



**Metal Additive Manufacturing
Solutions & Services**

wipro 3D

A wide-angle photograph of a modern corporate campus. In the foreground, a paved walkway leads towards a series of tiered water fountains. To the right is a well-maintained green lawn with several flagpoles. In the background, there are large, white, multi-story office buildings with glass windows, surrounded by lush green trees under a clear blue sky with some clouds.

WIPRO
*A diversified global
conglomerate*

Who we Are

About Wipro Group



WORLD'S MOST ETHICAL
COMPANY – 10th YEAR IN A ROW



\$ 9 + BILLION
CONSOLIDATED REVENUES
(FY 2019-20)



1,90,000 +
WORKFORCE



1180 ACTIVE CLIENTS
Presence IN
63 COUNTRIES



USD 21Bn \$
MARKET CAPITALIZATION



IT PRODUCTS &
SERVICES

Wipro Technologies

- IT
- BPO
- R&D Services
- Consulting Services



INFRASTRUCTURE ENGINEERING

Wipro Infrastructure Engineering

- Hydraulic Cylinders
- Truck Hydraulic Solutions
- Aerospace And Defense
- Industrial Hydraulics
- Wipro Water
- Industrial Automation



ADDITIVE
MANUFACTURING

WIPRO3D

- Metal Additive Manufacturing
Solutions & Services



CONSUMER CARE &
LIGHTING

Wipro Consumer Care & Lighting

- Personal Care
- Baby Care
- Wellness Products
- Lighting Furniture And Switches

Joint Ventures

**Wipro Kawasaki Precision
Machinery**

Hydraulic Pumps and Swing Motors
for Excavators

**Wipro-GE
Healthcare**

Healthcare Equipment
and Solutions

Wipro Infrastructure Engineering: Global Reach

Workforce : 2300 +
Facilities : 16
Legacy : 40 + years
in mfg



USA

Chambersburg
Rochester
Everett.

BRAZIL

Piracicaba
Plant area: 9,000 sq.m.

EUROPE

Pernio – Finland | Plant area: 16,000 sq.m.
Bispgarden – Sweden | Plant area: 3,500 sq.m.
Ostersund – Sweden | Plant area: 8,000 sq.m.
Rm Valcea – Romania | Plant area: 12,000 sq.m.
Skelleftea – Sweden | Tech and Protoshop
Israel : Aerostructure

INDIA

Bengaluru | Plant area: 15,800 sq.m. | Tech and Protoshop
Chennai | Plant area: 10,500 sq.m.
Hindupur (plant 1) | Plant area: 9,675 sq.m.
Hindupur (plant 2) | Plant area: 19,000 sq.m.



Aerospace & Defence

Aerospace play

Engineering

- Design
- Stress analysis
- Certification
- Manufacturing

PLM

- Product Data Management
- Knowledge Based Engineering (KBE)
- Manufacturing Solutions

Testing

- Qualification and pre-compliance testing covering DO160F and various MIL standards

Avionics

- Cabin Systems & IFEC
- Navigation
- Communication
- Cockpit Electronics

Consulting

- Sourcing, Market Strategies
- Benchmarking
- ECM, ILM



Aerospace & defense – Our credentials



Manufacturing Credentials

Current Products and Programs

- B787 – PDOS Cylinders and Pistons
- A330 – Nose Landing Gear Retraction & Locking Actuator
- A340 – Nose Landing Gear Retraction & Locking Actuator
- A380 – Nose Landing Gear Retraction Actuator
- A320 Neo – Power Door Opening System (PDOS) Cylinder & Piston

Product Portfolio

- Actuators & Parts
- Manifold / Valve Blocks
- Hydraulic components
- Other precision components

Manufacturing Facilities

- USA, Everett, 28,000 ft²
- Israel, Kiryat Bialik, 125,000 ft²
- India, Bengaluru



IT Services Credentials

Engineering & Manufacturing

- Certification Manufacturing
- Connected Cabin
- Avionics
- PLM integration
- Pre-compliance testing covering DO160F & other standards

Supply chain & IT transformation

- Work Transfer Management
- MRO
- Cyber Security Services
- SAP S4 HANA
- ServiceNow
- Workday & SFDC
- Office 365 capabilities
- SIAM
- Cloud offerings



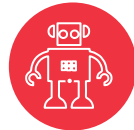
We are investing to be partners of the future

Investment Areas



Advanced Analytics

- Predictive asset maintenance
- Anomalous event analytics
- Flight schedule optimizer
- Warranty analytics
- Fraud analytics
- Social media analytics



Robotic Process Automation

- Upto 70% productivity benefits
- Process excellence & automation implementation
- Focus on
 - Order entry and validation
 - Inventory reporting, compliance reporting



Additive Manufacturing

- AM Material Research
- Engineering Design
- Additive Engineering & Topology Optimization
- Complex Machining and Assemblies
- AM Sample & Serial Production with Post Processing
- R&D
- Managed AM Services



Blockchain

- Airworthiness certificate
- Provenance tracking to combat conflict minerals
- Smart Diagnostics and machine maintenance



AR/VR

- MRO solution through AR & VR
- Both mobile and wearable AR & VR solutions
- Enhanced field service efficiency

➤ Creating experience-led, high velocity business models that operate on a global scale

➤ Accelerating Wipro's transformation to a digital culture by training 17,500 of our engineers in digital technologies

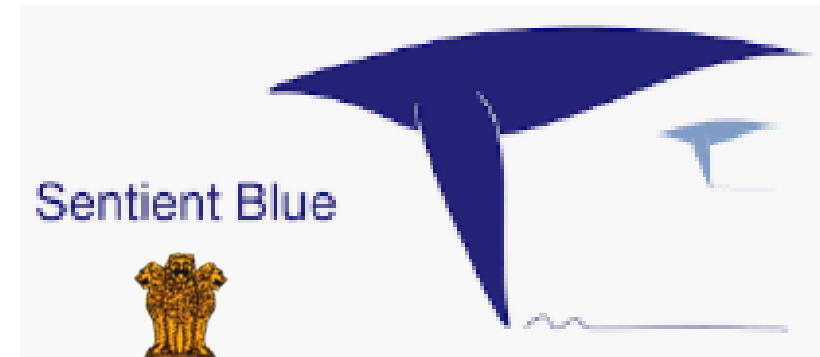
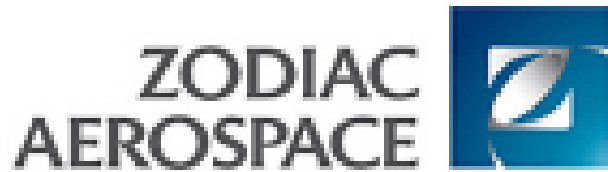
➤ Transforming IT and business processes through intelligent automation

➤ Expanding local capabilities across multiple geographies globally through acquisition and new delivery centers

