NASA OSMA NDE Program
Additive Manufacturing Foundational Effort

Jess Waller (NASA WSTF), James Walker (NASA MSFC), Eric Burke, (NASA LaRC), Douglas Wells (NASA MSFC), Charles Nichols (NASA WSTF)

NASA QUALITY ASSURANCE IN ADDITIVE MANUFACTURING (AM)
A WORKSHOP ON ASSURING AM PRODUCT INTEGRITY
October 11-12, 2016
Beckman Auditorium, California Institute of Technology, Pasadena CA

Approved for public release
Background

• NASA is providing key leadership in an international effort linking NASA and non-NASA resources to speed adoption of additive manufacturing (AM) to meet NASA’s mission goals. Participants include industry, NASA’s space partners, other government agencies, standards organizations and academia:

• Nondestructive Evaluation (NDE) is identified as a universal need for all aspects of additive manufacturing
Background

Contacts: Jess Waller (WSTF); James Walker (MSFC); Eric Burke (LaRC)

- NASA Agency additive manufacturing efforts were catalogued
- Industry, government and academia were asked to share their NDE experience in additive manufacturing
- NIST and USAF additive manufacturing roadmap were surveyed and a technology gap analysis performed
- NDE state-of-the-discipline was documented
Inconel Pogo-Z baffle for RS-25 engine for SLS

Reentrant Ti6-4 tube for a cryogenic thermal switch for the ASTRO-H Adiabatic Demagnetization Refrigerator

EBF\textsuperscript{3} wire-fed system during parabolic flight testing

28-element Inconel 625 fuel injector

Prototype titanium to niobium gradient rocket nozzle

Made in Space AMF on ISS

ISRU regolith structures

Aerojet Rocketdyne RL-10 engine thrust chamber assembly and injector

Dynetics/Aerojet Rocketdyne F-1B gas generator injector

SpaceX SuperDraco combustion chamber for Dragon V2
NDE of AM Technology Gaps

• Develop **in-process NDE** to improve feedback control, maximize part quality and consistency, and obtain ready-for-use certified parts
• Develop **post-process NDE** of finished parts
• Develop **voluntary consensus standards** for NDE of AM parts
• Develop better **physics-based process models** using and corroborated by NDE
• Use NDE to understand scatter in **design allowables database**
  generation activities (process-structure-property correlation)
• Fabricate AM **physical reference samples** to demonstrate NDE capability for specific defect types
• Apply NDE to **understand effect-of-defect**, and establish acceptance limits for specific defect types and defect sizes
• Develop **NDE-based qualification and certification protocols** for flight hardware (screen out critical defects)
Develop and Capture Best NDE Practice
NDE of AM Technology Gaps

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NDE-based AM Part Qualification & Certification

**Concept**

**in-process NDE**
- Design for Powder Bed Fusion
  - Build box limitations
  - Self-supporting design
  - Powder and Support removal
  - Finishing allowances
  - Surface texture requirements

- Structural Assessment
  - Material Properties

- Build Lot Execution
  - Platform selection
  - Reeater selection
  - Powder selection
  - Build parameters
  - Build data collection
  - Chamber environment
  - Restart policies
  - Post-build
  - Powder removal
  - Platform removal
  - Repair policies

**post-process NDE**
- Equipment
  - Calibration
  - Maintenance
  - Equipment Vendor
  - Software versions

**Model Quality**
- Integrity of solid
- Model checking
- Version control

**Model Processing**
- File formats
- Support integration
- Platform layout
- Part build orientation
- Lot acceptance

**Component Development Plan**
- Planning for all operations from Concept to Part
- Written prior to handoff from design to build

**NDT in-process**

**Hand-off From Design to Build**

**Build Vendor**
- Quality system
- Qualification

**Blend Lot**
- Chemistry
- Mixing
- Distribution

**Virgin Powder**
- Qual control spec
- Certification/analysis

**Recycled Powder**
- Sieving
- Environment control
- Re-use limitations

**Raw Part Inspection**
- Visual
- Radiography or CT
- Metallurgical
- Dimensional

**Thermal Processing**
- Part and lot acceptance articles
- Stress relief
- HIP
- Solution treat or anneal
- Precipitation age

