Table. S1 Average porosity under different process parameters

Parameter V_f/V_w	4/6	5/6	5/7	6/8	6/9	7/9
Average porosity (%)	2.7±0.3	2.0±0.2	2.0±0.2	3.4±0.3	1.4±0.2	1.3±0.2
Average grain size (μm)	50.0±3.3	54.2±5.0	48.4±3.3	51.7±4.1	48.1±2.9	54.7±3.8