6. Inspection, NDE

Purpose of Inspection

In-service structures

Safety or not → NDE is the only method to inspect without damage to structures.

Advantage of NDE

- Selection of appropriate repairment and retrofitting method
- Life prediction by fracture mechanics
- Periodic inspection schedule

Types of NDE Methods

2 different types of cracks and their detection Methods

Surface-breaking cracks

VT : Visual Testing
PT : Dye Penetrant Testing
MT : Magnetic Particle Testing
ET : Eddy Current Testing
UT : Ultrasonic Testing

Embedded cracks

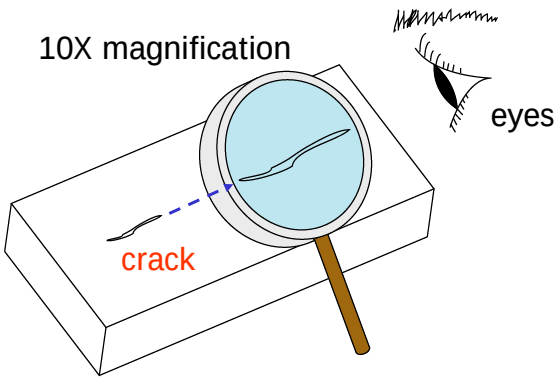
difficult to detect because they are invisible!!

UT : Ultrasonic Testing
RT : Radiographic Testing

3

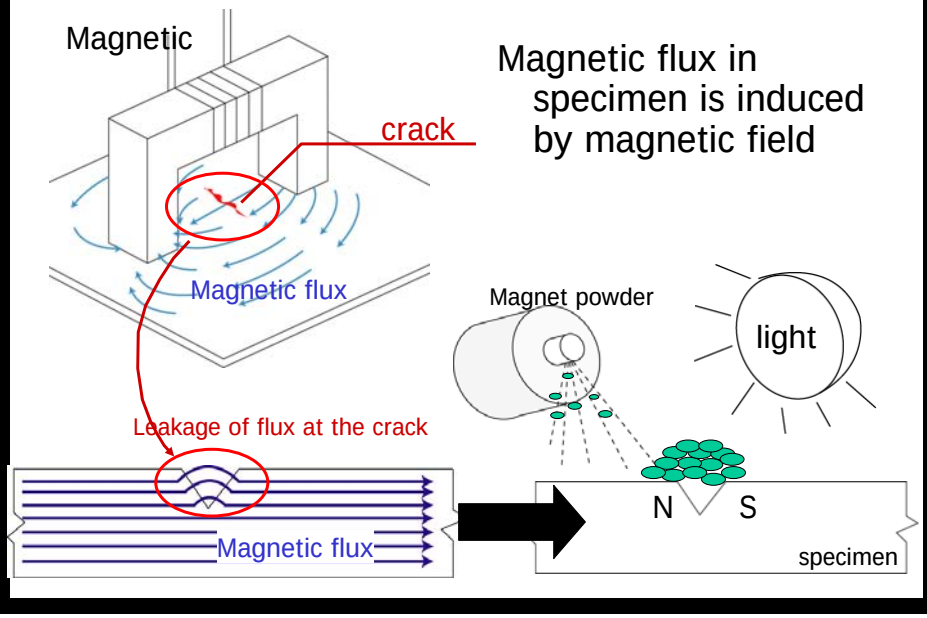
Visual Test (VT)

Preliminary inspection of structures



4

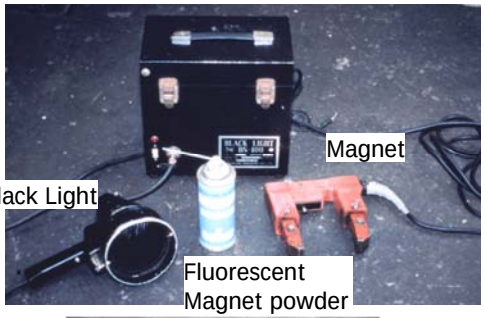
Magnetic Particle Test (MT)



5

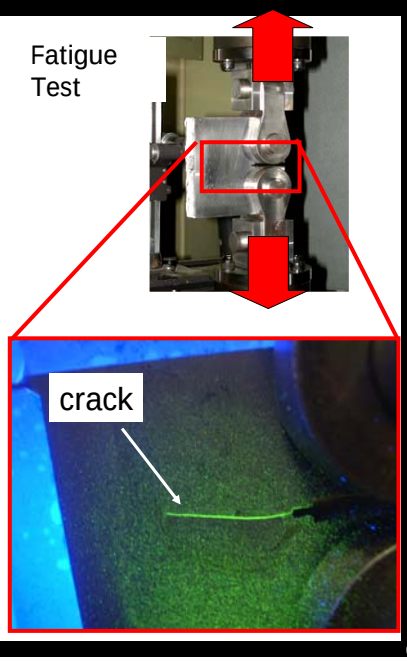
MT – Application at Sites

Equipments



Testing

Fatigue Test

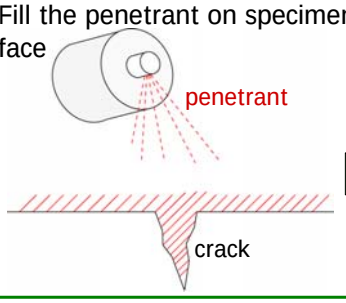


6

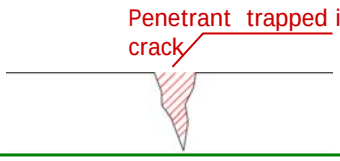
Dye Penetrant Test (PT)

Test Method

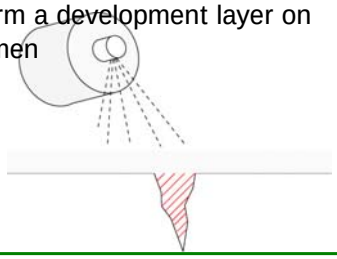
1. Fill the penetrant on specimen surface



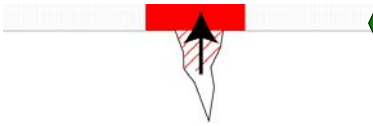
2. Clean specimen's surface (remove excessive penetrant)