**Finishing Operations**
- Machining
- Bead/girt blast
- Peening
- Honing/polishing
- Etching
- Cleaning

**Final Inspection/Acceptance**
- Dimensional
- Surface texture
- Final part PT, ET, UT, CT
- Lot acceptance test/result
- Process certification records

**Part**
United States and International AM Standardization Efforts

ASTM WK47031, NDE of metal parts used in aerospace applications (NASA leadership)
ASTM E07.10 WK47031 NDE of AM Guide
ISO TC 261 JG59 Best NDE Practice

• First defect catalogues to show defect ↔ NDE linkage
• Process method determines defects
• Defect type & part complexity determine NDE selection
49 current members

NASA, JAXA, ESA, NIST, USAF, GE Aviation, Boeing, Lockheed, Aerojet Rocketdyne, Honeywell, ULA and various AM and NDE community participants are represented
Coordinated by S. James (Aerojet Rocketdyne)

Electron Beam Freeform Fabrication (EBF³)
- Inconel 625 on copper
  - Ti-6Al-4V (4)
  - SS 316
  - Al 2216

Selective Laser Melting (SLM)
- Ti-6Al-4V bars
- Al-Si-10Mg dog bones
- Inconel 718 inserts (6) w/ different processing history
- Inconel 718 prisms for CT capability demonstration

Electron Beam Melting (EBM)
- SS 316 PT/RT panels w/ EDM notches

Characterized to date by various NDE techniques (CT, RT, PT, PCRT, and UT)
Identify Relevant Defects
## Background

While certain AM flaws (e.g., voids and porosity) can be characterized using existing standards for welded or cast parts, other AM flaws (layer, cross layer, unconsolidated and trapped powder) are unique to AM and new NDE methods are needed.

<table>
<thead>
<tr>
<th>Flaw type</th>
<th>Non-NDI</th>
<th>Common in DED &amp; PBF</th>
<th>Covered by current standards</th>
<th>Unique to AM</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>DED</strong></td>
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<tr>
<td>Poor surface finish</td>
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<tr>
<td>Porosity</td>
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<tr>
<td>Incomplete fusion</td>
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<tr>
<td>Lack of geometrical accuracy/steps in part</td>
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<tr>
<td>Undercuts</td>
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<tr>
<td>Non-uniform weld bead and fusion characteristic</td>
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<tr>
<td>Hole or void</td>
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<tr>
<td>Non-metallic inclusions</td>
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<tr>
<td>Cracking</td>
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<tr>
<td><strong>Unconsolidated powder</strong></td>
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<tr>
<td>Lack of geometrical accuracy/steps in part</td>
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<tr>
<td>Reduced mechanical properties</td>
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<tr>
<td>Inclusions</td>
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<tr>
<td>Void</td>
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<tr>
<td>Layer</td>
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<tr>
<td>Cross layer</td>
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<tr>
<td>Porosity</td>
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<tr>
<td>Poor surface finish</td>
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<tr>
<td><strong>Trapped powder</strong></td>
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Note: DED = Directed Energy Deposition, PBF = Powder Bed Fusion

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Typical PBF Defects of Interest

Also have unconsolidated powder, lack of geometrical accuracy/steps in the part, reduced mechanical properties, inclusions, gas porosity, voids, and poor or rough surface finish.
Typical PBF and DED Defects

Also interested in (gas) porosity and voids due to structural implications

Note: proposed new definitions in ISO/ASTM 52900 Terminology:

- **lack of fusion (LOF)**, \textit{n}—flaws caused by incomplete melting and cohesion between the deposited metal and previously deposited metal.
- **gas porosity**, \textit{n}—flaws formed during processing or subsequent post-processing that remain in the metal after it has cooled. Gas porosity occurs because most metals have dissolved gas in the melt which comes out of solution upon cooling to form empty pockets in the solidified material. Gas porosity on the surface can interfere with or preclude certain NDT methods, while porosity inside the part reduces strength in its vicinity. Like voids, gas porosity causes a part to be less than fully dense.
- **voids**, \textit{n}—flaws created during the build process that are empty or filled with partially or wholly un-sintered or un-fused powder or wire creating pockets. Voids are distinct from gas porosity, and are the result of lack of fusion and skipped layers parallel or perpendicular to the build direction. Voids occurring at a sufficient quantity, size and distribution inside a part can reduce its strength in their vicinity. Voids are also distinct from intentionally added open cells that reduce weight. Like gas porosity, voids cause a part to be less than fully dense.
NDE of AM Technology Gaps

