Composites Part A 135 (2020) 105904

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C P A

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In-situ -

ff

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A R T I C L E I N F O

Keywords:
T -
C ff
S
C
B

A B S T R A C T

C , - (3DG) , . H - (3D) (SLM) - . G *in-situ* (CVD) C , 3DG . A CVD SLM ff 3DG - (, ,) - (,) ff . T 3DG/ ff 88% 27% (EMI) ff , . P , EMI ffi- (*SE*) 47.8 B 2.7 GH *SE* 32.3 B 2–18 GH . T SLM .

1. Introduction

G , *sp*^{2} , V , (2DG), 5 , 6,7 , 4 , (EMI) 8 . (2630 ^{2} $^{-1}$) 1 , 3DG , 9 , 10 , (2 10^5 ^{2} V^{-1} $^{-1}$) (6-5000 W $^{-1}$ K^{-1}) 2 . H , π-π - - 11 , 12 . H , - (2D) . F , ff ff , 13 . S - ( ) 3 . A fi ff 14 . D - . C , - - (6-99.7%), fi - 15 . M (3DG) - CVD , fi - - 16 . B (6-0.6 $^{-2}$) 4 , , , - -

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:// . /10.1016/J .2020.105904
R 31 J 2020; R 1 A 2020; A 13 A 2020
Available online 18 April 2020
1359-835X/

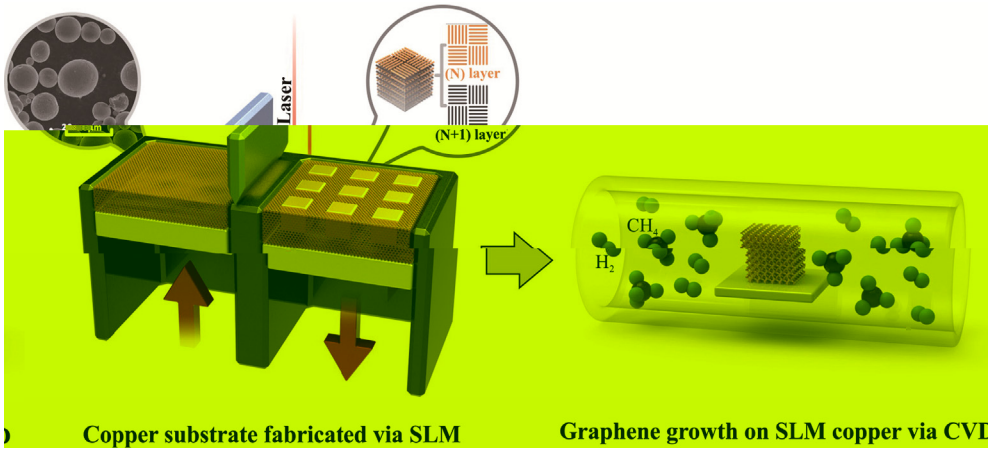

Fig. 1. I 3DG/C : ff SLM ( ) *in-situ* ff CVD ( ). (F fi , .)

ASTMB193-2002 2 2 20 ^{3} . T ff (2 10 10 ^{3}) (5 10 10 ^{3}) ASTME1461-2013 LFA (L fl , N LFA457, G). R (SENTERRA, B , G) 3DG/C ff - 514 . T *S* (*S11* *S21*) fl (VNA, A PNA-N5244A, US) 2–18 GH . T *SE* , *SE* , *SE* fl E . 2–5 S I .

3. Results and discussion

3.1. Formation of SLM copper

3.1.1. SLM manufacturing of copper under different line energy densities

T ff ( ) . D ff (F . 2) , 30% (A), 26.7% (B), 16.7% (C) 26.7% (D). D ff , LED (J/) 27 (E . 6, SI). T . T ffi . I A, ffi . I B, fi . T fl ffi , LED 400 J/ (C). W LED (> 800 J/) , 130 μ - (D), - 28 .

