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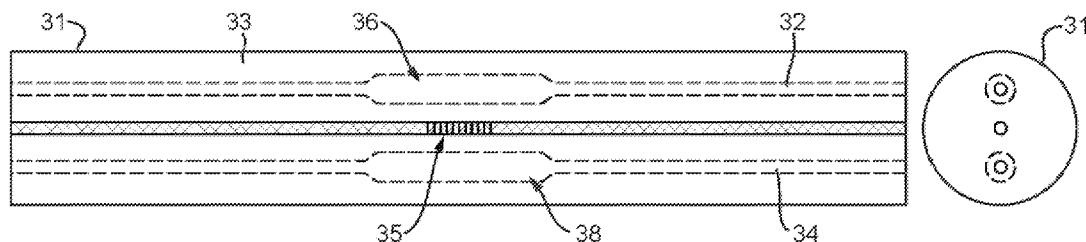


Fig. 7

(57) Abstract: A method for forming a pressure sensor is provided wherein an optical fibre is provided, the optical fibre comprising a core, a cladding surrounding the core, and a birefringence structure for inducing birefringence in the core. The birefringence structure comprises first and second holes enclosed within the cladding and extending parallel to the core. A portion of the optical fibre comprising the core and the birefringence structure is encased within a chamber, wherein the chamber is defined by a housing comprising a pressure transfer element for equalising pressure between the inside and the outside of the housing. An optical sensor is provided along the core of the optical fibre. Providing the optical sensor comprises optically inducing stress in the core so that the optical sensor exhibits intrinsic birefringence. The chamber is filled with a substantially non-compressible fluid. Consequently, the birefringence structure is shaped so as to convert an external pressure provided by the non-compressible fluid within the chamber to an anisotropic stress in the optical sensor.



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A METHOD FOR FORMING A PRESSURE SENSOR

FIELD OF THE INVENTION

The present invention relates to an optical fibre-based pressure sensor, a method for forming the pressure sensor and a system for monitoring pressure.

BACKGROUND TO THE INVENTION

10 Pressure is an important measurand to acquire when determining the status of a hydrocarbon reservoir and managing it effectively. Pressure sensors may be of a variety of types, each of which has its own advantages and disadvantages. A common type of sensor for downhole pressure measurement is the resonant quartz transducer. These devices can deliver excellent metrology performance and stability but their reliability is limited at high temperatures. These sensors are
15 also expensive and it is difficult to deploy many of them within a hydrocarbon well because each one typically requires its own cable for power and data transmission. Each of these cables forms a penetration through surface and sub-surface pressure barriers, which increases the number of potential leak points within the high pressure environment.

Optical fibre-based sensors have the potential to be more reliable at higher operating
20 temperatures since they do not require local electronics to operate in the harsh downhole environment. For example, these sensors may remain operational at pressures up to and in excess of 200 MPa and temperatures up to and in excess of 350 degrees Celsius. An additional benefit of some types of fibre-optic sensor is that several can be multiplexed on one cable, thereby reducing the number of cables required. Furthermore the absence of conditioning electronics in such sensors
25 allows the pressure sensors to be made smaller, thereby facilitating their deployment in more downhole locations.

It is known to use a Fibre Bragg Grating (FBG) within a fibre-optic pressure sensor. An FBG is an intrinsic optical sensor recorded within the core of an optical fibre using spatially-varying patterns of intense ultraviolet or infrared laser light to create periodic modulations in a
30 refractive index of the fibre. These modulations in the refractive index give rise to a wavelength selective mirror, whereby light travelling down the waveguide is partially reflected at each of the interfaces or gratings, whilst the remaining light is transmitted through the sensor. Maximum reflectivity occurs at the Bragg wavelength, which is a property of the FBG and is dependent on both the periodicity of the refractive index and the effective refractive index of the waveguide.

- 5 Changes in the temperature, pressure or strain at the sensor can give rise to a change in each of the periodicity and the refractive index, thus leading to a detectable change in the Bragg wavelength.

For some fibre-optic pressure sensors which utilise FBGs, the fibre is designed so that a uniform external pressure applied to the fibre is converted into an anisotropic force in the core of the waveguide. The effect of this is to induce pressure-dependent birefringence in the core. This
10 birefringence causes the reflection peak of the FBG to split in two such that the separation of the peaks is only a function of pressure. An early example of this is discussed in US 5841131. Unlike a conventional FBG, the grating is written into a waveguide containing a pair of air holes extending parallel to and on opposite sides of the core. The effect of these holes is to turn a hydrostatic pressure outside of the sensor into an asymmetric stress distribution in the core of the sensor.
15 Specifically, the stress parallel to the plane of the air-holes differs from the stress perpendicular to this plane. This causes a difference in refractive indices along the core, which leads to two different shifts in the reflection peak of the Bragg wavelength. Two reflection peaks may therefore be observed: one associated with light having polarisation parallel to the plane of the air-holes and another associated with light having a polarisation perpendicular to this. Changes in the
20 hydrostatic pressure outside of the sensor cause the wavelength separation of these peaks to change. Errors due to temperature, thermal gradients or changes in the physical characteristics of the grating are suppressed since these factors will affect the wavelength of both reflection peaks similarly and will not change the value of the peak separation. The sensing mechanism is completely within the optical fibre or waveguide and so there is no need for mechanical parts or
25 bonding mechanisms which could introduce hysteresis or instability. Furthermore the sensor is made entirely from fused SiO₂, a material with excellent elastic properties, high strength and very good resistance to creep. Thus, this 'side-hole sensor' concept can be used as the basis of an effective pressure sensor for harsh, high-pressure and high-temperature environments.

The pressure sensitivity of a side-hole fibre is a function of the size and location of the air
30 holes. The larger the holes and the closer they are to the core, the higher the sensitivity. If the hole spacing is smaller than a certain value, typically around 10 microns, the guiding characteristics of the pressure sensor will begin to deviate from those of conventional single-mode optical fibres. This will lead to higher optical losses when connecting the sensor to such a fibre, which can be a significant disadvantage, particularly if many sensors are to be multiplexed together. The size of
35 the holes is limited by the size of the waveguide. Increasing the diameter allows the designer to increase the sensitivity by making the holes or other features larger relative to the size of the core.

5 Diameters of 0.3 mm and higher are suggested in US 8687926 B2, however the larger the waveguide, the harder it becomes to join to a standard 0.125 μ m-diameter optical fibre.

10 Side-hole fibres are formed by drilling holes into a fibre preform. The preform is then heated and drawn, with careful process control process being employed to prevent the holes from collapsing. The asymmetry of the side-hole fibre means that as the fibre cools and shrinks, some asymmetry of stresses may be set up in the core. If this asymmetry of stress is small, then an FBG inscribed in this fibre will show a single peak. If the asymmetry is pronounced, then there may be some initial distortion or splitting of the peak, even before hydrostatic pressure is applied.

15 Techniques for controlling the birefringence of the waveguide which are independent of the drawing process and the presence of the side-holes have previously been proposed. For example US 5841131 suggests the use of an elliptical guiding structure surrounding the core. Optical fibres having an intrinsic birefringence can also be formed by providing internal means of applying asymmetric stresses to the core. This is typically achieved by distributing glass elements of a different composition asymmetrically around the core, as described by Udd "Review of multi-parameter fiber grating sensors", Fiber Optic Sensors and Applications V, ed. E. Udd, Proc. of SPIE Vol. 6770, 677002, 2007. These elements have a higher coefficient of thermal expansion than the surrounding cladding and when they cool from the high temperatures of the fibre drawing process they contract more, applying mechanical stress to the core. An FBG written in such a fibre may show the characteristic broadened or split peaks of the side-hole fibre described above. However, placing a structure outside the core may reduce the minimum separation of the air-filled side holes, leading to a reduction in sensitivity which can only be overcome by making larger holes in a larger fibre. It may also be difficult to drill holes in a preform which already contains stress-creating elements such as an elliptical core or bowtie features, since the internally-stressed preform may be too weak to survive the mechanical disturbances of the drilling process. Larger fibres or waveguides are more difficult to splice onto standard optical fibres. Furthermore if the core itself is asymmetrical, its guiding properties will differ from those of the core of a standard symmetrical optical fibre and this will lead to optical losses when the two are connected.

30 It is known that birefringent FBGs can be created in the core of a symmetrical optical fibre if the refractive index modulations created by the writing method are not circularly symmetric. For example, Jovanovic *et al.* Optics Express, 2009 Apr 13;17(8):6082-6095 discusses that an elliptical zone of refractive index modulation produced by point-by-point femtosecond laser inscription may create such an FBG with peak separations of tens of picometres. Chah *et al.* Optics

- 5 Letters. 2013 Feb 15;38(4):594-6 demonstrated that it is possible to separate the Bragg wavelength peaks by up to 800 pm by carefully focusing the laser used to write the grating away from the centre of the core. Mihailov *et al.* Laser Chemistry, vol. 2008, Article ID 416251, 20 pages, 2008 discusses the use of a femtosecond laser with a phase mask to induce a similar degree of peak separation by writing grating structures adjacent to but not overlapping the core of the fibre.
- 10 There remains a need to improve the sensitivity and accuracy of pressure sensors. It is also desirable for the cost and size of these devices to be reduced while maintaining mechanical robustness, excellent reliability and measurement performance. The present invention seeks to address these problems.

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SUMMARY OF THE INVENTION

A first aspect of the invention provides a method for forming a pressure sensor comprising:
providing an optical fibre comprising a core, a cladding surrounding the core, and a
birefringence structure for inducing birefringence in the core, wherein the birefringence structure
comprises first and second holes enclosed within the cladding and extending parallel to the core;
10 encasing a portion of the optical fibre comprising the core and the birefringence
structure within a chamber, wherein the chamber is defined by a housing comprising a pressure
transfer element for equalising pressure between the inside and the outside of the chamber;
providing an optical sensor along the core of the portion of optical fibre, wherein
providing the optical sensor comprises optically inducing stress in the core so that the optical
15 sensor exhibits intrinsic birefringence; and
filling the chamber with a substantially non-compressible fluid;
wherein the birefringence structure is shaped so as to convert an external pressure
provided by the non-compressible fluid within the chamber to an anisotropic stress in the optical
sensor.

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The pressure transfer element enables hydrostatic pressure acting on the outside of the
housing to be transmitted into the inside of the chamber. The optical fibre is formed so that this
pressure is converted into anisotropic stress at the core of the optical fibre. In particular, strong
variations in the stress and hence the refractive index are achieved in response to a change in the
25 pressure applied to the chamber. As a result, when light is transmitted along the core, it will be
reflected by the optical sensor at two different characteristic wavelengths, typically corresponding
to respective peak wavelengths. The pressure at the sensor may then be calculated from the
difference between these wavelengths.

25

The birefringence structure generally ensures that the birefringence of the optical sensor (and
30 therefore the peak separation) varies according to the hydrostatic pressure within the chamber.
However, the optical sensor itself is formed so as to have an intrinsic birefringence which is not
pressure-dependent. This is achieved by optically inducing stress in the core of the optical fibre.
The combination of a birefringence structure and the birefringent optical sensor ensures that the
pressure sensor has a high sensitivity to pressure and to transverse mechanical loads, particularly
35 at low pressures. For example, the intrinsic birefringence of the optical sensor generally ensures
that the reflection spectrum produced by the optical sensor comprises two individually resolvable
peaks even at atmospheric pressure.

35

5 The process of drilling and drawing a preform to make a birefringent, mechanically-sensitive fibre (as discussed in the prior art) will allow certain combinations of side-hole position, size and internal stress (and hence birefringence). However these combinations will not necessarily permit the production of a fibre with the optimum combination of optical and mechanical properties, since these properties cannot generally be adjusted independently. A further advantage of optically
10 inducing stress in the core (as proposed herein) is that this only affects the optical properties, not the mechanical ones. Thus, a drawing process may be used to form a structure with good mechanical properties but sub-optimal optical qualities, and then the above optical process followed for achieving the desired optical characteristics.

 The method preferably further comprises a step of internally etching the cladding by flowing
15 an etchant through the first and second holes along a length of the portion of optical fibre which comprises the optical sensor so as to increase the width of the first and second holes. Internally etching the cladding increases the width of the first and second holes in a direction perpendicular to the axis of the first and second holes. This in turn increases the amount by which the birefringence changes at the optical sensor in response to changes in pressure (referred to herein
20 as the “birefringence sensitivity”). Ten-fold increases in the sensitivity of the pressure sensor may be achieved according to this technique compared with if no internal etching had been performed.

