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[Continued on next page]

(54) **Title:** ULTRASONIC TRANSDUCER ASSEMBLY AND SYSTEM FOR MONITORING STRUCTURAL INTEGRITY

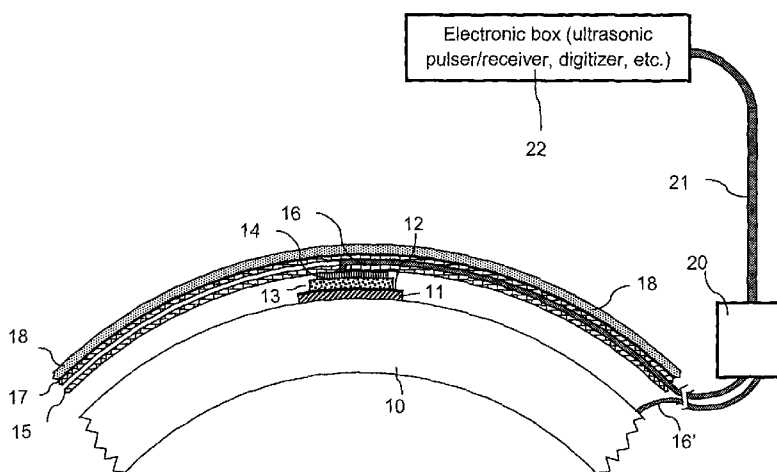


FIG. 2

(57) **Abstract:** In an ultrasonic transducer assembly, a conformable ultrasonic transducer has a piezoelectric layer and electrodes able to conform to curved surfaces, and a clamp for pressing the transducer into ultrasonic contact with a curved surface. Conformability is ensured with a thin, porous piezoelectric layer and suitable electrical conductors and insulators. The ultrasonic transducer may operate without further thermal shielding under harsh environments and/or at high temperatures.

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ULTRASONIC TRANSDUCER ASSEMBLY AND SYSTEM FOR MONITORING STRUCTURAL INTEGRITY

FIELD OF THE INVENTION

[0001] The present invention relates to an ultrasonic sensing assembly and system that is particularly useful for the monitoring of curved objects, including those that operate at high temperatures.

BACKGROUND OF THE INVENTION

[0002] Corrosion, erosion, fatigue, creep are examples of degradation mechanisms that limit the life time of structures and cause significant economic impact on many industries. The prediction of life time of structures is often not precise enough and inspection methods are regularly applied to structures to determine its health condition. Ultrasonics is one of the most valuable non-destructive testing methods to evaluate the condition of structures exposed to degradation mechanisms.

[0003] Structural health monitoring (SHM) of components of power plants, oil & gas and aerospace industries, such as pipes and other vehicle parts having respective contoured surfaces is desirable, but tricky. Access to the structural parts to be inspected may be difficult due, for example, to safety concerns for inspectors, or to a limited access to the structure surface due to thermal insulation, adjacent mechanisms, electrical, pneumatic or hydraulic control lines, etc. Furthermore, once access is provided, installing a sensor in a way that provides adequate contact between a piezoelectric material and the component to be tested, may be difficult. Also, the inspection may require the shutdown of a running process. Therefore permanently or semi-permanently installed transducers are often preferred, especially in transducers that permit a state of the structure to be sensed at any time (on demand) by electronic request. The time between inspections is typically chosen in order to provide accurate prediction of the remaining life time of the structures. Therefore permanently attached transducers with easy electronic interrogation of the sensor are in demand to make shorter and less costly interrogation of the condition of the structure.

[0004] Sensors for structural health monitoring are often required to operate in harsh environments as for example, at high temperatures. Therefore the permanently attached transducers may also be required to maintain its performance for long periods of time, at high temperatures. High temperatures transducer configurations have been proposed using a delay line and cooling of transducers as for example, in U.S. Pat. No. 7,185,547 to Baumel, entitled "Extreme Temperature Clamp-on Ultrasonic Flowmeter Transducer". The delay lines and cooling significantly limits the value of such transducers for widespread structural health monitoring. Therefore it is required to develop transducers composed of materials that can maintain a significant proportion of its essential properties at high temperatures.

[0005] Similar techniques have been used to separate ultrasonic transducers from high temperature surfaces and the separation, though perceived to be required for operation of the sensor, impairs the use of the sensor, and occupies a lot of space around the component.

[0006] Other examples of patents in this field are: US 3,781,576, to Runde, et al., entitled High temperature Ultrasonic Transducer; US 4,392,380, to Caines entitled High Temperature Pressure Coupled Ultrasonic Waveguide; US 4,567,770 to Rumbold et al., entitled Ultrasonic Transducer Apparatus and Method for High Temperature Measurements; US 4,738,737 to Runde et al., entitled Method of Using a High Temperature Ultrasonic Couplant Material; US 4,783,997, to Lynnworth entitled Ultrasonic Transducers for High Temperature Applications; US 5,325,012 to Sato et al., entitled Bonded Type Piezoelectric Apparatus, Method for Manufacturing the Same and Bonded Type Piezoelectric Element; US 5,886,456 to Stubbs et al., entitled Ultrasonic Transducer and Ultrasonic Detection and High Temperature Processing Systems Incorporating Same; and US 7,743,659 to Kearns et al., entitled Structural Health Monitoring (SHM) Transducer Assembly and System.

[0007] "Flexible Ultrasonic Transducers" by Kobayashi, M., Jen, C.K, and Levesque, D., IEEE Trans. on Ultrasonics, Ferroelectrics and Frequency Control, vol. 53, no. 8, August 2006 teaches that the flexible ultrasonic transducers (FUTs) are applicable to in-situ SHM, NDT and on-line diagnosis. To demonstrate the flexibility and operability of such FUTs when flexed, one experiment was performed on a thick pipe at room temperature and at elevated temperatures. As shown in FIG. 1, and FIG. 2, a viscous oil ultrasonic couplant was applied on the pipe at the location of testing, it was covered with a 75 micron stainless steel foil, and a PZT piezoceramic film, which was topped with a silver paste, to serve as an electrode.

