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S. No	Volume-9 Issue-5, March 2020, ISSN: 2278-3075 (Online) Published By: Blue Eyes Intelligence Engineering & Sciences Publication		Page No.
1.	Authors:	Hitesh V. Paghadar	1-4
	Paper Title:	Reduction of Harmonics Cause of Inrush Current for Transformer	
2.	Authors:	Avinash Burthare, Mukesh Pandey, Sohit Agarwal	5-8
	Paper Title:	Effect on Quality of Cement-Mortar by Inclusion of Nano Particle of Zinc Oxide	
3.	Authors:	Jana Shafi, P. Venkata Krishna	9-13
	Paper Title:	Machine Learning Models Predicting the Survival of Abrupt Heart Attack in Cardiac Sarcoidosis Disease using the Wearable Device	
4.	Authors:	Ravneet Kaur Sidhu, Ram Krishan	14-21
	Paper Title:	Security Threat of MANET: A Comprehensive Architecture	
5.	Authors:	Sweta S Panchal, Ved Vyas Dwivedi, Jayesh P Pabari	22-27
	Paper Title:	Development of Underwater Acoustic Channel Model for Wireless Sensor Network in Tank	
6.	Authors:	Sudeep D. Thepade, Rohan Awhad, Prakhar Khandelwal	28-34
	Paper Title:	Image Retrieval with Fusion of Thepade's Sorted Block Truncation Coding n-ary based Color and Local Binary Pattern based Texture Features with Different Color Places	
7.	Authors:	Madan Lal, Yantish Dev Jha, Haris Alam Zuberi	35-38
	Paper Title:	A Two Phase Mathematical Model of Fluid Flow through Bell Shaped Stenotic Artery	
8.	Authors:	Tejashwini N, D R Shashi Kumar, K Satyanarayana Reddy	39-45
	Paper Title:	Novel Framework for Maximizing Security over Wireless Network	
9.	Authors:	Shashikala S V, Ravikumar G K	46-52
	Paper Title:	Design and Development of Efficient Multipath TCP using GMM clustering for Big Data in Public Cloud Data Center	
10.	Authors:	Sfenrianto, Raden Aditya Bayu Pratama, Arie Handoko, Bagus Afan Herlambang	53-57
	Paper Title:	Usability and Quality Information in Pedulisehat.id CRM using Chatbot	
11.	Authors:	Derick Mathew, Chinnappa Naidu Rani	58-63
	Paper Title:	One Cycle Controlled Single–Stage Transformerless Buck-Boost Inverter	

12.	Authors:	Anita Sahoo, Tusharkanta Samal, Ambarish Panda, Keshar Kumari	64-69
	Paper Title:	Prioritized data based Energy Efficient MAC protocol in Wireless Body Area Network	
13.	Authors:	A.Meenakshi, M.Nivetha, P.Vigneshwari, M.Vijayakumari, K.Kumar	70-72
	Paper Title:	Automatic Fish Feeder System	
14.	Authors:	Kovuru Vijaya Kumar, Ch GVN Prasad	73-79
	Paper Title:	Software Defect Prediction using Support Vectorised Data and Intelligent Techniques	
15.	Authors:	G.Ramesh, V. Ranjith Babu, K. Kannan	80-86
	Paper Title:	Simultaneous Placements of TCSC and VSCDG for Congestion Management	
16.	Authors:	Dibyendu Barman, Md. Bakash Ahamed	87-92
	Paper Title:	Improved LZW Compression Technique using Difference Method	
17.	Authors:	Alanoud Alsudairy, Ahmed Alsanad, Ahmed Emam	93-100
	Paper Title:	Improving Solution Architecture of Internet of Things to Support a Successful Implementation of Digital Transformation in the Context of 2030 Vision of Saudi Arabia	
18.	Authors:	Amr A. Elbanna, Sherif S. Safar, Mokhtar M. Seddik	101-109
	Paper Title:	Column Stiffness Requirements for Diagonally Stiffened Steel Plate Shear Walls	
19.	Authors:	S.Saravanan, M.Saravanan, D.Jeyasimman, S.Vidhya, M.Vairavel	110-115
	Paper Title:	Experimental Prediction of Spring back in U Bending Profile Process Modeling using Artificial Neural Network	
20.	Authors:	S.Saravanan, M.Saravanan, D.Jeyasimman, S.Vidhya, M.Vairavel	116-122
	Paper Title:	Art of Single Step Analytical Analysis for Springback Formation in "U" Bending Forming Process	
21.	Authors:	Yogapriya. J, Dhivya. S, Suvitha. K	123-129
	Paper Title:	Convolutional Neural Networks in Image Retrieval System	
22.	Authors:	Kanchan Bala, Pawan Thakur	130-135
	Paper Title:	Novel Security Mechanism against DDoS Attack in Mobile Wireless Sensor Network	
23.	Authors:	Guduri Sulakshana, R Siva jyothi, Aluri Lakshmi	136-139
	Paper Title:	Detection of Hate Speech and offensive Language on Sentiment Analysis using Machine Learning Techniques	
24.	Authors:	Susmita Nath, Rajiv Tiwari, Sougata Karmakar	140-142
	Paper Title:	Prevalence of Musculoskeletal Disorders among Stone Polishing Workers using Stone Polishing Devices in Unorganized Sector of Guwahati (India)	
25.	Authors:	Premakumar MN, Ramesh S	143-148
	Paper Title:	Efficient Temporal-key Based Encryption Mechanism for WSN-ETEM	
26.	Authors:	Peerzada Fayaz, Brahmjeet singh	149-154
	Paper Title:	Utilization of Waste Rubber Tyres as an Ingredient in Concrete Mixes	
27.	Authors:	Natassya Afdalena Triany, Sani M. Isa	155-161
	Paper Title:	Sentiment Classification from Social Media for Stock Prediction with Data Mining	
28.	Authors:	Regidi Suneetha, P.V Sridevi	162-165
	Paper Title:	Recent Trends in Bio-Medical Textile Antennas	
29.	Authors:	B.Rajesh, P.Srinivas, K.Premsagar, P.Prashanthi Reddy, M.Akhila	166-168
	Paper Title:	IC 741 and IC AMP02FP Based Signal Conditioning Circuit for Electrostatic Sensor using Multisim	
30.	Authors:	Saravanan M, Rajeev Sukumaran, M.R. Christhuraj, Manikandan TT	169-173
	Paper Title:	Stochastic Network Calculus for Delay Variation in UWAN Multichannel Communication	
31.	Authors:	Maninder Singh, Sanjeev. K. Sharma, Suresh. K. Chadha	174-179
	Paper Title:	Effect of Supply Chain Integration on Companies' Competitive Advantage	
32.	Authors:	Kevin Angriawan, Rahmat Ivan Aziz, Teguh Sugiyono, Sfenrianto Sfenrianto	180-186
	Paper Title:	Designing E-learning Application to Enhance Education Effectiveness for PELNI	

