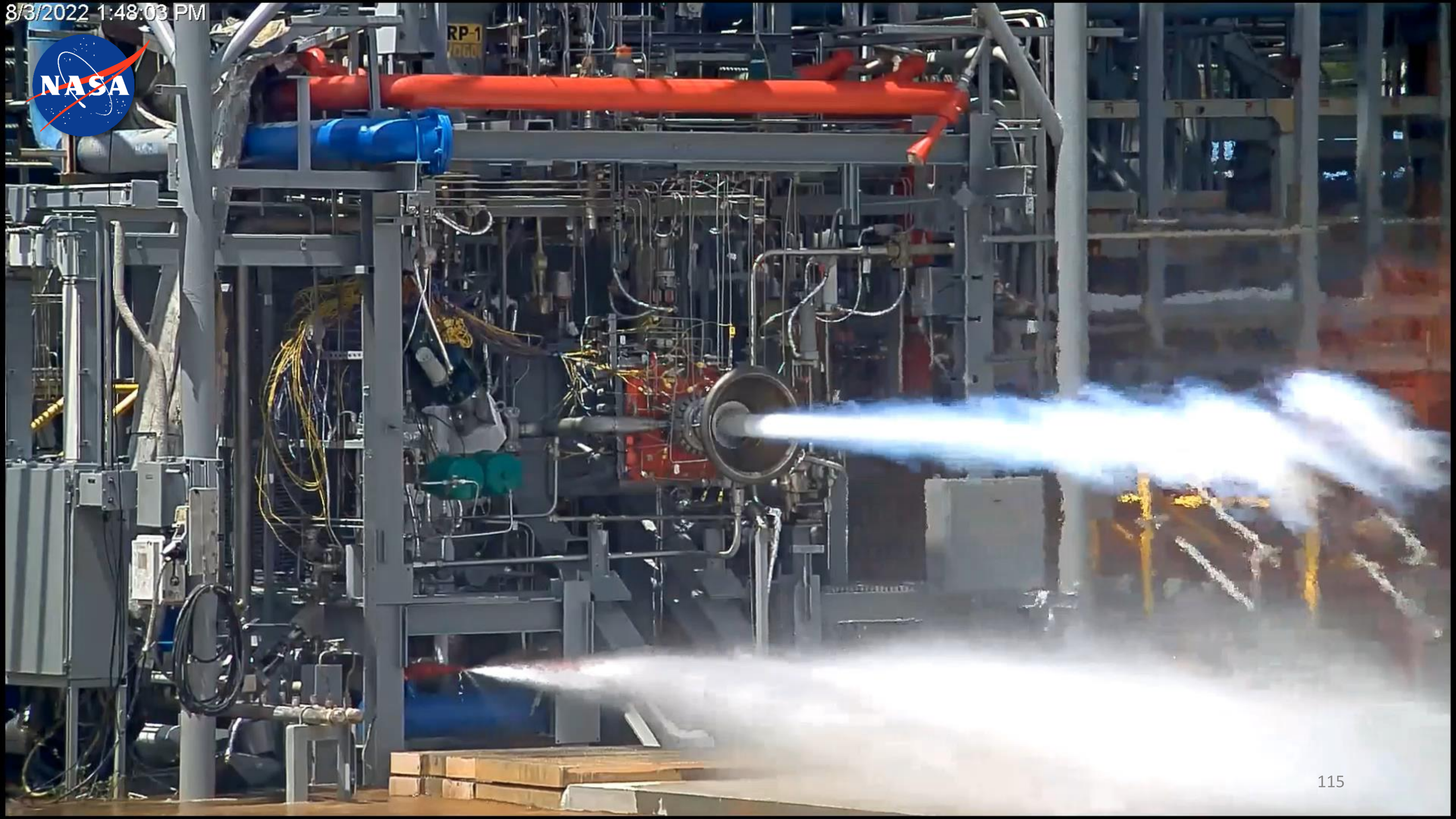
NASA led book on Metal Additive Manufacturing

https://arc.aiaa.org/doi/book/10.2514/4.106279

Online version and hardcopy available

P. R. Gradl, O. Mireles, C.S. Protz, C. Garcia. (2022). *Metal Additive Manufacturing for Propulsion Applications*. AIAA Progress in Astronautics and Aeronautics Book Series. https://arc.aiaa.org/doi/book/10.2514/4.106279

Additive manufacturing (AM) processes are proving to be a disruptive technology and are grabbing the attention of the propulsion industry. AM-related advancements in new industries, supply chains, design opportunities, and novel materials are increasing at a rapid pace. The goal of this text is to provide an overview of the practical concept-to-utilization lifecycle in AM for propulsion applications.


