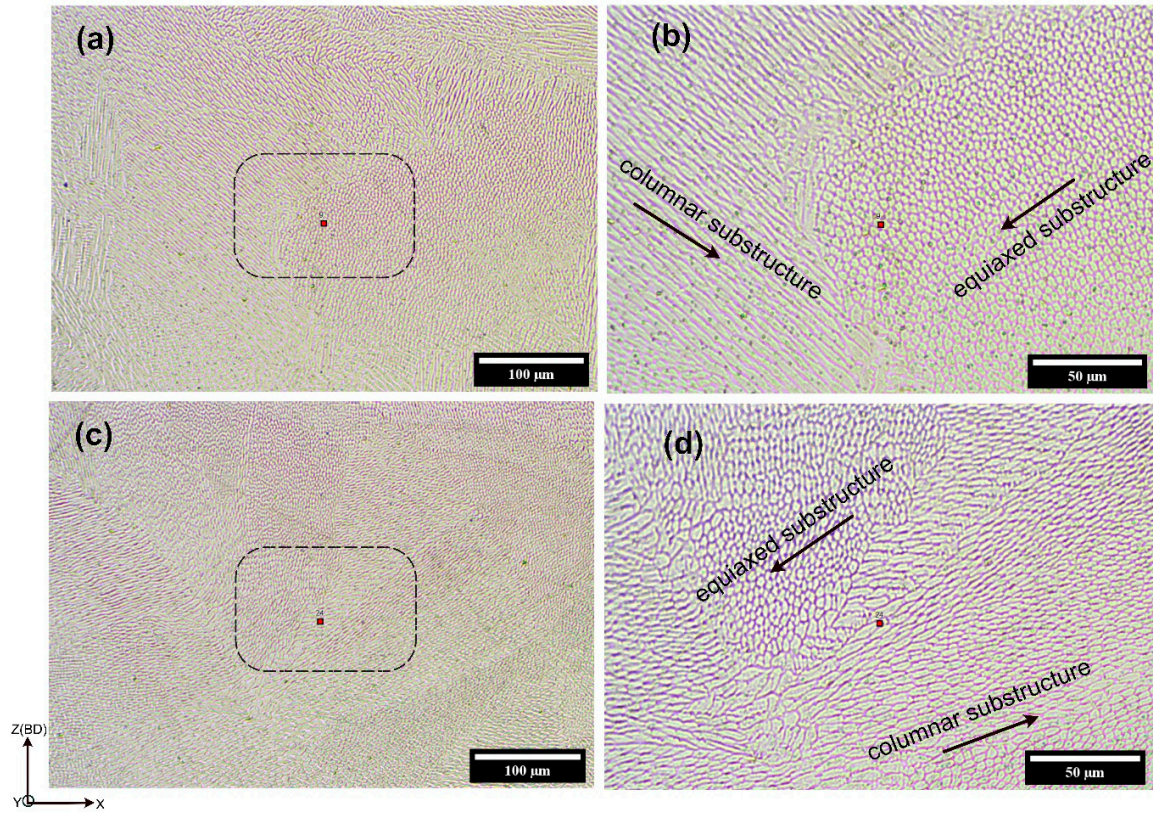
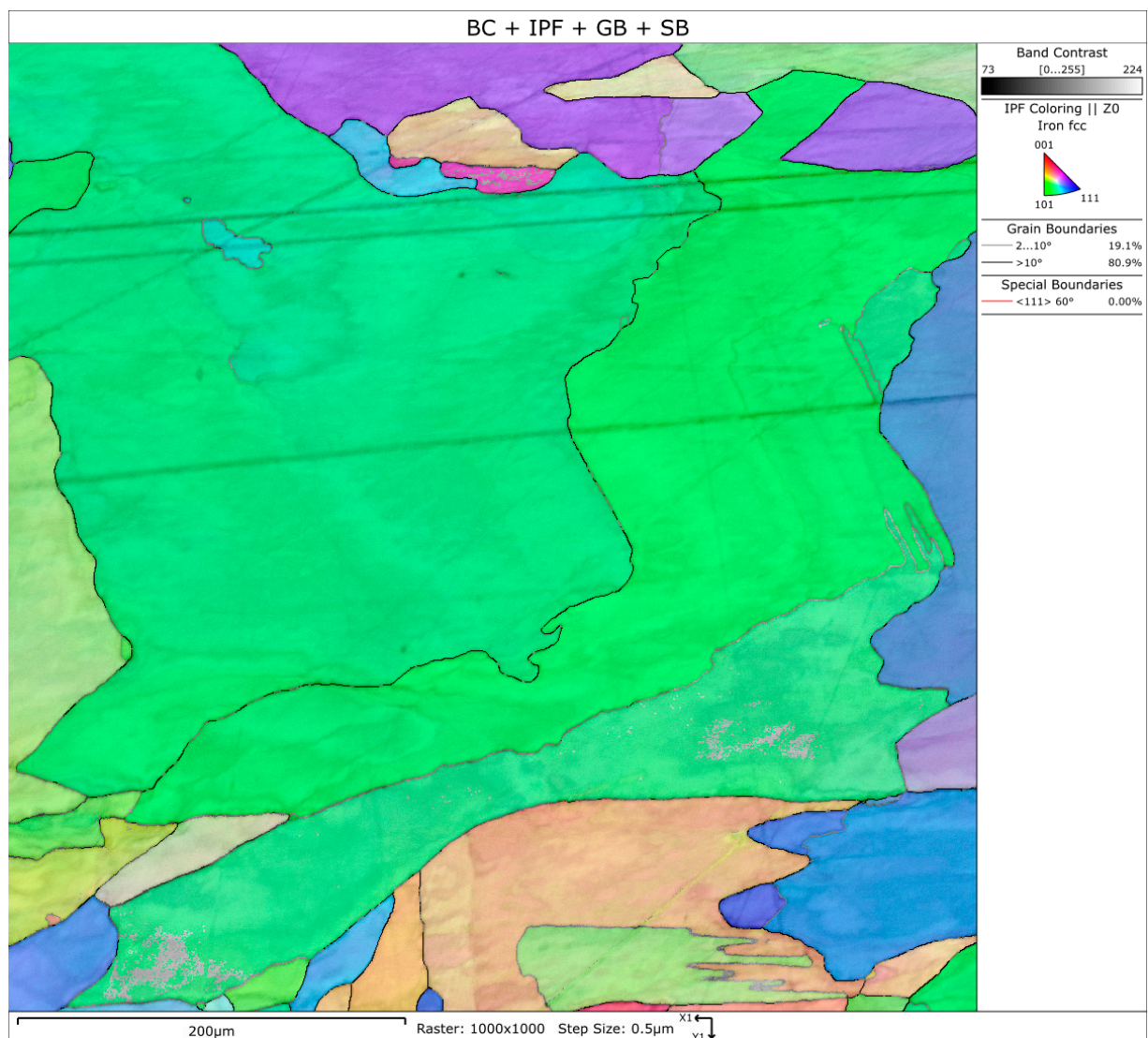