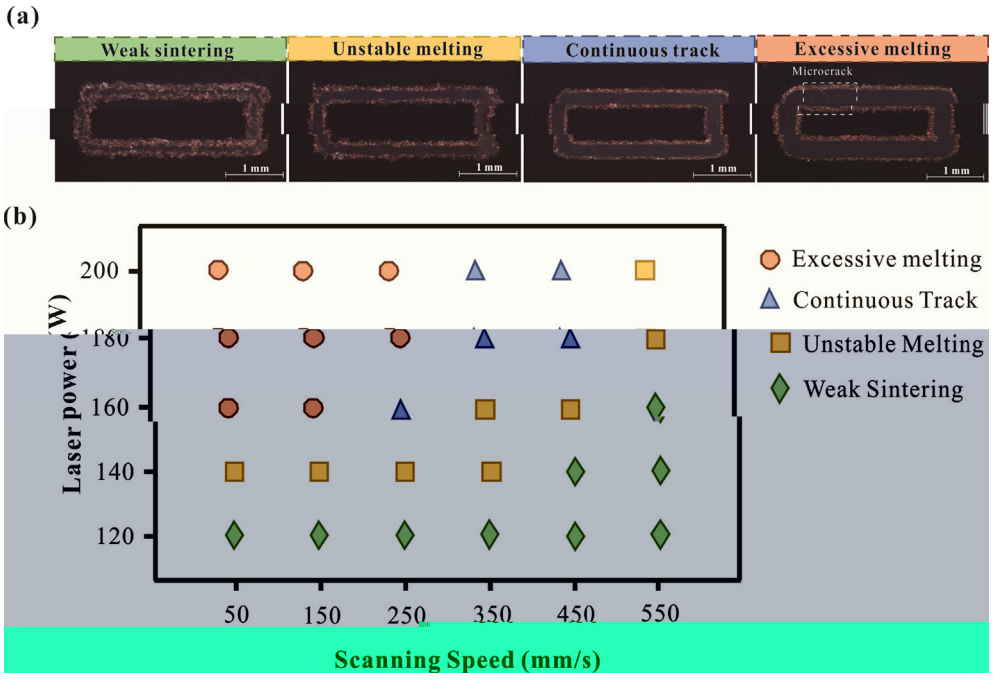

Fig. 2. ( ) T , , ; ( ) (F fi , .)

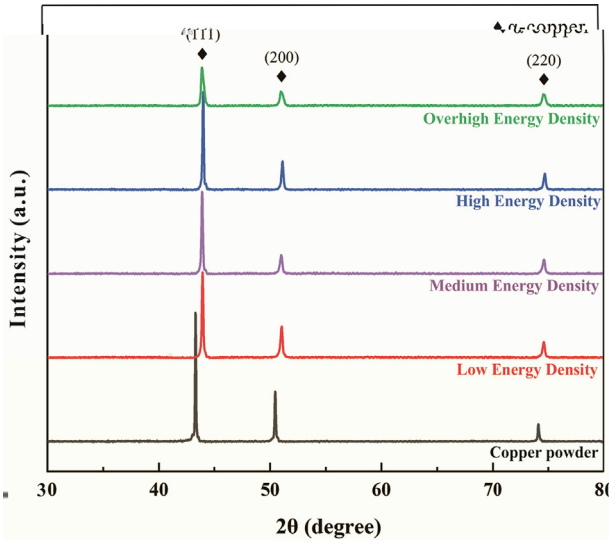

Fig. 3. RD - - . (F fi , .)

