

Figure 1

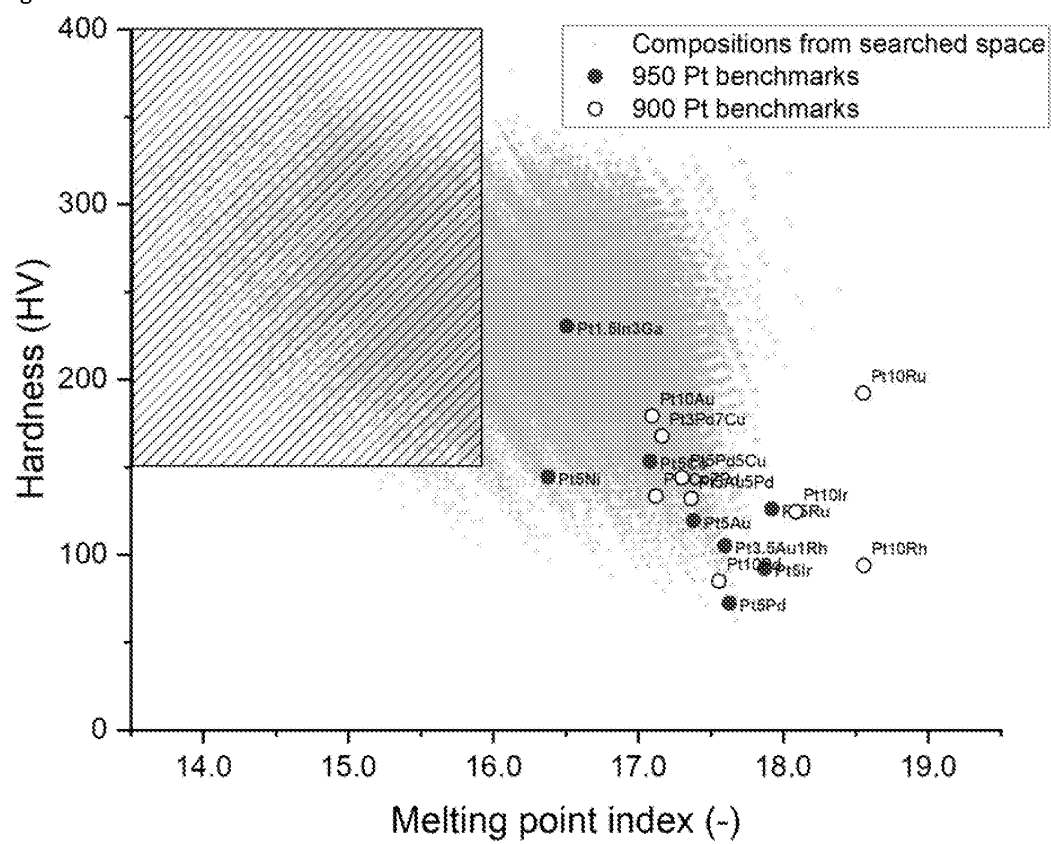


Figure 2

