



This project has received funding from the European Union's Horizon 2020 Research and Innovation programme under GA No 101004730.

IFAST WP 10.4

Additive Manufacturing of pure Cu and pure Nb SRF cavities

20. 04.2023 - Trieste, I.FAST Annual Meeting

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IFAST



Task 10.4

Additive Manufacturing of pure Cu and pure Nb SRF cavities

- Develop the design approach and test relevant properties of AM-manufactured Niobium RF cavities
- Develop the design approach and test relevant properties of AM-manufactured Ultra-Pure Cu-made RF body cavities - coated by a Niobium thin layer at the inner surface
- Both to be tested at room and at cryogenic temperature.

Deliverable: done December 2022 (Cu and Nb based SRF cavities produced and qualified)

Milestone: December 2023 (room and cryogenic temperature tests for Nb and/or Cu SRF Cavities)

Steps:

- Characterization of pure Cu produced by LPBF
- Production of Cu 6 GHz cavity prototypes
- Preliminary tests on prototypes
- Surface treatments on copper cavities
- Characterization of pure Nb produced by LPBF
- Production of Nb 6 GHz cavity prototypes
- Tests and surface treatments of niobium cavities
- Issues

Pure Copper

Printability of copper cavities:

- Orientation
- No internal supports
- Different down skin parameters



EOS M280
Yb fiber laser
Spot diameter: 80-100 μm
 $\lambda = 1060-1100 \text{ nm}$
Nominal power: 400 W



Pure Copper

Pure copper printed with different laser wavelengths and power



Green laser (515 nm, 1 kW)



Red laser (1060 nm, 370W)



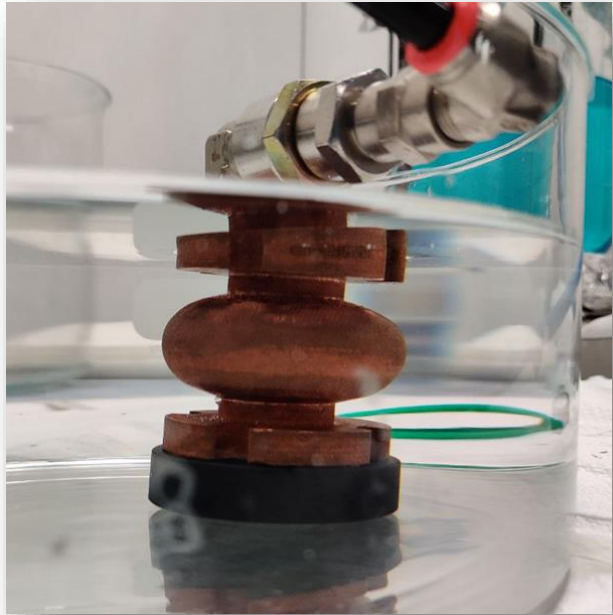
First prototypes (reduced height).

Acceptance tests performed.

Leak test:

Frequency at room temperature

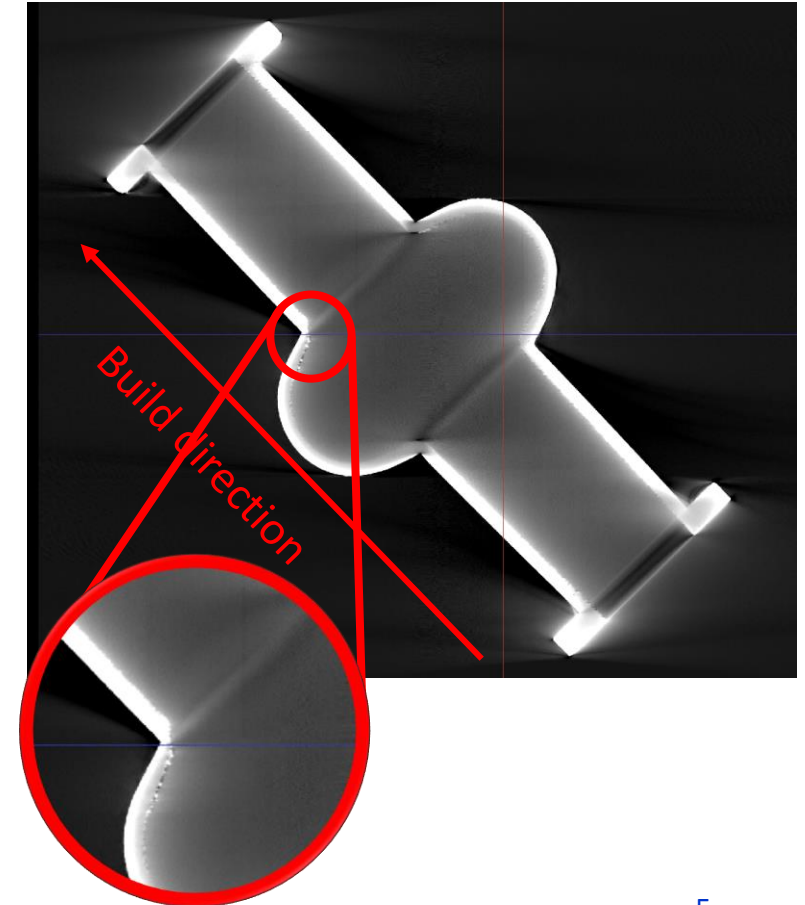
Cavity	Frequency (GHz)
T1	5.9871875
T2	5.986250
L1	5.9956250
L2	6.0015625
L3	6.0043750
P1	5.9481250
P2	5.9418750
P3	5.9390625



