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Mr Adi Subardi:

Thank you for submitting the manuscript, "EFFECT OF Mn CONTENT ON MECHANICAL
BEHAVIOR AND CORROSION RESISTANCE OF Fe-5Al-1C ALLOYS" to «Eastern-European
Journal of Enterprise Technologies». With the online journal management
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If you have any questions, please contact me. Thank you for considering this
journal as a venue for your work.

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От: **Oksana Nikitina** <0661966nauka@gmail.com>
Date: чт, 17 дек. 2020 г. в 19:43
Subject: Re: from "Eastern-European Journal of Enterprise Technologies" - Adi Subardi (stage 2, February)
To: <ratna@itny.ac.id>, <andyerwin@itny.ac.id>

Good afternoon, dear authors, this is a reminder letter that we are expecting an edited version of the article from you no later than December 19, 2020.
We wish you a good day and a great mood!
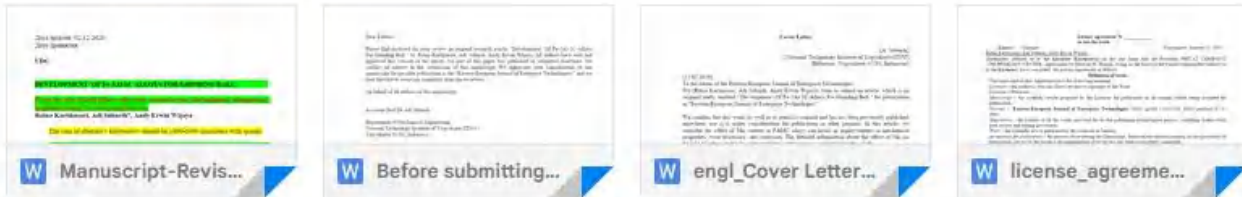We are always ready to help you!
with respect, Oksana Nikitina

Good afternoon, I have read the suggestions carefully and revised the manuscript as attached.
Regards,

Adi Subardi

...

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ср, 2 дек. 2020 г. в 12:21, Oksana Nikitina <0661966nauka@gmail.com>:

Good afternoon, dear Adi Subardi.

The article was accepted for consideration of the possibility of publication in (No. 1.2021).

At the 2 - stage of editing, please take into account the comments of the editor (article in the application, color notes are highlighted).

WE ASK YOU TO RIGHT STRICTLY IN THE OPTION WHICH IS IN THE APPENDIX (see appendix).

We ask you not to delete the comments so that we can see all your edits. All corrections by the author, please highlight in green.

Please provide an edited version of the article **by 07.12.2020.**

P.S. Please attach the documents to the article and send them to this address together with the article. I would like to remind you that we are not offering you an advance at this time, as we will be offering it in January 2021. We inform you that the article should be at least 15 pages, designed in accordance with the requirements of the site http://jet.com.ua/en/publication-terms/rules-for-submitting (the cost of 1 page - 25 euro, the Journal
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We are in touch 24/7.

with respect, general manager
Oksana Nikitina
viber +38(050)303-38-01
✉ 0661966nauka@gmail.com
twitter, linkedin
==================
Editorial staff of the "Eastern-European Journal of Enterprise Technologies"
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UDC

MICROSTRUCTURE AND IMPACT PROPERTIES OF Fe-11Al-xMn ON CRYOGENIC TEMPERATURES
From the title should follow what your research was: development, comparison, implementation, research, analysis, etc.

ANALYSIS Fe-11Al-xMn ON CRYOGENIC TEMPERATURES

Ratna Kartikasari, Adi Subardi, Andy Erwin Wijaya

This research is focused on increasing the reliability of Fe-11Al-Mn by combining the properties of Mn and the superiority of Fe-Al-C under cryogenic temperature. Three Fe-11Al-Mn alloys with compositions of 15 wt % Mn (F15), 20 wt % Mn (F20), and 25 wt % Mn (F25) were investigated. The cryogenic process uses liquid nitrogen in a temperature range of 0 ºC–196 ºC. Hardness testing using the Vickers method and SEM was used to analyze the microstructure. X-ray diffraction (XRD) testing was conducted to ensure the Fe-11Al-Mn alloy phase and corrosion testing was carried out using the three-electrode cell polarization method. With the addition of Mn, the Vickers hardness of the Fe-11Al-Mn alloy decreased from 331.50 VHN at 15 wt % to 297.91 VHN at 25 wt %. The value of tensile strength and fracture elongation values were 742.21 MPa, 35.3 % EI; 789.03 MPa, 41.2 % EI; and 894.42 MPa, 50.2 % EI, for F15, F20, and F25, respectively. An important factor for improving the performance of cryogenic materials is the impact mechanism. The resulting impact toughness increased by 2.85 J/mm^2 to 3.30 J/mm^2 for F.15 and F25, respectively. The addition of the element Mn increases the corrosion resistance of the Fe-11Al-Mn alloy. The lowest corrosion rate occurs at 25 % wt Mn to 0.016 mm/year. Based on the results, the F25 alloy has the highest mechanical and corrosion resistance of the three types of alloys equivalent to SS 304 stainless steel. The microstructure of Fe-11Al-Mn alloy was similar between before and after cryogenic temperature treatment, this condition showed that the microstructure did not change during the process. From the overall results, the Fa-11Al-Mn alloy is a promising candidate for material applications working at cryogenic temperatures by optimizing the Mn content.

Keywords: Fe-11Al-Mn, Microstructure, Mechanical characteristics, Impact, Corrosion resistance, Cryogenic temperature

1. Introduction

The development of food technology demands that commodities remain fresh and healthy both during storage and processing. Cryogenic technology provides the best solution where food is frozen at freezing point therefore it lasts longer. It has

been found that cryogenic freezing technology provides several advantages compared to conventional freezing, cryogenic technology can prevent the destruction of adenosine triphosphate (ATP) in fresh seafood products during the storage period, can accelerate the freezing of food products such as meat and eggs, inhibits the growth of microorganisms that destroy food products, prevent damage to the nutrition of food products. Cryogenic-based technology is also widely applied in various fields such as metallurgy, chemistry, petrochemical, power generation industry, and rocket propulsion, and food processing [1].

In the medical field, cryogenic technology plays a vital role in surgical operations by utilizing cryogenic temperatures to separate bad cells or cancer cells, while in the field of genetic engineering, cryogenic technology provides an opportunity for cells to survive. The use of low-temperature gases in a liquid state such as nitrogen, oxygen, and carbon dioxide is a necessity in cryogenic technology [2].

Handling of these materials is quite complicated and potential problems are avoided. Because liquefied gas is considered dangerous, during transportation and uses it requires safety guarantees. Currently, research on the application of cryogenic technology is focused on the design of containers or cooling jackets, also on temperature stability along with the design of the controller, and the most recent one is an effort to find the best material to be used as a cryogenic cooling container or jacket including the cryogenic vacuum pipe.

Investigations on the performance of Fe-Al-Mn steel have been widely reported. However, optimization of Mn content in Fe-Mn-Al-C steel systems has not been widely reported.

Please add the relevance of your work in this direction.

2. Literature review and problem statement

How this section should be built: The paper [.] presents the results of research ..., Shown, that..., But there were unresolved issues related to ..., The reason for this may be (objective difficulties associated with ..., fundamental impossibility ..., cost part in terms of ..., which makes relevant research impractical, etc.). A way to overcome these difficulties can be ..., This approach was used in [.], however ..., All this suggests that it is advisable to conduct a study on ...