**Figure S1. #** 3D roughness map of S8 sample.

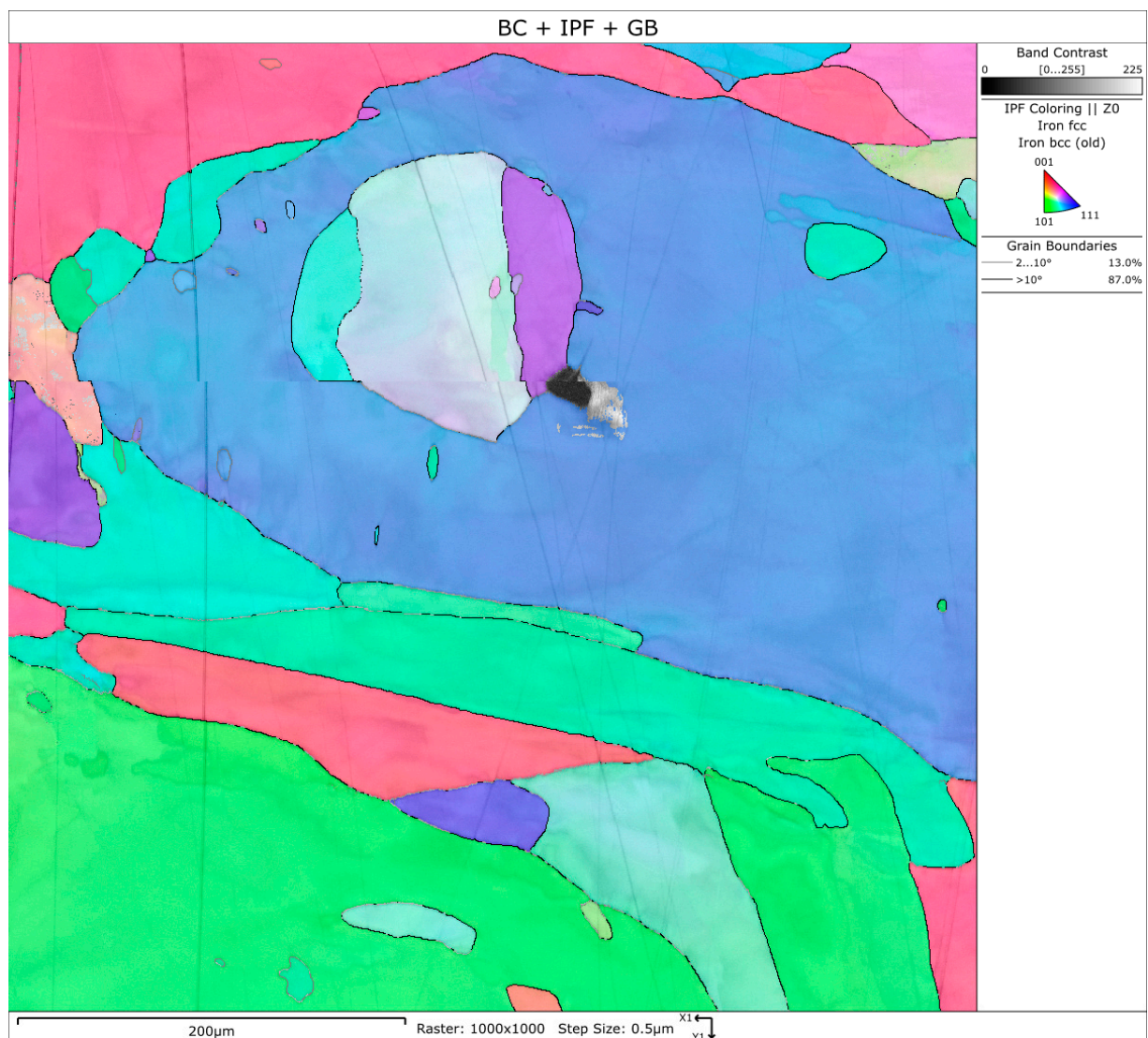


**Figure S2. #** Optical micrographs of (a,b) S2 sample; (c,d) S8 printed samples showing the presence of both cellular columnar and equiaxed substructure. The