

Iron Powder Storage Guidelines

- Store the powder indoors in dry conditions (relative humidity of less than 60%) at room temperature (20 °C).
- Avoid exposure to sunlight.
- The recommended maximum storage time at <60% RH and ≤20 °C is 6 months from certificate of analysis date. Higher temperatures and/or higher humidity will reduce the recommended storage time. Premixes containing MnS will have even shorter storage times at elevated temperatures and/or humidity conditions.
- Store the material on pallets and avoid contact with the walls or the floor. Do not stack powder containers directly on top of another.
- It is suggested to use the powder as soon as possible once the package is open.
- Check the condition of material that has been stored for longer than the recommended time prior to use. Checks can include AD, flow, and visual inspection for rust and agglomeration.
- Make sure the powder temperature is similar to the temperature near the compaction press. Significant differences can cause flow issues and/or condensation on the powder.

Recommended Maximum Storage Times

| Product | 20 °C (68 °F) and below | 30 °C (86 °F) | 40 °C (104 °F) |
|--|-------------------------|---------------|----------------|
| Base Iron, Low Alloy Steels and Premixes | 6 months | 3 months | 2 months |

* Times based on relative humidity less than 60%