		Medical Center	
33.	Authors:	Basharat Nabi, Anuj Sachar, Manish Kaushal	187-194
	Paper Title:	Effect of the Partial Replacement of Cement with Microsilica and Coarse Aggregate with Crushed Ceramic Tiles on the Properties of Concrete	
34.	Authors:	Kanav Sadawarti, Satish Saini	195-199
	Paper Title:	Machine Learning Based Efficient and Secure Storage Mechanism in Cloud Computing	
35.	Authors:	R. Naga Jyothi, M. Monish Sai, S. Suryanarayana, Venkata Ratnam Kolluru, Rajendraparasad Narne	200-203
	Paper Title:	Development of IoT Based and Wi-Fi Controlled Communication Robot by using Node MCU	
36.	Authors:	Shivaprasad Martha, Sandeep Kumar V	204-210
	Paper Title:	Massive MIMO User Location Based Pilot Allocation in Massive MIMO Systems	
37.	Authors:	Alok Jain, Renu Jain, D. K. Jain	211-214
	Paper Title:	Development of Quantum Hartley Transform for Signal Processing Applications	
38.	Authors:	Sushil Kumar Gupta, Sanjay Kumar, Rhea Srivastava, Chelliboyina Prasanna Lakshmi,Megha Raj Lakshmi	215-220
	Paper Title:	Voltage Stability Augmentation using Shunt FACTS	
39.	Authors:	Chaitanya Mishra, Tanveer Ahmed Kazi	221-223
	Paper Title:	Effect of MS Rings' Confinement on Lateral Deformations of M 25 Grade Circular RCC Columns under Axial Compression Loads	
40.	Authors:	Sanjay Singh, M Prabhahar	224-231
	Paper Title:	Combustion and Emission Characteristics of Algae Oil Fuelled VCR Engine with Thermal Barrier Coated Piston	
41.	Authors:	Mukhitdinova Firyuza Abdurashidovna, Kutybaeva Elizavetta Duysenbaevna, Daumenov Berdakh Aitmuratovich, Ismailova Dilfuza	232-238
	Paper Title:	Spiritual and Practical Factors of the Institution of Elections and Electoral Law Reforms in Uzbekistan	
42.	Authors:	Sri Sumarwati, Mohd Hasril Amiruddin, Badaruddin Ibrahim	239-244
	Paper Title:	Problems Faced by Post-Graduate Students During the Research Process	
43.	Authors:	Ana A., Ismail A., Kustiawan I., Meirawan D., Nugraha E.	245-250
	Paper Title:	Job Specifications during the Era of Disruption and Industry 4.0	
44.	Authors:	Saripudin S., Sumarto, Juanda E. A., Ade Gaffar Abdullah, Ana A.	251-260
	Paper Title:	Integration of ICT Skill Among Vocational School Teachers: A case in West Java, Indonesia	
45.	Authors:	B. Mabu Sarif, D. V. Ashok Kumar, M. Venu Gopala Rao	261-265
	Paper Title:	Design of IMC Tuned PID Controller for First Order Process with No Delay	
46.	Authors:	Md. Ashaf Uddaula, Md. Al - Amin Hossain, Md. Khalid Hossen, Ahmed Al Marouf	266-274
	Paper Title:	Implications of Meta Classifiers for Onset Diabetes Prediction	
47.	Authors:	A. Vanitha, S. Aruna, N.Balakrishnan	275-278
	Paper Title:	A Comprehensive Method on Fog Computing using Internet-of-Things	
48.	Authors:	Renuka Makwana, VedVyas Dwivedi, Prarthan Mehta	279-283
	Paper Title:	Dielectric Resonator Rectenna System using Full Wave Rectification Configuration	
49.	Authors:	R.Suresh, A.Ahamed Jasim, O.R.Amal Nagdev, B.Binny Sabin, V.Nagaraj, D.Jeyasimman	284-287
	Paper Title:	Design and Analysis of Remotely Amphibious Drone	
50.	Authors:	Radhika A, Priya G	288-297
	Paper Title:	Systematic Methods on Machine Learning Techniques for Clinical Predictive Modelling	
51.	Authors:	G. Jamuna Rani, Y.V. Hanumantha Rao, B. Balakrishna	298-302
	Paper Title:	Influence of Madhuca Longifolia Biodiesel Blends on Diesel Engine Characteristics	
52.	Authors:	Valentyna Praslova, Yuliia Riabets, Viktoriia Shchurova, Olena Zinovieva, Maryna Harbar	303-312
	Paper Title:	Functional Organization of Extraterrestrial Underground base on Mars	

53.	Authors:	A. Kurbanov, A.Turdiev, Z.Amanov, X.Kurbanov, S.Yadgarov	313-315
	Paper Title:	Development of a Technological Image of a Stone Crushing Machine	
54.	Authors:	Akhmetov Adilbek Agabekovich, Akhmedov Sherzodbek Anvarhon ogli, Botirov Ravshan Mahkam ogli, Kambarova Dilfuza Usmonaliyevna	316-319
	Paper Title:	Pressure on the Soil of the Front Wheels of Tractors with Different Wheel Formulas	
55.	Authors:	M.J. Nikhitha, P. Bharat Kumar, P. Sujatha	320-327
	Paper Title:	Harmony Search Algorithm Based Control of DFIG Wind Energy System in Multi Machine Power Systems	
56.	Authors:	Shulzhenko Sergey Nikolayevich, Fedorovich Anton Sergeevich, Kashukoev Kantemir Zhiraslanovich, Avenyan Artur Varuzhanovich, Sukharenko Kirill Andreevich, Petrova Katerina Valer'evna	328-332
	Paper Title:	Laboratory Examination of the Hydrogeological Conditions for the Preparation of Project Documentation for the Construction of an Apartment Building	
57.	Authors:	P.E.H.Ab. Rahman, A. Zainal, R. Hassan	333-336
	Paper Title:	Withdrawal Performance for Different Embedment Depths of Dowel Made from Chengal Species	
58.	Authors:	B. Pruthvi Raj Goud, S. Sravan Reddy, K. Praveen Kumar	337-342
	Paper Title:	Smart Attendance Notification System using SMTP with Face Recognition	
59.	Authors:	Rehan Ullah Khan, Saleh Albahli, Waleed Albattah, Mohammad Nazrul Islam Khan	343-349
	Paper Title:	Software Defect Prediction Via Deep Learning	
60.	Authors:	Yasir Karim, Saif A Khan, D.K.Sharma, Ravindra Gautam, Sanjeev Singh	350-357
	Paper Title:	Analysis of Concrete Made from Natural and Recycled Aggregate from Hardened Concrete	
61.	Authors:	Sunil V. Prayagi, Nischal P. Mungle, Mahendra P. Nimkar	358-359
	Paper Title:	Performance on Buoyancy Driven Flow in Square Duct Fitted with Twisted Strip	
62.	Authors:	Parmanand Prabhat, Syed Umar	360-363
	Paper Title:	Open-Cloud Computing Platform Design based on Virtually Dedicated Network and Container Interface	
63.	Authors:	Divyanshi Tyagi, Divyansh Khare, Disheak Ahlawat, Mansi, Gaurav Yadav	364-366
	Paper Title:	Analytical Look - Transparency in Online Informative Technology	
64.	Authors:	Sumitra Mallick, Mrutyunjaya Panda	367-371
	Paper Title:	A Taxonomy for Mental Illness in Healthcare System	
65.	Authors:	Rahul Kumar Singh, Mohd Ziaulhaq	372-376
	Paper Title:	A Work on Welding Productivity and Economy for Smaw & Fcaw Processes	
66.	Authors:	M.Aswini, P.Anukarthika, V.Nivedha, V.Poorani, M.Gengaraj, L.Kalaivani	377-381
	Paper Title:	Harmonics Mitigation Techniques in Renewable Energy Systems using Shunt Active Power Filter	
67.	Authors:	Shekhar Yadav, Komal Jaiswal, Dheeraj Kumar, Rajeev Singh	382-388
	Paper Title:	Ultra-Wideband Compact Microstrip Patch Antenna for C, X and K-band Applications	
68.	Authors:	V.Vanitha, D.Magdalin Mary, G.Sophia Jasmine, Akhil Balagopalan	389-391
	Paper Title:	Adaptive Neuro-fuzzy Inference System Based Short Term Wind Speed Forecasting	
69.	Authors:	P.Pujithsai, O.Goutham Sai, Varshith, Bagubali A	392-394
	Paper Title:	Density Controlled Traffic Lights System using Aurdino Mega 2560	
70.	Authors:	Kalpesh Borse, Prasit G. Agnihotri	395-398
	Paper Title:	Trends of Rainfall, Temperature and Rice Yield of Nashik Region of Maharashtra	
71.	Authors:	Liza M Kunjachen, Mhd Faheem Khan, Piyush Kumar, Rahul Ranjan, Snch Pallav	399-403
	Paper Title:	Dynamic & Intelligent Student Attendance Maintenance Based on Face Recognition	
72.	Authors:	J P Sridhar, R Prakash	404-411
	Paper Title:	Statistical Assessment of Whale Optimization Algorithm for Sizing and Placement of DG Considering Multi-Objective Function with PSO and CSA Algorithm	
73.	Authors:	Lina Storozhenko, Oksana Sheremeta, Svitlana Petkun, Inna Vanovska	412-418
	Paper Title:	Pedagogical Innovation and Methodology of Education in the Field of Information	

