Material
Data Sheet

EOS Maraging-Steel MS1

Ultra high strength tooling grade maraging steel

ECOPARTS
ADDITIVE METAL SOLUTIONS

EOS MaragingSteel MS1

EOS MaragingSteel MS1 is an ultra high strength tooling grade maraging steel. Its excellent properties are enabled by forming intermetallic phases and precipitates in heat treatment. It's nickel, cobalt, molybdenum and titanium alloying results in an excellent material for additive manufac- turing and provide low distortion and balanced properties. The properties enable successful use in diverse applications including injection molding and cold and hot working.

Main Characteristics:

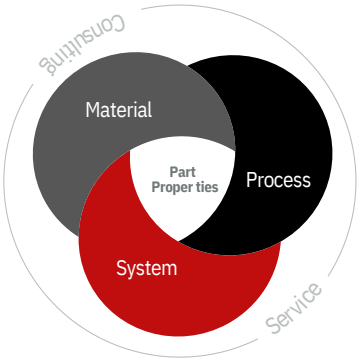
- → Ultra high strength and hardness
- → Properties adjustable with different heat treatment
- → Low distortions
- → Good machinability

Typical Applications:

- → Plastic injection molding
- → Extrusion tools
- → Hot pressing tools

The EOS Quality Triangle

EOS uses an approach that is unique in the AM industry, taking each of the three central technical elements of the production process into account: the system, the material and the process – together simply described as the Quality Triangle. EOS focuses on delivering reproducible part properties for the customer.



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

Powder Properties

The chemicalal composition of EOS MaragingSteel MS1 corresponds to AMS6514 18Ni300 maraging steel standard.

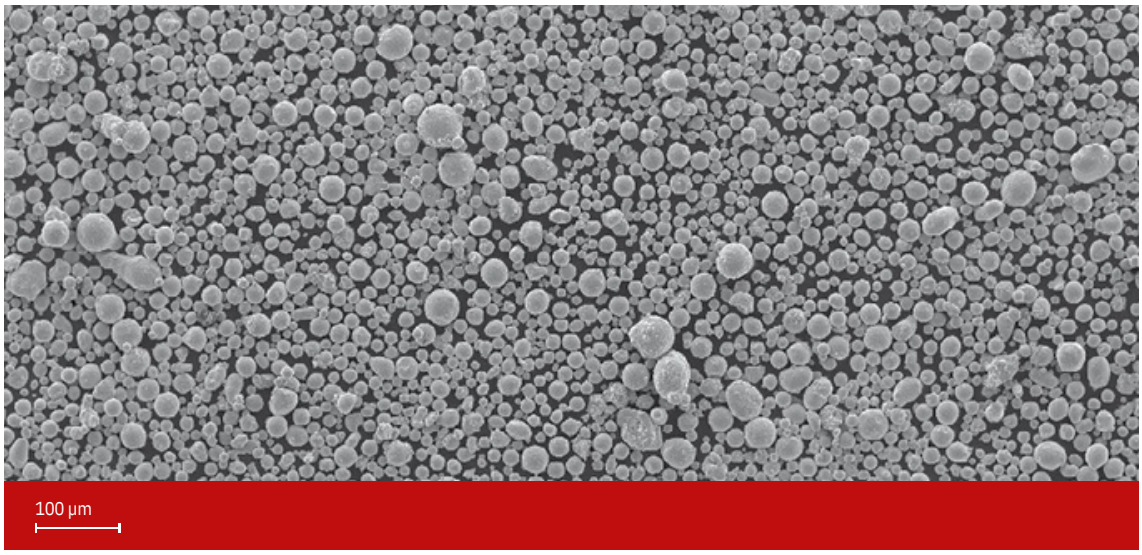
Powder chemical composition (wt.-%)

Element	Min.	Max.
Fe	Balance	
Ni	17.00	19.00
Co	8.50	9.50
Mo	4.50	5.20
Ti	0.60	0.80
Al	0.05	0.15

Powder particle size

Generic particle size distribution	15 – 65 µm

SEM picture of
EOS MaragingSteel MS1 powder.

