



## Ultrastrong Mg Alloy via Nano-spaced Stacking Faults

W. W. Jian , G. M. Cheng , W. Z. Xu , H. Yuan , M. H. Tsai , Q. D. Wang , C. C. Koch , Y. T. Zhu & S. N. Mathaudhu

To cite this article: W. W. Jian , G. M. Cheng , W. Z. Xu , H. Yuan , M. H. Tsai , Q. D. Wang , C. C. Koch , Y. T. Zhu & S. N. Mathaudhu (2013) Ultrastrong Mg Alloy via Nano-spaced Stacking Faults, Materials Research Letters, 1:2, 61-66, DOI: [10.1080/21663831.2013.765927](https://doi.org/10.1080/21663831.2013.765927)

To link to this article: <https://doi.org/10.1080/21663831.2013.765927>



Copyright W. W. Jian, G. M. Cheng, W. Z. Xu, H. Yuan, M. H. Tsai, Q. D. Wang, C. C. Koch, Y. T. Zhu and S. N. Mathaudhu



Published online: 12 Mar 2013.



Submit your article to this journal [↗](#)



Article views: 13423



View related articles [↗](#)



Citing articles: 84 View citing articles [↗](#)

## REPORT

## Ultrastrong Mg Alloy via Nano-spaced Stacking Faults

W. W. Jian<sup>a</sup>, G. M. Cheng<sup>a</sup>, W. Z. Xu<sup>a</sup>, H. Yuan<sup>a</sup>, M. H. Tsai<sup>a</sup>, Q. D. Wang<sup>b</sup>, C. C. Koch<sup>a</sup>,  
Y. T. Zhu<sup>a,\*</sup> and S. N. Mathaudhu<sup>a,c,\*</sup><sup>a</sup>Department of Materials Science and Engineering, North Carolina State University, Raleigh, NC 27695, USA;<sup>b</sup>School of Materials Science and Engineering, Shanghai Jiaotong University, Shanghai, People's Republic of China;<sup>c</sup>Materials Science Division, U.S. Army Research Office, Research Triangle Park, NC 27709, USA

(Received 12 September 2012; final form 9 January 2013)

Mg alloys are among the lightest alloys but they are usually weak. Here we report a new mechanism to make them ultrastrong while maintaining good ductility. Stacking faults with nanoscale spacing were introduced into a Mg–8.5Gd–2.3Y–1.8Ag–0.4Zr (wt%) alloy by conventional hot rolling, which produced a yield strength of ~575 MPa, an ultimate strength of ~600 MPa, and a uniform elongation of ~5.2%. Low stacking fault (SF) energy enabled the introduction of a high density of SFs, which impeded dislocation slip and promoted dislocation accumulation. These findings provide guidance for developing Mg alloys with superior mechanical properties.

**Keywords:** Stacking Faults, Mg, Strength, Ductility, Dislocations

Magnesium and its alloys have attracted extensive attention in the recent years due to their abundance, low-density, good castability and recyclability [1–4]. However, the application of Mg alloys has been substantially hindered by their relatively low strengths (tensile yield strength: ~100–250 MPa for commercial casting Mg alloys [5,6]) and limited ductility (elongation: 2–8% [5–7]) at room temperature. Outside of traditional precipitation control, Mg-alloy strengthening typically relies on two general approaches: non-traditional, esoteric processing and grain refinement. An example of non-traditional processing for high strength is rapid solidification/powder metallurgy, which was used to obtain a yield strength of ~600 MPa in a Mg–Zn–Y alloy with uniform distribution of long-period ordered structures [8]. While the resultant properties are remarkable, such unconventional processing technologies limit potential industrial application. In addition, the ultra-high strength is usually accompanied by marked losses in ductility [8].

The second general approach of grain refinement for strengthening has been used to obtain ultrafine (<1 μm) grains in Mg alloys [9–12]. The high concentration of grain boundaries (GBs) in the ultrafine-grained

microstructure provides barriers to motion of dislocations and consequently promotes the strength improvement. Nevertheless GB strengthening mechanism alone provided limited contribution to macroscopic yield strengths, which, in these reports [9–12], are typically less than 400 MPa. More importantly, refining the grain size is reported to suppress the propensity of deformation twinning which, in addition to dislocation slip is an important mechanism for enhancing strength and ductility [13–18]. Ultrafine-grained microstructures also suffer from strength reduction via grain growth at a relatively low temperature (0.32  $T_m$ ) [19], thus limiting the potential for further shaping or processing.