3.1.2. Formation of anisotropic microstructure under different volumetric energy density

T α- RD (1 1 1) (2 0 0) fl ff 2θ = 43.32 2θ = 50.45 , (F . 3), (1 1 1) . T - RD ff fi SLM . I , ff SLM ff , - 29 . T - SLM . T

: ( ) , ( ) - , ( ) . A 3000 J/ 3 (F . 4**a**), 180 μ , (F . 4**d**). T M 30 fl . T fi . W 857 J/ 3, (F . 4**b**). U , fi- 96.2% . H , , - . T (398 W −1 K−1), ffi (F . 4**c**). G , M - . B , SLM 31 . I , 128 J/ 3, - - fi , 88.6% - (F . 4**d**). T SLM (F . 5). T - - , . T , - 32 . T fi fl - . S W . 33 , ,

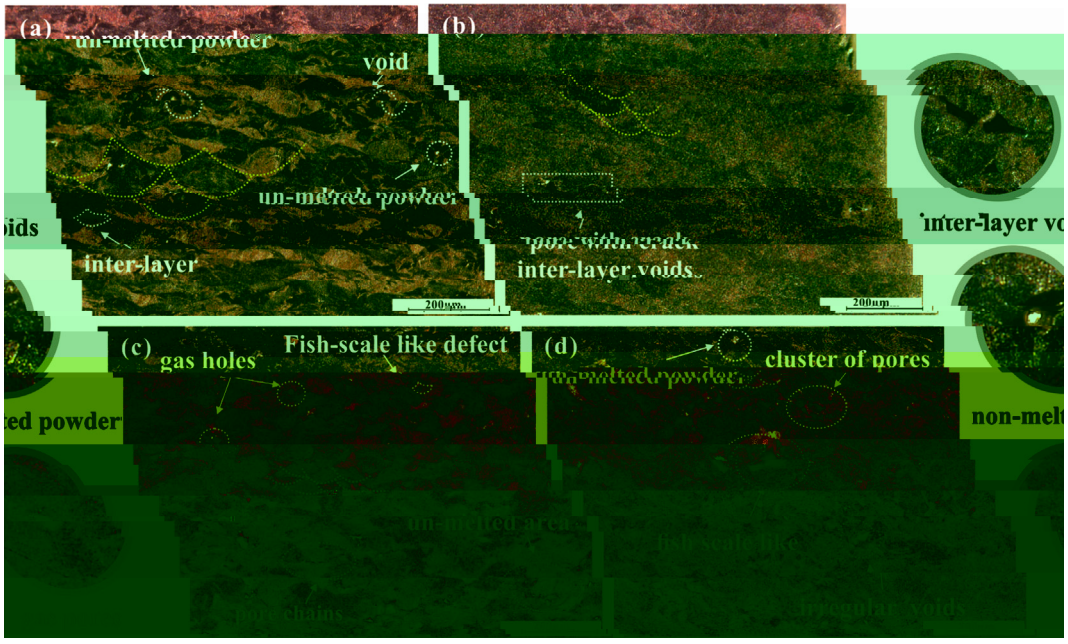

Fig. 4. O : ( ) (3000 J/ 3), ( ) (857 J/ 3), ( ) (285 J/ 3), ( ) (128 J/ 3), . (F fi , .)

