



For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

CROSS REFERENCES TO RELATED APPLICATIONS

This application is a Continuation-In-Part of United States Patent Application Serial No. 10/045,263 filed Nov. 7, 2001 and published as US 2002/0113717 A1 on Aug. 22, 2002, that claims priority from United States Provisional Patent Application Serial
5 No. 60/248,097 filed on November 13, 2000, all of which are incorporated herein by reference. This application is also related to United States Patent US 6,614,360, having the same assignee as the present application which is incorporated herein by reference.

FIELD OF THE INVENTION

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This invention generally relates to acoustic logging while drilling. More specifically this invention relates to a method and apparatus for generating an acoustic signal for measuring and processing an acoustic characteristic such as formation shear wave velocity of subsurface sonic waves after these waves traverse earth formations
15 adjoining a borehole or passing through a portion of the subsurface.

BACKGROUND OF THE INVENTION

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To obtain hydrocarbons such as oil and gas, wellbores (also referred to as the boreholes) are drilled by rotating a drill bit attached at the end of a drilling assembly generally referred to as the "bottom hole assembly" (BHA) or the "drilling assembly."

The wellbore path of such wells is carefully planned prior to drilling such wellbores utilizing seismic maps of the earth's subsurface and well data from previously drilled wellbores in the associated oil fields. Due to the very high cost of drilling such wellbores and the need to minimize time actually spent drilling and wireline logging wells, it is
5 essential to gain as much information as possible during drilling of the wellbores. Information about downhole conditions and materials may be acquired with wireline tools or bottom hole assemblies (BHA). Wireline tools are generally used after a wellbore is drilled, bottom hole assemblies may be used while the well is being drilled as part of the drilling string. Downhole wellbore information acquired from BHA
10 components may be utilized, among other things, to monitor and adjust the drilling direction of the wellbores or to detect the presence of geologic formations and hydrocarbons.

In logging while drilling through an earth formation, it is desirable to measure
15 formation shear wave velocity. The shear wave velocity of earth formations provides information important for exploration and production of oil and gas from the formation. The shear wave velocity profile enables the conversion of seismic shear wave time sections to depth sections and is utilized in the interpretation of seismic wave amplitude variation versus detector offset. The ratio between the shear wave velocity and the
20 compressional wave velocity is closely related to the rock lithology and is related to hydrocarbon saturation. Shear wave velocity is also used to evaluate the mechanical properties of the formation in reservoir engineering applications.

Because of the importance of earth formation shear velocity, various methods have been developed to measure it. In conventional wireline logging using a monopole acoustic tool, the shear velocity can be measured from the shear wave refracted along the borehole wall if the formation shear wave velocity is greater than the borehole fluid acoustic velocity. A formation that has a shear wave velocity faster than the borehole fluid is called a 'fast formation.' However, in a formation where the shear velocity is slower than borehole fluid velocity, a 'slow formation,' the shear wave can no longer refract along the borehole wall, and the shear velocity cannot be directly measured from monopole logging. Because of the need to measure shear velocity in slow formations, especially in the soft sediments of deep-water reservoirs, dipole acoustic logging tools were developed. The dipole tool induces and measures the bending or flexural wave motion in the formation. In a sufficiently low frequency range (1-3 kHz), the flexural wave travels at the shear velocity of the formation, regardless whether the formation is fast or slow. This allows for direct measurement of formation shear velocity using the dipole acoustic tool. Dipole acoustic logging is now a mature technology with worldwide commercial applications.

A viable technique for shear wave velocity measurement is using the quadrupole shear waves. A quadrupole acoustic tool induces and measures the quadrupole shear wave in the formation. The low-frequency portion of the wave travels at the formation shear wave velocity, allowing for direct shear velocity measurement from the quadrupole

wave. Although the quadrupole shear wave has been extensively studied theoretically and a wireline quadrupole-logging tool was also proposed (Winbow et al., 1991 in US Patent No. 5,027,331), this technology has not yet been commercially applied to the oil and gas industry. This is largely because the wide acceptance and success of the dipole
5 shear wave technology have fulfilled the needs for measuring shear velocity in slow formations.

The acoustic Logging-While-Drilling (LWD) technology has been developed in recent years out of the needs for saving rig-time and for real-time applications such as
10 geosteering and pore pressure determination, among others. The LWD acoustic technology is aimed at measuring the compressional- and shear-wave velocities of an earth formation during drilling. This technology has been successful in the measurement of compressional wave velocity of earth formations. The need for determining the shear wave velocity in slow formations calls for further development of the technology for
15 shear wave measurement capability. Because of the popularity and success of the dipole shear wave technology in wireline logging, this technology is naturally extended to the LWD situation and a LWD dipole acoustic tool has been built and offered for commercial applications.

20 The application of the dipole acoustic technology to LWD has a serious drawback caused by the presence of the drilling collar with BHA that occupies a large part of the borehole. The drawback is that the formation dipole shear wave traveling along the

borehole is severely contaminated by the dipole wave traveling in the collar. There is a need for a method of determination of shear wave velocities of earth formations that is relatively robust in the presence of tool mode waves propagating along the drill collar. The need is particularly acute in situations where the formation shear velocity is less than the velocity of propagation of compressional waves in borehole fluids. The parent application presents a system and methods for using higher acoustic modes, such as, for example, the quadrupole mode for determining the formation shear velocity. As discussed in the parent application and later, herein, the quadrupole, and higher, modes exhibit a cut-off frequency in the drill collar below which, these higher modes do not propagate in the collar. Therefore, it is desirable to transmit signals into the formation at frequencies below the collar cut-off frequency. One range of desirable frequencies, for example, is 1-3 kHz.

Common downhole acoustic sources utilize piezoelectric transducers for generating the acoustic signals. While such transducers may exhibit acceptable signal strength at higher frequencies, for example > 10 kHz, they are typically less efficient at lower frequencies of interest for the investigations desired here. The low signal strength can be masked by the drilling noise present during drilling. Low signal strength also limits the depth of investigation for such a system.

There is a need for an acoustic signal generator that provides a relatively high signal strength over the entire frequency range of interest for acoustic logging while drilling investigations.

SUMMARY OF THE INVENTION

In one aspect of the present invention, an acoustic logging apparatus comprises a drill collar conveyed on a drilling tubular in a borehole within a formation. At least one
5 electromagnetically energized actuator is disposed on the drill collar. At least one transmitting element is disposed on the drill collar. A flexure ring is coupled to the at least electromagnetically energized actuator and the at least one transmitting element for converting an electromagnetically energized actuator displacement into a related transmitting element displacement.

10 In another aspect, a method of generating an acoustic logging signal comprises conveying a drill collar on a drilling tubular into a borehole within a formation. At least one electromagnetically energized actuator is disposed on the drill collar. At least one transmitting element is disposed on the drilling collar. At least one transmitting element is coupled to the at least one electromagnetically energized actuator by a flexure ring
15 for converting an electromagnetically energized actuator displacement into a related transmitting element displacement. The at least one electromagnetically energized actuator is energized causing a related transmitting element displacement for transmitting an acoustic signal in the formation.

In another aspect, a transmitter for use in an acoustic logging tool, comprises at
20 least one magnetostrictive actuator providing a magnetostrictive actuator displacement substantially parallel to a longitudinal axis of the acoustic logging tool. A piston adapted to move substantially normal to the longitudinal axis of the acoustic logging

tool. A flexure ring is cooperatively coupled to the magnetostrictive actuator and the piston for converting the magnetostrictive actuator displacement into a related piston displacement.

5 **BRIEF DESCRIPTION OF THE DRAWINGS**

The novel features which are believed to be characteristic of the invention, both as to organization and methods of operation, together with the objects and advantages thereof, will be better understood from the following detailed description and the drawings

10 wherein the invention is illustrated by way of example for the purpose of illustration and description only and are not intended as a definition of the limits of the invention, wherein:

FIG. 1A shows a schematic diagram of a drilling system that employs the apparatus of the current invention in a logging-while-drilling (LWD) embodiment;

15 FIG. 1B illustrates a LWD tool on a drill collar;

FIG. 2 illustrates velocity dispersion curves for formation and drill-collar dipole modes.

FIG. 3 illustrates dipole acoustic waveforms in the presence of a drilling collar;

FIG. 4A shows a schematic illustration of the field for a quadrupole wave;

FIG. 4B illustrates velocity dispersion curves for formation and drill-collar quadrupole
20 modes;

FIG. 5A illustrates wavefield snapshots of acoustic energy near the borehole, where radial particle velocity associated with the quadrupole wave motion is displayed;

FIG. 5B illustrates quadrupole waveforms at various offsets;

FIG. 6A illustrates wavefield snapshots of acoustic energy near the borehole, where radial particle velocity associated with the quadrupole wave motion in a thin-collared pipe is displayed;

5 FIG. 6B shows time domain displays of the data in Figure 6A;

FIG. 7 illustrates a simplified perspective view of a source cross-section in conjunction with the drilling collar;

FIG. 8 illustrates a detailed cross-sectional view of a segmented ring transmitting implementation of a source;

10 FIG. 9 illustrates a detailed cross-sectional view of a compartmentalized segmented transmitting implementation of a source;

FIG. 10 is a perspective view of the sensor layout around the collar;

FIG. 11 illustrates a detailed cross-sectional view of a segmented ring receiving sensor implementation;

15 FIG. 12 illustrates a detailed cross-sectional view of a compartmentalized segmented receiving sensor implementation;

FIGURES 13A and 13B show the preset invention using two receiver elements for detection of quadrupole signals;

FIG. 14 illustrates a side view of a portion of the device of Figure 12;

20 FIG. 15 shows the higher order quadrupole modes in a fast formation;

FIG. 16 shows the equivalence of a quadrupole to a pair of dipoles;

FIG. 17A shows a cross-section of a magnetostrictive transmitter according to one preferred embodiment of the present invention; and

FIG. 17 B shows a view of Detail B of FIG. 17A.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

The present invention is a method, system and apparatus for generating multiple acoustic modes for measuring shear wave formation velocities while a well is being drilled. To
5 the extent that the following description is specific to a particular embodiment or a particular use of the invention, this is intended to be illustrative and is not to be construed as limiting the scope of the invention.

Figure 1A shows a schematic diagram of a drilling system **10** having a bottom hole
10 assembly (BHA) or drilling assembly **90** that includes sensors for downhole wellbore condition and location measurements. The BHA **90** is conveyed in a borehole **26**. The drilling system **10** includes a conventional derrick **11** erected on a floor **12** which supports a rotary table **14** that is rotated by a prime mover such as an electric motor (not shown) at a desired rotational speed. The drill string **20** includes a tubing (drill pipe or
15 coiled-tubing) **22** extending downward from the surface into the borehole **26**. A drill bit **50**, attached to the drill string **20** end, disintegrates the geological formations when it is rotated to drill the borehole **26**. The drill string **20** is coupled to a drawworks **30** via a kelly joint **21**, swivel **28** and line **29** through a pulley (not shown). Drawworks **30** is operated to control the weight on bit ("WOB"), which is an important parameter that
20 affects the rate of penetration ("ROP"). A tubing injector **14a** and a reel (not shown) are used instead of the rotary table **14** to inject the BHA into the wellbore when a coiled-

tubing is used as the conveying member **22**. The operations of the drawworks **30** and the tubing injector **14a** are known in the art and are thus not described in detail herein.

During drilling, a suitable drilling fluid **31** from a mud pit (source) **32** is circulated under
5 pressure through the drill string **20** by a mud pump **34**. The drilling fluid passes from the mud pump **34** into the drill string **20** via a desurger **36** and the fluid line **38**. The drilling fluid **31** discharges at the borehole bottom **51** through openings in the drill bit **50**. The drilling fluid **31** circulates uphole through the annular space **27** between the drill string **20** and the borehole **26** and returns to the mud pit **32** via a return line **35** and drill-cutting
10 screen **85** that removes the drill cuttings **86** from the returning drilling fluid **31b**. A sensor S_1 in line **38** provides information about the fluid flow rate. A surface torque sensor S_2 and a sensor S_3 associated with the drill string **20** respectively provide information about the torque and the rotational speed of the drill string **20**. Tubing injection speed is determined from the sensor S_5 , while the sensor S_6 provides the hook
15 load of the drill string **20**.