 The presence of the first and second holes and their subsequent enlargement reduces the cross-sectional area of the optical fibre and so may make it more fragile and liable to break. Advantageously therefore, the cladding is etched in situ within the housing that later forms part of
25 the pressure sensor. This housing supports the fibre during the internal etching and protects the etched fibre thereafter. More cladding material can therefore be removed according to this technique because the fibre does not need to be strong enough to withstand any kind of bending or stretching that may occur during handling. When the pressure sensor is formed, the load exerted by the non-compressible fluid can be controlled, for example by setting a maximum operating
30 pressure for the pressure sensor.

 The step of providing an optical sensor along the core of the portion of optical fibre may occur before or after the portion of optical fibre has been encased in the housing, as well as before or after etching. For example, if the optical sensor is provided before said encasement then it is formed at a location on the optical fibre corresponding to the encased portion of optical fibre.
35 Typically the optical sensor is a Fibre Bragg Grating (FBG) however other optical sensors such as

- 5 Long-Period Gratings, blazed or chirped fibre Bragg gratings, interferometric, spectroscopic or intensity-based sensors are also envisaged.

Typically the step of filling the chamber with a substantially non-compressible fluid forms the pressure sensor. For example this may occur after all etching processes have occurred and whilst the portion of optical fibre is encased within the housing. The substantially non-compressible fluid acts as a pressure transfer medium between the pressure transfer element and the optical fibre. The chamber is typically filled or substantially filled with liquid at this point to achieve this pressure transfer. The substantially non-compressible fluid may comprise any of the following: mineral oil, silicone oil, grease or a liquid metal based on gallium or indium and their alloys.

15 The optical sensor is typically written to the core using a high power light source capable of inducing internal stresses within the optical fibre. The step of providing the optical sensor therefore typically comprises inscribing the optical sensor onto the core using a femtosecond laser. However, this step could alternatively be performed using an ultraviolet laser asymmetrically focused on the core. The high power light source may, for example, induce localised melting and resolidification of the fibre, thereby creating zones of higher density core material having a higher refractive index. These zones may be arranged so as to create a wavelength selective mirror, typically in the form of an FBG. The resolidified zones will have a different density relative to their original state, which induces a stress on the neighbouring unaffected regions. Such stress may induce intrinsic birefringence in the optical sensor. Light may additionally be directed from the high power light source onto cladding material surrounding the core in order to further modify the birefringence in the optical sensor.

The use of the femtosecond laser advantageously allows the optical sensor to be written into a material which is not photosensitive. Thus, a fibre with a pure silica core could be used, instead of the germanium-doped silica core typically used in optical fibres. An advantage of using a pure silica core is that it has a greater resistance to hydrogen darkening when used in an environment containing hydrogen, such as the bore of an oil or gas well. An ultraviolet laser emitting light with a longer pulse length than that of the femtosecond laser could alternatively be used if asymmetrical focusing were applied to the core. However, this method would be less flexible as it only has an effect on photosensitive material and, in an optical fibre, this is typically the doped core (or doped cladding in the case of a fibre with a pure silica core).

5 Another advantage of using a femtosecond laser is that the light may penetrate any coatings provided on the outside of the fibre when writing the optical sensor to the core. The optical fibre therefore preferably further comprises a coating surrounding the cladding, and providing the optical sensor may then comprise directing light from the femtosecond laser through the coating onto the core. Suitable coatings include those made of polymers such as acrylate, silicone and
10 polyimide, and with inorganic coatings. Indeed, if a silicone coating is used then light from a UV laser may be directed through the coating onto the core instead of from a femtosecond laser. An inorganic coating, such as hermetic carbon, is preferably used as it would offer the highest degree of environmental protection to the optical fibre sensor by preventing the ingress of hydrogen, water and OH⁻ groups into the fibre. This may be particularly useful in oil and gas applications.
15 However, alternative coatings could be employed to protect the fibre, such as gold or aluminium oxide. Provided that the thickness of the coating is sufficiently thin, the femtosecond laser will be able to penetrate the coating and write the optical sensor to the core. Such thin coatings may generally be applied by a physical or chemical vapour deposition process, and so the method may further comprise a step of applying the coating to the cladding by a physical or chemical or vapour
20 deposition process.

The optical sensor may generally be formed by creating an asymmetric intensity distribution of light across the fibre, thus creating an asymmetric region of modified material having modified properties in terms of refractive index and stress. This may be achieved by any of a number of known processes. The step of providing the optical sensor may therefore comprise inscribing the
25 optical sensor using a point-by-point process, a line-by-line process or by directing light onto the core through a phase mask.

The first and second holes preferably remain enclosed within the cladding after the internal etching. Thus the cladding is not etched by the liquid etchant to the extent so that the first and second holes become exposed. The first and second holes may therefore remain internally formed
30 within the cladding both before and after the internal etching.

In some instances it is desirable to increase the birefringence sensitivity within one or more regions of the encased portion of optical fibre, for example those surrounding any optical sensors. This may be achieved by targeted heating of the etching fluid so as to increasing the etching rate in these regions. Preferably therefore the method further comprises heating the cladding during
35 the internal etching using a localised heat source. Typically the localised heat source comprises a resistive coil, a Peltier heater or an induction coil. An electric current may be applied to this

5 resistive coil to generate heat at certain regions surrounding the optical fibre through ohmic heating. Other localised heat sources are also envisaged, including a laser. For example a light source used to form the optical sensor may also be used to heat the cladding during the internal etching. Typically a liquid etchant comprising a mixture of aqueous solutions of ammonium fluoride and hydrofluoric acid, such as Buffered Oxide Etch, is used in combination with this
10 heating method. Such etchants provide a predictable increase in the etching rate in response to changes in temperature.

The birefringent structure enables a uniform external pressure applied to the outside of the cladding to be converted into anisotropic forces in the core of the waveguide. In order to help create these anisotropic forces, the axes of the core and the first and second holes may lie within a
15 common plane. Typically the first hole is provided on the opposing side of the core from the second hole.

Further increases in the birefringence sensitivity may be achieved by providing additional features to the birefringence structure. It is particularly desirable that the birefringence structure further comprises third and fourth holes enclosed within the cladding and extending parallel to the
20 core. The method may then further comprise externally etching the cladding along a length of the portion of optical fibre which comprises the optical sensor so as to expose the third and fourth holes.

An improved process for producing a pressure sensor may therefore be provided wherein further etching is applied to the cladding, in particular to the outside of the cladding, to lead to
25 further increases in the birefringence sensitivity. Furthermore, the external etching step, which changes the profile of the fibre, is performed after the sensor has been incorporated into a protective housing. This reduces the risk of mechanical damage during construction since the etched optical fibre does not need to be handled. A good optical coupling is also maintained because the externally etched length of the optical fibre is not directly spliced onto another fibre.
30 External etching may instead occur within an internal chamber of the housing that later forms part of the pressure sensor. An end of the optical fibre that has not been externally etched and which trails from the housing may instead be spliced onto a similarly shaped fibre, if needed. This is easier to achieve without the optical fibre breaking and whilst maintaining a good optical coupling than a process of splicing two differently shaped optical fibres together. Furthermore, the chamber
35 provides a dual purpose of providing a volume for containing the etchant during external etching

- 5 and providing a volume for containing the substantially non-compressible fluid. This further simplifies the method of manufacture for the pressure sensor.

Selective removal of the cladding through external and internal etching results in external hydrostatic pressure provided by the non-compressible fluid being converted into changes in the degree of anisotropy of stress in the core. This changes the birefringence at the optical sensor. For example, an increase in anisotropic stress may increase the birefringence at the optical sensor. The third hole is typically provided on an opposing side of the core from the fourth hole. If the etching were to significantly erode the cladding between one or each of the third and fourth holes and the core then the core could become damaged thereby affecting its optical transmission properties. The external etching may hence be controlled so as to expose the third and fourth holes without significantly removing the cladding between each of the third and fourth holes. Typically therefore the perimeter of the externally etched cladding may comprise a partial outline of the third and fourth holes. For example, the externally etched cladding may have a cross-sectional outline, as viewed along the core, in the form of a bow tie. The etching may therefore be limited so as to avoid removing too much cladding from the optical fibre.

20 The external etching may be performed using laser ablation. Targeted removal of the cladding can therefore be achieved at localised areas on the fibre. This enables the production of certain etched shapes in the cross section of the fibre which are particularly desirable for inducing birefringence. The housing may therefore comprise a window for transmitting a laser beam directed onto the length of the portion of optical fibre.

25 Alternatively the external etching may comprise flowing an etching fluid into the chamber and immersing the outside of the cladding in said etching fluid until the third and fourth holes are exposed. Unlike laser ablation, this process will typically remove an equal amount of cladding around the outside of the cladding, as the optical fibre inside the chamber is immersed in the etching fluid. Other desirable shapes of optical fibre for inducing birefringence may be produced according to this technique. In this approach the method preferably further comprises flushing the etching fluid from the chamber prior to filling the chamber with the substantially non-compressible fluid. For example, the substantially non-compressible fluid may be injected into an inlet of the housing so as to expel the etchant from the chamber until said chamber is filled with the substantially non-compressible fluid. This process may prevent any unwanted etching due to the presence of residual etching fluid in the chamber.

5 The axes of the core and the first and second holes preferably lie within a first plane, and the axes of the core and the third and fourth holes preferably lie within a second plane, wherein the second plane is different from, and preferably perpendicular to, the first plane. The optical fibre may therefore have two mirror planes: one which extends along the first plane and perpendicular to the axis of the core; and another which extends along the second plane and perpendicular to the
10 core. The amount of cladding surrounding the core may be different along one of these mirror planes than along the other. The compression forces acting on the optical sensor along these two lines will therefore be different. Desirable levels of birefringence may hence be induced.

 Optionally, the sensitivity to pressure may be further increased wherein the birefringence structure further comprises one or more additional holes enclosed within the cladding and
15 extending parallel to the core, wherein the additional holes remain enclosed within the cladding after said internal and external etching.

 In another desirable implementation the birefringence structure further comprises third and fourth holes that are enclosed within the cladding and which extend parallel to the core, wherein the core is arranged between the first hole and the second hole and between the third hole and the
20 fourth hole. Typically the first and second holes and the core are arranged along a first plane, and the third and fourth holes and the core are arranged along a second plane (as before). However, internally etching the cladding may cause the first hole to merge with the fourth hole and the second hole to merge with the third hole. The resulting etched holes may both be dumbbell shaped along the portion of the fibre encompassing the optical sensor when viewed in a plane having a
25 normal parallel to the core. This is achieved by the removal of cladding between the first and fourth holes and the removal of cladding between the second and third holes. For example, the internally etching process may further comprise flowing an etchant through the third and fourth holes along a length of the portion of optical fibre which comprises the optical sensor. The internal etching may therefore give rise to a non-circular shaped void surrounding the optical sensor for
30 inducing birefringence in the optical sensor. Such a structure can be used to produce pressure sensors having a particularly high sensitivity to changes in pressure.

 The core itself may be pre-formed to exhibit birefringence. For example, an elliptical core could be used. The birefringence structure may then further increase the birefringence at the core in response to changes in pressure applied to the optical fibre by the non-compressible fluid.

5 The method may further comprise splicing one or each end of the optical fibre protruding from the housing with a respective single-mode optical fibre. Such single-mode fibres are commonly used for transmitting signals reliably over long distances at minimal cost. This single-mode optical fibre may then be connected to a light source and/or detector as part of a system for monitoring pressure. Optionally, any of the holes may be closed by splicing an end of the optical
10 fibre containing said holes on a section of solid fibre, or by using a flame or electric arc or other suitable heat source to fuse and collapse an end of the optical fibre containing said holes.

Further aspects of the invention will now be discussed. These share similar advantages and features as discussed in relation to the first aspect. In particular, any feature discussed in the context of a given aspect is equally applicable to the remaining aspects.

15 A second aspect of the invention provides a pressure sensor comprising:
a housing defining a chamber, the housing comprising a pressure transfer element for equalising pressure between the inside and the outside of the chamber;
a substantially non-compressible fluid contained within the chamber; and
an optical fibre, wherein a portion of the optical fibre is encased within the chamber, the
20 portion comprising a core, a birefringent optical sensor provided along the core, a cladding surrounding the core, and a birefringence structure, wherein the birefringence structure comprises first and second holes enclosed within the cladding and extending parallel to the core, and wherein the optical sensor is configured to produce a reflection spectrum having a first peak associated with a first polarisation mode and a second peak associated with a second polarisation mode,
25 wherein the centre of the first peak is separated from the centre of the second peak by a wavelength greater than the full width half maximum of the first peak and the second peak when the non-compressible fluid is at atmospheric pressure.

