

Microstructure and Mechanical Properties of Hypo-and Hypereutectic Cast Mg/Mg₂Si Composites

Katarzyna N. Braszczynska'-Malik * and Marcin A. Malik

Faculty of Production Engineering and Materials Technology, AI, Czestochowa University of Technology, Armii Krajowej 19, 42-200 Czestochowa, Poland;

Abstract: In this paper, the microstructure and mechanical properties of two magnesium matrix composites—a hypoeutectic with 1.9 wt% Mg₂Si phase and a hypereutectic with 19 wt% Mg₂Si compound—were analyzed. The investigated materials were prepared using the gravity casting method. Microstructure analyses of the fabricated composites were carried out by XRD and light microscopy. The tensile and compression strength as well as yield strength of the composites were examined in both uniaxial tensile and compression tests. The microstructure of the hypoeutectic composite was in agreement with the phase diagram and composed of primary Mg dendrites and an Mg–Mg₂Si eutectic mixture. For the hypereutectic composite, besides the primary Mg₂Si phase and eutectic mixture, additional magnesium dendrites surrounding the Mg₂Si compound were observed due to nonequilibrium solidification conditions. The composites exhibited a rise in the examined mechanical properties with an increase in the Mg₂Si weight fraction and also a higher tensile and compression strength in comparison to the pure magnesium matrix (cast in the same conditions). Additionally, analyses of fracture surfaces of the composites carried out using scanning electron microscopy (SEM + EDX) are presented.

Keywords: magnesium; composite; Mg₂Si; microstructure; mechanical properties

1. Introduction

For many years, metal matrix composites (MMCs) have been designed in many different systems in terms of both different metal matrix alloys and various types of reinforcement phase [1–5]. Among them, magnesium matrix composites are very attractive due to the especially low density of the matrix metal. Additionally, thanks to their unique combination of different properties such as exceptional dimensional stability and high damping capacity, specific strength and stiffness, those composites are very attractive in such applications as the aerospace, automobile or electronics industries. Typical ex situ composites, in which reinforcements are introduced from outside to the matrix alloy, comprise the biggest group of magnesium matrix composites. Many different magnesium matrix alloys (from the Mg–Al, Mg–Zn or Mg–rare earth systems) with various reinforced phases (various particles or fibers) such as SiC, C_{gr}, TiC, Ti, microspheres etc. have been designed and investigated in recent years [6–14].

On the other hand, in situ composites constitute a separate group, in which reinforcement is formed inside the matrix. In this group, Mg/Mg₂Si composites are typical material in which reinforcing the Mg₂Si phase is created on the inside of the matrix due to the chemical reaction between magnesium and silicon [6,15–21]. The design of magnesium matrix composites with the Mg₂Si component is based on the Mg–Si binary phase diagram (presented in Figure 1). According to this diagram, eutectic transformation proceeds at 1.48 wt% silicon, and materials from the Mg–Si system are divided into hypoeutectic, eutectic and hypereutectic. These composites can be fabricated by both powder metallurgy [22–28] and the casting process [6,29–43]. Compared to other methods, casting is a method

that can be easily adapted to the required commercial scale of production and is the most economical. Although there is a large difference in the melting temperature of both the used elements, it is possible to dissolve silicon in liquid magnesium, which allows uniform composites with different weight fractions of the Mg_2Si component to be obtained.

Recently, $\text{Mg}/\text{Mg}_2\text{Si}$ composites have been intensively investigated due to the number of properties of the Mg_2Si phase such as low density (1.99 g/cm^3), a comparatively low thermal expansion coefficient ($7.5 \cdot 10^{-6} \text{ K}^{-1}$), relatively high Young's modulus (120 GPa) and high hardness ($4.5 \cdot 10^9 \text{ Pa}$) [17–21,30–36]. It should be additionally noted that the Mg_2Si compound is also used as a reinforcing phase of aluminum matrix composites [37–43] or as a component of magnesium matrix composites with SiC or aluminosilicate microspheres [27,44,45]. However, $\text{Mg}/\text{Mg}_2\text{Si}$ materials were most often investigated in separate experiments where composites with different weight fractions of silicon (i.e., the Mg_2Si phase) were analyzed. Pan Y et al. [18] described the microstructure of Mg with 8 wt% Si, whereas in works [17,29], a composite with 5 wt% Si was presented. The effect of the Si content on low frequency damping capacities was investigated for materials with 0.3, 0.8 and 2.3 wt% Si in work [30], but in paper [16], the results for a composite with only 1 wt% Si were presented. Additionally, in many papers, the influence of a third element (such as Bi, Ce, Nd, Y, Sr, Sb) was studied in order to analyze the modification phenomenon of the Mg_2Si primary phase or eutectic mixture [15,20,21,31–35], but these investigations were also most often performed on materials with one weight fraction of the Mg_2Si compound. Recently, gradient $\text{Mg}/\text{Mg}_2\text{Si}$ composites [46] and open cell foams [47] have also been fabricated and studied. Nevertheless, incomplete data concerning the correlation between the fabrication process, microstructure and properties of $\text{Mg}/\text{Mg}_2\text{Si}$ composites require detailed investigations, especially for future composite design. There are also many divergent results concerning particularly the morphology of the primary Mg_2Si phase or the influence of the Si (Mg_2Si) weight fraction on the mechanical properties. In some cases, cubic or polygonal morphology of the Mg_2Si primary phase was observed [29,30], but in the other works, primary dendrites of this compound were observed in the microstructure of the composites [18,19,36]. There are also poor data describing the mechanical properties of pure Mg with Mg_2Si composites in as-cast conditions. Hu X.S. et al. [30] reported that a composite with 0.8 wt% Si exhibited the highest tensile strength (152 MPa), whereas the tensile strength decreased for a composite with 2.3 wt% Si (117 MPa). Mirshahi F. et al. [17] obtained an ultimate tensile strength equal to 95 MPa for a composite with 5 wt% Si. Higher values of the ultimate tensile strength were obtained in work [19] for hot extruded (at 623 K) composites with 3, 5 and 7 wt% Si with extrusion ratios of 6:1, 12:1 and 18:1. Unfortunately, the results for as-cast composites at the initial stage (before extrusion) were not given in this work.

In the present paper, particular investigations of the microstructure and mechanical properties of two $\text{Mg}/\text{Mg}_2\text{Si}$ composites are presented. Hypoeutectic and hypereutectic composites were gravity cast in the same conditions, and the influence of the silicon weight fraction on the properties of the composites tested in both uniaxial tensile and compression tests (also in comparison with pure magnesium) was shown.