		and Communication Education in Ukraine	
74.	Authors:	Cho Do Xuan, Tisenko Victor Nikolaevich, Do Hoang Long, Nguyen Vuong Tuan Hiep, Le Quang Sang	419-424
	Paper Title:	Developing Apt Attacks Detection System Based on Correlation Analysis Methods	
75.	Authors:	Parvinder Singh, Rajeshwar Singh	425-431
	Paper Title:	Research Trends in Energy-Efficient Routing Protocols for Wireless Sensor Network	
76.	Authors:	S. Jamuna, K. Mohan Kumar	432-438
	Paper Title:	Computational way of Classifying Thyroid Disorder Patients and Identifying the Similar Patients using a Novel Method	
77.	Authors:	Mohammad Kanan	439-449
	Paper Title:	Quality Function Deployment: Comprehensive Framework for Patient Satisfaction in Private Healthcare Sector	
78.	Authors:	Gudlavalleti Deepak Kumar, B. Ananth Sreecharan, T. Sai Kiran, S. S. Sai Sandeep, Mouli. S	450-454
	Paper Title:	Design and Fabrication of an Automatic Water Hyacinth Removal and Prevention Machine	
79.	Authors:	Sanjay Motia, SRN Reddy	455-469
	Paper Title:	ICT Driven Decision Support & Information Dissemination (DSID): A Comprehensive Technical Appraisal of DSID Systems in Indian Agriculture	
80.	Authors:	Abdin, Hunaidah, Luh Sukariasih, Amiruddin Takda, La Sahara	470-477
	Paper Title:	Technology of Physics Learning Media Based on Software Macromedia Flash to Enhance Problem Solving Capability in Passive Electronics Topics	
81.	Authors:	Kavita Rani, Avinash Jethi	478-482
	Paper Title:	Implementation and Analysis of IP Tunnel in Virtual Private Networks	
82.	Authors:	Madhu M. Nayak, Sumithra Devi K. A.	483-487
	Paper Title:	A Systematic Analysis of Big Image Data Methodologies in Various Applications	
83.	Authors:	Mary N Peter, Pushpa Rani	488-494
	Paper Title:	Advanced Traffic Management System using A Fuzzy Logic Controller to Differentiate Parking Vehicle and Moving Vehicle	
84.	Authors:	Raghavendra Vijay Bhasker Vangara, Kailashnathan Thirupathur, Shiva Prasad Vangara	495-498
	Paper Title:	Opinion Mining Classification using Naive Bayes Algorithm	
85.	Authors:	R.Muthuminal, M.N.A.Gulshan Taj	499-505
	Paper Title:	Behaviour of Steel Transmission Line Towers under Earthquake Loads using Labview	
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	Paper Title:	Driver Drowsiness Detection System Based on Eyes, Mouth and Head Tilt	
87.	Authors:	Boobalan S C, Abirami P, Indhu K	512-516
	Paper Title:	Numerical Examination of Reinforced Concrete Skew Slabs	
88.	Authors:	Purnima Sai Koumudi Panguluri, Kishore Kumar Kamarajugadda	517-520
	Paper Title:	Image Generation using Variational Autoencoders	
89.	Authors:	Amani Al Tamseh, Eslam Al Karabsheh, Salam AL Kasassbeh	521-527
	Paper Title:	Traffic Demands Policies Effect on Congestion, Delay and Fuel Consumption	
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	Paper Title:	Automated Heart Dysfunctionality Identification Based on Iris using Deep Learning	
91.	Authors:	Shariq Haseeb, Aisha Hassan A. Hashim, Othman O. Khalifa, Ahmad Faris Ismail	532-539
	Paper Title:	Performance Analysis of Constrained Device Virtualization Algorithm	
92.	Authors:	Husain Bhaldar, Sanjay Kumar Goware, Mahesh S Mathpati, Ashish A Jadhav	540-544
	Paper Title:	Design of High Gain Wearable Rectangular Microstrip Textile Antenna for Wireless Application	
93.	Authors:	Sheetal Phatangare, Gayatri M.Bhandari, Yogesh Sharma	545-550
	Paper Title:	New Algorithms for Secure Outsourcing of Large-Scale Systems of Linear Equations	
94.	Authors:	P. Pooja, Geetanjali Chandam, Yanchen Oinam, Pratheeba Paul	551-

	Paper Title:	Carbon Sequestration by Curing in Concrete	553
95.	Authors:	K. Srividya, M. Radha Devi, M.Nagaswapnasri, J.Surendra, P.Anuroop	554-558
	Paper Title:	Automobile Radiator's Engineering and Analysation	
96.	Authors:	P.Manjula, P.Sundararajan	559-565
	Paper Title:	Applications of Fuzzy dot i* algebra in Computer Vision	
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	Paper Title:	Inverse of K Regular Super Fuzzy Matrix	
98.	Authors:	K. Akilandeswari, G.Anwar Basha, L. Baranivel	571-576
	Paper Title:	A Three-Stage Botnet Detection Technique using Random and Obrazom Graphs	
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	Paper Title:	Health Service Recommendation as Per Citizens Requirement using Machine Learning and Data Mining	
100.	Authors:	B.Hemanth Kumar Reddy, V.parthipan	582-589
	Paper Title:	Implementation of Novel Methodology using Secured Accessibility of Data's using Public and Private Key Verification Process with Steganography	
101.	Authors:	Ragul R, Arokia Paul Rajan R	590-593
	Paper Title:	Efficient Horizontal Scaling of Databases using Data Sharding Technique	
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	Paper Title:	Driver Drowsiness Detection System Based on Eyes using Canny Edge Detection Algorithm	
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	Paper Title:	Automated Gross Cutting in Farming Sector using Robotics and IOT	
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	Paper Title:	Behaviour of Different Nanomaterials in Geopolymer Concrete	
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	Paper Title:	Frequent Itemset Mining in a Unique Scan using Transaction Database	
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	Paper Title:	Analysis of Statements of Software Based on the Prioritization Strategy of Test Cases	
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	Paper Title:	Computer Vision-based Plant Leaf Disease Recognition using Deep Learning	
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	Paper Title:	Secure Multiparty Equality Check Based on Homomorphic Cryptosystem	
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	Paper Title:	An Optimal Receive Antenna Selection Algorithm using GA in MIMO Communication System	
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	Paper Title:	Detection and Recognition of Paddy Plant Leaf Diseases using Machine Learning Technique	
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	Paper Title:	Application of Drones in Agriculture domain	
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	Paper Title:	Influence of Various Temperatures on the Drying Time of 220/66 KV Transformer Insulations in Vapour Phase Drying Process	
113.	Authors:	Poorva Sinha, Kakelli Anil Kumar	652-659
	Paper Title:	RESTAPIs for Emerging Social Media Platforms	
114.	Authors:	Preeti Prasada, Patti. Haritha	660-662
	Paper Title:	Durable Motion Detection System using Node MCU	
115.	Authors:	S.M.F.D Syed Mustapha, Abdulmajeed Alsufyani	663-668
	Paper Title:	Automated Ontology Building for News Text using Associative Word Properties	