As discussed in relation to the first aspect, the cladding is hence shaped so as to convert changes in an external pressure provided by the non-compressible fluid within the chamber into
30 changes in an anisotropic stress on the optical sensor. In particular, the birefringence structure may be arranged to modify the birefringence of the optical sensor in response to changes in pressure provided by the non-compressible fluid. This can be used to monitor the pressure acting on the pressure transfer element. Furthermore, the optical sensor itself is provided with an intrinsic birefringence, which increases the sensitivity of the pressure sensor (particularly at low pressures),
35 and which allows greater freedom to produce a pressure sensor having good mechanical properties and good optical properties. The pressure sensor is typically configured such that the

5 birefringence structure increases the birefringence of the optical sensor in response to an increase in the pressure of the non-compressible fluid. This generally allows for a broader range of pressure measurements to be detected by calculating the peak separation of the reflected spectra, as will become apparent.

10 The first and second holes preferably have a larger cross sectional area along a region of the portion encompassing the optical sensor than along another region of the portion not encompassing the optical sensor. This larger cross sectional area (measured perpendicular to the axis of the holes) typically results from targeted internal etching, for example due to localised heating during the etching process (as earlier discussed). An enlarged void may hence be provided within each of the first and second holes along a specific region that encompasses the optical sensor. The
15 birefringence is consequently increased at these regions, without compromising the structural integrity of the remainder of the optical fibre. The enlarged voids are typically provided between two regions of the first and second holes having a comparatively smaller cross sectional area (the fibre being more stable in these regions). In one example, the diameter of the first and second holes may be at least 45 micrometres throughout the region of the portion of optical fibre
20 encompassing the optical sensor and at most 25 micrometres either side of this region.

Light which is transmitted along the optical fibre may be reflected from the optical sensor to produce a reflection spectrum. The birefringent optical sensor will typically reflect light at two separate peaks, as earlier discussed. The intrinsic birefringence of the optical sensor is preferably controlled such that these peaks are individually resolvable at atmospheric pressure (i.e. before
25 any further external load or pressure is applied to the pressure sensor). Each peak of the reflection spectrum will typically have a full width half maximum (FWHM) of between 0.18–0.25 nm, although optical sensors having a FWHM of from 0.1–2.0 nm may be used. The FWHM will typically be the same for the first and second peaks (to within detection resolution limits). Therefore, in order for each peak to be individually resolvable, the pressure sensor is formed such
30 that, when the non-compressible fluid is at atmospheric pressure, the centre of the first peak is separated from the centre of the second peak by at least 0.1 nm. More generally however the centre of the first peak may be separated from the centre of the second peak at atmospheric pressure by a wavelength separation equal or greater than the FWHM of the first or second peak. Typically this separation will be from 1 to 5 times the FWHM of the first or second peak.

35 The pressure sensor preferably further comprises an etching member for enabling etching of the cladding within the chamber. Typically this etching relates to the external etching earlier

5 discussed. For example, the etching member may comprise a conduit configured to enable a flow of etchant to and from the chamber. Alternatively it could be a window so as to enable a laser provided outside of the housing to direct a laser beam onto the cladding.

Preferably, the cladding within the encased portion of optical fibre has a non-elliptical (including non-circular) outline as viewed in a plane having a normal parallel to the axis of the
10 core. This is typically the case where external etching of the cladding has occurred. This outline may comprise two re-entrant features. These re-entrant features may correspond to the exposed third and fourth holes earlier discussed.

Typically, the optical fibre protrudes from one or both ends of the encased portion. The protruding optical fibre may be coupled to a light source and/or detector, typically via a single-
15 mode optical fibre.

The pressure transfer element is preferably a flexible member, such as a diaphragm or bellows. The flexible member may thus form part of the walls of the housing. For example, the housing may comprise an elongate portion, such as a tube, wherein the flexible member is provided on an end of the elongate portion. Alternatively, the pressure transfer element may be an orifice.
20 The orifice may hence expose the substantially non-compressible fluid to any fluid that surrounds the outside of the housing, such as a process fluid. Typically the substantially non-compressible fluid will then be chosen so as to be immiscible with the surrounding fluid. Pressure transfer may hence take place across the orifice, at the liquid interface, without the need for a physical barrier to separate the process fluid and the substantially non-compressible fluid. The remainder of the
25 housing may then be substantially inflexible such that pressure is transferred between the inside and the outside of the chamber via the pressure transfer element only.

A third aspect of the invention provides a system for monitoring pressure comprising:

- a pressure sensor according to the second aspect;
- a light source optically coupled to the encased portion of optical fibre; and
- 30 a detector configured to receive light transmitted by the light source along the optical fibre.

The light source may direct linearly polarised light into the optical fibre. When the light reaches the birefringent portion of optical fibre it will propagate in two different modes that travel
35 at different velocities. This light will then interact with the optical sensor, typically by reflecting

5 or absorbing a proportion of the incident light. Typically the detector will be arranged to detect the light which is reflected by the optical sensor. The birefringence causes two reflected signals or “peaks” to be detected at different wavelengths. Taking the example of where the optical sensor is an FBG, the wavelength of light reflected from the FBG is given by $\lambda_B = 2nd$, wherein n is the effective refractive index and d is the grating period. The difference in wavelength between
10 the two peaks hence occurs because the birefringence causes a difference in the effective refractive index between the two modes whereas the grating period stays constant. If the temperature of the pressure sensor changes, the peaks will wavelength of the peaks will move along a common direction by substantially the same amount. However, if the pressure acting on the pressure sensor changes then the difference in wavelength between these two peaks will also change. The system
15 can be used to monitor the pressure from this change in wavelength. Advantageously, the system is more sensitive to changes in pressure than prior art fibre-optic pressure sensors.

For these reasons, the optical sensor is preferably configured to simultaneously reflect light at two peak wavelengths, and the detector is preferably configured to monitor the pressure of the non-compressible fluid from the difference between the two peak wavelengths. Optionally
20 multiple said pressure sensors are multiplexed onto the optical fibre so as to provide several pressure measurements along a single cable.

A fourth aspect of the invention provides an optical fibre comprising a core, a birefringent optical sensor provided along the core, a cladding surrounding the core, and a birefringence structure, wherein the birefringence structure comprises first and second holes enclosed within the
25 cladding and extending parallel to the core, and wherein the optical sensor is configured to produce a reflection spectrum having a first peak associated with a first polarisation mode and a second peak associated with a second polarisation mode, wherein the centre of the first peak is separated from the centre of the second peak by a wavelength greater than the full width half maximum of the first peak and the second peak when the cladding is at atmospheric pressure.

30 The optical sensor may be formed according to any of the techniques earlier discussed in connection with the previous aspects.

5

BRIEF DESCRIPTION OF THE DRAWINGS

Embodiments of the invention will now be discussed with reference to the accompanying drawings in which:

Figure 1 is a cross-sectional illustration of a side view and an end view of an optical fibre in accordance with a first embodiment prior to internal etching;

10 Figure 2 is a cross-sectional illustration of a side view of an optical fibre during internal etching in accordance with the first embodiment;

Figure 3 is a cross-sectional illustration of a side view and an end view of an optical fibre after internal etching in accordance with the first embodiment;

15 Figure 4 is a cross-sectional illustration of a side view of the pressure sensor in accordance with any of the described embodiment;

Figure 5 is a schematic illustration of a system for monitoring pressure in accordance with the first embodiment;

Figure 6 is a cross sectional illustration of a side view of an optical fibre during internal etching in accordance with a second embodiment;

20 Figure 7 is a cross-sectional illustration of a side view and an end view of an optical fibre after internal etching in accordance with the second embodiment;

Figure 8 is a cross sectional illustration of a side view of an optical fibre during internal and external etching in accordance with a third embodiment;

25 Figure 9 is a cross-sectional illustration of a side view of the pressure sensor in accordance with the third embodiment;

Figure 10 is a cross-sectional end view of an optical fibre after internal and external etching in accordance with the third embodiment;

Figure 11 is a cross-sectional end view of an optical fibre after internal and external etching in accordance with a fourth embodiment;

30 Figure 12 is a cross-sectional end view of an optical fibre before internal etching in accordance with a fifth embodiment;

Figure 13 is a cross-sectional end view of an optical fibre after internal etching in accordance with the fifth embodiment;

35 Figure 14 is a flow diagram illustrating a method for forming a pressure sensor in accordance with the first embodiment;

Figure 15 is an example of a reflection spectrum obtained from a pressure sensor according to the prior art;

5 Figure 16 is an example of a reflection spectrum obtained from a pressure sensor formed in accordance with an embodiment;

 Figure 17 is an illustration of reflection spectra obtained from a pressure sensor formed in accordance with the first embodiment; and

 Figure 18 is an illustration of reflection spectra obtained from a pressure sensor in
10 accordance with a further embodiment.

5

DETAILED DESCRIPTION

A first embodiment of a method for forming a pressure sensor 10 will now be discussed with reference to Figures 1–5, 14, 16 and 17. The method begins at step 101 (Figure 14) when a waveguide in the form of an optical fibre 1 is provided. The optical fibre 1 is constructed from a cylindrical preform (not shown) having a core, formed of pure silica, and a cladding which surrounds the core. The preform typically has a diameter of 3–6 cm and may be 0.5–2 m in length (although other sizes are also possible). A pair of parallel holes is drilled into the cladding of the pre-form, typically 1–2 cm either side of the core. Optionally, silica glass tubes may be inserted into the holes of the preform after drilling. The pre-form is then drawn to form the optical fibre 1 shown in Figure 1 using standard drawing techniques. The silica glass tubes (if provided) will then become amalgamated with the surrounding material of the preform during this process, whilst preserving the presence of the holes.

If the holes which are drilled into the pre-form are too large then they will collapse during the drawing process. Care is taken therefore to avoid this. An optical sensor in the form of a Fibre Bragg Grating (FBG) 5 having intrinsic birefringence is then formed along the core 7 by directing light from a femtosecond laser onto the core 7. Femtosecond lasers deliver light in pulses of shorter duration (less than one picosecond) than are commonly used to inscribe FBGs. The shorter pulse is combined with a peak power up to three orders of magnitude higher. This increased power allows for a wider range of optical and structural modifications to be made to the material of the optical fibre. Advantageously the use of a femtosecond laser means that the FBG 5 may be formed through the coating material. Therefore prior to forming the FBG 5, the method may additionally comprise a step of applying a coating to the fibre, such as a hermetic carbon coating, for environmental protection. In alternative embodiments, including those in which a femtosecond laser is not used, the FBG 5 may be formed before the coating is applied, or no coating applied.

Light may be directed from the femtosecond laser onto the core by any of a number of known processes. In the event that a focused light source is used, a point-by-point or line-by-line method may be followed. In the former, the laser spot is focused on the desired position in the fibre and a single pulse of light is delivered before translating it along the fibre to deliver the next pulse, whereas in the latter the spot may be traversed normal to the axis of the fibre to create a wider feature before moving on to the next position along the core. Alternatively, the light may be directed through a phase mask onto the core, as described by Mihailov *et al.* or the optical sensor

5 may be formed using the techniques described by Jovanovic *et al.*, or Chah *et al.* (all referenced above).

Whether using a point source or a phase mask, an asymmetric intensity distribution of laser light will be produced across the fibre, thus creating an asymmetric region of modified material. This modification will be a combination of changed optical properties and mechanical
 10 characteristics (specifically stress) produced by the interaction of the laser pulse with the fibre materials. The mechanical modification will also affect the refractive index of the optical sensor, thereby optically inducing birefringence to the FBG 5. Specifically, the laser processing causes the melting and then densification of the fibre. This causes changes in refractive index that are distributed so as to form an FBG 5. Birefringence is therefore typically induced or modified in the
 15 fibre at the same time as writing the FBG. Alternatively, two laser processing operations may be performed: a first operation to write the FBG 5 in the core 7, and a second operation directing light onto the cladding 3 surrounding the core 7 to modify the refractive index in the core 7.

The first and second holes 2, 4 are cylindrical voids within the cladding 3 which form part of a birefringence structure for inducing birefringence within the core 7, and modifying the
 20 birefringence at the FBG 5. These holes 2, 4 extend parallel to the core 7, on opposing sides of the core 7, and at approximately equal distances from the core 7. This is illustrated by Figures 1 and 3, which show a cross-sectional side view of a section of the optical fibre 1 to the left and a cross-sectional end view of the optical fibre 1 to the right.