Use 7–10 references to the literature, each of the used sources should be accompanied by a comment (at least one sentence)

The section of the article "Analysis of literary data" is intended to show (highlight) parts of the problem that are not solved by other scientists. The outcome of the review is the identification of a "niche" of research that is not occupied by other scientists in this problem. This section is written on the basis of publications of **periodical scientific publications** (books, textbooks, monographs do not belong to those). A review of periodicals on a problem investigated by the author should include sources no more than 5–10 years old, and a review of foreign scientific

The operating temperature of the cryogenic technology reaches –253 °C in liquid hydrogen. The use of cryogens has the potential to cause physical hazards such as serious burns to the skin, permanent damage to the eyes, and ruptured vessels. In addition to creating a physical hazard, cryogenic materials can also be corrosive, flammable, and reactive.

Materials for cryogenic applications are carefully selected because their properties change drastically when exposed to very low temperatures [3]. Materials that are usually ductile at atmospheric temperatures, but tend to be very brittle at cryogenic temperatures, whereas other materials can increase ductility. Other factors need to be considered, especially the joining technique used must be chosen properly therefore that it does not change the basic properties of the material [4]. The properties of different materials at low temperatures depend on various factors such as crystal structure, grain size, tendency to absorb contaminants from the atmosphere, heat treatment, melting process, welding, and deformation.

As previously reported, the 300 series austenitic stainless steel are widely used for cryogenic applications due to their high strength and toughness at low temperatures. These alloys generally contain chromium (Cr) ranging from 18–21 % and nickel (Ni) 9–14 %. However, not the majority of austenitic stainless steels can be used below cryogenic temperatures because some austenitic stainless steels change the structure from FCC to BCC resulting in decreased ductility and toughness [4]. Another issue with austenitic stainless steel is the high cost of elemental Ni and the limitation of Cr sources around the world. Materials experts have made numerous attempts to identify replacement alloys for expensive Cr alloys and Ni-based alloys. The benefits of high austenitic Mn steels, including low cost, high strength, high ductility, and toughness, have been developed for cryogenic applications in the liquefied natural gas industry.

FCC metals are widely used because of their moderately low-temperature toughness, whereas BCC metals exhibit a ductile-brittle transition. Austenitic stainless steel (9% Ni) are commonly used in large-scale industries, although significant effort has been directed towards replacing expensive Ni-based alloys with low-cost high Mn steels of comparable strength, ductility, and toughness [4]. The Fe-Al-Mn alloy is one of the innovations developed by researchers in the material world. The Fe-Al-Mn alloy system is a low-cost austenitic type stainless steel due to the abundance of Al in the world [5]. Aluminum (Al) also functions as a structural stabilizer of ferrite [6], the addition of this element in the alloy system can increase oxidation and reduction resistance. The addition of Mn to the alloy system stabilizes the austenite structure, improves heat workability and ductility [7].

The stability of austenite can also be improved by adding carbon to the alloy system. The addition of 1% carbon contributes to the strength quite significantly [4]. Fe-Al-Mn alloys can be increased in strength by heat treatment aging [8]. The addition of 2 % Mn and Mo elements can increase ductility and toughness when the addition of 0.5 % Si elements are proven to increase the tensile strength of Fe-7.5Al-5Mn [9].

The high Mn content (> 35 %) causes the alloy to tend to be brittle due to the formation of the β-Mn phase. When Al content is above 12%, the alloy tends to form a ferritic stainless steel alloy system. The addition of Si to the Fe-Al-Mn alloy system causes a decrease in ductility due to the formation of carbide [10]. The decrease in ductility can be reduced by decreasing the Al content up to 5 %. The mechanical properties of Fe-Al-Mn alloys are influenced by the perfection of the austenite alloy structure which is determined by the content of Mn (> 15%) and Al (3-6 %). In addition, during the solution heat treatment process until quenching, the κ-carbide precipitate will be formed if the content of C and Al elements is sufficient [11].

Charles (1982) and Kim (1985) surname is not mentioned in scientific articles, enough references to works The authors of [12,13,14] demonstrated that Fe-Al-Mn alloys exhibit outstanding mechanical properties at low temperatures, therefore Fe-Al-Mn alloys can be considered potential new cryogenic alloys] **There should be a critical analysis of each source**. Also, various steel alloys have been investigated under cryogenic temperature treatment (15–22).

This work will formulate the Mn content ratio which has a significant effect on the performance of Fe-Al-Mn alloys and analyze the impact ability of the material at cryogenic temperatures.

3. The aim and objectives of the study

The aim of the study is to development of Fe-11Al-xMn [x =15 wt %, 20 wt %, and 25 wt %] alloys for a cryogenic cooling container or jacket including the cryogenic vacuum pipe.

To achieve this aim, the following objectives are accomplished:

– modify the structure of Fe-11Al-Mn by adding Mn content (15 wt %, 20 wt %, and 25 wt %);

– investigate the mechanical properties (hardness, tensile strength, and impact);

– investigate the physical properties of corrosion resistance;

– investigate the microstructure & the impact performance at the cryogenic temperature.

4. Materials and methods for preparing and testing specimens

This section should mention only about the way the research was carried out: theoretical methods, software and hardware, conditions of the experiment and validation of the proposed solutions (adequacy of the proposed models, etc.). Thus, everything should be noted about obtaining results, but no result is given in this section.

This section is irrelevant to the problem statement in section 3, as the problem in section 3 is relevant to section 5. "Research results...".

The raw materials for smelting are Fe-C, Fe-Mn-C medium, pure Al, and mild steel scrap. The composition calculation is conducted manually with material balance and smelting using a vacuum furnace. The wooden pattern is in the form of an ingot measuring 20 cm x 3cm x 3cm and is in the shape of a ball with a diameter of 30 mm, followed by making resin molds.

The smelting of the Fe-Al-Mn alloy begins with the manufacture of a starter block, namely the smelting of mild steel, Fe-Mn-C medium, and Fe-C with a target composition of 0.5%C and with variations of Mn 15, 20, and 25 wt %. The next stage is the smelting of the cylinder block with Al in an induction furnace with argon gas shielding. Composition control is carried out with a chill tester before pouring. Next hold, the molten metal is poured into the ingot mold manually using a ladle. Inspection of castings is carried out to ensure that the Fe-Al-Mn alloy castings are free from defects.

Specimen preparation for the characterization of Fe-11Al-xMn alloys included microstructure testing, tensile testing, hardness testing, impact testing, and corrosion resistance testing with three-electrode cell polarization. Microstructure testing was carried out with an optical microscope and SEM coupled with EDS-EDAX. The XRD test was carried out to confirm the Fe-Al-Mn alloy phase. Corrosion testing was carried out using the 3-electrode cell polarization method in a 0.5 % HCl solution.

5. Result of Experiment
This section is directly related to the tasks and describes the solution of tasks set in section 3. Each task has its own section: 5.1, 5.2,... It is also important that this section 5 should not be interpreted, the results of each task should be given in the form of "dry residue": formulas, tables, figures.

Structure the "Research results" section according to the task at hand (section 3):

**5.1….**

5.2…..