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Demonstrate NDE capability

Conceptual Physical Reference Samples

Reference: ASTM E 1320 “Standard Reference Radiographs for Titanium Castings”

Multiuse Sample (MUS)

RT & PCRT Sample

ECT Sample

UT Sample

PT Sample

An AM panel has an EDM notched placed on one side, which is cycled to grow a through-crack for evaluation on the side opposite the notch, allowing evaluation of a tight crack on an as-built surface or the development/technical review of penetrant removal (high background issue).
### Demonstrate NDE capability

<table>
<thead>
<tr>
<th></th>
<th>MSFC-GRC</th>
<th>GSFC</th>
<th>LaRC</th>
<th>JSC-LaRC</th>
<th>KSC</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>AM process method</strong></td>
<td>DMLS</td>
<td>DMLS (metal), LS (plastic)</td>
<td>LS</td>
<td>EBF³</td>
<td>EBM</td>
</tr>
<tr>
<td><strong>alloys</strong></td>
<td>titanium, Inconel, and aluminum</td>
<td>titanium, SS PH1, vero-white RGD835</td>
<td>SS</td>
<td>titanium</td>
<td>titanium</td>
</tr>
<tr>
<td><strong>reference standard geometries</strong></td>
<td><img src="image1.png" alt="Image" /></td>
<td><img src="image2.png" alt="Image" /></td>
<td><img src="image3.png" alt="Image" /></td>
<td><img src="image4.png" alt="Image" /></td>
<td><img src="image5.png" alt="Image" /></td>
</tr>
<tr>
<td><strong>features interrogated</strong></td>
<td>complex geometries; large/thick/dense and very thin cross sections; (universal NDE standard, slabs, rods, gage blocks)</td>
<td>rectangular prisms, rows of cylinders, cylinders, flat-bottom holes, cone</td>
<td>steps, flat bottom holes</td>
<td>bead arrays, steps, holes</td>
<td>2nd iteration (AM): 36 printed in-holes beginning at surface; 9 printed in-spheres internal to the part; cold plate (future)</td>
</tr>
<tr>
<td><strong>AM defects interrogated</strong></td>
<td>porosity/unfused mat., (restart, skipped layers), cracks, FOD, geometric irregularities</td>
<td>hole roughness and flatness/centricity</td>
<td>porosity, lack of fusion</td>
<td>grain structure, natural flaws, residual stress, microstructure variation with EBF³ build parameters</td>
<td>internal unfused sections</td>
</tr>
<tr>
<td><strong>NDE method(s) targeted</strong></td>
<td>post-process 2 MeV and μCT; PT, RT, UT, ET</td>
<td>post-process ? MeV CT</td>
<td>post-process ? MeV CT</td>
<td>post-process UT, PAUT</td>
<td>in-process NDE, not UT</td>
</tr>
<tr>
<td><strong>Comments</strong></td>
<td>collaboration with MSFC AM Manufacturing Group &amp; Liquid Engines Office</td>
<td>flat IQI not suitable due to 3D CT artifacts</td>
<td>x-ray CT LS step wedge</td>
<td>Transmit-Receive Longitudinal (TRL) dual matrix arrays</td>
<td>collaboration with CSIRO</td>
</tr>
</tbody>
</table>
Understand Effect-of-Defect
NDE of AM Technology Gaps

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Determine effect-of-defect on sacrificial specimens with seeded flaws

**Airbus Laser Powder Bed Fusion (PBF) samples**

Investigate effect post-processing on microstructure and surface finish on fatigue properties

**Advratech Laser PBF samples** (in progress)

FY17 STTR T12.04-9941 Real-Time Geometric Analysis of Additive Manufacturing status (NASA MSFC) Develops a novel process control and part documentation solution for selective laser melting (SLM) additive manufacturing (DECLINED).