The birefringence in a fibre can generally be expressed by the following equation: $B = B_T +$
 25 $\frac{\lambda}{2\pi}(S_o P_o - S_i P_i)$ where B_T is the static birefringence, λ is the wavelength, and S_o and S_i is the phase sensitivity of the birefringence to inner and outer pressure pressures P_o and P_i , respectively. In the present embodiment, the presence of the birefringence structure typically ensures that S_o and S_i take non-zero values and may further cause B_T to be non-zero. However, the process for forming the optical sensor further increases the magnitude of B_T , thereby ensuring the FBG 5 has an
 30 intrinsic birefringence. In particular, the static birefringence may be expressed as the sum of a static component introduced by the fibre B_f and a static component introduced by the sensor B_i , so that $B_T = B_f + B_i$. B_f results from the stress and geometrically induced birefringence that are due to the components of the fibre. B_i results from the sensor inscription process itself (principally the stress induced within the fibre). Embodiments of the invention are directed to modifying B_i such
 35 that B_T is sufficiently large to produce a reflection spectrum having two individually resolvable

5 (or potentially non-overlapping) peaks, even when the optical sensor is at atmospheric pressure. The optical sensor inscription process is also typically controlled such that $B_f + B_i$ has the same sign as $(S_o P_o - S_i P_i)$. This ensures that any increases in the pressure applied to the sensor do not cause the reflected peaks to move together and align. This will now be further discussed with reference to Figures 15 and 16.

10 Figure 15 is an example of a reflection spectrum from an FBG inscribed in a side-hole fibre according to the prior art. Unpolarised light is transmitted along the optical fibre and reflected from the FBG to produce a single peak, formed by the combination of the reflections from the two orthogonal polarisation states. Figure 16 is an example of a reflection spectrum from an optical sensor which is formed so as to have an intrinsic birefringence, in accordance with an embodiment.

15 As can now be seen, the reflection is fully split into two peaks, each one being capable of analysed by a suitable peak detection algorithm. This increased birefringence is a result of the FBG inscription process. When a pressure is then applied (i.e. in excess of atmospheric pressure), its effect is further to increase the peak separation.

There is no requirement for the initial wavelength separation between the peaks of Figure 15 to be less than a particular value, provided that each peak is separated by more than the FWHM of the peaks when the cladding is at atmospheric pressure. This is so that each peak is individually resolvable. However the smaller the separation is, the smaller the wavelength range occupied by the optical sensor and the greater the number of optical sensors that can be provided along the fibre and addressed by a given wavelength-division multiplexing technique. FGBs typically produce

25 peaks having a FWHM in the range of 0.1–2 nm, depending on the FBG.

The reflection spectrum may be monitored to ensure that the peak separation is appropriate and the parameters of the inscription process adjusted as required. For example, an interrogator may be connected to the fibre when the FBG is written and used to monitor the evolution of the FBG as it is made. If the interrogator is fitted with a polarisation controller, it could be used to

30 monitor the evolving birefringence as well. However, if sufficient birefringence is produced to make two distinct FBG reflection peaks, then the polarisation controller would not be necessary.

Returning to the first embodiment, the optical fibre 1 has a nominal 125 micrometre diameter. The core 7 has a diameter of 10 micrometres. The first and second holes 2, 4 also each have a diameter of 10 micrometres and are axially displaced from the central axis of the core 7 by

35 20–30 micrometres. Larger diameters holes may also be used, for example in the range of 10–20

5 micrometres however typically the diameter of the holes and their spacing from the core 7 will be chosen according to the diameter of the cladding 3. For example, if a larger cladding with a diameter of 280 micrometres is used, 20 micrometre diameter holes may be chosen each separated by 100 micrometres from the core.

At step 102 a portion of the length of optical fibre 1 is encased within a chamber defined by
10 an elongate housing 11. This is shown by Figure 2, wherein the housing 11 is substantially cylindrical and forms a sleeve. In the first embodiment the portion of optical fibre 1 that is encased within the housing 11 already contains the FBG 5 inscribed to it however in other embodiments the FBG 5 may be written onto the optical fibre 1 only once the optical fibre 1 has been encased within the housing 11. The housing 11 may therefore comprise a window in such embodiments so
15 as to enable an external light source, such as a laser to write the FBG 5 onto the optical fibre 1.

The optical fibre 1 is held taut between apertures provided on opposing ends of the housing 11 by clamps 13, 15 so as to extend through the chamber. The housing 11 thus fixes the length of the portion of optical fibre 1 that is contained encased so as to protect against differential thermal expansion effects on the optical fibre 1.

20 The housing 11 is sealed at the opposing apertures through which the optical fibre 1 extends. The seals may be formed of an epoxy resin. In the event that the optical fibre 1 is metal-coated, a metal-to-metal seal may be applied for example by soldering or brazing. Suitable sealant materials include stainless steels, nickel alloys, gold-based solders and brass. Optionally, a glass-to-metal seal may be applied, for example by the use of a glass mixture having a lower melting point than
25 the cladding 3 and the housing 11. A substantially non-compressible fluid 14 is then introduced to the chamber using one or more ports (not shown). The fluid 14 could be one of a variety of inert liquid. Suitable examples include mineral oil, silicone oil, grease or a liquid metal based on gallium or indium and their alloys. In other examples this fluid 14 is introduced to the chamber before the portion of optical fibre 1 is encased within the housing 11.

30 The housing 11 is formed of a corrosion resistant alloy, such as Inconel (RTM), capable of resisting the harsh environments found within a well of a hydrocarbon reserve. The housing 11 comprises a pressure transfer element in the form of a flexible diaphragm 12 that forms part of the walls surrounding the optical fibre 1. The diaphragm 12 may be located anywhere along the housing 11 so as to form a barrier between the fluid 14 contained within and any surrounding fluids
35 that are outside of the housing 11. In the present embodiment the diaphragm 12 forms a discrete

5 part of the walls of the housing 11 however the diaphragm 12 may alternatively fully surround the encased portion of optical fibre 1. The diaphragm 12 is typically formed of a corrosion resistant flexible material and so may comprise the same material as the remainder of the housing 11 (e.g. Inconel (RTM)), albeit made sufficiently thin so as to flex without breaking under normal operating conditions. The diaphragm 12 is configured to flex so as to transmit a hydrostatic pressure applied
10 to the outside of the housing 11 into the fluid 14 so as to equalise the hydrostatic pressure on opposing sides of the diaphragm 12. In other embodiments bellows may be used instead of the diaphragm 12. Alternatively, the pressure transfer element may take the form of an aperture which is open so as to expose the substantially non-compressible fluid 14 to any surrounding process fluid. In this case, a substantially non-compressible fluid 14 may be used which is immiscible
15 with the surrounding process fluid.

The housing 11 may be constructed so as to isolate the encased portion of optical fibre 1 from any axial stresses caused by thermal expansion of the housing 11. For example, the housing 11 may be further formed of one or more low-expansion materials (such as Invar (RTM), other nickel-iron alloys, Kovar (RTM) or a carbon fibre composite). Alternatively, the portion of optical
20 fibre 1 may be held slightly slack between opposing ends of the chamber so as to compensate from any axial expansion of the chamber. Such axial stresses would not typically affect any pressure measurements however they could interfere with any temperature measurements obtained using the FBG 5.

At step 103, with the portion of optical fibre 1 encased within the housing 11, an etching
25 process is performed. In the first embodiment the optical fibre 1 is etched internally only. A liquid etchant is flowed through the first and second holes 2, 4 through the portion of optical fibre 1 encased within the housing and along the direction indicated by the rightward pointing arrows in Figure 2. The liquid etchant may be an aqueous solution of hydrofluoric acid, although a more controllable option is the Buffered Oxide Etch (BOE) – which is a mixture of aqueous solutions
30 of ammonium fluoride and hydrofluoric acid. The use of BOE is particularly advantageous because it maintains its activity as it is used, thus it allows for a consistent etching rate.

The etchant will etch the cladding 3 at a predictable rate so as to increase the diameter of the first and second holes 2, 4, as illustrated by Figure 3. It is typically not possible to achieve large and enclosed voids within the cladding 3 without internal etching. This process increases the
35 anisotropic stress acting on the FBG 5 in response to increases in the hydrostatic pressure applied by the fluid 14. In so doing, the sensitivity of the pressure sensor 20 ultimately formed is increased.

5 The first and second holes 2, 4 are located sufficiently towards the centre of the cladding 3 so that if the internal etching were allowed to continue, the etchant would eventually come into contact with the core 7, which could degrade its optical transmission properties. Further internal etching would then cause the first and second holes 2, 4 to become exposed to the non-compressible fluid 14. The etchant is therefore passed along the first and second holes 2, 4 for a
10 predetermined amount of time so as to increase the diameter of the first and second holes 2, 4 by a controlled amount, without bringing the etchant into contact with the core 7. Typically the diameter of the first and second holes 2, 4 is increased from 10 micrometres to 25–35 micrometres by the internal etching. Depending on the width of the cladding 3, wider first and second holes 2, 4 may be desirable. For example, if the cladding is 280 micrometres in diameter, the first and
15 second holes 2, 4 may be internally etched to achieve respective diameters of around 100 micrometres.

 The etchant is then flushed from the first and second holes 2, 4 at step 104, for example using an inert liquid such as water. This liquid may then be ejected from the first and second holes 2, 4, for example using a jet of hot air. After the internal etching, the first and second holes 2, 4 remain
20 enclosed within the cladding 3 and each of the core 7 and the first and second holes 2, 4 remain separate and non-interconnected within the optical waveguide 1. In an alternative embodiment the FBG 5 may be written onto the optical fibre 1 only after the etching process is complete.

 At step 105 the opposing ends of the length of optical fibre 1 held by the grips 13, 15 are spliced onto first and second single mode optical fibres 18, 19 respectively. The pressure sensor
25 20 of Figure 4 is thereby formed. Optionally, additional components, such as braces or ducting, may be included to provide mechanical and environmental protection.

 The single mode optical fibres 18, 19 are typically solid fibres having a core and a cladding with diameters of 9 and 125 micrometres respectively, and a mode field diameter of approximately 10 micrometres at 1550 nm. These fibres are widely used for transmitting signals reliably over
30 long distances. It is therefore advantageous to couple the optical fibre 1 to such fibres 18, 19 at either end to ensure compatibility with any peripheral components to the system that may be provided and to increase the ease of any additional splicing that may be required for coupling such components to the pressure sensor 20.

 Figure 5 schematically illustrates a system for monitoring pressure using this pressure sensor
35 20. The first single mode optical fibre 18 is coupled to a light source 22, in the form of a laser,

5 and a detector 24. An alternative light source may however be used, such as a diode. The second single mode optical fibre 19 is coupled to further similarly constructed pressure sensors 20', 20'' such that the pressure may be measured at a plurality of locations along the resulting waveguide. A distal end of the waveguide protruding from the end pressure sensor 20'' is connected to a means of suppressing reflections (not shown), such as an optical absorber or an angled cleave. At the
10 opposing proximal end of the waveguide, the light source 22 is configured to inject a pulse of light along the waveguide in a first direction. A portion of this light is then reflected by the FBG provided within each of the pressure sensors 20, 20', 20'' and travels in a second direction, opposite to the first direction, until it reaches the detector 24. The wavelength of the reflected light is monitored by the detector 24.

15 Each birefringent FBG will reflect light at two peak wavelengths, each associated with a given polarisation mode, as earlier discussed with reference to Figure 16. The birefringence structure converts increases in the pressure within each of the pressure sensors 20, 20', 20'' to increases in the birefringence along the encased portions of optical fibre. This will cause the separation between the peaks associated with each polarisation mode to increase. Figure 17
20 provides a reflection spectrum illustrating this change in peak separation for one of the pressure sensors 20, 20', 20''. At atmospheric pressure, light is reflected from the FBG of the pressure sensor to form two peaks (shown here in solid lines). These peaks are sufficiently separated in wavelength so as to be non-overlapping and individually resolvable. When an external pressure is then applied to the pressure sensor (i.e. in excess of atmospheric pressure) the separation
25 between these peaks increases. The resulting spectrum is shown in dotted lines. The difference in peak wavelength between these peaks is measured by the detector 24 and the pressure acting on the sensors 20, 20', 20'' is calculated from this. US5841131 provides an example of how the pressure may be calculated from changes in the peak wavelength.

30 In an alternative embodiment, rather than starting with a small initial peak separation, as shown in Figure 17, the intrinsic birefringence of the optical sensors may be controlled so as to form a larger wavelength separation at atmospheric pressure. The birefringent structure may then be formed so that this separation decreases as more pressure is applied to the pressure sensor. Figure 18 provides a reflection spectrum from one such pressure sensor, in which the solid lines show the peaks reflected from a given optical sensor at atmospheric pressure, and the dotted lines
35 show the peaks observed after the pressure acting on this sensor is increased. Such an arrangement may work equally well as that of Figure 17, however the maximum pressure that could be measured would be limited because, at a certain point, the peaks would approach each other too

5 closely so as to no longer be individually resolvable. However, the pressure sensor may well be able to exceed this maximum measurement pressure without being damaged or losing measurement accuracy and when the pressure dropped to a suitable level, it would be useable again.

