WHAT IS CLAIMED IS:

1. A metal powder for additive manufacturing, comprising, by mass%, 14.0% to 24.0% of Ni, 2.0% to 8.0% of Mo, 11.5% to 13.0% of Co, 0.01% to 2.00% of Al, and 0.10% to 3.00% of Ti, the balance being Fe and unavoidable impurities.

2. The metal powder for additive manufacturing of claim 1, wherein 0.030% by mass or less of nitrogen is included.

3. The metal powder for additive manufacturing of claim 1 or 2, wherein 0.040% by mass or less of oxygen is included.

4. An additively manufactured product, comprising, by mass%, 14.0% to 24.0% of Ni, 2.0% to 8.0% of Mo, 11.5% to 13.0% of Co, 0.01% to 2.00% of Al, and 0.10% to 3.00% of Ti, the balance being Fe and unavoidable impurities, wherein in a cross section thereof parallel to a build direction thereof, there is fewer than 0.1 defect having an equivalent circle diameter of more than 20 μm per 1 mm^2, as measured by a method including:

taking the cross section parallel to the build direction from a central position of the of the additively manufactured product, the cross section parallel to the build direction being confirmed from traces of stacking in the additively manufactured product and a form of the additively manufactured product;

capturing images of the cross section using an optical microscope;

connecting the captured images to create a cross-sectional image of 1.25 mm or more in length and 1.6 mm or more in width, wherein an area of 1.25 mm or more in length and 1.6 mm or more in width is defined as one field of view, and 5 fields of view are photographed to obtain a measurement field of 10 mm^2;

binarizing each imaged field of view to clarify a boundary between a defect and a base material; and

measuring the number of all defects with an equivalent circle diameter of 5 μm or more in the field of view.

5. The additively manufactured product of claim 4, wherein in the cross section parallel to the build direction, there is 0.1 or more and less than 10 defects having an equivalent

circle diameter of 5 μm or more and 20 μm or less per 1 mm^2, as measured by the method defined in claim 4.