8/3/2022 1:48:03 PM
NASA
RP-1

Summary

- Various AM processes have matured for rocket propulsion applications each with unique advantages and disadvantages.
- AM is not a solve-all; consider trading with other manufacturing technologies and use only when it makes sense.
- **Complete understanding of the design process, build-process, feedstock, and post-processing is critical to take full advantage of AM.**
- Additive manufacturing takes practice!
- Standards and certification of the AM processes are in-work.
- AM is evolving and imagination is the limit.

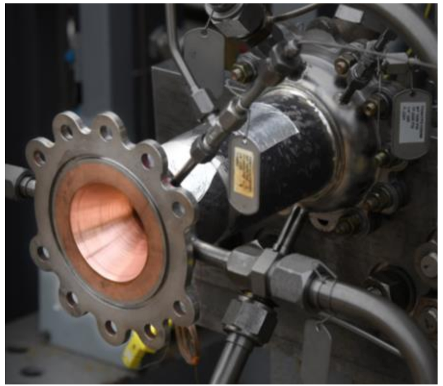


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Photo: NASA/Ben Smegelsky

Acknowledgements

- John Fikes
- Rapid Analysis and Manufacturing Propulsion Technology (RAMPT) Project
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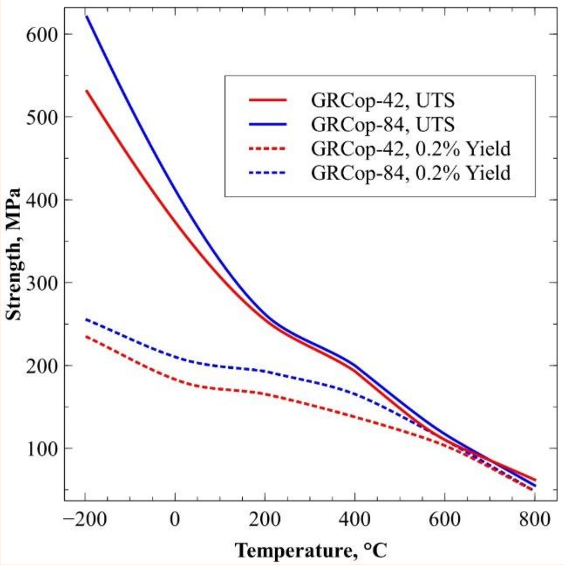
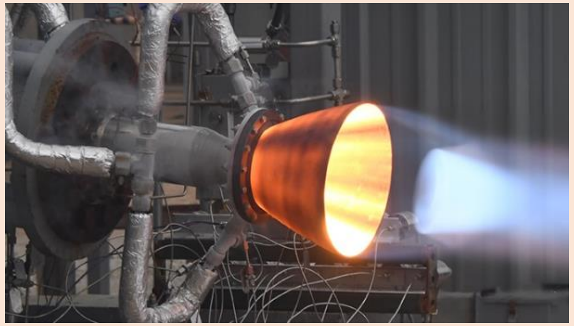
- Long Life Additive Manufacturing Assembly (LLAMA) Project
- Space Launch System (SLS) Program
- Nima Shamsaei
- Drew Hope
- Martin Annett
- Lynn Machamer
- RPM Innovations (RPMI)
- Tyler Blumenthal
- DM3D
- GE Research
- Bhaskar Dutta
- REM Surface Engineering
- Powder Alloy Corp
- AP&C
- Formalloy
- Auburn University (NCAME)
- Ben Williams
- Marissa Garcia
- Tim Smith / GRC
  Christopher Kantzos / GRC
- Tal Wammen
- Tom Teasley
- Scott Chartier
- Test Stand 115 crew
- Kevin Baker
- Matt Medders
- Adam Willis
- Nunley Strong
- Zach Taylor
- Matt Marsh
- Darren Tinker
- Dwight Goodman
- Will Brandsmeier
- Jonathan Nelson
- Bob Witbrodt
- Shawn Skinner
- Will Evans
- John Ivester
- Will Tilson
- Jim Lydon
- Brian West
- Gabe Demeneghi
- David Ellis / GRC
- Judy Schneider / UAH
- David Myers / MSFC EM21
- Scott Ragasa / MSFC EM21
- Sturbridge Metallurgical Services
- Product Evaluation Systems
- IMR Test Labs
- Robert Amaro / AMTT
- Ron Beshears
- James Walker
- Steve Wofford
- Johnny Heflin
- Mike Shadoan
  Keegan Jackson
- Many others in Industry, commercial space and academia

