

EOS NickelAlloy IN718  
Material Data Sheet

# EOS NickelAlloy IN718

## High Temperature Strength and Corrosion Resistance

EOS NickelAlloy IN718 is a precipitation-hardening nickel-chromium alloy that is characterized by having good tensile, fatigue, creep and rupture strength at temperatures up to 700 °C (1 290 °F). Parts built from EOS NickelAlloy IN718 can be easily post-hardened by precipitation-hardening heat treatments.

EOS NickelAlloy IN718 is a nickel alloy powder intended for manufacturing parts on EOS metal systems with EOS DMLS processes.

### Main Characteristics:

- Good tensile, fatigue, creep and rupture strength at temperatures up to 700 °C (1 290 °F)
- Parts are easily precipitation hardened
- Parts can be machined, spark-eroded, welded, micro shot-peened, polished and coated in both as-built and age-hardened states

### Typical Applications:

- Gas turbine components
- Instrumentation parts
- Power industry parts
- Process industry parts

### 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. The data resulting from each combination is assigned a Technology Readiness Level (TRL) which makes the expected performance and production capability of the solution transparent.

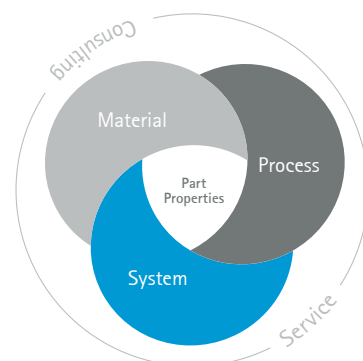
EOS incorporates these TRLs into the following two categories:

- Premium products (TRL 7-9): offer

highly validated data, proven capability and reproducible part properties.

- Core products (TRL 3 and 5): enable early customer access to newest technology still under development and are therefore less mature with less data.

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



## Powder Properties

The chemical composition of EOS NickelAlloy IN718 is in compliance with UNS N07718, AMS 5662, AMS 5664, W.Nr 2.4668, DIN NiCr19Fe19NbMo3.

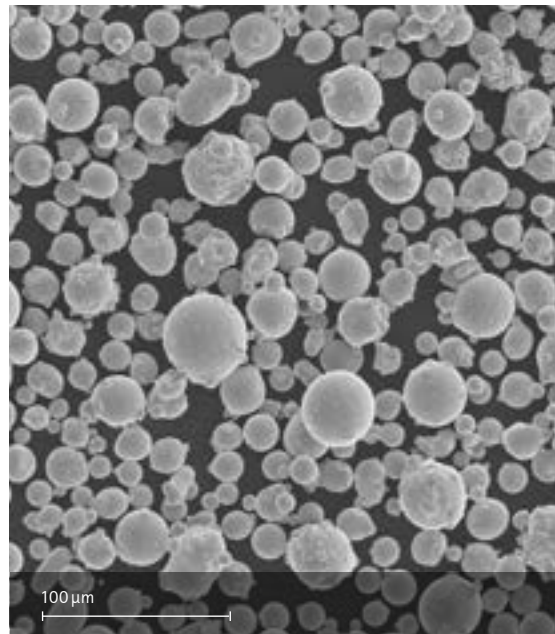
### Powder chemical composition (wt.-%)

Element	Min.	Max.
Fe	Rem.	
Ni	50.00	55.00
Cr	17.00	21.00
Nb	4.75	5.50
Mo	2.80	3.30
Ti	0.65	1.15
Al	0.20	0.80
Co	-	1.00
Cu	-	0.30
Si	-	0.35
Mn	-	0.35
Ta	-	0.05
C	-	0.08
S	-	0.015
P	-	0.015
B	-	0.006
Pb	-	0.0005
Se	-	0.0020
Bi	-	0.00003

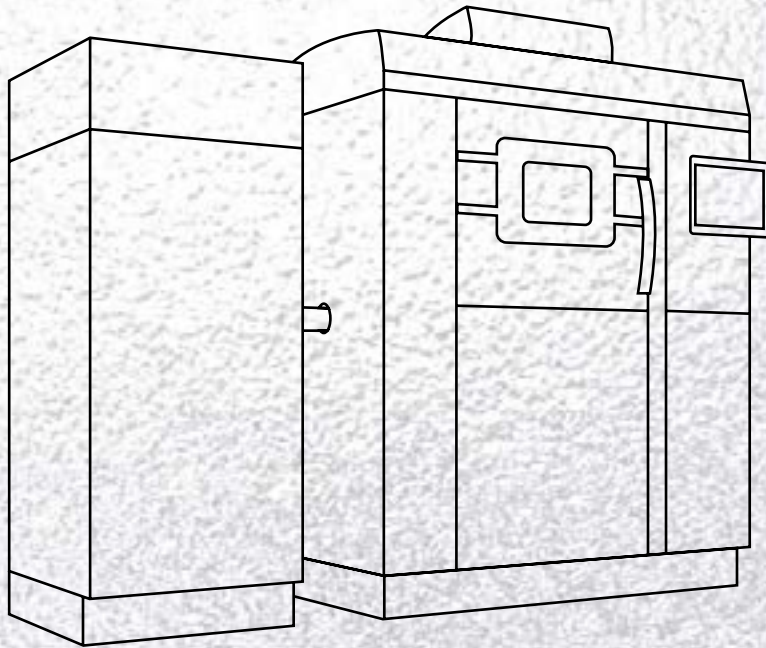
### Powder particle size

Generic particle size distribution	20-55 µm
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*SEM picture of EOS NickelAlloy IN718 powder.*







## EOS NickelAlloy IN718 for EOS M 290 | 40 $\mu\text{m}$

Process Information  
Heat Treatment  
Physical Part Properties  
Mechanical Properties  
Additional Data