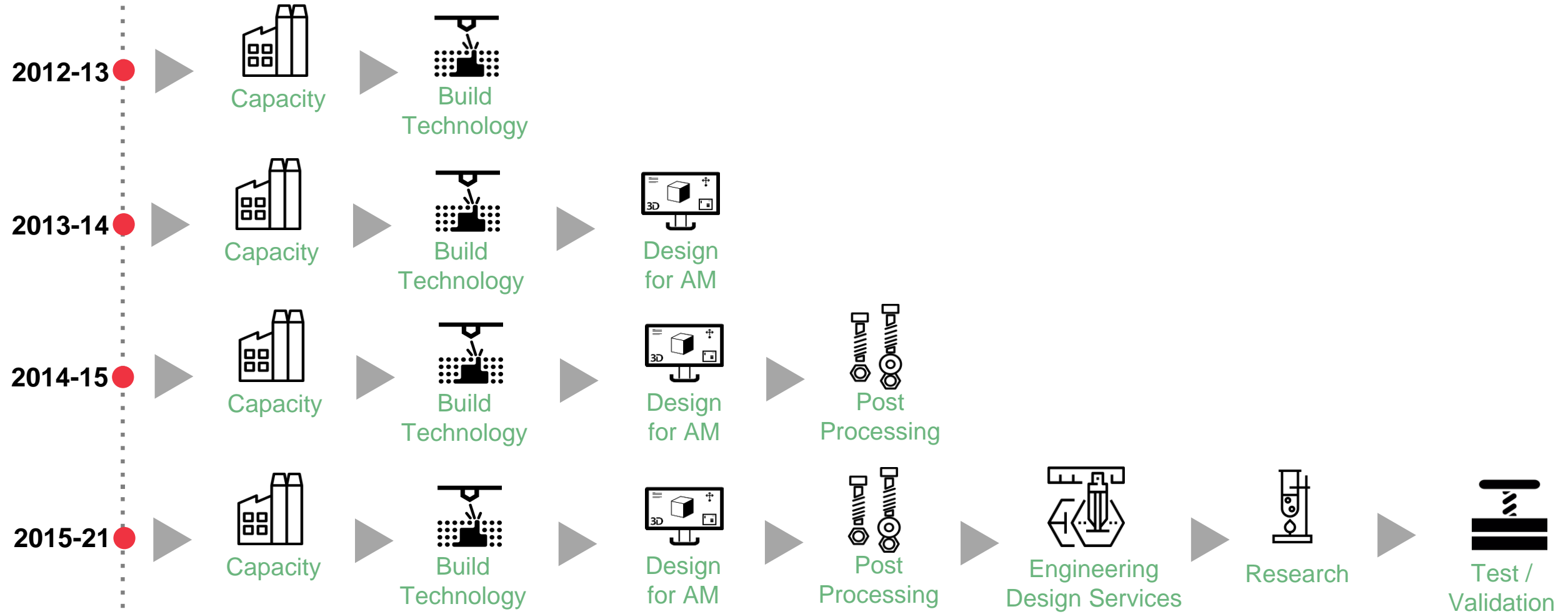
Additive Manufacturing Solutions



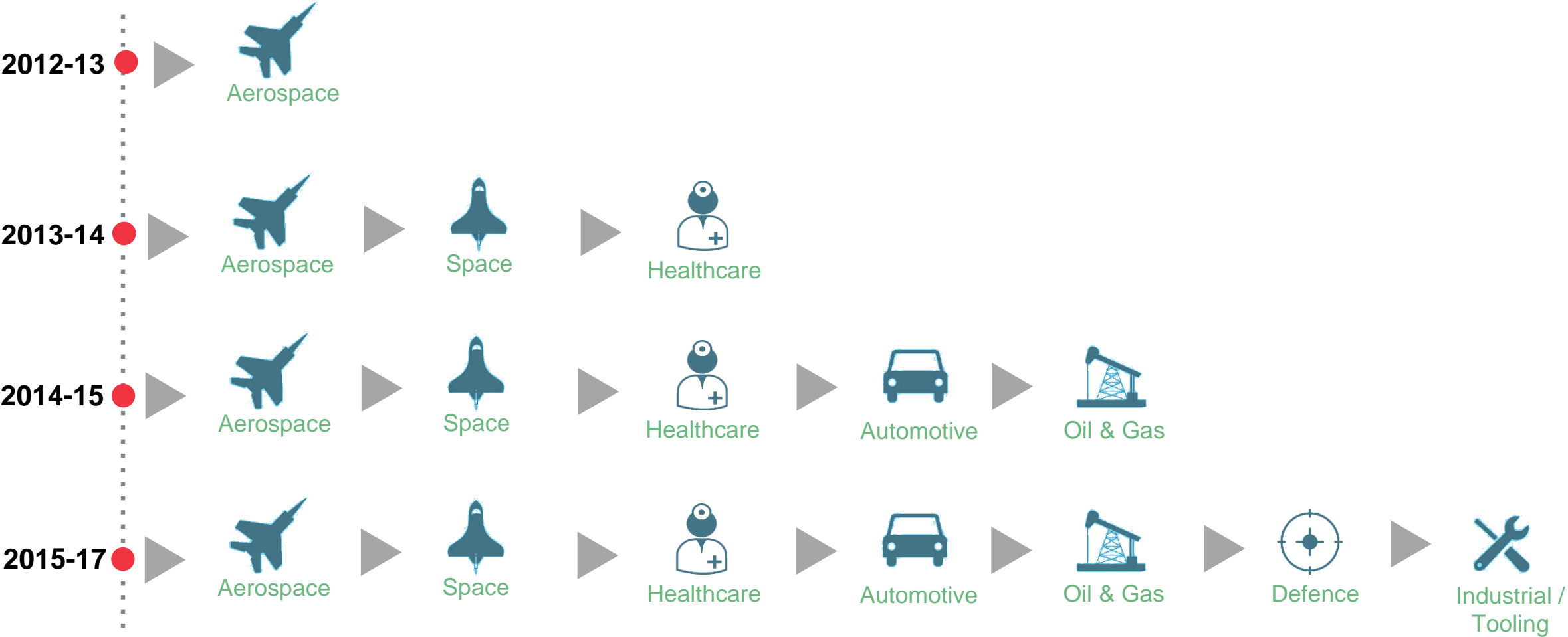
Our Aerospace AM Customers



Our AM Competencies



Our AM Journey



Five Strategic Priorities for a resilient AM business

- 01 Accelerate AM Adoption**
Focus & scale
- Prioritized sectors & markets
 - Consulting and competency building programs