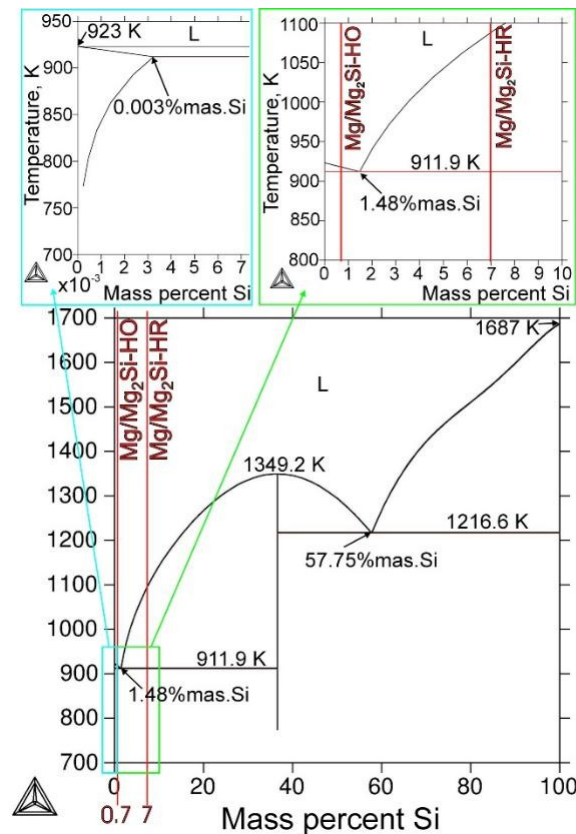


Figure 1: Mg-Si phase diagram (calculated in Thermo-Calc Software; Database: COST2 [48]).

2. Materials and Methods

In the present paper, particular investigations of the microstructure and mechanical properties of two Technically Mg/Mg₂Si pure composites magnesium are represented and pure. Hypoeutectic silicon in the form and hypereutectic of an ingot and composite powder, respectively, were gravity were cast in under the same conditions. The Mg and Mg₂Si influence composite were the silicon obtained weight by the fraction casting on method, on the property which involved of the

introducing composites. Site tested powder in both into uniaxial mixed molten tensile magnesium and compression in a steel test crucible (also in (with comparison capacity with of about pure

1 magnesium). 5 kg of molten was magnesium) shown. under a protective argon atmosphere. The chemical compositions of the prepared materials were chosen to obtain hypoeutectic and hypereutectic materials according

2. Materials and Methods

to the phase diagram (Figure 1) calculated in Thermo-Calc Software [48]. The first hypoeutectic material (called Mg/Mg₂Si-HO in this work) was fabricated with 0.7 wt% silicon, which corresponds to about 1.9 wt% Mg Si in magnesium. The second hypereutectic composite (called Mg/Mg₂Si-HR in this work) was fabricated with 7 wt% silicon, which corresponds to about 19 wt% Mg Si in magnesium. The prepared composite melts were gravity cast in a cold steel mold, which was designed about 1.5 kg of molten magnesium) under a protective argon atmosphere. The chemical compositions

for magnesium alloys and their composites (with the relatively large riser head and set of gas vents). of the prepared materials were chosen to obtain hypoeutectic and hypereutectic materials according to the phase diagram (Figure 1) calculated in Thermo-Calc Software [48]. The first hypoeutectic

The phase compositions of the investigated materials were analyzed by X-ray diffraction (XRD) to the phase diagram (Figure 1) calculated in Thermo-Calc Software [48]. The first hypoeutectic

using a Bruker D8 Advance diffractometer (Bruker Corporation, Billerica, MA, USA) with Cu material (called Mg/Mg₂Si-HO in this work) was fabricated with 0.7 wt% silicon, which corresponds to

X-ray radiation. Reflexes from particular phases were identified according to ICDD PDF-4+ cards [49], to about 1.9 wt% Mg₂Si in magnesium. The second hypereutectic composite (called Mg/Mg₂Si-HR in

The specimens for the microstructure investigations were prepared by standard metallographic this work) was fabricated with 7 wt% silicon, which corresponds to about 19 wt% Mg₂Si in

procedures. To reveal the microstructure, the samples were etched in a 1% solution of HNO₃ in magnesium. The prepared composite melts were gravity cast in a cold steel mold, which was

C H OH for about 60 s. The microstructures were observed with an Olympus GX51 light microscope designed for magnesium alloys and their composites (with the relatively large riser head and set of

(LM) gas vents) (Olympus, Tokyo, Japan) with differential interface contrast (DIC).

Mechanical properties tests of the composites were carried out according to relevant ASTM

The phase compositions of the investigated materials were analyzed by X-ray diffraction (XRD)

standards on a Zwick/Roell Z100 machine (Zwick Roell Group, Ulm, Germany) with a strain rate using a Bruker D8 Advance diffractometer (Bruker Corporation, Billerica, MA, USA) with CuK α

X-ray of 0.01 mm/s. The performed mechanical tests included experimental determination of the ultimate ray radiation. Reflexes from particular phases were identified according to ICDD PDF- 4+ cards [49].

tensile strength (UTS) and yield strength (TYS) on standard rodlike samples with a diameter of 8

mm. The specimens for the microstructure investigations were prepared by standard metallographic

in a uniaxial tensile test. Compression strength (CS) and yield strength under compression (YS) procedures. To reveal the microstructure, the samples were etched in a 1% solution of HNO₃ in

were determined in the uniaxial compression test on samples with a diameter of 8 mm and length C₂H₅OH for about 60 s. The microstructures were observed with an Olympus GX51 light microscope

(LM) (Olympus, Tokyo, Japan) with differential interface contrast (DIC).

Mechanical properties tests of the composites were carried out according to relevant ASTM standards on a Zwick/Roell Z100 machine (Zwick Roell Group, Ulm, Germany) with a strain rate of 0.01 mm/s. The performed mechanical tests included experimental determination of the ultimate tensile strength^{Materials 2020,13,3591} (UTS) and yield strength (TYS) on standard rodlike samples with a diameter of 8 mm^{off13} in a uniaxial tensile test. Compression strength (CS) and yield strength under compression (YS) were determined in the uniaxial compression test on samples with a diameter of 8 mm and length of 12 of 12 mm. Both tests were carried out at room temperature. For comparison, the same mechanical tests were performed for the used technically pure magnesium (cast in the same conditions in the same mold as the fabricated composites). For each material, three samples were tested. In addition, the fracture surfaces of the investigated composites after uniaxial tensile testing were observed by a JEOL a JEOL JSM-6610LV scanning electron microscope (SEM) (JEOL Ltd., Tokyo, Japan) with an energy dispersive X-ray spectrometer (EDX). (JEOL Ltd., Tokyo, Japan) with an energy dispersive X-ray spectrometer (EDX).