10 An optical fibre-based system is therefore provided for measuring the pressure at a plurality of locations along a single waveguide. Advantageously therefore, if such a system were implemented within a high pressure environment such as within a hydrocarbon well, the number of penetrations through each of the pressure barriers that are required for accommodating the system is limited to one. This is practically easier to implement and reduces the number of potential leak points.

15 A particular benefit of the above technique is that the cladding 3 is etched whilst the optical fibre 1 is supported within the housing 11 that goes on to form part of the pressure sensor 20. In contrast, if the optical fibre 1 were not supported within the housing 11 during the etching, significant stresses could be applied to the fibre through handling it. For example, if the optical fibre 1 were bent even slightly, the stresses would be concentrated in the region where the cladding
20 3 was thinnest. It would therefore not be possible to remove as much cladding material via etching without making the fibre susceptible to breaking apart when handled. However, since the etched optical fibre 1 no longer requires further handling in order to incorporate it within the pressure sensor, more cladding may be removed during etching and so the sensitivity of the pressure sensor may be increased.

25 Further embodiments of the invention will now be discussed which introduce further developments on the first embodiment. Similar components described and illustrated take an identical form to the first embodiment unless stated otherwise. In a second embodiment, illustrated by Figures 6 and 7, a localised heat source in the form of a resistive coil 46 is wrapped around the outside of the housing 41. Alternatively the localised heat source may take the form of a Peltier
30 heater or an induction heating coil. Once the chamber has been filled with the substantially non-compressible fluid 44, an electric current is applied to the coil 46 so as to heat a central region of the chamber containing the FBG 35 (in this case via the fluid 44 – which provides a heat transfer medium).

35 When the liquid etchant is then conveyed along the first and second holes 32, 34 at step 103, the etching rate will be increased where the temperature of the cladding 33 is higher. The internal

5 etching may thus be controlled so as to produce enlarged voids 36, 38 within the first and second holes 32, 34 respectively along a specific region that encompasses the FBG 35. The birefringence may thus be increased at this region, without compromising the structural integrity of the remainder of the optical fibre 31. These voids 36, 38 have a diameter of 45 micrometres whereas the remainder of the first and second holes 32, 34 have a diameter of 25 micrometres.

10 Typically the liquid etchant used is BOE (as before). A useful feature of BOE is the etching rate approximately doubles for every 10 degrees Celsius increase in temperature, within an operating range of 20–80 degrees Celsius. Thus, the increased etching may be carefully predicted in advance in accordance from the temperature profile of the cladding 33. Useful temperature ranges are generally in the region of 20 to 80 degrees Celsius.

15 A third embodiment of a method for forming a pressure sensor 80 will now be discussed with reference to Figures 8–10. This embodiment is similar to the second embodiment in that the internal etching process is assisted by use of a heating element 66. In the third embodiment however external etching of the cladding 53 is additionally performed. In this instance, the birefringence structure further comprises third and fourth holes 56, 58 that extend along the
20 cladding 53 in a direction parallel to the axis of the core 57. Like the first and second holes 52, 54, the third and fourth holes 56, 58 are initially drilled into the preform, which is then drawn to form the optical fibre 51. The third and fourth holes 56, 58 are formed at equal distances from the core 57, on opposing sides of the core 57 and radially outside of the first and second holes 52, 54. The axes of the first and second holes 52, 54 lie within a first plane, and the axes of the third and
25 fourth holes 56, 58 lie within a second plane, wherein the first plane is perpendicular to the second plane.

The third and fourth holes 56, 58 are initially fully enclosed within the cladding 53 such that the cladding has a circular profile (as before). At step 103 however a liquid etchant is introduced into the chamber through an inlet 68 whereupon it comes into contact with the outside of the
30 cladding 53. Typically the etchant is continuously circulated through the chamber via the inlet 68 and an outlet 69 during this stage. The etchant is allowed to etch the cladding 53, generally reducing its diameter, until the cladding material between each of the third and fourth holes 56, 58 and the outside of the optical fibre 51 is removed, thereby exposing the third and fourth holes 56, 58 to the liquid etchant. At this point the optical fibre 51 no longer has a circular profile, when
35 viewed along a plane perpendicular to the core 57. Instead this profile now comprises a partial outline of the third and fourth holes 56, 58, these holes forming respective re-entrant features for

5 the cladding 53. The cladding 53 thereby has a cross-sectional outline in the form of a bow tie profile, as illustrated by Figure 10.

The liquid etchant will etch the cladding 53 approximately equally around its circumference during the external etching. The first and second holes 52, 54 are provided radially inwards of the third and fourth holes 56, 58 however and so these will remain enclosed by the cladding 53 at the point that the third and fourth holes 56, 58 are exposed. At this moment, the liquid etchant is flushed from the chamber through the outlet 69 so as to prevent unwanted removal of cladding material either between the third and fourth holes 56, 58, or the between either of the first and second holes 52, 54 and the outside of the cladding 53. The substantially non-compressible fluid may be introduced into the chamber via the inlet 68 to help achieve this flushing. The flow of liquid into and out from the chamber via the outlet 69 is indicated by the vertical arrows in Figure 8. The chamber is then sealed by blocking the inlet 68 and the outlet 69, as shown by Figure 9.

The housing 61 may therefore advantageously provide the dual-purpose of providing a container for the liquid etchant and then subsequently containing the substantially non-compressible fluid. This improves the simplicity of the method for forming the pressure sensor 80.

Internal etching typically occurs either during the external etching or afterwards, with either the etchant or the substantially non-compressible fluid which surrounds the optical fibre 51 being used as a medium to transfer heat from the heating element 66 to the cladding 53. Optionally no such surrounding fluid is provided during this stage however. After the internal etching, the ends of the optical fibre 51 which trail from the apertures of the housing 61 are spliced onto respective single mode optical fibres 78, 79, as before. Advantageously, unlike the portion of the optical fibre 51 which has been subject to external etching, these ends have a circular profile that corresponds to the profile of the single mode optical fibres 78, 79. These ends will therefore be practically easier to splice together whilst maintaining a good optical coupling. The completed pressure sensor 80 having single mode optical fibres 78, 79 spliced onto either end of the birefringent optical fibre 51 is shown by Figure 9. Notably, the heating element 66 is removed at this stage since it is no longer required.

A cross-sectional end view of an optical fibre 71 in accordance with a fourth embodiment is illustrated by Figure 11. This embodiment substantially matches the third embodiment however the external etching has been performed using laser ablation rather than by immersing the optical

5 fibre in a liquid etchant. The housing (not shown) may therefore comprise a window for enabling a laser beam to be directed onto the cladding 73 from a position outside of the housing. The laser beam is directed onto opposing sides of the cladding 73 and then moved along the axis of the optical fibre 71 so as to expose the third and fourth holes 75, 76 across a region encompassing the FBG (not shown). Unlike the third embodiment, the external etching does not occur equally
10 around the outside of the cladding 73 and so there is less danger of accidentally exposing the first or second holes 72, 74. The first and second holes 72, 74 may therefore be formed larger than in the third embodiment, which can lead to further increases in the birefringence within the core 77.

Optionally, the same light source may be used to perform two or more of: writing the FBG onto the core 77, heating the cladding 73 during internal etching, ablating the cladding 73 during
15 external etching and transmitting a pulse of light along the core 77 during subsequent pressure monitoring.

A fifth embodiment of a pressure sensor will now be discussed with reference to Figures 12 and 13. In this embodiment the optical fibre 91 is internally etched within the housing of the pressure sensor (not shown). No external etching is performed.

20 Two pairs of parallel holes are initially drilled into the cladding of a pre-form which is then drawn so as to form the optical fibre 91 having a cross-sectional outline shown by Figure 12. Optical fibre 91 has a birefringence structure comprising a first hole 92, second hole 94, third hole 96 and fourth hole 98 – each enclosed within cladding 91 and rotationally dispersed about a central core 97. The holes 92, 94, 96, 98 have approximately the same diameter and are arranged at the
25 same radial distance from the core 97. The birefringence structure is arranged such that, when viewed in a plane having a normal parallel to the core 97, an acute angle is made between the first and fourth holes 92, 98 relative to the core 97, and an acute angle is made between the second and third holes 94, 96 relative to the core 97. An obtuse angle is therefore formed between the first and third holes 92, 96 relative to the core 97, and between the second and fourth holes 94, 98
30 relative to the core 97.

An optical sensor is formed on the core 97. A portion of the optical fibre 91 comprising the optical sensor is positioned within a chamber having a pressure transfer element, and the chamber is then filled with an inert fluid (as before). A heating element is provided so as to heat the portion of the optical fibre 91 within the chamber via the surrounding fluid. An internal etching process
35 is then performed during which a liquid etchant is flowed through each of the first, second, third

5 and fourth holes 92, 94, 96, 98 so as to remove a portion of the surrounding cladding 93. A higher etching rate occurs along the heated portion of the optical fibre 91 (as occurred in the second embodiment). The diameter of each of these holes 92, 94, 96, 98 is thereby enlarged until the first hole 92 coalesces with the fourth hole 98, and the second hole 94, coalesces with the third hole 96 – each along the heated portion. Care is taken not to merge any portions of the holes that extend
10 outside of the chamber (where the birefringence structure is comparatively weak). At this point the etchant is flushed from the holes 92, 94, 96, 98 so as to prevent the first and third, or second and fourth holes from merging, and to prevent any of the holes 92, 94, 96, 98 from coming into contact with the core 97.

A cross sectional view of the resulting structure is shown by Figure 13. As can be seen, the
15 **internal etching process results in the formation of a first etched hole 92' and a second etched hole 94'. These holes 92', 94' are non-circular and approximately dumbbell shaped when viewed in the cross-sectional plane having a normal parallel to the core 97. This dumbbell shape may equivalently be described as “peanut shaped” or generally ovoid comprising two opposing re-entrant portions positioned midway along the major axis.**

20 The core 97 is positioned midway between the centre of the etched holes 92', 94'. The thickness of cladding 93 separating the core 97 from the outside of the optical fibre 91 therefore varies significantly about the rotational axis of the core 97. This thickness is relatively high for the sectors not encompassing the first or second etched holes 92', 94' and relatively low for the sectors encompassing the first or second etched holes 92', 94'. Isotropic forces applied to the
25 outside of the encased portion of optical fibre 91 are therefore converted into anisotropic stress on the core 97 with a high level of asymmetry (without the need for external etching). This can lead to relatively large changes in the birefringence of the optical sensor and so the formation of a pressure sensor having a particularly high sensitivity.

In an alternative embodiment, dumbbell-shaped holes may be formed along the encased
30 portion of optical fibre without flowing an etchant along the third and fourth holes. For example the etchant may be flowed through the first and second holes only until these holes combine with the fourth and third holes respectively.

In a further embodiment (not illustrated) one or more additional holes (in addition to the four already discussed) may be provided within the cladding. These holes will extend parallel to the

5 core and remain enclosed within the cladding after any internal and external etching processes. Desirable levels of birefringence may hence be induced according to these techniques.

In a further embodiment of the invention, any of the above processes for forming an optical sensor may be performed without internally etching the fibre. Furthermore, in some embodiments of the invention, an optical fibre having a birefringence structure and an optical sensor with
10 intrinsic birefringence as earlier described may be provided in isolation (i.e. without a chamber). Such a fibre may itself be used as a pressure sensor.

In yet a further embodiment, the core may be pre-formed so as to exhibit birefringence. For example, an elliptical core could be used. The birefringence structure may also comprise stress rods. The rods may be inserted into holes drilled in the preform to form a “PANDA” fibre.
15 Alternatively, doped regions may be provided outside the core to induce anisotropic stress in the core. For example, the preform may comprise regions of the cladding formed of highly-doped silica glass that has a different coefficient of thermal expansion (CTE) from the surrounding cladding. When the fibre cools from the drawing process, this difference in CTE causes different parts of the fibre will contract by different amounts, thereby creating stress-induced birefringence
20 in the core. This forms a “BOWTIE” fibre. The birefringence is then modulated in response to changes in pressure supplied by the substantially non-compressible fluid by the birefringence structure.

The above techniques may be used in any combination with the other embodiments disclosed.

