

Meltio Stainless Steel 17-4PH

17-4PH / ER 630 / 1.4542 / UNS S17400

17-4PH is a precipitation-hardening martensitic stainless steel with excellent mechanical properties and corrosion resistance. It is a versatile material with high strength, good toughness, and good resistance to stress corrosion cracking, making it ideal for a wide range of applications in the aerospace and chemical industries.

General Properties

Wire Diameter	Weight on Spool	Spool Type	Wire Coating	Melting Point	Wire Density	Recom. Build plate	Drive Wheels	Inertization ³
1.0 mm	15 kg	BS300	Uncoated	1404-1440 °C	7.75 g/cm³	304 Steel	1.0 V-Groove	Local

Chemical Composition

Fe	C	Ni	Si	Mn	Cr	Mo	Nb	Cu
Bal.	0.02	4.7	0.4	0.5	16.5	0.2	0.23	3.4

Tested Print Profiles

Laser	Profile name	Laser Power [W]	Energy Density [J/mm3]	Deposition Rate [g/h]	Volume rate [cc/h]	Relative Density [%]	Max Pore/Defect [µm]
976 nm	Verified Density	1100	146.6	196	25.29	99.91	-
450 nm	Rev 25 2025-05-30	1000	138.88	265	33.55	99.96	70 / 282
	Rev5 2025-06-13	1400	116.66	335	43.87	-	-

* Printing profiles available in our official Slicers: **Meltio Horizon** for standalone Printers and **Meltio Space** for Laser Integration Kits.
** Profiles developed for the 1.4Kw blue head will be available for Meltio Space for laser integration kits.

Structural Properties ¹

ASTM E8/E8M UNE EN ISO 6892-1 UNE EN ISO 6507-1	Wire	Infrared Laser				Blue Laser			
		Heat Treatment		As Printed		Heat Treatment		As Printed	
		XY	XZ	XY	XZ	XY	XZ	XY	XZ
Ultimate Tensile strength [MPa]	990	-	1391 ± 7	-	1017 ± 15	WIP	WIP	WIP	WIP
Yield strength [MPa]	870	-	1243 ± 8	-	815 ± 17	WIP	WIP	WIP	WIP
Elongation [%]	9	-	10 ± 3	-	14 ± 0.1	WIP	WIP	WIP	WIP
Hardness [HV-30]	-	-	393	-	258	-	-	-	324

Reference Standards

	Casting (ASTM A747)	Wrought (ASTM A7058/A7058 M)	Wrought (ASTM 1472)
Ultimate Tensile strength [MPa]	1205	1310	1310
Yield strength [MPa]	1035	1035	1170
Elongation [%]	5	5	10
Hardness [HV-30]	-	-	388

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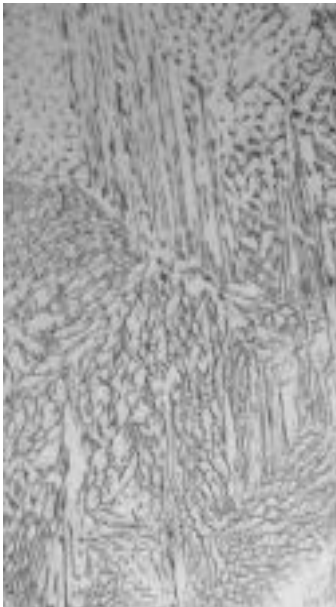
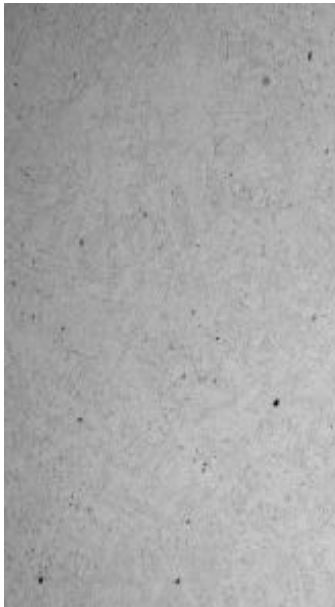
Internal Structure ²

Micrography

The as printed microstructure of 17-4 PH stainless steel is heterogeneous and mostly martensitic with some retained austenite.
Solution Annealing and Age Hardening results in a significantly refined grain structure with a predominantly martensitic microstructure and equiaxed morphology.