## EOS NickelAlloy IN718 for EOS M 290 | 40 µm Process Information

System set-up	EOS M 290
EOS material set	IN718 Performance 2.0
EOSPAR name	IN718_040_PerformanceM291_2xx
Software requirements	EOSPRINT 1.7 or newer, EOSPRINT 2.6 or newer, EOSYSTEM 2.9 or newer
Powder part no.	9011-0020
Recoater blade	EOS HSS Blade
Nozzle	EOS Grid Nozzle
Inert gas	Argon
Sieve	63 µm

### Additional information

Layer thickness	40 µm
Volume rate	4.2 mm <sup>3</sup> /s
Min. wall thickness	Typical 0.3 - 0.4 mm

## Heat Treatment

Heat treatment procedure conform to Aerospace Material Specification AMS 2774 and AMS 5662. As manufactured microstructure for additively manufactured IN718 consists of gamma phase ( $\gamma$ ). Heat treatment for IN718 is required to produce desired microstructure and part properties (gamma double prime precipitates,  $\gamma''$ ). Heat treatment is also used to relieve stresses.

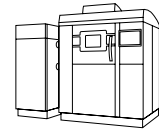
### Step 1:

**Solution Annealing:** hold at 954 °C (1 750 °F) for 1 hour per 25 mm (0.98 inch) of thickness, air (/argon) cool

### Step 2:

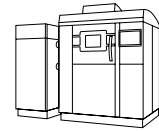
**Ageing Treatment:** hold at 718 °C (1 325 °F) 8 hours, furnace cool to 621 °C (1 150 °F) and hold at 621 °C (1 150 °F) for total precipitation time of 18 hours, air (/argon) cool

## Chemical and Physical Properties of Parts<sup>1</sup>



*Heat treated microstructure.  
Etched according to  
ASTM E407-07.*

Defects	Result	Number of samples
Average defect percentage	0.03 %	10
Density, ISO3369	Result	Number of samples
Average density	min 8.15 g/cm <sup>3</sup>	10



## Mechanical Properties in Heat Treated State<sup>1</sup>

Tensile properties heat treated  
(acc. AMS 2774 and AMS 5662)

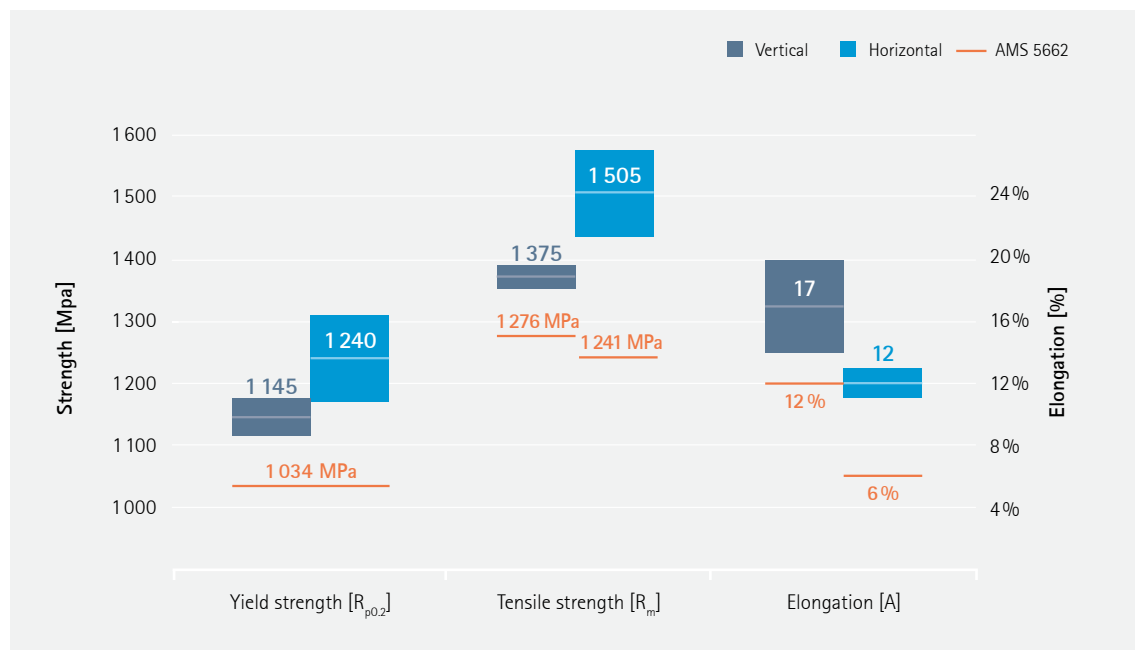
	Yield strength $R_{p0.2}$ [MPa]	Tensile strength $R_m$ [MPa]	Elongation at break A [%]	Number of samples
Vertical	1 145	1 375	17	54
Horizontal	1 240	1 505	12	26

Hardness as per ISO 6508-1

Hardness, HRC	47
Number of samples	45

Hardness as per DIN EN ISO 6506-1:2014

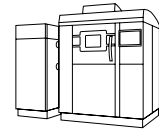
Hardness, HB	466
Number of samples	10



\* T90: Tolerance intervals provide upper and lower bounds where 90 % of the population falls with 95 % confidence. Tolerance intervals are based on validation data / QA statistics and are not directly transferrable to other systems.