3. Form a development layer on specimen

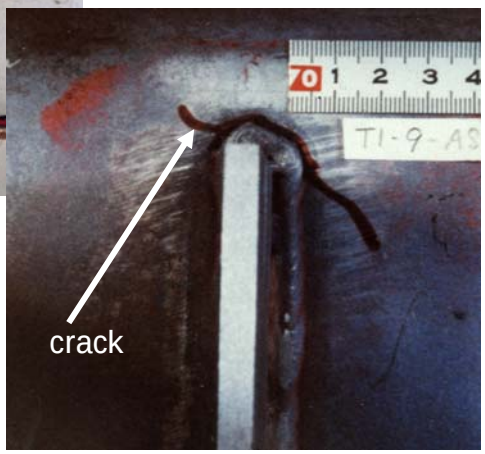


4. Penetrant leaks to development layer resulting in image of crack



7

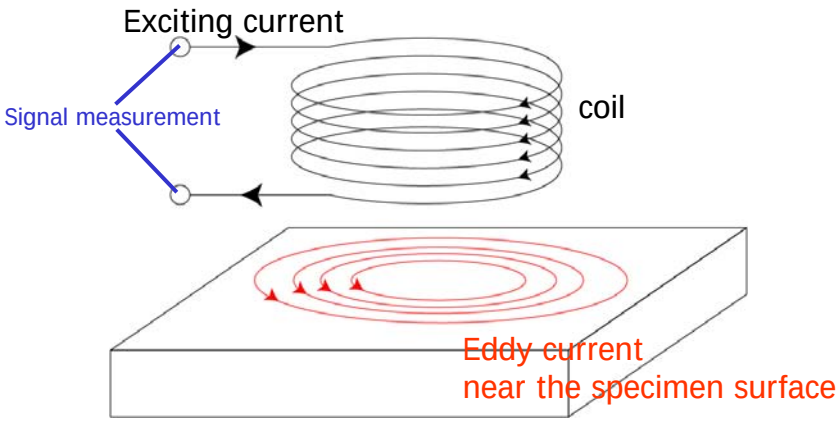
PT – Application at Sites



8

Eddy Current Test (ET)

Theory

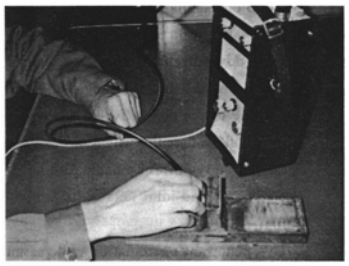


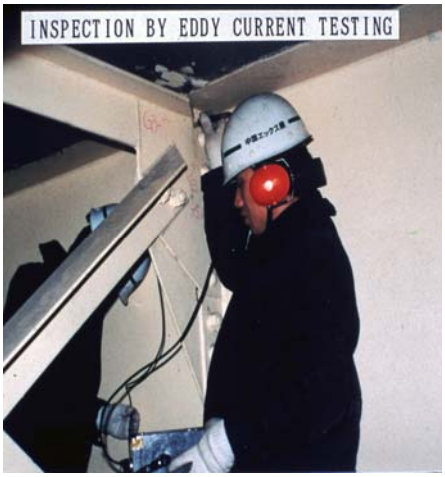
If there is cracks or defects in the specimen ,signals will change

9

ET – Application at Sites

Equipment

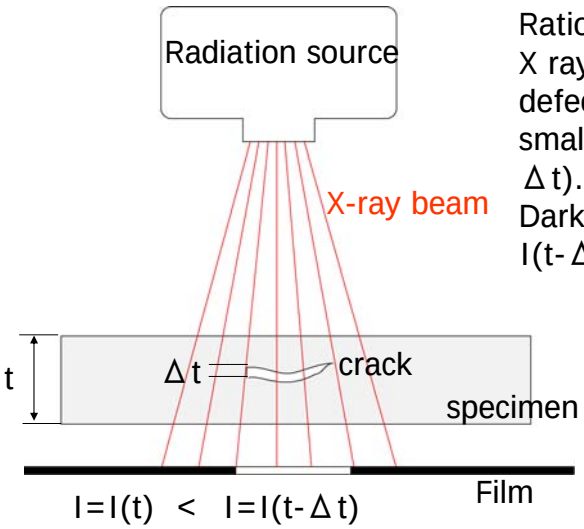




10

Radiographic Test (RT)

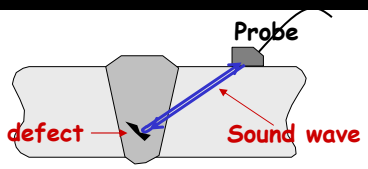
Transmit the X-ray to the specimen and the film



Ratio of received X ray without defect I(t) is smaller than I(t-Δt).
Darker image with I(t-Δt)

11

Ultrasonic Test (UT)

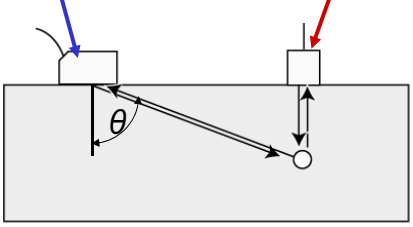


- Quality control of welds in shops
- Maintenance inspection in sites

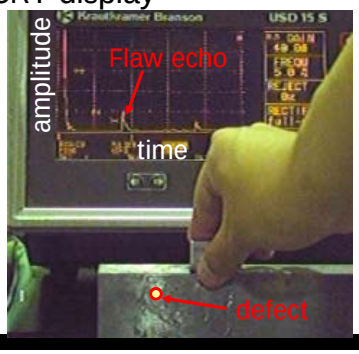
Types of probes

Normal-beam probe

Angle-beam probe:
45°, 60°, 65°, and 70°

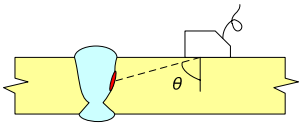


A-Scan:
Observe the flaw echo via CRT display

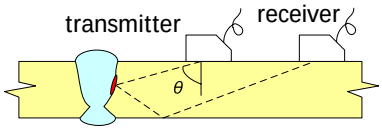


12

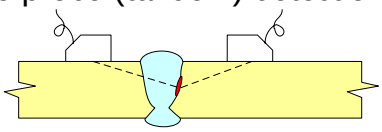
Ultrasonic Test (UT 2)



single probe detection



double probe (tandem) detection



V reflection technique

A-Scan:

The data of UT is presented in form of an unprocessed radio frequency (RF) signal or an A-Scan.
Observe the flaw echo via CRT display