The pipe itself served as the ground. A mechanical holder is provided to maintain the FUT in place.

[0008] While the mechanical holder of Kobayashi et al. encircled a pipe, it was not a clamp for the FUT as the term is used in the present art, and the active area of the FUT is substantially free of pressure as there is a wide opening in the clamp surrounding the FUT, as is shown in FIGs. 1 and 2. The purpose of the clamp is just to prevent slipping of the FUT on the oiled, rounded, surface. Also in this previous art, the electrical connections are made by spring-loaded pins that are not practical for real industrial applications.

[0009] Other previous art that uses some kind of flexible transducers like United States patent 5,166,573 to Brown, for example, which teaches how to produce polymer-base FUTs and flexible UT arrays, but does not teach a practical assembly to attach to permanently monitor structures. Also, as the piezoelectric layers of these transducers are polymer-based, they are inherently incapable of high temperature applications.

[0010] Accordingly, there is a need for improved ultrasonic transducer assemblies to perform structural health monitoring that can be permanently installed in curved objects, can maintain performance for long periods of time, including at high temperatures and harsh environments, and can allow easy and automated electronic interrogation of the condition of the structure.

BRIEF SUMMARY OF THE INVENTION

[0011] A transducer assembly is provided for structural health monitoring, and the like, that improves the durability and signal quality while avoiding difficulties characterized with the prior art. While one substantial advantage of using a clamp is that substantially higher pressures can be applied, allowing a greater variety of couplants to be used for higher temperature applications, for example, the clamp with a flexible piezoelectric film has advantages even in low temperature applications without any couplant, improving durability of the transducer assembly, avoiding debonding, and improving signal quality and strength.

[0012] Accordingly, an ultrasonic transducer assembly is provided that includes a piezoelectric film that is able to conform to curved surfaces, at least a flexible electrode adjacent to a top surface of the piezoelectric film, to make the piezoelectric film able to act as an ultrasonic transducer, a flexible insulating layer covering the top electrode and at least

part of a first electrical connector extending from the top electrode to an electronic control, the insulating layer having a shape and size to substantially surround a section of a component to be monitored, and a permanent or semi-permanent clamp adapted to apply at least a 0.2 MPa compressive stress on a region of the component aligned with the top electrode. The clamping of the FUT in the region aligned with the top electrode ensures that the stress is applied where the contact is needed to improve ultrasonic coupling between the FUT and the section of the component.

[0013] The transducer assembly is preferably flexible so that it may be clamped to curved surfaces, such as pipes, or pipe fittings (e.g. elbows, couplers, pipe joints, etc.) and other shaped components, especially those components that have sections that include convex surfaces. The materials chosen for construction of the transducer assembly may retain sufficient structural, electrical, and chemical integrity under severe harsh environments, such as high temperatures, making the assembly suitable for high temperature operation. For example, the piezoelectric film may have a composition consistent with fabrication using one or more layers of a mixture of a piezoelectric powder and organic precursors of dielectric and/or piezoelectric material. The resulting piezoelectric film may therefore have a level of porosity that improves flexibility, resistance to thermal shock and ultrasonic bandwidth.

[0014] The transducer assembly may further comprise an ultrasonic coupling layer (or couplant) composed of an ultrasonic transmitting material that makes an intimate physical contact with the transducer assembly, for making intimate physical contact with the component to be monitored. The couplant may comprise a high temperature paste or liquid, or a soft metal, such as aluminum, gold, tin, zinc or other alloys known to the art of soldering and brazing. A foil of a soft (or temperature softened) metal may be particularly preferred for longevity of the couplant system. Some foils (such as gold) require greater stress to ensure intimate physical contact. Accordingly, if a metal foil couplant is used, the clamp may be adapted to apply at least 1 MPa compressive stress, or at least 10 MPa compressive stress. The clamp may be adapted to apply an initial compressive stress greater than 1 MPa to plastically deform the metal foil, and a far lower compressive stress thereafter for maintaining the intimate physical contact. The metal foil may have been strained by a much greater compressive stress than the clamp, in which case the clamp may serve only to maintain intimate physical contact between the assembly and the component.

[0015] The assembly may further comprise a bottom electrode adjacent the piezoelectric film on a surface opposite the top electrode. The bottom electrode may be electrically coupled to the component, which is sufficiently conductive to serve as a ground for the flexible ultrasonic transducer, or coupled to the electronic control by a second electrical connector that is insulated from the first electrical connector. The bottom electrode may also serve as the clamp.

[0016] The insulating layer may include a conductive path between top and bottom insulations, with a via through the bottom insulation for providing electrical contact between the conductive path and the top electrode. The insulating layer may be formed of mica or polyimide.

[0017] The piezoelectric layer may be bonded to the component to be monitored by a ceramic binder made from organic precursors of a piezoelectric and/or dielectric ceramic.

[0018] A protective layer may surround the insulating layer. The clamp may be a band that serves as the protective layer. The clamp may be a tube clamp, comprising a deformable band for surrounding the section, formed of metal or a fibreglass textile, and may have a tensioning mechanism with a spring or spring washer to maintain a constant tension under different thermal conditions. More deformable band materials have superior conformability making them suited to components having more complex geometry.

[0019] A plurality of separate piezoelectric films may be spaced along the insulating layer to provide a transducer array, each piezoelectric film being similar. The separate piezoelectric films are independently electronically addressable by the electronic control, or are commonly electronically controlled.