Tensile properties as manufactured

	Yield strength $R_{p0.2}$ [MPa]	Tensile strength $R_m$ [MPa]	Elongation at break A [%]	Number of samples
Vertical	650	970	32	41
Horizontal	800	1 090	25	36



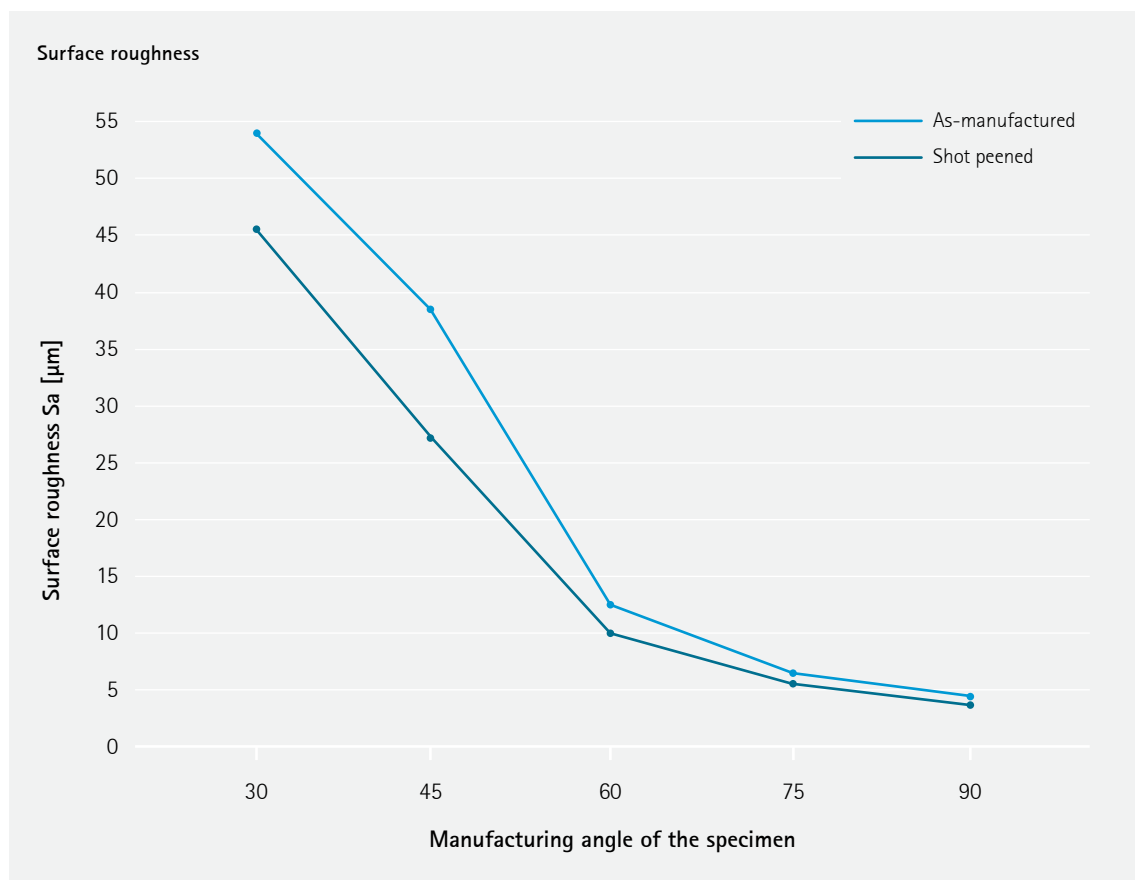
## Additional Data<sup>1</sup>

### Coefficient of Thermal Expansion ASTM E228-17

Temperature	25-100 °C	25-200 °C	25-300 °C	25-400 °C	25-500 °C	25-600 °C	25-700 °C
CTE	13.1*10 <sup>-6</sup> /K	13.7*10 <sup>-6</sup> /K	14.1*10 <sup>-6</sup> /K	14.4*10 <sup>-6</sup> /K	14.7*10 <sup>-6</sup> /K	15.0*10 <sup>-6</sup> /K	15.5*10 <sup>-6</sup> /K

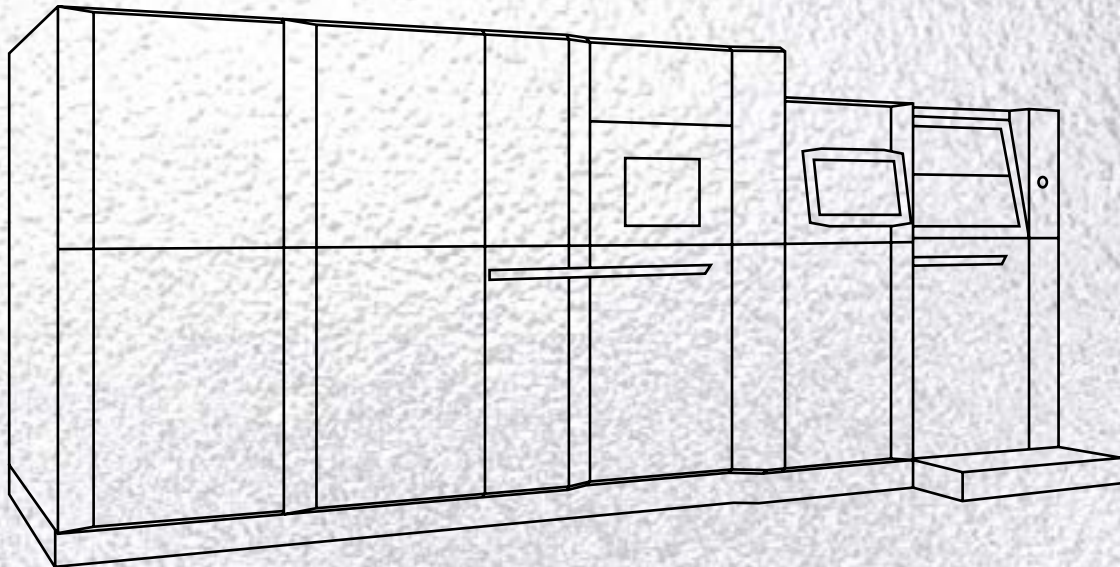
### Surface Roughness

Horizontal surface	As-manufactured Sa 4.5 µm	Shot Peened Sa 3.8 µm
Vertical and angled surfaces according to figure		



*The surface quality was characterized by optical measurement method according to internal procedure. The 90 degree angle corresponds to vertical surface.*