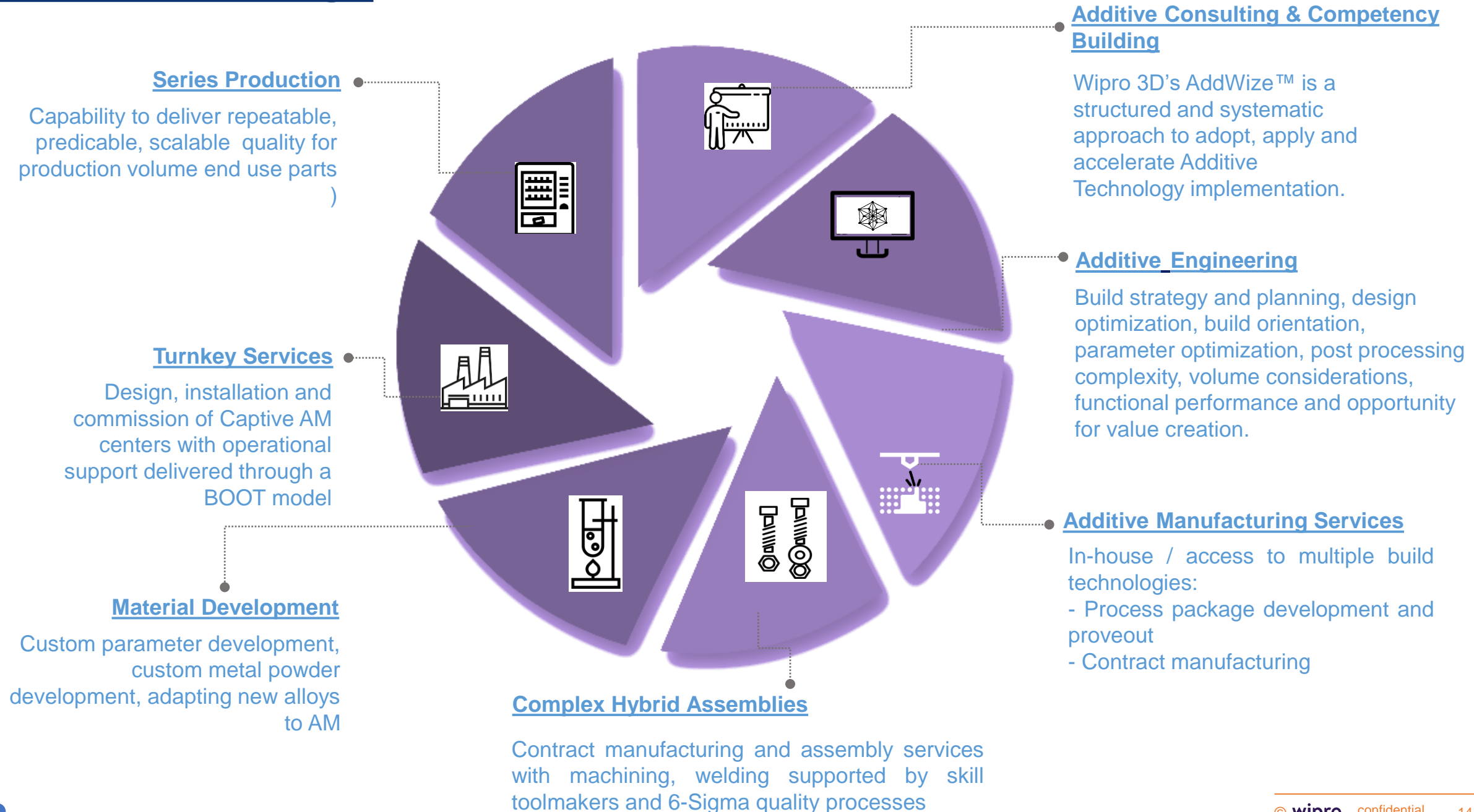
- 02 Strengthen Clients and Partnerships**
- Strategic clients with mature AM use cases
 - Large AM production business
 - Strategic partnerships for AM machines, software and post processing

- 03 Lead with Business Solutions**
- Beyond manufacturing services
 - Leveraging industry, technology and consulting expertise
 - Captive AM centres
 - Managed AM services
 - Customer specific AM and PP processes

- 04 Deliver Right-Fit Products**
- Quality and Manufacturing systems
 - Process Certifications
 - Standards compliance
 - Additive Engineering Framework

- 05 Quality First**
- A holistic quality and manufacturing standard developed for LPBF
 - Encompassing materials, models, machines, processes, input and output





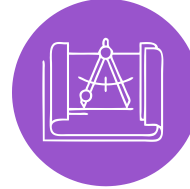
Capacity

Adequate manufacturing capacity and access to idle capability in the ecosystem to assure customers of timely delivery of required volumes / parts.



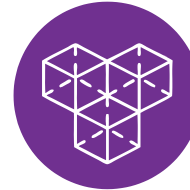
Engineering Design

Deep understanding of the industry, components, design capability and component awareness.



Additive Engineering

Build strategy and planning, design optimization, build orientation, parameter optimization, post processing complexity, volume considerations, functional performance and opportunity for value creation.



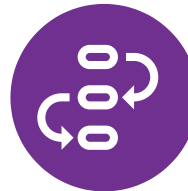
Application Engineering

In-house / access to multiple build technologies: metal sintering, electron beam melting, with multiple build volumes, speeds and applications.



Post Processing

In house and augmented capabilities for various post processing techniques including HIPing, micro machining, abrasive flow machining etc.



Research

Custom parameter development, custom metal powder development, adapting new alloys to AM, post processing.



Test and Validation Certifications

Part Prove outs, design of experiments working with prestigious academia, and work with clients to run performance tests.



Our Additive Manufacturing Solutions Centre



CAPACITY

- 12,000 sft to be later scaled to 20-40,000 square feet state of the art facility in Bangalore



POST PROCESSING

- Inert Gas & Vacuum furnace
- Machining Centres
- Shot peening (various media)
- EDM Wire Cut
- Surface Grinder
- Specialized Machining processes
- Tumbling Equipment



BUILD TECHNOLOGY

- EOS M290, M280
Build size: 250 x 250 x 300 (mm)
- EOS M400
Build size: 400 x 400 x 400 (mm)
- Automatic powder handling module
- Developing custom Electron Beam metal powder bed fusion machine



RESEARCH



TEST / VALIDATION

- Particle size analyser
- Optical Microscope
- 7 Axis 3D Scanner
- ONH Analyser
- CMM
- Part Density Measurement System
- Powder Flowability Test Equipment
- Powder Tap Density Measurement

Ecosystem of Partners for Specialized Machining, Testing, Validation and other services Includes existing and planned equipment.

PRODUCT CLASS	PRODUCT NAME	PRODUCT CLASS	PRODUCT NAME
MARAGING STEEL	Maraging Steel MS1	COBALT CHROME	EOS Cobalt Chrome MP1
			EOS Cobalt Chrome SP2
STAINLESS STEEL	SS 17-4 PH	TITANIUM	Titanium Ti6Al4V
	SS 15-5 PH		Titanium Ti6Al4V ELI
	SS 316L		Titanium TiCP grade 2
	EOS SS CX (Corax)		
NICKEL ALLOY	Nickel Alloy IN 718	ALUMINIUM	
	Nickel Alloy IN 625		Aluminium AISi10Mg
	Nickel Alloy HX		
CUSTOM	A286 HR Steel, Super Duplex SS, CM 247 LC under development	Can be made available based on technical and commercial due diligence.	