[0020] Accordingly a method is provided for producing a transducer assembly. The method comprises providing a flexible ultrasonic transducer, including at least a top electrode adjacent to a flexible piezoelectric film; bonding said top electrode to an insulating layer, the insulating layer having a shape and size to substantially surround a section of a component to be monitored, providing insulated electrical connection from the top electrode to an electronic control, and providing a permanent or semi-permanent clamp adapted to apply at least a 0.2 MPa compressive pressure on a region of the component aligned with the top electrode.

[0021] The method may further comprise preparing a part of a surface of the section of the component; applying a couplant to the part of the surface to provide intimate physical contact between the couplant and the surface; and mounting the previously assembled layers to the couplant to provide intimate physical contact between the couplant and the flexible ultrasonic transducer. If the couplant is in the form of a metal foil, the mounting may comprise applying an initial compressive stress greater than 1 MPa to plastically deform the soft metal foil. Alternatively, applying the couplant may comprise applying an adhesive material, such as a polymer based glue, silver paste, ceramic cement, glass known in the art of adhesive bonding.

[0022] If the couplant or the component is not electrically conductive, the method may further comprise applying a bottom electrode and insulated conductors from the bottom electrode to the electrical control. The bottom electrode may be a titanium, aluminum or stainless steel foil, or other metal or metalized foil.

[0023] Providing the flexible ultrasonic transducer may comprise applying one or more layers of a mixture of a piezoelectric powder and organic precursors of dielectric and/or piezoelectric material; heat treating the applied layers; and poling the applied layers to produce the piezoelectric film, and may further comprise applying the top electrode as a silver or gold paste or by thin film deposition of a conductive metal, such as gold, silver, platinum or aluminum. Alternatively the flexible ultrasonic transducer may be provided as a separate component, or may be integrated with the insulating layer.

[0024] The electrical control may comprise an electric pulse generator, an electric signal detector, an electrical analog to digital signal converter, a digital memory, and a communications interface for exchanging digitized signals by conductor or wirelessly.

BRIEF DESCRIPTION OF THE DRAWINGS

[0025] Preferred embodiments of the invention can be understood in more detail from the following descriptions taken in conjunction with the accompanying drawings in which:

FIG. 1 shows a perspective view of a clamp-on multi-element transducer array according to an embodiment of the present invention;

FIG. 2 shows a partial cross-sectional view of a single-element transducer assembly according to an embodiment of the present invention;

FIG. 3 shows a partial cross-sectional view of a multi-element transducer assembly according to an embodiment of the present invention;

FIG. 4A shows a partial cross-sectional view of an example lay-up configuration for forming the transducer assembly according to an embodiment of the present invention;

FIG. 4B shows a partial cross-sectional view of another example lay-up configuration for forming the transducer assembly according to an embodiment of the present invention;

FIG. 4C shows a partial cross-sectional view of another example lay-up configuration for forming the transducer assembly according to an embodiment of the present invention; and

FIG. 4D shows a partial cross-sectional view of another example lay-up configuration for forming the transducer assembly according to an embodiment of the present invention.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

[0026] The following detailed description of embodiments refers to the accompanying drawings, which illustrate specific embodiments of the invention. This invention may, however, be embodied in different forms and should not be construed as limited to the embodiments set forth herein.

[0027] FIG. 1 is a schematic illustration of an example of the embodiment of multi-element ultrasonic transducer assembly for monitoring structural integrity. In this example a tube clamp **18** is used as a mechanically constraining layer. It embraces all other layers of the assembly and makes a robust attachment to the component to be monitored **10** represented by a tube in this example. Tube clamp **18** ensures good physical contact between layers of the transducer assembly where ultrasound need be transmitted. The transducer assembly is mounted on a pipe. Other common examples of components to be monitored include pipe fittings, and pressure vessels among others. In this example, a connection box **20** is used to connect electrical conductors of the transducer assembly array to an external multi-conductor cable **21** that is to be connected to an electronic control **22**. In another embodiment, each conductor of the external multi-conductor cable **21** continues to each element of the transducers and the connection box **20** is not necessary.

[0028] FIG 2 is a schematic illustration of a cross-sectional detailed view of a part of an ultrasonic transducer assembly in accordance with an embodiment of the present invention, having a single piezoelectric element. It will be noted that the extreme thinness of some of the layers make them ill suited for scaled representation. For example, the electrodes may be hundreds of nanometers thick, the piezoelectric layers and electrical foils may be microns thick, insulating layers may be hundreds of microns thick, and the tube clamp band may be a few millimetres thick or thinner, in typical examples.

[0029] In this embodiment, a piezoelectric film **13**, located between a top electrode **14** and a bottom electrode **12**, is driven by an electric excitation carried by electric conductors **16** and **16'**. The piezoelectric film **13**, in this embodiment, has preferably some flexibility in order to bend to fit curved objects, even if it was formed by in-situ deposition. The piezoelectric film **13** preferably has some internal damping to avoid the need for a backing, while still being able to excite and detect short ultrasonic pulses. If the transducer assembly is to be used to monitor components at high temperature, it is preferable that the piezoelectric film **13** show good resistance to thermal expansion of both top electrode **14** and bottom electrode **12**. The piezoelectric layer **13** may be made of materials that maintain piezoelectricity at high temperatures. These properties for a piezoelectric film can be obtained, for example, by producing it by the method known in the art as the sol-gel route. Both the top electrode **14** and bottom electrode **12** are preferably thin compared to the ultrasonic wavelength in order to avoid spurious echoes. Thin electrodes have also, in general, the advantage of being flexible, which allows them to be fitted to curved surfaces. Electric conductors **16,16'** connect the top and bottom electrodes to the electronic control **22**, and are electrically separated from other electric conductive parts of the assembly by the top insulator **17** and bottom insulator **15**. The connection to the bottom electrode **16'**, often referred to as the ground, can be connected to the component **10**, provided that it is electrically conductive and the bottom electrode is connected to the component **10**. In some embodiments, it may be preferable to use a connection box **20** between the electric conductors **16,16'** of the transducer assembly and the electronic control **22**. In such cases, appropriate conductive cables **21** connect the electronic control **22** to the connection box **20**. The electrical conductors **16,16'** can be in the form of wire or a foil strip or any other electrical conductor means known in the art. The electric insulation layers **15** and **17**, are preferably of a flexible material, to conform to a component with curved surfaces, while maintaining its properties at high temperatures (if the component **10** is monitored at high