**number of tasks (Section 3) = number of subsections Result**

5. 1. Modify the structure of Fe-5Al-1C
### 5. 1. 1. The chemical compositions
The XRD patterns for F15, F20, and F25 are shown in Fig. 1. The specimen synthesis process was successful, there were no peaks caused by impurities. The XRD pattern in Fig. 1a-1c shows that the Fe-11Al-15 Mn alloy consists of two dominant phases, austenite (γ) at an angle 2-theta of 45° and ferrite (FeAl) at an angle 2-theta of 75°. At 20 % Mn the austenite phase increased while the ferrite (FeAl) phase decreased significantly.
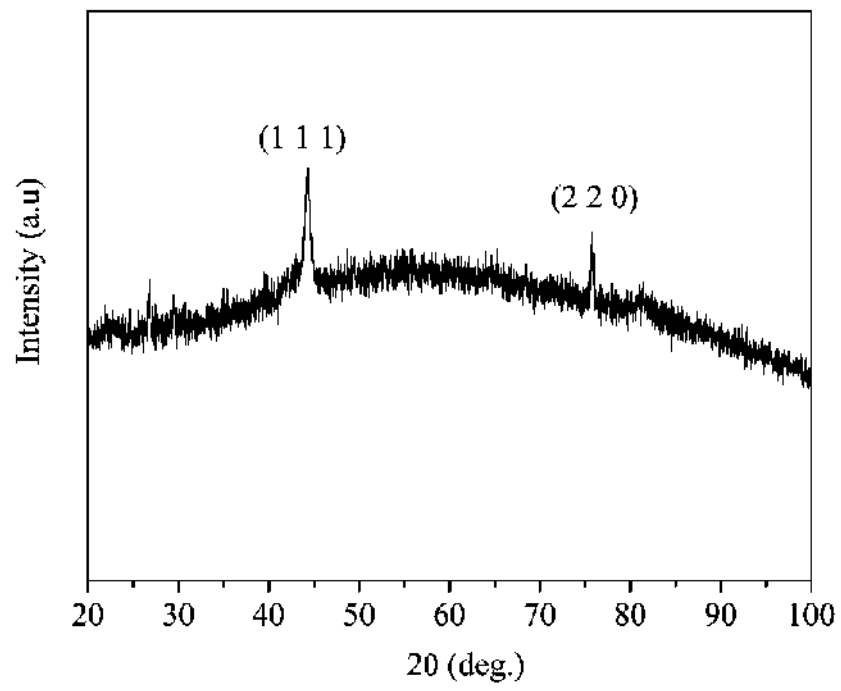
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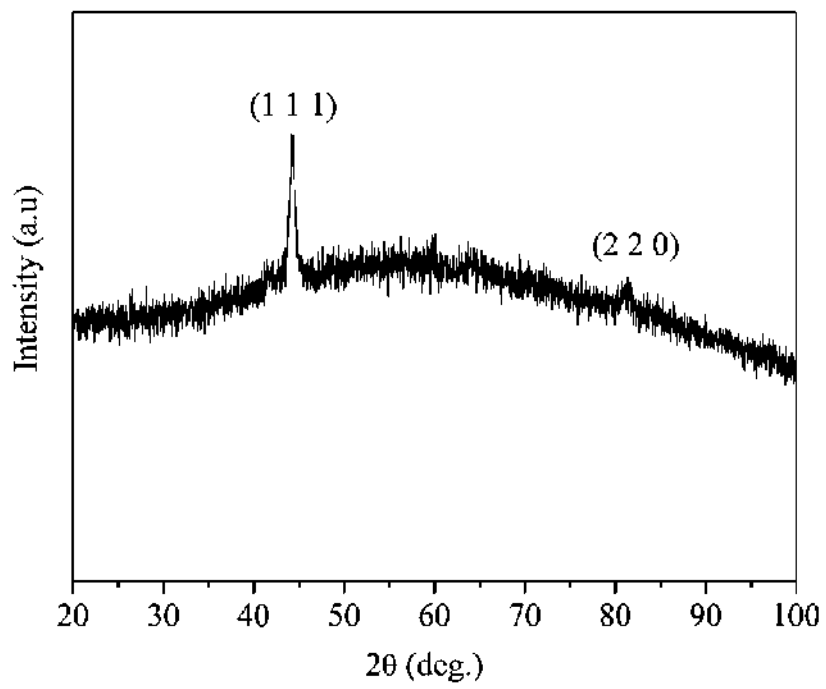
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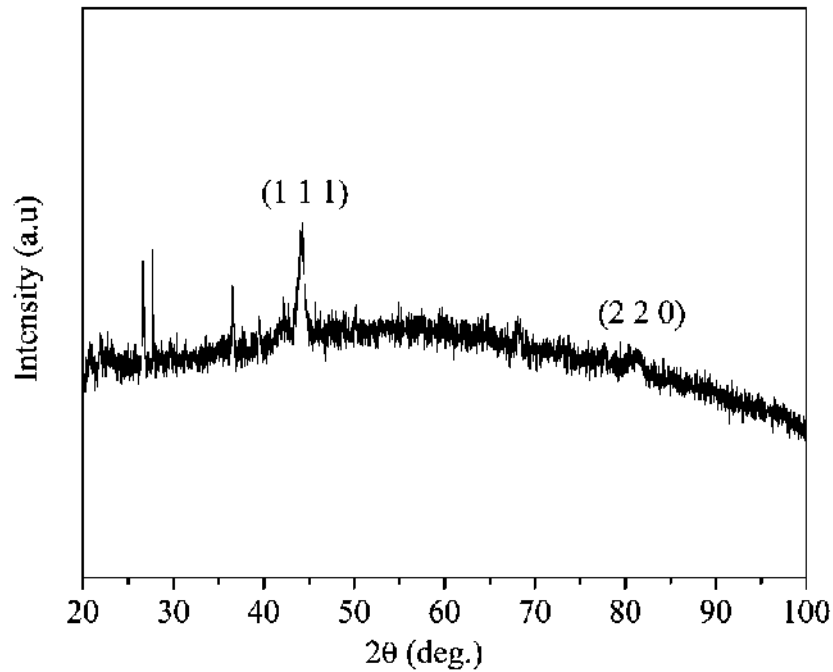
c

Fig. 1. Room-temperature XRD pattern: *a*–F15; *b*–F20; *c*–F25

At 25 % Mn almost all austenite phases, the ferrite phase is nearly invisible. The EDS curve reveals that Fe has a high intensity, implying that the γ Fe phase is equally distributed. The γ Fe phase has an FCC crystal structure and has a crystal plane (111), while at an angle 2-theta of 75° it has a crystal plane (220). Chemical composition test to obtain the percentage of chemical elements contained in the specimen. The elements in the Fe-Al-Mn alloy greatly affect their mechanical properties. The Mn element in the specimen is expected to replace the properties of the Cr element in the cryogenic materials. Visually, the higher the Mn content in the Fe-Al-Mn alloy shows grayish-white castings (Fig. 2).

Fig. 2. Castings of Fe-Al-Mn alloys

Before the table should be a link to the table (in the same section) Has been revised

Table 1 presents the chemical composition of the three specimens is 15.354 % (F15), 21.280 % (F20), and 25.320 % (F25) which showed that they were consistent with the ratio of Mn content applied to these specimens.

Table 1
Chemical alloy composition

| Element	F15	F20	F25
Fe	81.978	74.299	71.403
Al	9.096	10.473	11.165
Mn	15.354	21.280	25.320
C	0.086	0.932	0.846
Si	1.839	2.632	1.165
P	0.043	0.051	0.056
S	0.018	0.013	0.006
Ni	0.057	0.051	0.034
Cr	0.150	0.151	0.717
Mo	0.034	0.037	0.126

The overall composition test results met the expected target and the smelting method has reached the alloy composition. The Fe element dominates the Fe-11Al-Mn alloy with a content of 81.978 % (F15), 74.299 % (F20), and 71.403 % (F25) respectively. Other elements in low percentage are C, Si, P, S, Ni, Cr and Mo. From this group, only Si was detected in higher percentages of 1.839% (F15), 2.632%, and 1.165% (F25).