Design

 **SOLIDWORKS**

 **CATIA**

 **Altair**
Inspire

Simulation

 **CFD**

 **Mechanical**

AM &
QC

 **DNA**^{am}

 **Simufact**[™]

Magics
by **Materialise** 


EOSTATE



Additive Engineering

Additive Engineering – Design Process Capabilities

Tool



Altair Inspire™



simufact additive

Process

New
Design
Input

Reverse
Engineering

Drawing & CAD
Modelling

Design
Optimisation for
AM

Data
Preparation for
LPBF

Manufacturing
with Laser
Fusion and
Relevant
Certification

Capability

3D Scanning
Point Cloud Data to
STL

STL to CAD
Machining Allowance
Primary Supports

Topology Optimisation
Generative Design
Additive Considerations
FE Analysis

Orientation & Support
Part Positioning
Process Parameters
Thermo-mechanical Analysis

Case in Point: Inner Ring for Turbine Nozzle

Reverse Engineering

Parametric CAD Modelling

Design Optimisation for AM

Data Preparation for LPBF

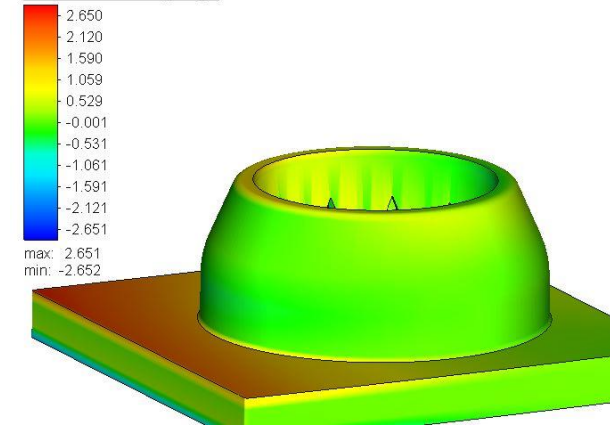
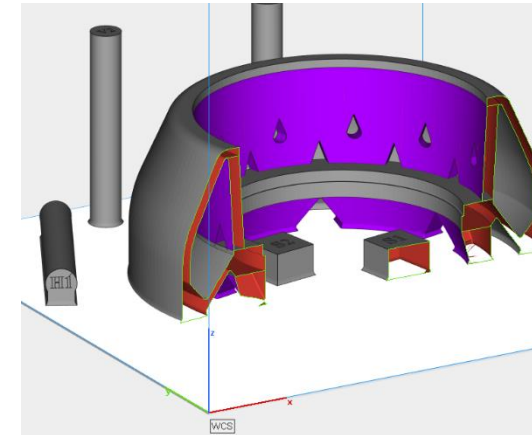
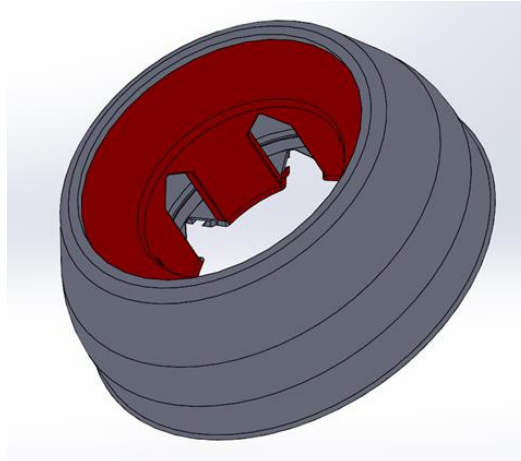
Manufacturing with Laser Fusion and Relevant Certification



ORIGINAL COMPONENT



REALIZED COMPONENT



CAD Data developed using Point Cloud Data & 2D Drawing

Point Data Created Using Onsite 3D Laser Scanner



CAD Modelling for Printing and Machining

Solid Support Structures for Heat Dissipation
Vane Profile Machining Allowance



Additive Design Considerations

Build Strategy for Qualification
Manual Support Removal
Solid Supports for Heat Dissipation



Thermo-mechanical Build Simulation

Residual Stress
Deformation
Peak Temperature



simufact additive

© wipro confidential



Application Engineering

Case in Point - Aerospace



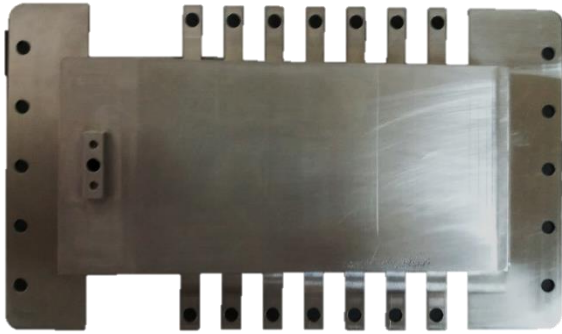
High Pressure Compressor Stator
300 mm Dia
Ti6Al4V
25 KN – 32 KN Thrust Jet Engine
Validated at 100% ground speed



Flame Tube
280 x 162 mm
IN718
UAV Engine (2000K op temp)
Passed system level combustion testing



Nozzle Guide Vane
450 mm Dia
IN718
25 KN – 32 KN Thrust Jet Engine
Validated at 100% ground speed



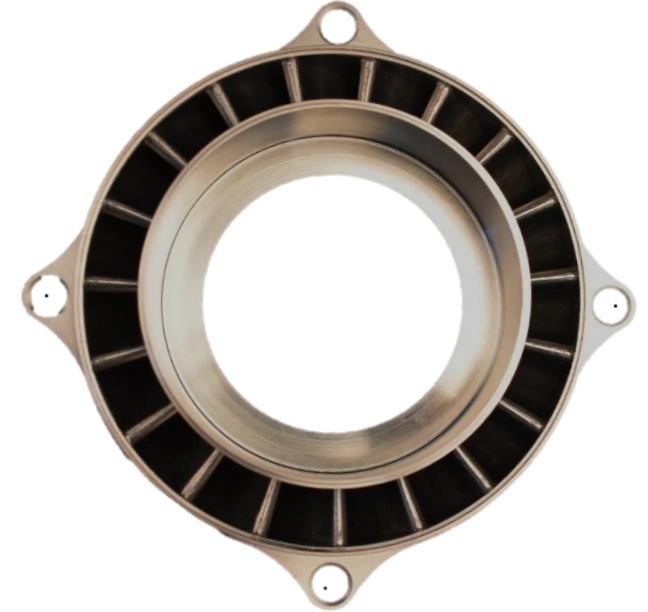
Rx Antenna
172 x 85 x 37 mm
SS316L
Missile Communication
Validated