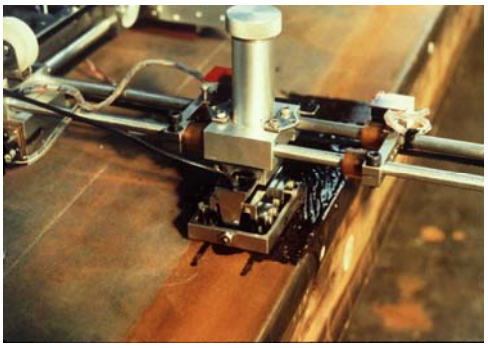
A-scan lacks in recordability and objective evaluation

13

UT – Application at Sites

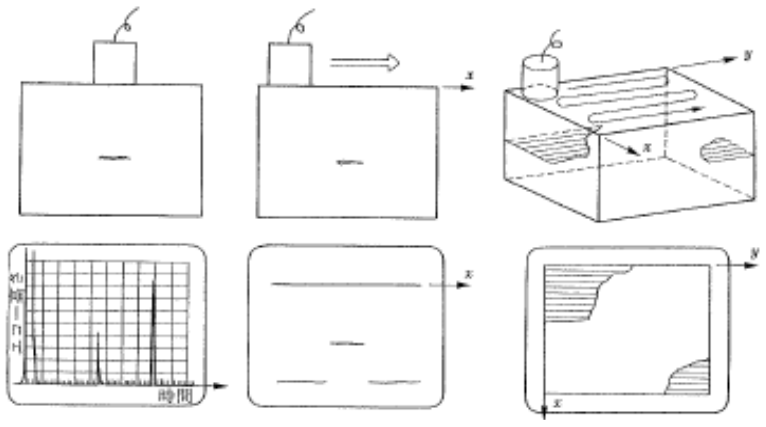
Manual UT (MUT)

Automatic UT (AUT)



14

A Scope, B Scope, C Scope



A-Scope B-Scope C-Scope

15

Research Works on NDE

Topics

- Detection of surface-breaking fatigue cracks
  Chitoshi Miki, Makoto Fukazawa, Masahiko Katoh, and Hisao Ohune: Journal of Structural Eng./Earthquake Eng., JSCE, No.386/I-8, pp. 329-337, 1987.10. (in Japanese)

- Effects of paint films on detectability of cracks by NDI methods
  Makoto Fukazawa, Hisao Ohune, Masahiko Katoh and Chitoshi Miki: Journal of Structural Eng./Earthquake Eng., JSCE, No.398/I-10, pp. 395-404, 1988.10. (in Japanese)

- Detection of embedded fatigue cracks
  Jiro Tajima, Munehiro Fukui, Chitoshi Miki and Makoto Fukazawa: Journal of Structural Eng./Earthquake Eng., JSCE, No.386/I-8, pp. 427-434, 1987.10. (in Japanese)

- Current development of ultrasonic testing systems (2001~2004)

16

Research Works on NDE

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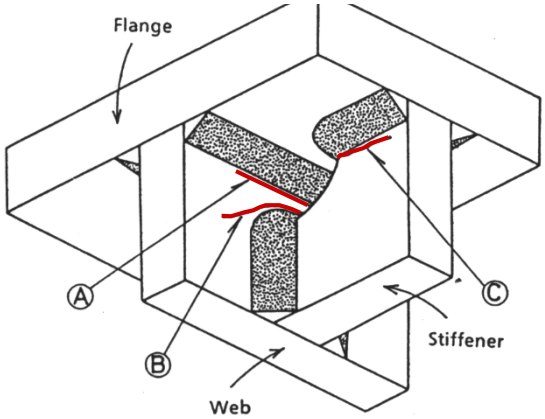
Surface-Breaking Fatigue Cracks

Fatigue cracks initiated at toes of fillet welds



1. MT
2. PT
3. ET
4. RT
5. UT

Which is the most promising method ?

How is the resolution of the method?

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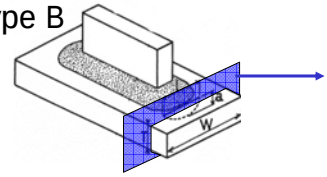
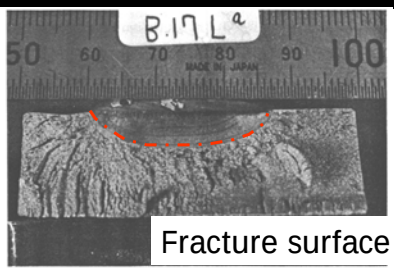
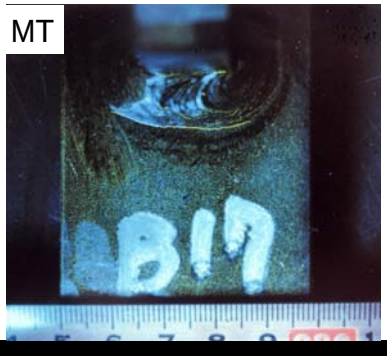
Fracture Surfaces and Results

Type B





Results



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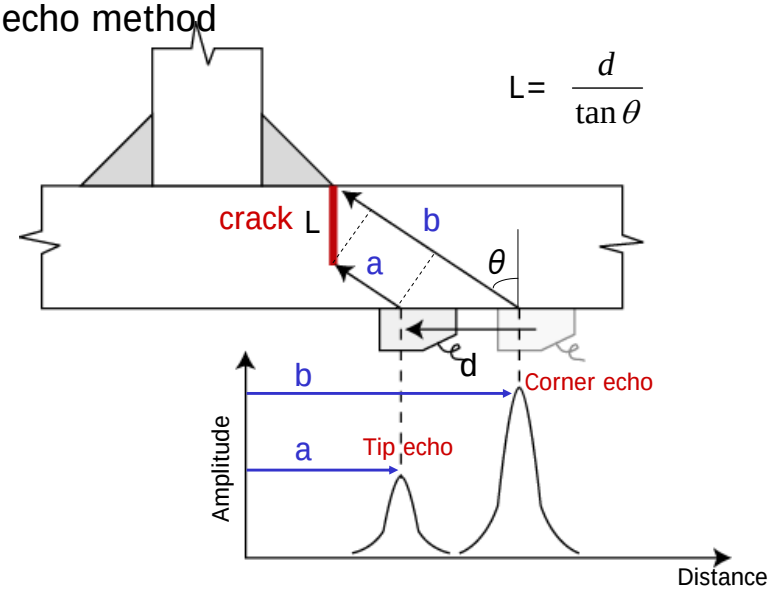
Estimation of Crack Depths by UT