FY17 STTR T12.04-9979 Metal Digital Direct Manufacturing (MDDM) for Close-Out of Combustion Chambers and Nozzle Fabrications. Sub-scale and intermediate size nozzles will be fabricated using hybrid MDDM processes and delivered to the NASA-MSFC for hot fire testing (APPROVED)
Qualify & Certify NASA AM Hardware
NDE of AM Technology Gaps

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Background

Contact: Doug Wells (MSFC)

- Comprehensive draft technical standard is in review
- All Class A and B parts are expected to receive comprehensive NDE for surface and volumetric defects within the limitations of technique and part geometry
- Not clear that defect sizes from NASA-STD-5009§ are applicable to AM hardware
- NDE procedural details are still emerging

§NASA-STD-5009, Nondestructive Evaluation Requirements for Fracture-Critical Metallic Components
Background

Comprehensive NDE required for surface and volumetric defects

§ NASA classifications should not to be confused with those used in the ASTM International standards for AM parts, such as F3055 Standard Specification for Additive Manufacturing Nickel Alloy (UNS N07718) with Powder Bed Fusion. The ASTM classes are used to represent part processing only and are unrelated.
Qualification & Certification

• It is incumbent upon the structural assessment community to define critical initial flaw sizes (CIFS) for the AM part to define the objectives of the NDE.

• Knowledge of the CIFS for AM parts will allow the NDE and fracture control communities to evaluate risks and make recommendations regarding the acceptability of risk.

• CIFS defects shall be detected at the accepted probability of detection (POD), e.g., 90/95, for fracture critical applications.

• Demonstration of adequate part life starting from NASA-STD-5009 flaw sizes is generally inappropriate for fracture critical, damage tolerant AM parts.

• It is recognized that parts with high AM Risk may have regions inaccessible to NDE. To understand these risks it is important to identify the inaccessible region along with the CIFS.
Qualification & Certification

- Parts with low AM risk should exhibit much greater coverage for reliable NDE.
- Multiple NDE techniques may be required to achieve full coverage.
- Surface inspection techniques (PT, ECT, UT) may require the as-built surface be improved to render a successful inspection, depending upon the defect sizes of interest and the S/N ratio.
- For PT, surfaces improved using machining, for example, require etching prior to inspection to remove smeared metal.
  - Removal of the as-built AM surface to a level of visually smooth may be insufficient to reduce the NDE noise floor due to near-surface porosity and boundary artifacts.
- NDE demonstration parts with simulated CIFS defects are used to demonstrate NDE detection capability.
- NDE standard defect classes for welds and castings welding or casting defect quality standards will generally not be applicable.
Qualification & Certification

- Relevant AM process defect types used must be considered.
- AM processes tend to prohibit volumetric defects with significant height in the build (Z) direction. The concern instead is for planar defects, such as aligned or chained porosity or even laminar cracks, that form along the build plane. The implications of this are:
  - planar defects are well suited for growth
  - planar defects generally have low contained volume
  - the orientation of defects of concern must known before inspection, especially when detection sensitivity depends on the defect orientation relative to the inspection direction
  - the Z-height of planar defects can be demanding on incremental step inspection methods such as CT
- Until an AM defects catalog and associated NDE detection limits for AM defects are established, NDE acceptance criteria shall be for part-specific point designs.
Determine Rejection Thresholds for Critical Defects
December 18, 2016

TO: Members of Committees E08, E07 and F42

SAVE THE DATE

Round Table Discussion: Mechanical Behavior of Additive Manufactured Components
May 5, 2016
San Antonio, TX

About the Event
A Round Table Discussion on Mechanical Behavior of Additive Manufactured Components will be held Thursday, May 5, 2016 and is sponsored by ASTM Committee E08 on Fatigue and Fracture in conjunction with F42 on Additive Manufacturing Technologies and E07 on Nondestructive. The discussion will be held at the Grand Hyatt San Antonio in San Antonio, TX, in conjunction with the May standards development meetings of the committee.