Starting Nozzle
172 x 85 x 37 mm
IN718
UAV Engine
Validated

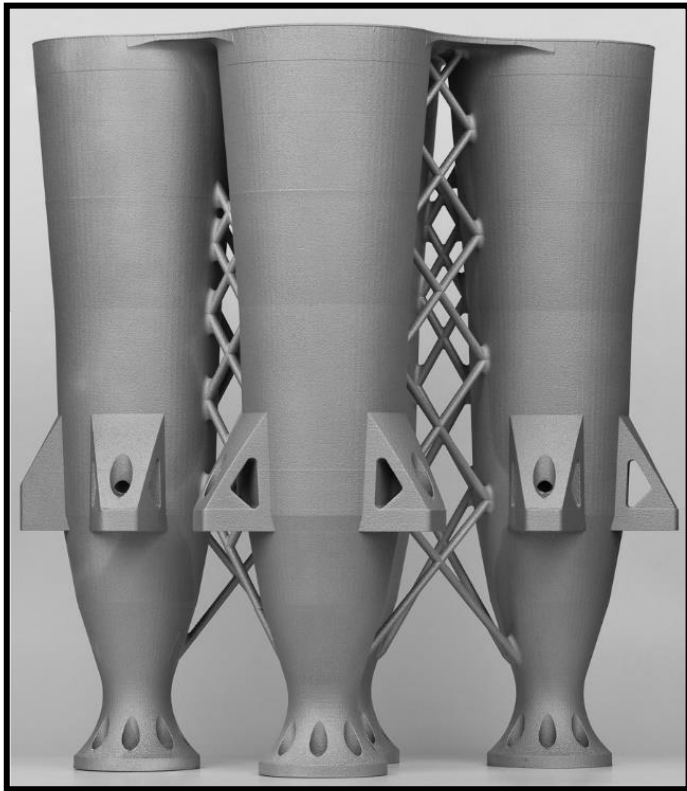


Anti Icing Assembly
1 m dia
IN718 & Ti6Al4V
Aircraft Thermal Management
Under Testing



Nozzle Disc
120 x 32 mm
IN718
Missile Propulsion
Passed endurance testing, flight trials
upcoming

Case in Point - Space



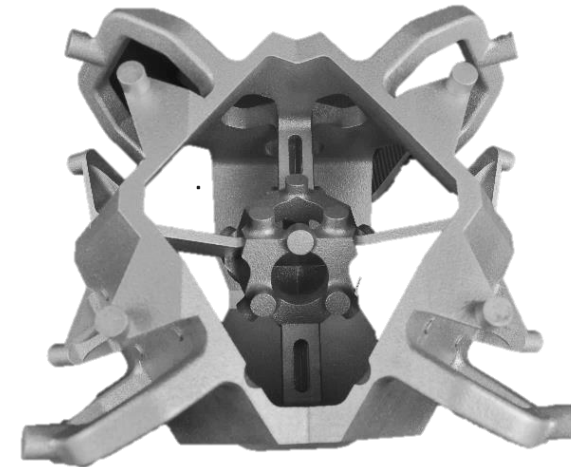
NW Feed Cluster 2x2
250 x 250 x 320 mm
AlSi10Mg
Satellite Communication
In Orbit



Pre Burner Impeller
170 x 87 mm
AlSi10Mg
Cryo Fuel System
Validated



Injector
142 x 50 mm
Ti6Al4V
Rocket Propulsion
Validated



MINS Cluster
178 x 168 x 193 mm
AlSi10Mg
Rocket Guidance & Positioning System
Under Testing

Case in Point - Aerospace

PART

INNER RING



MATERIAL

A286 HR STEEL

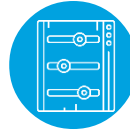


AM COMPETENCIES DEMONSTRATED

DESIGN FOR AM



BUILD TECHNOLOGY



VALUE DELIVERED

HOMOGENEOUS
STRUCTURE



WEIGHT
REDUCTION



BETTER FUNCTIONAL
PERFORMANCE



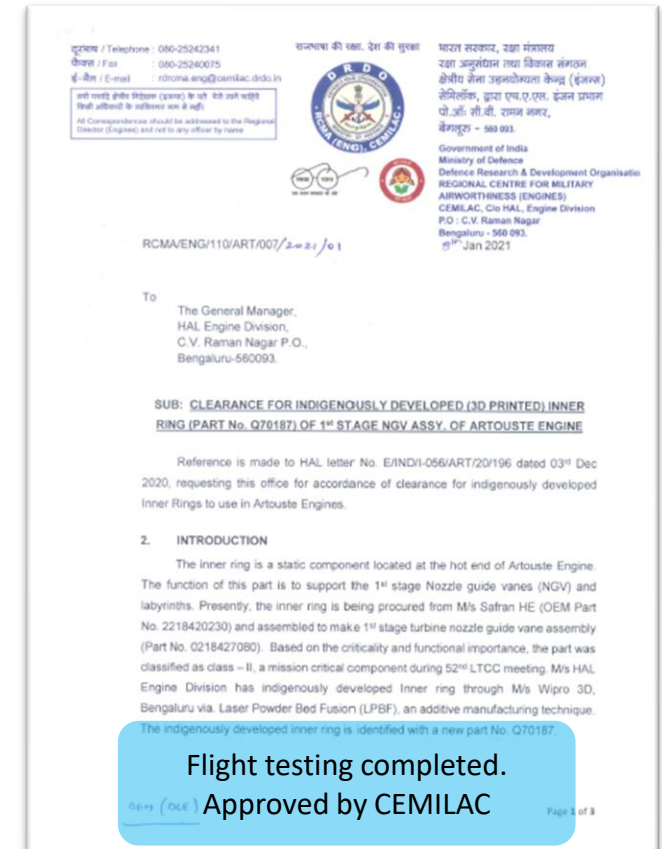
- A landmark project in application engineering with metal AM
- Scope:
 - Material development and adoption to LPBF
 - RM characterization and validation
 - AM process development
 - Material testing,
 - Machining trials and prove out,
 - Inspection (radiography, CMM, and CT scan) executed over 2.5 years