In some applications only rotating the drill pipe **22** rotates the drill bit **50**. However, in many other applications, a downhole motor **55** (mud motor) is disposed in the drilling assembly **90** to rotate the drill bit **50** and the drill pipe **22** is rotated usually to supplement
20 the rotational power, if required, and to effect changes in the drilling direction. In either case, the ROP for a given BHA largely depends on the WOB or the thrust force on the drill bit **50** and its rotational speed.

The mud motor **55** is coupled to the drill bit **50** via a drive disposed in a bearing assembly **57**. The mud motor **55** rotates the drill bit **50** when the drilling fluid **31** passes through the mud motor **55** under pressure. The bearing assembly **57** supports the radial and axial forces of the drill bit **50**, the downthrust of the mud motor **55** and the reactive upward
5 loading from the applied weight on bit. A lower stabilizer **58a** coupled to the bearing assembly **57** acts as a centralizer for the lowermost portion of the drill string **20**.

A surface control unit or processor **40** receives signals from the downhole sensors and devices via a sensor **43** placed in the fluid line **38** and signals from sensors S_1 - S_6 and
10 other sensors used in the system **10** and processes such signals according to programmed instructions provided to the surface control unit **40**. The surface control unit **40** displays desired drilling parameters and other information on a display/monitor **42** that is utilized by an operator to control the drilling operations. The surface control unit **40** contains a computer, memory for storing data, recorder for recording data and other peripherals.
15 The surface control unit **40** also includes a simulation model and processes data according to programmed instructions. The control unit **40** is preferably adapted to activate alarms **44** when certain unsafe or undesirable operating conditions occur.

The BHA may also contain formation evaluation sensors or devices for determining
20 resistivity, density and porosity of the formations surrounding the BHA. A gamma ray device for measuring the gamma ray intensity and other nuclear and non-nuclear devices used as measurement-while-drilling devices are suitably included in the BHA **90**. As an

example, **Figure 1A** shows an example resistivity-measuring device **64** in BHA **90**. It provides signals from which resistivity of the formation near or in front of the drill bit **50** is determined. The resistivity device **64** has transmitting antennae **66a** and **66b** spaced from the receiving antennae **68a** and **68b**. In operation, the transmitted electromagnetic waves are perturbed as they propagate through the formation surrounding the resistivity device **64**. The receiving antennae **68a** and **68b** detect the perturbed waves. Formation resistivity is derived from the phase and amplitude of the detected signals. The detected signals are processed by a downhole computer **70** to determine the resistivity and dielectric values.

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An inclinometer **74** and a gamma ray device **76** are suitably placed along the resistivity-measuring device **64** for respectively determining the inclination of the portion of the drill string near the drill bit **50** and the formation gamma ray intensity. Any suitable inclinometer and gamma ray device, however, may be utilized for the purposes of this invention. In addition, position sensors, such as accelerometers, magnetometers or gyroscopic devices may be disposed in the BHA to determine the drill string azimuth, true coordinates and direction in the wellbore **26**. Such devices are known in the art and are not described in detail herein.

20 In the above-described configuration, the mud motor **55** transfers power to the drill bit **50** via one or more hollow shafts that run through the resistivity-measuring device **64**. The hollow shaft enables the drilling fluid to pass from the mud motor **55** to the drill bit **50**.

In an alternate embodiment of the drill string **20**, the mud motor **55** may be coupled below resistivity measuring device **64** or at any other suitable place. The above described resistivity device, gamma ray device and the inclinometer are preferably placed in a common housing that may be coupled to the motor. The devices for measuring formation porosity, permeability and density (collectively designated by numeral **78**) are preferably placed above the mud motor **55**. Such devices are known in the art and are thus not described in any detail.

As noted earlier, a significant portion of the current drilling systems, especially for drilling highly deviated and horizontal wellbores, utilize coiled-tubing for conveying the drilling assembly downhole. In such application a thruster **71** is deployed in the drill string **90** to provide the required force on the drill bit. For the purpose of this invention, the term weight on bit is used to denote the force on the bit applied to the drill bit during the drilling operation, whether applied by adjusting the weight of the drill string or by thrusters. Also, when coiled-tubing is utilized a rotary table does not rotate the tubing; instead it is injected into the wellbore by a suitable injector **14a** while the downhole motor **55** rotates the drill bit **50**.

Figure 1B is a schematic view of an acoustic logging while drilling tool system on a BHA drill collar **90** containing a drill bit **50**. This system is mounted on the BHA drill collar **90** for performing acoustic measurements while the formation is being drilled. The acoustic logging while drilling tool system has a source **105** to emit acoustic vibrations

106 that may traverse formation 95 and may also be propagated along the borehole wall and be received by sensors A and B which may be in arrays. These sensors are discussed later in the application. A point to note is that the sensors are disposed between the transmitter and the drillbit 50. This has important benefits in that the desired signal
5 produced by the transmitter travels in a direction opposite to the direction of noise generated by the drillbit 50. This makes it possible to use suitable filtering techniques, including phased arrays, to greatly reduce the drillbit noise. In an alternate embodiment of the invention, the transmitter 105 may be located between the sensors and the drillbit 50

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The application of the dipole acoustic technology to LWD has a serious drawback caused by the presence of the drilling collar with BHA that occupies a large part of the borehole. The drawback is that the formation dipole shear wave traveling along the borehole is severely contaminated by the dipole wave traveling in the collar. This is demonstrated by
15 the following theoretical analysis/numerical modeling results.

The dipole wave excitation and propagation characteristics for a borehole with a drilling collar are analyzed. Using known analyses methods, for example the analyses of the type described in Schmitt (1988), one can calculate the velocity dispersion curve for the
20 formation and collar dipole shear (flexural) waves. The dispersion curve describes the velocity variation of a wave mode with frequency. In the example, the borehole diameter is 23.84 cm and the inner- and outer diameter of the collar is 5.4 and 18 cm. respectively.

The inner collar column and the annulus column between the collar and borehole are filled with drilling mud whose acoustic velocity and density are 1,470 m/s and 1 g/cc, respectively. The collar is made of steel (compressional velocity, shear velocity and density of steel are 5,860 m/s, 3,130 m/s, and 7.85 g/cc, respectively). The formation is
5 acoustically slow with compressional velocity of 2,300 m/s, shear velocity 1,000m/s, and density 2 g/cc. It is to be noted that the example is for illustrative purposes only and not intended to be a limitation on the scope of the invention.

The calculated drilling collar and formation flexural wave dispersion curves for dipole
10 modes are shown in **Figure 2**, for the frequency range shown as the horizontal axis of 0 to 14 kHz. The collar dipole wave dispersion curve **201** displayed along the vertical axis shows how velocity of the collar dipole wave varies with frequency over the range 0 to 14 kHz. The formation dipole wave dispersion curve **203** shows that except for low frequencies in this range, there is relatively little change in velocity. The formation and
15 collar flexural wave modes coexist almost for the entire frequency range, except at the very low frequency where the collar flexural mode appears to terminate at the formation shear velocity. Below the frequency where the collar mode terminates, the formation flexural mode velocity appears to continue the collar flexural mode behavior that would exist in the absence of the formation, the velocity decreasing to zero at the zero
20 frequency. This cross-over phenomenon is caused by the strong acoustic interaction between the collar and the formation in this dipole excitation situation.

Dipole acoustic wave propagation in a borehole with a drilling collar may be simulated with numerical finite difference techniques, for example as described in Cheng et al. (1995). The model parameters are the same as used in the above velocity dispersion calculation example. The dipole source and an array of receivers are placed on the rim of the collar. The source excitation center frequency is 2 kHz. **Figure 3** shows the simulated dipole acoustic waveforms displayed with time along the horizontal axis. Dipole acoustic waveforms are displayed by offset corresponding to source-receiver distance along the vertical axis in **Figure 3**. Receiver locations are spaced 0.1524m apart beginning with the near trace waveform at 1.833m 301 to 2.9m 303 offset from the source. The dipole acoustic waveforms are dominated by the collar flexural wave that has a faster velocity and a dispersive character. The initial strong impulses 305 of the dispersive collar flexural wave are followed in time by dispersive energy that is stronger than the flexural wave of interest representing the formation S-wave. The dashed line 335 represents the arrival location and velocity of the formation flexural wave. The formation flexural wave of interest, aligned with dashed line 335, is smaller in amplitude compared with the collar flexural wave, and is severely contaminated by the interaction of the collar flexural wave.

The above velocity dispersion calculation and wave propagation simulation results demonstrate that there is a strong interaction between formation and drilling collar flexural waves. The fundamental cause of this is that the two wave modes coexist in the same frequency range of interest. There are several drawbacks of the LWD dipole

technology for shear velocity measurement. The first is the difficulty in obtaining good quality formation flexural wave measurements in the presence of severe contamination from the collar flexural wave. The collar wave, being a low-frequency mode, is difficult to suppress using attenuation techniques such as cutting grooves and/or inserting

5 absorptive materials in the collar, etc. The second drawback is that the formation flexural wave, even if it could be reliably measured, cannot yield accurate formation shear velocity information because of the collar interaction. As can be seen from **Figure 2**, the high frequency limit of the collar mode approaches the shear velocity of the collar and at the frequency **205** where the collar dipole mode ceases to exist, the velocity of the collar

10 dipole mode is the formation shear velocity **207**. The velocity **203** of the formation dipole mode is, at all frequencies, below the formation shear velocity **205**. In the absence of a collar, when excited at low frequencies, the formation dipole mode would propagate at a velocity equal to the formation shear velocity. Determination of the formation shear velocity from the dispersion curves of either the formation dipole mode or the collar

15 dipole mode is not an easy matter. In addition, during drilling operations, there is a strong dipole mode excited by the drillbit that produces additional noise. For the foregoing reasons, it is difficult, if not impossible, to measure formation shear wave velocity using the dipole acoustic technology in the LWD environment.

20 The preferred manner of deploying certain sensors for LWD shear wave data acquisition, for example in drill string BHA **90** of **Figure 1A** and **1B** will now be described. The actual BHA utilized for a particular application may contain some or all of the sensors

described in the background section, in addition to the present invention. For the purpose of this invention any such BHA could contain one or more seismic sources and receivers referred to as an acoustic logging tool (collectively represented herein by numeral 88) at a suitable location in the BHA 90.

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This invention incorporates a quadrupole acoustic technology for the LWD shear velocity measurement. **Figure 4A** shows an illustration of a quadrupole field. It shows a characteristic four-lobed pattern that may be substantially characterized by a $\cos 2\theta$ azimuthal variation. In the present instance, the field may be associated with particle motion or with pressure. The greatest advantage of using the quadrupole wave is that the collar quadrupole wave exists only above a certain frequency called the cut-off frequency. This frequency depends on the drilling collar thickness and borehole size. Thus, by determining the cut-off frequency for the collar and borehole dimensions, one can select a frequency band in which only the formation quadrupole shear wave is excited. Determining the velocity of the formation quadrupole wave will fulfill the needs for shear wave velocity measurement in the LWD environment. This is different from the situation in wireline logging: while *Winbow* does discuss the use of quadrupole logging on a wireline device, there is no discussion of a cutoff frequency of a quadrupole wave. *Winbow* teaches a wireline logging device. As would be known to those versed in the art, the tool diameter in wireline devices is typically much smaller than the borehole diameter. *Chen* has also discussed the use of a quadrupole source for shear wave logging and shows a comparison of experimental results with theoretical dispersion curves for

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Stoneley waves within the borehole. The tool diameter *Chen's* model is less than half the borehole diameter. As would be known to those versed in the art, Stoneley waves are interface waves propagating along the wall of the borehole. In contrast, the present invention deals with a MWD device wherein the diameter of the drill collar is almost the same as the diameter of the borehole. In such a case, the collar mode becomes important. This collar mode is different from the Stoneley waves discussed in *Chen*.