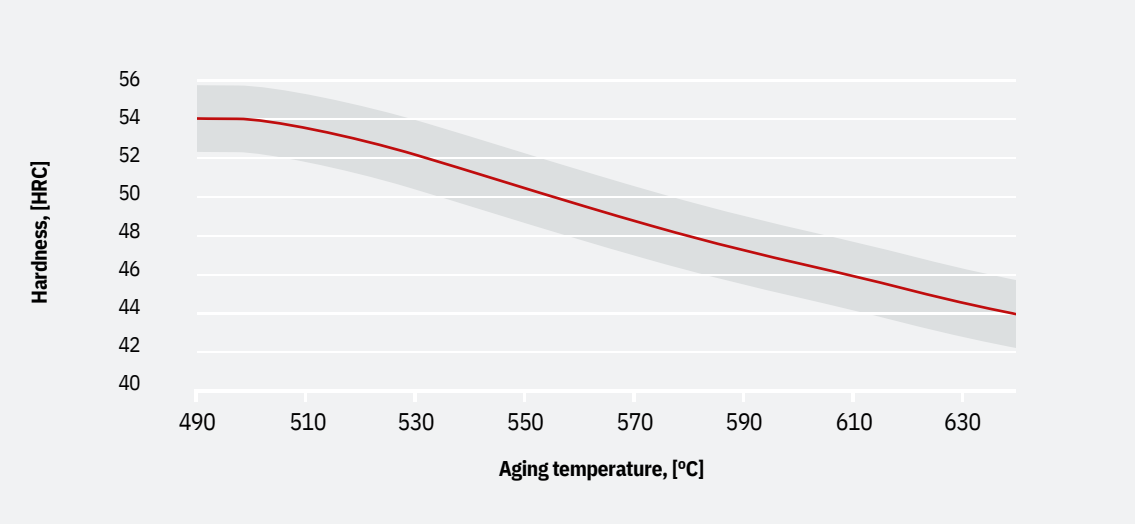


Heat Treatment

EOS MaragingSteel can be heat treated to match various needs of different applications. The two step heat treatment can be performed under vacuum or inert gas atmosphere. First step is solution annealing to minimize amount of austenite in the martensitic matrix.The need- ed hardness and strength is achieved through aging treatment where hardening takes place through forming of intermetallic phases and precipitates.

Solution annealing: 2 h at 940 °C (±10 °C) measured from the part followed by rapid air cooling to room tempera- ture (below 32 °C). Cooling rate 5-60 °C/min. Reaching room temperature before starting aging treatment is required to achieve desired microstructure.

Aging: For peak hardness of 54 HRC age 6 h at 490 °C (±10 °C) measured from the part followed by air cooling. Mechanical properties presented in this document achieved through this aging procedure. For lower hard- ness and strength choose aging temperature according to the graph below



Rockwell C hardness according to ISO 6508

Coefficient of Thermal Expansion ASTM E228

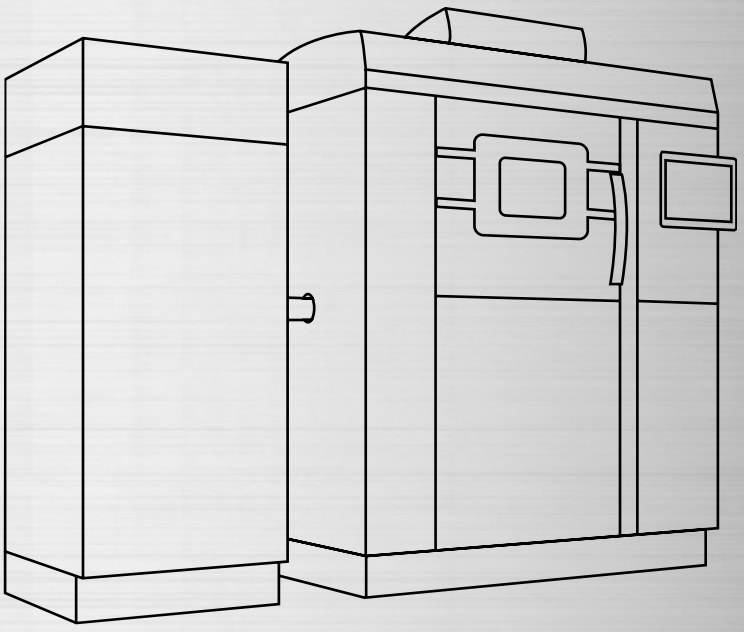
Temperature	25-100 °C	25-200 °C	25-300 °C	25-400 °C
CTE	10.6 *10-6/K	10.9*10-6/K	11.2*10-6/K	11.5*10-6/K