## EOS NickelAlloy IN718 for EOS M 300-4 | 40 $\mu\text{m}$

Process Information

Heat Treatment

Physical Part Properties

Mechanical Properties

## EOS NickelAlloy IN718 for EOS M 300-4 | 40 µm Process Information

System set-up	EOS M 300-4
EOS material set	IN718 40µm M300-4
EOSPAR name	IN718_040_CoreM304 1.X
Software requirements	EOSPRINT 2.9 or newer, EOSYSTEM 2.12 or newer
Powder part no.	9011-0020
Recoater blade	EOS HSS Blade, two-sided recoating
Inert gas	Argon
Sieve	63 µm

Additional information	
Layer thickness	40 µm
Volume rate	up to 4 x 4.2 mm <sup>3</sup> /s

### Heat Treatment

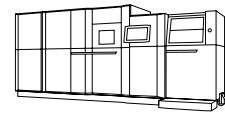
Heat treatment procedure conform to Aerospace Material Specification AMS 2774 and AMS 5662. As manufactured microstructure for additively manufactured IN718 consists of gamma phase (γ). Heat treatment for IN718 is required to produce desired microstructure and part properties (gamma double prime precipitates, γ<sup>''</sup>). Heat treatment is also used to relieve stresses.

#### Step 1:

**Solution Annealing:** hold at 954 °C (1 750 °F) for 1 hour per 25 mm (0.98 inch) of thickness, air (Argon) cool

#### Step 2:

**Ageing Treatment:** hold at 718 °C (1 325 °F) 8 hours, furnace cool to 621 °C (1 150 °F) and hold at 621 °C (1 150 °F) for total precipitation time of 18 hours, air (Argon) cool



## Chemical and Physical Properties of Parts<sup>1</sup>

Defects	Result	Number of samples
Average defect percentage	< 0.05	64
Max. pore size	< 100 μm	64

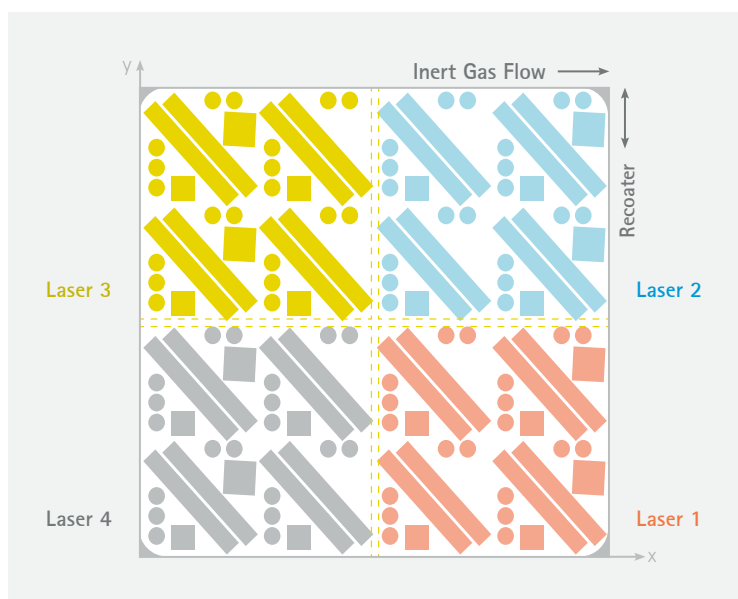
## Mechanical Properties<sup>1</sup>

Typical part properties	Yield strength $R_{p0.2}$ [MPa]	Tensile strength $R_m$ [MPa]	Elongation at break A [%]	Number of samples
As manufactured vertical	634	957	36	158
As manufactured horizontal	796	1092	27	62
Heat treated vertical	1141	1370	20	159
Heat treated horizontal	1267	1531	15	44

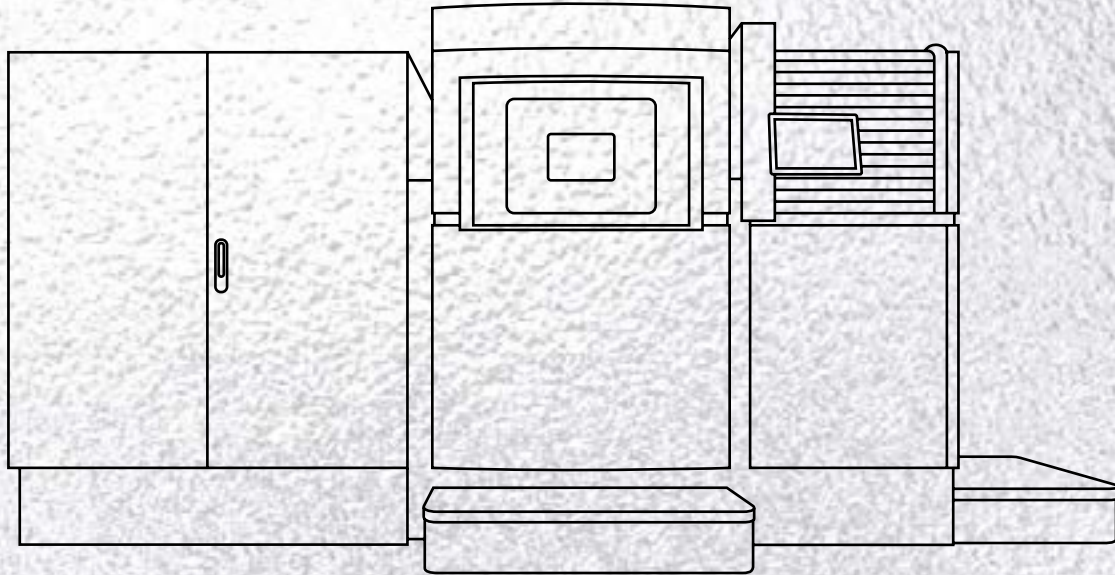
Mechanical properties tested according to EN ISO 6892-1 B10. The values in the table are average values. Heat treatment procedure in accordance with AMS 5662.