N₂ 2 atm, room temperature
Under vacuum



Computed tomography



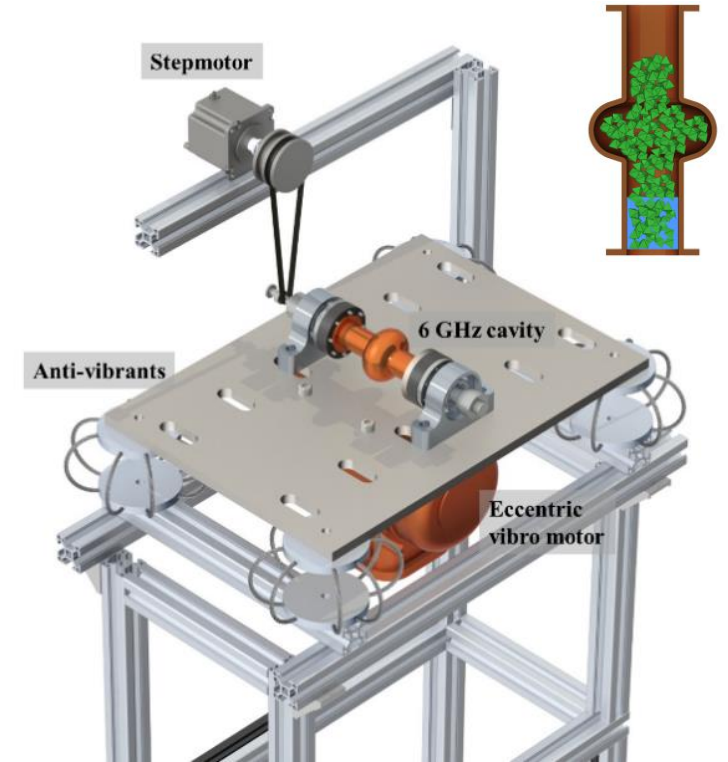
Surface treatments

- Rösler Italiana Srl

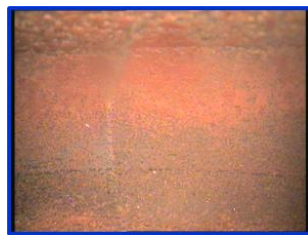
Traditional Mass finishing + chemically assisted mass finishing+ final polishing