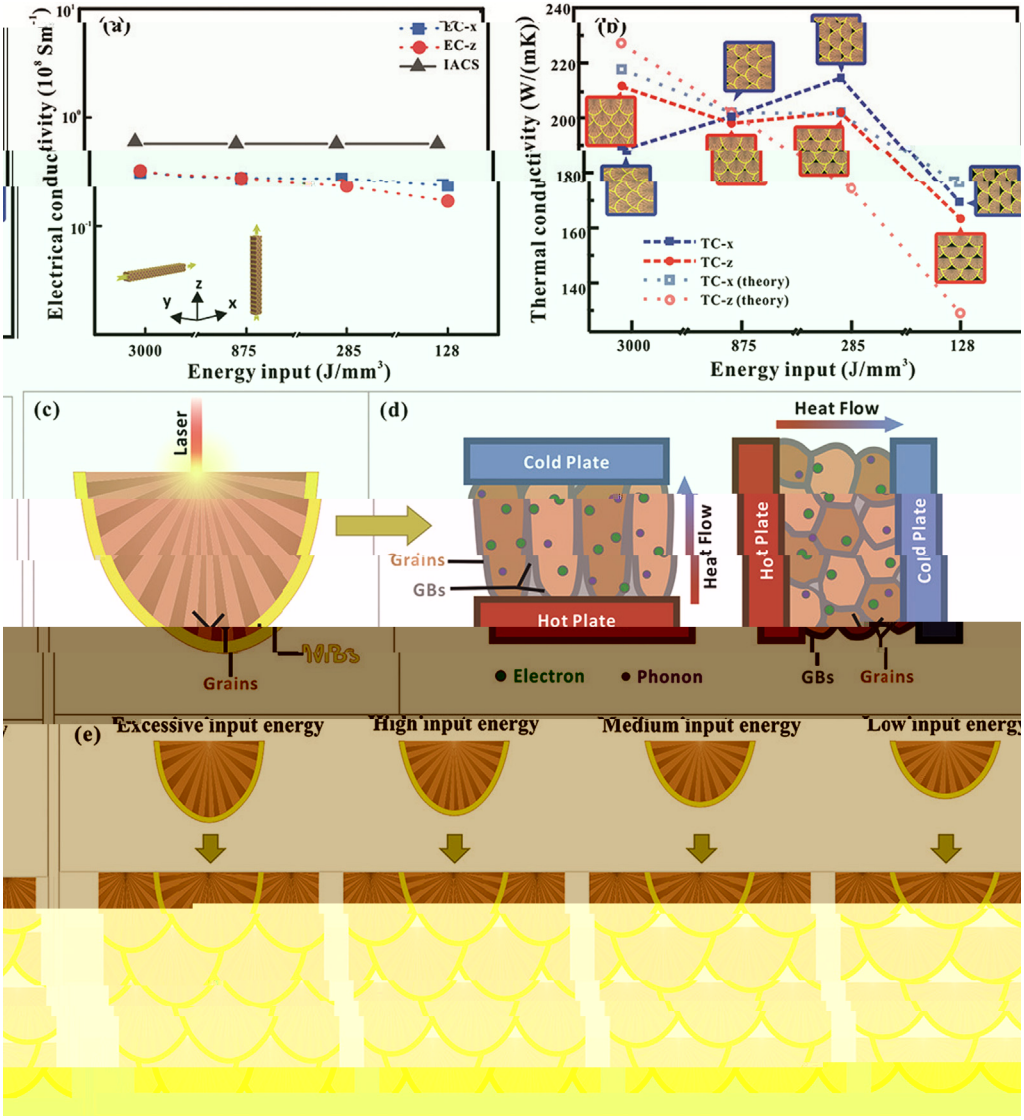

Fig. 7. ( ) H ( ) ; ( ) ; ( ) ; ( ) ff . (E). (F fi ,

. . A ,

3.3. Morphology and structure of CVD 3DG/Cu porous scaffolds

F ff ff ff . G *in-situ* CVD . A ff , ’ 39 . A , 33 V , (25 V) 39 . U C N , L . 40 . H , (. . 23 , - 41) CVD- , - fl

SEM, - - . T SEM - 3DG/C ff - 450 μ (F . 8**a**). A fi (F . 8**b**), fl ff , . T - ff , EDS (F . 8**c-d**), fi V - . A fl fi (F . 8**e-g**). T 3DG/C ff - (F . 8**h**). R 3DG/C - . T G- (~ 1590 $^{-1}$) 2D- (6·2699 $^{-1}$) 42 (F . 8). S D- (~1350 $^{-1}$) fl - 43 , D G (I_D/I_G)