The feasibility of determining formation shear velocity from quadrupole wave measurement is demonstrated using theoretical/numerical analysis examples. **Figures 4 A,B** shows the velocity dispersion curves of the formation 401 and collar quadrupole waves 403 and 405. Velocity in meter per second (m/s) is displayed along the vertical axis and frequency in kilohertz (kHz) along the horizontal axis. The velocity dispersion curve for an exemplary collar of thickness 35mm is shown as curve 403. The velocity dispersion curve for an exemplary collar of thickness 63mm is shown as curve 405. The formation quadrupole wave is slightly dispersive and reaches the formation shear wave velocity at a low cut-off frequency (around 2 kHz in this case). This indicates that formation shear wave velocity can be determined as the low frequency limit of the velocity of formation quadrupole waves. The collar quadrupole wave velocity curve shows very high values due to the high shear rigidity (steel) and thick wall (63 mm) of the drilling collar. The collar wave for the 63mm thick collar 405, however, exists only in the frequency range above 10 kHz; whereas, the required frequency for shear velocity measurement of the formation is around 2 kHz, well separated from the frequency range

(> 10 kHz) of the collar wave. This frequency separation allows for designing a method and apparatus to generate quadrupole waves only in a predetermined frequency band (0-10 kHz in this case). In this band, only the formation quadrupole wave is generated. This wave excitation/generation scheme may be demonstrated using finite difference
5 simulations.

In a finite difference modeling, a quadrupole source and an array of receivers with a 0.1524 m. spacing are placed at the rim of the collar. The source wavelet center frequency is chosen to be 2 kHz, the amplitude spectrum of the source wavelet
10 diminishing to zero at about 5 kHz, which is below 10 kHz, the cut-off frequency of the collar quadrupole wave. **Figure 5a** shows three snapshots in time of the wavefield intensity due to the quadrupole source. Each snapshot, **501**, **503**, and **505** is a cross-section displaying a fluid inside the drill collar **521**, the drill collar **90**, fluid **523** outside the drill collar, and a formation **95**. Radial particle velocity associated with the
15 quadrupole wave motion is displayed shaded **507**, **509**. These **Figure 5a** snapshots display the locations of wavefield intensity at several instants of time (0.24 milliseconds for **501**, 1.22 milliseconds for **503**, and 2.21 milliseconds for **505**, respectively). In the borehole fluid annulus high wavefield intensity is seen **507** and high wavefield intensity is seen in the formation **509**. The wave motion in the fluid annulus and the motion in the
20 formation are in phase, traveling at the formation shear velocity as demonstrated by the juxtaposition of high wavefield intensity in the fluid **507** and the formation **509** for all three snapshots **501**, **503** and **505**. This is the formation quadrupole wave as discussed in

connection with **Figures 4 A,B**. There is almost no discernable wave intensity for locations anywhere inside the collar except for the initial time (snapshot 0.24 ms) **501** around the source, showing that the collar quadrupole wave is not excited in this frequency band for this collar thickness (2.48 inches).

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The time-domain quadrupole waveforms of the receiver array are displayed in **Figure 5B** where time is represented along the horizontal axis. Quadrupole acoustic waveforms are displayed by offset corresponding to source-receiver distance along the vertical axis in **Figure 5B**. Receiver locations are spaced 0.1524m apart beginning with the near trace waveform at 1.833m **531** to 2.9m **533** offset from the source. **Figure 5B** shows only one wave, the formation quadrupole wave, traveling across the array at the formation shear velocity. The dashed line **535** marks the formation quadrupole wave first arrival. This time-domain wave simulation result is consistent with the frequency domain dispersion analysis result of **Figures 4 A,B**. These examples demonstrate that choosing an appropriate wave excitation frequency band can eliminate collar quadrupole waves.

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The excitation frequency band should be selected based on the drilling collar and borehole dimensions. In drilling practice, the size of the borehole is varied to suit exploration/production needs and/or geological environment of the well to be drilled. Accordingly, the size of the drilling collar also varies. The change of the collar and borehole dimensions, especially the former, will significantly change the collar quadrupole wave characteristics. This, again, can be demonstrated using

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theoretical/numerical analysis examples. The quadrupole dispersion curves for a 35 mm thickness drilling collar (dashed curves) are shown in **Figure 4B**. With the thinner collar, the formation quadrupole dispersion curve (dashed line **403**) is also changed. The cut-off frequency of the formation mode is raised to about 3 kHz and the whole curve exhibits higher values compared to the thick collar case (solid curve **405**). The curve approaches the formation shear wave velocity at low frequencies. On the other hand, the collar quadrupole wave velocity is much reduced compared to the thick collar case (solid curve **405**) and shows a much lower cut-off frequency (about 6 kHz). The general trend shown in Figure 4 is that increasing the collar thickness will move the frequency band of the collar quadrupole wave away from that of the formation quadrupole wave. When the frequency band of the collar quadrupole wave is close to that of the formation quadrupole, measurement of the formation quadrupole wave will be severely impaired, as the following wave simulation example demonstrates.

The example case is where the collar pipe is relatively thin (thickness is only 16 mm or 0.63 inches). The cut-off frequency of the collar quadrupole wave is now about 3.5 kHz. Other parameters, as used in the simulation of **Figure 5B**, are kept unchanged. With the 2 kHz center excitation frequency, both formation and collar quadrupole waves are excited. **Figure 6A** is the counterpart of **Figure 5A**, showing the wavefield snapshots for the 16mm thick collar case. **Figure 6A** shows three snapshots in time of the wavefield intensity due to the quadrupole source. Each snapshot, **601**, **603**, and **605** is a cross-section displaying a fluid **621** inside the drill collar, drill collar **90**, fluid **625** outside the

drill collar, and a formation **95**. Radial particle velocity associated with the quadrupole wave motion is displayed shaded **611**, **613**. These **Figure 6A** snapshots display the locations of wavefield intensity at several instants of time (0.24 milliseconds for **601**, 1.22 milliseconds for **603**, and 2.21 milliseconds for **605**, respectively). In the borehole fluid **625** annulus high wavefield intensity is seen **611** and high wavefield intensity is seen in the collar **613**. For all the three time instants **601**, **603** and **605**, the wavefield intensity in the entire borehole containing the collar is dominated by the collar quadrupole wave. Formation quadrupole wave is weakly excited, which is out of phase with the collar wave.

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The time domain array waveforms are shown in **Figure 6B**. The time-domain quadrupole waveforms of the receiver array are displayed in **Figure 6B** where time is represented along the horizontal axis. Quadrupole acoustic waveforms are displayed by offset corresponding to source-receiver distance along the vertical axis in **Figure 6B**.

15 Receiver locations are spaced 0.1524m apart beginning with the near trace waveform at 1.833m **631** to 2.9m **633** offset from the source. The time domain waveforms are dominated by the collar quadrupole wave that has a moveout velocity of about 1,300 m/s. The dashed line **635** represents the arrival time for the formation quadrupole wave. In this case, it is difficult to measure the formation quadrupole wave in the presence of the strong collar wave. This example demonstrates the importance of the frequency band selection for the LWD quadrupole wave generation and measurement devices.

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The above examples demonstrate the advantage of the quadrupole shear wave in the LWD environment and the requirements that facilitate making the LWD quadrupole shear wave measurement. As a result, a quadrupole LWD shear wave system can be constructed. Quadrupole shear waves in the LWD environment can be generated using a quadrupole source mounted on the drilling collar **90**. **Figure 7** is a simplified perspective view of the source cross-section in conjunction with the drilling collar. As shown in **Figure 7**, the quadrupole source comprises the drilling collar **90** and eight members of equal dimension. The sections are number **701-708**. These members are eight equal sectors of the source cylinder. The cylinder sections are made from either an electrostrictive (or piezoelectric) or a magnetostrictive material capable of generating stress/pressure wave signals from the input electric pulse. In an alternate embodiment of the invention (not shown) the sections comprise electromechanical devices of such devices are shown in US Patent 5,852,262 to *Gill*, the contents of which are incorporated herein by reference. Included in the teachings of *Gill* is an actuator that produces a pressure pulse. By use of suitably configured portholes, dipole or quadrupole pulses may be produced. Bender bars may also be used. Although dividing the source cylinder into four equal sectors suffices to produce a quadrupole source, using eight (or any multiple of four) sectors for the source reduces the mass of each sector so they more easily withstand drilling vibrations. While the description of the source herein uses eight source segments as an example, those versed in the art would recognize how any multiple of four sources could be excited to produce a quadrupole signal.

The lower part of **Figure 7** is a cross-sectional view of the quadrupole shear wave source on the plane perpendicular to the axis of the drilling collar. The elements of the source device are, in one embodiment, eight sectors labeled **701, 702, 703, 704, 705, 706, 707** and **708**. When electrical pulses are applied to the source, each sector will expand or contract in a radially outward or inward manner. Specifically, the electrical pulses can be applied such that sectors (**701, 702**) and diametrically opposed sectors (**705, 706**) will expand and simultaneously, sectors (**703, 704**) and sectors (**707, 708**) will contract, as illustrated in **Figure 7**. Then four stress/pressure waves will be generated in the surrounding borehole fluid/formation, as well as in the drilling collar. It is also to be noted that when a device such as that taught in *Gill* is used, there may only be a single actuator that produces quadrupole signals from suitable portholes.

When all eight sectors are made from the same material and the electrical pulses applied to them have substantially the same amplitude, then the interaction of the four pressure/stress waves inside the drilling collar and in the surrounding borehole/formation will produce quadrupole shear waves. More specifically, if the electrical pulses are modulated such that the frequency band of the generated pressure/stress waves is below the cut-off frequency of the quadrupole shear wave in the drilling collar, then the interaction of the four stress waves in the collar will cancel each other. The interaction of the pressure/stress wave in the borehole and formation will produce a formation quadrupole shear wave to propagate longitudinally along the borehole. This frequency band modulation of the source pulses is part of one embodiment of the present invention.

An actual implementation of the quadrupole shear wave source is now described in more detail. **Figure 8** illustrates a detailed cross-sectional view of a segmented ring transmitter implementation. This implementation has a segmented ring mounted on an elastomeric isolation component **801** in a continuous pocket **803** around the collar **90**. The isolation component is used to reduce drill string induced acoustic signals. The sensor sub assembly can be oil-filled with a cover sleeve **815**, as illustrated, or it can be a potted assembly, requiring no oil. An electronic drive circuit(s) **809** is coupled to the transmitter element(s) **811** to excite acoustic signal(s) into the borehole and formation. A cover sleeve **815** may cover transmitter elements **811**. The electronic drive circuit **809** may be placed in the inner mandrel **813**. The transmitting element(s) **811** can be implemented in various forms to include rings, cylinders, plates, and piston or solenoid elements. The number of segments can be increased in circumferential and/or axial direction as needed.

Figure 9 illustrates a detailed cross-sectional view of a compartmentalized segmented transmitting implementation which has segments mounted on individual elastomeric isolation components **901** in compartmentalized pockets **903** around the collar **90**. There may be oil fill **907** between the transmitting element **911** and a cover sleeve **915**. The transmitting electronics **909** may reside in the inner mandrel **813**.

The quadrupole shear wave in the earth formation produced by the above described quadrupole source may be detected at locations spaced longitudinally along the borehole

from the source, as schematically illustrated in **Figure 1B**. **Figure 1B** is a schematic view of an acoustic logging while drilling tool system on a BHA drill collar **90** containing a drill bit **50**. This system is mounted on the BHA drill collar **90** for performing acoustic measurements while the formation is being drilled. The acoustic logging while drilling tool system may have a source **105** to emit acoustic vibrations **106** that may traverse formation **95** and be received by sensors A and B which may be in arrays. The use of arrays with axially spaced apart elements as shown in **Figure 1B** makes it possible to use well-known phased array filtering techniques for attenuating signals traveling in a particular direction with a specified range of velocities. In a preferred embodiment of the invention, this phased array filtering is used to attenuate noise generated by the borehole. The phased array filtering may also be used to attenuate the collar mode by defining a range of velocities to be attenuated. In an alternate embodiment of the invention, a plurality of axially spaced apart transmitter elements is used and the phased array filtering is used to reduce the generation of collar mode signals.

