

**INDO-MIM PVT LTD.**

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PLM-247

PLM-247 is a Ni-base superalloy used for its creep resistant and outstanding oxidation resistant. Its Chemical Composition corresponds to UNS___ for use in additive manufacturing processes. Vacuum Induction Melting - Inert Gas Atomization process is used at INDO-MIM for manufacturing of powder. Our unique ASB technique improves powder sphericity, which enhances flowability in achieving consistent density and uniform build rates.

Particle Size Distribution

Light scattering (ASTM B822 / ISO 13320-1)				
Application	Size Range	D10%	D50%	D90%
MIM	<22µm	5.0 max	12.0 max	22.0 max
BJ	<25µm	5.5 max	13.5 max	25.0 max
LPBF	15 – 53µm	24.0 max	36.0 max	54.0 max

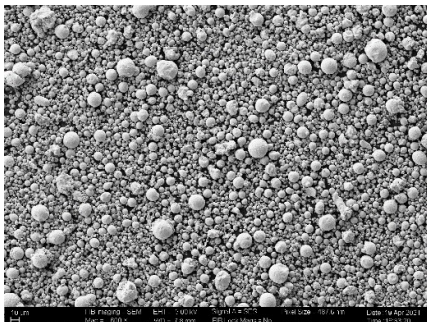
Physical Properties

Property	g/cc	Test Method
Tap Density	4.60 min	ASTM B527
True Density	8.00 min	ASTM B923

Chemical Composition (weight %)

Element	Range (%)
Carbon	0.06 – 0.09
Silicon	0.00 – 0.25
Manganese	0.00 – 0.10
Phosphorous	0.012 max
Sulphur	0.012 max
Aluminium	5.45 – 5.70
Chromium	8.10 – 8.50
Tungsten	9.40 – 9.70
Cobalt	9.10 – 9.50
Oxygen*	0.03 max
Nitrogen*	0.03 max
Iron	Balance

Morphology



* Applicable only for LPBF

Customization on chemical composition & particle size can be made.

Packing with 10 / 50 / 100 kg containers & custom packing is possible.

MIM: Metal Injection Molding | BJ: Binder Jetting | LPBF: Laser Powder Bed Fusion

*Specification is only for illustrative purposes, and it varies with specific application requirements