In this letter, we report a new mechanism for inducing ultrahigh strengths (yield strength: ~575 MPa, ultimate strength: ~600 MPa) and maintaining moderate ductility (uniform elongation: ~5.2%) via conventional processing (hot rolling) of a Mg-alloy (Mg–8.5Gd–2.3Y–1.8Ag–0.4Zr (wt%)) with relatively large grain sizes (13 μm). We posit that the introduction of a high density of stacking faults (SFs) with nanoscale spacing provides for a high density of barriers to block and pin dislocations and retention of work hardening for enhanced ductility.

\*Corresponding authors. [ytzhu@ncsu.edu](mailto:ytzhu@ncsu.edu), [suveen.n.mathaudhu.civ@mail.mil](mailto:suveen.n.mathaudhu.civ@mail.mil)

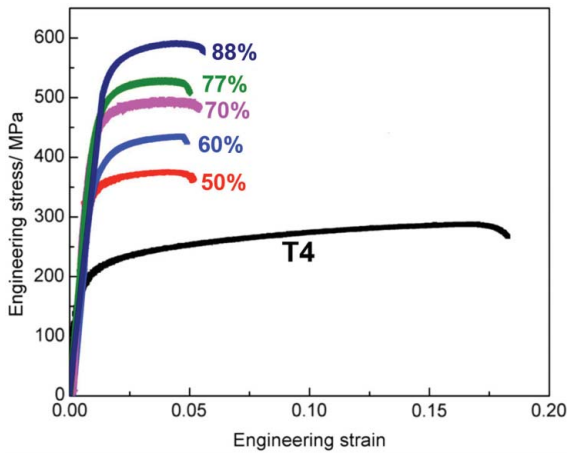


Figure 1. Engineering stress–strain curves of Mg alloy samples under T4 treatment and hot rolling with different thickness reductions (marked by the curves).

The casting procedure used to produce the Mg–8.5Gd–2.3Y–1.8Ag–0.4Zr (wt%) (hereafter referred to as “Mg alloy ingot can be found in reference [20]. The Mg alloy was then T4 treated (solution treatment at 500°C for 12 h in a vacuum furnace and quenched in room temperature silicon oil); the T4 conditions serve as a baseline for property assessment. Prior to each rolling pass, specimens were heated in a furnace at 450°C for 15 min and rolled on a conventional hot roller with a thickness reduction of <5% per pass to a total rolling reduction of 50%–88%. Rolled specimens were air-cooled to room temperature. Tensile test samples were cut on the rolling plane and pulled to failure in the direction parallel to rolling direction using a strain rate of  $2.35 \times 10^{-3} \text{ s}^{-1}$ . The gauge length and width of the testing samples are 7 and 1 mm, respectively. The surfaces of gauge region were polished to mirror-like surfaces before tensile testing and at least three samples for each rolling parameter were tested. For transmission electron microscopy (TEM) studies, specimens were gently polished and then ion milled to perforation on a cold stage with low angle and low-energy ion beam, and microscopy was conducted on a JEM-2000FX and a JEM-2010F operating at 200 kV.

Figure 1 shows the tensile engineering stress–strain curves of the Mg alloy samples after T4 treatment, and after hot rolling to different thickness reductions. Both the tensile yield strength and ultimate strength of the rolled samples increase as the rolling strain increases. At 88% rolling reduction, the grain size was refined to  $\sim 13 \mu\text{m}$ , and the maximum tensile yield strength and ultimate strength reached 575 and  $\sim 600$  MPa, respectively, which are more than two times the values of the T4 treated baseline. Compared with the yield strength and uniform elongation values of various Mg alloys [9,11,21–54] as shown in Figure 2, the current result is an extraordinary combination of ultrahigh strength and reasonably good ductility. Importantly, the elongation to failure of

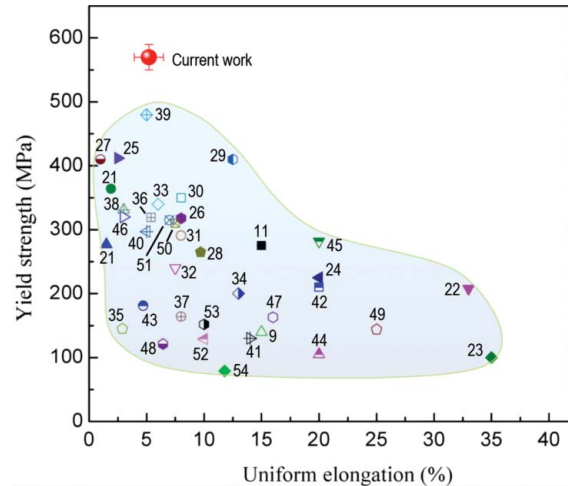


Figure 2. Summary of room temperature tensile yield strength and uniform elongation of previous reports and our current work. The criteria used to summarize and reproduce this figure are (1) only room temperature uniaxial tensile test results were included, (2) the gauge length of tensile test sample was larger than 5 mm and (3) the stress–strain curve must be indicated in the individual report in order to reproduce the uniform elongation. The reference number is adjacent to the data point. Note: Ref. [8] reported a Mg alloy with a yield strength of 600 MPa, but its uniform elongation is not available.