The Round Table Discussion is a supplement to the Workshop on Mechanical Behavior of Additive Components and will provide a forum for the exchange of ideas regarding the mechanical behavior of components fabricated using additive manufacturing, with a focus on the development of fatigue related standards for additive manufacturing.

For more information please visit: [http://www.astm.org/E08RTD5-2016](http://www.astm.org/E08RTD5-2016)

If you have any questions, please contact me by reply.

Hannah Sparks
Administrative Assistant, Symposia Operations

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tel +1.610.832.9677

Address:
• Fracture & fatigue of AM parts
• AM parts used in fracture critical applications
• Critical flaw size for AM defects
Current NASA Efforts Related to NDE of Additive Manufacturing
FY16 Continuing Projects

- An Assessment of NDE Capability and Materials Characterization for Complex Additive Manufacturing Aerospace Components (Walker, Martin)
- Investigation of NDE Flaw Detectability in AM Parts (Koshti, Stanley, Taminger, Hafley, Brice, Burke)
- X-ray Computed Tomography Image Quality Indicator Development (Jones, Fischetti, Kent)
- KSC Foundational Methodology for Additive Manuf. – Electron Beam Melting NDE (Skow)
- Evaluation of Additively Manufactured Metals for use in Oxygen Systems (Tylka)
- NDE of Aerospace Parts (including Additive Manufactured) Voluntary Consensus Organization Standards and Related Round-Robin Tests (Waller, Nichols)
FY17 New Starts

- A Quantitative Assessment of NDE Capability on Additive Manufactured (Selective Laser Melting) Inconel 718 (Walker, Martin)

Additive Manufacturing Structural Integrity Initiative (AMSII)

- Involves the characterization of defect structures of selective laser melting (SLM) Inconel® 718 material within the nominal process window and its limits, build test articles for NDE studies and correlation with destructive test results
- Relevance to parts made for Commercial Crew Program (CCP), Space Launch System (SLS) and Multipurpose Crew Vehicle (MPCV)
America Makes/ANSI
Additive Manufacturing
Standardization Collaborative
(AMSC)

Below is the evolving list of WGs and their co-chairs, and issues that they will be addressing in terms of identifying existing or needed standards and specifications. Participants are invited to sign up for one or more groups using the sign-up sheet. The working groups are holding online meetings every two weeks. (Note: Specific meeting times should be confirmed with ANSI as recurring meeting times listed below are subject to change on specific dates when there are holidays or other conflicts that may necessitate re-scheduling.)

**Design WG**
Meets: Every other Tuesday, 10-11:30 am Eastern, beginning May 10, 2016  
Co-chairs: John Schmelzle, NAVAIR, and Jayanthi Parthasarathy, MedCAD

Input (Design guides, Design intent)  
Designing parts (Design tools, Simulation and modeling, Design for assemblies)  
Design documentation (Neutral build file, Product definition data sets)  
Validation

**Process and Materials WG**
Meets: Every 4th Tuesday, 11 am – 12 noon Eastern, beginning May 24, 2016  
Co-chairs: Todd Rockstrom, GE Aviation, and Art Kracke, AAK Consulting LLC  
* All members are asked to join one of the 4 Subgroups (SG)

Future State: Left to Right Enabling Commercialized AM products
America Makes & ANSI Additive Manufacturing Standardization Collaborative (AMSC)

Working Group (WG) Architecture and Co-Chairs
(updated 5/13/16)

**Precursor Materials SG**
Meets: Every other Tuesday, 1-2 pm Eastern, beginning May 3, 2016
Leader: Jim Adams, MPIF

- Chemistry
- Cleanliness
- Feed stock
- Characterization
- Safety & Training
- OEM process & control

**Process Control SG**
Meets: Every other Thursday, 1-2 pm Eastern, beginning May 5, 2016
Leader: TBD

- Equipment
- Digital format
- Calibration
- Parameter control
- Powder handling
- Powder reuse/recycle
- Operator training
- Safety
- Machine qualification

**Post-Processing SG**
Meets: Every other Tuesday, 1-2 pm Eastern, beginning May 10, 2016
Leader: Patrick Ryan, L5 Management