### Layout of test job

Part properties based on 2 test jobs each for the as manufactured and heat treated data.







## EOS NickelAlloy IN718 for EOS M 400-4 | 40 $\mu\text{m}$ HiPro

Process Information  
Heat Treatment  
Physical Part Properties  
Mechanical Properties

## EOS NickelAlloy IN718 for EOS M 400-4 | 40 µm HiPro

### Process Information

This process parameter includes two variations of the exposure set: the first one provides better productivity while the second one enables low angle buildability down to 20° at least<sup>1</sup>. The low angle buildability can be optimized further through the part geometry and the length of overhang.



System set-up	EOS M 400-4
EOS material set	IN718 HiPro M400-4
EOSPAR name	IN718_040_M404_100
Software requirements	EOSPRINT 2.11 or newer, EOSYSTEM 2.15 or newer
Powder part no.	9011-0020
Recoater blade	EOS HSS Blade
Nozzle	Aerospike V2
Inert gas	Argon
Sieve	63 µm

#### Additional information

Layer thickness	40 µm
Volume rate	4 x 5.2 mm <sup>3</sup> /s
Min. wall thickness	Typical 0.3 - 0.4 mm

### Heat Treatment

Heat treatment procedure conform to Aerospace Material Specification AMS 2774 and AMS 5662. As manufactured microstructure for additively manufactured IN718 consists of gamma phase ( $\gamma$ ). Heat treatment for IN718 is required to produce desired microstructure and part properties (gamma double prime precipitates,  $\gamma''$ ). Heat treatment is also used to relieve stresses.

#### Step 1:

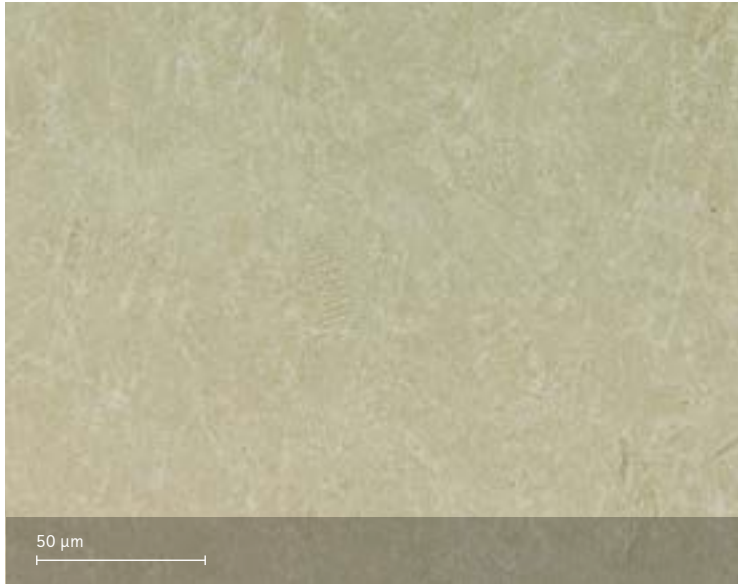
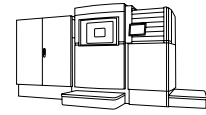
**Solution Annealing:** hold at 954 °C (1 750 °F) for 1 hour per 25 mm (0.98 inch) of thickness, air (/argon) cool

#### Step 2:

**Ageing Treatment:** hold at 718 °C (1 325 °F) 8 hours, furnace cool to 621 °C (1 150 °F) and hold at 621 °C (1 150 °F) for total precipitation time of 18 hours, air (/argon) cool



## Chemical and Physical Properties of Parts<sup>1</sup>



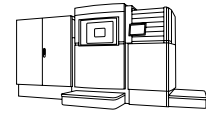
*Heat treated microstructure.  
Etched with Kalling's II etchant.*

Defects	Result	Number of samples
Average defect percentage	0.01	10

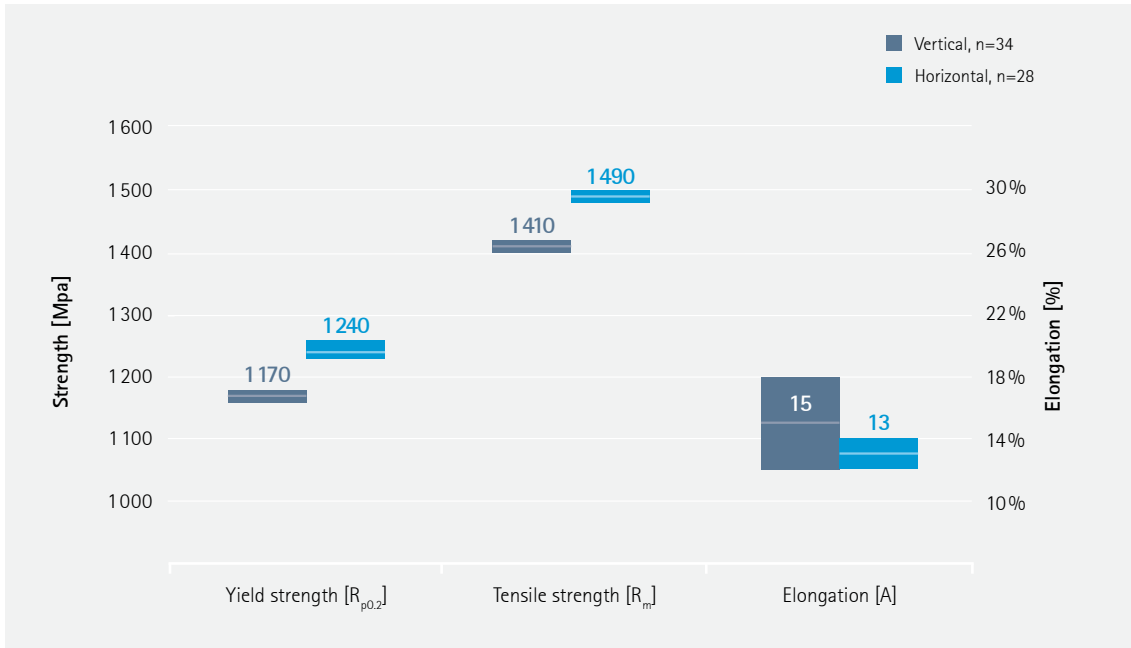
  

Density, ISO3369	Result	Number of samples
Average density	min 8.15 g/cm <sup>3</sup>	NA