As shown in **Figure 10** for an embodiment of the present invention, acoustic detectors may be mounted at the rim of the drilling collar. Each detector consists of four similar sensors circumferentially spaced around the collar, for example sequentially named as A, B, C, and D. **Figure 10** is a perspective view of a sensor layout around the collar in relation to source elements as described in **Figure 7**. The center of each sensor is longitudinally aligned with a junction of two source sectors that expand/contract

simultaneously. For example, sensor A is aligned with the junction between source sectors 701 and 702, sensor B is aligned with the junction between source sectors 703 and 704, etc. The four-sensor detector acts to enhance the efficiency of the quadrupole source and to remove possible contamination from a monopole component of the wave signal.

5

An actual implementation of the quadrupole shear wave receivers as quadrupole detector arrays is now described in more detail. **Figure 11** illustrates a detailed cross-sectional view of a segmented ring receiving sensor implementation which has a segmented ring mounted on an elastomeric isolation component 1101 in a continuous pocket 1103 around the collar 90. The isolation is used to reduce drill string induced signals. The sensor sub assembly can be oil-filled 1107 with a cover sleeve 1115, as illustrated or it can be a potted assembly, requiring no oil. An electronic signal conditioning circuit(s) 1109 is coupled to the receiver element(s) 1111 to sense acoustic signal(s) in the borehole and formation. The receiver circuit 1109 may reside within the inner mandrel 813. The receiving element(s) can be implemented in various forms to include rings, cylinders, plates, and piston or solenoid elements. The number of segments can be increased in a circumferential and/or axial direction as needed. The material for the receiver elements may be selected from a piezoelectric material, an electrostrictive material; and, a magnetostrictive material.

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Figure 12 illustrates a detailed cross-sectional view of a compartmentalized segmented receiving sensor implementation which has receiver segments 1211 mounted on

individual elastomeric isolation components **1201** in compartmentalized pockets **1203** around the collar **90**. The inner mandrel **813** holds receiver circuit **1209**, which is coupled with a receiver element **1211**. The receiver element **1211** has a cover sleeve **1215** with an oil filled space **1207** in between.

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United States Patent 6,614,360 B1, assigned to the assignee of this application, the contents of which are fully incorporated herein by reference, teaches how a quadrupole mode may obtained by suitable combination of signals received by two receiver elements with two different excitations of a quadrupole transmitter.

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This is illustrated in **Figure 13a** showing another embodiment of the invention in which a quadrupole excitation is provided by four segments **1401a - 1401d** of a transmitter.

Alternatively, the quadrupole signal could be provided by pairing adjacent segments of the eight-element transmitter discussed above. Hereafter, when references are made to

15 four element transmitters and receivers, it is to be understood that these are intended to cover eight element transmitters and receivers as well. The signal, after propagating through the formation, is detected by a dipole receiver **1410** comprising receiver elements **1403a** and **1403c**. Subsequently, a quadrupole mode is excited as in **Figure 13b** by the transmitter **1400** and received by the same receiver elements **1403a** and **1403c**. Denoting
20 by A and C the signals received by the receiver elements **1403a** and **1403b** for the transmitter firing of **Figure 13a**, and by A* and C* the signals received by the receiver elements **1403a** and **1403b** in **Figure 13b**, by performing the operation

$$S = (A + C) - (A^* + C^*),$$

the signal S will be a quadrupole signal with all common modes including the BHA/drillbit signals attenuated. These common modes include the body wave through the tool, monopole signals (P and S) through the formation and Stoneley waves within the borehole. The Stoneley waves are more of a problem with an MWD tool than with a wireline tool due to the smaller annulus between the tool and the borehole wall: consequently, removal of the common modes is more important than for wireline logging.

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Figure 14 shows a side view of a receiving sensor segment. The collar **90** contains a transducer element **1211** that includes a plurality of active elements **1251**. The other components in **Fig. 14** are as in **Figure 12** and are not discussed further.

15 The signals received from, for example, the **Figure 10** sensors A, B, C, and D may be combined as $(A+C)-(B+D)$. For the source configuration and firing scheme shown in **Figure 7**, the generated quadrupole wave arriving at the sensors A, B, C, and D can be described as follows. Sensors A and C will see, respectively, a pressure wave of the same polarity and amplitude, and sensors B and D, a pressure wave of the same
20 amplitude but reversed polarity. Therefore, adding the signals from A and C and subtracting the signals from B and D, as $(A+C)-(B+D)$, will produce a signal four times stronger than each individual signal of one sensor. Moreover, a LWD quadrupole source,

when placed off the borehole axis, as is often the case during drilling, will also generate a monopole component to propagate along the borehole. At low frequencies, the monopole wave will propagate as a tube wave to contaminate the formation quadrupole shear wave. The low frequency tube wave motion is substantially homogeneous inside the borehole, such that each individual sensor will measure substantially the same tube wave signal. This monopole tube wave can be canceled out by the combination $(A+C)-(B+D)$.

An alternative embodiment of the invention is the low-pass filtering of the signals recorded by each sensor below the cut-off frequency of the collar quadrupole wave. If the source pulses have high frequencies and are not modulated, or if the quadrupole component of the drilling noise has frequency content above the cut-off frequency of the collar quadrupole wave, then the collar quadrupole wave will be excited and recorded by the sensors. Because the collar quadrupole wave exists only above its cut-off frequency, it can be removed by low-pass filtering the sensor signals below the cut-off frequency. As stated above, this cut-off frequency can be determined from the borehole and drilling collar dimensions. Thus the low-pass filter can be designed and installed as a part of the sensor data acquisition and processing system.

For signal coherence enhancement and processing purposes, arrays of the above-mentioned detectors/receivers are placed longitudinally along the drilling collar. The spacing between the adjacent detectors typically ranges from 0.5 to 1 ft (0.1524 to 0.3048 m). The formation shear wave velocity may be determined by correlating the quadrupole

shear wave across the receiver array using any standard array processing method as taught in United States Patent 5,441,890 to *Tang*.

The above discussion has been directed towards determination of formation shear
5 velocities by what would be recognized by those versed in the art as the first order mode.
In “fast” formations where the shear velocity exceeds the compressional velocity in the
borehole fluid, higher modes may exist. This is illustrated in **Figure 15a**. The abscissa is
the frequency and the ordinate is the velocity. **1301a** and **1301b** show an example of the
phase and group velocities of the 1st order quadrupole mode while **1303a** and **1303b**
10 show the phase and group velocities of the 2nd order mode. The formation shear- and
compressional-wave velocities are 4,500 and 2,500 m/s, respectively; the drilling collar
and borehole dimensions and other related parameters are the same as in Figure 5B. The
waveform simulation uses a 5-kHz center-frequency source. Two quadrupole modes
exist in the frequency range below 21 kHz. They are named the first and the second
15 quadrupole mode, respectively, with the higher order mode existing in a higher frequency
range. For the example in **Figure 15A**, the first and the second mode starts to appear
from about 3 and 8 kHz, respectively. The first mode shows a steeply decreasing phase
dispersion curve **1301a** with a well-defined group velocity **1301b** minimum. The
presence of the group velocity minimum produces a phenomenon called the Airy phase.
20 The associated waveforms are shown in **Figure 15B**. The wave energy associated with
the Airy phase dominates the waveforms and lags significantly behind the formation
shear-arrival time **1311**, as shown in **Figure 15B**. In this situation, it is difficult, if not

impossible, to measure the fast formation shear-wave velocity from the waveform data for the first mode.

Measuring the waveform of the second quadrupole wave mode can directly determine the fast formation shear velocity. As shown in **Figure 15A**, in a broad frequency range above the cut-off frequency, the phase velocity curve of the second mode is very close to the formation shear velocity (2,500 m/s in this case). Both the phase and group velocity curves of the second mode are quite flat, indicating minimal dispersion effects. In fact, the quadrupole wave excited in this higher frequency range, which is associated with the second mode, propagates at the formation shear-wave velocity, as illustrated in **Figure 15B**. Since the second quadrupole mode of the formation can be effectively excited below the frequency range of the collar quadrupole, the interference from the latter mode can still be avoided or minimized. As shown in **Figure 15B**, there is no discernable wave energy associated with the collar quadrupole. The example shown in **Figures 15A, 15B** shows that one can reliably determine the formation shear-wave velocity by exciting and measuring the second quadrupole wave mode associated with a fast formation.

The above examples have used a unitary drill collar to illustrate the principles of using quadrupole mode excitation for determination of formation shear properties in a LWD environment. For practical reasons, the logging tool of the present invention may comprise multiple segments of drill collars with transmitters and receivers on different segments of the drill collar. The principles described above are equally applicable to

such segmented drill collars and are intended to be within the scope of the invention. It is possible that the cut-off frequency and the dispersion curves may be different for each segment of the drill collar. This does not affect the principles of operation of the logging tool.

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The above examples have further illustrated the implementation of quadrupoles by at least two pairs of matched “monopole” elements wherein elements within each pair move in unison. An alternative method for excitation of a quadrupole signal or reception of a quadrupole signal is possible using two dipoles, such as bender bars. This is illustrated in **Figure 16**. The elements **1401 – 1403** comprise one dipole, e.g., a first bender bar, and the elements **1405-1407** comprise a second dipole, e.g., a second bender bar. The motion of the bender bars is not radial: it is orthogonal to a radial line joining the center of the tool to the midpoint of the bender bar; nevertheless, a significant quadrupole signal may be excited or received by the configuration shown in **Figure 16**. Such an implementation is intended to be within the scope of the present application.

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Figure 9 describes transmitter elements in multiple pockets spaced around a drill collar **90** that is a part of an acoustic logging tool. As previously mentioned, such a transmitter may be an electromagnetically energized transmitter such as, for example, a magnetostrictive transmitter. One preferred embodiment of a transmitter **1700** is shown in **Figures 17A and B**. Multiple transducer pockets **1730** are spaced around a circumference of drill collar **90** in a manner similar to that described with reference to **Figure 9**. Transmitter **1700** comprises two magnetostrictive actuators **1703** positioned to

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abut shoulders 1731 in pocket 1730 in collar 90. Alternatively, one magnetostrictive actuator 1703 may be used. Each magnetostrictive actuator 1703 is connected by a drive rod 1712 to a flexure ring 1704. Flexure ring 1704 is also coupled to a transmitting element, such as piston 1702, by connecting pin 1718. Piston 1702 is in contact with

5 drilling fluid 31 such that movement of piston 1702 generates a pressure signal in drilling fluid 31. Each magnetostrictive actuator 1703 comprises a magnetostrictive material 1711 surrounded by an electrical coil 1710. Current flowing through each coil 1710 creates a magnetic field that interacts with magnetostrictive material 1711 causing a change in length of magnetostrictive material 1711. A number of materials such as, for example,

10 nickel and nickel alloys exhibit magnetostrictive properties. A preferred magnetostrictive material is a rare-earth material such as a terbium-dysprosium-iron material. Such a material is described in United States Patent No. 4,308,474 which is incorporated herein by reference. Terbium-dysprosium-iron magnetostrictive materials, also herein called rare-earth magnetostrictive materials (REMM) are available, for example, from Etrema

15 Products, Inc. of Ames, Iowa under the brand name ETREMA TERFENOL-D. Note that such materials are also called giant magnetostrictive materials because they exhibit unit elongations, also called strain, 2-3 times that of common magnetostrictive materials such as nickel. Alternatively, other rare-earth combinations may use, for example, holmium, erbium, or gadolinium in place of terbium or dysprosium. The use of such materials in an

20 actuator is described, for example, in United States Patents Nos. 6,012, 521, 6,037,682, 6,230,799 B1, and 6,501,072 B2, all of which are incorporated herein by reference. Alternatively, as one skilled in the art will appreciate, electrostrictive materials that

change shape due to an applied electric field may be used. Such materials, including lead magnesium niobate materials, are commercially available and will not be described here further.