the processed Mg alloy retains a moderate level (5–6%) without diminishing during the hotrolling process.

The TEM analysis was performed to probe the main microstructural features that are responsible for the observed strengthening in the hot rolled Mg–8.5Gd–2.3Y–1.8Ag–0.4Zr (wt%) alloy. It was observed that beyond 50% thickness reductions, basal plane SFs become the primary crystalline defects (see Figure 3). The (0001) basal plane SFs are further verified by the presence of streaking along the [0001] direction in the selected area diffraction pattern [55] (Figure 3(d)). The average spacing between adjacent SFs,  $d$ , decreases with rolling thickness reduction. At 88% thickness reduction, nano-spaced SFs with an average spacing  $d \sim 16$  nm were formed in most of the coarse ( $\sim 13 \mu\text{m}$ ) grains. The formation of high density of SFs is due to the low SF energy (SFE) of this Mg alloy. It has been reported that both Gd and Y lower the SFE of Mg [56,57]. The SFs can be formed by the dissociation of a full dislocation into two partial dislocations on the basal plane during plastic deformation. The partial dislocations can be driven apart by applied stress to form a wide planar SF ribbon [58]. Our primary TEM observations also indicate that there was a transition stage in the rolling thickness reduction range of  $\sim 30\%$  to  $\sim 50\%$ , in which deformation mechanism transitioned from dislocation slip to SFs-mediated process. Further study on this transition is underway and will be reported in the future.

Plotting the yield strength against the reciprocal of average spacing of SFs,  $1/d$ , reveals a linear relationship

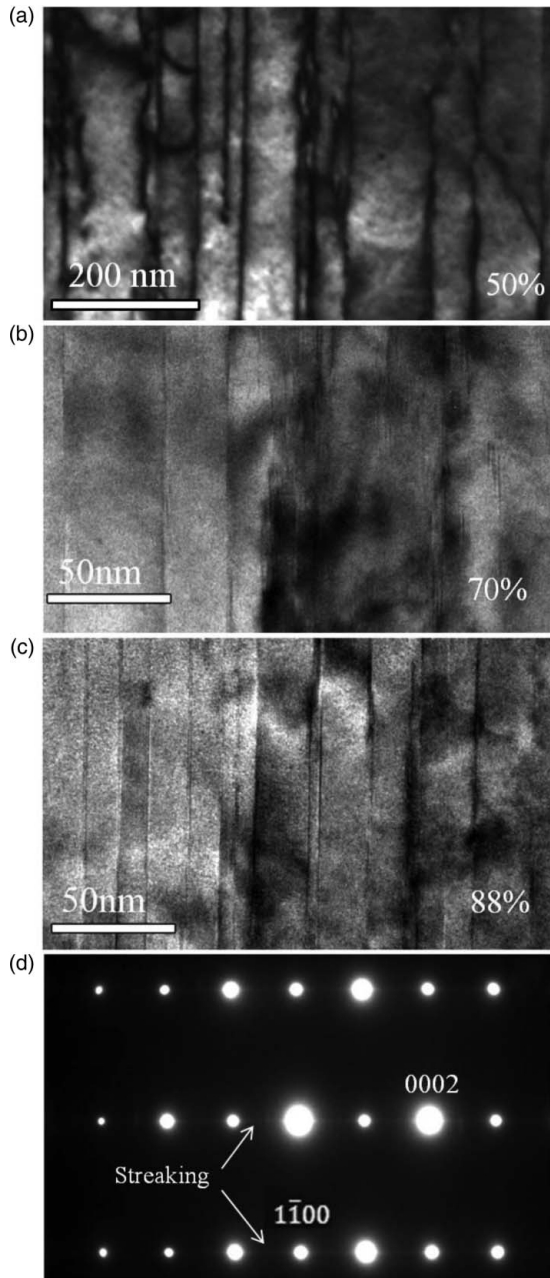


Figure 3. TEM images of Mg alloy samples with various rolling thickness reductions: (a) 50%,  $d = 55$  nm, (b) 70%,  $d = 25$  nm and (c) 88%,  $d = 16$  nm. Image (d) is the SAD pattern of the 70% rolled sample in which the streaking verifies the basal plane SFs.