## 5. 1. 2. The microstructure of Fe-11Al-Mn alloys

Microstructure testing was carried out with an optical microscope with a magnification of 500x. Etching was conducted using HCl, HNO$_3$, and HF etching fluids. The microstructure is shown in Fig. 3, *a – c*. The alloy phase will reach 100 % ferritic at Al content above 10%. ~~Low and medium Mn content also cannot change the ferritic structure into perfect austenite [23]. The addition of 5–10 % Mn to the Fe-Al-C alloy system forms α/γ duplex structure [7]. The ability of Mn to form and stabilize the austenite structure is only half that of the element Ni, these conditions require Mn in sufficient quantities to obtain a perfect austenite structure [24].~~
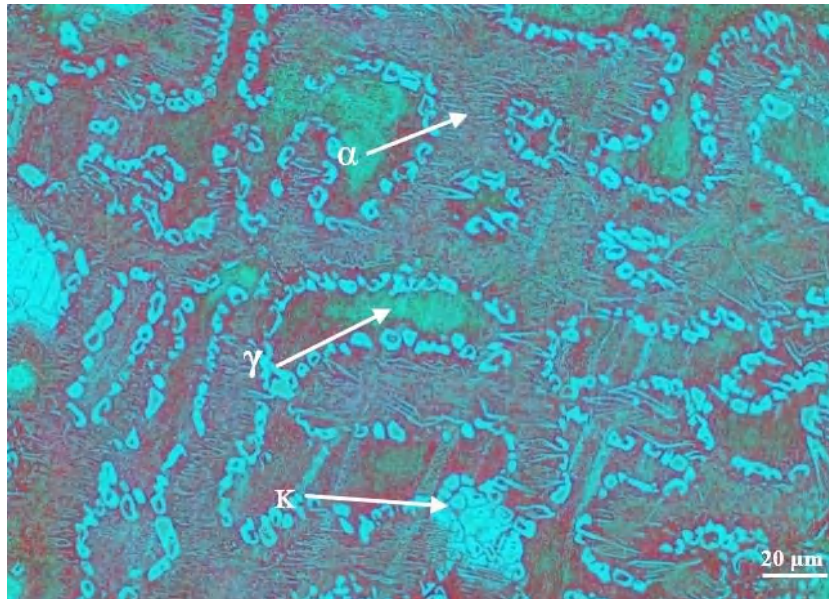

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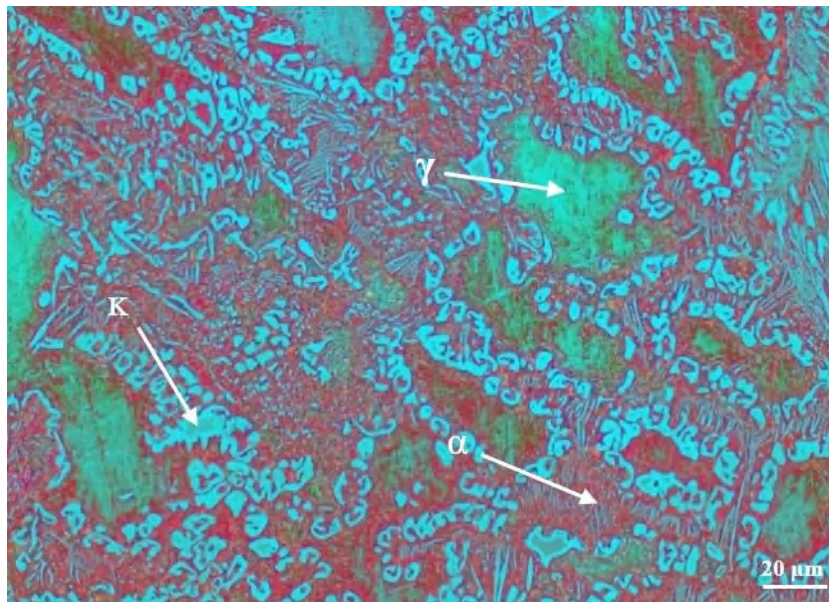
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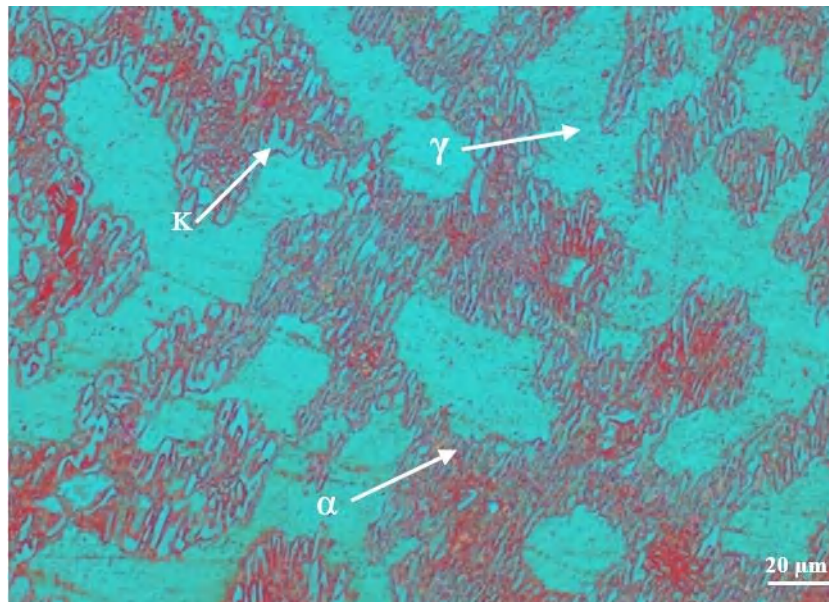
c

Fig. 3. Microstructure: *a* –F15; *b* –F20; *c* –F25

~~Mn is dissolved in the Fe system as a solid solution with a disordered FCC structure [25]. The presence of Al atoms in the system changes the disordered FCC structure to ordered FCC and C atoms cause the formation of the K (Fe,Mn)3AlC phase. This κ phase surrounds the austenite phase in the α/γ duplex system [26].~~
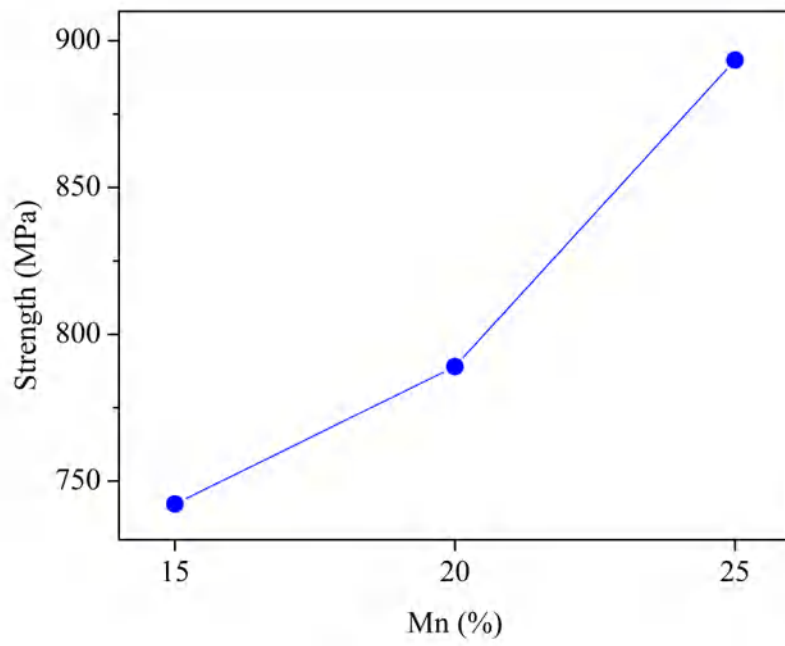
5. 2. Mechanical properties
5. 2. 1. Hardness and tensile strength