116.	Authors:	Kaushik Adhikary, Shashi Bhushan, Sunil Kumar, Kamlesh Dutta	669-675
	Paper Title:	Decision Tree and Neural Network Based Hybrid Algorithm for Detecting and Preventing Ddos Attacks in VANETS	
117.	Authors:	Noureddine Skik, Ahmed Abbou, Rafika El idrissi	676-684
	Paper Title:	Integral Backstepping Control of Three-phase Grid-Connected Photovoltaic Systems for Power Optimization	
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	Paper Title:	Urdhva Tiryak Sutra Based Ancient Multiplication in Reversible Logic Circuits	
119.	Authors:	Dhwani Brahmbhatt, Yogesh Parmar	698-701
	Paper Title:	MATLAB Simulation and HDL Implementation of DVB-S2 Modulator	
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	Paper Title:	Smart Electric Heating Device	
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	Paper Title:	The Modeling Framework for the Need of Training Ship on Maritime Vocational Education	
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	Paper Title:	Secure Fault Diagnosis for Framework on Chip Design and Testing	
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	Paper Title:	Smart Forest Farming using Iot	
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	Paper Title:	Various Algorithms & Techniques Driving Data Science for Big Data	
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	Paper Title:	Interconnected IoT Architectural Platforms and Applications	
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	Paper Title:	Three Level Inverter Controlled UPFC for Harmonic Reduction using Space Vector Pulse Width Modulation Technique	
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	Paper Title:	Software Defined Networking Based Protection against DDOS in IoT	
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	Paper Title:	Mind Mapping Method as an Effective Tool for Teaching Database Course	
129.	Authors:	Hesham Abusaimeh	751-757
	Paper Title:	Security Attacks in Cloud Computing and Corresponding Defending Mechanisms	
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	Paper Title:	Automatic Toothbrush for Specially-Abled Patients	
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	Paper Title:	Promising Methods for Treating Colored Wastewater in Light Industry Enterprises	
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	Paper Title:	Security Enhanced Model for Cloud Data Based on Dynamic Data Fragmentation and Replication (DDFR)	
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	Paper Title:	Advanced Improvement in Speed of Operation of 3-Stage CMOS Ring Oscillator Clock Generation using CPG	
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	Paper Title:	Strategies and Quality Guidelines for Effective User Interface Design	
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	Paper Title:	Smart Run Time Electricity Bill Calculation using LabVIEW	
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	Paper Title:	Forecasting Traffic Congestion and Traffic Reduction using Big Data Analytics	

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	Paper Title:	Measurement of the Effect of Controlling Parameters on Performance of Abrasive Jet Machine	
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	Paper Title:	Implementation of MODWT on Real Time Power Quality Disturbance Signal	
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	Paper Title:	Improved Data Hiding Scheme using VQ based Index Map Compression and Codebook Extension	
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	Paper Title:	Cardiovascular Disease Prediction and Classification using Modified Teaching Learning Optimization Method	
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	Paper Title:	Design of Spectral Filters Based on Linear Polarized Mode Coupling of Optical Fibers	
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	Paper Title:	Gh24 Bio Generator Power Generating Device	
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	Paper Title:	Analysing Delays of Construction Projects in Western Part of Mumbai: Causes and Effects	
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	Paper Title:	Real Time Detection of Small Objects	
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	Paper Title:	Brain Tumor MRI Image Segmentation and Noise Filtering using FCNN	
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	Paper Title:	Design of Semi-Automatic Coconut Dehusker for Small Scale Farmers	
147.	Authors:	Sipali Pradhan, Jitendu Kumar Mantri, Sujogya Mishra, P. K. Pattnaik	853-855
	Paper Title:	Mathematical Modelling for Prediction and Classification of Neonatal Infections by using Rough Set	
148.	Authors:	Abdulaziz S. Alaboodi, Mohammad S. Alshitawi, Ayman F. Omar, Abdulaziz B. Alharby	856-861
	Paper Title:	Air Quality in Buraydah, Saudi Arabia	
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	Paper Title:	Process Parameter Optimization in EDM using Heat Treated Al Tool and without Heat Treated Al Tool	
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	Paper Title:	Validating a Big Data for Data Quality using Single Column Data Pattern Profiling Technique	
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	Paper Title:	Newspaper Article Classification using Machine Learning Techniques	
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	Paper Title:	Image Steganography: Critical Findings through Some Novel Techniques	
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	Paper Title:	Utilisation of Seasand as Partial Replacement of Fine Aggregrate to Strengthen the Concrete	
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	Paper Title:	Human Computer Interaction Based on Hand Gesture	
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	Paper Title:	Rooftop Solar and Wind Power Based Hybrid Energy Storage System for AC Railway Traction	
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	Paper Title:	Elementary Analysis of Bhasmas used as Ethnomedicine in Tribal Areas of	

		Mayurbhanj Districts of Odisha, India	
157.	Authors:	Zahari Md Rodzi, Abd Ghafur Ahmad	909-916
	Paper Title:	Fuzzy Parameterized Hesitant Fuzzy Linguistic Term Soft Sets (FPHFLTSSs) in Multi-Criteria Decision Making	
158.	Authors:	Chayan Paul, Pronami Bora	917-921
	Paper Title:	Digit Speech Recognition using Hidden Markov Model Toolkit	
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	Paper Title:	A Framework for Predicting Drug Target Interaction Pairs Through Heterogeneous Information Fusion	
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	Paper Title:	Design of a Harmonic Filter for a Grid Connected Doubly Fed Induction Generator under Unsymmetrical Fault Conditions	
161.	Authors:	Renu Nagpal, Parminder Singh, B. P. Garg	937-943
	Paper Title:	Swine Influenza Mimicked Optimization (SIMO)	
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	Paper Title:	Route Inference Based Sinkhole Attack Detection System for Mobile Ad Hoc Networks	
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	Paper Title:	Design and Implementation of Low Power Delay Locked Loop using Multiplexer Based Phase Frequency Detector	
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	Paper Title:	Predicting Student Failure in University Examination using Machine Learning Algorithms	
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	Paper Title:	An Adaptive Arbitration Technique with 4x4 Mesh Topology for Low Area and High Speed NOC Design	
166.	Authors:	Archana P. R., Nisha T. P., Leya Elizabeth Sunny	966-972
	Paper Title:	Semantically Enhanced Information Retrieval System	
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	Paper Title:	A Machine Learning Framework for Profitability Profiling and Dynamic Price Prediction for the New York City Taxi Trips	
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	Paper Title:	Solution for the Problems in RADAR Systems from SNR Gain Expressions and Blackout Likelihood Detection for Aviation Systems	
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	Paper Title:	Reducing Cost of Walking with Fused Deposition Modelling Rendering Point Cloud Data	
170.	Authors:	Mark Mikhail, Mahdi Keramatikerman, Amin Chegenizadeh, Sergei Terzaghi, Geoffrey Burns, Hamid Nikraz	987-990
	Paper Title:	Influence of Bagasse Ash on Compaction Behvaiour of Soil	
171.	Authors:	A. Raj Kumar, J. Y. V. Shiva Bhushan	991-994
	Paper Title:	Slope Stability Analysis of Recycled Concrete Fine Aggregate Stabilized and Blended Soils	
172.	Authors:	Shakthi Murugan K. H., Sumathi M.	995-998
	Paper Title:	Performance Analysis of Millimeter waves over FSO System under Fog Weather Conditions	
173.	Authors:	Tanmay Jain, Ayush Raina, Boominathan P	999-1003
	Paper Title:	Round Robin Load Balancer for Node Swarm Clusters Running a Chatting Service on the Cloud	
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	Paper Title:	Modeling and Analysis of Piston using Various Piston Crown Geometries	
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	Paper Title:	Butterfly Shaped Printed Monopole Antenna for Ultra Wide Band Applications	
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	Paper Title:	Aspect Based Sentiment Analysis for E-Commerce Websites with Visualization through Machine Learning Algorithm	