Proven Out




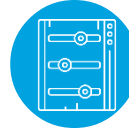




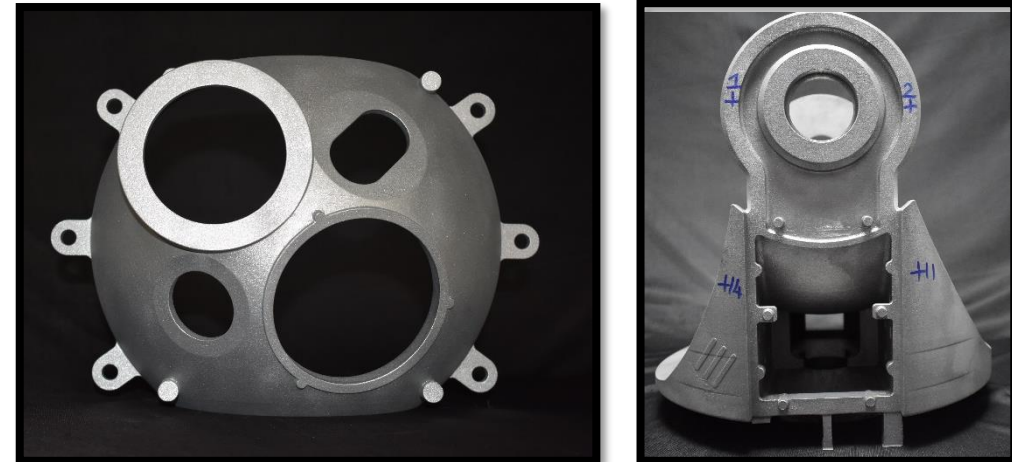
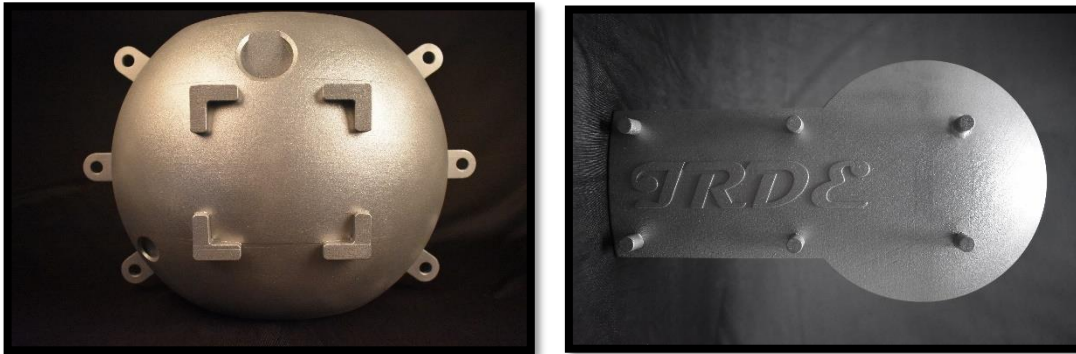



Application: Helicopter engine

Features : 2.2 mm wall thickness










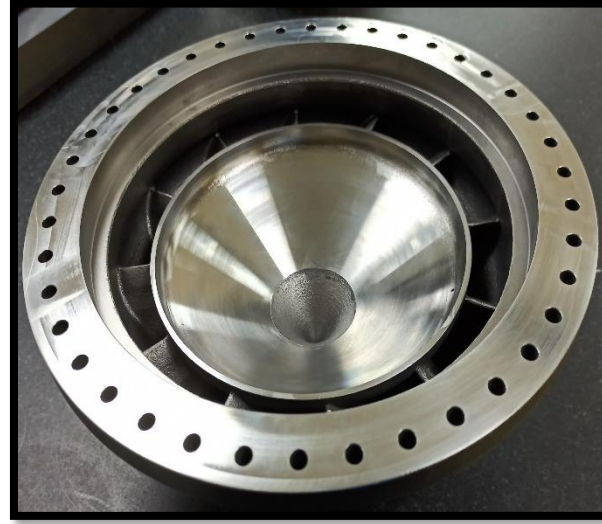
Case in Point - Defence

PART	MATERIAL	AM COMPETENCIES DEMONSTRATED		VALUE DELIVERED		
GIMBAL MOUNTED CAMERA HOUSINGS	AlSi10Mg	DESIGN FOR AM	BUILD TECHNOLOGY	HOMOGENEOUS STRUCTURE	WEIGHT REDUCTION	BETTER FUNCTIONAL PERFORMANCE
						
				Application: Electro Optical Surveillance system for Helicopter		
				Features : 2 mm wall thickness PO to part : 30 days		
Proven Out						

- One of the tallest part printed in M400 the size is about Ø 370 X 356 mm and continuous 12 days build

Case in Point - Space

PART	MATERIAL	AM COMPETENCIES DEMONSTRATED		VALUE DELIVERED		
LOX & LH 2 Exhaust Casings	IN718	DESIGN FOR AM	BUILD TECHNOLOGY	HOMOGENEOUS STRUCTURE	WEIGHT REDUCTION	BETTER FUNCTIONAL PERFORMANCE
						



Application: Rocket Combustion

Features : 2 mm Blade thickness

Build hours : 140 per part

Qualification tests cleared:
Pressure test at 650 Kelvin for 10 min with 6.5 Bar simulating hot engine test condition

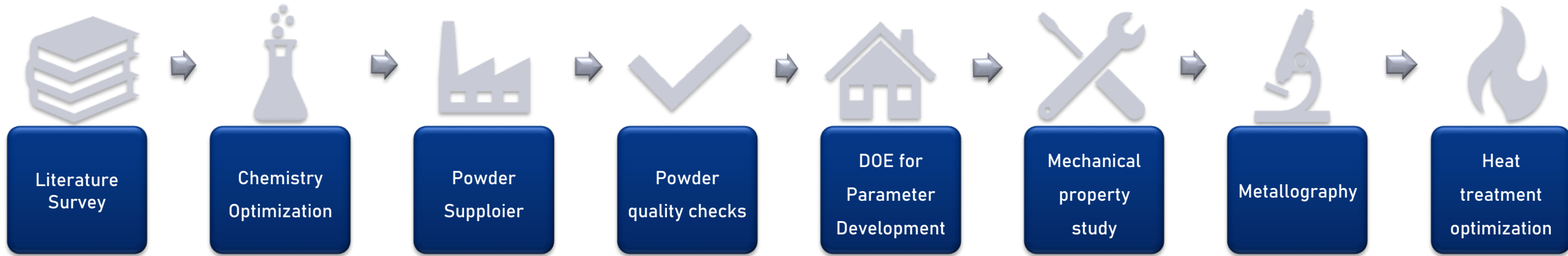
Proven out





Material Adoption

Material Adoption & Development Framework



- Understanding of Metallurgy of material
- Role of each alloying element in the material
- Chemistry alterations to make it feasible for AM
- Effect of chemistry alterations on final properties

- Vacuum/gas atomized powder manufacturing : supplier
- Particle Size Distribution
- Flowability
- Apparent density
- Tap density
- ONH
- Powder morphology

- Systematic DOE approach used for parameter development
- Base line parameter / go to parameters chosen after benchmarking with similar materials
- Further development based on the results obtained

- Metallography – as built without etch defects, after etch melt pool formation observation
- Part Density
- Mechanical properties- tensile, stress rupture, fatigue.
- Heat treatment cycle optimization
- After HT metallography for phases, grain size