When both actuators 1703 are driven in-phase, the change in length, or
5 displacement 1740, causes push rods 1712 to impart a compressive force on each side of flexure ring 1704 causing compression of flexure ring 1704 in a direction that is substantially parallel to the longitudinal axis of collar 90. The compression in flexure ring 1704 causes a related displacement 1741 of flexure ring 1704 and piston 1702 in a direction substantially transverse to the motion 1740. As shown in Figure 17B, the
10 piston displacement 1741 is substantially normal to the outer surface of collar 90. The compression of flexure ring 1704 causes piston 1702 to move outward and generate a pressure signal 1745 in drilling fluid 31 that propagates through the drilling fluid 31 and into formation 95 surrounding borehole 26 (see Fig. 1). Multiple windings (not shown) may be incorporated in coils 1710 in order to enhance operation at multiple frequencies
15 of interest. As described previously, it is desirable in at least one preferred embodiment, to operate such a transmitter at frequencies below the cut-off frequency for the quadrupole mode in collar 90, for example, on the order of 1-3kHz. At such frequencies, piezoceramic materials are limited, due to their material properties, to lower strains than are rare-earth materials such as terbium-dysprosium-iron materials. As such, the rare-
20 earth magnetostrictive materials are more efficient at generating higher amplitude signals than are piezoceramic materials. The use of rare-earth magnetostrictive materials provides a higher signal strength at the low frequencies and they are also usable at the

higher frequencies, allowing a single type of transmitter over the range of frequencies of interest discussed previously.

In one embodiment, flexure ring 1704 may be configured as a mechanical amplifier such that the amplitude of motion 1740 of magnetostrictive material 1711 results in a piston displacement 1741 that is amplified compared to the displacement of magnetostrictive material 1711. One skilled in the art will realize that if flexure ring 1704 is substantially cylindrical, then the piston displacement 1741 will be substantially the same as the ring deflection caused by the displacement of magnetostrictive material 1711. The flattening of the flexure ring 1704 to an substantially oblate shape, as shown in **Figure 17A,B**, results in a piston motion 1741 that is greater than the deflection of the flexure ring caused by the motion 1740 of magnetostrictive material 1711. The amplification factor may be predetermined using analysis techniques known in the art, such as for example, finite element techniques and depends on the cross section properties, the material properties, and the oblateness of the flexure ring 1704. In addition, flexure ring 1704 may be designed to take advantage of natural vibrational resonances of the ring to enhance the displacement output of the piston. For example, using techniques known in the art, the arched ring shape may be sized such that the arched section 1750 (see **Fig. 17B**) resonates transverse to the displacement of the magnetostrictive material 1711. This resonance further amplifies the motion of the piston 1702 at the lower frequencies of interest. In addition, the lengthwise resonance of the arch may be used to amplify the displacement of the piston at the higher frequencies of interest.

Sensor **1705** is coupled to the arches **1750** and **1751** of flexure ring **1704** and detects the motion of the arches. Signals from sensor **1705** are fed to a controller (not shown) that controls the drive signals to coils **1710**. As such, the drive frequency may be adjusted to control the piston output at predetermined levels.

5 In one embodiment, a reduced thickness section **1760** of piston **1702** is constrained between ring **1720** and retaining body **1701** and floats between elastomeric seals **1721** and **1722** in a predetermined gap between ring **1720** and retaining body **1702**. In this embodiment, the maximum piston travel is determined by difference between the predetermined gap and the thickness of reduced section **1760**. Seals **1721** and **1722** act
10 cooperatively with reduced thickness section **1760** to effect a seal for preventing intrusion of drilling fluid **31** into the transmitter pocket **1730**. In an alternative embodiment (not shown), a flexible bellows coupled between piston **1702** and retaining body **1701**. Retaining body **1701** is fastened to collar **90** and seals the transmitter in pocket **1730** using seal **1732**. A non-conductive oil fills the pocket to and acts through a pressure
15 compensating system (not shown) by passage **1715** to equilibrate the internal pressure of pocket **1730** with the fluid pressure in borehole. Such compensating systems are known in the art and are not described here further.

As described previously, four transmitter pockets **1730** may be spaced around the collar **90**. Alternatively, multiples of four may be used. In operation, with four pockets,
20 the transmitters described herein may be operated as (i) a monopole source, (ii) a dipole source by actuating, and (iii) as a quadrupole source as described previously. Higher pole

sources may be created with more transmitters spaced around the collar 90 as discussed previously.

The above description has been made with respect to a LWD application of the invention. The present invention may also be used in Logging-while-Tripping. As
5 would be known to those versed in the art, it is common for drillbits to wear out and the process of removing a drillstring for the purpose of changing a drill bit is called “tripping.” Making measurements while tripping has the additional advantage that no drilling is being carried out, so that the signals received by the receivers of the present logging tool are not contaminated by drillbit generated noise.

10

While the foregoing disclosure is directed to the preferred embodiments of the invention, various modifications will be apparent to those skilled in the art. It is intended that all variations of the appended claims be embraced by the foregoing disclosure.

What is claimed is:

1. An acoustic logging apparatus, comprising:
 - 5 - a drill collar conveyed on a drilling tubular in a borehole within a formation;
 - at least one electromagnetically energized actuator on said drill collar;
 - at least one transmitting element disposed on said drill collar; and
 - a flexure ring coupled to the at least one electromagnetically energized actuator
 and to the at least one transmitting element for converting an
10 electromagnetically energized actuator displacement into a related transmitting
 element displacement.
2. The acoustic logging apparatus of claim 1, wherein displacement of said at least one
transmitting element generates an acoustic signal transmitted into the formation.
3. The acoustic logging apparatus of claim 1, wherein the at least one
15 electromagnetically energized actuator comprises a magnetostrictive actuator.
4. The acoustic logging apparatus of claim 1, wherein the at least one
electromagnetically energized actuator comprises an electrostrictive actuator.
5. The acoustic logging apparatus of claim 1, wherein the transmitting element
comprises a piston.
- 20 6. The acoustic logging apparatus of claim 3, wherein the at least one magnetostrictive
actuator comprises:
 - a magnetostrictive material; and

- at least one coil surrounding said magnetostrictive material imparting a predetermined magnetic field in said magnetostrictive material when said coil is energized causing said magnetostrictive material to dimensionally change by a predetermined amount causing said magnetostrictive actuator displacement.

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7. The acoustic logging apparatus of claim 1, wherein the electromagnetically energized actuator displacement is substantially parallel to a collar axis and the transmitting element displacement is substantially normal to said collar axis.

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8. The acoustic logging apparatus of claim 1, wherein the flexure ring comprises a metallic material.

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9. The acoustic logging apparatus of claim 1, wherein the flexure ring is comprised of a shape to amplify the piston displacement relative to the magnetostrictive actuator displacement.

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10. The acoustic logging apparatus of claim 9, wherein said shape is substantially oblate.
11. The acoustic logging apparatus of claim 6, wherein said magnetostrictive material comprises a rare-earth magnetostrictive material.

12. The acoustic logging apparatus of claim 11, wherein said rare earth
magnetostrictive material comprises terbium, dysprosium, and iron.
- 5 13. The acoustic logging apparatus of claim 6, wherein said magnetostrictive material
comprises at least one of (i) a nickel material and (ii) a nickel alloy.
14. The acoustic logging apparatus of claim 1, wherein said at least one
electromagnetically energized actuator is disposed in at least one pocket formed in
10 an outer surface of said drill collar.
15. The acoustic logging apparatus of claim 1, further comprising a sensor coupled to
said flexure ring for detecting the displacement of said flexure ring and generating a
signal related thereto.
- 15 16. The acoustic logging apparatus of claim 15, wherein said sensor signal is used by a
controller to control said electromagnetically energized actuator displacement.
17. The acoustic logging apparatus of claim 6, wherein said at least one coil comprises
20 a plurality of coils, each coil of said plurality of coils adapted to operate over a
different predetermined frequency range.

18. The acoustic logging apparatus of claim 1, wherein said flexure ring is adapted to resonate at least one predetermined operational frequency to enhance the displacement of the transmitting element.
- 5 19. A method of generating an acoustic logging signal comprising:
- conveying a drill collar on a drilling tubular into a borehole within a formation;
 - disposing at least one electromagnetically energized actuator on said drill collar;
 - 10 - disposing at least one transmitting element on said drilling collar;
 - coupling said at least one transmitting element to said at least one electromagnetically energized actuator by a flexure ring converting an electromagnetically energized actuator displacement into a related transmitting element displacement ; and
 - 15 - energizing said at least one electromagnetically energized actuator causing a related transmitting element displacement for transmitting an acoustic signal in said formation.
20. The method of claim 19, wherein the at least one electromagnetically energized actuator comprises a magnetostrictive actuator.
- 20 21. The method of claim 19, wherein the at least one electromagnetically energized actuator comprises an electrostrictive actuator.
22. The method of claim 19, wherein the transmitting element comprises a piston.

23. The method of claim 19, wherein the at least one electromagnetically energized actuator comprises:
- a magnetostrictive material; and
 - at least one coil surrounding said magnetostrictive material imparting a predetermined magnetic field in said magnetostrictive material when said coil is energized causing said magnetostrictive material to lengthen by a predetermined amount causing said magnetostrictive actuator displacement.
24. The method of claim 19, wherein the electromagnetically energized actuator displacement is substantially parallel to a drill collar axis and the transmitting element displacement is substantially normal to said drill collar axis.
25. The method of claim 19, wherein the flexure ring comprises a metallic material.
26. The method of claim 19, wherein the flexure ring is comprised of a shape to amplify the piston displacement relative to the electromagnetically energized actuator displacement.
27. The method of claim 26, wherein said shape is substantially oblate.

28. The method of claim 23, wherein said magnetostrictive material comprises a rare-earth magnetostrictive material.
29. The method of claim 28, wherein said rare earth magnetostrictive material includes
5 terbium, dysprosium, and iron.
30. The method of claim 23, wherein said magnetostrictive material comprises at least one of (i) a nickel material and (ii) a nickel alloy.
- 10 31. The method of claim 19, wherein said at least one electromagnetically energized actuator is disposed in a pocket formed in an outer surface of said drill collar.
32. The method of claim 19, further comprising a sensor coupled to said flexure ring for detecting the displacement of said flexure ring and generating a signal related
15 thereto.
33. The method of claim 32, wherein said sensor signal is used by a controller to control said magnetostrictive actuator displacement.
- 20 34. The method of claim 23, wherein said at least one coil comprises a plurality of coils, each coil of said plurality of coils adapted to operate over a different predetermined frequency range.

35. The method of claim 19, wherein said flexure ring is adapted to resonate at least one predetermined operational frequency to enhance the displacement of the piston.

