



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 for unopened packages is 6 months from certificate of analysis date. Higher temperatures and/or higher humidity will reduce the recommended storage time. For premixes containing MnS, the recommended maximum storage time is 4 months for unopened packages.
- 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.
- It is suggested to use the powder as soon as possible once the package is open.
- Store the material on pallets and avoid contact with the walls or the floor. Do not stack powder containers directly on top of another.
- 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%