Tip-echo method

$$L = \frac{d}{\tan\theta}$$



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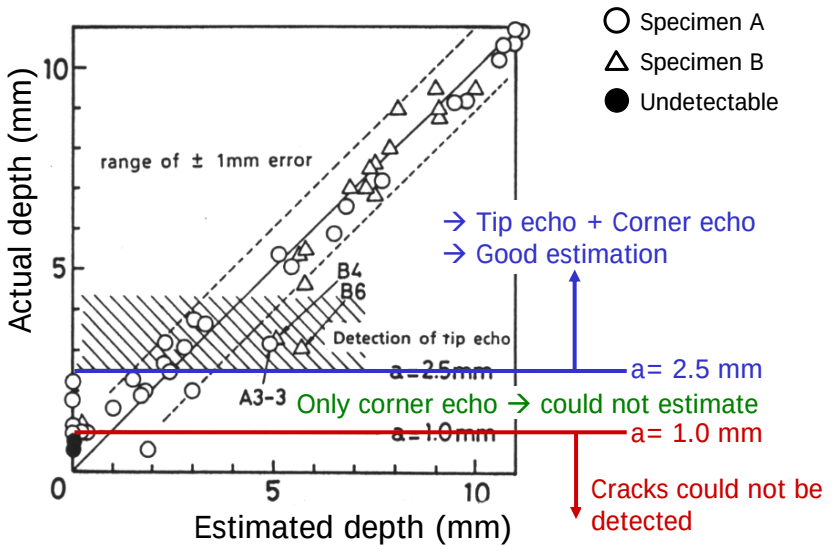
Results of UT



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Summary

Minimum detectable sizes of defects by NDI methods

with MT, ET, PT

	Size		Detection of crack(a ≧ 5mm)
	ℓ	a	
MT	<5mm	<0.5mm	Overestimated
ECT	6mm	1.0mm	Overestimated
PT	10mm	2.5mm	Underestimated

with UT

	Minimum Detectable Depth	Accuracy
Corner Echo	1mm	-----
Tip Echo	2.5mm	± 1mm

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Research Works on NDE

Topics

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  Chitoshi Miki, Makoto Fukazawa, Masahiko Katoh, and Hisao Ohune: Journal of Structural Eng./Earthquake Eng., JSCE, No.386/I-8, pp. 329-337, 1987.10. (in Japanese)

- Effects of paint films on detectability of cracks by NDI methods
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- Current development of ultrasonic testing systems (2001~2004)

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Paint Films

Most of steel bridge members are coated with paint.
Paint films prevent steel bridges from weathering corrosion.

How does it affect the inspection ?

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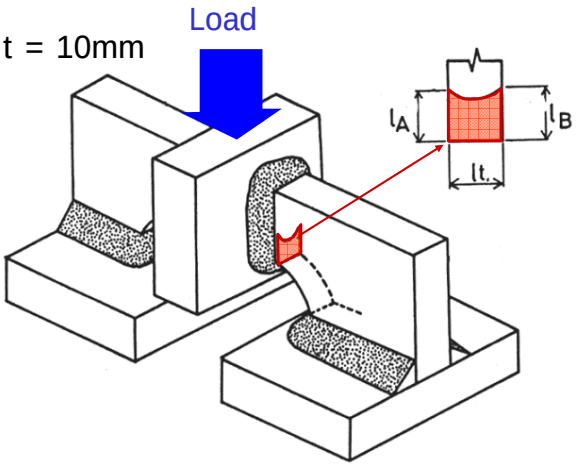
Specimens with Paint Films



→ **Before** removal of paint
→ **After** removal of paint

VT, ET, MT, PT, UT

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Painting Process

Process		Painting Material	Standard amount used (g/cm²)	Painting Interval (20°C)
Work Shop	1st layer	Etching Primer	Spray 130	12H-3M
	2nd layer	Rust Resisting Paint	Spray 170	2D-1M
	3rd layer	Rust Resisting Paint	Spray 170	2D-6M
Field	4th layer	Phthalic Resin Coating	Brush 110	24H-15D
	5th layer	Phthalic Resin Coating	Brush 105	

5 Layers

Total Thickness =100 μm

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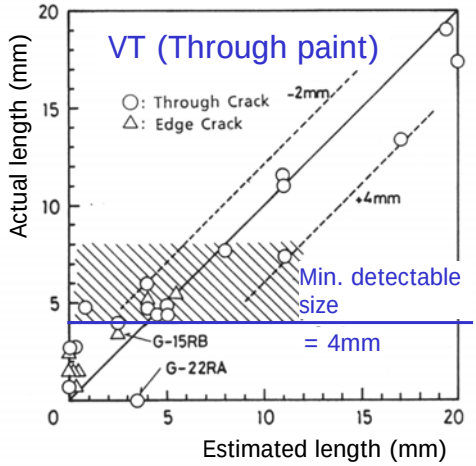
Inspection Results – VT (I)



Discontinuities of paint films are the **sign of presence of cracks** → Easy to detect

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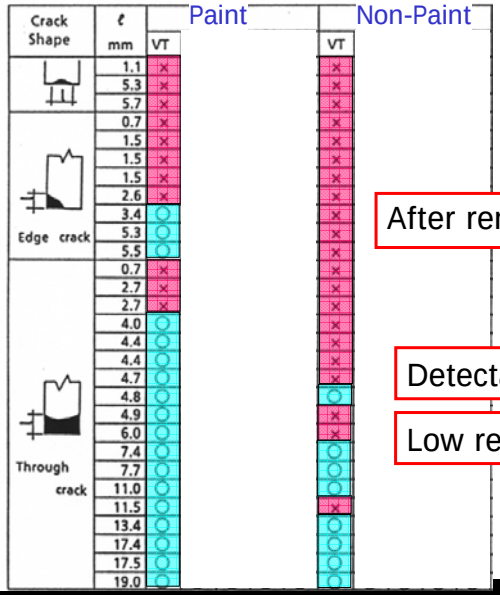
Inspection Results – VT (II)