temperature). Materials that are known to be suitable for insulator layers include mica, fibreglass textiles and polyimide, among others. To hold this ultrasonic transducer assembly layers **12-17** to the component **10**, the clamp **18** is provided. The clamp **18** applies a stress that keeps the layers in intimate physical contact with each other and the component **10**. At the same time, the clamp **18** protects the assembly against external aggression.

[0030] The ultrasonic excitation generated by the piezoelectric layer **13** is typically better transmitted to the component **10** via a coupling layer **11**. The coupling layer **11** may be a liquid, gel, or solid and should be preferably thin compared to the wavelength of ultrasonic wave generated by the piezoelectric layer. Some materials that may be used as an coupling layer include ultrasonic liquid couplants, polymeric adhesive materials, silver and gold paste, soft metal foils like gold, aluminum, zinc and tin as well as low melting temperature metals like aluminum, zinc, tin and other alloys known in the art of soldering and brazing.

[0031] To facilitate installation of the ultrasonic transducer assembly of the present invention to component **10**, the layers **12** to **18** may be preferred to be preassembled in a manufacturing facility. The preassembled transducer is then installed to the component to be monitored **10** after preparing its surface, if needed, and applying the coupling layer **11**. Some coupling layers solutions may need a thermal treatment to obtain the desired properties, and some operate only at certain temperatures.

[0032] A multi-element ultrasonic transducer assembly can also be of interest. FIG 3 shows an example of an embodiment, which is similar to a one-element configuration shown in FIG. 2 but have many elements along the component **10**. The electrical conductor **16** in this embodiment connect the top electrode **14** of each element of transducer subassembly independently of the connection box **20** allowing independent ultrasonic operation for each element. The bottom electrode connection **16'**, or ground connection, is common for all elements. It will be noted that independently addressable elements may be desired for different purposes, and parallel insulated conductors between the top and bottom insulating layers **15,17** can be provided.

[0033] There are many configurations for layers of the ultrasonic transducer assembly of this invention that can conform to curved surfaces of the component to be monitored. The transducer assembly configuration shown in FIG. 4A as an enlarged cross-sectional view, is similar to those already described in FIG. 2 and FIG. 3 with a coupling layer **11**, making intimate contact to the component **10** and the bottom electrode **12**. The piezoelectric layer

13 is in intimate physical contact with bottom electrode **12** and the top electrode **14**. The electrical conductor **16** is in conductive contact with the top electrode **14** at one of its ends through a hole in the bottom insulator **15**, and at the other of its ends, at the connection box **20** or the electronic control **22** (depending on the control arrangement chosen). Two insulator layers, the bottom insulator layer **15** and top insulator layer **17** may be used to insulate the electrical conductor **16** from other conductive parts of the assembly.

[0034] Alternatively a single top insulator could be used, with an alternative insulation provided, to the extent needed. Clamp **18** keeps the layers that need intimate physical contact together, and at the same time, may protect the assembly against external aggression.

[0035] Another transducer assembly configuration is shown in FIG. 4B with an enlarged cross-sectional view. Similar reference numerals denote analogous elements, and their description is not repeated herein. In this case, the piezoelectric layer **13** is in intimate contact with the component **10**. This intimate contact can be obtained by the fabrication of the piezoelectric film **13** directly on the surface of component **10** or alternatively by bonding a piezoelectric film to the component to be monitored with a binder with similar characteristics to the piezoelectric layer. In this embodiment the bottom electrode is provided by the component **10**, and electrical connection with this ground plane is provided to the connection box or electrical control (not shown).

[0036] FIG. 4C schematically illustrates an enlarged cross-sectional view of a transducer assembly in which the clamp **18** is also bottom electrode **12**. In this example, the piezoelectric layer **13** is in intimate contact with the clamp **18**. This configuration may be particularly useful wherein the chosen coupling layer **11** needs a higher stress mechanical constraint to make intimate physical contact with the component **10** to allow efficient transmission of the ultrasonic waves, e.g. if the surface of the component is particularly rough, or the couplant **11** is stiff. The remainder of the flexible ultrasonic transducer may be the same as above, but it may further be desirable to provide a protective layer **19**, to surround the top insulating layer **17** to protect the assembly against external aggression. Protective layer **19** need not apply any appreciable pressure to the insulating layer **17**.

[0037] FIG. 4D schematically illustrates an enlarged cross-sectional view of a transducer assembly having no couplant **11** other than the bottom electrode **12**, that may be a soft metal foil.