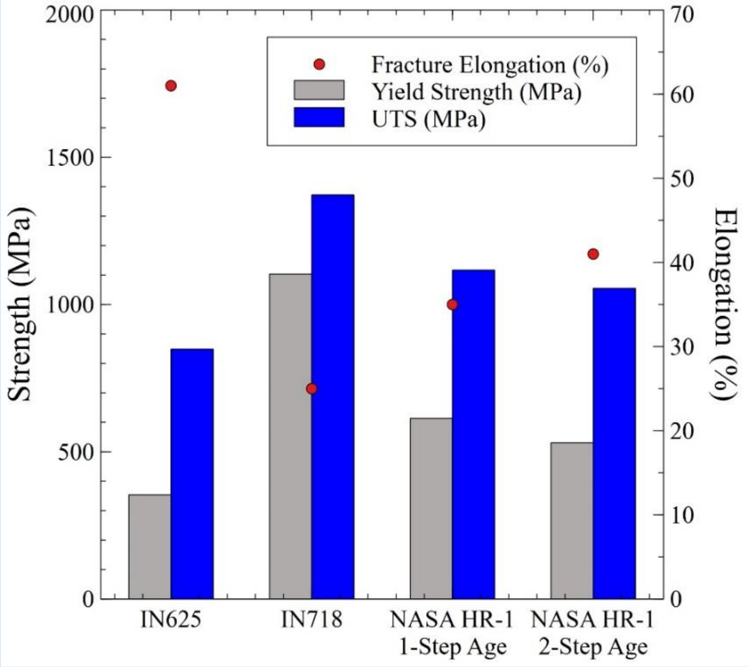
AM Enabling New Alloy Development

GRCop-42, High conductivity and strength for high heat flux applications

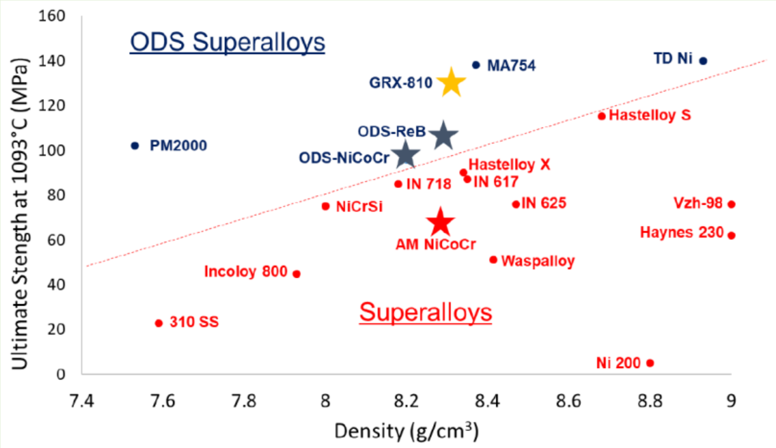




NASA HR-1, high strength superalloy for hydrogen environments



GRX-810, high strength, low creep rupture and oxidation at extreme temperatures



Ref: Tim Smith, Christopher Kantzos / NASA GRC