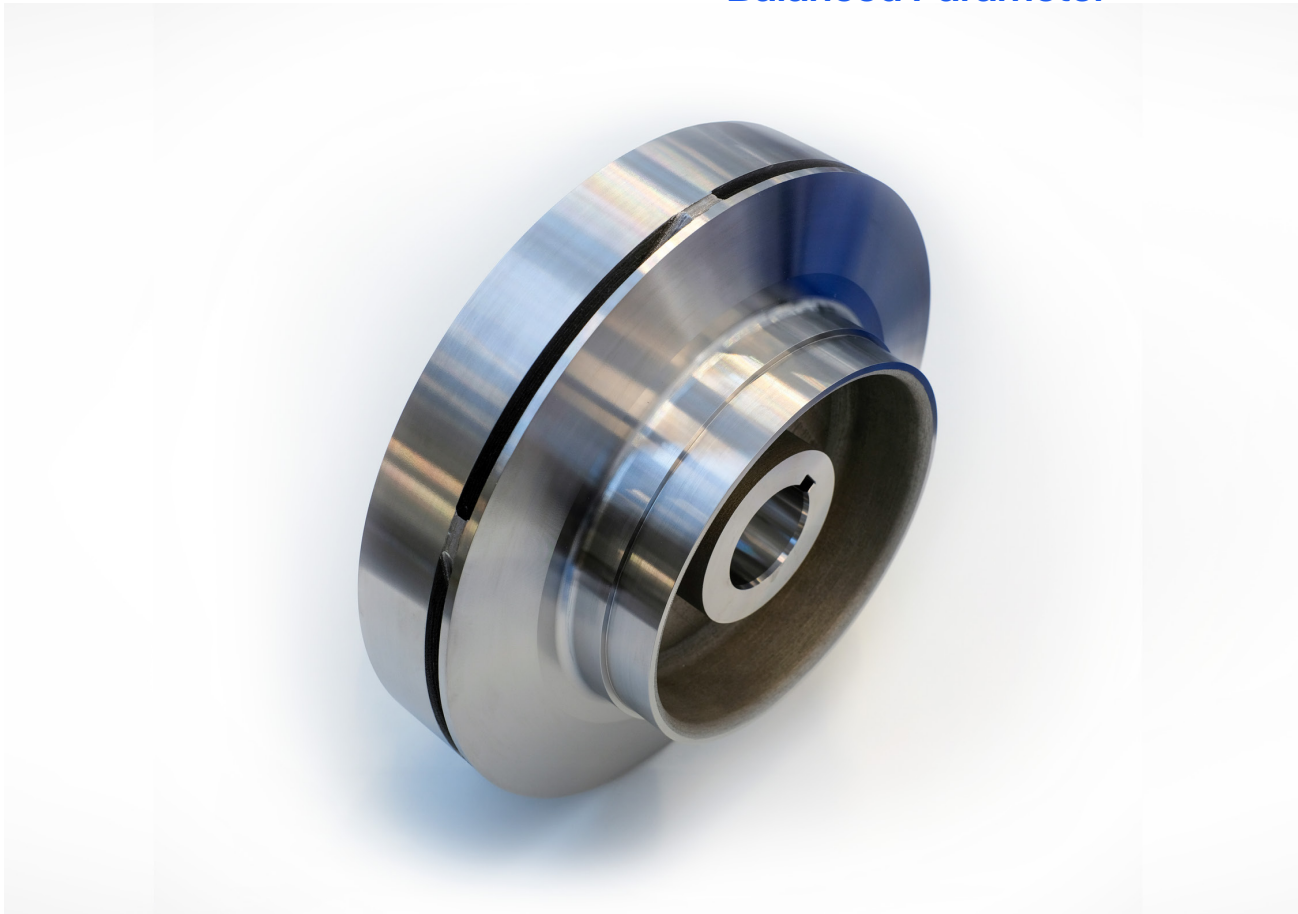




IN 625

Typical Mechanical Properties

Ultimate tensile strength	1071 MPa
Yield strength	731 MPa
Elongation at break	34%

Process Parameter



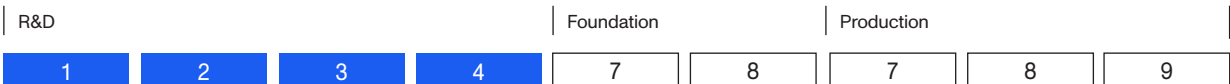
Nickel Based Alloy

A solid solution strengthening nickel alloy, characterized by having excellent mechanical properties and corrosion resistance and can be readily printed. The high strength and ductility have resulted in its use in a wide range of applications.