WHAT IS CLAIMED IS:

1. An ultrasonic transducer assembly, comprising:
 - a piezoelectric film able to conform to curved surfaces;
 - an electrode adjacent to a top surface of the piezoelectric film to make the piezoelectric film able to act as an ultrasonic transducer;
 - a flexible insulating layer covering the top electrode and at least part of a first electrical connector extending from the top electrode to an electronic control, the insulating layer having a shape and size to substantially surround a section of a component to be monitored; and
 - a permanent or semi-permanent clamp adapted to apply at least a 0.2 MPa compressive stress on a region of the component aligned with the top electrode.
2. The transducer assembly of claim 1 wherein the transducer assembly is flexible, and the clamp comprises a band that, when tensioned, causes the assembly to conform to a convex surface of the section of the component.
3. The transducer assembly of claim 1 further comprising the component, which has the form of a pipe or a pipe fitting.
4. The transducer assembly of claim 1 wherein all materials used to fabricate the assembly retain sufficient structural, electrical, and chemical integrity to operate at high temperatures.
5. The transducer assembly of claim 4 wherein the piezoelectric film has a composition consistent with fabrication using one or more layers of a mixture of a piezoelectric powder and organic precursors of dielectric and/or piezoelectric material, wherein the after heat treatment the piezoelectric film has a level of porosity that improves flexibility, resistance to thermal shock and ultrasonic bandwidth.
6. The transducer assembly of claim 1 further comprising an ultrasonic coupling layer composed of an ultrasonic transmitting material making intimate physical contact with the transducer assembly at a top surface, and for making intimate physical contact with the component at a bottom surface.

7. The transducer assembly of claim 6 wherein the coupling layer comprises a high temperature paste or liquid, or a soft metal, such as aluminum, gold, tin, zinc or other alloys known to the art of soldering and brazing.
8. The transducer assembly of claim 6 wherein the coupling layer comprises a metal foil, and wherein:
 - the clamp is adapted to apply at least 1 MPa compressive stress;
 - the clamp is adapted to apply at least 10 MPa compressive stress;
 - the clamp is adapted to apply an initial compressive stress greater than 1 MPa to plastically deform the metal foil, and a far lower compressive stress thereafter; and
 - the metal foil was strained by a much greater compressive stress than the clamp, which serves only to maintain intimate physical contact between the assembly and component.
9. The transducer assembly of claim 1 further comprising a bottom electrode electrically coupled to the component, which is sufficiently conductive to serve as a ground for the flexible ultrasonic transducer.
10. The transducer assembly of claim 1 further comprising a bottom electrode electrically coupled to the electronic control by a second electrical connector that is insulated from the first electrical connector.
11. The transducer assembly of claim 1 wherein the insulating layer comprises a conductive path between top and bottom insulations, with a via through the bottom insulation for providing electrical contact between the conductive path and the top electrode.
12. The transducer assembly of claim 1 wherein the insulating layer comprises a layer of mica or polyimide.
13. The transducer assembly of claim 1 wherein a surface of the component serves as a bottom electrode of the flexible ultrasonic transducer, and has an electrical connection to the electrical control.
14. The transducer assembly of claim 13 wherein the piezoelectric layer is bonded to the component to be monitored by a ceramic binder made from organic precursors of a piezoelectric and/or dielectric ceramic.

15. The transducer assembly of claim 1 wherein the clamp is a band that also serves as a bottom electrode for the flexible ultrasonic transducer and the flexible ultrasonic transducer is deposited directly on the clamp.
16. The transducer assembly of claim 15 further comprising a protective layer surrounding the insulating layer.
17. The transducer assembly of claim 1 wherein the clamp is a band that also serves as a protective cover for the flexible ultrasonic transducer, surrounding the insulating layer.
18. The transducer assembly of claim 1 wherein a plurality of similar separate piezoelectric films are spaced along the insulating layer to provide a transducer array.
19. The transducer assembly of claim 18 wherein the separate films are independently electronically addressable by the electronic control, or commonly electronically controlled.
20. The transducer assembly of claim 1 wherein the clamp is a tube clamp, comprising a deformable band for surrounding the section, formed of metal or a fibreglass textile.
21. The transducer assembly of claim 1, wherein the clamp includes a tensioning mechanism, having a spring or spring washer to maintain a constant tension under different thermal conditions.
22. A method for producing a transducer assembly, the method comprising:
providing a flexible ultrasonic transducer, including at least a top electrode adjacent to a flexible piezoelectric film;
bonding said top electrode to an insulating layer, the insulating layer having a shape and size to substantially surround a section of a component to be monitored,
providing insulated electrical connection from the top electrode to an electronic control,
and
providing a permanent or semi-permanent clamp adapted to apply at least a 0.2 MPa compressive pressure on a region of the component aligned with the top electrode.
23. The method of claim 22 further comprising:
preparing a part of a surface of the section of the component;
applying a couplant to the part of the surface to provide intimate physical contact between the couplant and the surface; and

mounting the previously assembled layers to the couplant to provide intimate physical contact between the couplant and the flexible ultrasonic transducer.

24. The method of claim 23 wherein applying the couplant comprises applying a foil of mounting the previously assembled layers comprises applying a soft metal, such as aluminum, gold, tin, zinc or other alloys known to the art of soldering and brazing as a foil, and wherein mounting the previously assembled layers comprises apply an initial compressive stress greater than 1 MPa to plastically deform the soft metal foil.

25. The method of claim 23 wherein one of the couplant and the component is not electrically conductive, and providing the flexible ultrasonic transducer comprises applying a bottom electrode and an insulated conductor from the bottom electrode to the electrical control.

26. The method of claim 25 wherein the bottom electrode is provided with a metal foil such as titanium or stainless steel foil.

27. The method of claim 23 wherein applying the couplant comprises applying an adhesive material, such as a polymer based glue, silver paste, ceramic cement, glass known in the art of adhesive bonding.

28. The method of claim 22 wherein providing the flexible ultrasonic transducer comprises applying one or more layers of a mixture of a piezoelectric powder and organic precursors of dielectric and/or piezoelectric material; heat treating the applied layers; and poling the applied layers to produce the piezoelectric film.

29. The method of claim 28 wherein providing the flexible ultrasonic transducer comprises applying the top electrode as a silver or gold paste or by thin film deposition of a conductive metal, such as gold, silver, platinum or aluminum.