3. Results and Discussion

3. Results and Discussion

Figure 2 shows the X-ray diffraction micrographs for the Mg/Mg₂Si-HO and Mg/Mg₂Si-HR fabricated composites. It confirmed that both materials were composed of Mg and Mg₂Si phases. Additionally, the comparison of the X-ray patterns obtained for both materials revealed a distinct increase in the reflex intensity from the Mg₂Si phase in the Mg/Mg₂Si-HR rather than in the Mg/Mg₂Si-HO composite, which confirmed the rise in the volume fraction of this structural constituent in the material with the higher weight fraction of silicon. It should also be noted that reflexes from pure constituent in the material with the higher weight fraction of silicon. It should also be noted that silicon were not registered, confirming that all the silicon was introduced into the molten magnesium

reflexes from pure silicon were not registered, confirming that all the silicon was introduced into the and created the Mg₂Si phase.

molten magnesium and created the Mg₂Si phase.

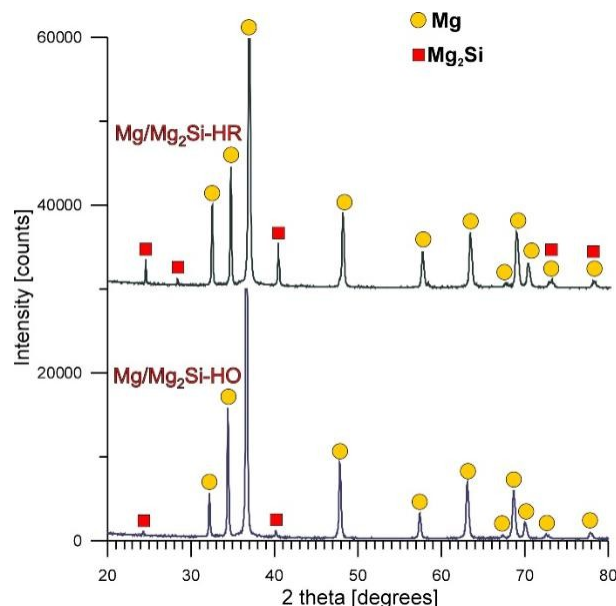


Figure 2. X-ray diffraction patterns of Mg/Mg₂Si-HO and Mg/Mg₂Si-HR composites.

in the investigated materials had irregular morphology—typical for a faceted–nonfaceted eutectic.

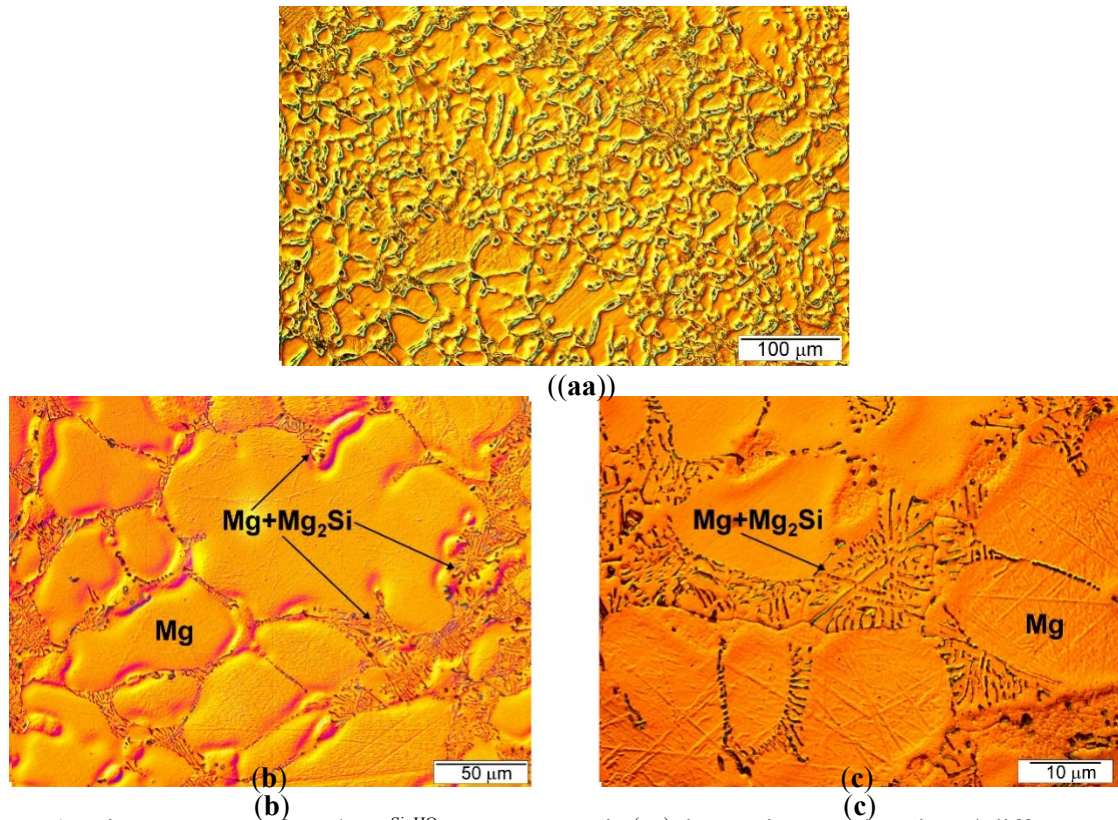


Figure 3. Microstructure of Mg/Mg₂Si composite (a–c) three micrographs taken at different magnifications for Mg/Mg₂Si–HO.

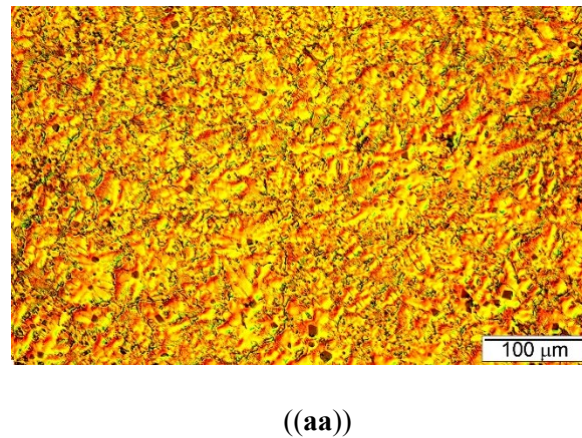


Figure 4. Cont.

