

Figure S1. # 3D roughness map of S8 sample.

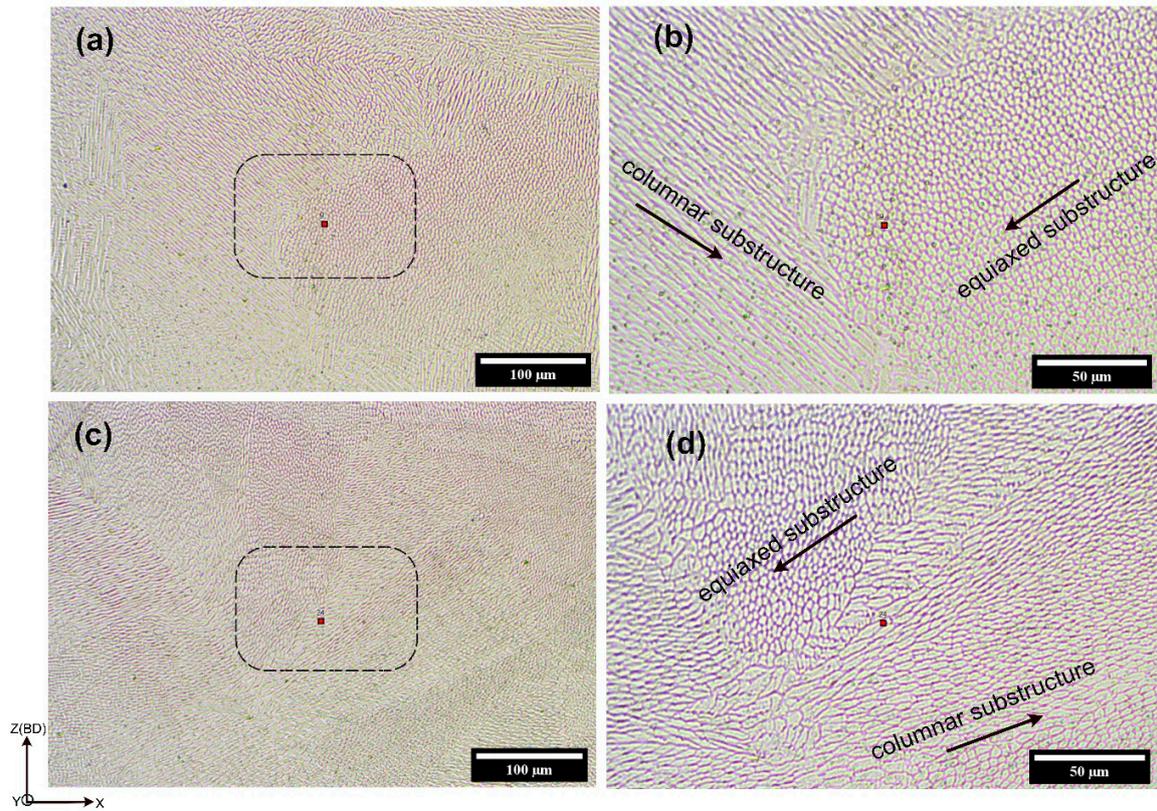


Figure S2. # Optical micrographs of (a,b) S2 sample; (c,d) S8 printed samples showing the presence of both cellular columnar and equiaxed substructure. The area bounded by dashed lines in (a,c) are magnified in (b,d) respect.

