

ABSTRACT

An object of the present invention is to provide a method for manufacturing a metal printed object, which can reduce the manufacturing time by a simple method without requiring a large-scale modification of the manufacturing apparatus, and the

5 present invention provides a method for manufacturing a metal printed object in which, in the presence of a shielding gas supplied around a metal powder on a base plate, heat is supplied to the metal powder using energy rays to print a metal layer on the base plate, and the metal layer is subsequently laminated, wherein when modeling a first metal layer in contact with the base plate, mass per unit volume of the shield gas at a

10 temperature of 25°C and a pressure of 0.1 MPa is in a range of $1.00 \times 10^{-4} \text{ g/cm}^3$ to $1.3 \times 10^{-3} \text{ g/cm}^3$.