Before and after the removal of paint films



= Correct Judgment

= Misjudgment

After removal → No sign of cracks

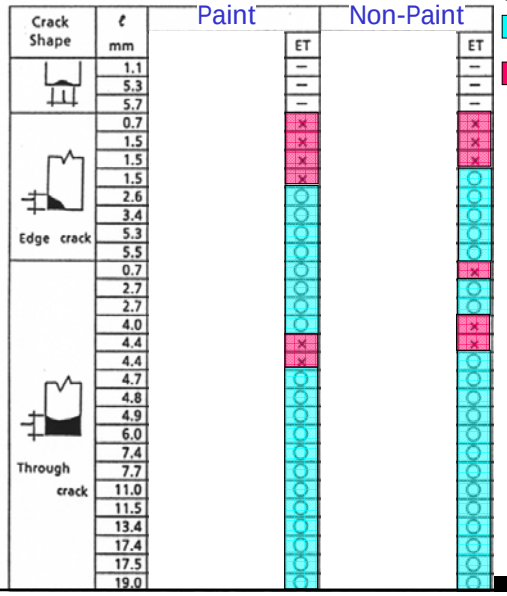
Detectability largely decreases

Low reliability

28

Inspection Results – ET

Before and after the removal of paint films



= Correct Judgment

= Misjudgment

Almost no effects

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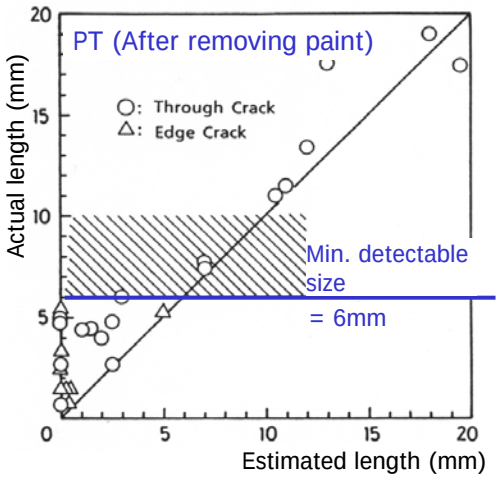
Inspection Results – PT (I)



Underestimate the length of cracks

Min. size = 6 mm

30

Inspection Results – PT (II)

Before and after the removal of paint films

= Correct Judgment

= Misjudgment

After removal of paint films

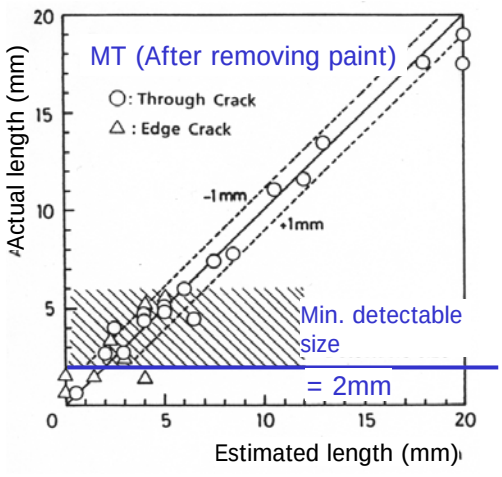
→ Slight amount of penetrant leaks into the cracks

→ Low color contrast

Detectability decreases

31

Inspection Results – MT (I)



Min. size = 2 mm

Error = ±1 mm

The most reliable methods

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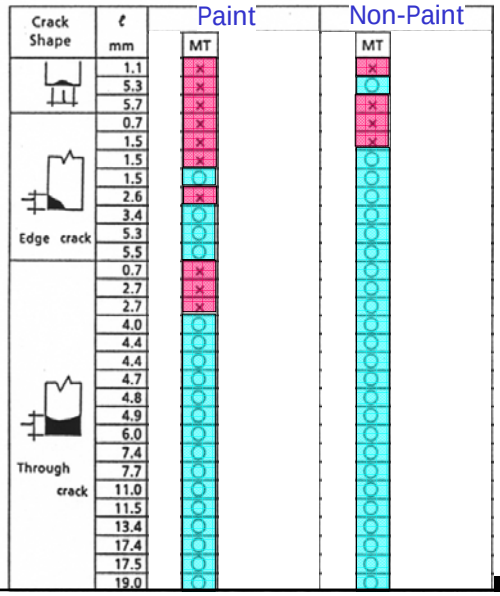
Inspection Results – MT (II)

Before and after the removal of paint films



= Correct Judgment

= Misjudgment

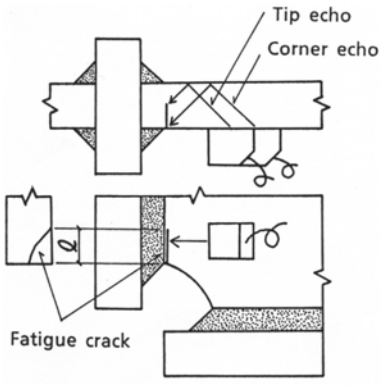
After the removal

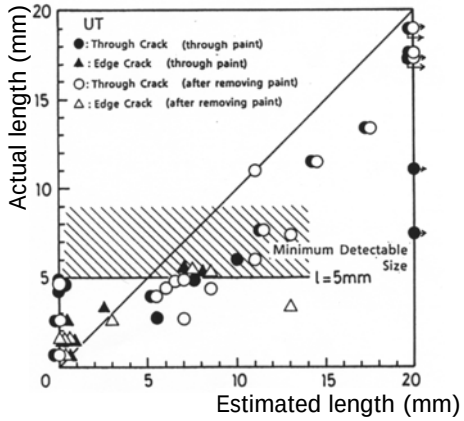
Detectability increases

33

Inspection Results – UT (I)

Inspection procedure



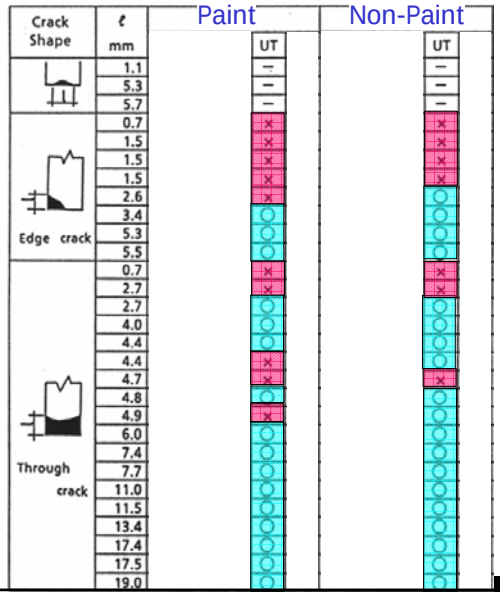


Overestimate the length of cracks

34

Inspection Results – UT (II)