25 It is envisaged that the pressure sensor and system herein will be particularly useful for acquiring pressure measurements within lubricating and cooling fluid conduits in pumps, motors, compressors and other subsea machinery used by the oil and gas industry. Other potential uses include internal and external measurements of process fluid in Electrical Submersible Pumps for oil recovery. The system typically has a low-mass and does not require protection from
30 electromagnetic interference. This makes it well suited for acquiring pressure readings within aircrafts, in particular along their hydraulic systems. Furthermore, the pressure sensors are non-intrusive, making them well suited for process pressure measurements. Such pressure sensors could therefore be integrated into components such as valves and seals, providing additional functionality and potentially enhancing the effectiveness and safety of process plants.

5 As will be appreciated, a pressure sensor is therefore provided which offers improved sensitivity over the prior art. This pressure sensor is relatively simple and therefore inexpensive to construct. Furthermore the pressure sensor may be constructed so as to be physically smaller than some prior art sensors. It may also be used as part of a system for monitoring pressure that is resistant to high pressure and temperature environments and requires no additional electrical
10 cabling that could provide potential leak points within high pressure environments.

5 What is Claimed is:

1. A method for forming a pressure sensor comprising:
providing an optical fibre comprising a core, a cladding surrounding the core, and a birefringence structure, wherein the birefringence structure comprises first and second holes enclosed within the cladding and extending parallel to the core;
10 encasing a portion of the optical fibre comprising the core and the birefringence structure within a chamber, wherein the chamber is defined by a housing comprising a pressure transfer element for equalising pressure between the inside and the outside of the chamber;
providing an optical sensor along the core of the portion of optical fibre, wherein providing the optical sensor comprises optically inducing stress in the core so that the optical
15 sensor exhibits intrinsic birefringence; and
filling the chamber with a substantially non-compressible fluid;
wherein the birefringence structure is shaped so as to convert an external pressure provided by the non-compressible fluid within the chamber to an anisotropic stress in the optical sensor.
- 20 2. A method according to claim 1, wherein providing the optical sensor comprises inscribing the optical sensor onto the core using a femtosecond laser.
3. A method according to claim 2, wherein the core is formed of pure silica.
4. A method according to claims 2 or 3, wherein the optical fibre comprises a coating surrounding the cladding and wherein providing the optical sensor comprises directing light from
25 the femtosecond laser through the coating onto the core.
5. A method according to claim 4, wherein the coating is formed of an inorganic material, such as hermetic carbon.
6. A method according to claim 4, further comprising applying the coating to the cladding by a physical or chemical or vapour deposition process.
- 30 7. A method according to claim 6, wherein the coating is formed of gold or aluminium oxide.
8. A method according to any of the preceding claims, wherein providing the optical sensor comprises inscribing the optical sensor using a point-by-point or line-by-line process.

- 5 9. A method according to any of claims 1 to 7, wherein providing the optical sensor comprises directing light onto the core through a phase mask.
10. A method according to any of the preceding claims, wherein the axes of the first and second holes and the core lie within a common plane.
11. A method according to any of the preceding claims, further comprising:
10 internally etching the cladding by flowing an etchant through the first and second holes along a length of the portion of optical fibre which comprises the optical sensor so as to increase the width of the first and second holes.
12. A method according to claim 11, wherein the first and second holes remain enclosed within the cladding after the internal etching.
- 15 13. A method according to claims 11 or 12, further comprising heating the cladding during the internal etching using a localised heat source.
14. A method according to claim 13, wherein the localised heat source comprises a resistive coil, a Peltier heater or an induction coil.
15. A method according to any of claims 11 to 14, wherein the birefringence structure further
20 comprises third and fourth holes enclosed within the cladding and extending parallel to the core, wherein the core is arranged between the first hole and the second hole, and wherein the core is arranged between the third hole and the fourth hole, and wherein the internal etching causes the first hole to merge with the fourth hole and the second hole to merge with the third hole.
16. A method according to claim 15, wherein internally etching the cladding comprises
25 flowing an etchant through the third and fourth holes along a length of the portion of optical fibre which comprises the optical sensor so as to increase the width of the third and fourth holes.
17. A method according to any of claims 1 to 14, wherein the birefringence structure further comprises third and fourth holes enclosed within the cladding and extending parallel to the core, the method further comprising:
30 externally etching the cladding along a length of the portion of optical fibre which comprises the optical sensor so as to expose the third and fourth holes.
18. A method according to claim 17, wherein the perimeter of the externally etched cladding comprises a partial outline of the third and fourth holes.

- 5 19. A method according to claims 17 or 18, wherein said external etching is performed using laser ablation.
20. A method according to claim 19, wherein the housing further comprises a window for transmitting a laser beam directed onto the length of the portion of optical fibre.
- 10 21. A method according to claims 17 or 18, wherein external etching comprises flowing an etching fluid into the chamber and immersing the outside of the cladding in said etching fluid until the third and fourth holes are exposed.
22. A method according to claim 21, further comprising flushing the etching fluid from the chamber prior to filling the chamber with the substantially non-compressible fluid.
- 15 23. A method according to any of claims 17 to 22, wherein the axes of the core and the first and second holes lie within a first plane, and wherein the axes of the core and the third and fourth holes lie within a second plane, the second plane being different from the first plane.
24. A method according to claims 17 to 23, wherein the birefringence structure further comprises one or more additional holes enclosed within the cladding and extending parallel to the core, wherein the additional holes remain enclosed within the cladding after said etching.
- 20 25. A method according to any of the preceding claims, further comprising splicing one or each end of the optical fibre protruding from the housing with a single-mode optical fibre.

- 5 26. A pressure sensor comprising:
a housing defining a chamber, the housing comprising a pressure transfer element for
equalising pressure between the inside and the outside of the chamber;
a substantially non-compressible fluid contained within the chamber; and
an optical fibre, wherein a portion of the optical fibre is encased within the chamber, the
10 portion comprising a core, a birefringent optical sensor provided along the core, a cladding
surrounding the core, and a birefringence structure, wherein the birefringence structure comprises
first and second holes enclosed within the cladding and extending parallel to the core, and wherein
the optical sensor is configured to produce a reflection spectrum having a first peak associated
with a first polarisation mode and a second peak associated with a second polarisation mode,
15 wherein the centre of the first peak is separated from the centre of the second peak by a wavelength
greater than the full width half maximum of the first peak and the second peak when the non-
compressible fluid is at atmospheric pressure.
27. A pressure sensor according to claim 26, wherein the first and second holes have a larger
cross sectional area along a region of the portion encompassing the optical sensor than along
20 another region of the portion not encompassing the optical sensor.
28. A pressure sensor according to claims 26 or 27, wherein the birefringence structure is
arranged to modify the birefringence of the optical sensor in response to changes in the pressure
of the non-compressible fluid.
29. A pressure sensor according to claim 28, wherein the birefringence structure is configured
25 to increase the birefringence of the optical sensor in response to an increase in the pressure of the
non-compressible fluid.
30. A pressure sensor according to any of claims 26 to 29, wherein the pressure sensor is
thereby formed such that, when the non-compressible fluid is at atmospheric pressure, the centre
of the first peak is separated from the centre of the second peak by at least 0.1 nm.
- 30 31. A pressure sensor according to any of claims 26 to 30, further comprising an etching
member for enabling etching of the cladding within the chamber.
32. A pressure sensor according to claim 31, wherein the etching member comprises a conduit
configured to enable a flow of etchant to and from the chamber.

- 5 33. A pressure sensor according to claims 31 or 32 wherein the cladding has a non-elliptical outline as viewed in a plane having a normal parallel to the axis of the core.
34. A pressure sensor according to claim 33, wherein the outline comprises two re-entrant features.
- 10 35. A pressure sensor according to any of claims 26 to 30, wherein the first and second holes are dumbbell shaped along the portion encompassing the optical sensor, when viewed in a plane having a normal parallel to the core.
36. A pressure sensor according to any of claims 26 to 35, wherein the optical fibre protrudes from one or each end of the encased portion.
- 15 37. A pressure sensor according to any of claims 26 to 36, wherein the optical sensor comprises a Fibre Bragg Grating.
38. A pressure sensor according to any of claims 26 to 37, wherein the pressure transfer element is a flexible member.
39. A pressure sensor according to any of claims 26 to 38, wherein the pressure transfer element is an orifice.
- 20 40. A system for monitoring pressure comprising:
a pressure sensor according to any of claims 26 to 39;
a light source optically coupled to the encased portion of optical fibre; and
a detector configured to receive light transmitted by the light source along the optical fibre.
- 25 41. A system according to claim 40, wherein the optical sensor is configured to simultaneously reflect light at two peak wavelengths, and wherein the detector is configured to monitor the pressure of the non-compressible fluid from the difference between the two peak wavelengths.

- 5 42. An optical fibre comprising a core, a birefringent optical sensor provided along the core,
a cladding surrounding the core, and a birefringence structure, wherein the birefringence structure
comprises first and second holes enclosed within the cladding and extending parallel to the core,
and wherein the optical sensor is configured to produce a reflection spectrum having a first peak
associated with a first polarisation mode and a second peak associated with a second polarisation
10 mode, wherein the centre of the first peak is separated from the centre of the second peak by a
wavelength greater than the full width half maximum of the first peak and the second peak when
the cladding is at atmospheric pressure.