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	Paper Title:	Assessment of Performance of Students using Conditional Statistical Technique	
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	Paper Title:	Analytical Design of the Dis Architecture: The Hybrid Model	
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	Paper Title:	Erdos – Renyi Random Graph and Machine Learning Based Botnet Detection	
180.	Authors:	Dipen Paul, Poorva Pitke, Purva Karmarkar	1041-1046
	Paper Title:	Techno-Economic Feasibility of Wind Power Farms in India	
181.	Authors:	Vandana Dhawane, Rajankumar Bichkar	1047-1053
	Paper Title:	Automatic Generation Control using Genetic Algorithm Based PID Controller	
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	Paper Title:	Anoniv Chat: A Cloud-Based Ios Application for Communication without Revealing the Identity	
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	Paper Title:	Compressing Effort and Schedule in ERP Implementations with Iterative Methodologies : Few Industrial Cases	
184.	Authors:	T.Chandralekha, S.Abinaya, Anshu Rathour, Arthi Mahalakshmi, Chinnerikuppam Heema	1068-1071
	Paper Title:	Detection of Aflatoxin in Food Products using UV Fluorescence Spectroscopy	
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	Paper Title:	Modification of Polymer Wastes and Obtaining Com Composites Based on Them Annotation	
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	Paper Title:	Forecasting Insurance and Patient Charges using Linear Regression	
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	Paper Title:	Building a Model of an Information Management System for Multilevel Organizational Structures	
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	Paper Title:	Throughput Enhancement of Continuous Time Replication Strategy using Multicast GALS in NoCs	
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	Paper Title:	Correlative Analysis of EZW and SPIHT Compression Algorithms using Seven lets Wavelet Technique	
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	Paper Title:	Analysis of Position Based Routing Vanet Protocols using Ns2 Simulator	
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	Paper Title:	Length Biased Weighted Quasi Gamma Distribution with Characterizations and Applications	
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	Paper Title:	Mechanical Properties of Ceramic Waste as an Alternative Material of Concrete Aggregate	
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	Paper Title:	Swarm Intelligence Based Algorithm for Efficient Routing in VANET	
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	Paper Title:	Secure Handshake Hybrid Secured Algorithm for Acceleration-Based Pairing Mechanism in Wrist Worn Devices	
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	Paper Title:	Novel Supervised Learning Scheme for Optimizing the Classification Performance of Breast Cancer MRI	

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	Paper Title:	Particle Swarm Optimization and Texture Analysis Image Processing Techniques using MRI Images to Detect Brain Tumor in Human	
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	Paper Title:	Development of Geoinformation Technology for Monitoring Events on the Basis of Data from Unstructured Web Resource Text	
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	Paper Title:	Performance and Efficiency Features of Bin Model Solar Instant Water Heater using Copper Plate Collector	
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	Paper Title:	HR Analytics using R-Machine Learning Algorithm: Multiple Linear Regression Analysis	
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	Paper Title:	Emission and Combustion Characteristics of Biodiesel with Dee Additive and Thermal Barrier Coated Piston	
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	Paper Title:	Inlet Swirl and Dump Gap Effect on Static Pressure Recovery in Dump Diffuser-Combustor using Two Equation Turbulence Model	
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	Paper Title:	Hand Gesture to Speech and Text Conversion Device	
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	Paper Title:	Fly Ash Effects on Fresh Concrete	
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	Paper Title:	Automatic Table Cleaning Robot	
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	Paper Title:	Torque Enhancement of Switched Reluctance Motor with Teethed Stator Pole	
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	Paper Title:	Driving License Corroborator using Internet of Things and Data Mining Techniques	
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	Paper Title:	Thermal Analysis of Steam Power Plant of High Capacity	
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	Paper Title:	Improving Missing Value for Distributed Database using SMOTE and Random Forest Technique	
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	Paper Title:	Automatic Bar Bending Machine using Pneumatic System	
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	Paper Title:	Consumer Credit Risk Analysis using Data Mining Clustering and Business Intelligence Solutions	
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	Paper Title:	The Prediction of Heart Disease using Machine Learning Technique	
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	Paper Title:	Modeling Method for Leveraging Data Quality in Healthcare Big Data	
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	Paper Title:	Minimization of SIDELOBE Attenuation and Power of a Fir Low Pass Filter using FRFT and CSD Algorithm	
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	Paper Title:	SFRA, Detect of Winding Deformation in Power Transformer	
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	Paper Title:	Creating Generative Art through Processing using Heart Rate Sensing	
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	Paper Title:	Biodynamic Response of Femur Bone	
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	Paper Title:	Diabetes and its Complication Prediction using Multi-Task Learning	
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	Paper Title:	Tool Wear Rate on Inconel 718 using W-Powder Mixed Electric Discharge Drilling	
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	Paper Title:	Sustainable Materials -Quarry Waste and Waste Plastic as Fine Aggregate for Improving Elastic Properties of Concrete	
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	Paper Title:	Capacity Level of Extension Worker and Institutional Support in Developing the Capability of Extension Worker to use Information Technology	
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	Paper Title:	The Influence of External Factors on Quantum Magnetic Effects in Electronic Semiconductor Structures	
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	Paper Title:	Structural and Optical Properties of Alcohol, Alcohol-Aqueous and Aqueous Mediums Mediated Zinc Oxide/Copper Oxide (Zno/Cuo) Nanocomposites Synthesized Via Co-Precipitation Process	
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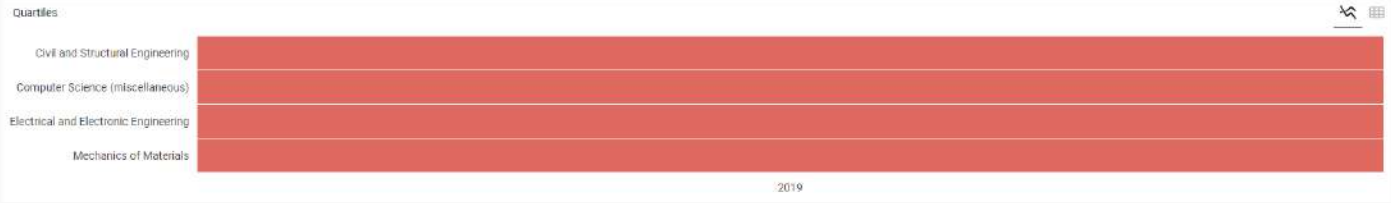