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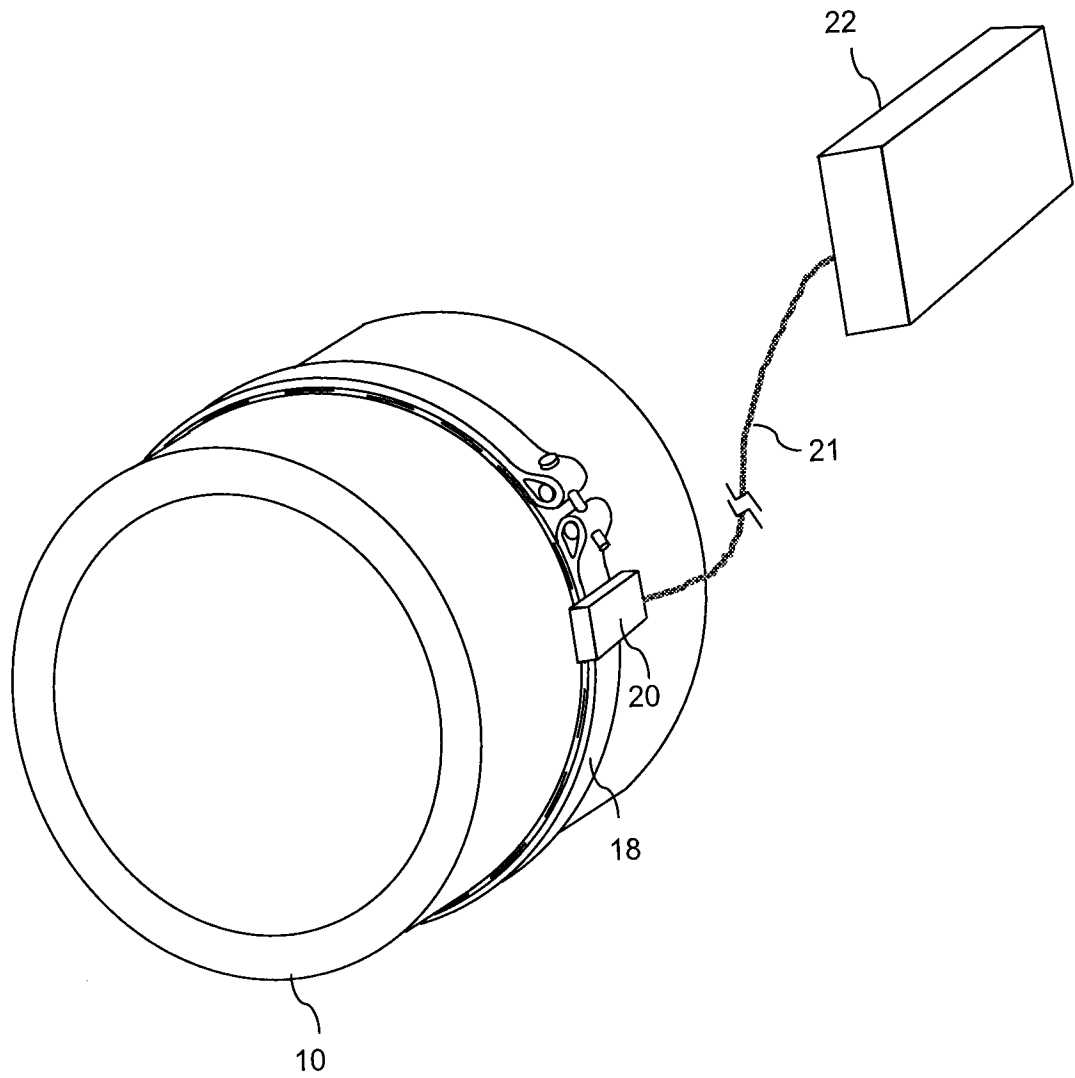


FIG. 1

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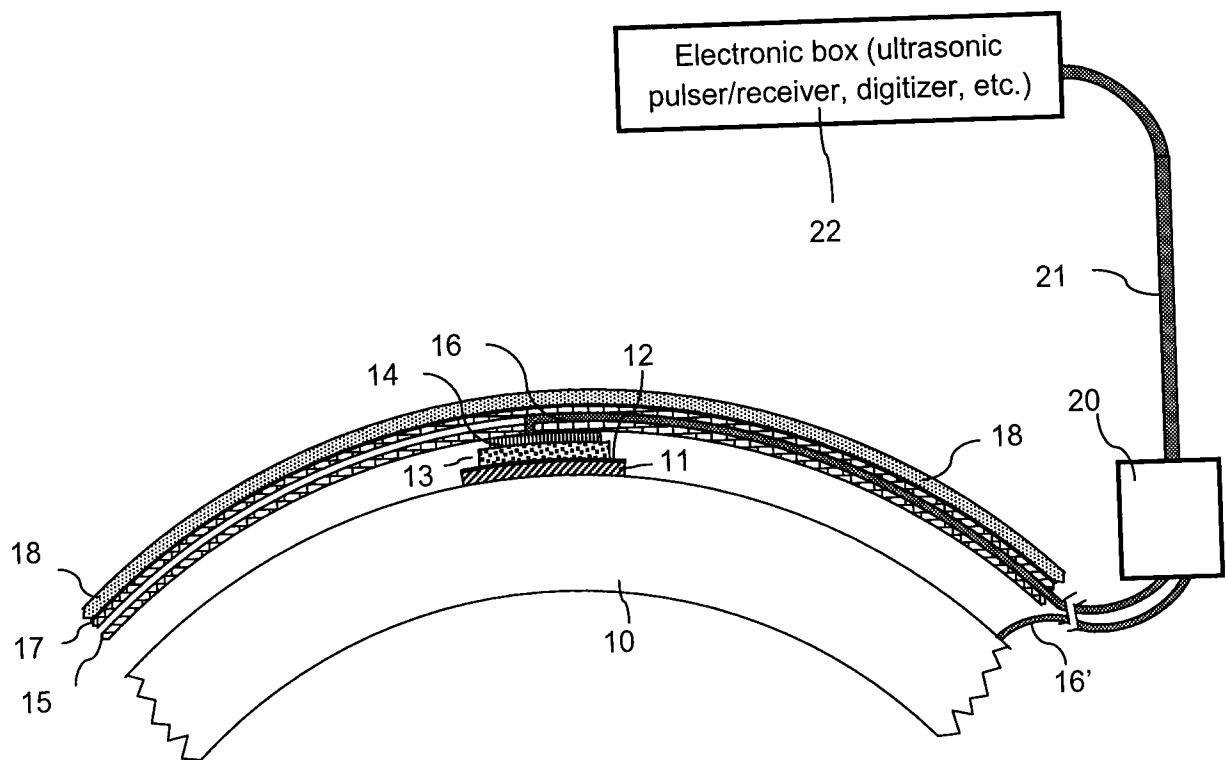