(Figure 4), i.e.

$$\sigma_{0.2} = \sigma_0 + \frac{k}{d}, \quad (1)$$

where  $d$  is the mean spacing between adjacent SFs,  $\sigma_0$  is the total strength contributed by strengthening mechanisms other than SFs. This relationship is similar to the empirical Hall–Petch equation and its physical model is being developed and will be published in the future. In the current Mg alloy, a number of typical strengthening

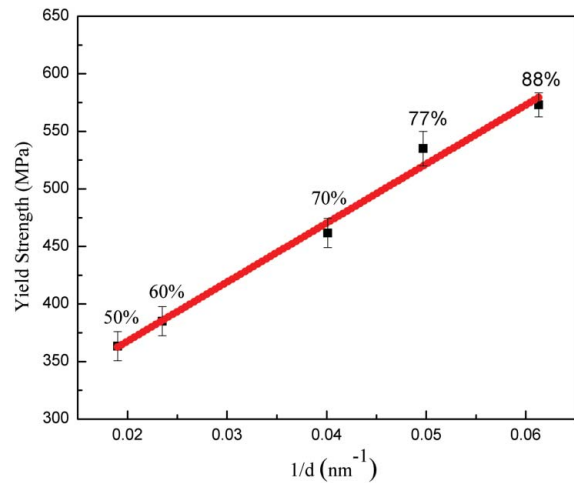


Figure 4. Yield strength vs the reciprocal of mean spacing between SFs of rolled samples with different thickness reduction. The number by each data point indicates the thickness reduction by hot rolling.

mechanisms such as solid solution strengthening, grain refinement, dynamic precipitation and textural strengthening are expected to be active [8,20]; however, strengthening contributions from these are not expected to be the primary cause of the ultrahigh strength observed.

The large slope of the linear correlation between the strength and  $1/d$ , the reciprocal of the SF spacing indicates that the SFs are very effective in improving the strength. Fitting the data in Figure 4 with Equation (1) yields  $\sigma = 340$  MPa, and  $k = 3780$  MPa nm. Therefore, introducing SFs with an average spacing of 16 nm increased the yield strength of the Mg alloy by 70% from 340 to 575 MPa. This indicates that SFs are very effective in improving the strength of Mg alloys. The fact that SFs increased the strength, but did not decrease the ductility (see Figure 1) makes SFs very attractive for improving mechanical properties of Mg alloys. This discovery is especially important for hexagonal close-packed (hcp) metals and alloys, because twinning, an effective approach for improving strength and ductility for face centered cubic (fcc) metals and alloys, becomes very difficult to activate in hcp metals when the grain sizes are below a few hundred nanometers [13,14], making it very difficult to combine the strengthening effects of refining grains and introducing twins.

SFs on basal planes are expected to provide similar effect on impeding dislocation movement as reported for nano-twinned electrodeposited Cu [17] As dislocations slip and encounter SF boundaries, they can either (1) cut or interact with SFs in order to move and facilitate plastic deformation or (2) accumulate around SF boundaries and accommodate a moderate strain hardening [59]

In order to probe the dislocation interactions with SFs, postmortem TEM observation (Figure 5) was conducted on tension-tested samples that were hot rolled