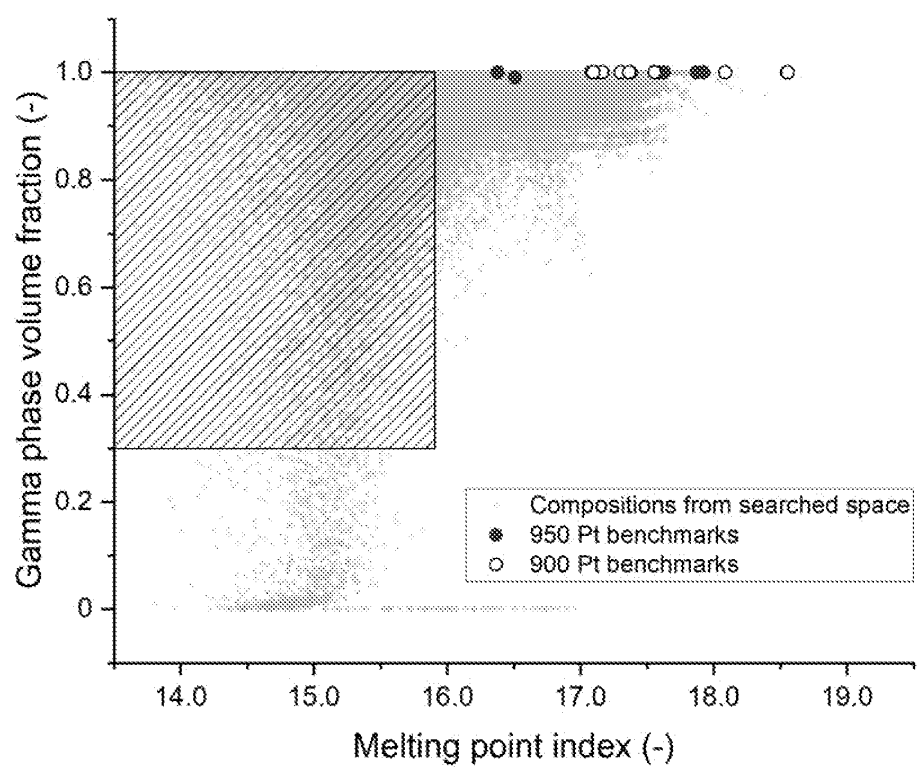


Figure 3

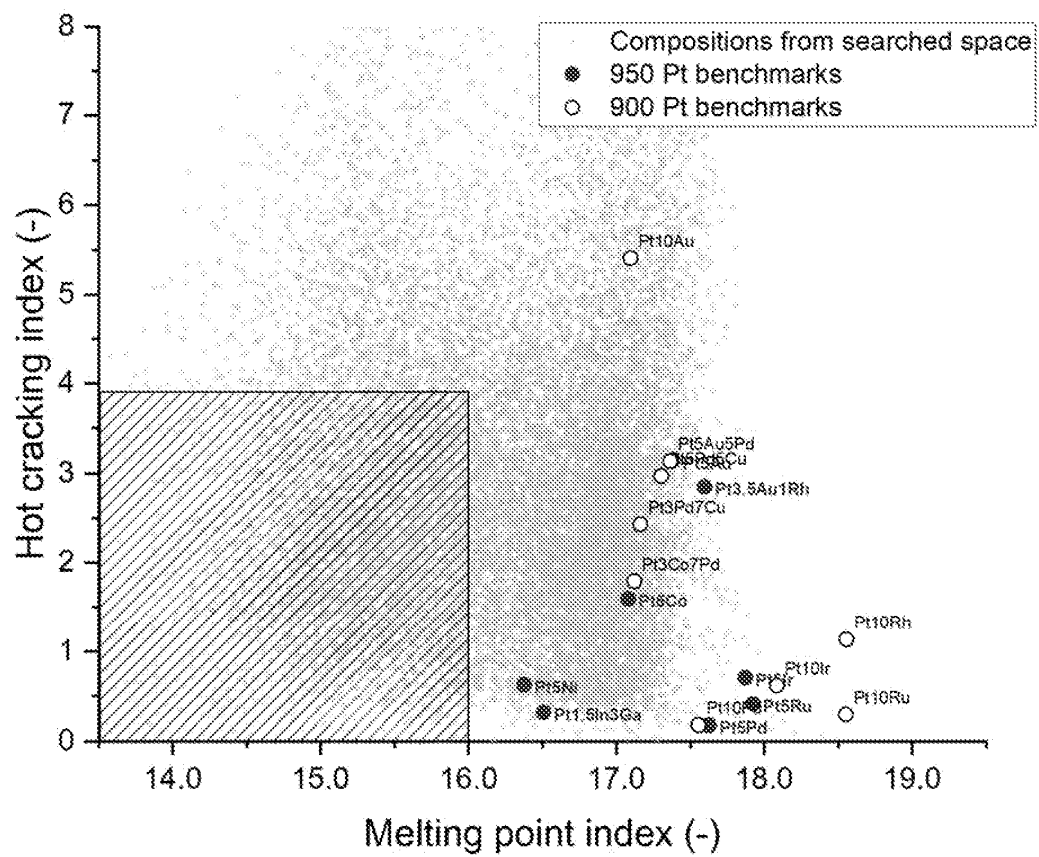