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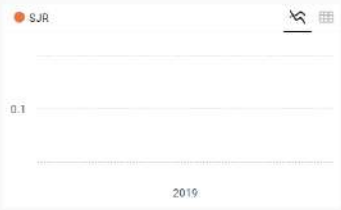

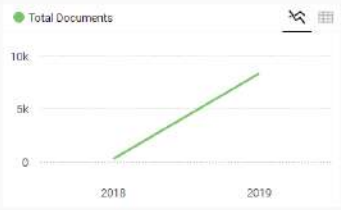

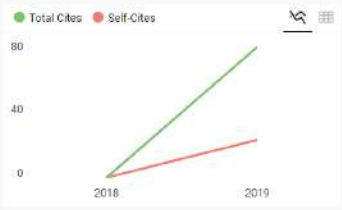

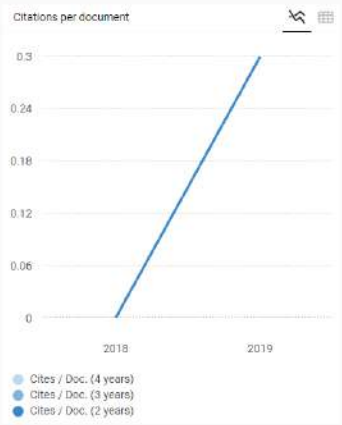

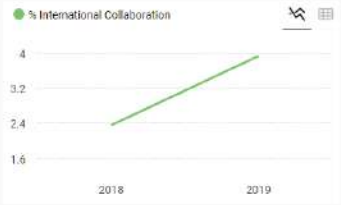

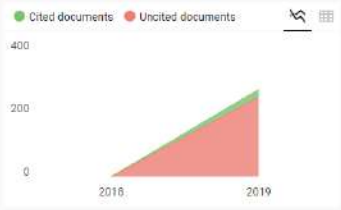

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Mechanical Properties of Ceramic Waste as an Alternative Material of Concrete Aggregate

Muhtar

Abstract*: The increasing building construction in the field of civil engineering that requires supporting materials, starting in terms of human resources and material resources. Progress in the material field must consider energy-saving aspects. Therefore it is necessary to think about the use of useless materials such as ceramic waste. The purpose of this study is to see the potential of ceramic waste as an aggregate in terms of mechanical properties, with the hope of providing an alternative to concrete aggregates other than natural stone aggregates. Ceramic waste aggregate material testing is done by testing: chemical composition, absorption and water content, specific gravity, soundness, abrasion, granular form, gradation, and X-ray diffraction (X-RD). The test results show that the ceramic waste aggregate (CWA) can be used as a concrete aggregate. Ceramic waste aggregate (CWA) characteristics are sufficient to meet the standards as concrete aggregates according to the SII standard, BSI standard, and ASTM standards. While the X-ray diffraction test (X-RD) shows that no element damages concrete, there is no active silica that can react with alkaline cement and is not as a pozzolan.

***Keywords*: Mechanical properties, ceramic waste aggregate (CWA), ceramic concrete.**

I. INTRODUCTION

The increasing development and construction materials industry has an impact on reducing natural resources and environmental pollution. Some important factors that must be considered during building construction such as the level of waste of raw materials and the impact of disposal, renovation, and replacement of building components and their maintenance, and waste treatment during the demolition of the building [1] In the context of promoting sustainable development, the recommended general strategy is to reduce, reuse, and recycle in accordance with aspects of community growth and needs. Waste management and studying the mechanical properties of these waste materials is very important to determine their utilization. Waste recycling is one way to prevent waste materials from entering landfills and reduce supplies sourced from natural resources [2].

Concrete is the main element in the world of construction buildings that continue to dominate until now. Steel is the main material of reinforced concrete derived from fossils that are not renewable and is increasingly depleting its raw material. Concrete aggregate is a concrete material sourced from natural resources and often causes environmental damage due to continuous use. To reduce the depletion of materials originating from natural resources, alternative sources of renewable, energy-efficient, renewable materials must be used, and even the use of waste materials such as ceramic waste. Ceramic waste is a waste that is generated from many sources, including the construction industry waste, building construction waste, and household waste. Ceramic waste is a hazardous waste and causes environmental pollution. Research on the impact of ceramic waste on environmental pollution has been widely carried out, including [3] and [4]. Many opportunities to be researched about reinforced concrete materials including reinforcing materials, cement, fine aggregate, and coarse aggregate. The use of concrete reinforcement material from renewable energy has been widely carried out such as bamboo as a substitute for steel reinforcement for simple construction [5], [6], [7], [21] as well as the use of ceramic waste as concrete material [8], [9], [10], and [22].

Ceramic waste aggregate as a substitute for normal aggregate has been done by Anderson (2016) [2] with the conclusion that the effect of mechanical behavior due to replacement of coarse aggregate varies more than normal concrete, and depends on the mechanical properties of the ceramic waste material used. It is important to understand the influence of the characteristics of different constituent materials on concrete mechanical behavior. Wadie (2017) [11] concluded that recycled ceramic tile aggregates can be used as structural concrete aggregates. Siddique (2019) [12] concluded that concrete with fine bone china ceramic waste aggregate produced concrete that was resilient and durable. Replacement of normal fine aggregate with porcelain ceramic waste aggregate is recommended up to 40% in concrete.

Nepomuceno (2018) [13] evaluates the performance of concrete mechanic using recycled ceramic coarse aggregates from industrial brick waste. The results of his research indicate the feasibility of partial replacement of normal aggregates with aggregates from ceramic waste, although concrete mechanical performance decreases with the increasing replacement of normal aggregates with ceramic waste aggregates. The decreasing performance of concrete [13] indicates a difference in the quality of ceramic waste to the results of other studies that show improved performance. Alireza (2019) [14] concluded that the partial replacement of 40% normal aggregate with ceramic waste aggregate produced optimal mechanical properties and increased compressive strength, tensile strength, and flexural strength by 13%, 15%, and 3%, above normal concrete.

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Muhtar (2019) [15] conducted research on partial replacement of normal aggregate with ceramic waste aggregate showing an optimum value of 55%.

II. MATERIAL AND METHODS

A. Ceramic Waste

The ceramic waste consists of floor ceramic waste, closet, roster, gallon jars, decorative ceramics, and others. ceramic waste is taken from factory waste, household waste, and building waste. The hardness and thickness of ceramic waste vary. The thickness of the ceramic waste is between 5 mm to 10 mm. Then the ceramic waste is milled to a maximum size of 5 mm for fine aggregate, and a maximum of 10 mm for coarse aggregate. Various forms of ceramic waste are shown in Fig. 1 and Fig. 2.

Fig. 1. The production waste

Fig. 2. The household and building waste

B. X-ray diffraction

The main requirement for aggregates is that they should not be alkaline and not react with cement or be pozzolanic. To find out whether the ceramic waste aggregate reacts with the cement, an X-ray diffraction test is performed. The initial step is mashing the ceramic waste aggregate until smooth with a maximum grain size of 0.3 mm. Then, mix the ceramic waste aggregate that has been crushed with enough water to become a concrete mixture. Make to specimens with a size of 5 mm x 5 mm. In comparison, specimens are also made with normal aggregates. Place the test object in a wet or damp room until 28 days old. Finally, the specimens are tested by X-rays after the age of 28 days.