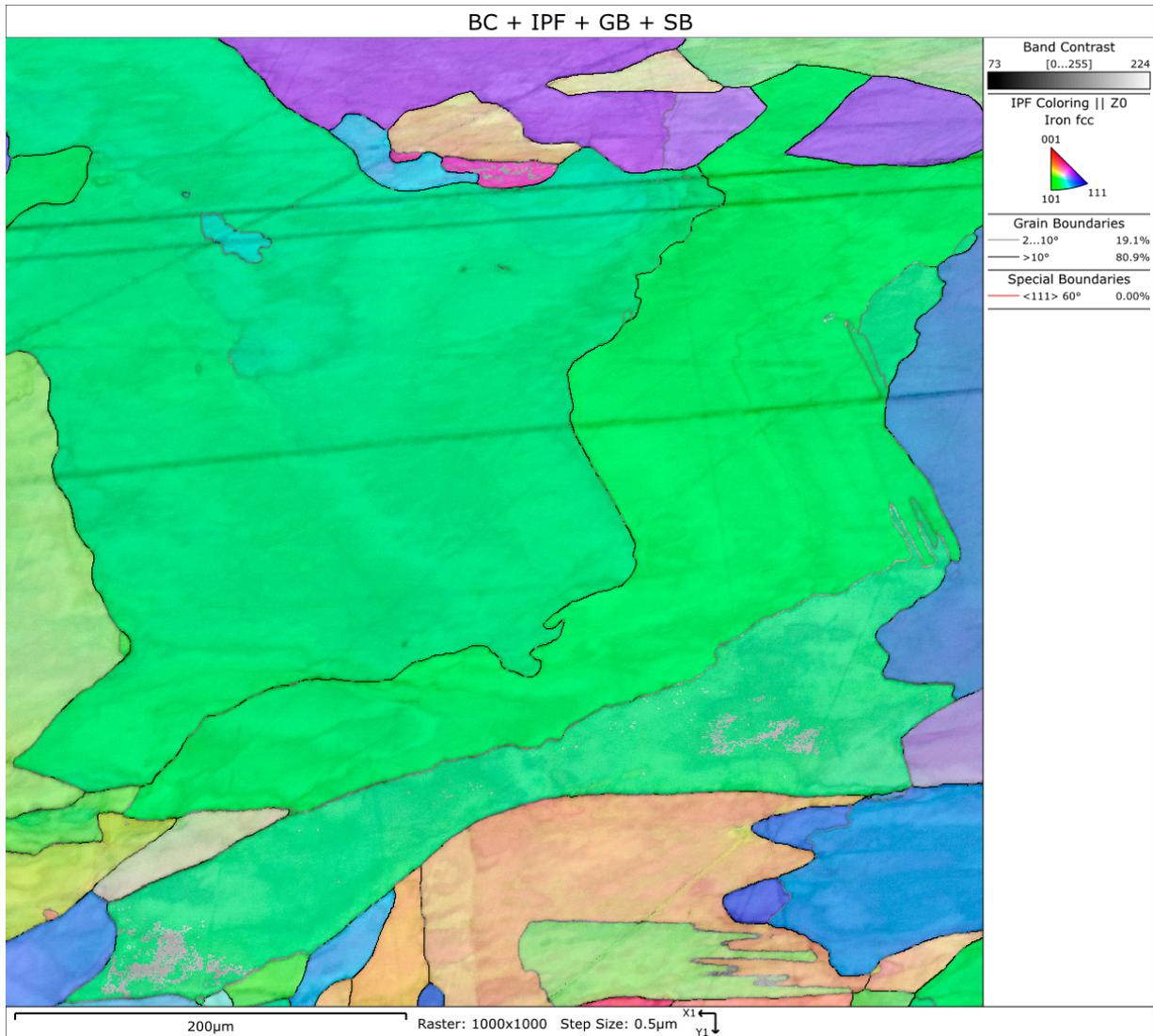


Figure S3. ## EBSD map for S2 sample.