FIG. 2

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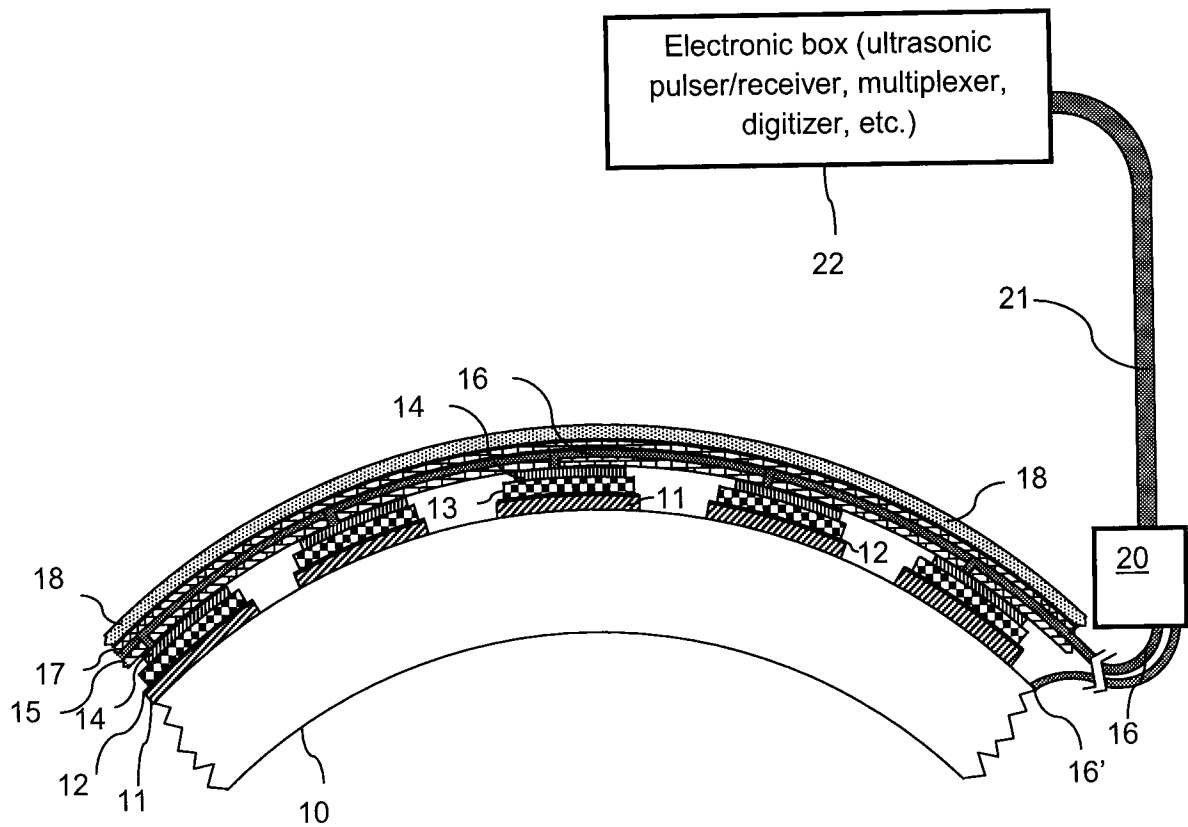


FIG. 3

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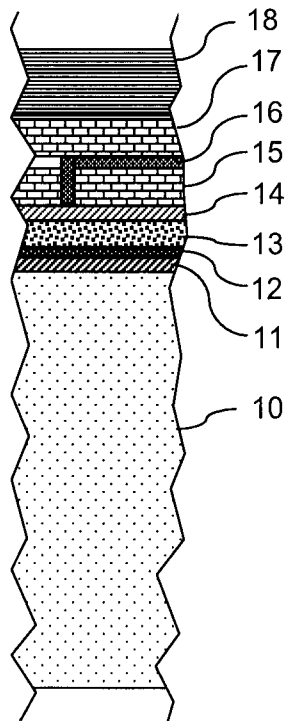