5 36. A transmitter for use in an acoustic logging tool, comprising:

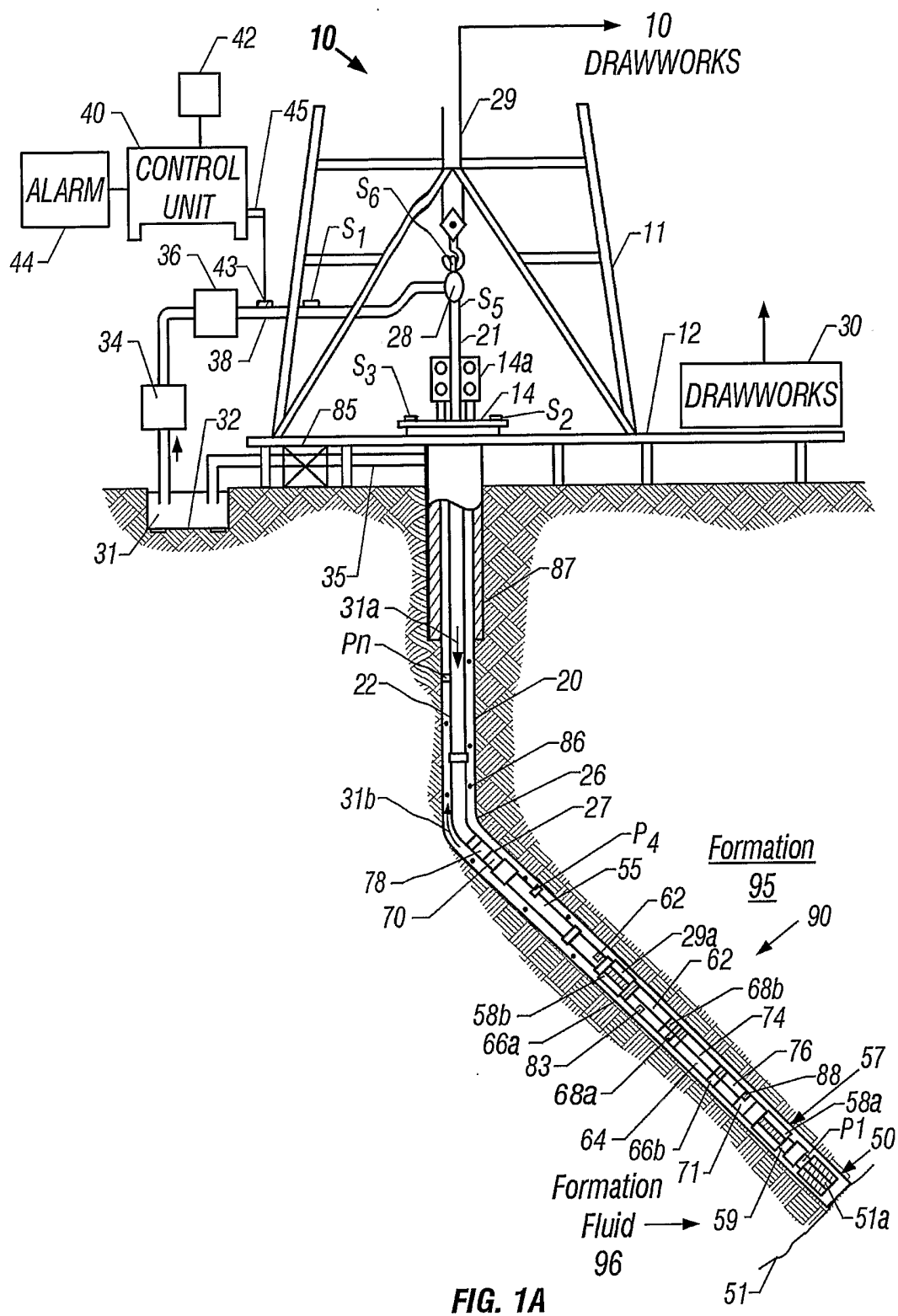
- at least one magnetostrictive actuator providing a displacement substantially parallel to a longitudinal axis of said acoustic logging tool;
- a piston adapted to move substantially normal to said longitudinal axis of said acoustic logging tool; and
- a flexure ring cooperatively coupled to said magnetostrictive actuator and to said piston for converting said magnetostrictive actuator displacement into a related piston displacement.

15 37. The transmitter of claim 36, wherein the at least one magnetostrictive actuator includes:

- a magnetostrictive material; and
- at least one coil surrounding said magnetostrictive material imparting a predetermined magnetic field in said magnetostrictive material when said coil is energized causing said magnetostrictive material to lengthen by a predetermined amount causing said magnetostrictive actuator displacement.

38. The transmitter of claim 36, wherein the flexure ring comprises a metallic material.
39. The transmitter of claim 36, wherein the flexure ring is comprised of a shape to
5 amplify the piston displacement relative to the magnetostrictive actuator
 displacement.
40. The transmitter of claim 39, wherein said shape is substantially oblate.
- 10 41. The transmitter of claim 37, wherein said magnetostrictive material comprises a
 rare-earth magnetostrictive material.
42. The transmitter of claim 41, wherein said rare earth magnetostrictive material
 comprises terbium, dysprosium, and iron.
- 15 43. The transmitter of claim 37, wherein said magnetostrictive material comprises at
 least one of (i) a nickel material and (ii) a nickel alloy.
44. The transmitter of claim 36, wherein said at least one transmitter is disposed in a
20 pocket formed in an outer surface of a drill collar that is part of said acoustic
 logging tool.

45. The transmitter of claim 36, wherein said at least one transmitter comprises a plurality of transmitters disposed circumferentially around said drill collar.
46. The transmitter of claim 36, further comprising a sensor coupled to said flexure ring
5 for detecting the displacement of said flexure ring and generating a signal related thereto.
47. The transmitter of claim 46, wherein said sensor signal is used by a controller to control said magnetostrictive actuator displacement.
- 10 48. The transmitter of claim 37, wherein said at least one coil comprises a plurality of coils, each coil of said plurality of coils adapted to operate over a different predetermined frequency range.
- 15 49. The transmitter of claim 36, wherein said flexure ring is adapted to resonate at least one predetermined operational frequency to enhance the displacement of the piston.



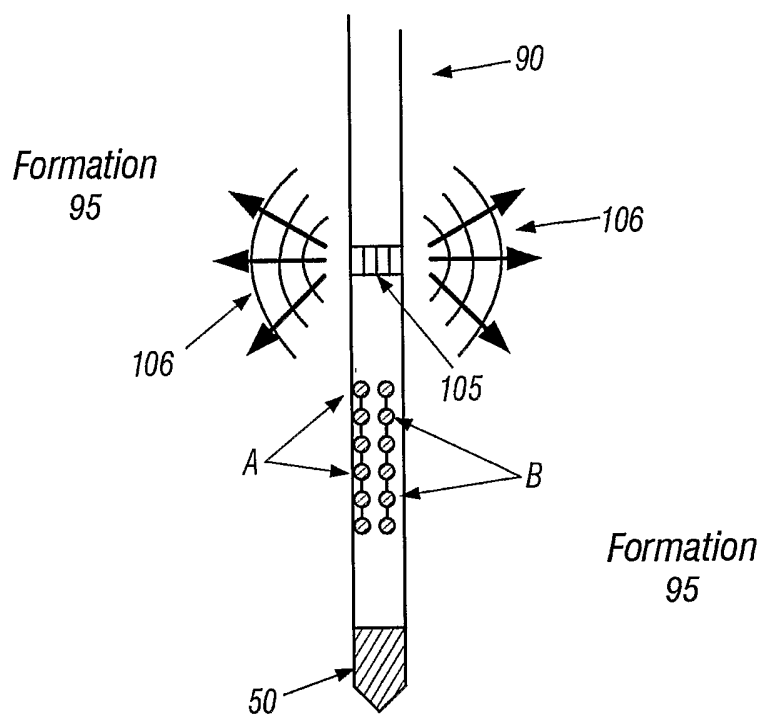


FIG. 1B

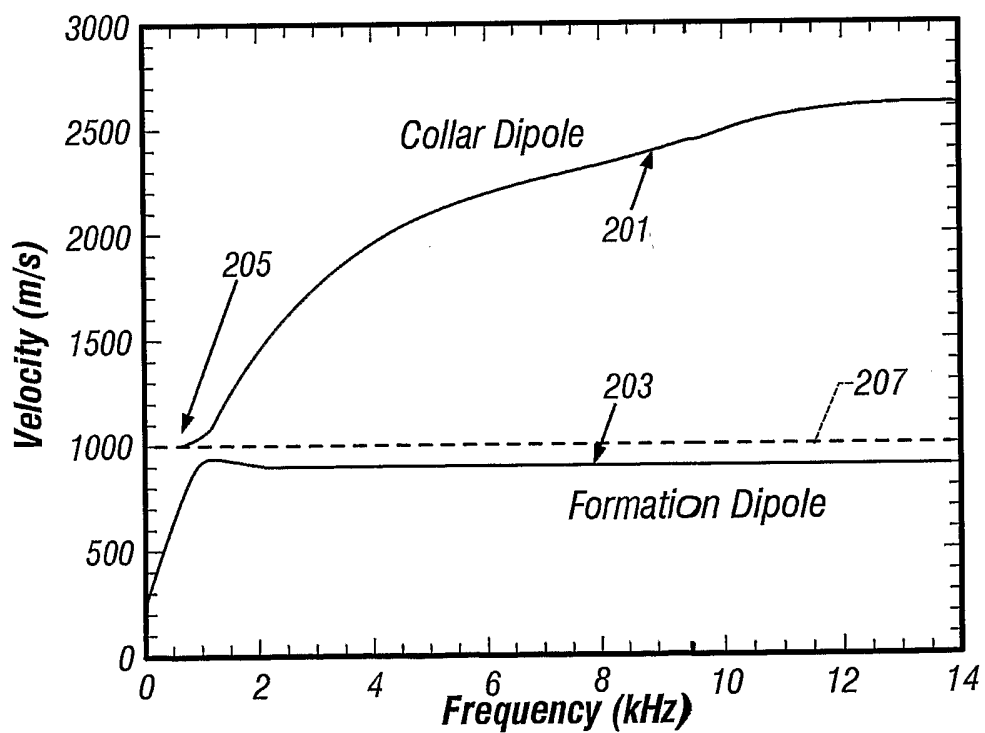


FIG. 2

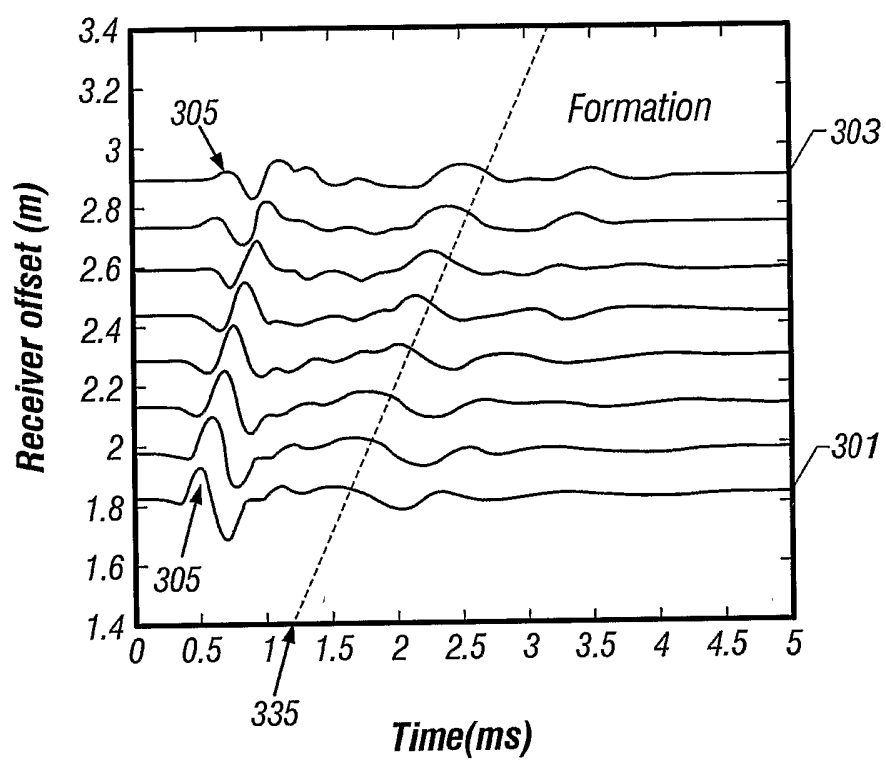
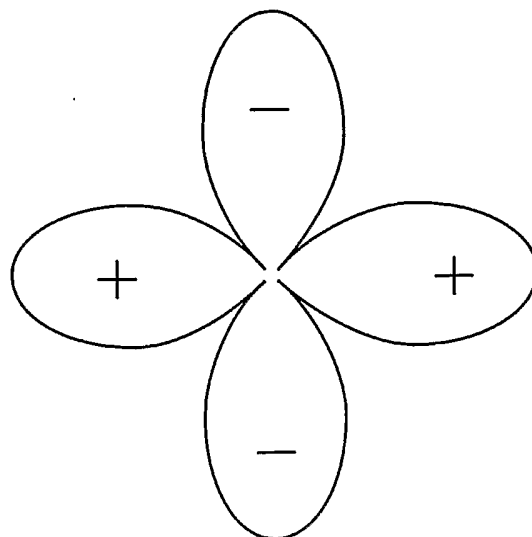
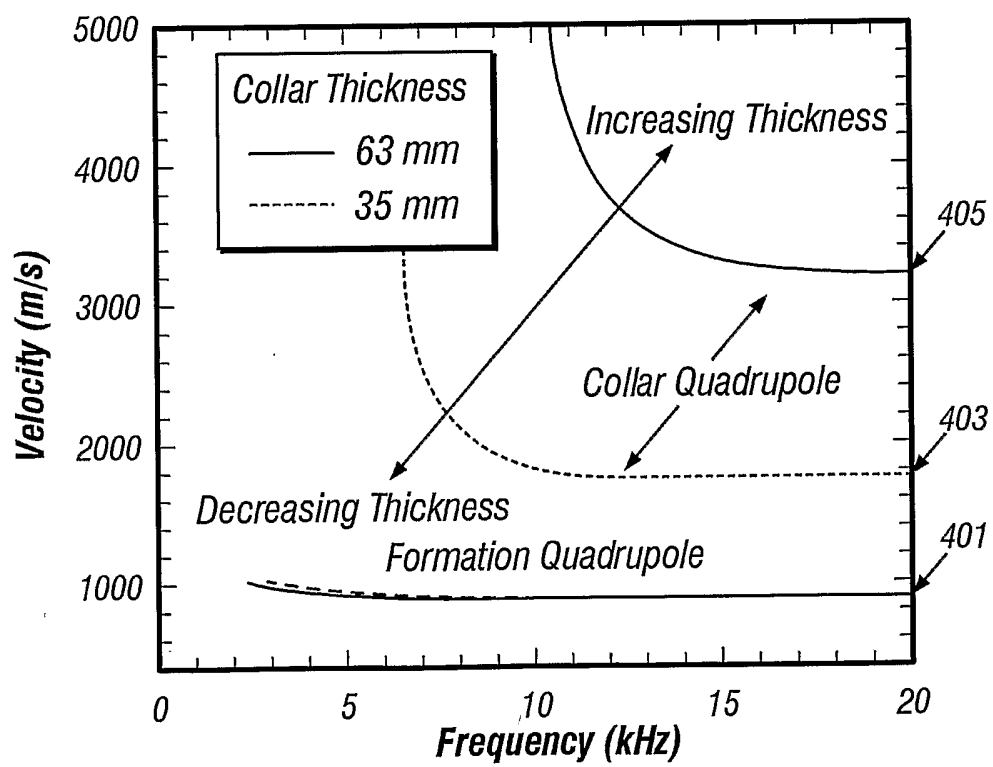


