Meltio Mild Steel ER70-S

ER70S-6 / S 42 4 M21 3Si1 / AWS A5.18

ER70-S, also known as low alloy carbon steel or mild steel, is a highly versatile material due to its strength, ductility, and low cost. It is used in many applications, including construction, automotive and manufacturing. Its excellent weldability and machinability make it easy to work with, while its high ductility and toughness make it suitable for structural applications.

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	1425 -1485 ºC	7.8 g/cm³	304 Steel	1.0 V-Groove	Local

Chemical Composition

Fe	C	Mn	Si	S	P
Bal.	0.07	1.45	0.85	0.02	0.01

ISO/ASTM 52942:2020: Group A [5]

Tested Print Profiles

Laser	Profile name	Meltio TRL[4]	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**	Proven	1100	183.33	168	21.54	99.19	-
450 nm	**Rev 41 2025-06-03**	Qualified	1000	92.59	330	42.31	99.83	137 / 250
	Rev1 2025-05-07	Qualified	1400	101.3	423	53.85	-	-

* 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 1.0kW			
		Heat Treatment		As Printed		Heat Treatment		As Printed	
		XY	XZ	XY	XZ	XY	XZ	XY	XZ
Ultimate Tensile Strength [MPa]	560	-	-	598 ± 5	525 ± 12	467 ± 2	463 ± 7	647 ± 58	600 ± 63
Yield Strength [MPa]	480	-	-	484 ± 8	402 ± 37	295 ± 4	300± 5	559 ± 71	550± 34
Elongation [%]	25	-	-	71 ± 1	15 ± 9	39 ± 3	26 ± 8	21 ± 4	11 ± 5
Hardness [HV-30]	-	–	-	-	175	-	-	-	136

Reference Standards

	Casting (ASTM A494)	Wrought *(ASTM A.3)*
Ultimate Tensile Strength [MPa]	585	550
Yield Strength [MPa]	205	250
Elongation [%]	24	23
Hardness [HV-30]	160	127

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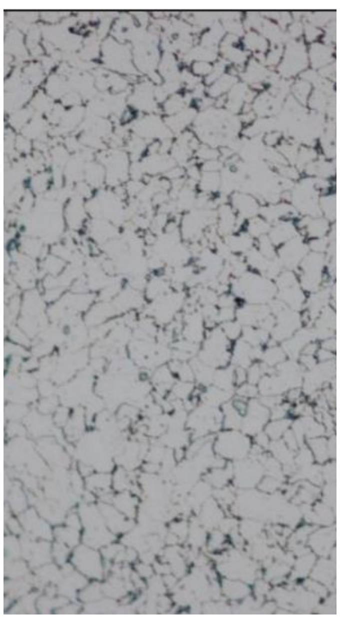
Internal Structure [2]

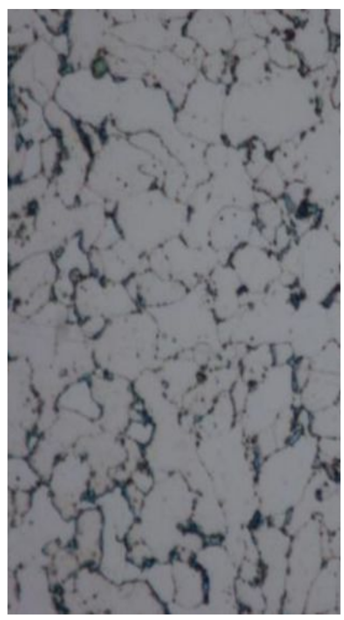
Micrography

The investigation reveals that the microstructure of the ER70-S specimens consists of a ferritic matrix intermixed with pearlite at the grain boundaries, wherein the interlayers exhibit larger grain sizes owing to the heat generated during material deposition.