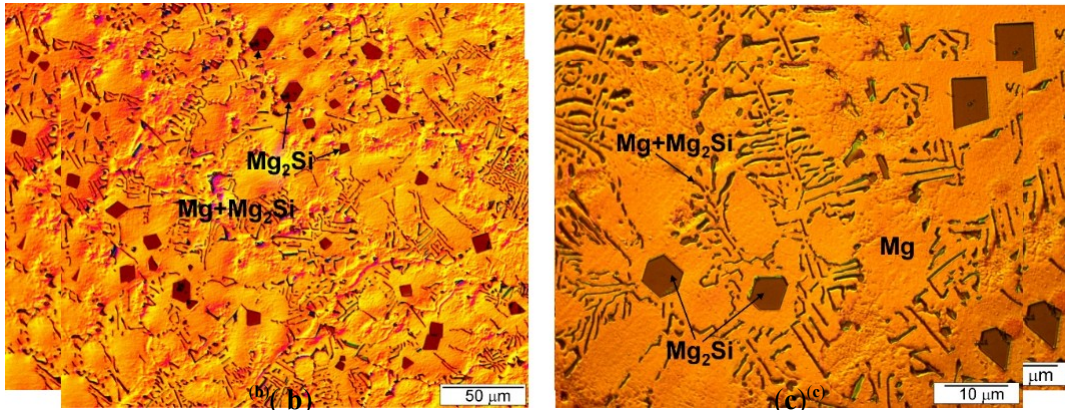
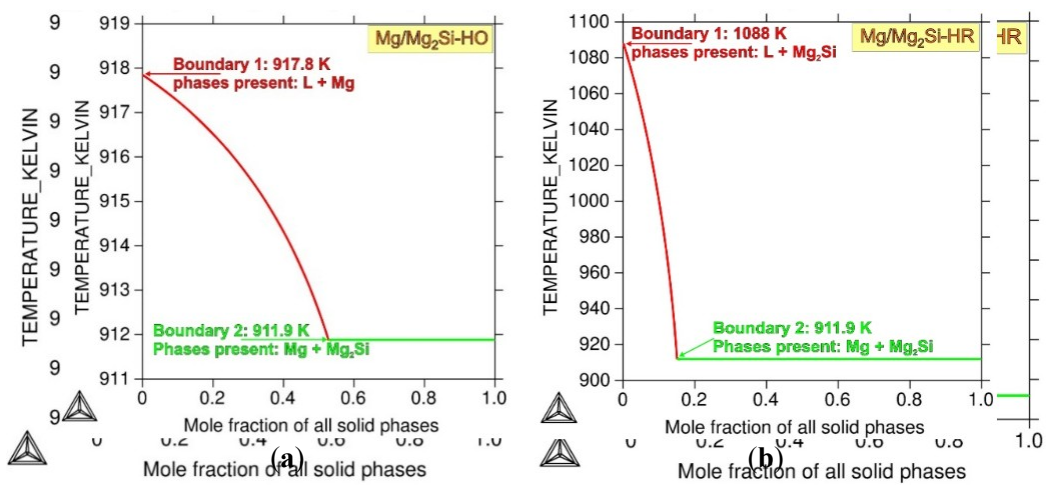


Figure 4. Microstructure of Mg/Mg₂Si—HR composite ((aa—cc)) shows three micrographs taken at different magnifications for Mg/Mg₂Si—HR.

magnifications for Mg/Mg₂Si—HR.
magnifications for Mg/Mg₂Si—HR.



the composite (and the presence of further elements or impurities) and super-cooling during solidification (which also depends on the casting temperature). These factors need very detailed

depends on the casting temperature). These factors need very detailed studies especially in the context of impurities. It is most likely that a very small amount of surface-active third elements influenced the phase morphology, similar to the aluminum–silicon system (in which a content of up to 9 ppm phosphorus causes changes in the microstructure of hypereutectic alloys).

The formation of the primary Mg_2Si phase in the $\text{Mg}/\text{Mg}_2\text{Si}$ –HR composite is in agreement with both the phase diagram (Figure 1) and the solidification curves calculated according to the Scheil

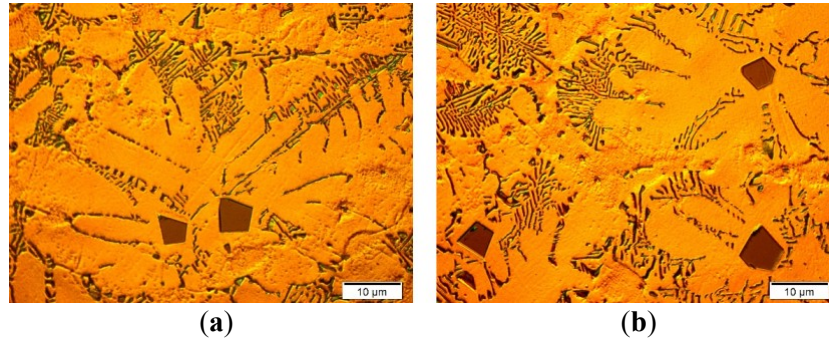


Figure 6. Micrographs of $\text{Mg}/\text{Mg}_2\text{Si}$ –HR composite microstructure presenting magnesium dendrites surrounding primary Mg_2Si crystals. (a,b) shows two micrographs taken from different areas of tensile test for both composites and compared with those obtained for technically pure magnesium cast in the same conditions. The analogical results presenting the compression strength (CS) and yield strength (YS) values obtained in the uniaxial compression test are shown in Figure 8b. Both the

fabricated composites exhibited higher mechanical properties than technically pure magnesium. The obtained results of the ultimate tensile strength of both the investigated composites were also alloy[46]. [50] and significantly higher than the one obtained by the gradient composite (about 200 MPa) [46].

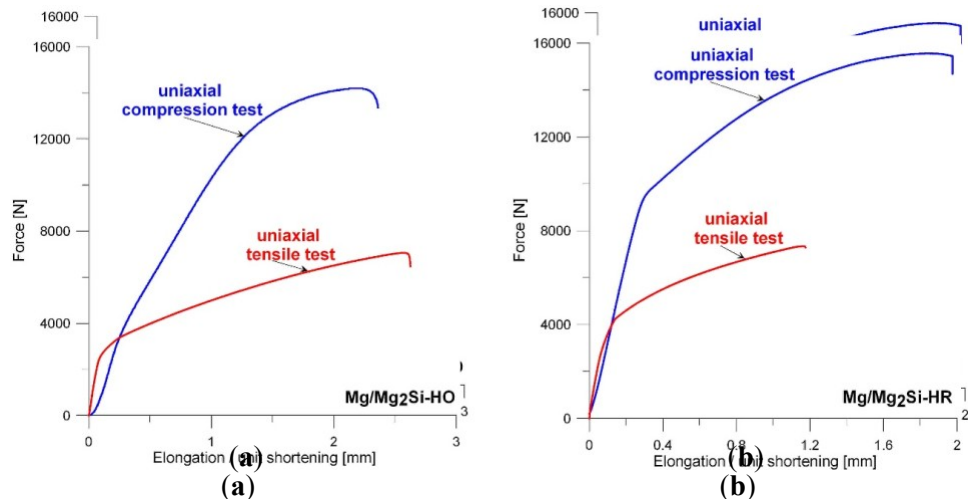


Figure 7. Representative tension and compression curves for the Mg/Mg2Si-HO (a) and Mg/Mg2Si-HR

Figure 7. Representative tension and compression curves for the Mg/Mg2Si-HO (a) and Mg/Mg2Si-HR composites (b).