Before and after the removal of paint films



= Correct Judgment

= Misjudgment

No large effects

35

Summary

Detectable crack length limit

NDT	Minimum Detectable Length, mm		Accuracy
	Paint	Nonpaint	
VT	4.0	8.0	Poor accuracy(varied widely)
MT	(4.0)	2.0	Appropriate
PT	(4.0)	8.0	Underestimated
UT	5.0	6.0	Overestimated
ECT	5.0	5.0	None

36

Research Works on NDE

Topics

- Detection of surface-breaking fatigue cracks
  Chitoshi Miki, Makoto Fukazawa, Masahiko Katoh, and Hisao Ohune: Journal of Structural Eng./Earthquake Eng., JSCE, No.386/I-8, pp. 329-337, 1987.10. (in Japanese)

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- Current development of ultrasonic testing systems (2001~2004)

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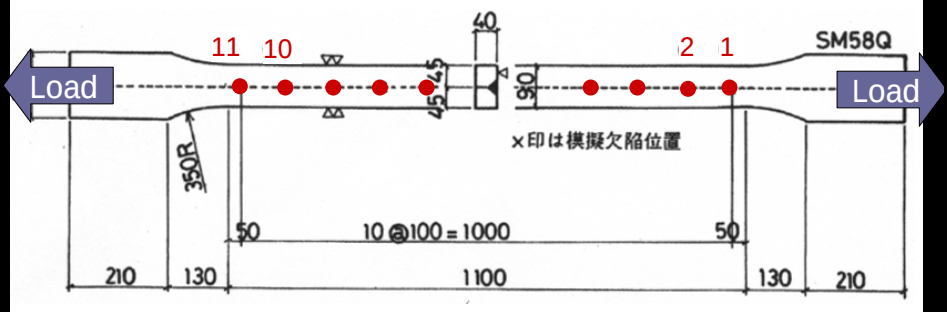
Specimens with Artificial Defects

JIS-SM58Q

● locations of defects

Totall 11 defects



Apply fatigue test to this specimen until cracks reach surface

→ Apply **UT** and **RT**

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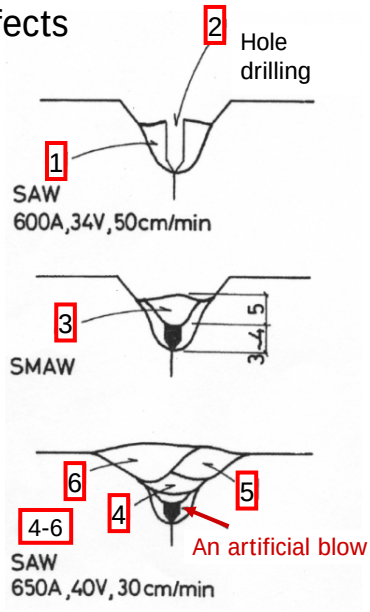
Procedure for Introducing Defects

Blowhole-like defects



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Inspection Results

Compare with actual size

Crack	Estimated size by UT [mm]	Actual Size [mm]
C-5	19.3	19.1
C-6	6.2	6.3
A-9	5.9	5.9

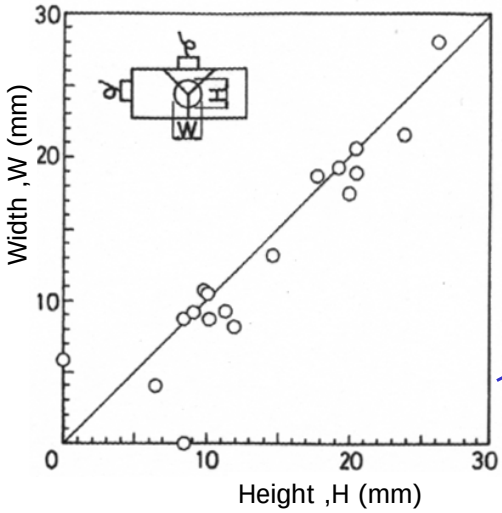
Good agreement

High accuracy of crack size estimation

40

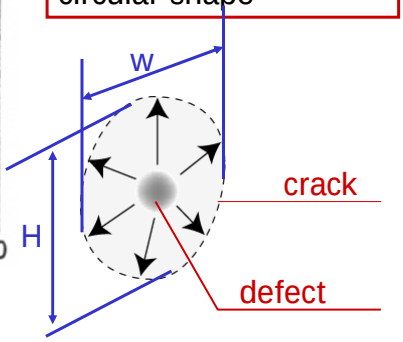
Relation of Crack Width and Height

Results detected by UT



Width and height are almost the same

Cracks propagate with circular shape



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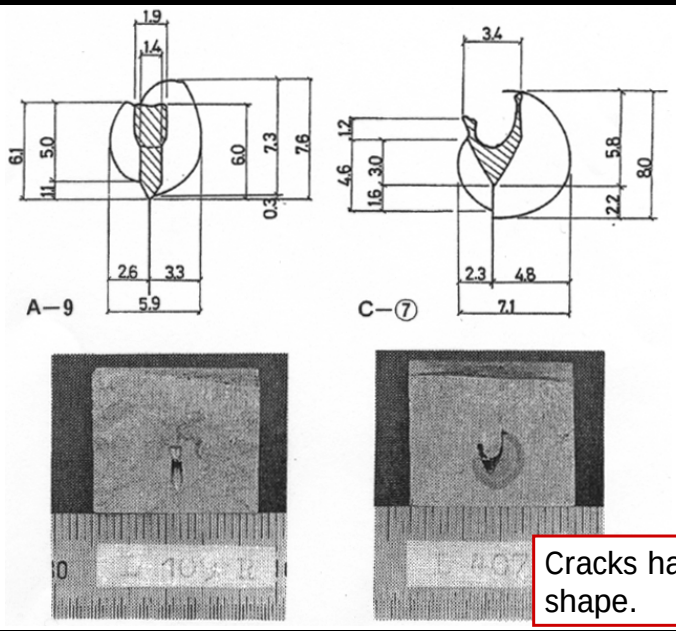
Fracture Surfaces



Cracks have circular shape.