FIG. 3

**FIG. 4A****FIG. 4B**

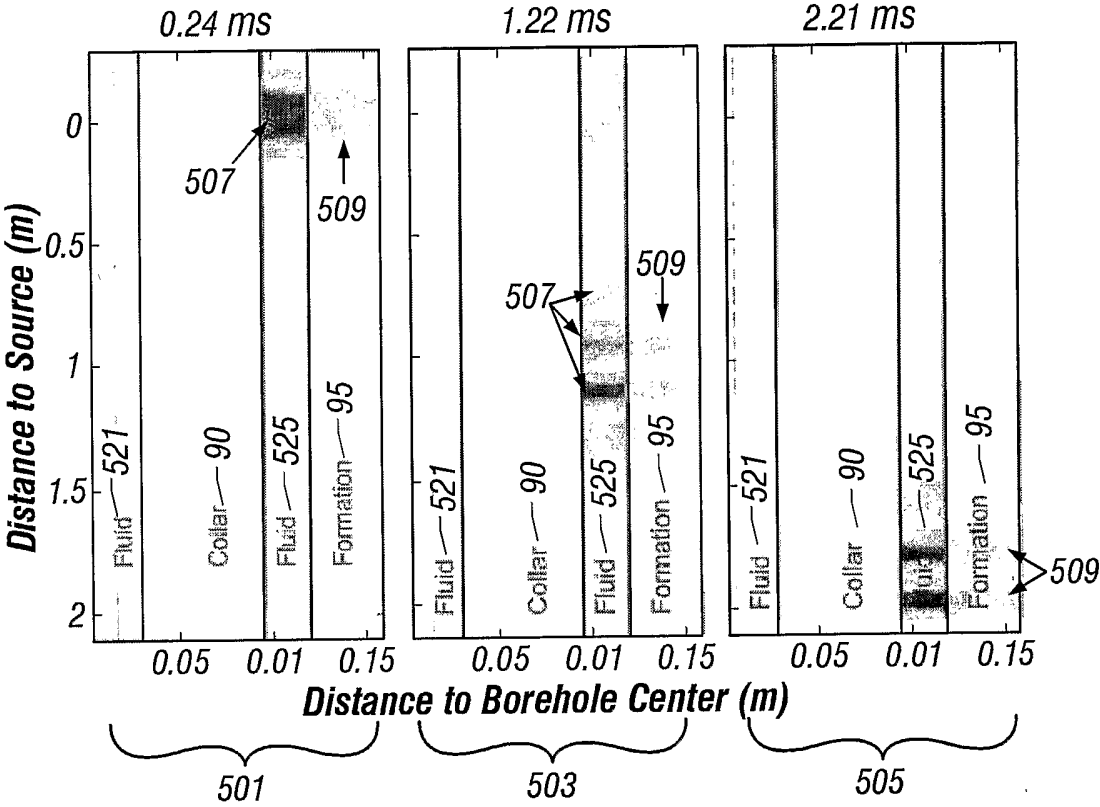


FIG. 5A

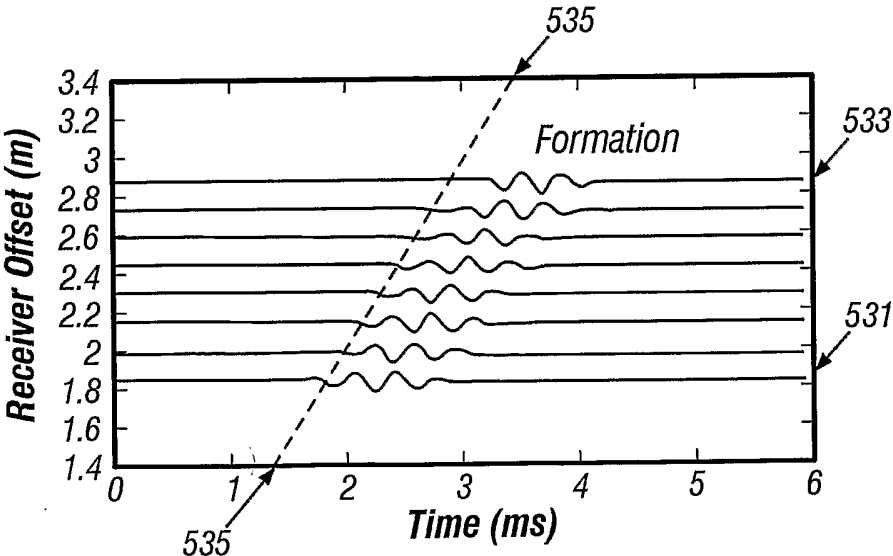


FIG. 5B

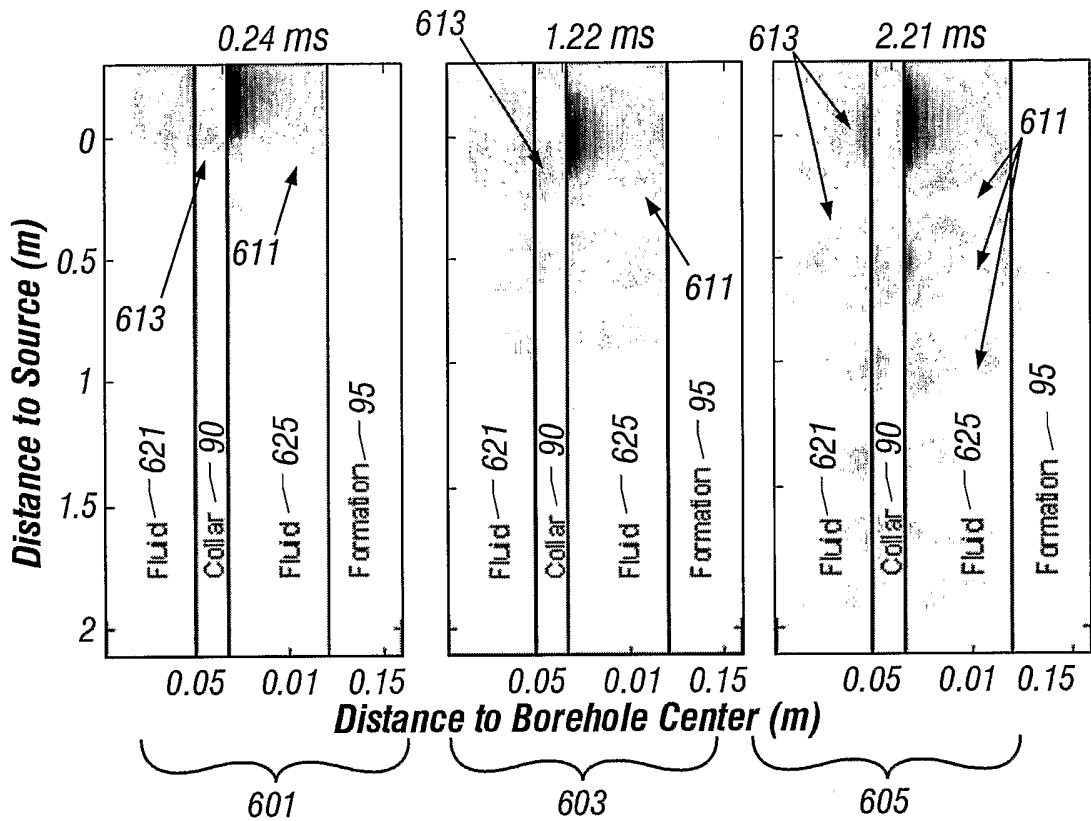


FIG. 6A