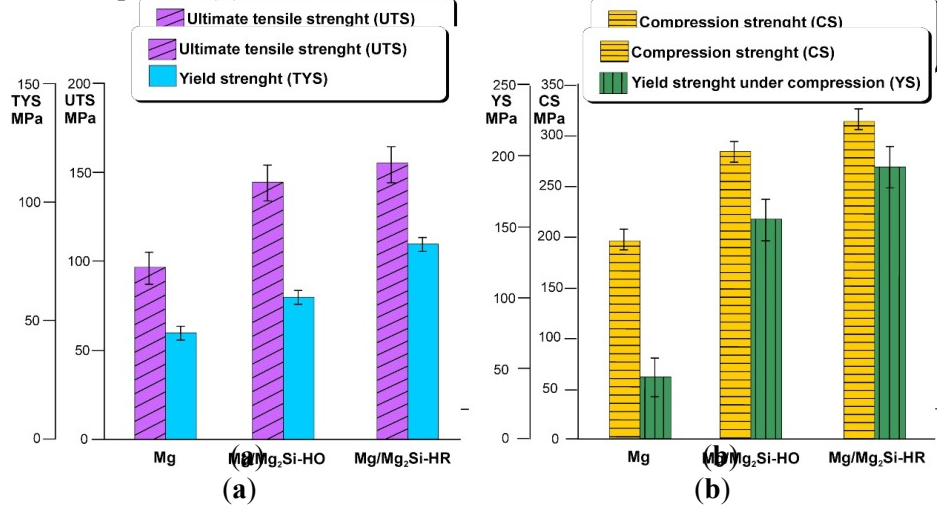


Figure 8. Average values of ultimate tensile strength (UTS) and yield strength (TYS) (a), compression strength (CS) and yield strength under compression (YS) (b) for Mg/Mg2Si-HO and Mg/Mg2Si-HR composites comprised with technically pure magnesium (with scatter of results).

visible when comparing Figure 9a,b (produced at the same magnification). The fracture surface of visible when comparing Figure 9a, b (produced at the same magnification). The fracture surface of visible when comparing Figure 9a, b (produced at the same magnification). The fracture surface of the Mg/Mg₂Si–HO composite was characterized by cleavage steps, which are typical for magnesium. the Mg/Mg₂Si–HO composite was characterized by cleavage steps, which are typical for magnesium. the Mg/Mg₂Si–HO composite was characterized by cleavage steps, which are typical for magnesium. The failure of magnesium is usually brittle through cleavage or quasi-cleavage due to the hexagonal closed packed structure. Higher magnifications used during fracture surface observations (Figure 10) also revealed cracking through the Mg + Mg₂Si eutectic.

also revealed cracking through the Mg + Mg₂Si eutectic.

2

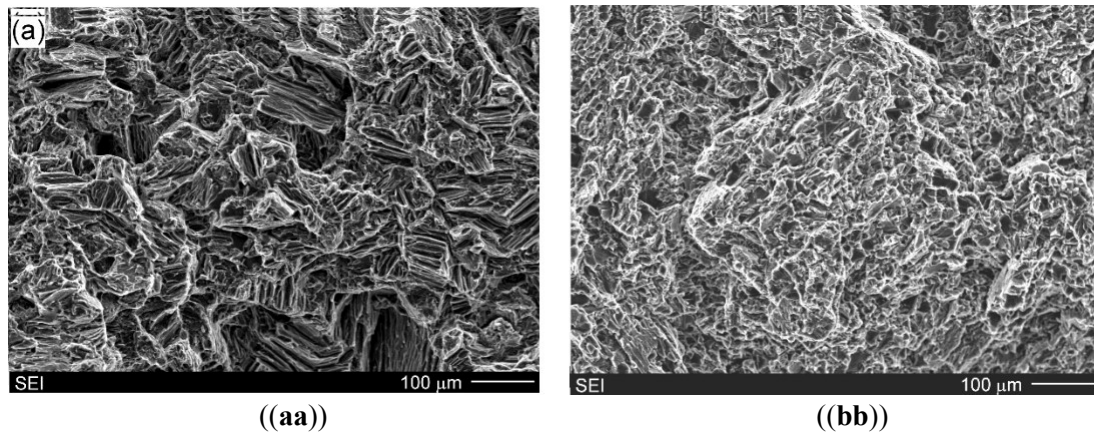


Figure 9. SEM micrographs of fracture surface of Mg/Mg₂Si–HO (a) and Mg/Mg₂Si–HR (b) composites (after uniaxial tensile test).

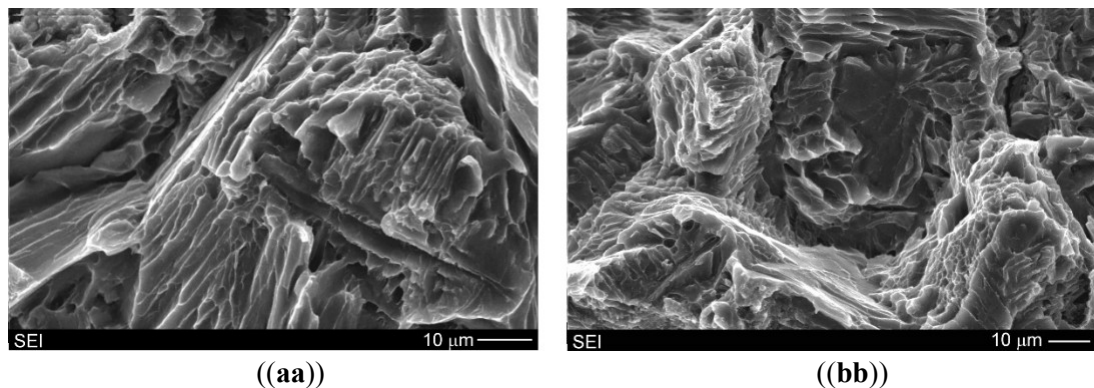


Figure 10. SEM micrographs of Mg/Mg₂Si–HO composite fracture surfaces illustrating cracking.

of the material investigated in the present study did not indicate this mechanism in the Mg/Mg₂Si—HR compositeposite.. The micrographs presented in Figures 11c,d,d and 12 show that the cracking process

with the propagation of secondary cracks. All the Mg₂Si phases designated as 1–3 in Figure 11c and as proceeded through the Mg₂Si with the propagation of secondary cracks.. All the Mg₂Si phases 1–2 in Figure 12a had visible effects of brittle cracking. The presented SEM results also indicate that designated as 11–33 in Figure 11c and as 11–22 in Figure 12a had visible effects of brittle cracking.. The primary Mg₂Si crystals and the surrounding magnesium phase were strongly connected, which could presented SEM results also indicate that primary Mg₂Si crystals and the surrounding magnesium also be an additional argument for the heterogeneous nucleation of magnesium dendrites on the Mg₂Si phase were strongly connected, which could also be an additional argument for the heterogeneous

phase. The magnesium dendrite surrounding the Mg₂Si cracked particle (described as 3) is especially nucleation of magnesium dendrites on the Mg₂Si phase.. The magnesium dendrite surrounding the visible in Figure 11.

