

Meltio Titanium 64

Ti-6Al-4V / ER Ti-5 / S Ti 6402c / 3.7165

Ti64 is a popular and widely used alloy due to its excellent combination of strength, low density, and corrosion resistance. It is used in a variety of industries, including aerospace, and chemical processing, due to its properties. Its high strength-to-weight ratio makes it a preferred choice for lightweight applications.

General Properties

Wire Diameter	Weight on Spool	Spool Type	Wire Coating	Melting Point	Wire Density	Recom. Build plate	Drive Wheels	Inertization ⁴
1.0 mm	7.5 kg	BS300	Uncoated	1674 °C	4.4g/cm³	Titanium	1.0 V-Groove	Full chamber

Chemical Composition

Ti	Al	V	Fe	C	N	H	O
Bal.	5.5	3.5	0.4	0.08	0.05	0.015	0.2

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]	Oxygen Content
976 nm	Verified Density	1100	122.22	144	32.5	99.90	-	0.250 - 0.450
450 nm	Rev 30 2025-05-06	1000	47.61	360	75.62	99.87	376 / 550	0.095 - 0.213
	Rev 10 2025-06-23	1400	48.07	461	104.82	-	-	-

* 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]	895	802 ± 7	788 ± 12	-	-	852 ± 11	850 ± 11	958 ± 12	962 ± 12
Yield strength [MPa]	828	727 ± 17	693 ± 16	-	-	740 ± 9	699 ± 9	852± 11	854 ± 11
Elongation [%]	10	7 ± 1	9 ± 1	-	-	12.50 ± 0.5	14.13 ± 0.5	11.75± 0.5	9.50 ± 0.5
Hardness [HV-30]	-	-	311	303	-	-	-	332	-

Reference Standards

	Cast (ASTM B367)	Cast (ASTM F1108)	Wrought (ASTM A381)	Wrought (ASTM F1472)
Ultimate Tensile strength [MPa]	895	860	895	930
Yield strength [MPa]	825	758	828	860
Elongation [%]	6	8	10	10
Hardness [HV-30]	-	342	-	349

Fatigue ²

ASTM E466 (XZ)	Infrared Laser		Blue Laser	
	Heat Treated (A.H)	Heat Treated (HIP)	As Printed	Heat Treated
Stress Range [Mpa]	450	530	WIP	WIP
N° of Cycles (Nf)	1x10^7			
Stress Ratio (R)	-1			

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Internal Structure ³

Micrography

The observed microstructure is composed of acicular martensite embedded in the beta phase. The columnar shape of the grains extends along the manufacturing direction due to epitaxial growth of the original beta phase. In the XY section, the microstructure appears as polyhedral grains of α' + β , with alpha phases at grain boundaries.

IR Laser

Blue Laser



As-printed XY
100x Magnification



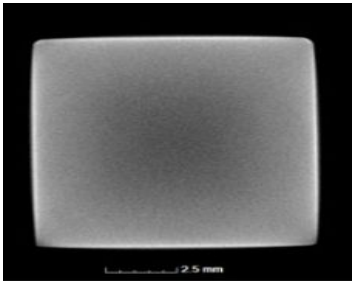
HT XY
100x Magnification



As-printed XY
100x Magnification

Tomography

CT Scan of 3D printed sample part in Ti64 using IR Laser without detectable voids or defects. Resolution of 24 μ m 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.

Mechanical Properties were obtained, based on a printed block of 160x30x70 mm using the Verified Density Parametrization for IR Laser and a printed block of 95x155x55 mm using the **Rev 30 2025-05-06** profile for the Blue laser, from it 16 ASTM E8M samples were extracted using EDM and were analyzed by an external laboratory. IR laser were carried out by CATEC info@catec.aero and AIDIMME aidimme@aidimme.es)

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 lab. (IR laser were carried out by CATEC info@catec.aero and Blue laser were carried out by CETEMET i+d+i@cetemet.es).

Heat Treatment

Heat treatment is recommended for Ti64 to enhance its mechanical properties. Through heat treatment, the alloy becomes stronger, more ductile, and more resistant to fatigue, making it suitable for high-stress applications. Heat treatment also eliminates residual stresses and helps to refine the microstructure of the alloy, leading to improved toughness and increased resistance to crack growth. Heat treatment of Ti64 after 3D printing is a crucial step in maximizing its performance in applications.

Solution Annealing		Age Hardening	
Vacuum atmosphere Heat up to 920°C	Hold for 2h Cooling to RT	Vacuum atmosphere Heat up to 460°C	Hold for 8h Cooling inside the oven to RT

2.Fatigue Life

Specimens printed using Meltio’s wire-laser metal 3D printing process can withstand high fatigue cycles, performing at the same level as samples produced using conventional manufacturing methods. The results also indicate that specimens exhibit good fatigue behaviour even in the as-printed state, without the application of heat treatments.

Mechanical Properties were obtained, based on a printed block of 160x30x70 mm using the Verified Density Parametrization, from it 16 ASTM E466 samples were extracted using EDM and were analyzed by an external laboratory. (AIDIMME aidimme@aidimme.es)

3.Internal Structure

Micrography

The micrography were obtained from a 10x10x60 mm printed block using the Verified Density Profile for IR laser and **Rev 30 2024-12-17** 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. (CATEC info@catec.aero)

Oxygen Content

Oxidation is a crucial factor that particularly affects the properties and performance of 3D printed titanium samples. Titanium has a high affinity for oxygen when exposed to air at high temperatures, which leads to embrittlement and reduced mechanical properties, such as decreased resistance to wear, fatigue, and corrosion and were analyzed by an external laboratory. (AIDIMME aidimme@aidimme.es)

Relative Density

Characterizing materials for its Blue Laser technology using 300x400x60 mm Titanium 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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4. 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 20 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.