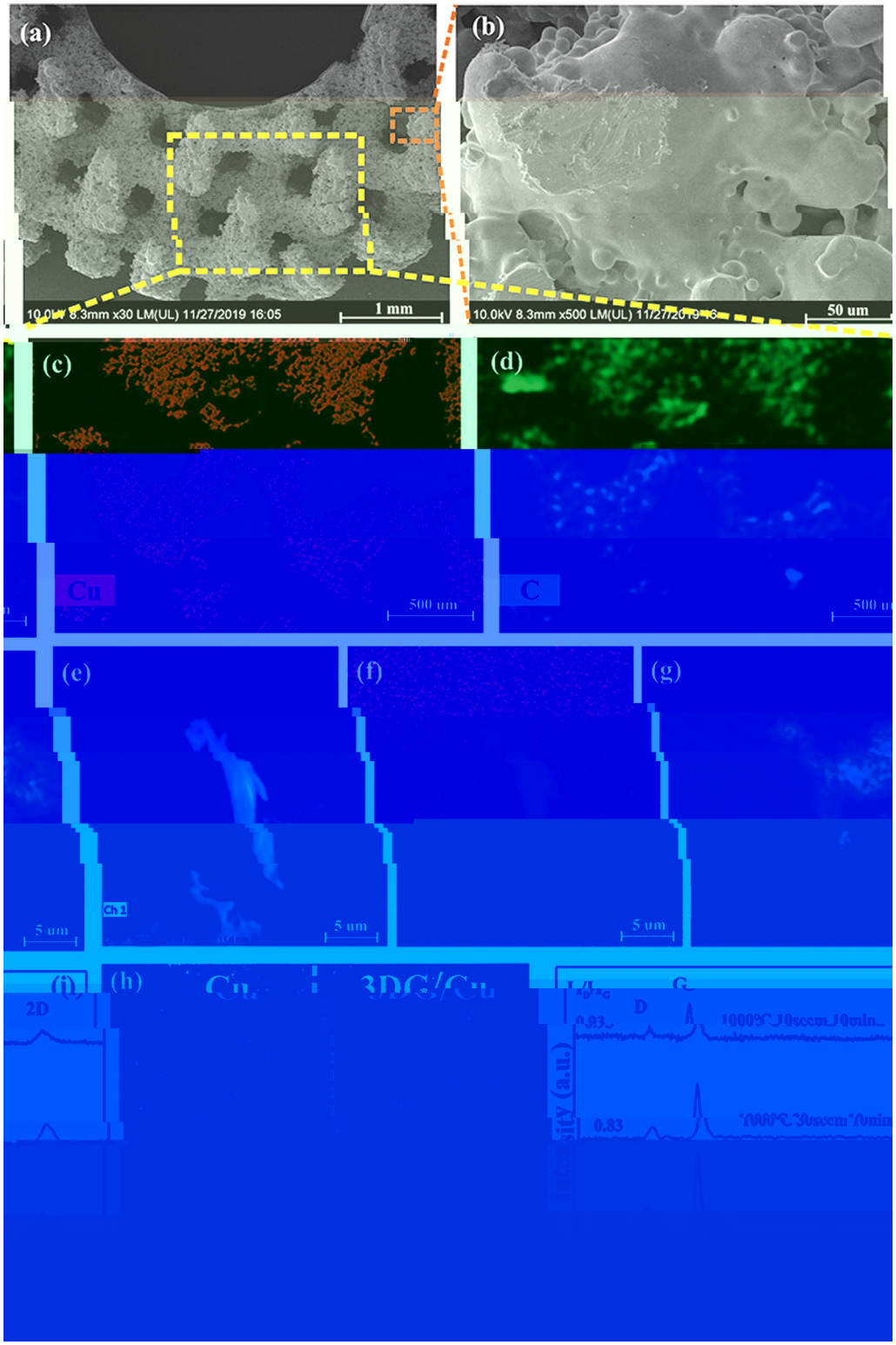

Fig. 8. (-) SEM 3DG/C ff ff fi ; EDS ( ) C ( ) C; ( ) fi SEM , EDS ( ) C ( ) C; ( ) OM; ( ) R ff ff . (F fi , .)