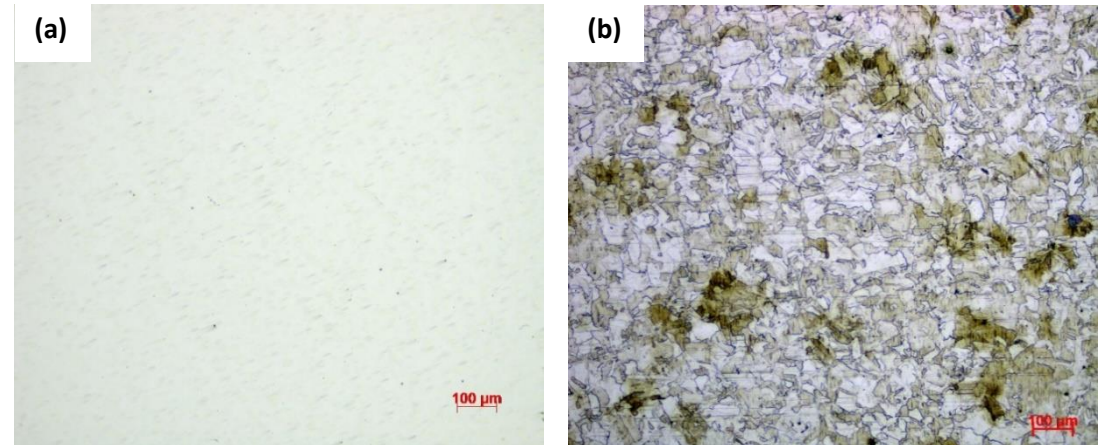
A286 Steel (Heat Resistant Steel)

- The A286 alloy is an Iron-Nickel based austenitic superalloy, that is useful for applications requiring high strength and corrosion resistance.
- This “Heat Resistant Superalloy” is designed to maintain its good strength and oxidation resistance at temperatures up to 700°C.
- Applications: Aircraft and industrial gas turbines, Jet engines, Turbine wheels and blades, frames, casings, offshore oil and gas industry

Chemistry (wt.%)	
C	max 0.08
Mn	max 0.35
Si	max 0.3
Cr	13.5-16
Ni	24-27
Mo	1-1.5
Ti	1.9-2.35
B	0.003-0.01
V	0.1-0.5
Co	max 1
Fe	Balance

Mechanical Properties	
Property	LPBF
Tensile	
Tensile Strength (MPa)	800 -1050
Yield Strength (MPa)	600 -900
Elongation (%)	3-12
Elevated tensile (650°C)	
Tensile Strength (MPa)	500-600
Yield Strength (MPa)	450-550
Elongation (%)	1-5
Hardness (HBW)	333 ± 10
Density (g/cm³)	7.8

Microstructure



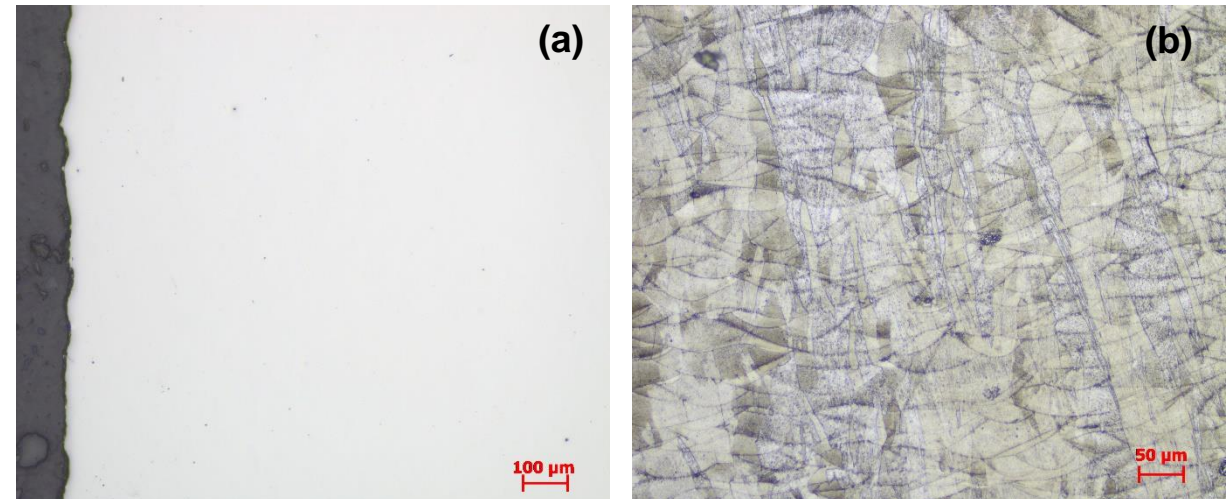
(a) Without etch micrograph_no porosities; (b) Microstructure of A286 after etch showing equiaxed structure(100X)

- CM 247 LC is a nickel base superalloy with low carbon content. It is a modified superalloy with a chemical composition of Mar-M247. With a potential for operation at high temperatures ($\approx 1100^\circ\text{C}$) due to the high γ' volume fraction.
- Applications: combustion chamber out to the exhaust nozzle, turbine blades and vane segments.

Chemistry (weight %)																		
Element	Al	C	Cr	Co	Cu	Fe	Hf	Mn	Mo	Nb	Ni	P	Rh	S	Si	Ta	W	Zr
Min.	5.4	0.05	8.0	9.00	-	-	1.2	-	0.4	-	Balance	-	-	-	-	3.1	9.3	0.004
Max.	5.7	0.1	8.5	9.50	0.10	0.25	1.6	0.20	0.6	0.10		0.015	0.1	0.005	0.15	3.3	9.7	0.02

Mechanical Properties		
Property	LPBF	LPBF + HIP
Tensile		
Tensile Strength (MPa)	1130 ± 15	1300 ± 50
Yield Strength (MPa)	930 ± 15	790 ± 20
Elongation (%)	8 ± 3	15 ± 5
Elevated tensile (760°C)		
Tensile Strength (MPa)	1230 ± 30	-
Yield Strength (MPa)	830 ± 30	-
Elongation (%)	12 ± 4	-

Microstructure



- (a) Without etch microstructure showing NSD;
- (b) Microstructure of CM247 after etch showing columnar in Z direction as built condition (100X)

A person wearing a white lab coat is shown from the side, holding a black pen and writing on a spiral-bound clipboard. The background is a blurred laboratory or industrial setting with various pieces of equipment and bright lights. A dark blue horizontal band is overlaid on the bottom half of the image.