Fig. 4, *a* shows that increasing the content of Mn from 15 % to 25 % in Fe-Al-Mn alloys causes a relatively small decrease in hardness ranging from 0.5-5%. The highest hardness value occurred at 15 % Mn content of 225.5 VHN and the hardness value continued to decrease with increasing Mn content until the lowest hardness occurred at 25 % Mn content reaching 297.907 VHN or a decrease in hardness of 5 %.
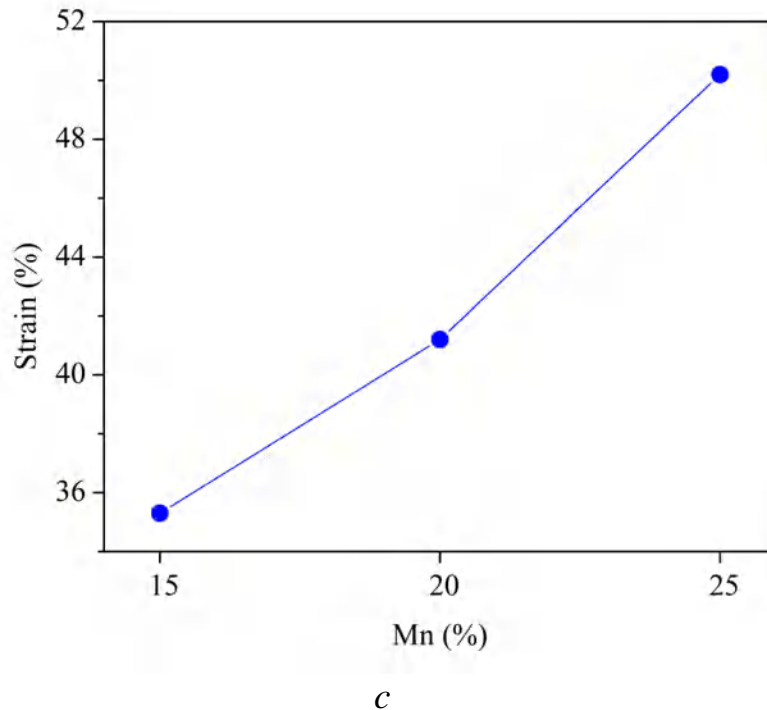
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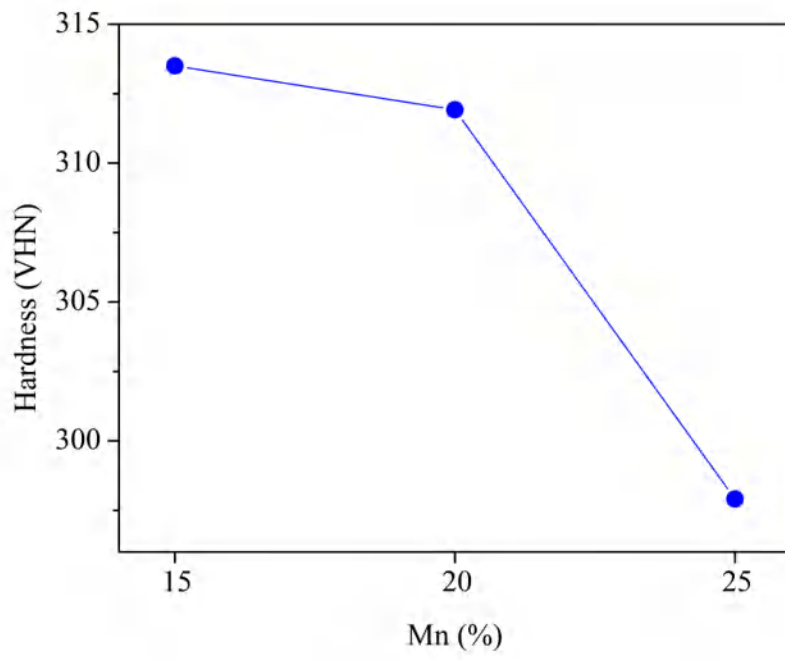
Fig. 4. Mechanical properties: *a* –Vickers hardness; *b* – tensile strength; *c* – fracture elongation values of F15, F20, and F25

Overall, the tensile strength of Fe-Al-Mn alloys is in the range of 731.3-885.07 MPa, the higher the Mn content, the higher the tensile strength and strain (Fig. 4, *b*, *c*). Tensile strength in specimens with 15 % Mn content (F15) reached 742 MPa. The next composition, which is 20 wt % Mn and 25 wt % Mn, has a higher strain than SS 304, which is 41.2 % and 50.2 %. The higher strain at higher Mn content was due to lower lattice density at higher Mn content. The Mn atom occupies the position of the Fe atom which is larger than the Fe atom.

The increase in strength followed by an increase in strain is one of the advantages of Fe-Al-Mn alloys compared to conventional stainless steels. This phenomenon is due to the combined effect of the presence of the elements Al, Mn, and C in the alloy system. The formation of a solid solution of Fe-Al-Mn causes a significant increase in strength and strain at the same time. The addition of Mn in steel increases the strength and toughness significantly [27].

5. 2. 2. Impact properties

Fig. 5 shows Effect of Mn content on the impact toughness for the Fe-11Al-Mn alloys. The addition of Mn to Fe-Al-Mn alloys increased the toughness significantly up to 3.10 J/mm^2 at 20 % Mn and reached the highest toughness at 25 % Mn content of 3.3 J/mm^2. The addition of Mn to the Fe-Al-C alloy system increased the strength and toughness significantly. The increase in strength followed by a significant increase in ductility resulted in a very high increase in toughness. This condition is caused by changes in the microstructure of the alloy towards austenitic. The alloy composition with 25 % Mn produces a toughness value that is almost equivalent to

that of conventional SS 304 as cast stainless steel of 3.12 J/mm².

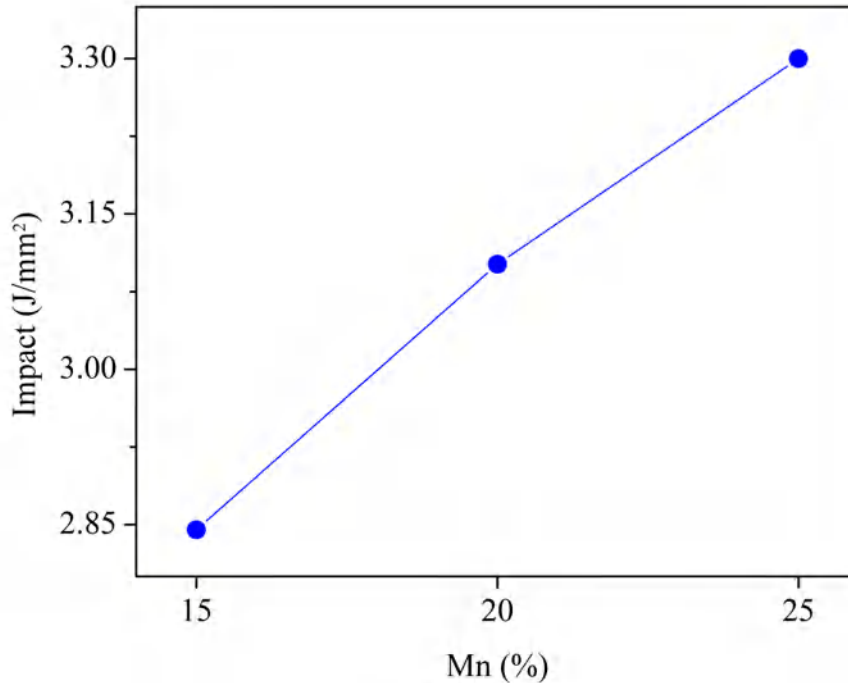**Before the Fig. should be a link to the Fig. (in the same section)** Has been revised

Fig. 5. Effect of Mn content on the impact toughness for the Fe-11Al-Mn alloys

Fig. 6 shows the impact (toughness) effect on the Mn content for the Fe-11Al-xMn alloys. On the surface of the F25 specimen has a ductile fracture which is not present in the F15 and F20 specimens.
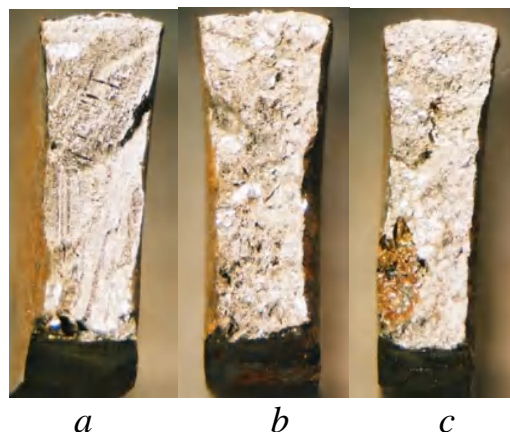

a   *b*   *c*

Fig. 6. Fracture surface after the impact test: *a* – F15; *b* – F20; *c* – F25

The toughness value of Fe-Al-Mn alloy is 0.18 J/mm² (5.8 %) higher than that of SS 304. The substitution of Mn in the Fe system is the cause of the significant

increase in toughness significant. The difference in the distance between atoms (lattice) causes the movement of atoms in the material when receiving a load to become more flexible. Mechanically, the toughness, ductility, and strain are higher.