area bounded by dashed lines in (a,c) are magnified in (b,d) respect.

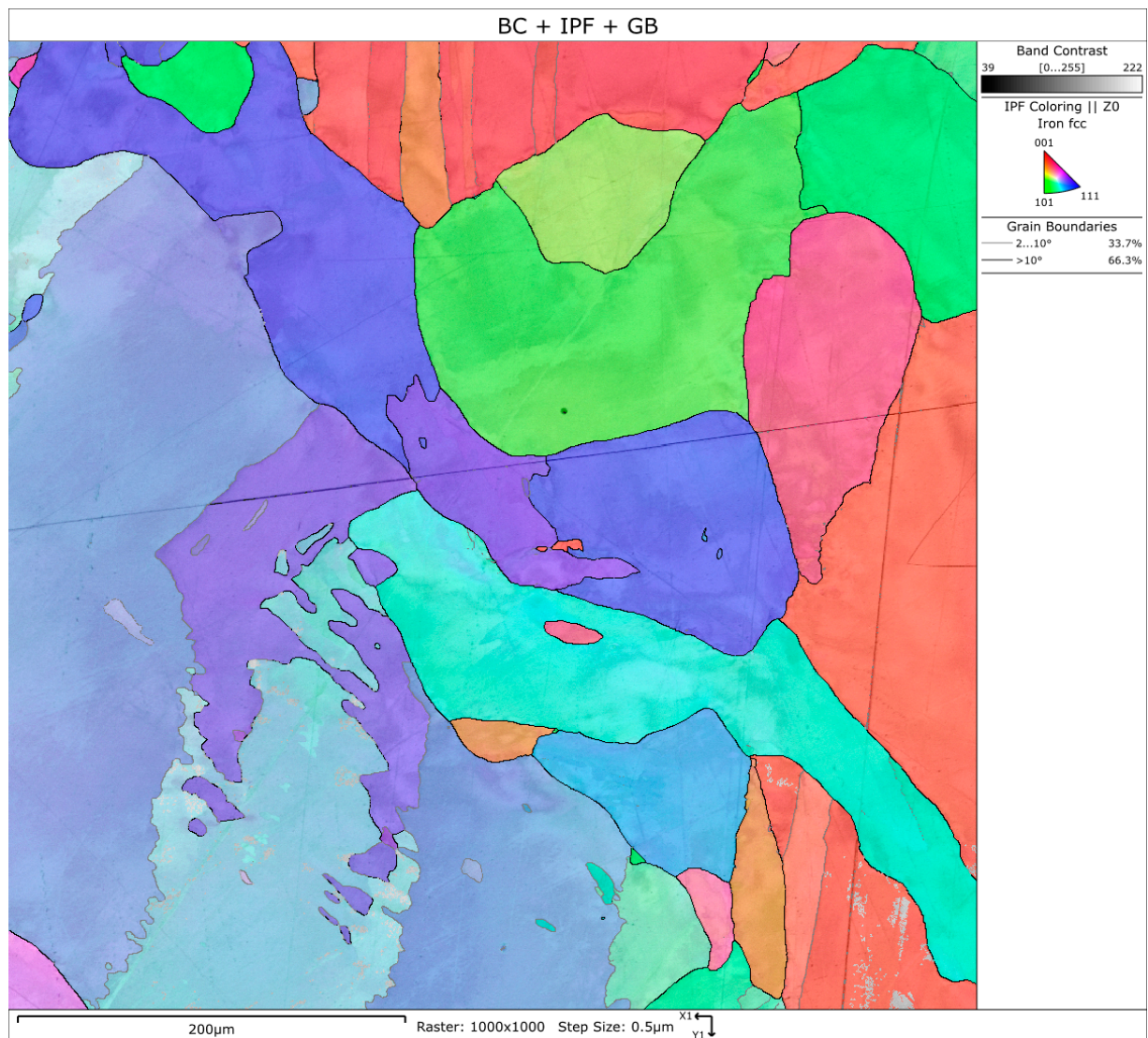


**Figure S3. ##** EBSD map for S2 sample.





**Figure S4. ##** EBSD map for S4 sample.



**Figure S5. ##** EBSD map for S8 sample.