- INFN LNL

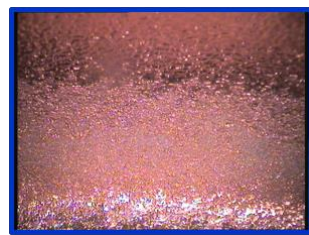
Electropolishing + Vibrotumbling



Vibrotumbling apparatus



As built



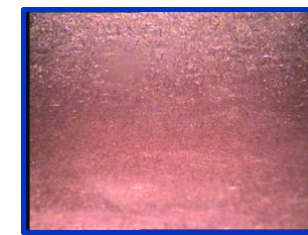
After EP1



After EP2



After VT 1

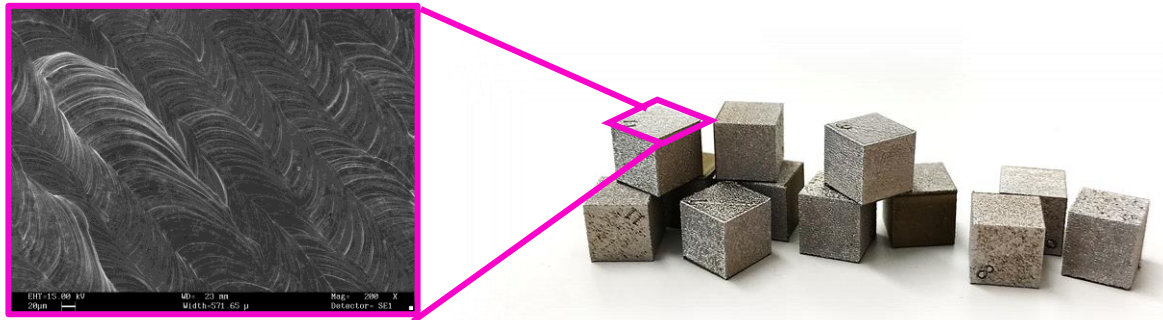


After VT 2

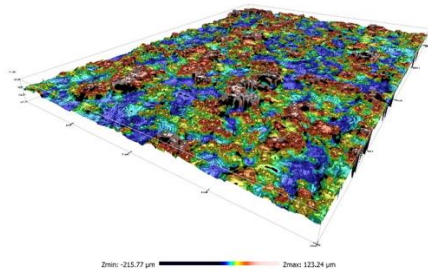
Niobium

Process parameters deeply investigated:

- Maximization of density;
- Improvement of as-build surface quality



Maximum density achieved: 99.8%
(Archimedes method)



Elements	Quantity
Nb	99.9 %
C	<50 ppm
H	<50 ppm
N	<100 ppm
O	<600 ppm
Ta	<100 ppm
Cr	<50 ppm
Fe	<50 ppm
Ni	<50 ppm
Hf	<50 ppm
Mo	<50 ppm
Zr	<50 ppm
W	<50 ppm

EOS M100
Yb fibre laser
Spot diameter: 40 µm
 $\lambda = 1064 \text{ nm}$
Nominal power: 200 W



Inclined walls:

Angles investigated: 18° 20°, 22°, 25°, 30°, 35°, 40°, 45°, 50°

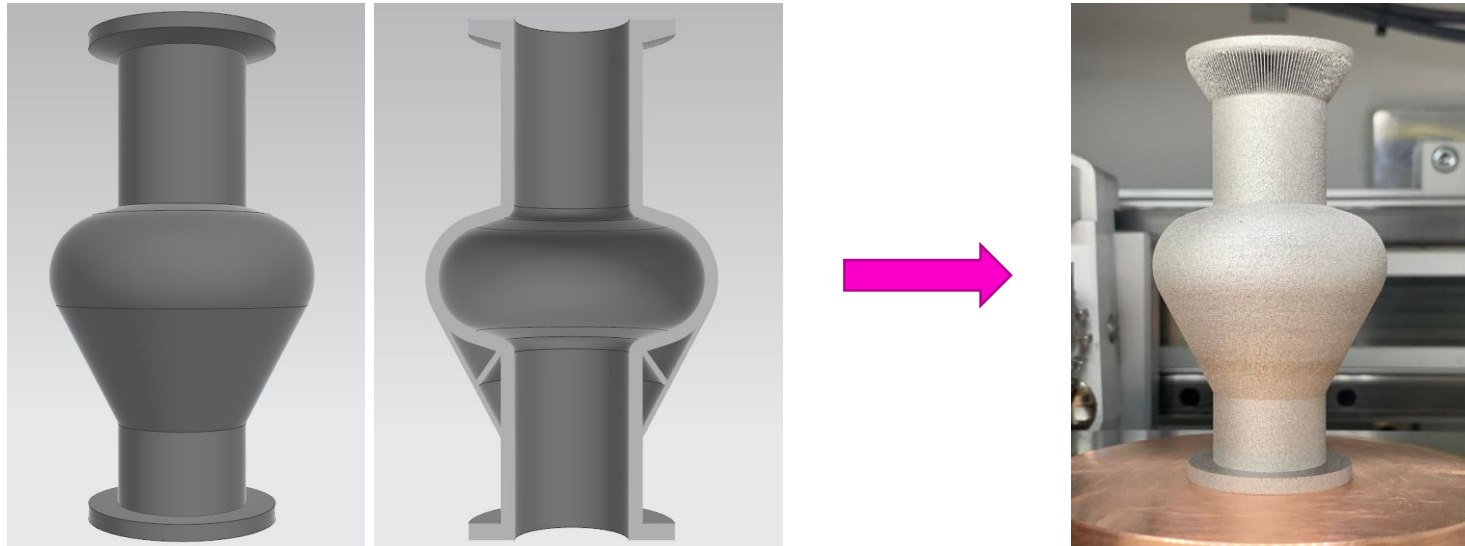
Acceptable results only for angles higher than 35°.