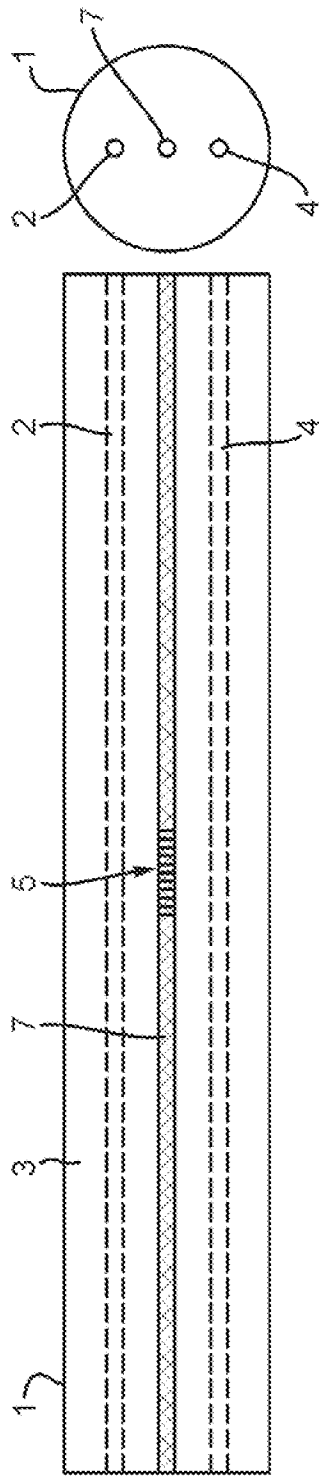


Fig. 1

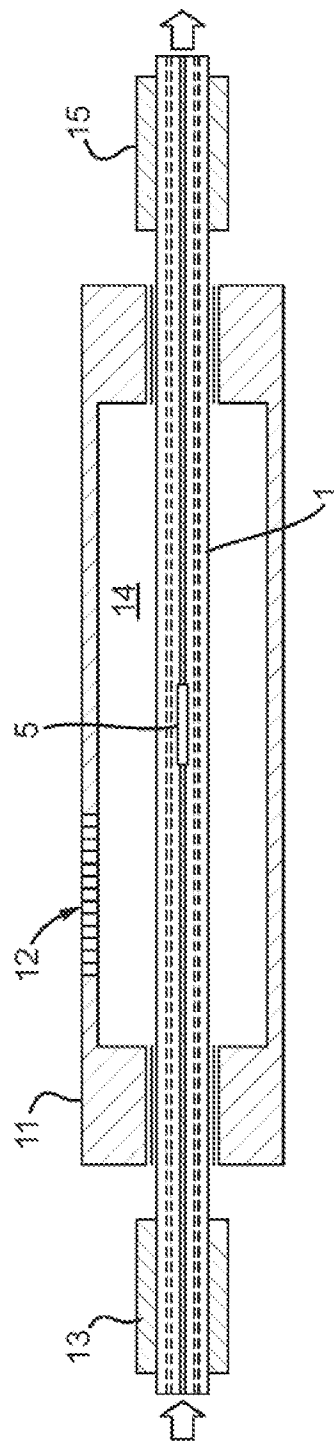


Fig. 2

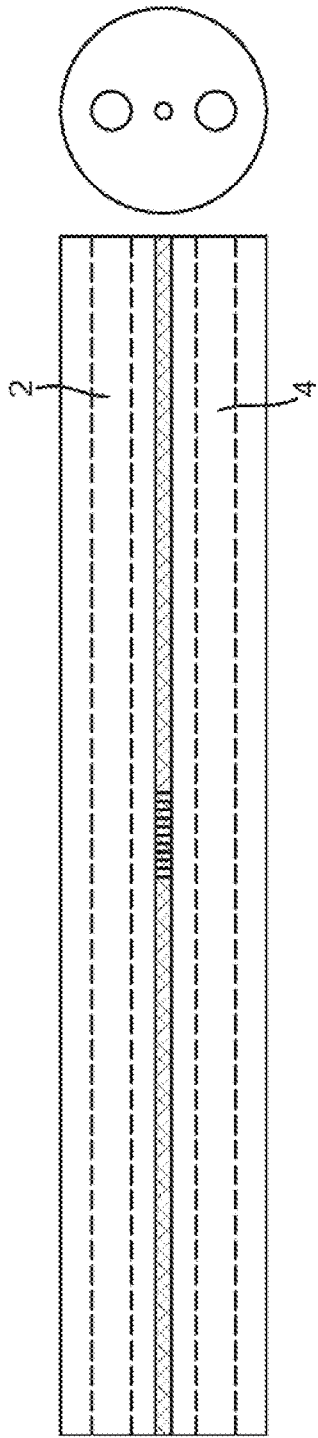


Fig. 3

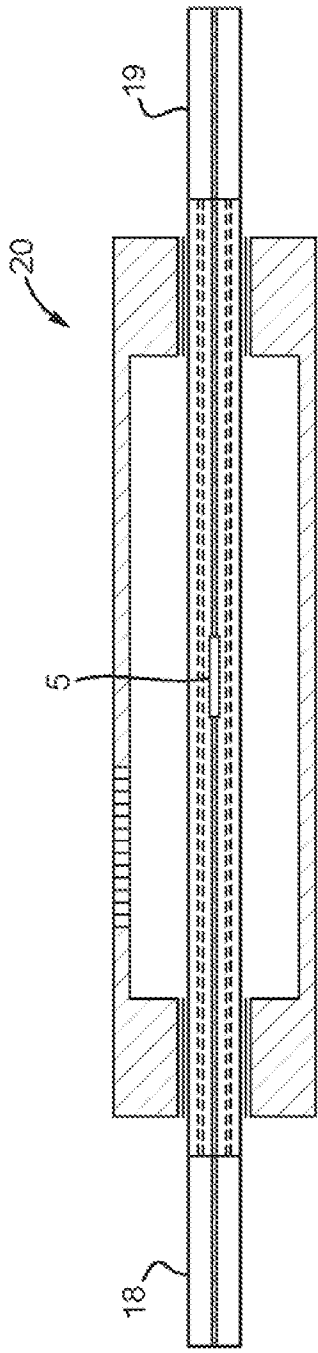
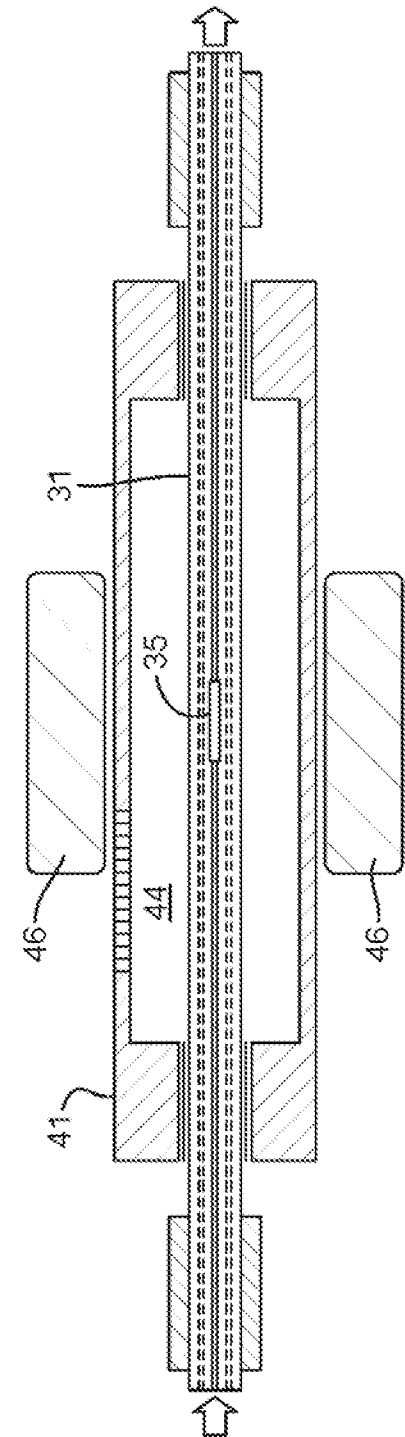
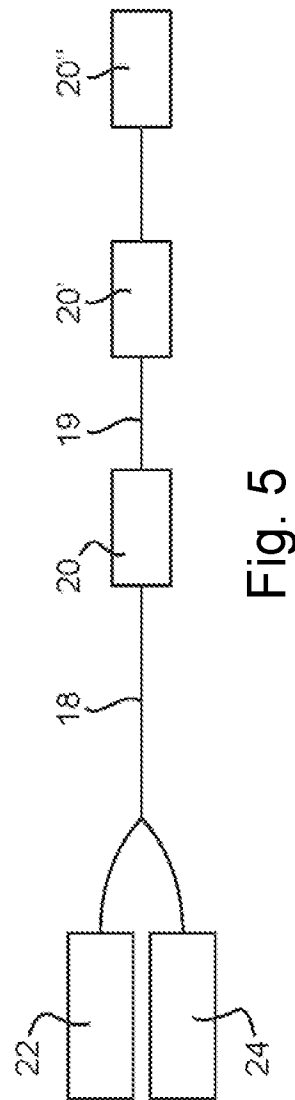


Fig. 4



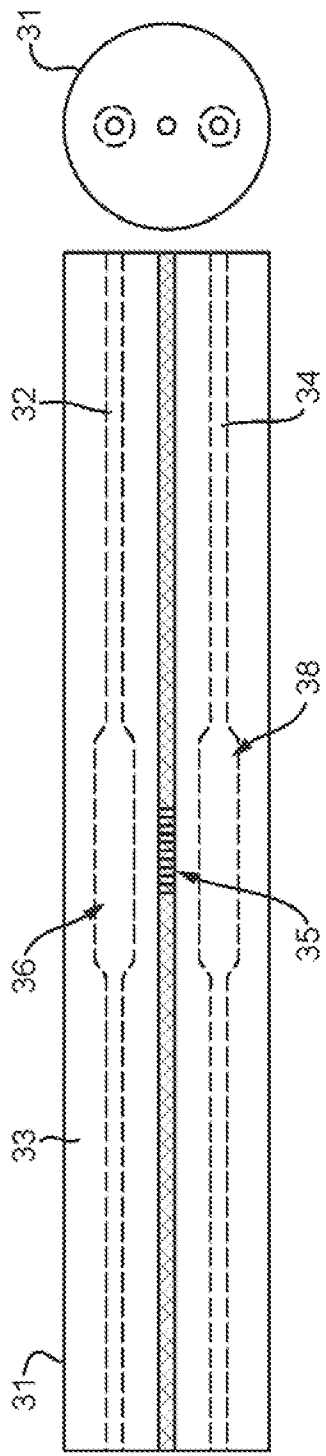


Fig. 7

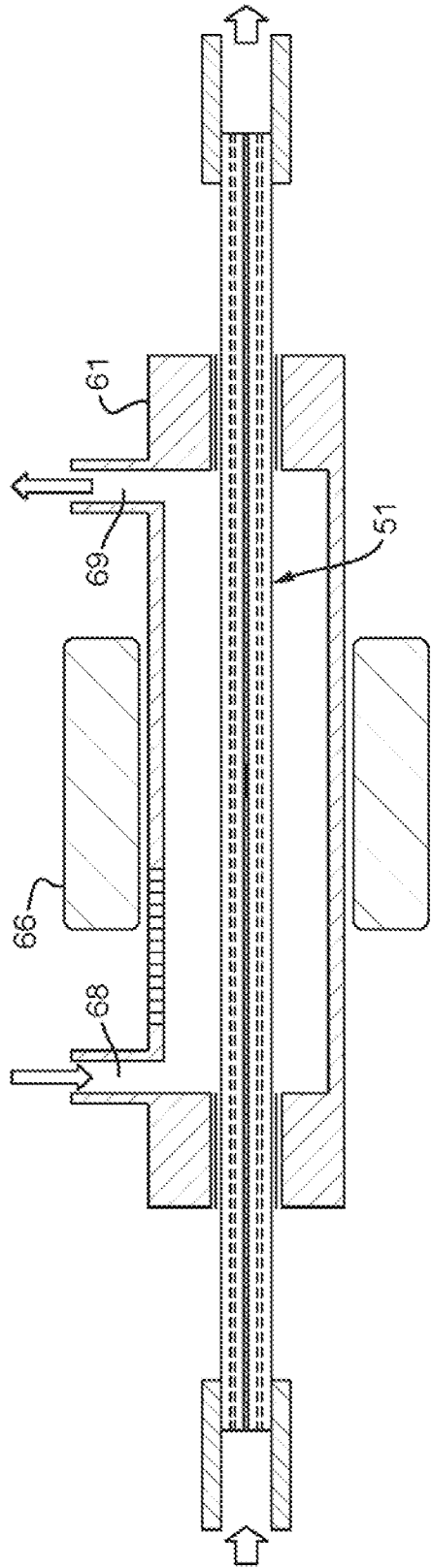


Fig. 8

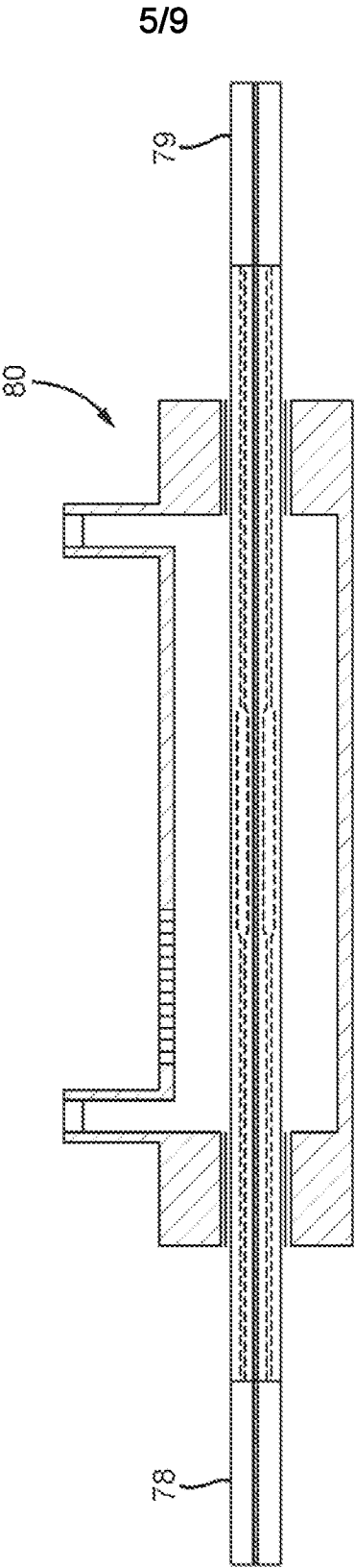


Fig. 9

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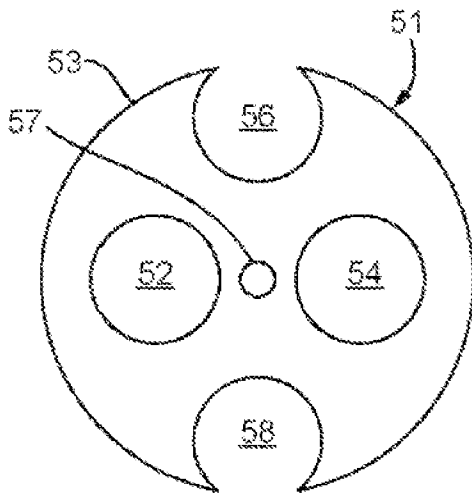