Modulus of Elasticity ASTM E 132-04

State	Heat treated
Modulus of elasticity [GPa]	190

TRL 8

Premium



EOS MaragingSteel MS1

for EOS M 290 | 40 µm

Process Information

Chemical and Physical Part Properties

Mechanical Properties

Additional Data

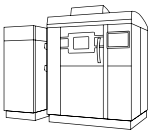
EOS MaragingSteel MS1 for EOS M 290 | 40 µm
Process Information

This process product is optimized for building high quality parts with EOS M 290 system using EOS MaragingSteel MS1.

System set-up	EOS M 290
EOSPAR name	MS1_040_PerformanceM291
Also compatible with	EOS M290-2 400W
Powder part no.	9 011- 0 016
Recoater blade	Ceramic blade
Nozzle	Grid nozzle
Inert gas	Nitrogen
Sieve	63 µm

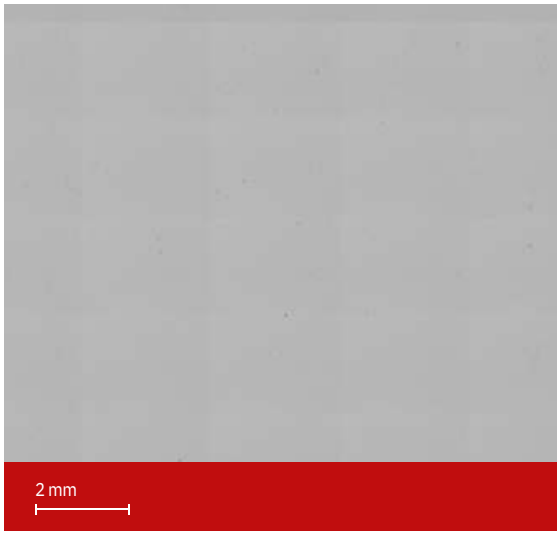
Additional information	
Layer thickness	40 µm
Typical dimensional change after HT	+0.1 %
Volume rate	4.2 mm3/s

Chemical and Physical Properties of Parts1



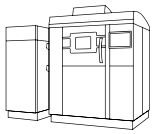
Chemical composition of printed parts matches the chemistry of EOS MaragingSteel MS1 powder.

