

Process Parameters

Laser

- Power
- Wavelength
- Spot-size
- Shape
- Pulse duration
- Pulse frequency

⋮

Scanning

- Scan speed
- Hatch spacing
- Scan path/pattern

⋮

Powder

- Particle size and distribution
- Shape
- Flowability
- Layer thickness
- Spreading speed

⋮

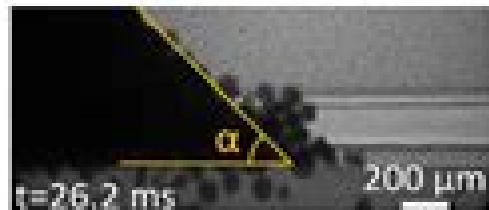
Process Chamber

- Atmospheric gas content
- Oxygen levels
- Chamber pressure
- Base-preheating
- Purging gas velocity

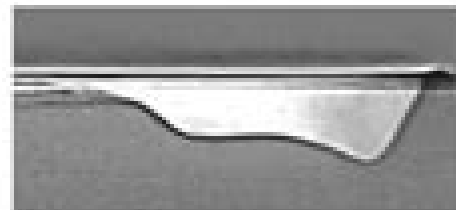
⋮

and many more...

Process Mechanisms



Powder spreading



Melting

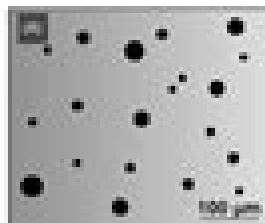


Spattering

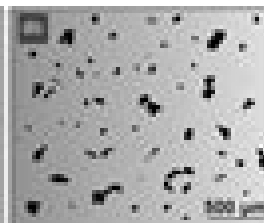


Vapor plume

Defects



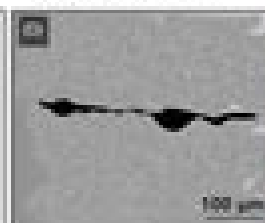
Gas/keyhole pores



Lack of fusion
(incomplete or partial melting)



Cracks



Delamination



Distortion



Materials Processing Defects

M. Predeleanu



Materials Processing Defects:

Advanced Methods in Materials Processing Defects M. Predeleanu, P. Gilormini, 1997 *Materials Processing Defects* M. Predeleanu, S.K. Ghosh, 1995-02-24 The technological field of defects and more appropriately avoidance of them is very current in perhaps all sectors of the manufacturing industry This is particularly important to reduce minimize waste everywhere to address lean production procedures The recent advances in finite plasticity and viscoplasticity damage modelling instability theories fracture modelling computer numerical techniques and process simulation etc offer new approaches and tools for defect prediction analyses and guidelines for designing components to be manufactured by traditional and emerging process technologies This volume contains contributions from well known researchers and experts in the field presenting an up to date overview of advances in this area Subjects covered include micro and macro scale observation of defects localization and instability analysis damage modelling and fracture criteria defect prediction methods design considerations to avoid defects

Proceedings of the Second International Conference on Material Processing Defects International Conference on Material Processing Defects (2, 1992, Siegburg), 1992 Advanced Methods in Materials Processing Defects M. Predeleanu, P. Gilormini, 1997-06-18 This collection of papers focus on advanced methods for predicting and avoiding the occurrence of defects in manufactured products A new feature is included namely the influence of the processing induced defects on the integrity of structures The following topics are developed damage modeling damage evaluation and rupture strain localization and instability analysis formability characterization prediction of shape inaccuracies influence of defects on structural integrity The main manufacturing operations are covered and various materials are examined such as new and conventional metal alloys ceramics polymers and composites

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Advanced methods in materials processing defects : contributions to the Third International Conference on Materials Processing Defects, July 1-3, 1997, Cachan, France M. Predeleanu, P. Gilormini, 1997 Advances in Finite Deformation Problems in Materials Processing and Structures American Society of

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