Fig. 10

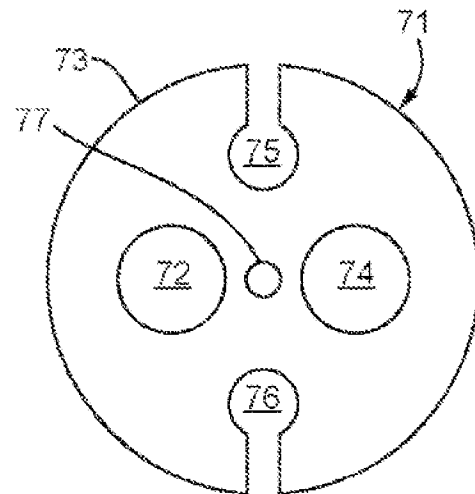


Fig. 11

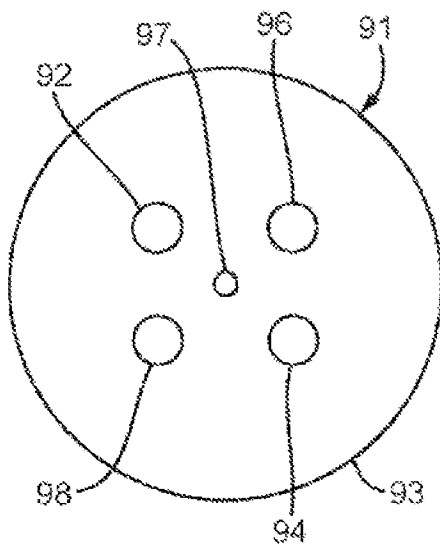


Fig. 12

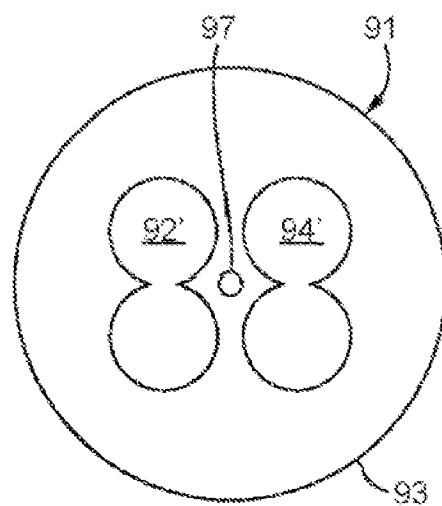


Fig. 13

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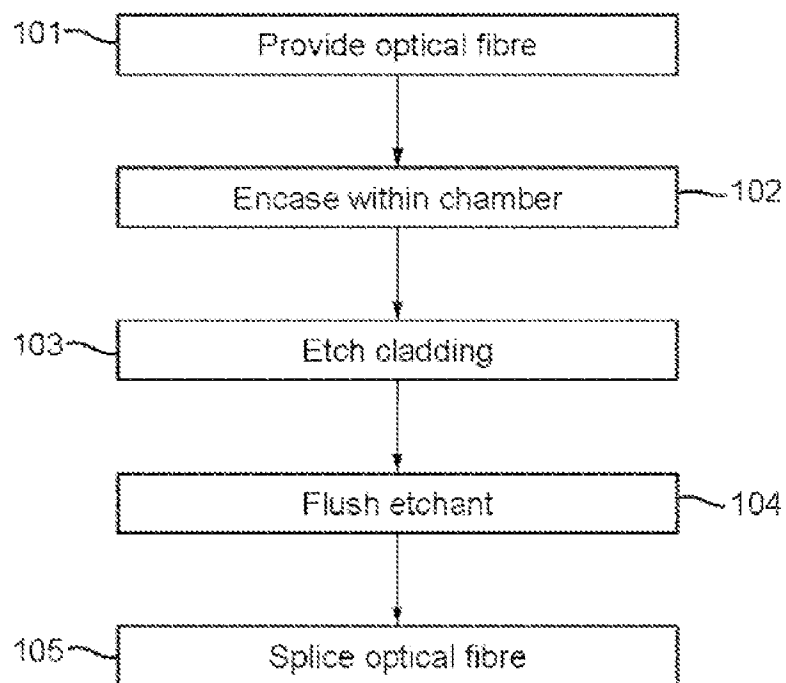
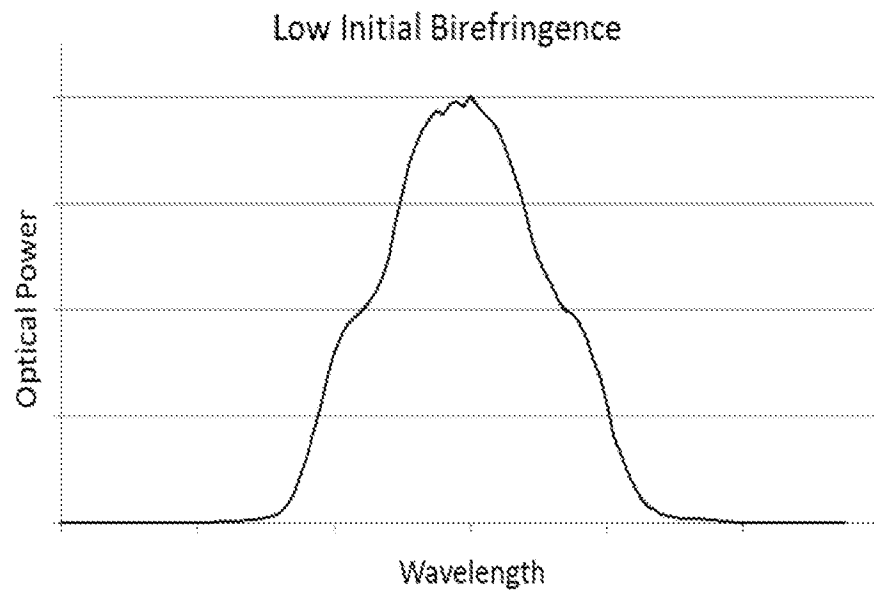


Fig. 14

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Prior Art

Fig 15

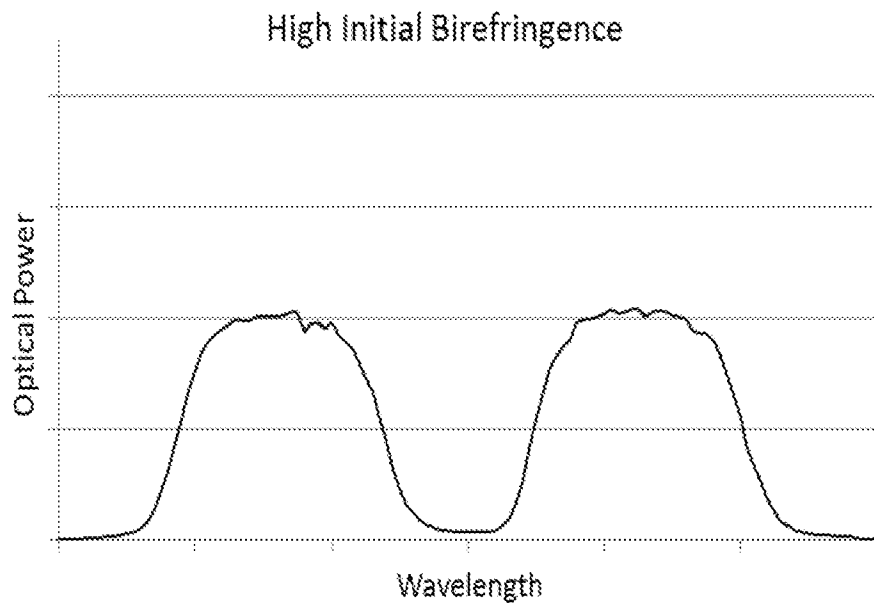


Fig 16

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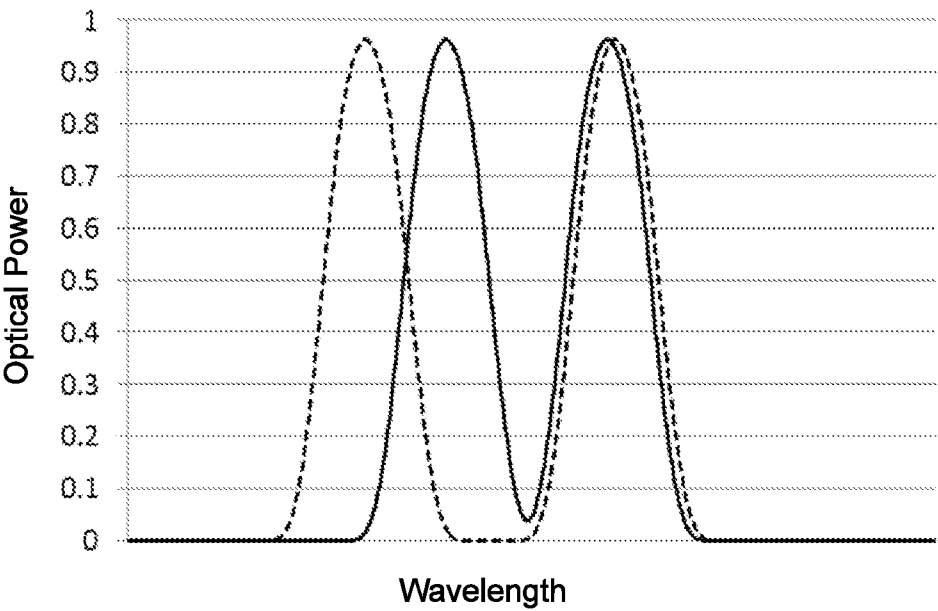


Fig 17

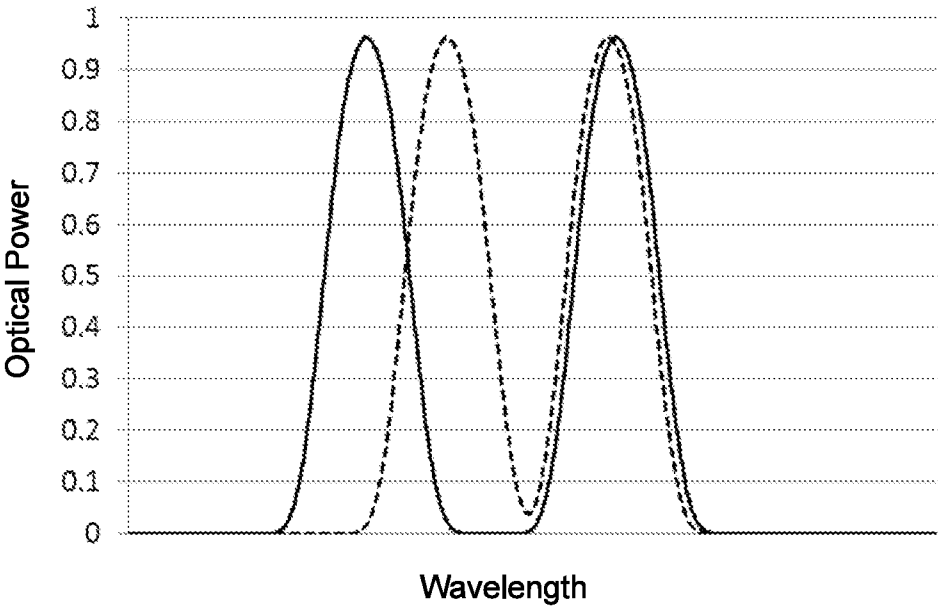


Fig 18

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US2020/018242**A. CLASSIFICATION OF SUBJECT MATTER****G01L 11/02(2006.01)i, G01L 1/24(2006.01)i, G01D 5/26(2006.01)i, G01L 19/08(2006.01)i**

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)

G01L 11/02; C03B 37/023; G01L 1/24; G01N 21/00; G02B 6/00; G02B 6/02; G02B 6/032; G02B 6/34; G01D 5/26; G01L 19/08

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Korean utility models and applications for utility models

Japanese utility models and applications for utility models

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

eKOMPASS(KIPO internal) & Keywords: pressure sensor, form, optical fibre, birefringence structure, core, cladding, chamber, optical sensor, substantially non-compressible fluid, shape, anisotropic stress

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	WO 99-032863 A1 (OPTOPLAN AS et al.) 01 July 1999 abstract, page 1, line 1 - page 6, line 18, claim 1 and figures 1-3	1-14, 25-42
A		15-24
Y	US 2014-0147074 A1 (WEATHERFORD/LAMB, INC.) 29 May 2014 paragraphs [0003]-[0054] and figures 1-10	1-14, 25-42
Y	US 2007-0177846 A1 (CHEN et al.) 02 August 2007 paragraphs [0002]-[0108] and figures 1A-22	35
A	US 2012-0224811 A1 (GEERNAERT et al.) 06 September 2012 paragraphs [0001]-[0051] and figures 1-8	1-42
A	US 8780339 B2 (UDD, ERIC) 15 July 2014 column 1, line 13 - column 4, line 55 and figures 1A-24H	1-42



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"D" document cited by the applicant in the international application

"E" earlier application or patent but published on or after the international filing date

"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)

"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

"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

"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

"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

"&" document member of the same patent family

Date of the actual completion of the international search

18 June 2020 (18.06.2020)

Date of mailing of the international search report

18 June 2020 (18.06.2020)

Name and mailing address of the ISA/KR

International Application Division

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

PCT/US2020/018242

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