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The biological implications of this study are that it has been shown that creep material deformation is similar in solubility products and solute diffusion in alloys, but there is a major difference between fracture and crack formation. By adopting these results, alloys can be selected not only on the basis of their mechanical properties, but also on the basis of its biocompatibility. All stainless steel materials, such as AISI 304, exhibit creep at  $10^{-5}$ s $^{-1}$  due to the presence of non-metallic inclusions, and should therefore be avoided for biomedical applications. Commercially pure titanium and Ti-6-aluminium-4-vanadium powder are used. The powder is sieved to 50-100 microns. The titanium powder is compacted into discs of 15mm diameter and 4mm thickness. Cylindrical specimens are then machined from the discs using electrodischarge machine. The specimens are subjected to creep at a strain rate of  $2 \times 10^{-5}$ s $^{-1}$ . The current study presents clear evidence that the nucleation of cracks from pores is a serious issue with EBM Ti-6Al-4V. It is the second stage of the study to be presented at the upcoming AM symposium (BECAM) in Biarritz, and we fully expect to be able to extend this work in the months and years ahead. Once the pore distribution is understood it will be possible to predict the fatigue life of EBM Ti-6Al-4V specimens based on their defect morphology. If this is done accurately, the manufacturing process should be adjusted to produce components that will have near to a defect free surface and surfaces that are not in contact with pores. Unfortunately, at present, there is no way to do this based on any form of structural and metallurgical analysis or visual inspection. Future research should consider methods to assess the pore distribution in EBM Ti-6Al-4V samples and to objectively evaluate the magnitude of a defect without the need to break the sample, or leave the periodic CT scan in place. It is likely that such a system would be extremely slow to operate, and thus probably not suitable for long lived components, but could be built into a version of the current machine to obtain a rapid assessment. This could be used to adjust the EBM manufacturing parameters and hence pore distribution in real time as part dimensions are changed. We would also like to see if the knowledge acquired in the current study can be used in commercial systems to optimise the design and reduce the pore content prior to processing, with the aim of producing more fatigue capable specimens. In this paper we have focused on the investigation of pore initiated fatigue in EBM Ti-6Al-4V. However, the progression of pore initiated fatigue crack growth should be compared with bulk material fatigue, to determine if the fatigue life of EBM Ti-6Al-4V is indeed improved by the elimination of voids and porosity. This will be the topic of future research. 5ec8ef588b

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