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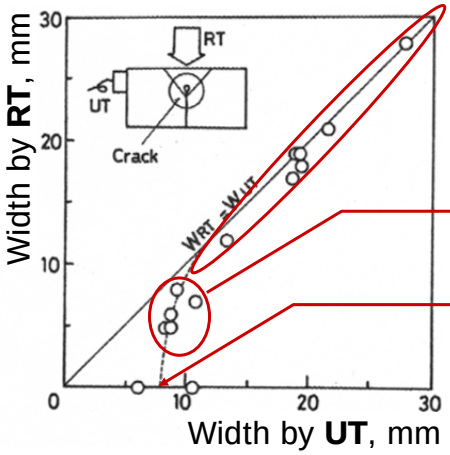
Width of Cracks by RT and UT



Good agreement with crack size >= 12mm

RT:
Underestimate cracks with size 8 – 12 mm

RT:
Cracks with size less than 8mm could not be detected.

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Summary

UT is better than RT in terms of accurate estimation of crack sizes.

Recently UT become the most popular method for inspection.

- No danger to human
- Faster than RT
- Cheaper than RT

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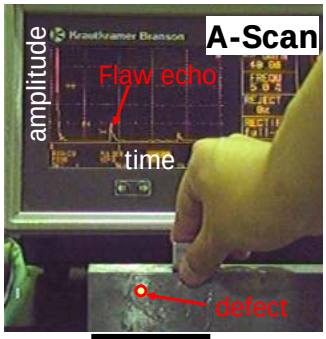
Disadvantages of UT

1. Presentation of results

UT A scope lacks reliability and objectivity in the result presentation.

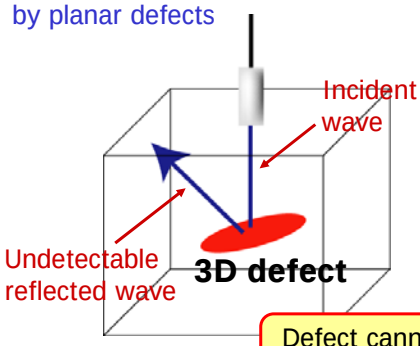


To improve

Visualization of defects

2. Detection of 3D defects

Difficult to detect waves reflected by planar defects



Defect cannot be detected !!

To improve

New type of probes

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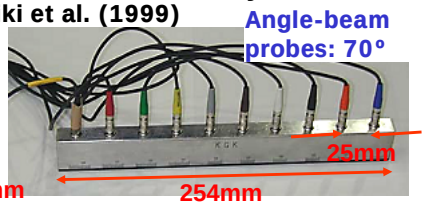
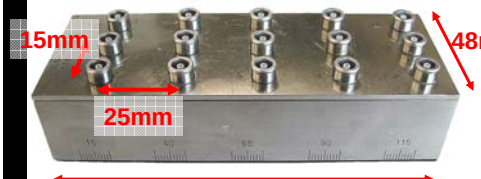
Recent Development of UT

Multi-channel array probes

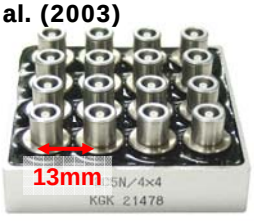
Linear Tandem Array Probe
Miki et al. (1999)



Planar Tandem Array Probe
Miki et al. (2002)



Planar Pitch-Catch Array Prob
Miki et al. (2003)



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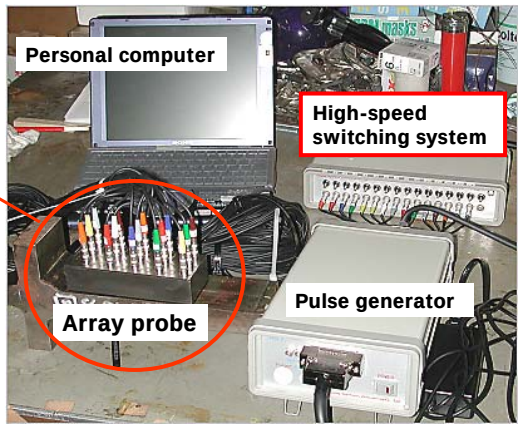
Ultrasonic Inspection System



Advantages of this system

- Compact and portable ➔ appropriate for in-service inspection
- Very fast ➔ All wave signals are recorded within 5 seconds
- All wave signal can be recorded at sampling frequency of 60 MHz, which is large enough for defect evaluation.

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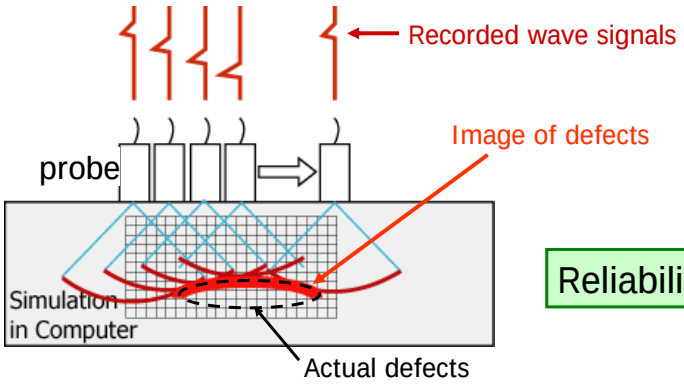
Visualization System

Synthetic Aperture Focusing Technique (SAFT)



Reliability increased

Our target

- Three dimensions
- Multi-channel array probes

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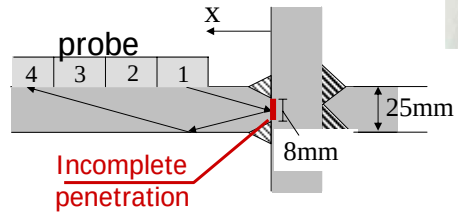
Detection by Linear Tandem Array Probe

