

ZRapid
Mold steel CX
Material Data Sheet

ZRapid Mold steel CX

Combines Corrosion Resistance with High Strength and Hardness

ZRapid Mold steel CX is a tooling grade steel characterized by having a good corrosion resistance combined with high strength and hardness. Parts built from ZRapid Mold steel CX can be machined, shot-peened and polished in as manufactured or heat treated state.

Main Characteristics:

- Stainless steel with excellent corrosion resistance combined with high strength and hardness
- The parts are easily machinable and offer excellent polishability
- The parts offer excellent wear and fatigue resistance

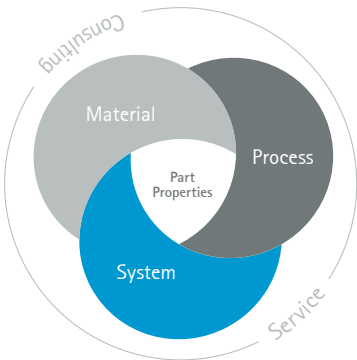
Typical Applications:

- Plastic injection molding tools and tool parts for demanding applications
- Rubber molding tools and tool parts
- Molding tools and tool parts for corrosive plastics
- Other industrial applications where high strength and hardness are required

The ZRapid Quality Triangle

ZRapid uses an approach that is unique in the AM industry, taking each of the three central technical elements of the production process into account: the system, the material and the process – together simply described as the Quality Triangle. ZRapid focuses on delivering reproducible part properties for the customer.

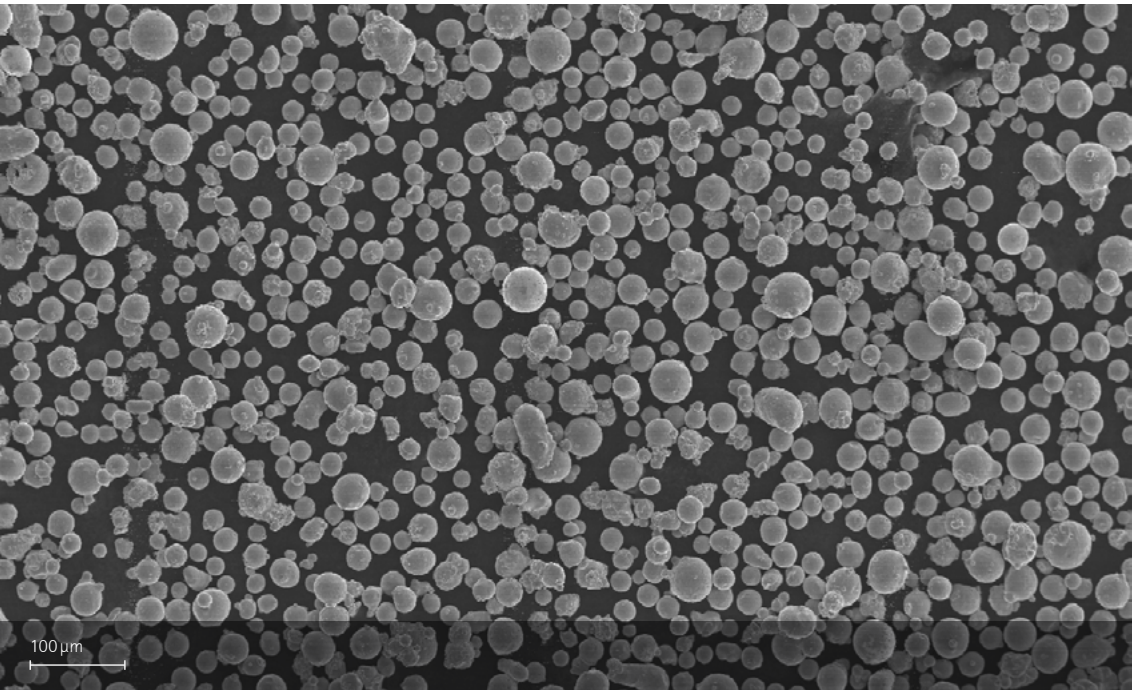
All of the data stated in this material data sheet is produced according to ZRapid Quality Management System and international standards.