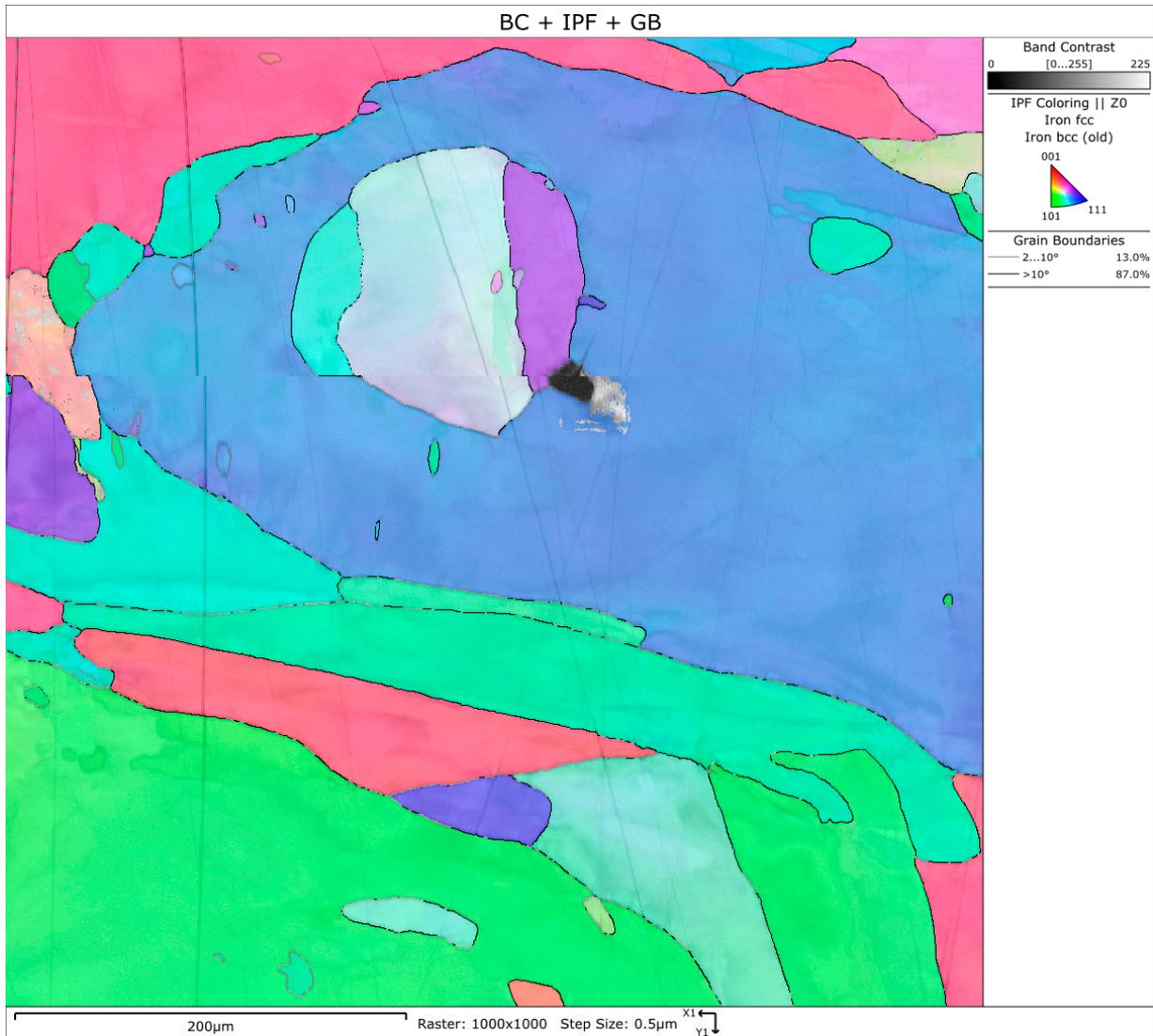


Figure S4. ## EBSD map for S4 sample.

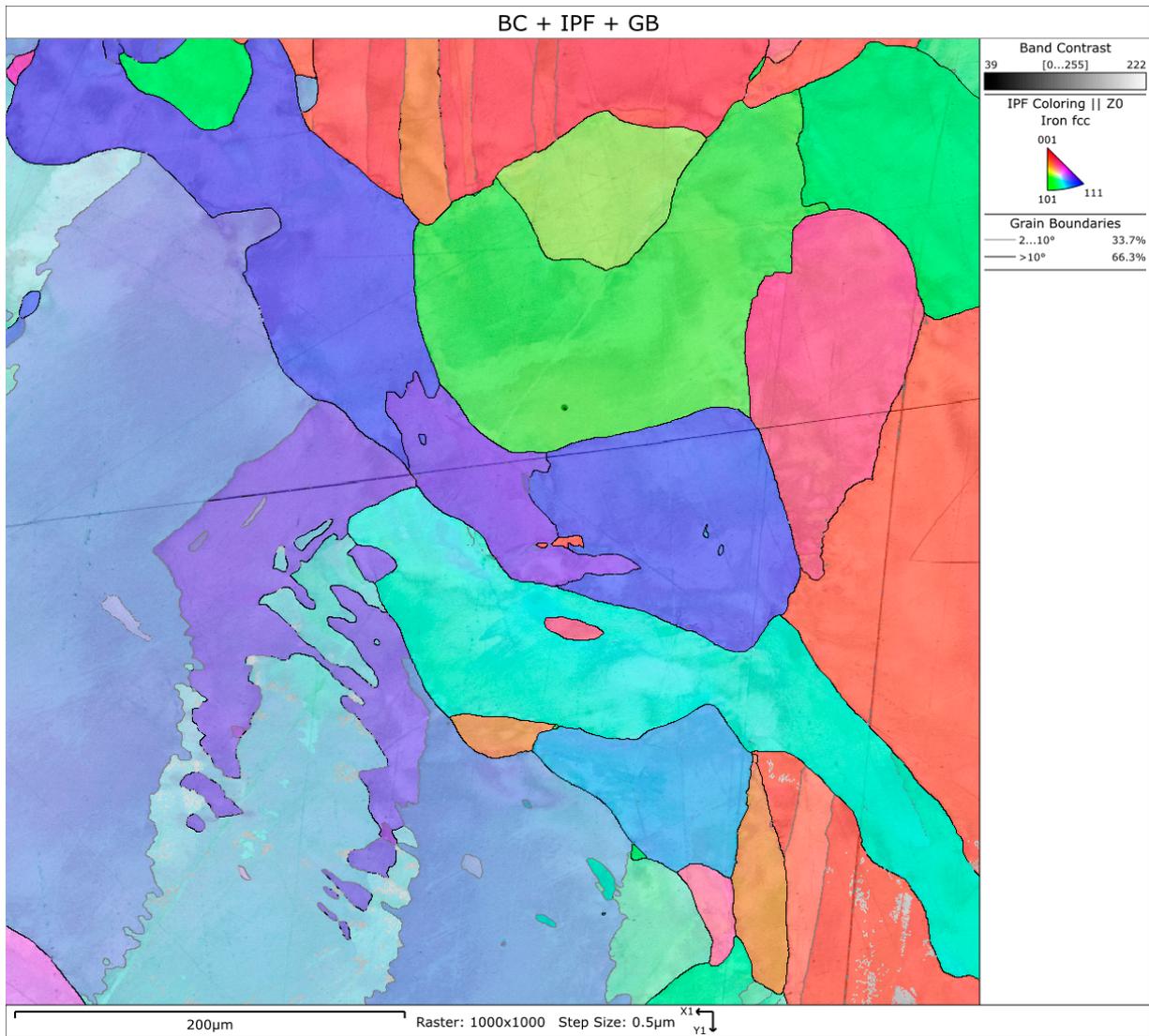


Figure S5. ## EBSD map for S8 sample.