IR Laser



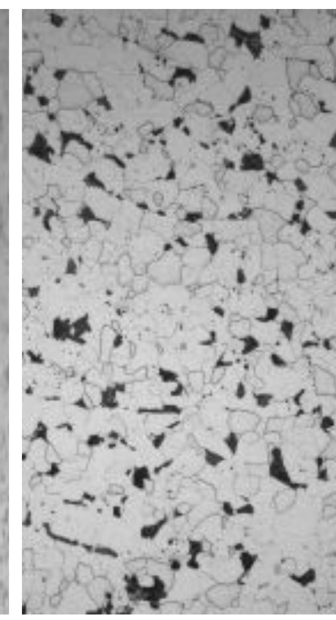
As-printed XY
500x Magnification



HT XY
500x Magnification

Blue Laser

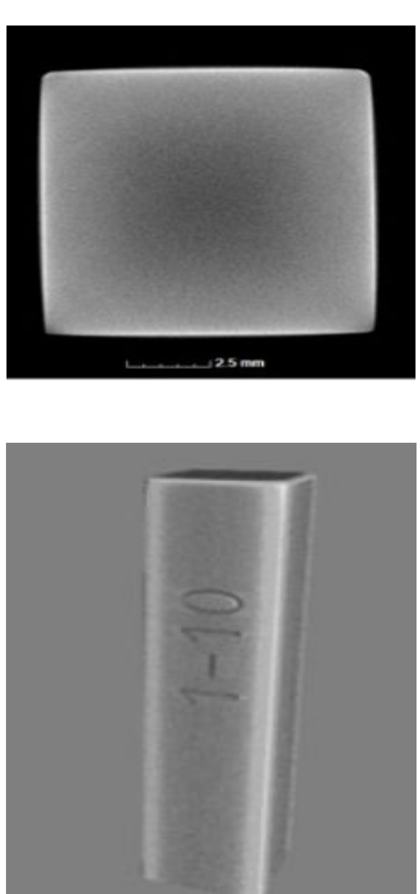
As-printed XY
500x Magnification



HT XY
500x Magnification

Tomography

Computed Tomography Scan of 3D printed sample part in ER70-S without detectable voids or defects. Resolution of 24 µm per pixel.



3D / Top View

Front View

MELTIO

Meltio Material Datasheet

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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 41 2025-06-03** profile for the Blue laser, from it 16 ASTM E8M samples were extracted using EDM and were analyzed by an external laboratory. (*CETEMET* i+d+i@cetemet.es, *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. (*University of Jaen (UJA)* info@strainanalysisuja.es, *IDONIAL* info@idonial.com).

Heat Treatment

With ER70-S it is not mandatory to perform a heat-treatment after 3D printing for general use case applications. A Normalizing heat treatment can be applied to ER70-S to improve its microstructure and mechanical properties. By eliminating unstable constituents such as acicular ferrite and bainite, a more uniform and homogeneous microstructure is achieved, leading to a better distribution of pearlite and ferrite. This results in increased ductility and toughness, as well as a reduction in the anisotropy of the material.

Normalization

Protective atmosphere Heat up to 900°C	Maintain for 2h Cooling in air 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 36 2025-02-21** 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, *ADIMME* aidimme@aidimme.es)

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)

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.

4.Meltio TRL Classification System

The manufacturing process of Copper and Aluminum using Meltio's Blue Laser technology has certain limitations. Currently, thin-walled geometries (produced in a single pass) can be reliably manufactured. However, solid or bulky components present challenges due to variations in material behavior and thermal properties as the volume and mass increase. While small solid volumes of these materials can be printed, scalability remains an area of ongoing development.

Additionally, the technological readiness of Copper and Aluminum printing is currently between **Technology Readiness Level (TRL) 3 and 4,** indicating that it is still in the experimental validation and optimization stages. In contrast, other Meltio materials, such as steels, nickel and titanium alloys, have reached higher maturity levels, ranging from TRL 7 to 9, with validated applications in industrial environments.

To clearly communicate the development and readiness level of materials within the Meltio ecosystem, an internal classification system has been established, aligned with the standard Technology Readiness Levels (TRL). This framework offers a structured reference for customers, partners, and integrators regarding the current validation stage and industrial applicability of each material.

Meltio Tier	TRL	Description
Meltio Explore	1–3	Exploratory phase focused on researching new alloys and process configurations. Designed for R&D environments aiming to push the boundaries of the technology.
Meltio Develop	4–6	Active development stage. Functional results have been achieved, with evolving process parameters. Suitable for concept validation and pre-industrial applications.
Meltio Qualified	7-8	Material and process qualified for demanding applications. High repeatability and reliability, ready for integration into real-world production environments.
Meltio Proven	9	Fully validated in industrial settings. Material used in end-use parts with proven performance in actual production. Represents the highest level of technological maturity.

5. Material Classification (ISO/ASTM 52942:2020)

The metallic material specified in this technical data sheet is classified in accordance with ISO/ASTM 52942:2020 – Additive Manufacturing — Metallic Materials — Classification. This standard defines a harmonised system for the designation and categorisation of metallic materials used in additive manufacturing, ensuring consistent identification and traceability.

Mild Steel ER70S-6 is designated within **Group A**, corresponding to low alloy steels.