Powder Properties

Powder chemical composition (wt.-%)			Powder particle size	
Element	Min.	Max.	Generic particle size distribution	15 – 53 μm
Fe	Balance			
Cr	11.00	13.00		
Ni	8.40	10.00		
Mo	1.10	1.70		
Al	1.20	2.00		
Mn	–	0.20		
Si	–	0.22		
C	–	0.051		

SEM image of ZRapid Mold steel CX powder.



Process Information

System set-up	ZRapid SLM280
ZRapid ParameterSet	SLM280 CX -0.04mm
ZRapid name	ZRapid CX
Software requirements	ZRapid Presto 4.0
Powder part no.	CX
Recoater blade	ZRapid stainless steel blade
Nozzle	ZRapid grid nozzle
Inert gas	Argon
Sieve	53 µm

Additional information

Layer thickness	40 µm
Volume rate	3.2 mm³/s
Min. wall thickness	Approx. 0.4 mm
Typical dimensional change after HT (for parts ø 50 mm)	0.1 %



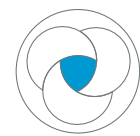
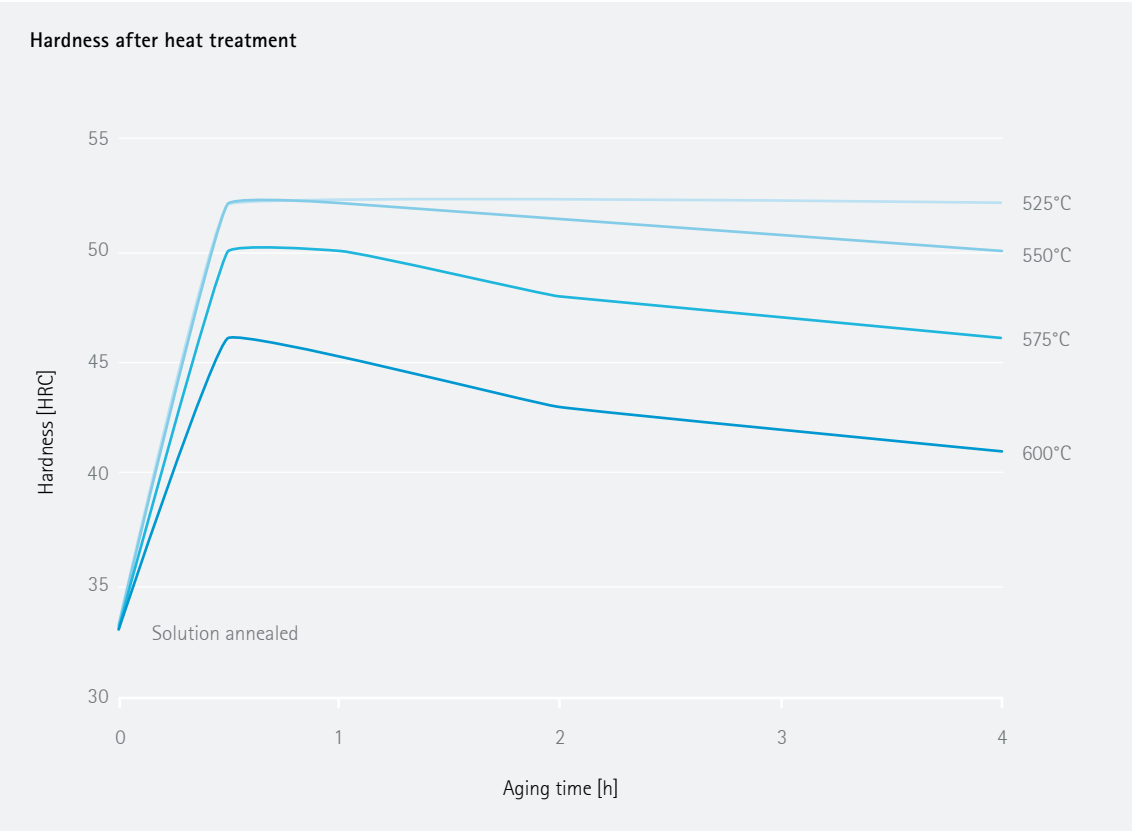
Heat Treatment