Micrograph of polished surface



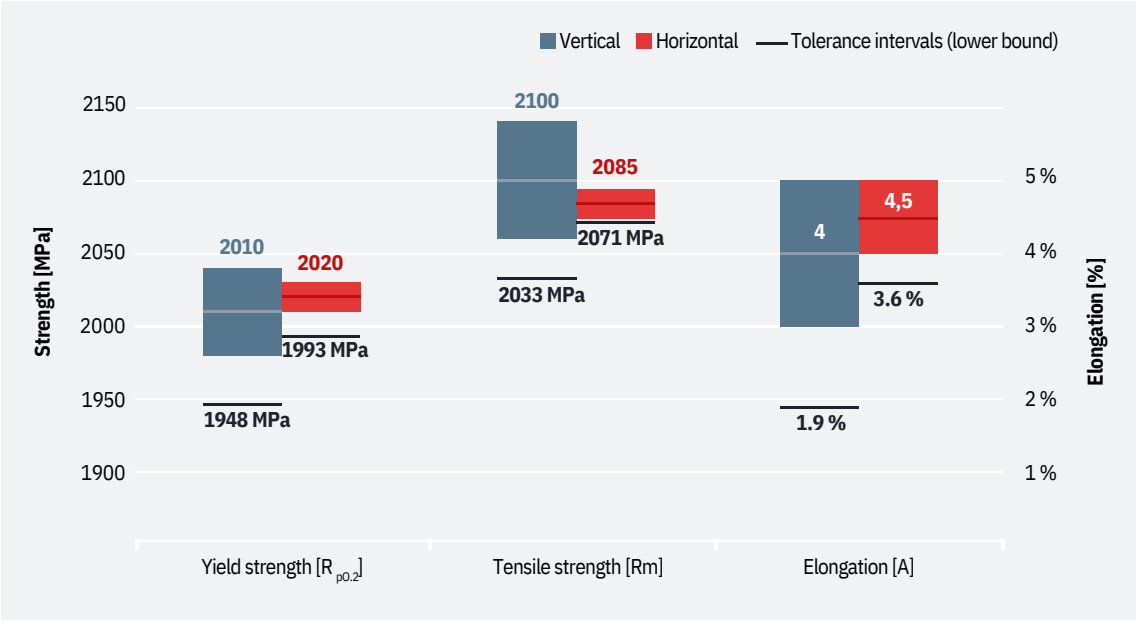
Defects	Result	Number of samples
Average defect percentage	0.04 %	10

Mechanical Properties1



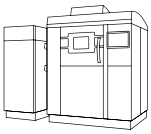
Mechanical properties ISO6892-1

Heat Treated	Yield strength Rp0.2 [MPa]	Tensile strength Rm [MPa]	Elongation at break A [%]
Ver tic al	201	210	4
Horizontal	0	0	4.5
	202	208	
	0	5	

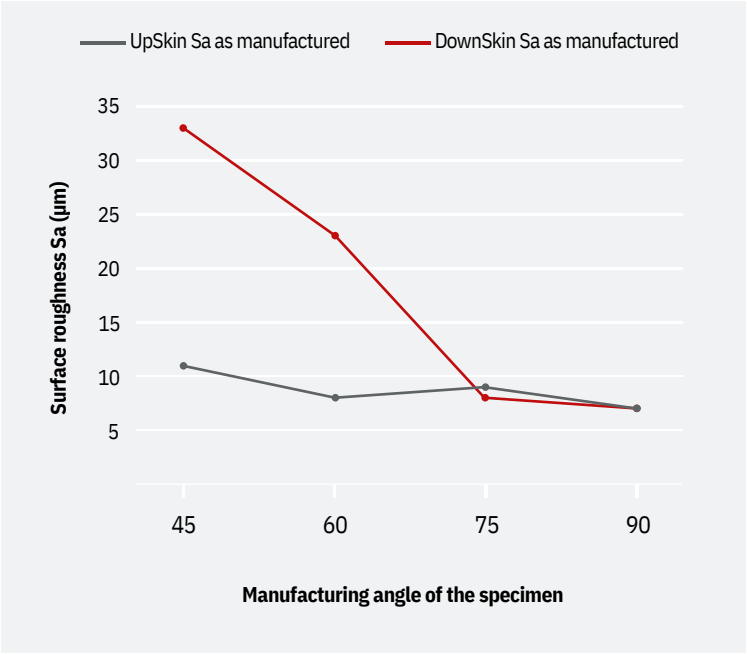


T95: Tolerance intervals provide lower bounds where 95 % of the population falls with 95 % confidence.
Tolerance intervals are based on validation data / QA statistics and are not directly transferable to other systems.

