



$X_{\text{Con20},n_{\text{melting pool}}}$

$X_{\text{Con20},n_{\text{powder covered melting pool}}}$

Referenced lateral displacement in x

$$s_{x_{\text{melting pool}}} = 62.1 \mu\text{m}$$

$$s_{x_{\text{powder covered melting pool}}} = 72.1 \mu\text{m}$$

$$s_{x_{\text{displacement}}} = 26.7 \mu\text{m}$$