ZRapid Mold steel CX can be heat treated to match various needs of different applications. The two step heat treatment can be performed under vacuum or inert gas atmosphere. First step is solution annealing to minimize amount of austenite in the martensitic matrix. The needed hardness and strength is achieved through aging treatment where precipitation hardening takes place.

Solution Annealing:
30 minutes at 850 °C (±10 °C) measured from the part followed by rapid air cooling to room temperature (below 32 °C). Cooling rate 20-60 °C/min. Reaching room temperature before starting aging treatment is required to achieve desired microstructure.

Aging:
For peak hardness and strength 2 h at 525 °C (±10 °C) measured from the part followed by air cooling. Mechanical properties presented in this document achieved through this aging procedure.

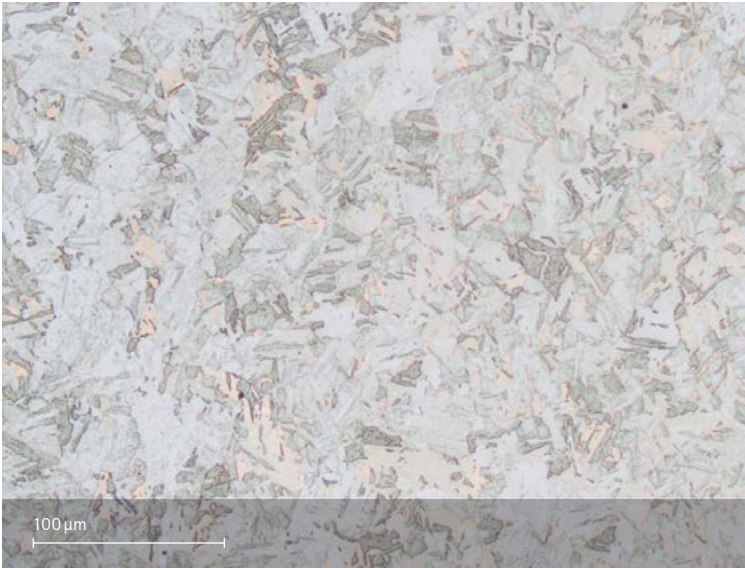
If lower hardness and improved toughness is required aging temperature can be increased according to figure below.



Chemical and Physical Properties of Parts



Chemical composition of built parts is compliant to **ZRapid** Mold steel CX powder chemical composition.