Additional Data1



Surface Roughness

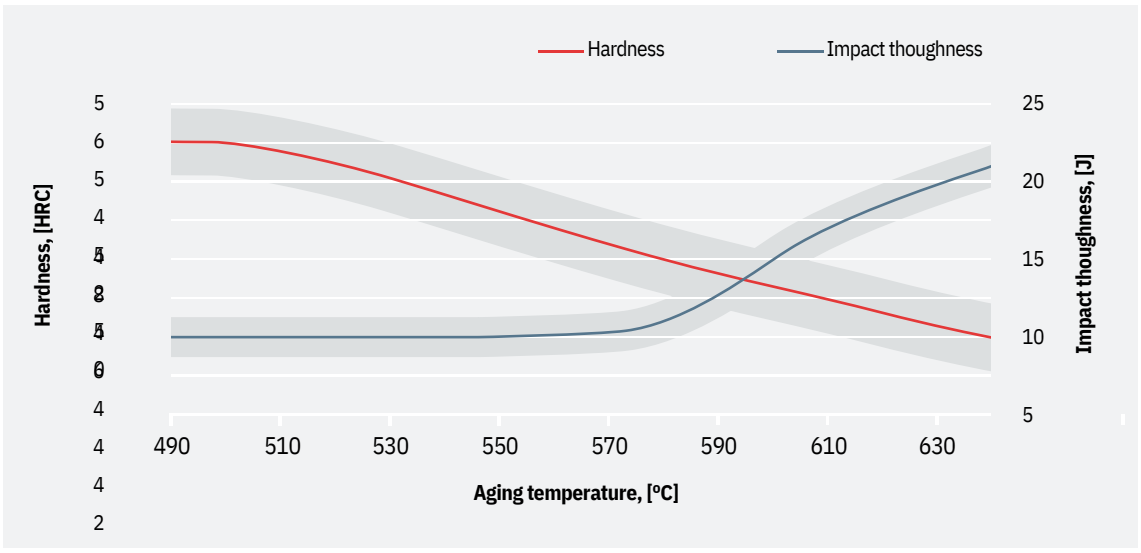


Fatigue Strength

State	Heat treated
Fatigue Strength [MPa]	650

Fatigue strength determines a stress level where specimen fails at a defined number of stress cycles. Fatigue strength was estimated statistically according to ISO 12107. Testing was performed according to ASTM E466. Fatigue results typically show large deviations due to the nature of the fatigue process.

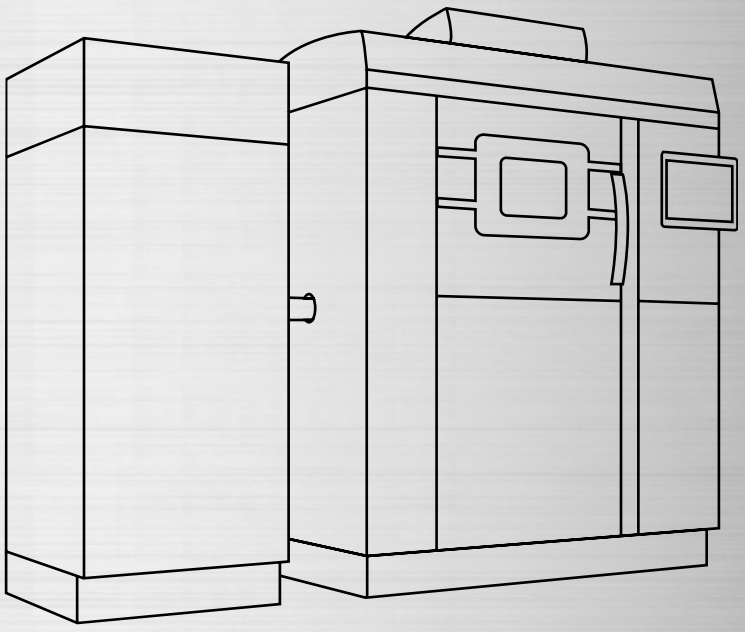
Impact Thoughness



Charpy-V impact thoughness in relation to hardness and aging temperature according to ISO 148.