- Heat Treat
- HIP
- Surface finishing
- Machining
- Hybrid machines
- Removal of Support Materials

**Finished Materials SG**
Meets: Every other Thursday, 1-2 pm Eastern, beginning May 12, 2016
Leader: TBD

- Design allowables
- Component testing
- Component certification
- Microstructure
- Chemistry
- Mechanical properties
- Cleanliness
- Bio-compatibility
- Quality control

**Qualification & Certification (Q&C) WG**
Meets: Every other Monday, 2:30 – 4 pm Eastern, beginning May 9, 2016
Co-chairs: Armen Kurdian, U.S. Navy, and Shawn Moylan, NIST

Ensure that all stages of a particular AM process have commonly understood standards to enable Qualification
(Qualification is defined as ensuring suitability to meet functional requirements in a repeatable manner)
Ensure that AMSC WGs have adequate representation from industry & government
Generate checklists for all aspects of AM (variability, repeatability, suitability, etc.)
America Makes & ANSI Additive Manufacturing Standardization Collaborative (AMSC)

Working Group (WG) Architecture and Co-Chairs
(updated 5/13/16)

Non-Destructive Evaluation (NDE) WG
Meets: First Meeting May 20, 2016 at 1 pm Eastern
Co-chairs: TBD

Scope: NDE of Finished Parts
Test methods or best practice guides for NDE of AM parts
Common defects found in AM parts and Probability of Detection (PoD) assessments of NDE techniques
Test samples for PoD or NDE technique performance evaluation
Geometry and surface texture measurement techniques (especially for internal features)
Gaps in current NDT methods
AM defects terminology
Intentionally seeding AM flaws

Maintenance WG
Meets: Every other Monday 2-3:30 pm Eastern, beginning May 16, 2016
Co-chairs: David Coyle, NAVSUP WSS, and Michele Hanna, Lockheed Martin

Scope: Maintenance of parts and machines
Standard repair procedures for parts and tooling
Standard inspection processes
Model based inspection
Questions?

THIS IS ONLY THE BEGINNING
Back-ups
Key Documents Driving the Improved Safety and Reliability of AM Parts

NASA AM Foundational Effort

Technological Acceptance and Increased Utilization
NIST Roadmap

Contact: Kevin Jurrens (NIST)
- Technology challenges impede widespread adoption of AM
- Measurement and monitoring techniques, including NDE, cut across all aspects of AM, from input materials to processing to finished parts
- Ways to fully characterize AM parts, including NDE, are needed to insure processing effectiveness and part repeatability (part certification)
- NASA participation
  - Matt Showalter, GSFC
  - Karen Taminger, LaRC
  - Gary Wainwright, LaRC
  - Nancy Tolliver, MSFC
Effect of Design Complexity on NDE

Contact: Evgueni Todorov (EWI)
• Great initial handling of NDE of AM parts
• Report has a ranking system based on geometric complexity of AM parts to direct NDE efforts
• Early results on NDE application to AM are documented
• Approach for future work based on CT and PCRT
Effect of Design Complexity on NDE

Most NDE techniques can be used for Complexity Groups§ 1 (Simple Tools and Components) and 2 (Optimized Standard Parts), some for Group 3 (Embedded Features); only Process Compensated Resonance Testing and Computed Tomography can be used for Groups 4 (Design-to-Constraint Parts) and 5 (Free-Form Lattice Structures):

Background

NDE options for design-to-constraint parts and lattice structures: LT, PCRT and CT/μCT

### Table

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<thead>
<tr>
<th>NDE Technique</th>
<th>1</th>
<th>2</th>
<th>3</th>
<th>4</th>
<th>5</th>
<th>Comments</th>
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<td>VT</td>
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<td>Screening; size restrictions (e.g., compressor blades)</td>
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Key:
- Y = Yes, technique applicable
- P = Possible to apply technique given correct conditions
- NA = Technique Not applicable

Notes:
- (a) Only surfaces providing good access for application and cleaning
- (b) Areas where shadowing of acoustic beam is not an issue
- (c) External surfaces and internal surfaces where access through conduits or guides can be provided
- (d) Areas where large number of exposures/shots are not required

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