. W fl , I_D/I_G 0.71 0.93, - . A , (T ff 1000 C, fl CH_4 30 , C ff , 26.8% 20) 3DG/C . 14.8%

3.4. Thermal property and EMI shielding effectiveness of 3DG/Cu porous scaffolds

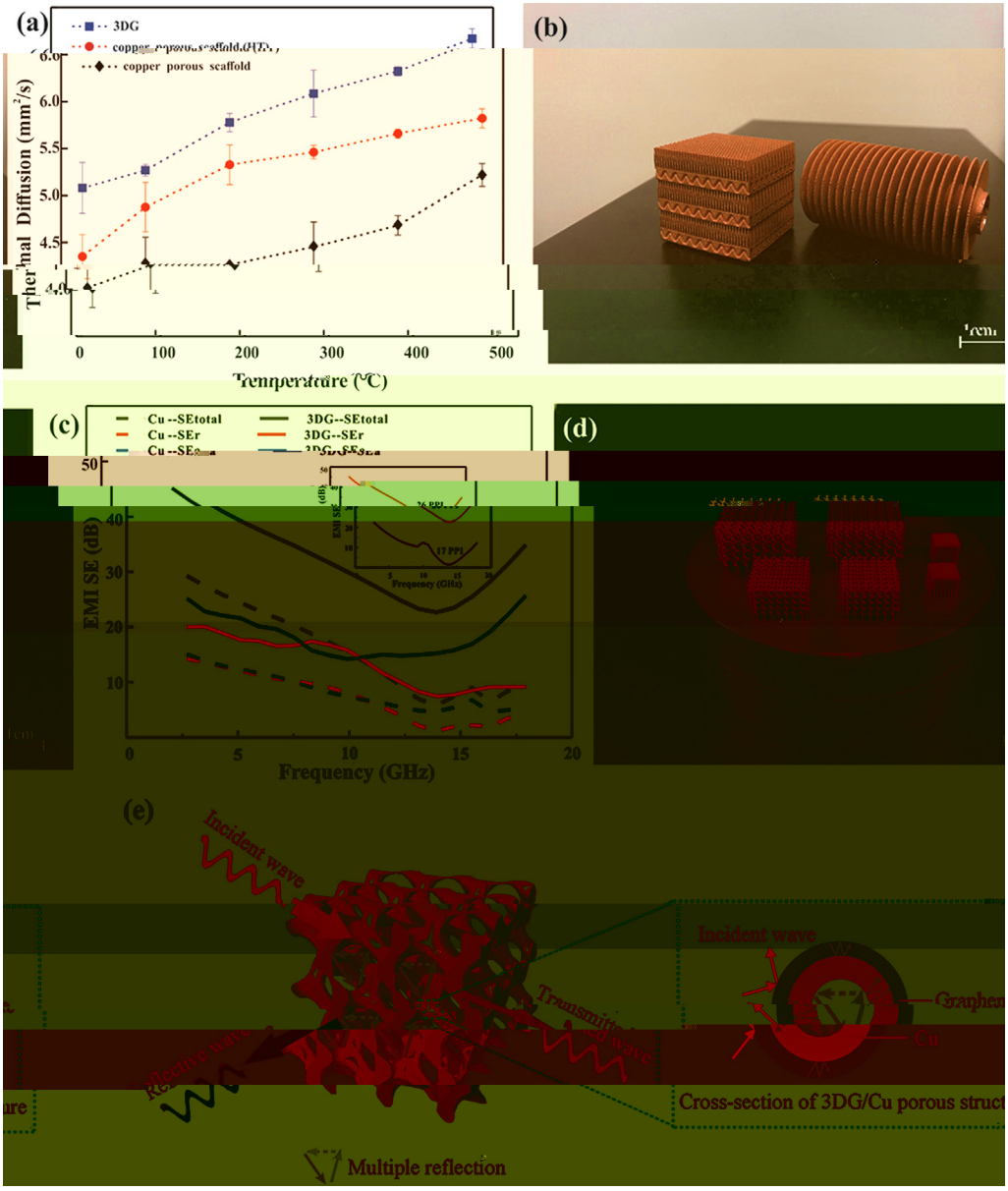

Fig. 9. P 3DG/C ff : ( ) ff ; ( ) SLM fl (- fl) - ; ( ) EMI SE; ( ) C ff ff ; ( ) S 3DG/C EMI. (F fi , .)

Table 1
C - EMI -
.

Coating materials	Substrate	Method	Maximum shielding efficiency (dB)	Improvement of thermal property (%)	Ref
G	G	I + + +	37	–	50
G	PS	H - +	29.3	–	56
G	PMMA	S + +	19	–	57
C /G /C	A	S fi +	–	8.5	58
G	N	F + CVD	–	554	59
G	C -N	+	20	–	60
G	C	P + CVD	–	2.4	61
G	C	F - +	47	6.3	62
G	C	CVD + SLM	47.8	27	T

Note: ( )-PPMA, -PS.

HT *in-situ* (F . 9**a**). S - - - 3DG/C ff . I HT 1–2 . I , . W , SLM fl (fl 500 μ) (F . 9**b**), - . G , , , - (T 1). I . O - , N . T 3DG/C ff EMI, EMI *SE,* (EM) , 2–18 GH (F . 9**c**), . W *in-situ* ff , *SE* 15.9 32.3 B, 47.8 B (88.2%), 6 20 B. T 3DG/C fi . J K . 44 EMI . T EMI *SE* 133% (. .,) 20 110 PPI ( ). R V K 45 EMI . W 17 26 PPI (F . 9**c insert**) 105% EMI *SE*. I , EMI V ff SLM. T 3DG/C 26 PPI EMI *SE* 32.3 B, 99.9% EMI . T 60 (30 ff) 46 . T EMI 3DG/C - - T 1. I EMI *SE* 3DG/C 3D - , . T EMI fl (SE_r), (SE_a) fl (EM) 47 , , , , 48 . R 49 , fl , . T EM fi 50 . R EMI . T - - - ff , C 51 . F - , - 52 S O_2 53 . W 3DG/C ff fi SE_r SE_a, F . 