TRL 3

Core



EOS MaragingSteel MS1

for EOS M 290 | 50 µm

Process Information

Chemical and Physical Part Properties

Mechanical Properties

Additional Data

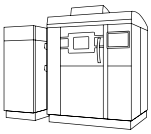
EOS MaragingSteel MS1 for EOS M 290 | 50 µm
Process Information

This process product is optimized for fast production of MS1 parts with EOS M 290.

System set-up	EOS M 290
EOSPAR name	MS1_050_SpeedM291
Also compatible with	EOS M290-2 400W
Powder part no.	9 011- 0 016
Recoater blade	Ceramic blade
Nozzle	Grid nozzle
Inert gas	Nitrogen
Sieve	63 µm

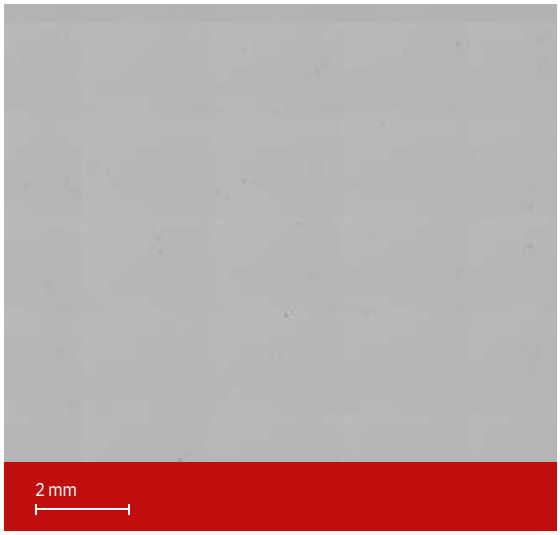
Additional information	
Layer thickness	50 µm
Typical dimensional change after HT	+0.1 %
Volume rate	5.5 mm3/s

Chemical and Physical Properties of Parts1



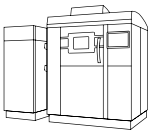
Chemical composition of printed parts matches the chemistry of EOS MaragingSteel MS1 powder.

Micrograph of polished surface



Defects	Result
Average defect percentage	< 0.1 %

Mechanical Properties1

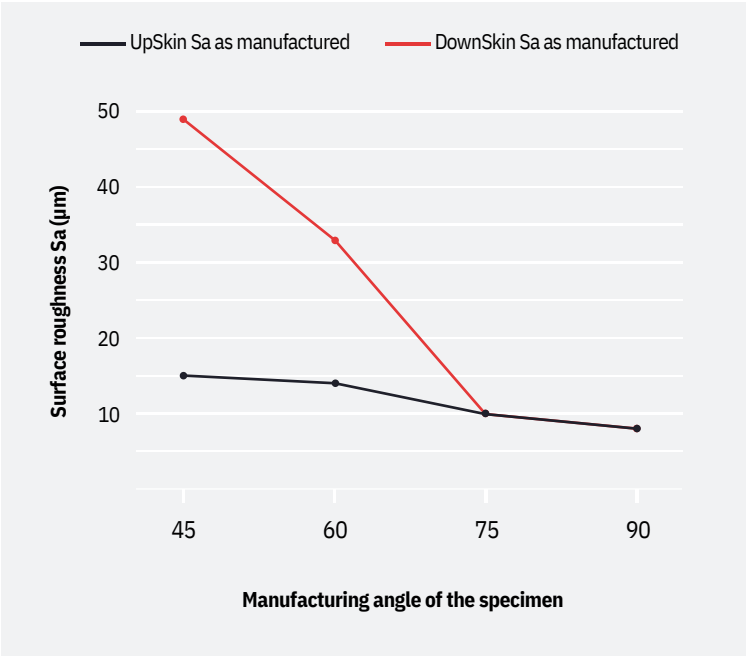


Mechanical properties ISO6892-1

Heat Treated	Yield strength Rp0.2 [MPa]	Tensile strength Rm [MPa]	Elongation at break A [%]
Ver tic al	2000	2100	2
Horizontal	2030	2100	3

Additional Data1

Surface Roughness



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ADDITIVE METAL SOLUTIONS

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