

Meltio Stainless Steel 316L

ER316LSI / G 19 12 3 L Si / 1.4430

Austenitic steel with excellent durability, low reactivity and adequate elevated temperature properties. The alloy has a low carbon content which makes it particularly recommended when there is a risk of intergranular corrosion. Thus, parts manufactured with SS316L are an excellent choice in corrosion prone 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	15 kg	BS300	Uncoated	1398 °C	8.0 g/cm³	304 Steel	1.0 V-Groove	Local

Chemical Composition

Fe	C	Si	Mn	Cr	Ni	Mo
Bal.	0.02	0.9	1.7	18.5	12.0	2.7

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	122.22	259	32.38	99.7	-
450 nm	Rev 10 2025-06-20	1000	83.33	361	45.57	99.97	185 / 266
	Rev3 2025-06-24	1400	59.52	483	60.48	-	-

* 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]	620	556 ± 8	547 ± 8	643 ± 6	655 ± 11	665 ± 55	641 ± 47	659 ± 10	586 ± 77
Yield strength [MPa]	420	215 ± 3	253 ± 17	429 ± 16	347 ± 28	334 ± 64	332 ± 50	521 ± 21	474 ± 22
Elongation [%]	35	65 ± 1	62 ± 2	38 ± 2	41 ± 4	46 ± 14	46± 14	37.7 ± 3	17.7± 15
Hardness [HV-30]	-	192	192	198	-	-	WIP	173	-

Reference Standards

	Cast (ASTM A743)	Cast (ASTM A403)	Wrought (ASTM A473-24)	Wrought (ASTM A351)
Ultimate Tensile strength [MPa]	485	515	450	550
Yield strength [MPa]	205	208	170	260
Elongation [%]	30	40	40	35
Hardness [HV-30]	-	215	-	225

Fatigue ²

ASTM E466 (XZ)	Infrared Laser		Blue Laser	
	As printed	Heat Treated	As Printed	Heat Treated
Stress Range [Mpa]	220	190	WIP	WIP
N° of Cycles (Nf)	5x10^6			
Stress Ratio (R)	-1			

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Internal Structure ³

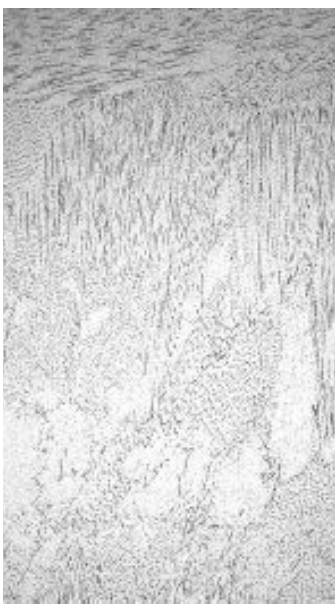
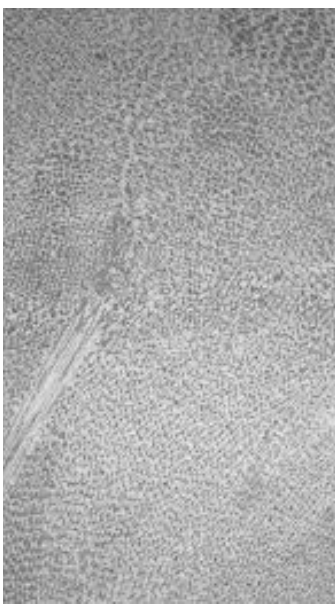
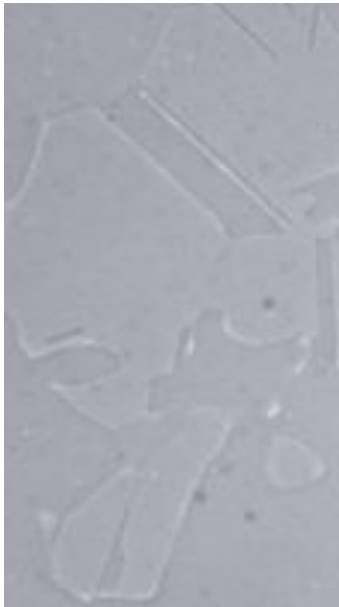
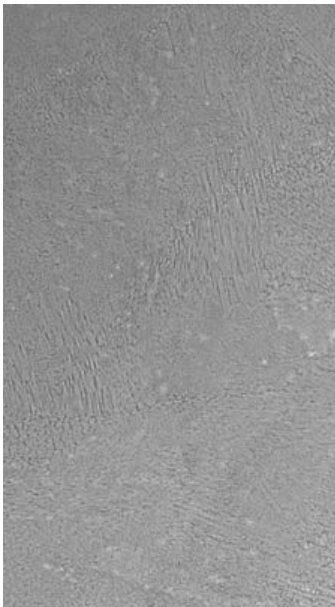
Micrography

IR: The as-built SS316LSi samples show a microstructure with both cellular and columnar dendritic solidification mode. In as printed condition we find around 5.6% ferritic structures which are reduced to 0.2 % after heat-treatment of re-austenization.

Blue:The microstructural analysis of stainless steel SS316LSi reveals a primarily austenitic FCC matrix with a minor presence of delta ferrite (δ) as a secondary phase. In the As-Built condition, the structure is dominated by solidification dendrites, with δ -ferrite forming initially and partly transforming into austenite upon cooling. Residual δ -ferrite remains in interdendritic regions, often displaying vermicular or lath-like morphologies. After thermal treatment (HT), partial dissolution of dendrites occurs, enabling the formation of austenitic grains. In these recrystallized zones, δ -ferrite tends to accumulate along grain boundaries, while in non-recrystallized areas, it remains in interdendritic regions.

IR Laser

Blue Laser



As-printed XY
100x Magnification

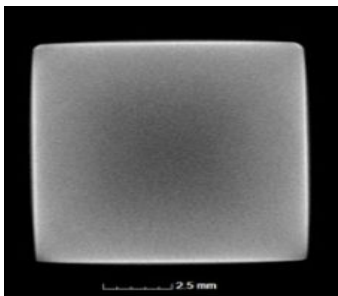
HT XY
100x Magnification

As-printed XY
100x Magnification

HT XY
100x Magnification

Tomography

CT Scan of 3D printed sample part in SS316L 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.

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 9 2024-12-05** profile for the Blue 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 lab. (IR laser were carried out by IDONIAL info@idonial.com and Blue laser were carried out by CETEMET i+d+i@cetemet.es).

Heat Treatment

With SS316L it is not mandatory to perform a heat-treatment after 3D printing for general use case applications. As-built Meltio SS316L parts show a mainly austenitic structure with some small ferrite content. This Ferrite content may be adjusted via re-austenization to fit the requirements of a specific application. Applying the heat-treatment a 99.8% austenitic structure structure can be achieved. SS316L may also be stress relieved between 450°C and 500°C without affecting its microstructure.

Re-austenization

Protective atmosphere	1050°C	Maintain for 2h	Cooling to RT
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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.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. (IDONIAL info@idonial.com)

3.Internal Structure

Micrography

The micrography were obtained from a 10x10x60 mm printed block using the Verified Density Profile for IR laser and **Rev 9 2024-12-05** 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)

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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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 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.