9**e**. W 3DG/C ff , fl , - ff . S - , 3DG/C - fl . T EM fi EM , SE_r. O , ff fi EM ff , , EM - . T ff J 54 . I fi fl ff . M , , fl , EM EM . T 44 . T 3D EM . I , CVD R - S 3.3 , 55 . I EM , . O , 3DG/C fl , fi . T ff .

4. Conclusions

A 3DG/C ff *in-situ* CVD . T ff . W , 3DG/C EMI *SE* 15.9 ( ) 32.3 B, 47.8 B (88.2%), 26.8% ff . T 3DG/C ff fl , fl - . T V EMI 3DG/C ff EMI .

Credit authorship contribution statement

Kaka Cheng: C , M , F , W - . **Wei Xiong:** V , I , W - . **Yan Li:** W - & , F , R , S . **Liang Hao:** F . **Chunze Yan:** R , F . **Zhaoqing Li:** V . **Zhufeng Liu:** F . **Yushen Wang:** I , S . **Khamis Essa:** W - & . **Li Lee:** D . **Xin Gong:** S . **Ton Peijs:** W - & , S .

Declaration of Competing Interest

T fl .

Acknowledgement

T fi N N S F C (N . 51671091, N . 51902295, N . 51675496). T J F R F C U , C U G (W) (N . (N . CUG170677) H P N S F (N . 2019 CFB264).

Appendix A. Supplementary data

S :// . /10.1016/J .2020.105904.

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