Mg₂Si cracked particle (described as 3) is especially visible in Figure 11..

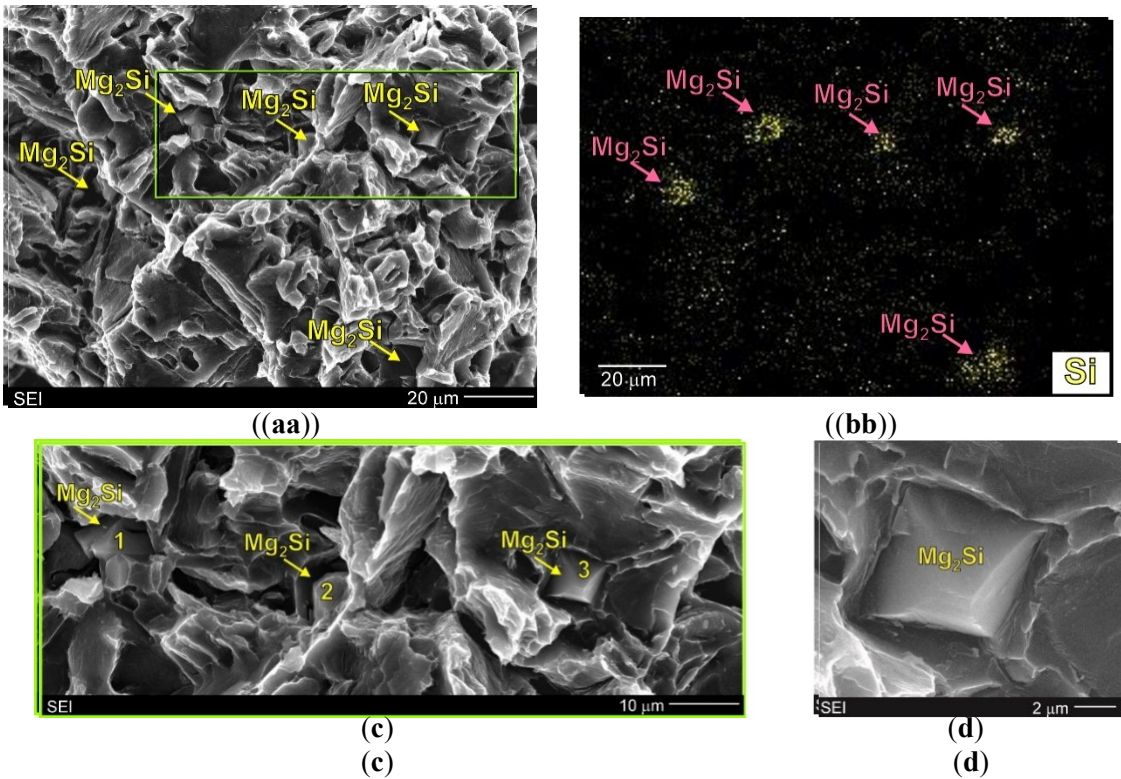


Figure 11. SEM micrographs of Mg/Mg₂Si composite fracture surfaces (after 500 MPa tensile test). (a) Low magnification SEM image showing the overall fracture surface of the Mg/Mg₂Si composite. Several Mg₂Si phases are visible and labeled with yellow arrows. A green box highlights a specific area. (b) EDS map showing the distribution of silicon (Si) in the fracture surface. The Si signal is shown in yellow, and the Mg signal is in red. The map shows the distribution of Si in the fracture surface. (c) Higher magnification SEM image of a specific area, showing Mg₂Si phases labeled 1, 2, and 3. (d) Higher magnification SEM image of a specific area, showing a single Mg₂Si phase labeled 3.

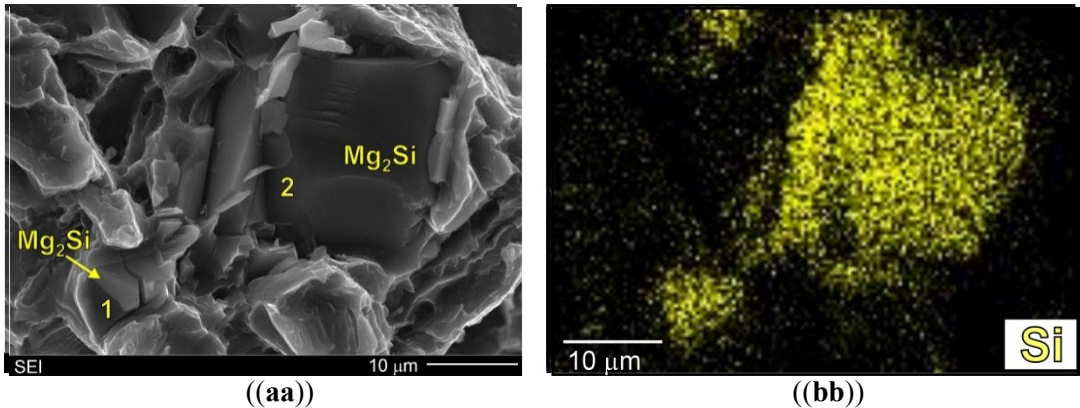


Figure 12.. SEM micrographs of Mg/Mg₂Si—HR composite of fracture surfaces (after uniaxial tensile test) ((**aa**)) with adequate silicon surface distribution (EDX) ((**bb**)).
test) (**a**) with adequate silicon surface distribution (EDX) (**b**).

- 1 Magnesium matrix composites with 1.9 and 19 wt% Mg₂Si phase were successfully fabricated by the casting method.
- 2 The microstructure of the material with 1.9 wt% Mg₂Si consisted of primary magnesium dendrites and an Mg + Mg₂Si eutectic mixture, whereas the composite with 19 wt% Mg₂Si exhibited a primary polygonal Mg₂Si compound surrounded by magnesium dendrites and eutectic.
- 3 The composites exhibited a rise in tensile and yield strength in both the tensile and compression tests with an increase in the weight fraction of the Mg₂Si phase.
- 4 The fracture surface observations revealed that during the uniaxial tensile test, the cracking process of the fabricated composites proceeded through all structural constituents.