Cruciform joint



Linear tandem array probe

Image result

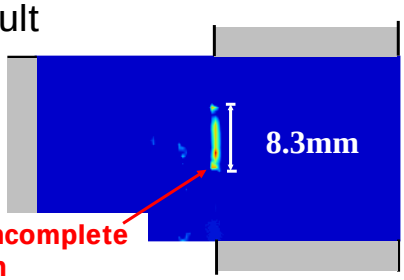


Image of incomplete penetration

High objectivity

Very accurate results

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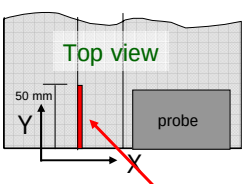
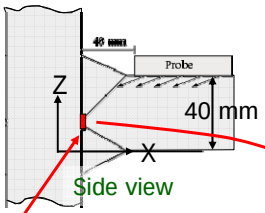
Detection by Planar Tandem Array Probe

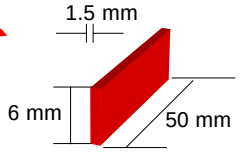
Weld defect in cruciform joint

Setup





Geometry



Incomplete penetration

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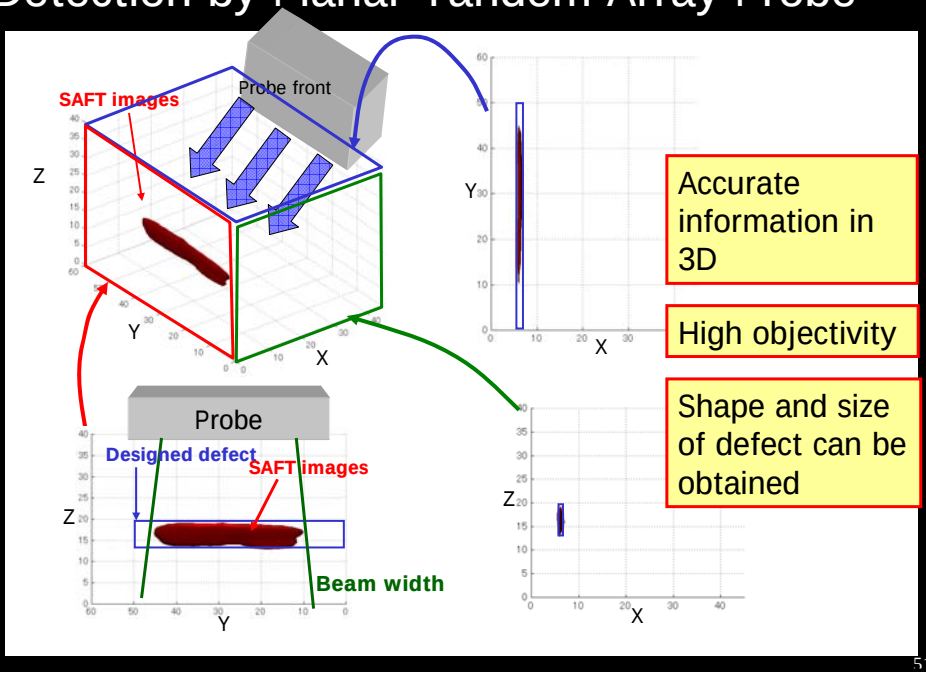
Detection by Planar Tandem Array Probe



Accurate information in 3D

High objectivity

Shape and size of defect can be obtained

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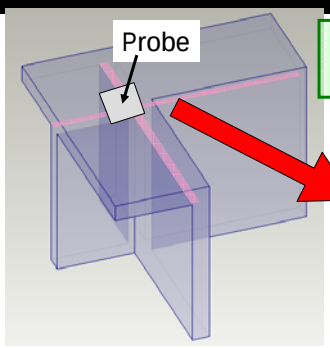
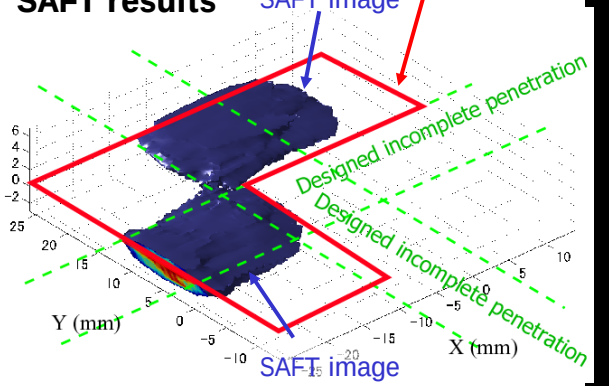
Detection by Planar Pitch-Catch Array Probe



Inspection at intersection of incomplete penetrations

Inspection area

SAFT results



SAFT images present at location of incomplete penetrations.

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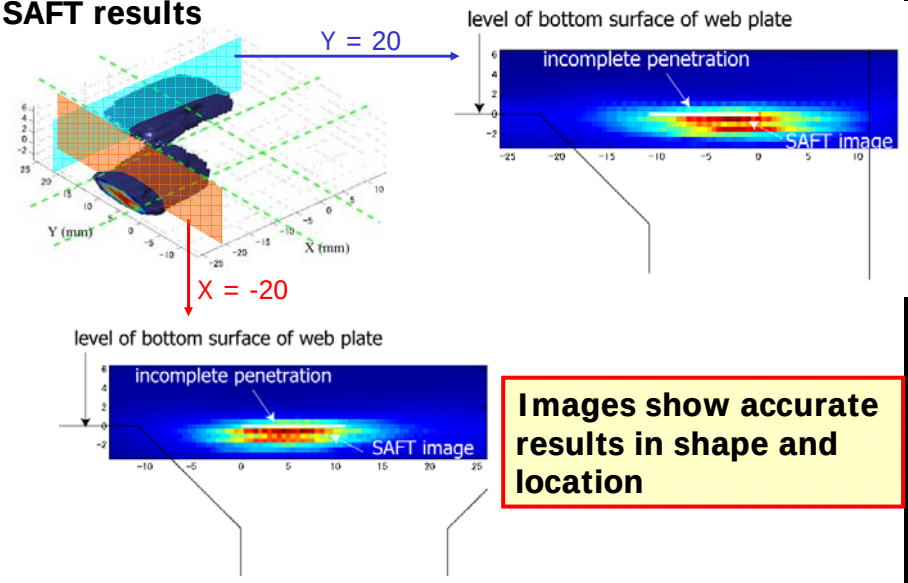
Detection by Planar Pitch-Catch Array Probe

SAFT results



Images show accurate results in shape and location

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