Figure 4

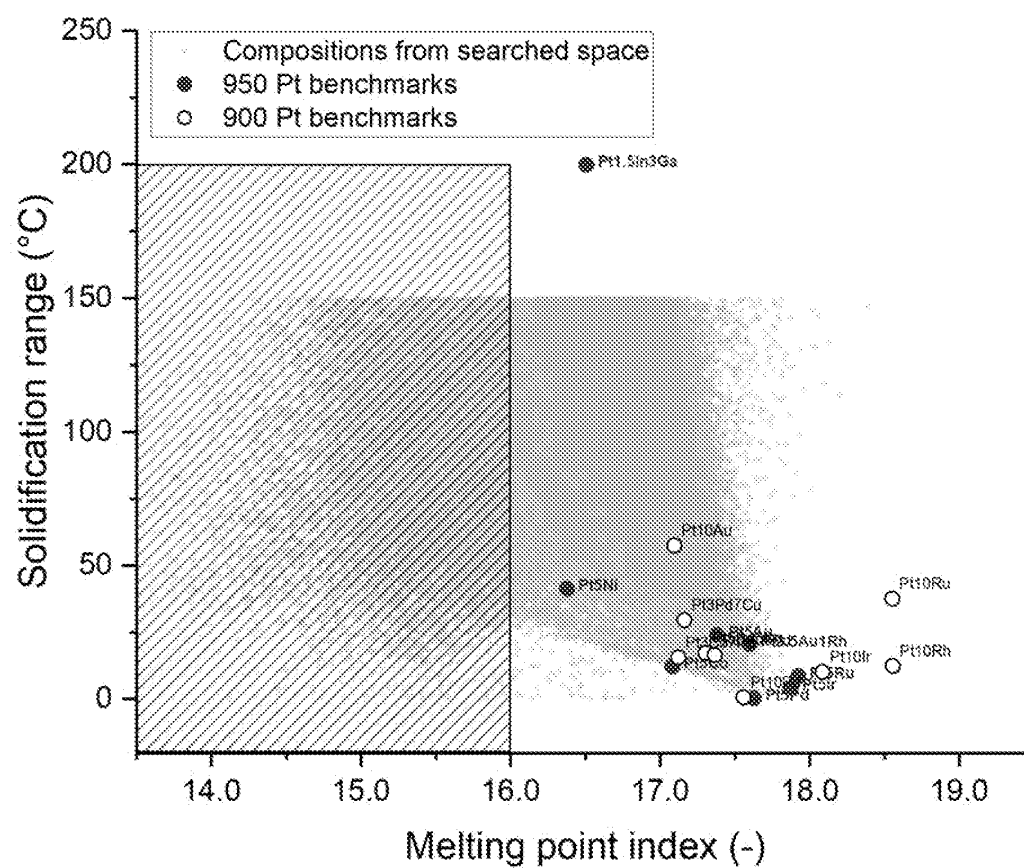