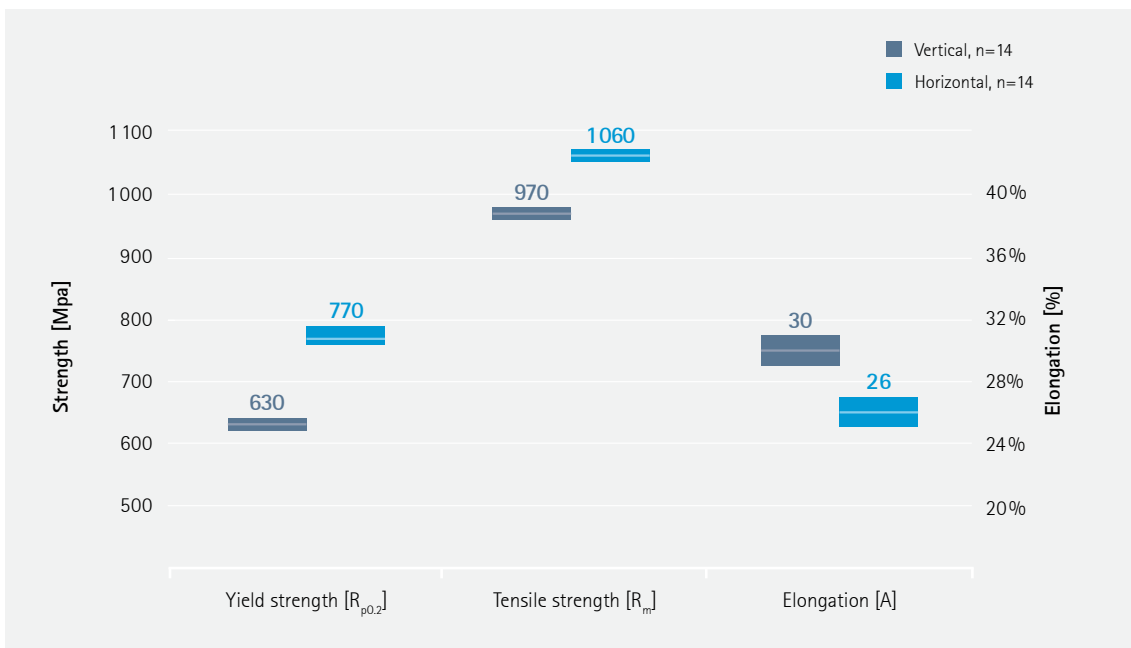
# Mechanical Properties<sup>1</sup>

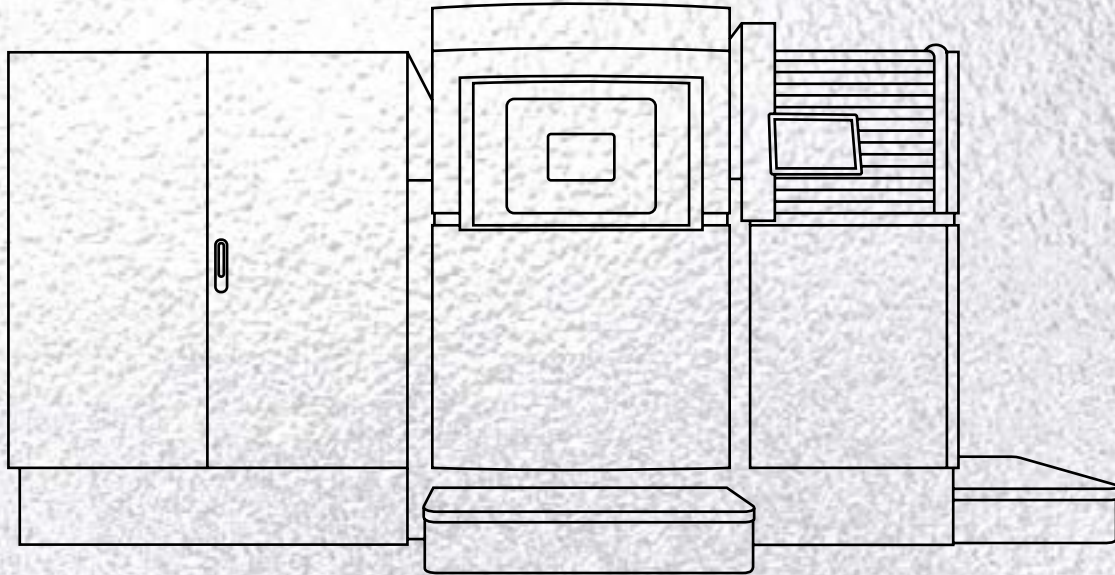


## Tensile properties heat treated



## Tensile properties as manufactured





## EOS NickelAlloy IN718 for EOS M 400-4 | 80 $\mu\text{m}$ HiPro

Process Information  
Heat Treatment  
Physical Part Properties  
Mechanical Properties

## EOS NickelAlloy IN718 for EOS M 400-4 | 80 µm HiPro

### Process Information

This process provides high productivity with a volume rate that is 119% faster than the IN718 40 µm Flexline and 77% faster than IN718 40 µm HiPro processes.