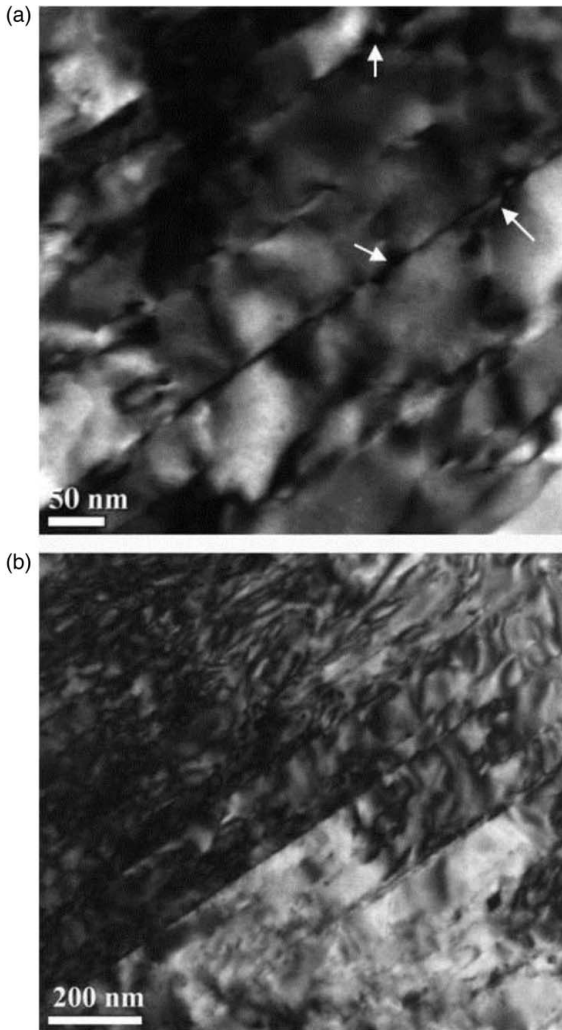


Figure 5. TEM images of 88% hot rolled sample after tensile test. (a) Fragments of SFs cut by the dislocations marked by white arrows (b) High density of dislocations was trapped between SFs.

to 88% to produce nano-spaced SFs Figure 5(a) shows the distinctly different features of fragmented SFs as compared to Figure 3(c). Some SFs have been broken into short segments (Figure 5(a)), and a high density of dislocations are trapped between SFs (Figure 5(b)). As shown in Figure 5(a), some SF segments are well aligned along a line, suggesting that they were most likely formed from a single SF that was cut by dislocations (marked by white arrows) slipping on pyramidal or prismatic planes.

Since the slip systems in hcp Mg are limited at room temperature, it is necessary to activate  $\langle c \rangle$  and/or  $\langle c + a \rangle$  dislocations to slip on the pyramidal or prismatic slip planes. Such dislocation slip will encounter SFs and cut SFs into segments, which are additional pinning sites to block dislocation motion. These dislocation-SF interactions are similar in some way to the dislocation-twin interactions in an fcc system [59] More investigation is needed to study these interaction details.

The blocking of dislocations by SFs and the cutting of SFs by dislocations will hinder the slip of dislocations, which consequently increases the yield strength. The high density of dislocations between SFs after tensile testing indicates that SFs are effective in blocking and accumulating dislocations, which will enhance strain-hardening rate and consequently help with ductility retention. This explains why no ductility reduction is observed with increasing strength when a high density of SFs is introduced into the Mg alloy.

In summary, conventional hot rolling was conducted on a T4treated Mg–8.5Gd–2.3Y–1.8Ag–0.4Zr (wt%)Mg alloy with thickness reduction up to 88%. Unprecedented strength and moderate ductility (YS  $\sim$ 575 MPa, UTS  $\sim$ 600 MPa and uniform elongation  $\sim$ 5.2%) were observed in the resultant coarse-grained alloy. TEM studies show that a high density of nano-spaced SFs are the main defects inside of the grains and their density increased as rolling thickness reduction increased. The strength of the processed Mg alloy was found to increase as the mean spacing between adjacent (SFs) decreased. Nano-spaced SFs are found to be tremendously effective in impeding the movement of dislocations and retaining strain hardening. Activation of nonbasal dislocations during tensile testing accounts for the detected moderate ductility, in addition to the capability of retaining strain hardening. It is expected that optimization of approaches that introduce a high density of nano-spaced SFs will enable other Mg alloys with concurrent high strength and good ductility.

**Acknowledgements** This work was supported by the U.S. Army Research Office under grant no. W911NF-12-1-0009. QDW is supported by the National Natural Science Foundation of China under grant no. 51074106

## References

- [1] Nie JF, Gao X, Zhu SM. Enhanced age hardening response and creep resistance of Mg–Gd alloys containing Zn. *Scripta Mater.* 2005;53:1049–1053.
- [2] He SM, Zeng XQ, Peng LM, Gao X, Nie JF, Ding WJ. Microstructure and strengthening mechanism of high strength Mg–10Gd–2Y–0.5Zr alloy. *J Alloys Compd.* 2007;427:316–323.
- [3] Honma T, Ohkubo T, Kamado S, Hono K. Effect of Zn additions on the age-hardening of Mg<sub>2</sub>O<sub>2</sub>Gd–1.2Y–0.2Zr alloys. *Acta Mater.* 2007;55:4137–4150.
- [4] Yamada K, Hoshikawa H, Maki S, Ozaki T, Kuroki Y, Kamado S, Kojima Y. Enhanced age-hardening and formation of plate precipitates in Mg–Gd–Ag alloys. *Scripta Mater.* 2009;61:636–639.
- [5] Mordike BL, Ebert T. Magnesium – properties – applications – potential. *Mater Sci Eng A.* 2001;302:37–45.
- [6] Pekguleryuz M, Labelle P, Argo D. Magnesium die casting alloy AJ62x with superior creep resistance, ductility and die castability. In: Ruden T, editor. *Lightweight magnesium technology 2001–2005. Proceedings; 2006 March; Warrendale (PA): Society of Automotive Engineers; 2006.*