IR Laser

Blue Laser



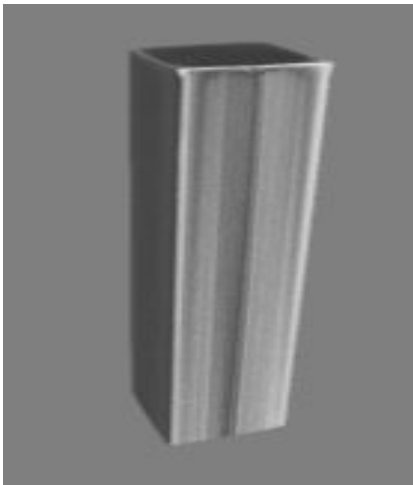
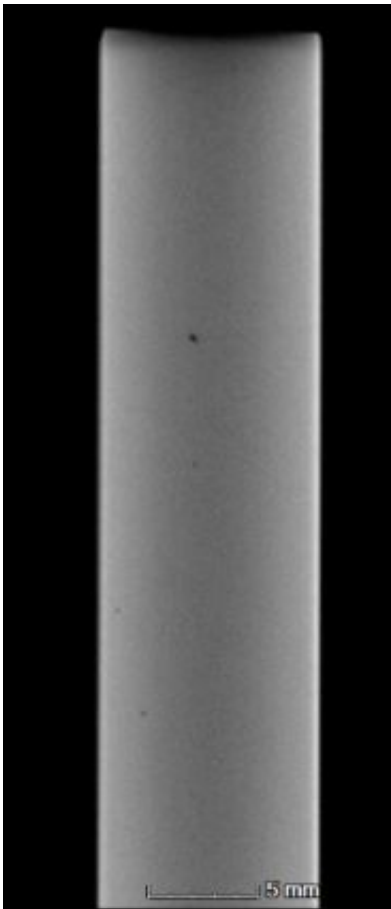
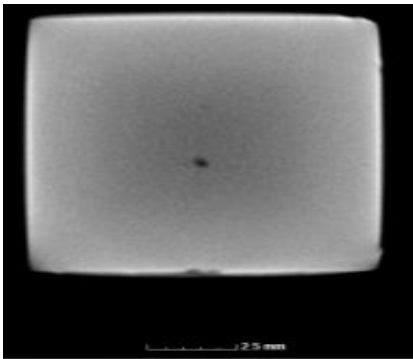
As-printed XY
100x Magnification

HT XY
100x Magnification

As-printed XY
100x Magnification

Tomography

CT Scan of 3D printed sample part in 17-4PH using IR Laser without detectable voids or defects. Resolution of 24 µm per pixel.



3D / Top View

Front View

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1.Structural Properties

Tensile Tests

Specimens printed using Meltio’s wire-laser metal 3D printed process perform at the same level as samples made with conventional manufacturing methods. Results show low deviations and near isotropic properties even in the as-printed state without the application of heat-treatments. Testing is carried out in the less favorable XZ direction to ensure the values are applicable across complete part.

Mechanical Properties were obtained, based on a printed block of 160x30x70 mm using the Verified Density Parametrization for IR Laser from it 16 ASTM E8M samples were extracted using EDM and were analyzed by an external laboratory. (IDONIAL info@idonial.com)

Hardness

Based on a printed block of 30x60x20 mm using Verified Density Parametrization. A sample from this block of 10x10x60 mm was extracted using EDM. from it UNE-EN ISO 6507-1 and was analyzed by an external laboratory. (IDONIAL info@idonial.com).

Heat Treatment

To achieve the best mechanical properties, 17-4PH should be heat-treated after 3D printing. The standard heat treatment process for 17-4PH involves two steps: Solution Annealing and Age Hardening. Solution annealing removes internal stresses of the metal that have been formed during 3D printing and Age Hardening will upgrade the mechanical properties. Machining may take place before or after the solution annealing depending on part tolerance requirements.

Solution Annealing		Age Hardening	
Heat up to 1000°C-1050°C	Hold 1 hour Cooling to RT	Heat up to 480°C-500°C	Hold 3 hour Slow Cooling to RT

Typical Parameters for a ASTM E8M cylinder sample of 4 mm diameter and 10 mm long extracted by EDM from a printed block for Tensile Tests

2.Internal Structure

Micrography

The micrography were obtained from a 10x10x60 mm printed block using the Verified Density Profile for IR laser and **Rev 21 2024-12-13** profile for the Blue laser. The metallographic analysis followed ASTM E3-11:2017 standards, ensuring proper preparation and examination of the microstructure and were analyzed by an external laboratory. (IDONIAL info@idonial.com)

Tomography

The tomography images were obtained from a 10x10x60 mm printed block using the Verified Density Profile for IR laser and were analyzed by an external laboratory. (SERMET3D info@sermet3d.com)

Relative Density

Characterizing materials for its Blue Laser technology using 300x400x60 mm 304L steel build plates. Relative density and pore size are evaluated through micrography following NASA-STD-6030 “Additive Manufacturing Requirements for Spaceflight Systems,” based on a 250x250x30 mm printed specimen. The results comply with NASA-STD-6030, showing an overall porosity fraction below 0.25% by volume and were analyzed by an external laboratory. (IDONIAL info@idonial.com , CETEMET i+d+i@cetemet.es , AIMEN comunicacion@aimen.es)

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3. Inertization

Inertization of Meltio M600 machinery can be performed in two ways: localised inertisation or full chamber inertization. Both options are designed to ensure a controlled environment during the 3D printing process and prevent oxygen contamination of reactive materials.

Localised Inertization:

In this mode, the shielding gas is supplied locally through the shield nozzle located in the deposition head, with a flow rate of approximately 15 L/min. This method is suitable for most applications where oxygen control in the work area is necessary without requiring a completely isolated environment.

Full Chamber Inertization:

For more demanding applications, it is possible to perform a full chamber inertization. In this case, the chamber must be preconditioned before the printing process is started, reaching an oxygen concentration of 50 ppm. It is essential to control the oxygen concentration in the chamber, as reactive materials can absorb oxygen even when the part is hot, not only when it is in the melt pool.

The choice of inertisation method depends on the properties of the material to be used and the specific requirements of the printing process, ensuring the highest quality and integrity of the manufactured parts.