C. Testing Methods

Concrete aggregate material that will be used as an aggregate must go through a series of tests. Testing the mechanical properties of concrete aggregates must be based on applicable standards, such as ASTM, SNI, BSI, and so on. Types of tests conducted on ceramic waste aggregates include chemical composition test, absorption, and water content test based on ASTM C 33-03 [16], specific gravity test based on ASTM C 127 [17], Soundness test based on ASTM C 88-99a [18] and testing of the soundness on ceramic waste aggregates shown in Fig. 3, abrasion test based on ASTM C 131-01 [19] and testing of the abrasion and impact on ceramic waste aggregates shown in Fig.5, granular form test based on BS 812-105.2 [20] and testing of the granular form on ceramic waste aggregates shown in Fig.4, and gradation test based on ASTM C 33-03 [16].

Fig. 3. Testing of the soundness or weathering on ceramic waste aggregates.

Fig. 4. Testing of the granular form on ceramic waste aggregates

Fig. 5. Testing of the abrasion and impact on ceramic waste aggregates.

III. RESULTS AND DISCUSSION

A. Chemical Composition

From the results of chemical tests on the ceramic waste aggregates show that ceramic waste aggregates consist of beneficial and detrimental elements in concrete. Ceramic waste aggregate contains elements Feldspar ($KALSi_3O_8$) and Silicate (SiO_2), both of these compounds are silicate compounds that have high hardness but can cause cracks in concrete and have low tensile strength. Concrete aggregates that contain a lot of silicates cause the concrete to be ductile or brittle, but it has high compressive strength. From the results of the hardness test (abrasion test), it is evident that the ceramic waste aggregate has a relatively small percentage of damage that is 17.88%. Other elements contained in the ceramic waste aggregate include AL_2O_3, CaO, Na_2O, and Fe_2O_3. These elements are oxide compounds commonly found in cement, so they do not have a negative impact on concrete.

B. Water content, specific gravity, and Absorption

Based on Table 1, normal aggregates have greater water content than the ceramic waste aggregate (CWA) which is 4.78% for normal fine aggregate and 3.87% for CWA fine aggregate, 4.03% for normal coarse aggregate and 3.10% for CWA coarse aggregate. This is due to the greater porosity or cavities in the normal aggregate, and is evidenced by the absorption rate of normal aggregates is greater than that of ceramic waste aggregates (CWA). However, this is not fully a reference in determining the water content, because it still depends on the aggregate environment conditions and aggregate conditions when tested, such as wet, dry face and so on.

Absorption of aggregate on the water depends on the pores, if the aggregate has large pores, then absorption will also be large. On absorption examination, the normal aggregate has greater absorption than the CWA aggregate which is 1.58% for normal fine aggregate, 0.51% for CWA fine aggregate, and 3.95% for normal coarse aggregate and 3.01% for CWA aggregate. This is because the normal aggregate pores are greater than the CWA aggregate.

Table-1: Quality data of fine aggregate and coarse aggregate

Measuring parameters	Normal fine aggregate	CWA fine aggregate	Normal coarse aggregate	CWA coarse aggregate
Water content	4.78 %	3.87 %	4.03 %	3.10 %
Specific gravity	2.62	2.26	2.62	2.13
Water absorption	1.58%	0.51%	3.95%	3.01%
Unit weight	1.609 gr/cm^3	1.561 gr/cm^3	1.531 gr/cm^3	1.509 gr/cm^3

For specific gravity testing, normal aggregates have a specific gravity greater than CWA aggregate which is 2.62 for normal fine aggregate, 2.26 for CWA fine aggregate. For normal coarse aggregate specific gravity 2.62 and CWA coarse aggregate 2.13. From the description above it appears that the normal aggregate and CWA aggregates fall into the category of normal aggregates which have a specific gravity between 2-2.7. But for the CWA aggregate, it is quite light in the normal aggregate category because the normal aggregate ranges from 2.5-2.7.

C. Soundness

This test aims to estimate the level of soundness when subjected to weathering action in concrete or other applications. The nature of the aggregate resistance to the influence of weather is called weather resistance or eternal shape. This property is an indication of the aggregate ability to withstand excessive volume changes caused by changes in environmental conditions, such as freezing, thawing, temperature changes, the rainy season, alternating dry seasons and so on.

Table 2 shows data from research results based on the ASTM C 88-99a [18], standard, namely by immersing ceramic waste aggregates in a solution of magnesium sulfate ($MgSO_4$). The percentage of weathered aggregate is 1.484%. This shows that the aggregate of CWA can be used as a concrete aggregate because it meets the ASTM standard of maximum weathering of 18%.

Table-2: Data of soundness test results

Specimens	Weathered aggregate (%)	Average (%)
I	1.10	
II	2.15	
III	1.50	1.484
IV	0.80	
V	1.87	

D. Abrasion and impact

Aggregate hardness is important for concrete materials because aggregate hardness greatly affects the strength of the concrete, especially its compressive strength. Hardness testing is carried out based on ASTM C 131-01 [19] standard, namely by using the Los Angeles Engine. Table 3 shows the data from the abrasion test and obtained the average value of the destroyed percentage of the CWA aggregate was 17.88%. The percentage of the test results shows that the CWA aggregate meets the ASTM standard with maximum wear out the limit of 40%. From the limitations provided by the ASTM standard, aggregate ceramic waste can be used as concrete aggregates in this study.

Table-3: Data of abrasion and impact test results

Specimens	the aggregate of losses (%)	Average (%)
I	17.92	
II	18.04	
III	17.66	17.88
IV	17.48	
V	18.28	

E. Granular form

Aggregates can have various forms of granules, such as round, angular, flat, oval or long. The ceramic waste aggregate has a sharp, flat, slightly oval shaped granular shape, and there is a slippery surface.

This is because ceramic waste comes from fragments of goods that have flat and sharp shapes.

Table-4: Data of granular form test results

Specimens	Flakiness index (%)	Elongation index (%)
I	19.53	6.65
II	19.10	6.78
III	21.58	6.40
IV	21.64	7.14
V	20.51	7.29
Average	20.47	6.85

The research of this grain shape is based on the BS 812-105.2 [20] standard: part 3. The standard limit of the maximum grain shape index according to BSI is 20%. Table 4 shows the results of granular form testing. The flakiness index is 20.47% and the elongation index is 6.85%. From the results of this test, it shows that the CWA aggregate is sufficient to meet the standard so that it can be used as a concrete aggregate in this study.

F. Gradation

From Table 5 the normal fine aggregate fineness modulus is 3.16 and the fine aggregate of CWA is 3.69. The fineness modulus of normal coarse aggregate is 6.25 and the coarse aggregate of CWA is 6.14. Table 5 shows the normal aggregate and coarse aggregate CWA meets the ASTM standard, while the fine aggregate CWA does not meet. Therefore, the fineness modulus is calculated based on the combined aggregate of normal fine aggregates with CWA fine aggregates. Table 5, shows the combined aggregate fineness modulus already meets ASTM standards.

Table-5: Data of gradation test results

Type of aggregate	Fineness modulus	Standard limit (ASTM)
Normal fine aggregate	3.16	2.0 - 3.5
CWA fine aggregate	3.69	2.0 - 3.5
Normal coarse aggregate	6.25	6.0 - 6.9
CWA coarse aggregate	6.14	6.0 - 6.9
Combined fine aggregate	3.54	2.0 - 3.5
Combined coarse aggregate	6.17	6.0 - 6.9

Based on ASTM standards the fineness modulus for fine aggregates is 2.0-3.5 and for coarse aggregates 6.0-6.9. For the normal fine aggregate gradation zone and the CWA fine aggregate zone including zone I (coarse sand). Whereas the normal aggregate gradation zone and the CWA coarse aggregate gradation zone include zone III (fine gravel) with a maximum grain size of 9.6 mm and a minimum of 4.7 mm. From Fig. 6 and Fig. 7 shows that the combined aggregate gradation zone meets the percentage of the gradation zone boundaries, namely zone I and zone III. From the description above, the normal aggregate and CWA aggregates can be processed and used as normal concrete mixtures in this study.