FIG. 4A

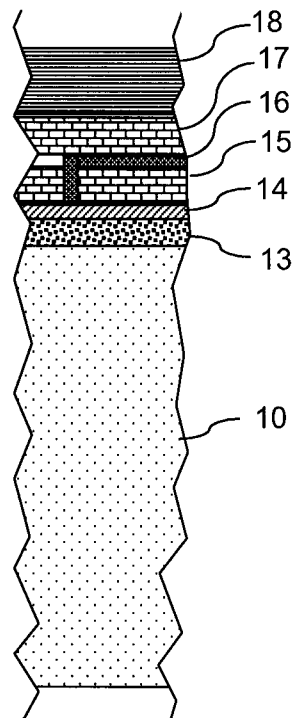


FIG. 4B

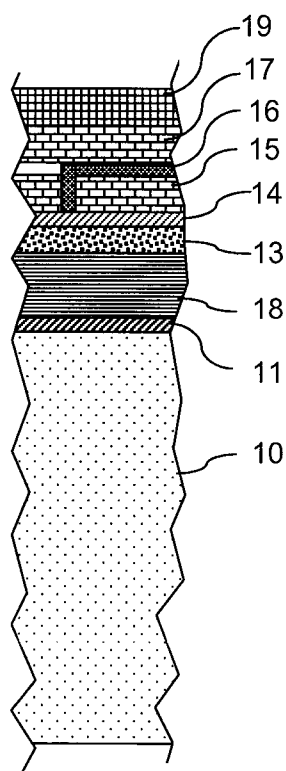


FIG. 4C

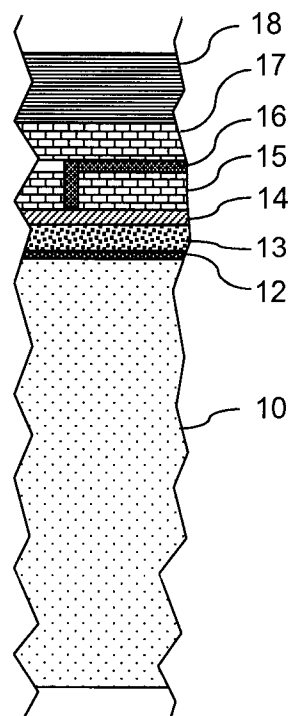


FIG. 4D

INTERNATIONAL SEARCH REPORT

International application No.
PCT/CA2011/001234

A. CLASSIFICATION OF SUBJECT MATTER IPC: G01N 29/22 (2006.01) , G01N 29/28 (2006.01) According to International Patent Classification (IPC) or to both national classification and IPC																				
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) IPC: G01N (2006.01) (using keywords) Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched Electronic database(s) consulted during the international search (name of database(s) and, where practicable, search terms used) Canadian Patent Database, Epoque, Esp@cenet, TotalPatent, United States Patent Database (USPTO), WEST. Keywords: conductors, electrodes, flexible, insulators, piezoelectric film, pipe, stress, transducer, ultrasonic.																				
C. DOCUMENTS CONSIDERED TO BE RELEVANT <table border="1"> <thead> <tr> <th>Category*</th> <th>Citation of document, with indication, where appropriate, of the relevant passages</th> <th>Relevant to claim No.</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>US 5922961 (Hsu et al.) 13 July 1999 (13-07-1999) - see entire document</td> <td>1-29</td> </tr> <tr> <td>A</td> <td>CA 2459921 (Zloter et al.) 22 December 2009 (22-12-2009) - see entire document</td> <td>1-29</td> </tr> <tr> <td>A</td> <td>CA 2667751 (Dausch et al.) 8 May 2008 (08-05-2008) - see entire document</td> <td>1-29</td> </tr> <tr> <td>A, P</td> <td>CN 201804553 (Yurong et al.) 20 April 2011 (20-04-2011) - see entire document</td> <td>1-29</td> </tr> <tr> <td>A, E</td> <td>CA 2745558 (Krohn et al.) 21 January 2012 (21-01-2012) - see entire document</td> <td>1-29</td> </tr> </tbody> </table>			Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.	A	US 5922961 (Hsu et al.) 13 July 1999 (13-07-1999) - see entire document	1-29	A	CA 2459921 (Zloter et al.) 22 December 2009 (22-12-2009) - see entire document	1-29	A	CA 2667751 (Dausch et al.) 8 May 2008 (08-05-2008) - see entire document	1-29	A, P	CN 201804553 (Yurong et al.) 20 April 2011 (20-04-2011) - see entire document	1-29	A, E	CA 2745558 (Krohn et al.) 21 January 2012 (21-01-2012) - see entire document	1-29
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☐ Further documents are listed in the continuation of Box C. ☒ See patent family annex. <table border="1"> <tbody> <tr> <td>* Special categories of cited documents :</td> <td>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</td> </tr> <tr> <td>"A" document defining the general state of the art which is not considered to be of particular relevance</td> <td>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</td> </tr> <tr> <td>"E" earlier application or patent but published on or after the international filing date</td> <td>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</td> </tr> <tr> <td>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</td> <td>"&" document member of the same patent family</td> </tr> <tr> <td>"O" document referring to an oral disclosure, use, exhibition or other means</td> <td></td> </tr> <tr> <td>"P" document published prior to the international filing date but later than the priority date claimed</td> <td></td> </tr> </tbody> </table>			* Special categories of cited documents :	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention	"A" document defining the general state of the art which is not considered to be of particular relevance	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone	"E" earlier application or patent but published on or after the international filing date	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art	"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"&" document member of the same patent family	"O" document referring to an oral disclosure, use, exhibition or other means		"P" document published prior to the international filing date but later than the priority date claimed							
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Date of the actual completion of the international search 13 February 2012 (13-02-2012)		Date of mailing of the international search report 22 February 2012 (22-02-2012)																		
Name and mailing address of the ISA/CA Canadian Intellectual Property Office Place du Portage I, C114 - 1st Floor, Box PCT 50 Victoria Street Gatineau, Quebec K1A 0C9 Facsimile No.: 001-819-953-2476		Authorized officer Tung Nguyen (819) 956-3859																		

INTERNATIONAL SEARCH REPORT
Information on patent family members

International application No.
PCT/CA2011/001234

Patent Document Cited in Search Report	Publication Date	Patent Family Member(s)	Publication Date
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CN201804553U	20 April 2011 (20-04-2011)	None	
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