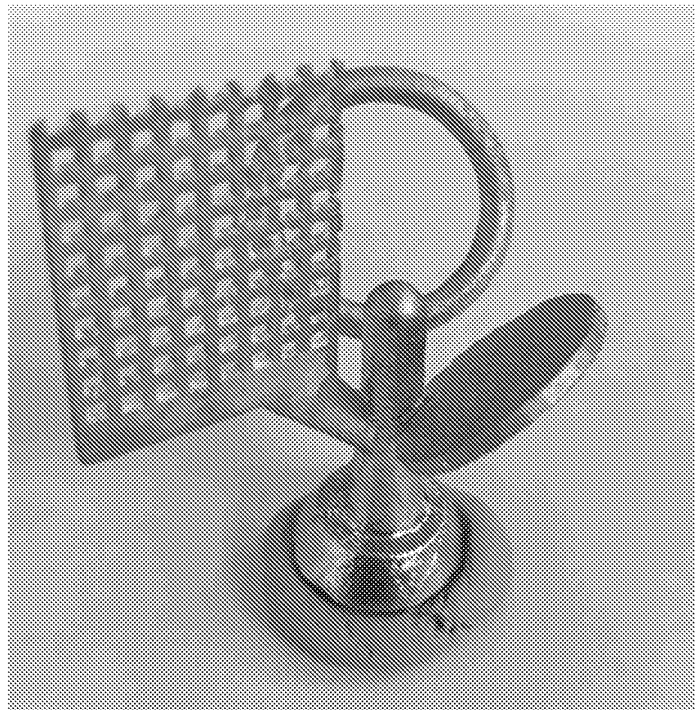
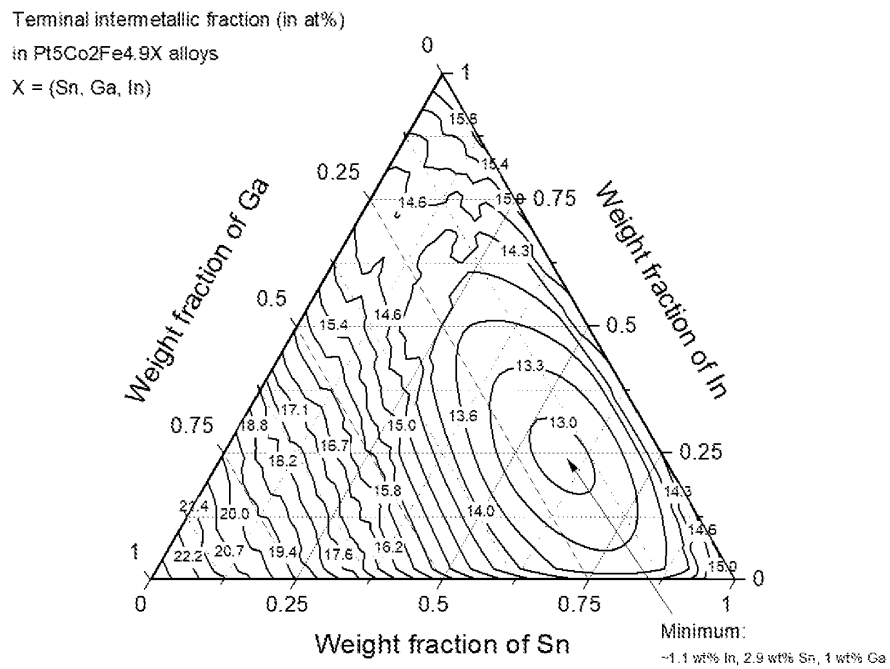