Author Contributions: Conceptualization, K.N.B.-M. and M.A.M.; methodology, K.N.B.-M. and M.A.M.; investigation, K.N.B.-M. and M.A.M.; writing—original draft preparation, K.N.B.-M. and M.A.M.; writing—review and editing, K.N.B.-M. and M.A.M. All authors have read and agreed to the published version of the manuscript.

Funding: This research received no external funding.

Conflicts of Interest: The authors declare no conflict of interest.

References

1. Kucharczyk, A.; Naplocha, K.; Tomanik, M. Processing in porous niti preforms for niti/mg composites. *Arch. Metal. Mater.* **2019**, *64*, 747–752.
2. Dolata, A.J.; Dyzia, M.; Boczek, S. Influence of the Sr and Mg alloying additions on the bonding between matrix and reinforcing particles in the AlSi7Mg/SiC-C_{gr} hybrid composites. *Arch. Metal. Mater.* **2016**, *61*, 651–656. [[CrossRef](#)]
3. Dolata, A.J. Hybrid composites shaped by casting methods. *Solid State Phenom.* **2014**, *211*, 47–52. [[CrossRef](#)]
4. Nishida, Y. *Introduction to Metal Matrix Composites: Fabrication and Recycling*; Springer: Tokyo, Japan, 2013. [[CrossRef](#)]
5. Chawla, N.; Chawla, K.K. *Metal Matrix Composites*; Springer Science + Media: New York, NY, USA, 2013. [[CrossRef](#)]
6. Braszczynska'-Malik, K.N. *Magnesium Alloys and Composites on Their Matrix*; Czestochowa University Publisher: Czestochowa, Poland, 2017; ISBN 978-83-7193-674-6.
7. Braszczynska', K.N. Contribution of SiC particles to the formation of the structure of Mg-3wt %RE cast composites. *Zeitschrift für Metallkunde* **2003**, *94*, 144–148. [[CrossRef](#)]
8. Saravanan, R.A.; Surappa, M.K. Fabrication and characterization of pure magnesium-30 vol.% SiCp particle composite. *Mater. Sci. Eng. A* **2000**, *276*, 108–116. [[CrossRef](#)]
9. Bochenek, A.; Braszczynska', K.N. Structural analysis of the MgAl5 matrix—SiC particles cast composites. *Mater. Sci. Eng. A* **2000**, *290*, 122–127. [[CrossRef](#)]
10. Braszczynska'-Malik, K.N.; Przelozyn'ska', E. Analyses of AM50-Tip metal-metal composite microstructure. *J. Alloys Comp.* **2018**, *731*, 1181–1187. [[CrossRef](#)]

11. Braszczyńska-Malik, K.N.; Przelozyńska, E. The influence of Ti particles on microstructure and mechanical properties of Mg-5Al-5RE matrix alloy composite. *J. Alloys Comp.* **2017**, *728*, 600–606. [[CrossRef](#)]
12. Godzierz, M.; Olszówka-Myalska, A. Influence of casting procedure on wear of magnesium matrix composites reinforced with carbon open-celled foam. *Compos. Theory Pract.* **2019**, *19*, 64–70.
13. Braszczyńska-Malik, K.N.; Kamieniak, J. AZ91 magnesium matrix foam composites with fly ash cenospheres fabricated by negative pressure infiltration technique. *Mater. Charact.* **2017**, *128*, 209–216. [[CrossRef](#)]
14. Braszczyńska-Malik, K.N.; Kamieniak, J. The role of Ni-P coating structure on fly ash cenospheres in the formation of magnesium matrix composites. *Metal. Mater. Trans. A* **2017**, *48A*, 5649–5657. [[CrossRef](#)]
15. Chen, K.; Li, Z. Effect of co-modification by Ba and Sb on the microstructure of Mg₂Si/Mg–Zn–Si composite and mechanism. *J. Alloys Comp.* **2014**, *592*, 196–201. [[CrossRef](#)]
16. Hu, X.S.; Wu, K.; Zheng, M.Y. Effect of heat treatment on the stability of damping capacity in hypoeutectic Mg–Si alloy. *Scripta Mater.* **2006**, *54*, 1639–1643. [[CrossRef](#)]
17. Mirshahi, F.; Meratian, M. High temperature tensile properties of modified Mg/Mg₂Si in situ composite. *Mater. Des.* **2012**, *33*, 557–562. [[CrossRef](#)]
18. Pan, Y.; Liu, X.; Yang, H. Microstructural formation in a hypereutectic Mg–Si alloy. *Mater. Charact.* **2005**, *55*, 241–247. [[CrossRef](#)]
19. Mosleh, S.; Emamy, M.; Majdi, H. The effect of Si and extrusion process on the microstructure tensile properties of Mg–Mg₂Si Composite. *Procedia Mater. Sci.* **2015**, *11*, 79–83. [[CrossRef](#)]
20. Zheng, N.; Wang, H.Y.; Gu, Z.H.; Wang, W.; Jiang, Q.C. Development of an effective modifier for hypereutectic Mg–Si alloys. *J. Alloys Comp.* **2008**, *463*, L1–L4. [[CrossRef](#)]
21. Hu, J.; Tang, C.; Zhang, X.; Deng, Y. Modification of Mg₂Si in Mg–Si alloys with neodymium. *Trans. Nonferrous Met. Soc. China* **2013**, *23*, 3161–3166. [[CrossRef](#)]
22. Seth, P.P.; Singh, N.; Singh, M.; Prakash, O.; Kumar, D. Formation of fine Mg₂Si phase in Mg–Si alloy via solid-state sintering using high energy ball milling. *J. Alloys Comp.* **2020**, *821*, 153205. [[CrossRef](#)]
23. Niu, X.; Lu, L. Formation of magnesium silicide by mechanical alloying. *Adv. Perform. Mater.* **1997**, *4*, 275–283. [[CrossRef](#)]
24. Sun, B.; Li, S.; Imai, H.; Umeda, J.; Kon, K. Synthesis kinetics of Mg₂Si and solid-state formation of Mg–Mg₂Si composite. *Powder Tech.* **2012**, *2017*, 157–162. [[CrossRef](#)]
25. Lu, L.; Thong, K.K.; Gupta, M. Mg-based composite reinforced by Mg₂Si. *Compos. Sci. Technol.* **2003**, *63*, 627–632. [[CrossRef](#)]
26. Nieroda, P.; Kolezynski, A.; Leszczynski, J.; Nieroda, J.; Pasierb, P. The structural, microstructural and thermoelectric properties of Mg₂Si synthesized by SPS method under excess Mg content conditions. *J. Alloys Comp.* **2019**, *775*, 138–149. [[CrossRef](#)]
27. Olszówka-Myalska, A.; Wrzeźniowski, P.; Myalska, H.; Godzierz, M.; Kuc, D. Impact of the morphology of micro- and nanosized powder mixtures on the microstructure of Mg–Mg₂Si–CNT composite sinters. *Materials* **2019**, *12*, 3242. [[CrossRef](#)] [[PubMed](#)]
28. Zhang, W.; Li, X.; Ding, D.; Gao, P. Microstructure and mechanical properties of Mg₂Si/AZ91 composites in situ synthesized by using silica fume as the Si source. *J. Mater. Eng. Perform.* **2018**, *27*, 5300–5311. [[CrossRef](#)]
29. Mirshahi, F.; Meratian, M.; Panjepour, M. Effect of cooling rate on morphology and distribution of precipitates Mg₂Si particles in Mg/Mg₂Si composites, Magnesium. In *Proceedings of the 8th International Conference on Magnesium Alloys and Their Applications 2009*, Weimar, Germany, 26–29 October 2009; Kainer, K.U., Ed.; Wiley-VCH: Weinheim, Germany, 2010; ISBN 978-3-527-32732-4.