Heat treated microstructure.
Etching; ASTM E407-94

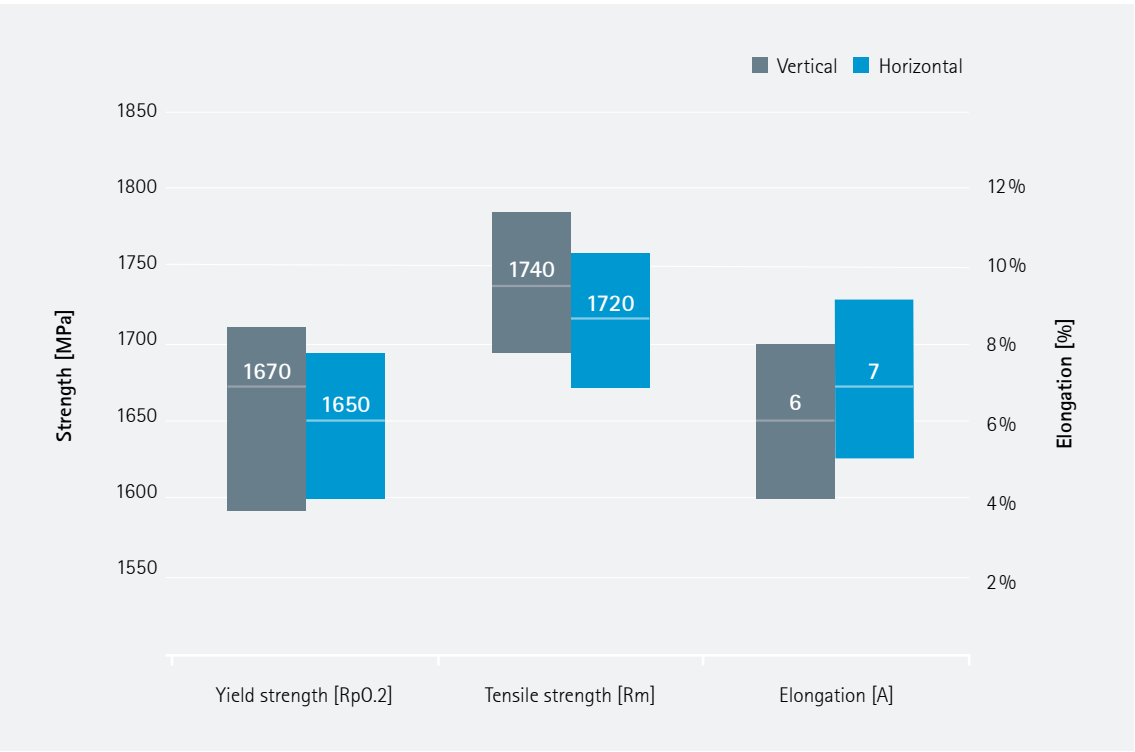
Defects	Result	Number of samples
Average defect percentage	0.03 %	65
Density, ISO3369	Result	Number of samples
Average density	7.69 g/cm ³	65

The areal defect percentage was determined from cross-cuts of the built parts using an optical microscope fitted with a camera and analysis software. The analysis was carried out for sample area of 15 x 15 mm. The defects were detected and analyzed with an image capture/analysis software with an automatic histogram based filtering procedure on monochrome images. The density of the built specimen was measured according to ISO3369.

Mechanical Properties in Heat Treated State

Mechanical properties ISO6892-1				
	Yield strength Rp0.2 [MPa]	Tensile strength Rm [MPa]	Elongation at break A [%]	Number of samples
Vertical	1670	1740	6	189
Horizontal	1650	1720	7	162

Hardness in heat treated state ISO6508	
Hardness, HRC	50
Number of samples	45



Additional Data



Fatigue Strength

Fatigue strength determines a stress level where specimen fails at a defined number of stress cycles [ISO 12107]. Fatigue strength was estimated statistically according to ISO 12107.

Fatigue strength at 1 x 10 ⁷ cycles in heat treated state ASTM E466	
Fatigue strength, MPa	699

Testing was done according to ASTM E466. Fatigue results typically show large deviations due to the nature of the fatigue process [ISO 12107].

Corrosion Resistance Comparison of Tooling and Precipitation Hardening Steels

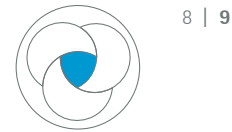
ZRapid Material	Hardness [HRC]	Corrosion resistance
ZRapid MaragingSteel MS1	54	–
ZRapid Mold steel CX	52	● ● ● ●
ZRapid Mold steel PH1	43	● ● ● ●
ZRapid Mold steel 17-4PH	42	● ● ● ● ●

Corrosion Resistance
Corrosion resistance comparison between ZRapid tooling and precipitation hardening steels based on potentiody-namic measurement data.