- [7] Champrenault M, Maas CA, Cunningham J. Magnesium powertrain mount brackets: new application of material being used in this sub-system for vehicle mass reduction. In: Liu ZK, Powell BR, Zheng WY, editors. Magnesium technologies 2007. Proceedings; 2007 April; Warrendale (PA): Society of Automotive Engineers; 2007.
- [8] Inoue A, Kawamura Y, Matsushita M, Hayashi K, Koike J. Novel hexagonal structure and ultrahigh strength of magnesium solid solution in the Mg–Zn–Y system. *J Mater Res.* 2001;16:1894–1900.
- [9] Yamashita A, Horita Z, Langdon TG. Improving the mechanical properties of magnesium and a magnesium alloy through severe plastic deformation. *Mater Sci Eng A.* 2001;300:142–147.
- [10] Ma AB, Jiang JH, Saito N, Shigematsu I, Yuan YC, Yang DH, Nishida Y. Improving both strength and ductility of a Mg alloy through a large number of ECAP passes. *Mater Sci Eng A.* 2009;513–514:122–127.
- [11] Yoshida Y, Arai K, Itoh S, Kamado S, Kojima Y. Realization of high strength and high ductility for AZ61 magnesium alloy by severe warm working. *Sci Tech Adv Mater.* 2005;6:185–194.
- [12] Jian WW, Kang ZX, Li YY. Effect of hot plastic deformation on microstructure and mechanical property of Mg–Mn–Ce magnesium alloy. *Trans. Nonferrous Met Soc China.* 2007;17:1158–1163.
- [13] Wu XL, Youssef KM, Koch CC, Mathaudhu SN, Kecskes LJ, Zhu YT. Deformation twinning in a nanocrystalline hcp Mg alloy. *Scripta Mater.* 2011;64:213–216.
- [14] Zhu YT, Liao XZ, Wu XL. Deformation twinning in nanocrystalline materials. *Prog Mater Sci.* 2012;57:1–62.
- [15] Zhao YH, Bingert JE, Liao XZ, Cui BZ, Han K, Sergueeva AV, Mukherjee AK, Valiev RZ, Langdon TG, Zhu YT. Simultaneously increasing the ductility and strength of ultra-fine-grained pure copper. *Adv Mater.* 2006;18:2949–2953.
- [16] Zhao YH, Zhu YT, Liao XZ, Horita Z, Langdon TG. Tailoring stacking fault energy for high ductility and high strength in ultrafine grained Cu and its alloy. *Appl Phys Lett.* 2006;89:121906-1-3.
- [17] Lu K, Lu L, Suresh S. Strengthening materials by engineering coherent internal boundaries at the nanoscale. *Science.* 2004;304:422–426.
- [18] Lu L, Shen YF, Chen XH, Qian LH, Lu K. Ultra-high strength and high electrical conductivity in copper. *Science.* 2004;304:422–426.
- [19] Lian JS, Valiev RZ, Baudalet B. On the enhanced grain-growth in ultrafine grained metals. *Acta Metall Mater.* 1995;43:4165–4170.
- [20] Wang QD, Chen J, Zhao Z, He SM. Microstructure and super high strength of cast Mg–8.5Gd–2.3Y–1.8Ag–0.4Zr alloy. *Mater Sci Eng A.* 2010;528:323–328.
- [21] Chino Y, Mabuchi M. Influences of grain size on mechanical properties of extruded AZ91 magnesium alloy after different extrusion processes. *Adv Eng Mater.* 2001;3:981–983.
- [22] Kim WJ, Hong SI, Kim YS, Min SH, Jeong HT, Lee JD. Texture development and its effect on mechanical properties of an AZ61 Mg alloy fabricated by equal channel angular pressing. *Acta Mater.* 2003;51:3293–3307.
- [23] Agnew SR, Horton JA, Lillo TM, Brown DW. Enhanced ductility in strongly textured magnesium produced by equal channel angular processing. *Scripta Mater.* 2004;50:377–381.