30. Hu, X.S.; Wu, K.; Zheng, M.Y.; Gan, W.M.; Wang, X.J. Low frequency damping capacities and mechanical properties of Mg–Si alloys. *Mater. Sci. Eng. A*. **2007**, 452–453, 374–379. [[CrossRef](#)]
31. Han, W.D.; Li, Y.H.; Li, X.D.; Dai, J.; Li, K. Doping and adsorption mechanism of modifying the eutectic Mg₂Si phase in magnesium alloys with rare earth elements: A first-principles study. *Appl. Surf. Sci.* **2020**, 503, 144331. [[CrossRef](#)]
32. Wang, Y.; Guo, X. Heterogeneous nucleation of Mg₂Si and Mg₂(Si,Sn) on Mg₃Sb₂ nucleus in Mg containing Si alloys. *Mater. Chem. Phys.* **2019**, 223, 336–342. [[CrossRef](#)]
33. Jiang, Q.C.; Wang, H.Y.; Wang, Y.; Ma, B.X.; Wang, J.G. Modification of Mg₂Si in Mg–Si alloys with yttrium. *Mater. Sci. Eng. A* **2005**, 392, 130–135. [[CrossRef](#)]
34. Guo, E.J.; Ma, B.X.; Wang, L.P. Modification of Mg₂Si morphology in Mg–Si alloys with Bi. *J. Mater. Proc. Tech.* **2008**, 206, 161–166. [[CrossRef](#)]
35. Shin, H.C.; Son, J.; Min, B.K.; Choi, Y.S.; Cho, K.M.; Cho, D.H.; Park, I.M. The effect of Ce on the modification of Mg₂Si phases of as-cast eutectic Mg–Si alloys. *J. Alloys Comp.* **2019**, 792, 59–68. [[CrossRef](#)]
36. Malik, M.; Majchrzak, K.; Braszczyńska-Malik, K.N. Microstructural analysis of AM50/Mg₂Si cast magnesium composites. *Arch. Foundry Eng.* **2012**, 12, 109–112. [[CrossRef](#)]
37. Wang, K.Y.; Zhao, R.D.; Wu, F.F.; Wu, X.F.; Chen, M.H.; Xiang, J.; Chen, S.H. Improving microstructure and mechanical properties of hypoeutectic Al–Mg₂Si alloy by Gd addition. *J. Alloys Comp.* **2020**, 813, 152178. [[CrossRef](#)]
38. Que, Z.; Wang, Y.; Fan, Z. Heterogeneous nucleation of eutectic structure in Al–Mg–Si alloys. *Metal. Mater. Trans. A* **2020**, 51, 2697–2702. [[CrossRef](#)]
39. Shafieizad, A.H.; Zarei-Hanzaki, A.; Abedi, H.R.; Al-Fadhalah, K.J. The Mg₂Si phase evolution during thermomechanical processing of in-situ aluminum matrix macro-composite. *Mater. Sci. Eng. A* **2015**, 644, 310–317. [[CrossRef](#)]
40. Zainon, F.; Ahmad, K.R.; Daud, R. The effects of Mg₂Si_(p) on microstructure and mechanical properties of AA332 composite. *Adv. Mater. Res.* **2016**, 5, 55–66. [[CrossRef](#)]
41. Chegini, M.; Shaeri, M.H.; Taghiabadi, R.; Chegini, S.; Djavanroodi, F. The correlation of microstructure and mechanical properties of in-situ Al–Mg₂Si cast composite processed by equal channel angular pressing. *Materials* **2019**, 12, 1553. [[CrossRef](#)]
42. Ghandvara, H.; Idris, M.H.; Abu Bakar, T.A.; Nafari, A.; Ahmad, N. Microstructural characterization, solidification characteristics and tensile properties of Al–15%Mg₂Si–x(Gd–Sb) in-situ composite. *J. Mater. Technol.* **2020**, 9, 3272–3291. [[CrossRef](#)]
43. Zhu, X.; Yang, H.; Dong, X.; Ji, S. The effects of varying Mg and Si levels on the microstructural inhomogeneity and eutectic Mg₂Si morphology in die-cast Al–Mg–Si alloys. *J. Mater. Sci.* **2019**, 54, 5773–5787. [[CrossRef](#)]
44. Kamieniak, J.; Braszczyńska-Malik, K.N. Problems fabricating cast magnesium matrix composites with aluminosilicate cenospheres. *Compos. Theory Pract.* **2014**, 14, 214–218.
45. Braszczyńska-Malik, K.N.; Kamieniak, J. Analysis of interface between components in AZ91 magnesium alloy foam composite with Ni–P coated fly ash cenospheres. *J. Alloys Comp.* **2017**, 720, 352–359. [[CrossRef](#)]
46. Jiang, W.; Wang, J.; Yu, W.; Ma, Y.; Guo, S. In-situ formation of a gradient Mg₂Si/Mg composite with good biocompatibility. *Surf. Coat. Tech.* **2019**, 361, 255–262. [[CrossRef](#)]
47. Liu, J.; Zhang, L.; Liu, S.; Han, Z.; Dong, Z. Effect of Si content on microstructure and compressive properties open cell Mg composite foams reinforced by in-situ Mg₂Si compounds. *Mater. Charact.* **2020**, 159, 110045. [[CrossRef](#)]
48. Thermo-Calc Software AB, TCS Mg-Based Alloys Database, Version 4.0; TCMG: Stockholm, Sweden, 2015.
49. ICDD. Powder Diffraction File, PDF-4+; International Centre for Diffraction Data: Pennsylvania, PA, USA, 2015. Available online: <https://www.icdd.com/> (accessed on 14 August 2020).