Coefficient of Thermal Expansion
ASTM E228

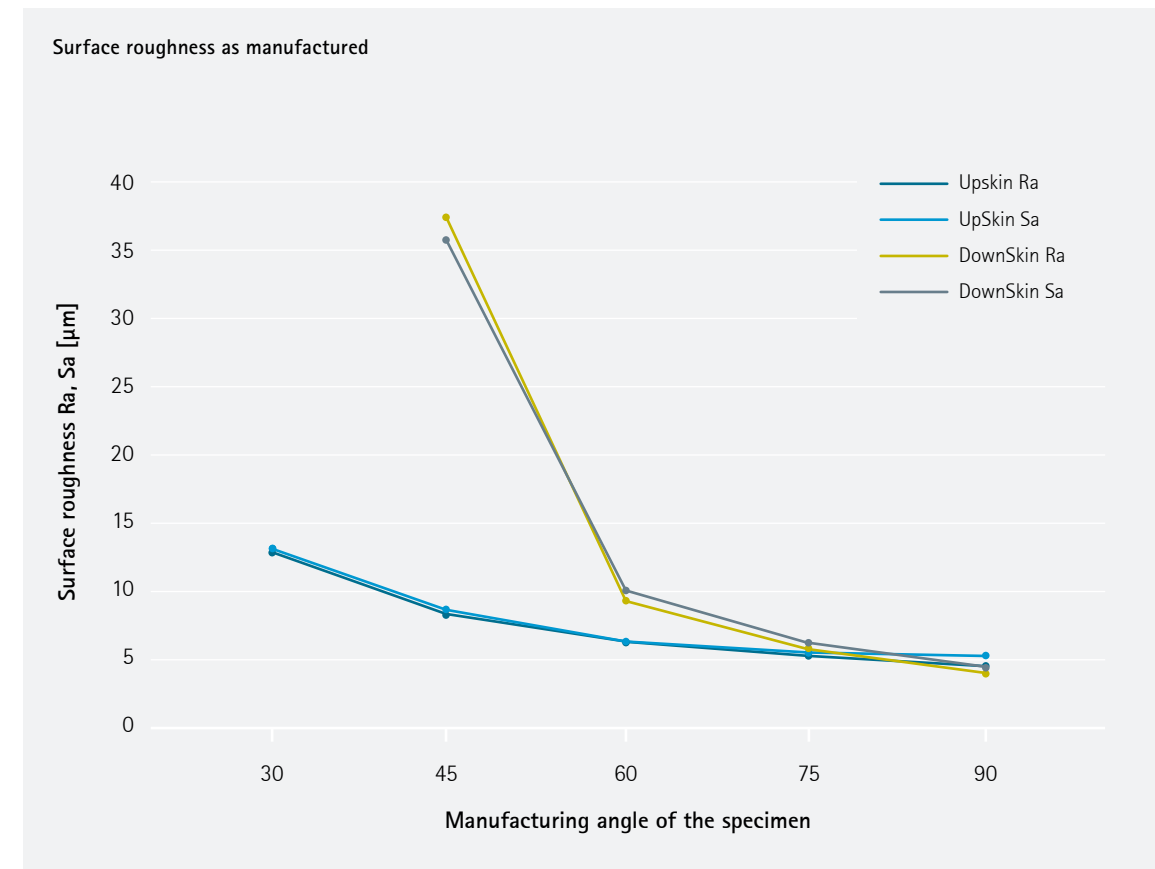
Temperature	25 – 100 °C	25 – 200 °C	25 – 300 °C	25 – 400 °C
CTE	11.1 *10 ⁻⁶ /K	11.6 *10 ⁻⁶ /K	11.9 *10 ⁻⁶ /K	12.0 *10 ⁻⁶ /K

Additional Data



Surface Roughness

Horizontal surface	Ra 7.5 μm, Sa 9.0 μm
Vertical and angled surfaces according to figure	



The surface quality was characterized by optical measurement method according to internal procedure. The 90 degree angle corresponds to vertical surface.

Headquarters

ZRapid Tech
No.13, Tongan Road
West, Suzhou, Jiangsu
Province, China.
Phone +86 51263398290
Fax +86 51263398240

www.zero-tek.com



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Cover: This image shows a possible application.

中瑞科技(ZRapid Tech) Rapid Prototyping Machine Et Service Supplier
ADD: No.13, Tongan Road West, Suzhou, Jiangsu Province, China.
Tel: 86-512-63398290 www.zero-tek.com