Highlights

- High strength and ductility
- Suited to components in high temperature environments such as aircraft engines, rocket casings and industrial gas turbines with service temperatures below 650°C
- Applications in aerospace, motorsport and energy
- Layer thickness: 80µm
- Density >99.7%
- ASTM standard mechanical properties
- Good productivity
- Minimum controlled features 0.5mm

Process Readiness Level (PRL)



To learn more,
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or visit:
additiveindustries.com

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Specifications are
subject to change
without notice.
Additive Industries
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accordance with
ISO 9001

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Powder Chemistry^[2,3]

Composition	Ni	Cr	Mo	Nb+Ta	Fe	Co	Mn	Si	Al	Ti	C	O
Min (wt%)	Bal	20.00	8.00	3.15	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Max (wt%)	Bal	23.00	10.00	4.15	5.00	1.00	0.50	0.50	0.40	0.40	0.08	0.02
Composition	S	P	N									
Min (wt%)	0.00	0.00	0.00									
Max (wt%)	0.015	0.015	0.02									

Process details

Layer thickness	80	[µm]
Build rate ^[8] (per laser)	30.24	[cm ³ /hr]
Optical density ^[4]	≥ 99.7	[%]
Volumetric density ^[11]	≥ 8.45	[g/cm ³]

Mechanical properties ^[5]	Orientation	As-built (Mean)	Standard Dev.	Heat-treat (Mean)	Standard Dev.	Units
Ultimate tensile strength	Horizontal	1071	15	-	-	[MPa]
	Vertical	870	5	-	-	[MPa]
Yield strength	Horizontal	731	10	-	-	[MPa]
	Vertical	574	5	-	-	[MPa]
Elongation at break	Horizontal	34	1	-	-	[%]
	Vertical	51	1	-	-	[%]
Youngs modulus	Horizontal	219	10	-	-	[GPa]
	Vertical	193	10	-	-	[GPa]
Vickers Hardness ^[6]		257	5	-	-	[HV10]

Surface Roughness ^[7]	Mean	Standard Deviation	Units
Vertical Surface Roughness (Ra)	8	1	[µm]
Vertical Surface Roughness (Rz)	47	5	[µm]
45° Surface Roughness (Ra)	13	3	[µm]
45° Surface Roughness (Rz)	69	15	[µm]

Notes

1. The material is processed under Argon shielding atmosphere.
2. Powder Chemistry as per Additive Industries specification O5732 Rev. 1.0.
3. Additive Industries consolidated material is in compliance with ASTM F3056-14
4. Density measured by Optical Measurement Method as per internal process. This is the minimum guaranteed value that is achieved under standard processing conditions, manufactured using Additive Industries' qualification jobs.
5. Tensile test samples were produced as round blanks. These were machined to size and tested in accordance with ASTM E8m at a NADCAP approved supplier.
6. Hardness measured in accordance with DIN EN ISO6507-1:2018

- as per internal process. Hardness values measured in XY and XZ planes from components manufactured using Additive Industries' qualification jobs.
7. Surface Roughness measured in as-printed condition in accordance with internal process. Roughness measurement conducted on specimens with varying unsupported manufacturing angle.
8. Build Rate stated is a typical value per laser. It is calculated using the formula: Layer Thickness x Laser Scan Speed x Hatch Distance.
9. Parameter released: IN625_80_BAL_MF1A55_INT_1.0.
10. Heat Treatment : NA
11. Volumetric density measured according to ASTM B962. This is a minimum volumetric density measurement achieved on samples manufactured using Additive Industries' qualification jobs.



Disclaimer

The data presented in this material datasheet is valid only for Additive Industries' released powder, machine, and parameter sets, processed under the defined shielding atmosphere. The properties of the printed parts have been measured on test coupons according to industry standards where available, and the data correspond to our state-of-the-art at the time of publication. These results are based on Additive Industries' signoff build layout and reflect material performance under the specified conditions; for more information, please contact Additive Industries. Users should be aware that variations in the presented values may arise due to differences in process conditions, including but not limited to thermal management, build plate temperature, job-specific heat accumulation, inter-layer time, part positioning, and overall machine calibration. The data provided do not warrant any guarantee for printed parts, and it remains the responsibility of the producer or purchaser to verify the ultimate properties of the printed material for their specific application. The listed data are subject to change without notice as we continuously strive to develop and improve our machine performance and the properties of printed materials. Users are advised to exercise caution and consider material selection, build layout, and machine configuration when interpreting and applying this information.

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