- [24] Kim WJ, Lee JB, Kim WY, Jeong HT, Jeong HG. Microstructure and mechanical properties of Mg–Al–Zn alloy sheets severely deformed by asymmetrical rolling. *Scripta Mater.* 2007;56:309–312.
- [25] Kim WJ, Lee YG. High-strength Mg–Al–Ca alloy with ultrafine grain size sensitive to strain rate. *Mater Sci Eng A.* 2011;528:2062–2066.
- [26] Xu C, Xu SW, Zheng MY, Wu K, Wang ED, Kamado S, Wang GJ, Lv XY. Microstructures and mechanical properties of high-strength Mg–Gd–Y–Zn–Zr alloy sheets processed by severe hot rolling. *J Alloys Compd.* 2012;524:46–52.
- [27] Xu SW, Oh-Ishi K, Kamado S, Uchida F, Homma T, Hono K. High-strength extruded Mg–Al–Ca–Mn alloy. *Scripta Mater.* 2011;65:269–272.
- [28] Leng Z, Zhang JH, Zhang ML, Liu XH, Zhan HB, Wu RZ. Microstructure and high mechanical properties of Mg–9Y–4Zn (Y: Y-rich misch metal) alloy with long period stacking ordered phase. *Mater Sci Eng A.* 2012;540:38–45.
- [29] Mora E, Garces G, Onorbe E, Perez P, Adeva P. High-strength Mg–Zn–Y alloys produced by powder metallurgy. *Scripta Mater.* 2009;60:776–779.
- [30] Gunde P, Hanzi AC, Sologubenko AS, Uggowitzer PJ. High-strength magnesium alloys for degradable implant applications. *Mater Sci Eng A.* 2011;528:1047–1054.
- [31] Somekawa H, Mukai T. High strength and fracture toughness balance on the extruded Mg–Ca–Zn alloy. *Mater Sci Eng A.* 2007;459:366–370.
- [32] Wang JL, Dong HW, Wang LD, Wu YM, Wang LM. Effect of hot rolling on the microstructure and mechanical properties of Mg–5Al–0.3Mn–2Nd alloy. *J Alloys Compd.* 2010;507:178–183.
- [33] Xu SW, Zheng MY, Kamado S, Wu K, Wang GJ, Lv XY. Dynamic microstructural changes during hot extrusion and mechanical properties of a Mg–5.0 Zn–0.9 Y–0.16 Zr (wt%) alloy. *Mater Sci Eng A.* 2011;528:4055–4067.
- [34] Fang DQ, Bi GL, Wang LM, Li GY, Jiang ZH. Microstructures and mechanical properties of Mg–2Y–1Mn–1Nd alloys fabricated by extrusion. *Mater Sci Eng A.* 2010;527:4383–4388.
- [35] Xiao WL, Jia SS, Wang J, Wu YM, Wang LM. Effects of cerium on the microstructure and mechanical properties of Mg–20Zn–8Al alloy. *Mater Sci Eng A.* 2008;474:317–322.
- [36] Peng QM, Dong HW, Tian YJ, Zhang HJ. Effect of backward extrusion on microstructure and mechanical properties of Mg–Gd based alloy. *Mater Sci Eng A.* 2012;532:443–448.
- [37] Zhang JH, Liu SJ, Leng Z, Liu XH, Niu ZY, Zhang ML, Wu RZ. Structure stability and mechanical properties of high-pressure die-cast Mg–Al–La–Y-based alloy. *Mater Sci Eng A.* 2012;531:70–75.
- [38] Homma T, Hirawatari S, Sunohara H, Kamado S. Room and elevated temperature mechanical properties in the as-extruded Mg–Al–Ca–Mn alloys. *Mater Sci Eng A.* 2012;539:163–169.
- [39] Miura H, Maruoka T, Yang X, Jonas JJ. Microstructure and mechanical properties of multi-directionally forged Mg–Al–Zn alloy. *Scripta Mater.* 2012;66:49–51.
- [40] Zhang BP, Geng L, Huang LJ, Zhang XX, Dong CC. Enhanced mechanical properties in fine-grained Mg–1.0Zn–0.5Ca alloys prepared by extrusion at different temperatures. *Scripta Mater.* 2010;63:1024–1027.
- [41] Yang CW, Lui TS, Chen LH, Hung HE. Tensile mechanical properties and failure behaviors with the ductile-to-brittle transition of the alpha plus beta-type Mg–Li–Al–Zn alloy. *Scripta Mater.* 2009;61:1141–1144.