System set-up	EOS M 400-4
EOS material set	IN718 HiPro 80 µm
EOSPAR name	IN718_040_080_HiProM404_100
Software requirements	EOSPRINT 2.11 or newer, EOSYSTEM 2.15 or newer
Powder part no.	9011-0020
Recoater blade	EOS HSS Blade
Nozzle	Aerospike V2
Inert gas	Argon
Sieve	63 µm

#### Additional information

Layer thickness	80 µm
Volume rate	4 x 9.2 mm <sup>3</sup> /s
Min. wall thickness	Typical 0.3 - 0.4 mm

### Heat Treatment

Heat treatment procedure conform to Aerospace Material Specification AMS 2774 and AMS 5662.

As manufactured microstructure for additively manufactured IN718 consists of gamma phase (γ). Heat treatment for IN718 is required to produce desired microstructure and part properties (gamma double prime precipitates, γ"). Heat treatment is also used to relieve stresses.

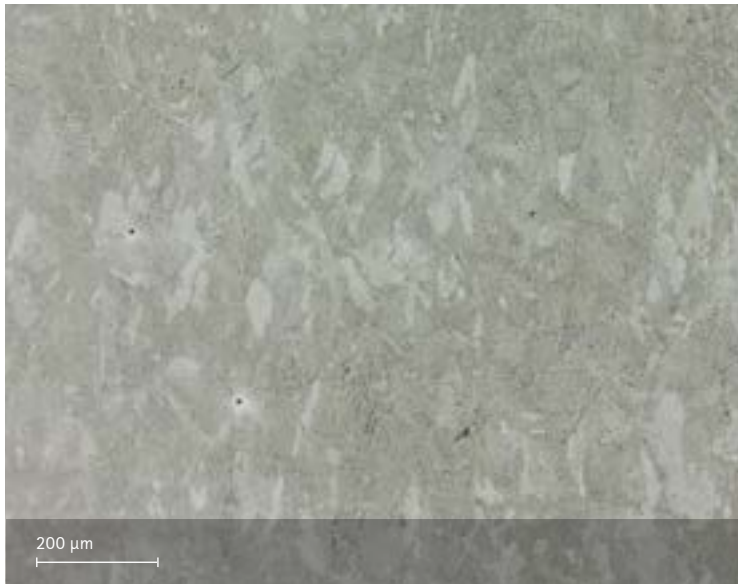
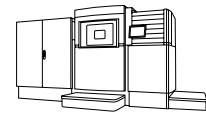
#### Step 1:

**Solution Annealing:** hold at 954 °C (1750 °F) for 1 hour per 25 mm (0.98 inch) of thickness, air (/argon) cool

#### Step 2:

**Ageing Treatment:** hold at 718 °C (1325 °F) 8 hours, furnace cool to 621 °C (1150 °F) and hold at 621 °C (1150 °F) for total precipitation time of 18 hours, air (/argon) cool

## Chemical and Physical Properties of Parts<sup>1</sup>

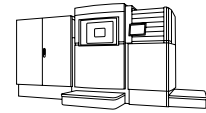


*Heat treated microstructure.  
Etched with Kalling's II etchant.*

Defects	Result	Number of samples
Average defect percentage	0.025%	13
Density, ISO3369	Result	Number of samples
Average density	min 8.25 g/cm <sup>3</sup>	NA



# Mechanical Properties in Heat Treated State<sup>1</sup>

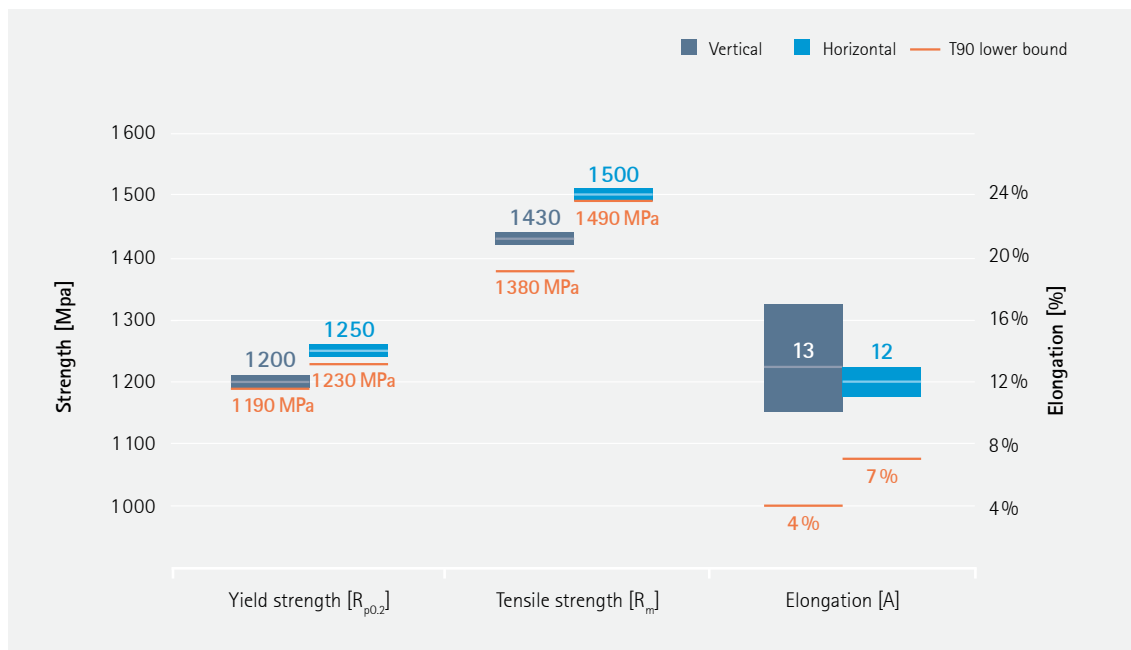


Tensile properties heat treated at room temperature  
(acc. AMS 2774 and AMS 5662)

