

X1 Metal 420i™

60% 420 Steel Infiltrated with 40% Bronze



ExOne™

Collaborate. Innovate. Accelerate.

X1 Metal 420i™ is a matrix material composed of 60% 420 steel infiltrated with 40% bronze. This material offers good mechanical properties, is available in both an annealed and non-annealed condition, is able to be machined, welded and polished, and offers excellent wear resistance.

Applications

This material system is ideally suited for parts exposed to highly abrasive environments such as pump components, and parts for down-hole drilling and mining equipment. Additional applications include industrial components, molds, tooling, art objects and decorative hardware.



Printed part

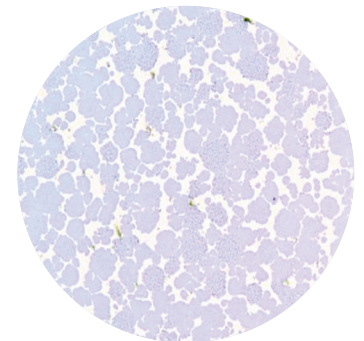
Composition

Stainless Steel: Alloy 420

Bronze: 90% Cu / 10% Sn

Printing

Using binder jetting technology, ExOne's state-of-the-art 3D printing machines produce parts directly from CAD models by precisely controlling the jetting of binder onto a powder bed, and then subsequently spreading new layers of powder. This process is repeated until the part is completed. This 3D printing process offers increased design flexibility, reduced manufacturing cost and shortened lead times.



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Post Processing

After printing is complete, the parts are cured in an oven, which enables the parts to be handled. After curing, the parts are sintered and infiltrated with bronze above 1100°C. Cool down can be varied to control the machinability and hardness of the material.

Typical Material Properties

Material Properties	Test Method	X1 Metal 420i™
Tensile Strength		
Ultimate Strength	ASTM E8	99 ksi (682 MPa)
Yield Strength (0.2% offset)		66 ksi (455 MPa)
Elastic Modulus		21.4 Mpsi (147 GPa)
Elongation		2.3%
Hardness	ASTM E18	97 HRb
Fractional Density	MPIF 42	95%+
Density		0.284 lbs/in ³ (7.86 g/cm ³)
Machinability		Refer to ExOne for recommendations
Weldability		Use silicone bronze rod & TIG weld
Thermal Conductivity	ASTM E1530	13 BTU/hr ft °F (22.6 W/m ² K)
Specific Heat	ASTM E1263	0.114 BTU/lb °F (478 J/kg ^o K)
Thermal Expansion Coefficient	ASTM E228	7.4 x 10 ⁻⁶ /°F (13.4 x 10 ⁻⁶ /°K)

Surface Finish

After sintering: ≈ 600 μin R_a (15 μm R_a)
 Bead blasting: ≈ 300 μin R_a (7.5 μm R_a)
 Barrel finishing: ≈ 50 μin R_a (1.25 μm R_a)



Printed part, raw finish



Printed part, polished

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