5. 3. Physical properties of Corrosion Resistance

Corrosion testing was conducted by calculating the corrosion rate of the samples using the weight difference before and after soaking in a 0.5 % HCl (chloride acid) solution [28]. Fig. 7 shows the corrosion rate of Fe-Al-Mn-C alloy in the range of 0.016-0.031 mm/yr in 0.5% NaCl media, with a tendency for the corrosion rate to decrease with increasing Mn content in the alloy.
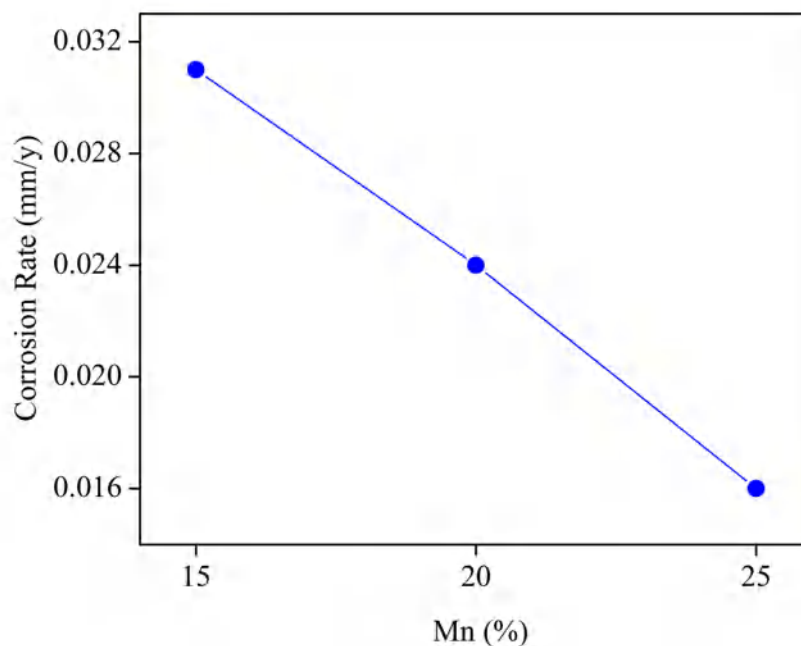

Fig. 7. Corrosion rate for F15, F20, F25, and SS 304

Before the table should be a link to the table (in the same section)
Table 2 shows the corrosion rates for the F15, F20, F25, and SS 304 specimens. The Mn element in the Fe-11Al-1C alloy has a significant impact on corrosion resistance. The alloy with the lowest element of Mn (15%) produces the highest corrosion resistance compared to other specimens.

Table 2
Corrosion rate values for F15, F20, F25, and SS 304

| Specimens	I Corr (µA/cm²)	Corrosion Rate (mm/y)
F15	3.66	0.031
F20	2.85	0.024
F25	1.95	0.016
SS 304	3.05	0.025

The corrosion resistance of this alloy up to 20 % Mn is included in the very good category, while the alloy with 25 % Mn content is included in the extraordinary category. The lowest corrosion rate of Fe-Al-Mn-C alloy occurs at 25 % Mn content, which is 0.016 mm/yr, lower than the corrosion rate of SS 304 stainless steel, which is 0.025 mm/yr. The decrease in the corrosion rate was quite significant, reaching 78.67%.

5. 4. Microstructure And Impact Properties of Fe-11Al-xMn at Cryogenic Temperatures
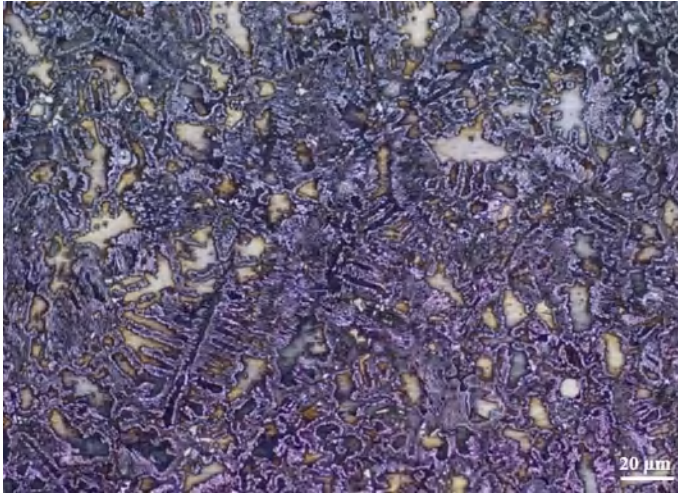**5. 4. 1. Microstructure of Fe-11Al-xMn at Cryogenic Temperatures**
The cryogenic process was carried out using liquid nitrogen at various temperatures of 0 ºC, -100 ºC, and -196 ºC for 2 hours. This process is carried out to determine the resistance of the material to cryogenic temperatures. The test specimens were immersed in liquid nitrogen at various temperatures and times. To determine the phenomenon at room temperature and slightly above room temperature, the specimens were tested at temperatures of 100 ºC and 200 ºC. Fig. 8 shows the microstructure of Fe-Al-Ma alloy after the cryogenic process, similar to the microstructure before the cryogenic process (Fig. 3). Has been revised
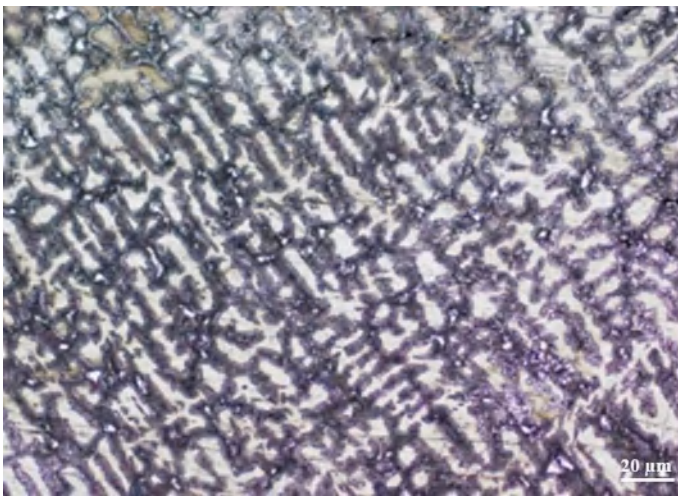
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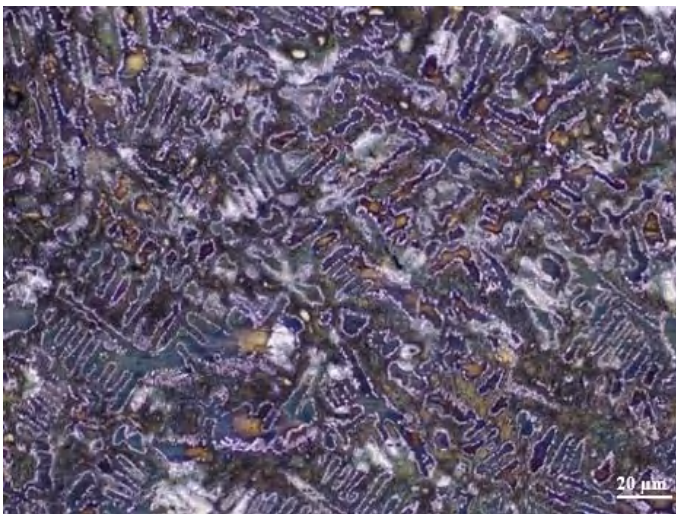
a

b

c

Fig. 8. Microstructure of Fe-11Al-Mn alloy after cryogenic treatment for F15, F20, and F25

The microstructure of the three specimens F15, F20, and F25 was unaffected by the cryogenic treatment. This shows that the cryogenic treatment has a negligible effect on the microstructure. The high C concentration in this alloy prevents austenite from converting to martensite.