NEED TO APPLY THE NO CONTACT SUPPORT APPROACH



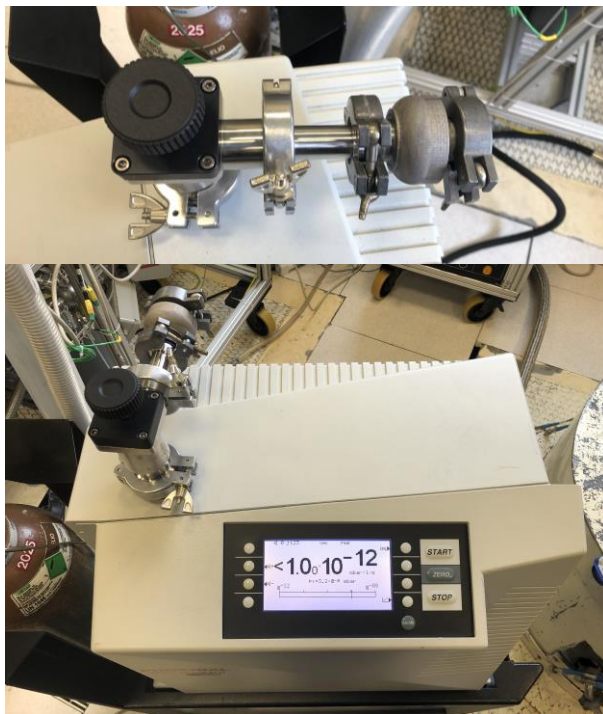
Niobium

- Seamless niobium cavities successfully printed
- Supporting structures optimized to reduce the building time and material consumption



Acceptance tests performed.

Leak test:
Under vacuum



Frequency test at room temperature

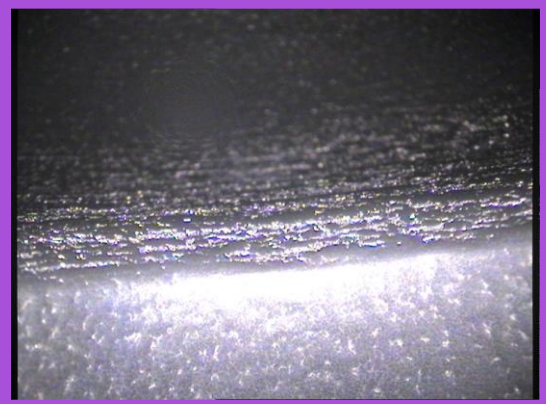
Cavity	Frequency (GHz)
Nb small	5.999
Nb big	6.027



