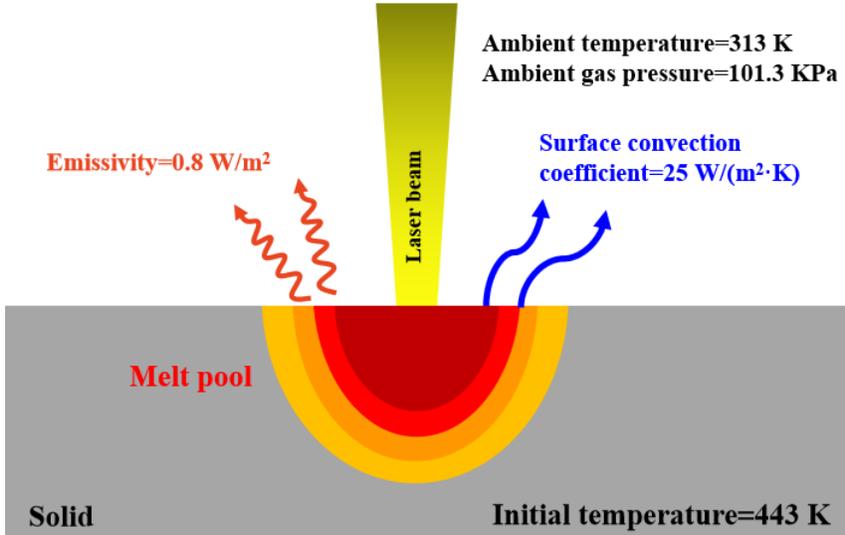


Supplementary Figure S1. Schematics showing the hatch scanning strategy and contour scanning (yellow lines) used in the present study.

Laser heat source denoted by subroutine



Supplementary Figure S2. Schematic showing the boundary conditions set in the simulation model of a melt pool.