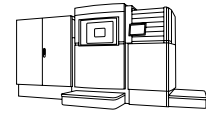
	Yield strength $R_{p0.2}$ [MPa]	Tensile strength $R_m$ [MPa]	Elongation at break A [%]	Number of samples
Vertical	1200	1430	13	30
Horizontal	1250	1500	12	30

Hardness as per ISO 6507

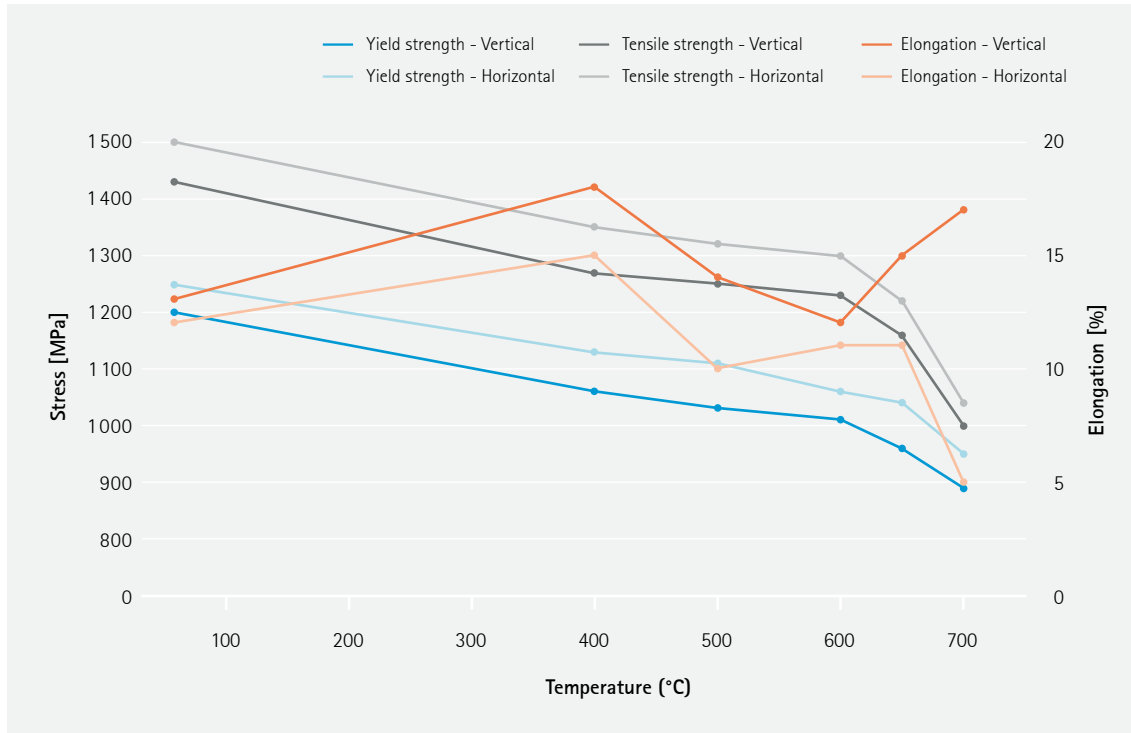
Hardness, HV	467
Number of samples	12



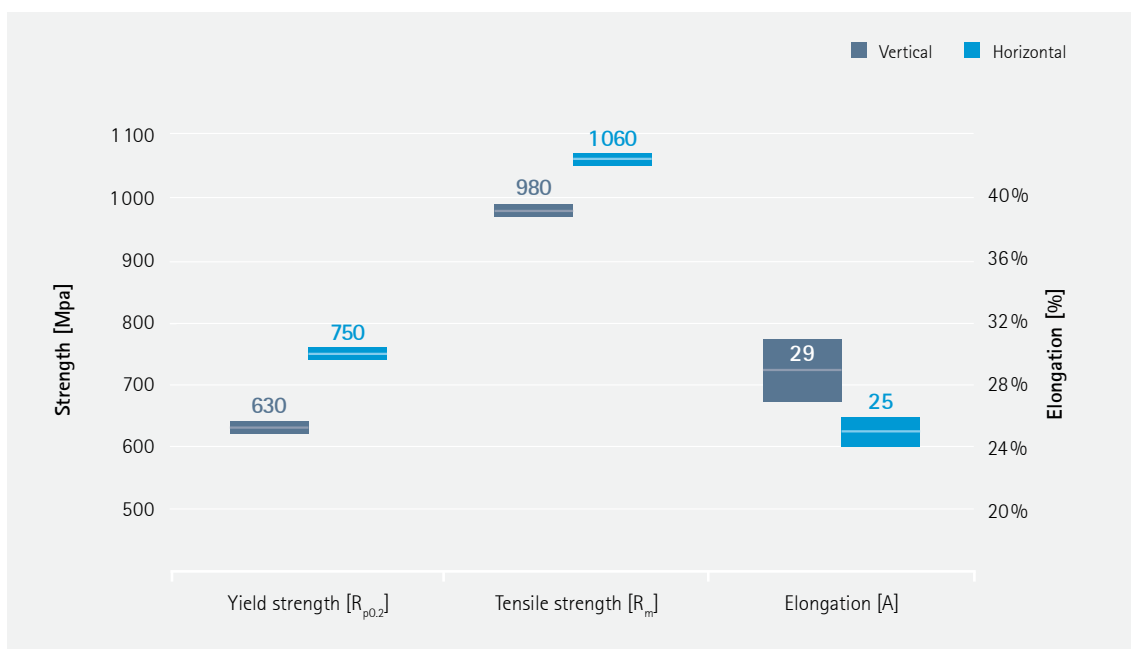
\* T90: Tolerance interval provides limits within which 90 % of the population falls with 95 % level of confidence. Tolerance intervals are based on e.g validation data / QA statistics.



### Tensile properties at elevated temperatures



### Tensile properties as manufactured



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Cover: This image shows a possible application.

