

M300 Tool Steel

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Material & Process Capability

M300 Tool Steel is an ultra-low carbon alloy with very high strength & hardness properties derived from intermetallic compounds rather than carbon content. The material is comprised mainly of nickel, with cobalt, molybdenum, & titanium as secondary intermetallic alloying metals.

It is ideal for tooling applications such as High Pressure Die Cast (HPDC) inserts, injection molding, and other types of tooling.

The Velo3D end-to-end manufacturing solution uniquely enables companies to build the parts they need without compromising design or quality - resulting in complex parts higher in performance than traditional casting techniques or other additive methods.



General Process

This data sheet specifies the expected mechanical properties and characteristics of this alloy when manufactured on a Velo3D Sapphire System. All data is based on parts built using Velo3D standard 50 µm layer thickness parameters, using Praxair FE-339-3, a Velo3D-approved powder. Parts built from M300 on a Sapphire System can be heat treated like those manufactured by other methods.

	Sapphire Sapphire 1MZ	Sapphire XC Sapphire XC 1MZ
Typical Volume Rate ¹ , cc/hour	up to 40	up to 160
Density, g/cc (lbs/cubic in)	8.0 (0.29)	
Relative Density, percent	99.9+	
Surface Finish ² , S _a , µm (µin)	<15 (590) for angles >25° from horizontal	

Mechanical Properties at Room Temperature

Property ³	As Printed		After Heat Treatment 1 ⁴		After Heat Treatment 2 ⁵	
	Mean	Mean-3σ	Mean	Mean-3σ	Mean	Mean-3σ
Modulus of Elasticity, GPa (msi)	130 (18.9)	105 (15.2)	170 (24.7)	160 (23.2)	165 (23.9)	145 (21.0)
Ultimate Tensile Strength, MPa (ksi)	1015 (147.3)	995 (144)	1490 (216.2)	1470 (213.3)	1295 (187.9)	1280 (185.7)
Yield (0.2% Offset), MPa (ksi)	800 (116)	780 (113)	1280 (185.7)	1265 (183.5)	860 (125)	805 (117)
Elongation At Break, percent	18	14	15	12	21	17
Charpy V-notch, J ⁶	44	31	11	8	22	15
Hardness, HRC	29	25	37	35	43	40

1. Geometry-dependent. **2.** Depends on orientation and process selected. **3.** All specimens were printed in argon atmosphere and tested using ASTM E8/E8M-22, ASTM E23-18, or ASTM E18-22. Mechanical & tensile samples printed in vertical orientation & machined. **4.** Solution at 850°C, 2 hours and age 600°C, 6 hours. **5.** Solution at 850°C, 2 hours and age 650°C, 3 hours. **6.** Charpy blocks were printed in the XY direction and machined.