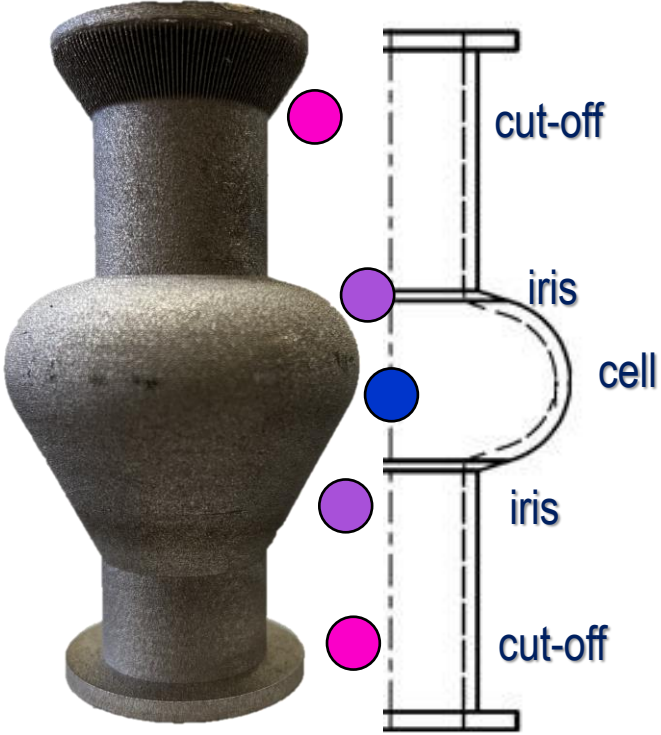
Computed tomography



Surface treatments



INFN LNL:
Mechanical treatment
Electropolishing
Work in progress



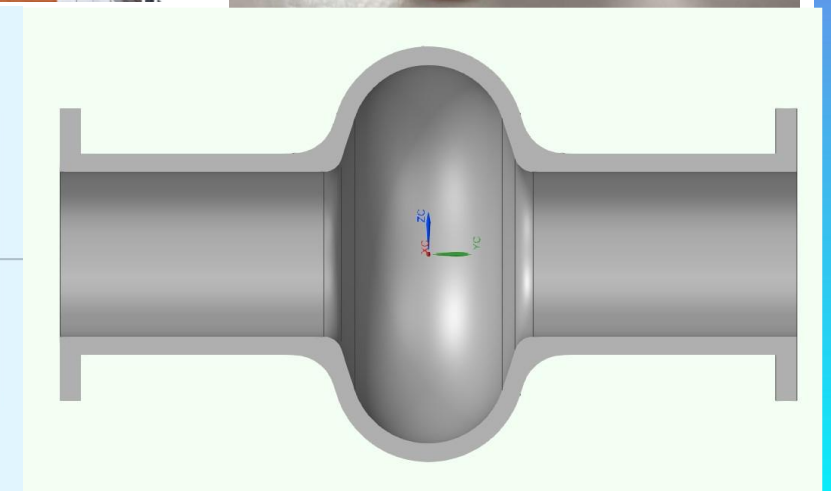
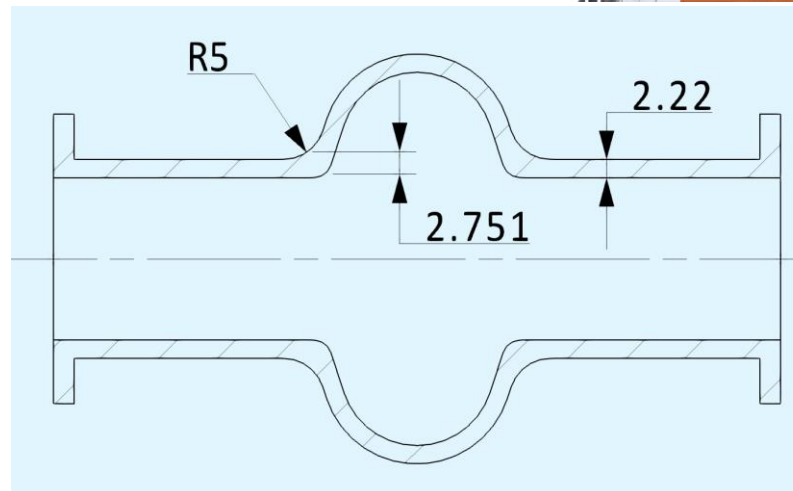
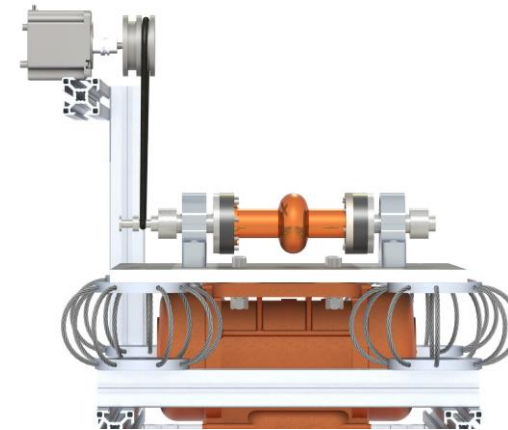
Printed cavities Nb, Cu

Issues.

Scratches and pitting appeared during the surface treatments performed by Rösler on both T1 and T2.

Due to mechanical loads, Vibrotumbling apparatus, caused ruptures in correspondence of the iris of the copper cavities.

We'll produce a couple of Cu cavities with a different fillet radius between IRIS and cut off, while maintaining a reduced wall thickness to guarantee an high temperature uniformity at cryogenic temperatures.



Thanks for your attention