5. 4. 2. The Impact Properties of Fe-11Al-Mn at Cryogenic Temperatures

The purpose of the Charpy impact test is to determine the brittleness or ductility of a material (specimen) to be tested by loading suddenly on the object to be tested statically. The Charpy impact test also known as the Charpy v-notch test is a standard high strain rate test that determines the amount of energy absorbed by a material during fracture. Figure 9 shows the impact properties of the F15, F20, F25, and SS 304 specimens at various temperatures up to -190ºC. At 190ºC, the impact values are 2.79 J/mm^2 (F15), 3.19 J/mm^2 (F20), 3.35 J/mm^2 (F25), and 3.13 J/mm^2 (SS 304). The impact value didn't considerably decline at -190ºC, notably for the F20, F25, and SS 304 specimens, which are 3.09 J/mm^2, 3.15 J/mm^2, and 3.11 J/mm^2, respectively.
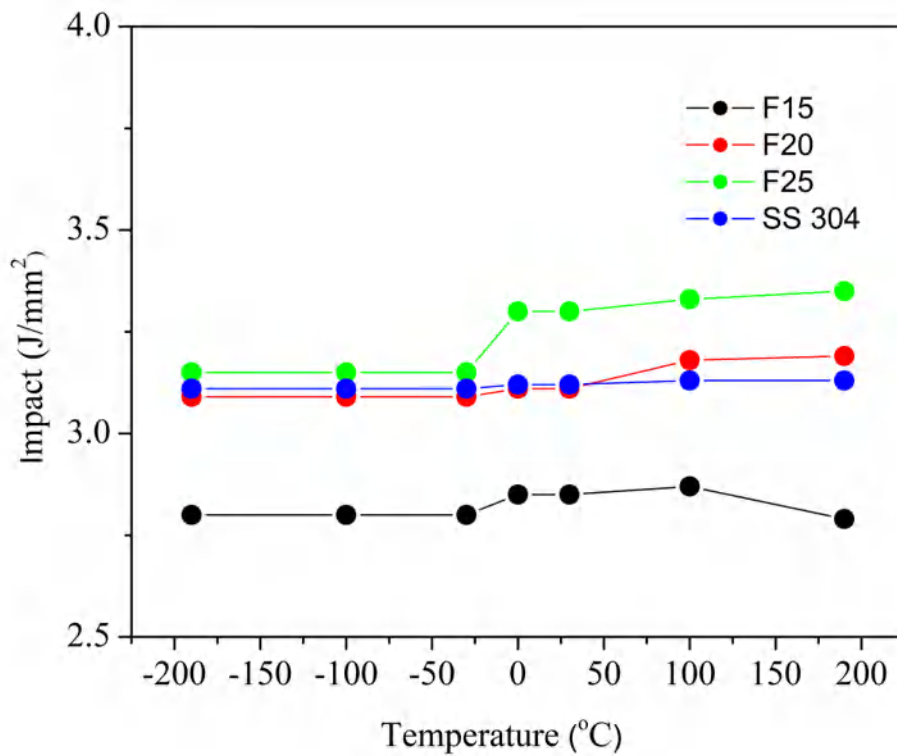
Fig. 9. The effect of temperature on impact for Fe-Al-Mn alloy

The impact values of Fe-Al-Mn and SS 304 specimens in the temperature range of 190 ºC and -190ºC are listed in Table 3. The impact values of the four specimens at temperatures below 0ºC to -190ºC did not change and were stable.

Table 3
Impact values for Fe-Al-Mn alloys and SS 304 stainless steel

Temp.	Impact (J/mm^2)			
(ºC)	F15	F20	F25	SS 304
190	2.79	3.19	3.35	3.13
100	2.87	3.18	3.33	3.13
30	2.85	3.11	3.30	3.12
0	2.85	3.11	3.30	3.11
-30	2.80	3.09	3.15	3.11
-100	2.80	3.09	3.15	3.11
-190	2.80	3.09	3.15	3.11

Absorbed energy is a measure of the toughness of a given material and depends on the brittle-ductile transition temperature. This method is widely used in safety-critical industries because it is easy to prepare and perform. Fig. 9 shows the real fracture surface changes of the 15 %, 20 %, and 25 % Mn compositions. The higher the Mn content indicates the higher ductility, the necking is very clearly presented at the Mn content of 20 % and 25 %. At cryogenic temperatures, Fe-Al-Mn alloy did not cause significant changes in microstructure and mechanical properties. From the overall results, it can be concluded that this alloy is resistant to cryogenic temperatures and can be used for low-temperature applications.

6. Discussion of experimental results

Build a section according to this scheme:
1. The answer to the question, what explains the results.
2. What are the features of the proposed method and the results obtained in comparison with existing
3. What are the limitations of this study?
4. What disadvantages of this study can be noted and how can they be eliminated in the future.
5. What can be the development of this research and what difficulties (mathematical, experimental or any other kind) can be encountered
Has been revised

The chemical composition data of alloy specimens F15, F20, and F25 are high alloy steel FA-Al-Mn-Si as shown in Table 1. This alloy steel contains elements of carbon, aluminum, manganese, silicon, phosphorus, and sulfur. The element Mn plays a role in preventing precipitation in aluminum alloys which increases corrosion resistance. The microstructure, grain size, and mechanical strength of metal alloys are influenced by the composition of the alloy applied. Impurities in the alloy system are elements that can be ignored because they do not affect the behavior of the alloy metal.

Fig. 3, *a* shows the microstructure of Fe-11Al-15Mn alloy consisting of austenite, ferrite (FeAl) [29] structure, and intermetallic compound (Fe,Mn)3AlC (κ phase) surrounding austenite grains. In Fig. 3, *b*, where the 20 % Mn content presents that the ferrite structure is decreasing followed the area of the increasing phase. Fig. 3, *c* shows that there is a change in the pattern or shape of the austenite and ferrite grains. The austenite structure dominates, the ferrite structure disappears and shows the dendritic structure in a wider area. The appearance of double phases in the three compositions was due to the relatively high Al content and insufficient Mn content to reach the perfect austenite phase [3]. Low and medium Mn content also cannot change the ferritic structure into perfect austenite [23]. The addition of 5–10 % Mn to the Fe-Al-C alloy system forms α/γ duplex structure [7]. The ability of Mn to form and stabilize the austenite structure is only half that of the element Ni, these conditions require Mn in sufficient quantities to obtain a perfect austenite structure [24]. Mn is dissolved in the Fe system as a solid solution with a disordered FCC structure [25]. The presence of Al atoms in the system changes the disordered FCC

structure to ordered FCC and C atoms cause the formation of the K (Fe,Mn)3AlC phase. This κ phase surrounds the austenite phase in the α/γ duplex system [26].