- [42] Hou XL, Cao ZY, Wang LD, Xu SW, Kamado S, Wang LM. Microstructure and mechanical properties of extruded Mg–8Gd–2Y–1Nd–0.3Zn–0.6Zr alloy. *Mater Sci Eng A*. 2011;528:7805–7810.
- [43] Liu HB, Qi GH, Ma YT, Hao H, Jia F, Ji SH, Zhang HY, Zhang XG. Microstructure and mechanical property of Mg–2.0Ga alloys. *Mater Sci Eng A*. 2009;526:7–10.
- [44] Zhang BP, Wang Y, Geng L, Lu CX. Effects of calcium on texture and mechanical properties of hot-extruded Mg–Zn–Ca alloys. *Mater Sci Eng A*. 2012;539:56–60.
- [45] Kim WJ, Lee HW, Yoo SJ, Park YB. Texture and mechanical properties of ultrafine-grained Mg–3Al–1Zn alloy sheets prepared by high-ratio differential speed rolling. *Mater Sci Eng A*. 2011;528:874–879.
- [46] Miao Q, Hu LX, Wang GJ, Wang ED. Fabrication of excellent mechanical properties AZ31 magnesium alloy sheets by conventional rolling and subsequent annealing. *Mater Sci Eng A*. 2011;528:6694–6701.
- [47] Zhang JH, Liu K, Fang DQ, Qiu X, Yu P, Tang DX, Meng J. Microstructures, mechanical properties and corrosion behavior of high-pressure die-cast Mg–4Al–0.4Mn–xPr (x = 1, 2, 4, 6) alloys. *J Alloys Compd*. 2009;480:810–819.
- [48] Yang J, Wang LD, Wang LM, Zhang HJ. Microstructures and mechanical properties of the Mg–4.5Zn–xGd (x = 0, 2, 3 and 5) alloys. *J Alloys Compd*. 2008;459:274–280.
- [49] Lim HK, Kim DH, Lee JY, Kim WT, Kim DH. Effects of alloying elements on microstructures and mechanical properties of wrought Mg–MM–Sn alloy. *J Alloys Compd*. 2009;468:308–314.
- [50] Son HT, Lee JB, Jeong HG, Konno TJ. Effects of Al and Zn additions on mechanical properties and precipitation behaviors of Mg–Sn alloy system. *Mater Lett*. 2011;65:1966–1969.
- [51] Xu DK, Liu L, Xu YB, Han EH. The influence of element Y on the mechanical properties of the as-extruded Mg–Zn–Y–Zr alloys. *J Alloys Compd*. 2006;426:155–161.
- [52] Xu DK, Liu L, Xu YB, Han EH. The effect of precipitates on the mechanical properties of ZK60–Y alloy. *Mater Sci Eng A*. 2006;420:322–332.
- [53] Watanabe H, Yamaguchi M, Takigawa Y, Higashi K. Mechanical properties of Mg–Al–Ca alloy processed by hot extrusion. *Mater Sci Eng A*. 2007;454:384–388.
- [54] Yang J, Wang JL, Wang LD, Wu YM, Wang LM, Zhang HJ. Microstructure and mechanical properties of Mg–4.5Zn–xNd (x = 0, 1 and 2, wt%) alloys. *Mater Sci Eng A*. 2008;479:339–344.
- [55] Li B, Yan PF, Sui ML, Ma E. Transmission electron microscopy study of stacking faults and their interaction with pyramidal dislocations in deformed Mg. *Acta Mater*. 2010;58:1730–1739.
- [56] Smola B, Stulikova I, Pelcova J, Mordike BL. Significance of stable and metastable phases in high temperature creep resistant magnesium-rare earth base alloys. *J Alloys Compd*. 2004;378:196–201.
- [57] Sandlobes S, Friak M, Zaeferrer S, Dick A, Yi S, Letzig D, Pei Z, Zhu LF, Neugebauer J, Raabe D. The relation between ductility and stacking fault energies in Mg and Mg–Y alloys. *Acta Mater*. 2012;60:3011–3021.
- [58] Liao XZ, Srinivasan SG, Zhao YH, Baskes MI, Zhu YT, Zhou F, Lavernia EJ, Xu HF. Formation mechanism of wide stacking faults in nanocrystalline Al. *Appl Phys Lett*. 2004;84:3564–3566.
- [59] Zhu YT, Wu XL, Liao XZ, Narayan J, Kecskes LJ, Mathaudhu SN. Dislocation-twin interactions in nanocrystalline fcc metals. *Acta Mater*. 2011;59:812–821.