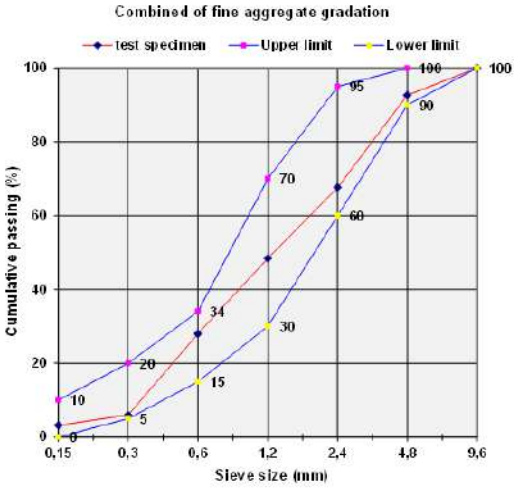

Fig. 6. Gradation curve for combined fine aggregate

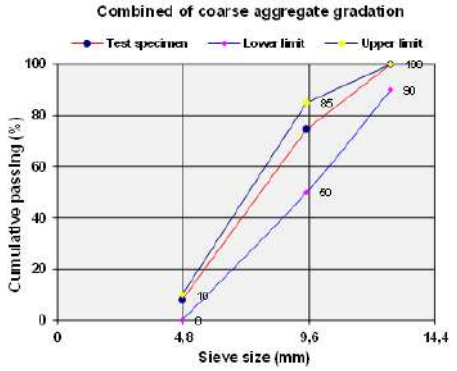

Fig. 7. Gradation curve for combined coarse aggregate

G. X-ray Diffraction

The results of the X-ray Diffraction test for two specimens, namely concrete from normal aggregate and concrete from ceramic aggregate are shown in Table 6.

Table-6: The test result of phase identification with X-ray diffractometers

Number	Type of Concrete	Identified Material	Information
1	Concrete of normal aggregate	a. Portlandite, syn b. Anorthite, Sodian, Intermediate	Testing with powder method
2	Concrete of ceramic aggregate	a. Portlandite, syn b. Quartz c. Calcium Silicate Hydrate d. Dioxolan Hydrate e. Copper Nitrate Hydrate	Testing with powder method

The results of the X-ray diffractometer identification test clearly showed the presence of different elements difference between normal concrete and ceramic waste aggregate concrete as shown in Table 6, Fig.8 and Fig. 9. Normal concrete contains elements of Portlandite [$Ca(OH)_2$] Sodian, Anorthite, and intermediate [$(Ca,Na)(Si,Al)_4O_8$]. Ceramic waste aggregate concrete contains elements of Portlandite [$Ca(OH)_2$], Quartz [SiO_2], Calcium Silicate Hydrate [$Ca_1.5SiO_3.5!\ XH_2O$], Dioxolan Hydrate [$C_3H_6O_2!\ 17H_2O$], Copper Nitrate Hydrate [$Cu(NO_3)2!6H_2O$].

From Table 6, Fig.8 and Fig. 9 do not indicate the presence of elements that can react with cement or damage concrete such as alkali, acid, sulfate and chlorite, both in normal concrete and in the aggregate concrete of ceramic waste.

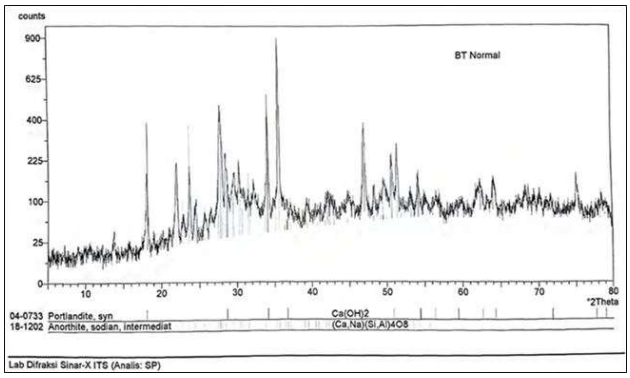

Fig. 8. The identification of normal concrete with the X-ray

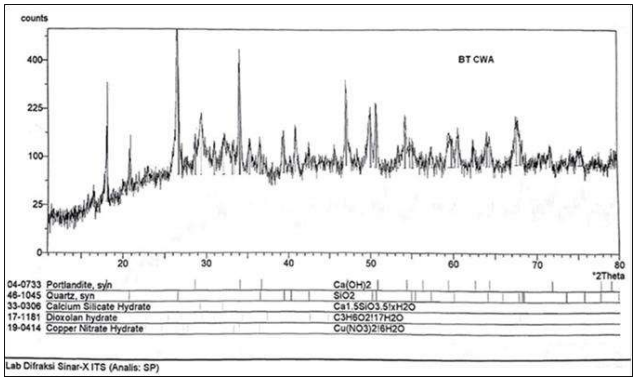

Fig. 9. The identification of ceramic concrete with the X-ray

Elements such as Anhydrite [$CaSO_4$], Barite [$BaSO_4$], Gypsum [$CaSO_4.2H_2O$], and Alunit [$KaI_3(OH)_6(SO_4)$] are common ingredients containing the element sufat. While the element Opal [$SiO_2.nH_2O$] or Silicate Acid [$Si(OH)_4$] is active or amorphous silica that can react with alkaline cement such as [Na_2O and K_2O]. Active silica or amorphous silica are commonly found in materials such as Phyllite, Metadolerite, Granite, Dacite, and Quarsite. But in concrete with ceramic waste aggregate, there is only silica or quartz [SiO_2] which is not reactive to alkaline cement. And also in concrete with ceramic waste aggregate, there is no pozzolanic silica element that can react with cement such as $Na(OH)_2$ produced from the hydration process of C_3S and C_2S, to produce new CSH gel (CSH-2 gel) such as Eq. (1) and Eq. (2) below:

$$2(3CaO.SiO_2) + 6H_2O \longrightarrow 3CaO.2SiO_2.3H_2O(gelCSH1) + 3Ca(OH)_2 \quad (1)$$

$$Ca(OH)_2 + SiO_2(SF) + H_2O \longrightarrow gelCSH-2 \quad (2)$$

The materials found in the ceramic waste aggregate concrete are Calcium Silicate Hydrate, Dioxolan Hydrate, and Copper Nitrate Hydrate cases which function as fillers and not damage the concrete. Dioxolan is a compound on the surface of ceramics that functions as a glossy. Copper compounds found on the surface of ceramics are coating materials that function as glazes. And these compounds are percentage very small as shown in Fig. 6.

IV. CONCLUSIONS

From the results of testing of mechanical properties of ceramic waste aggregate materials obtained several conclusions:

- Based on tests of mechanical properties, ceramic waste materials can be used as concrete aggregate materials but must attend to the maximum gradation according to the thickness and slippery surface of the ceramic waste.
- To overcoming the problem of industrial and residential waste, especially ceramic waste can be done by utilizing it as a concrete aggregate but must pay attention to economic and performance aspects.
- The X-ray test results show that concrete aggregates from ceramic waste are not pozzolanic and there are no elements that can react with alkaline cement, so they can be used as concrete aggregates

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