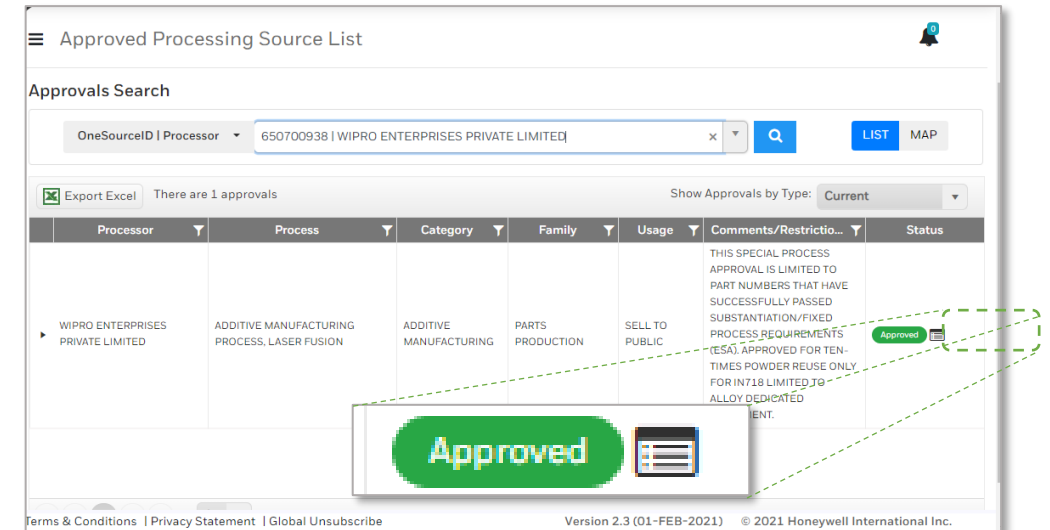
Systems & Certification



AS 9100 D Certified



Lloyd's Register
Certified



AM Certified by an American Aerospace
Engine Manufacturer



Expected Sept 2021

AM Enterprise Backbone



Build File Management



Chemical Analysis



Batch Splitting & Blending



Inventory Management



Inclusions Reporting



Quality Control



Visible Powder Traceability



Tooling & Equipment
Management



Powder Status & Locations



Visual Stock Location
Management



Powder Tolerance

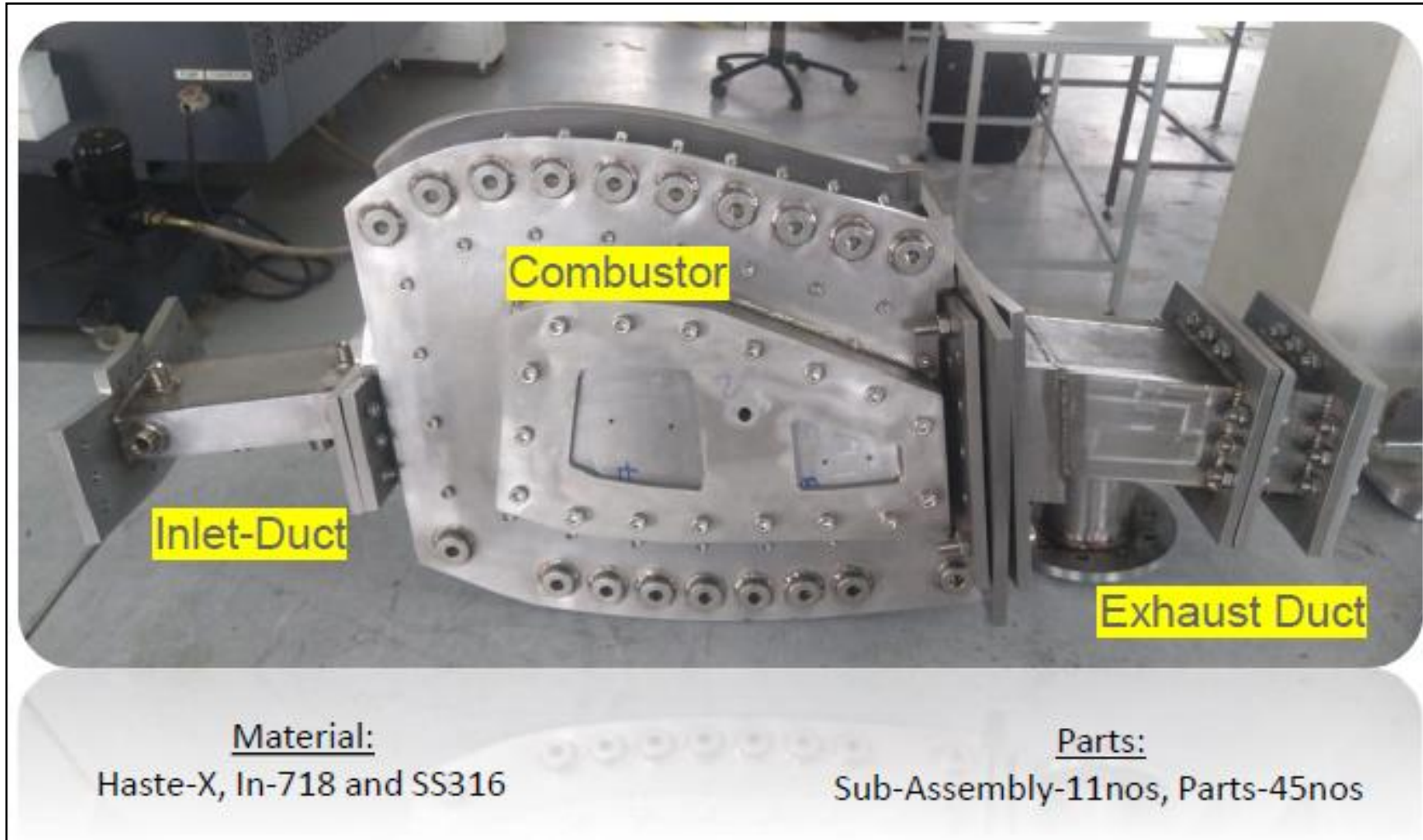


Chemical Trial



More than LPBF

Hybrid Assemblies



Suggested Next Steps

- GKN is looking to adopt Metal Additive Manufacturing to gain a business benefit for castings supply chain.
- Wipro3D suggests to begin with a Pilot as follows:
 1. Wipro3D will conduct an online meeting for GKN, sharing the Additive Thinking Framework, and examples of 'right-fit' parts for AM and 'not-fit' parts for AM.
 2. Based on this meeting, GKN can select a group of parts for Wipro3D evaluation, and share the 3D models and 2D drawings.
 3. It is suggested to select a diverse of parts based on material, functionality, cost, quantity and current pain-point.
 4. Wipro3D will react to the shortlisted parts with a justification for AM, where applicable, and with a recommendation to continue as-is, where AM would not be feasible.
 5. Based on GKN approval, Wipro3D will share a quote for the selected parts.
 6. Wipro3D will not charge for the pilot steps 1-4 listed above.
 7. Basis successful use of the selected AM parts, Wipro3D will assist GKN to create a roadmap for transitioning casting parts to AM.

Note: Ideally, Wipro3D conducts AM pilots in person. However, given the current pandemic and travel restrictions, we can meet online.

Why Wipro 3D as your Strategic AM Partner

- Demonstrated experience in Metal AM for 5+ years
- Proven knowledge and understanding of Additive Design & Engineering
- Strong engineering design, simulation and domain led workforce
- AS 9100 D Certified and Lloyd's Register Certified
- R&D Capabilities
- Custom material adoption
- Developing additional AM applications in advanced materials
- In house metal AM set up all under one roof: Metal AM machines, post processing machines and materials characterization lab
- Ability to scale in multiple geos, both domestic and international
- IP protection measures and culture
- In the process of implementing global footprint in metal AM
- Strong partner ecosystem including 3D Printer OEMs, AM providers, research organizations, software vendors



Thank you

Contact

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www.Wipro-3D.com



wipro 3D