Figure 5



Tree design for castings (height ~60 mm)

Figure 6

Figure 7

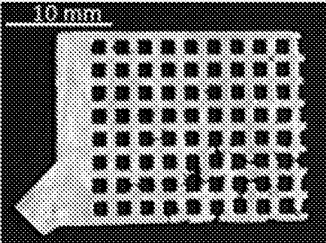
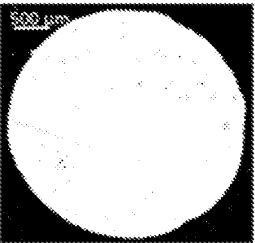
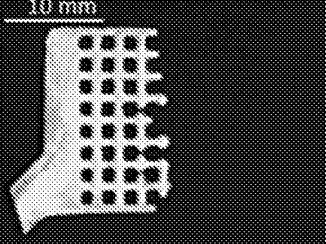
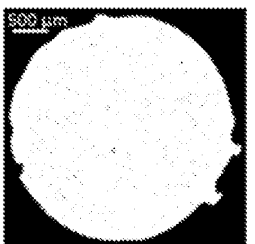
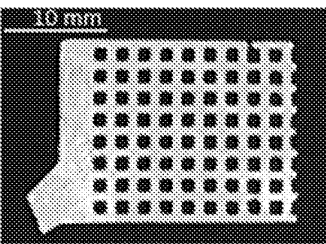
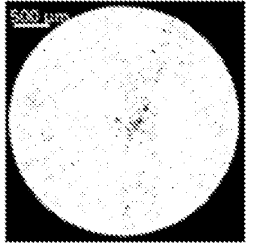
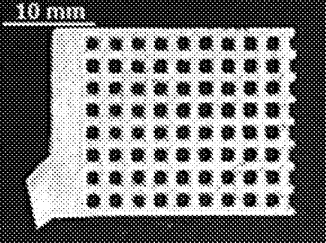
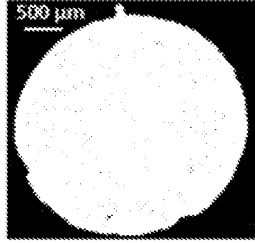
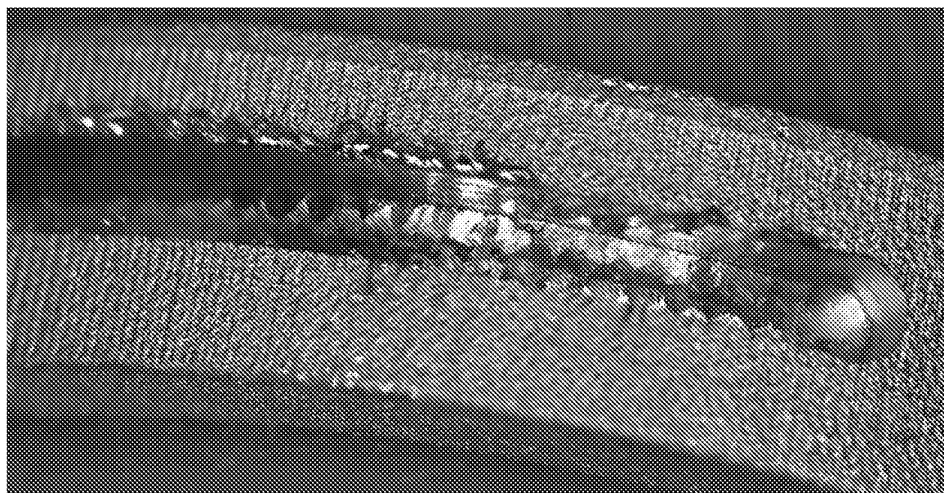
	Hardness / HV1	Grid fill	Porosity
Comparative example 1	123 ± 3	 100 %	 0.48 %
Comparative example 2	135 ± 3	 45 %	 0.27 %
Comparative example 3	275 ± 10	 100 %	 1.32 %
Example 0	170 ± 10	 100 %	 0.53 %

Figure 8

Comparative
example 2



Example 0

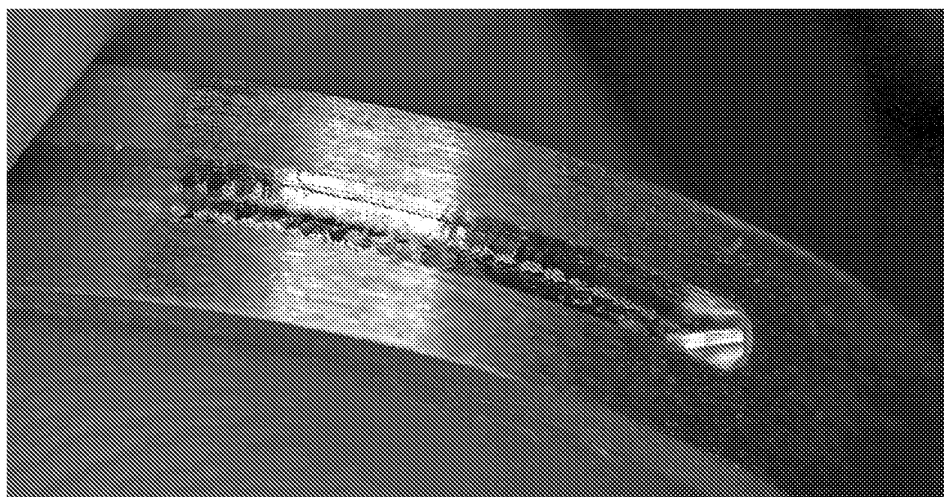


Figure 9