Based on structural changes that occur in the range of increasing Mn content, the increase in the area of the austenite structure formed causes a decrease in hardness, this condition is equivalent to a decrease in tensile strength that occurs due to an increase in Mn content in the alloy [30]. The Mn atoms occupying the position of the Fe atom shift the Al atoms in the Fe-Al-Mn-C alloy system causing the lattice density to decrease so that the hardness level decreases [25]. Due to the size of the Mn atom (1.79 Angstrom) is smaller than the size of Al (1.82 Angstrom) and closer to the size of the Fe atom (1.72 Angstrom), the decrease in hardness is not significant. Compared with austenitic stainless steel SS 304 with a hardness value of 203 VHN, the composition with the closest hardness value is 25 % Mn alloy. It was observed from the microstructure that the alloy formed with 25 % Mn was a perfect austenite structure

Mechanical properties and fracture elongation values for F15, F20, and F25 are shown in Figure 4. Compared to austenitic stainless steel SS 304 with a tensile strength of 552.5 MPa, Fe-Al-Mn alloy achieved a higher tensile strength than SS 304. Mn elements in steel play a role in increasing strength, the results of this study also concluded that the higher the Mn content in Fe-11Al-Mn alloys have higher tensile strength [30]. Besides that, the austenitic structure which is stable at room temperature and increasing with higher Mn content causes higher strength than SS 304, conventional austenitic stainless steel [5].

The strengthening mechanism using Mn and Al elements in the Fe-Al-Mn alloy system can be explained as follows, Mn in the Fe crystal system occupies an equivalent position with Fe. This crystal system is FCC (γ). The element Al occupies the corner points of the cubic crystal while Fe and Mn atoms occupy the center point of the side of the cubic crystal system (γ') [7]. The change in crystal structure from disordered to γ' ordered (Fig. 3) causes a significant increase in tensile strength. At levels of Mn below 15 %, some of the γ' ordered will be transformed into the (Fe,Mn)3AlC phase. Meanwhile, at 25 % Mn content, the microstructure changed to austenite (γ) completely [8]. The formation of a single phase from several of these elements causes a stress field interaction between soluble atoms and dislocations, this condition requires greater mechanical energy to form plastic deformation [25].

Fig. 7 shows the corrosion rates for F15, F20, F25, and SS 304 stainless steel. As the Ni element in conventional stainless steel, the Mn element in the Fe-Al-Mn-C alloy besides playing a role in increasing strength and toughness, the Mn element also plays a role in stabilizing the austenite structure at room temperature and also plays a role in increasing the corrosion resistance of the alloy.

Fig. 8 presents the microstructure of Fe-11Al-Mn alloy after cryogenic treatment. The microstructure of the Fe-Al-Mn alloy system is relatively stable in the temperature range of 0 ºC to 200 ºC [4]. Strong bonds between atoms lead to high phase stability. The microstructure of the Fe-Al-Mn alloy after the cryogenic process using SEM showed that the structure of austenite, ferrite, and kappa had almost the same pattern and size as the original alloy. It can be concluded that the Fe-Al-Mn alloy does not undergo a brittle-ductile transition in the temperature range of -200 ºC

to 200 °C. This condition is similar to the phenomenon in SS 304 stainless steel.

Fig. 9 shows the effect of temperature on impact for Fe-Al-Mn alloy The transition curve of Fe-Al-Mn alloy is horizontal, very similar to the transition curve of SS 304 stainless steel and the impact value is close to the impact value of SS 304. The highest toughness value of Fe-11Al-25Mn alloy is 3.3J/mm^2, the value is still above the toughness value of SS 304 stainless steel, which is 3.12 J/mm^2.

Overall, this research is still limited to testing the microstructure and impact toughness under cryogenic treatment and testing of mechanical properties has not been carried out on Fe-11Al-Mn alloys under cryogenic conditions. In addition, the performance improvement of Fe-11Al-Mn alloy steel requires further development. Heat treatment including surface hardening and age hardening is a commonly applied method that can improve ductility, wear resistance, and hardness.

7. Conclusions number of objectives=number of conclusions

In this section, describe in the conclusions the solution of the tasks that you set for yourself in section 3, but do not repeat the problems literally - this should be a description of the solutions of the problems.

As a result of the research:

1. ... with indication of qualitative or quantitative indicators of research results

2. ... with indication of qualitative or quantitative indicators of research results

3. ... with an indication of qualitative or quantitative indicators of research results

Has been revised

1. ~~The structure of the Fe-11Al-Mn alloy into Fe-11Al-xMn (F15, F20, F25) has been successfully developed by the addition of Mn content. The main elements contained in the sample are Fe, Al, and Mn.~~

2. ~~The tensile test indicated the higher the Mn content indicates the higher the tensile strength, the F25 specimen reaches the highest value of 893.42 MPA.~~

3. ~~The corrosion resistance of Fe-Al-Mn alloys increased significantly with increasing Mn content. The lowest corrosion rate on the F25 specimen reached 0.016 mm/year, including the very good category.~~

4. ~~The cryogenic-temperature microstructure test results showed that the microstructure of the Fe-Al-Mn alloy was almost similar between the specimens before and after the cryogenic process. Strong bonds between atoms lead to high phase stability.~~

5. ~~The cryogenic-temperature impact test results indicated that the impact toughness increased with increasing Mn content. In specimens with a cryogenic temperature treatment of -190 °C, the impact toughness of F25 reached 3.15 J/mm²~~ ~~which was higher than SS304 stainless steel.~~

1. It has been determined that the alloy structure of Fe-11Al-Mn to Fe-11Al-xMn (F15, F20, F25) has been successfully developed with the addition of Mn content.

2. It has been determined that the tensile test shows that the higher the Mn

content indicates the higher the tensile strength, the tensile stress of the F25 specimen exceeds SS 304.

3. The corrosion resistance of Fe-Al-Mn alloys increases significantly with increasing Mn content. Specimen F25 shows the lowest corrosion rate and qualifies as a material working under cryogenic temperatures

4. The results of the cryogenic temperature microstructure test showed that the microstructure of the Fe-Al-Mn alloy was almost the same between the specimens before and after the cryogenic process. Strong bonds between atoms lead to high phase stability.

5. Impact test results are comparable to tensile test data, impact toughness increases with increasing Mn content. These results are consistent with the tensile test data. Specimens treated with a cryogenic temperature of -190ºC, the impact toughness of F25 is 3.15 J/mm^2 which is higher than that of SS304 stainless steel..

Acknowledgments

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Ratna Kartikasari
Doctor of Mechanical Engineering, Associate Professor
Department of Mechanical Engineering
Institut Teknologi Nasional Yogyakarta
Jl Babarsari Caturtunggal, Depok, Sleman, Daerah Istimewa Yogyakarta, Indonesia, 55281
E-mail: ratna@itny.ac.id
Contact phone: +6281392019208
The number of articles in international databases: 7
H-index: 2
ORCID: https://orcid.org/0000-0001-8859-3258
https://www.researchgate.net/profile/Ratna_Kartikasari
https://scholar.google.com/scholar?hl=id&as_sdt=0 %2C5&q=ratna+kartikasari&oq= Ratna+Kartika

Adi Subardi
Corresponding author
Doctor of Materials Science and Engineering, Assistance Professor
Department of Mechanical Engineering
Institut Teknologi Nasional Yogyakarta
Jl Babarsari Caturtunggal, Depok, Sleman, Daerah Istimewa Yogyakarta, Indonesia, 55281
E-mail: subardi@itny.ac.id
Contact phone: +6282133167082
The number of articles in international databases: 14
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Andy Erwin Wijaya
Doctor of Mines Engineering, Assistance Professor
Department of Mines Engineering
Institut Teknologi Nasional Yogyakarta
Jl Babarsari Caturtunggal, Depok, Sleman, Daerah Istimewa Yogyakarta, Indonesia, 55281
E-mail: andyerwin@itny.ac.id

Contact phone: +6282300182053
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   National Dong Hwa University
   Hualien 974301, Taiwan R.O.C

2. Dr Ir. Dody Prayitno, M.Eng.
   Associate Professor
   E-mail: (dodyprayitno@trisakti.ac.id)
   Department of Mechanical Engineering
   Trisakti University
   Jakarta 11440, Indonesia

3. Ir. Djarot B. Darmadi, M.T., Ph.D.
   Associate Professor
   E-mail: b_darmadi_djarot@ub.ac.id)
   Department of Mechanical Engineering
   Brawijaya University
   Malang, East Java 65145, Indonesia