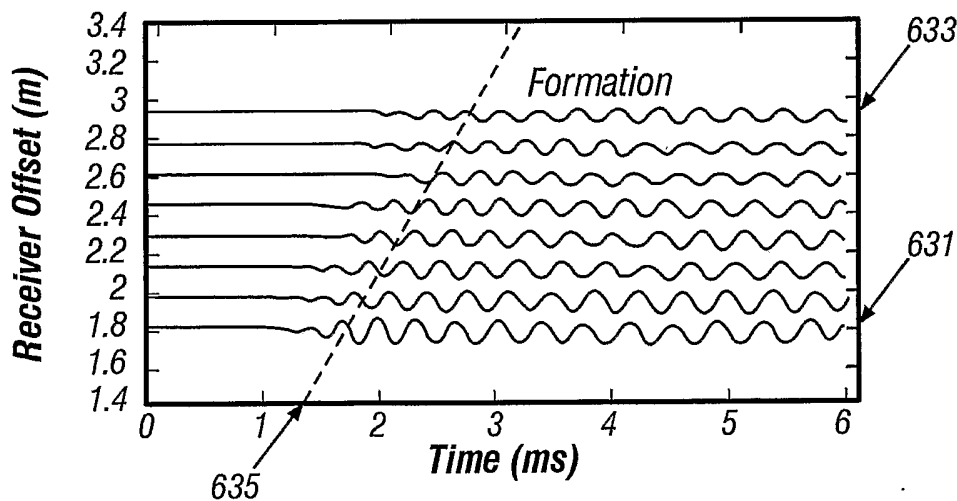
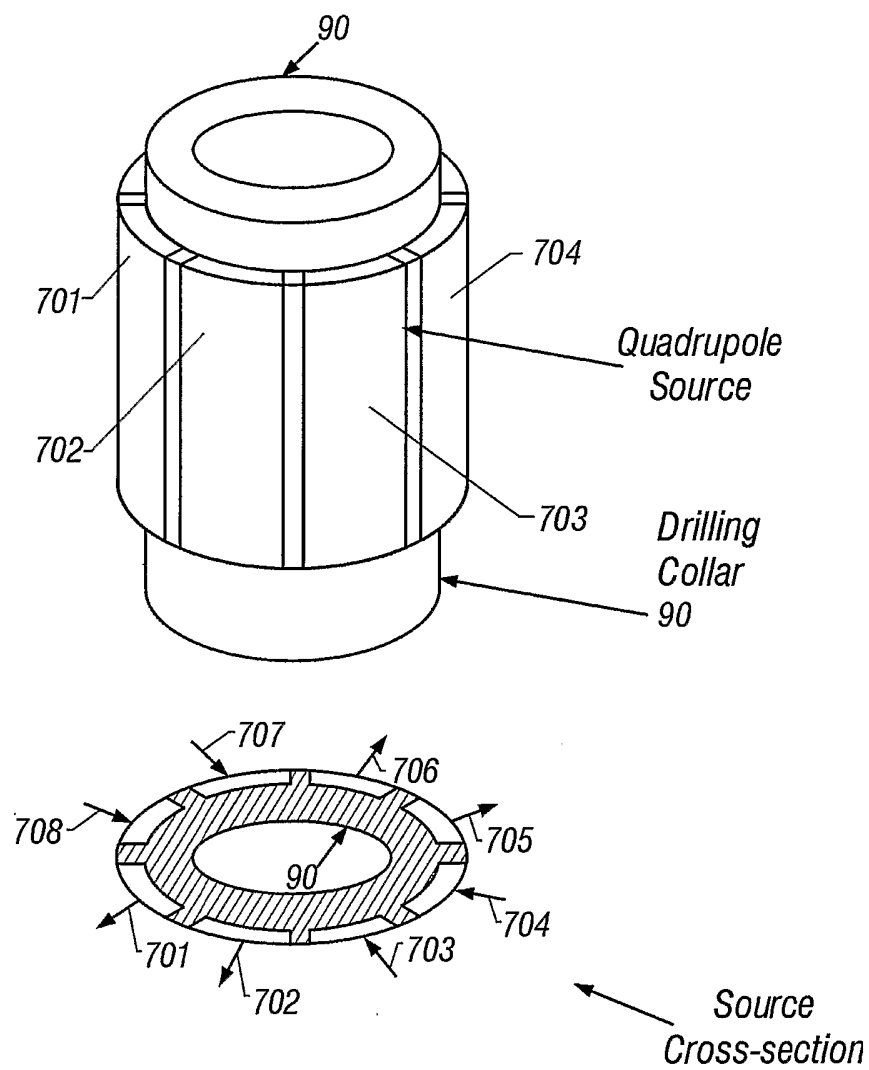
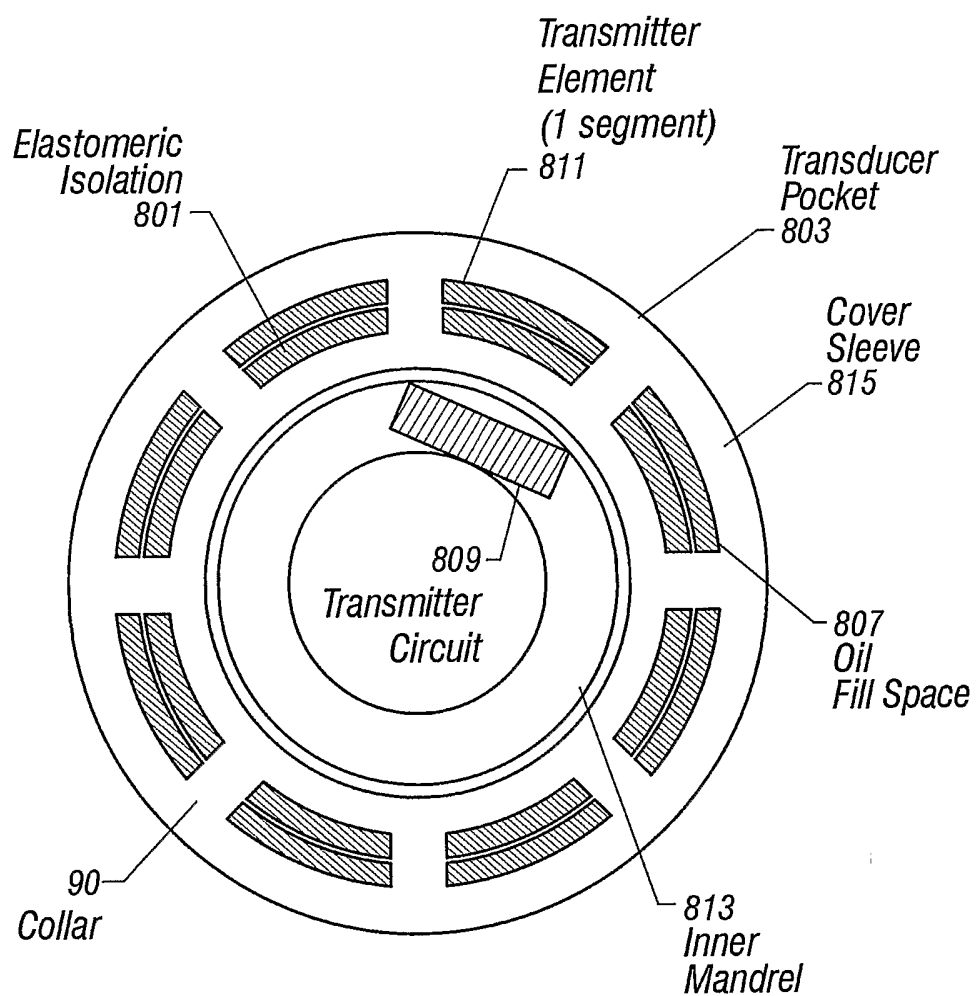
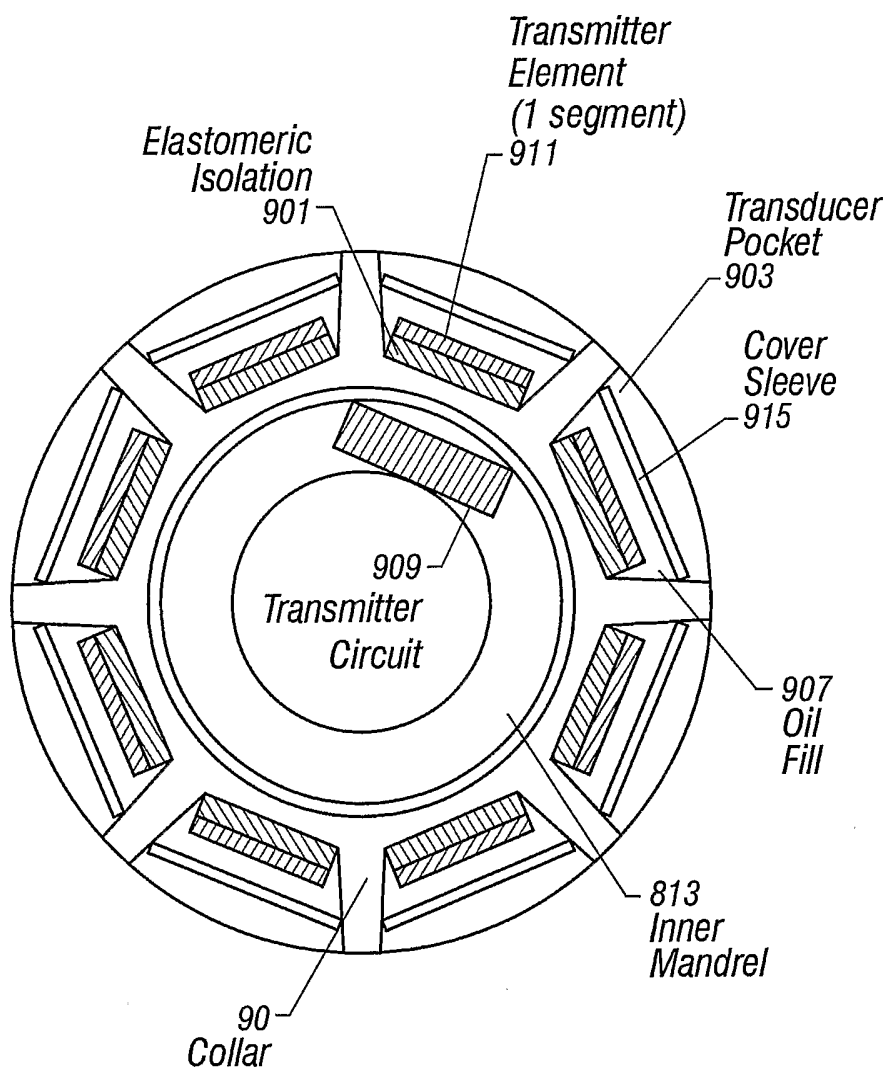
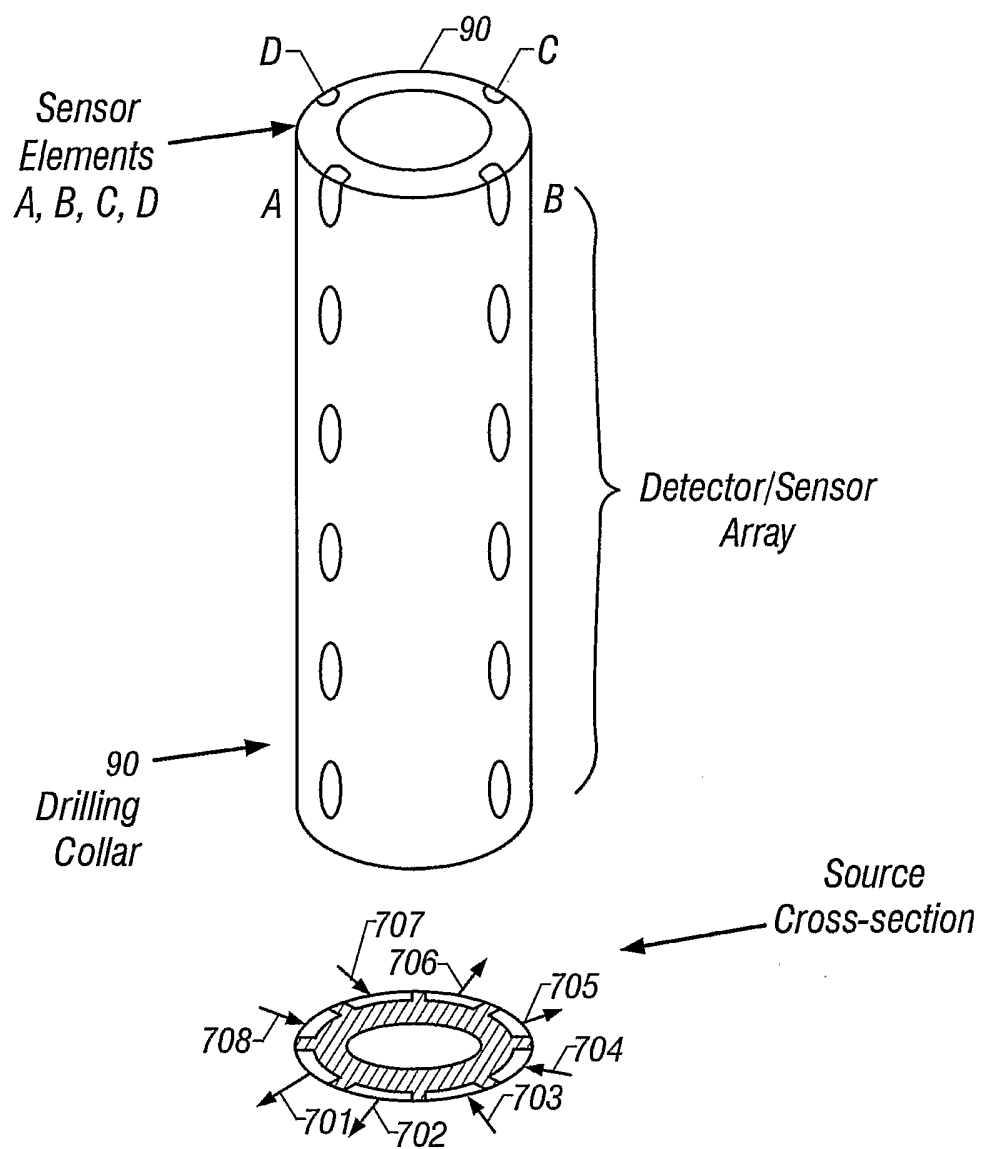


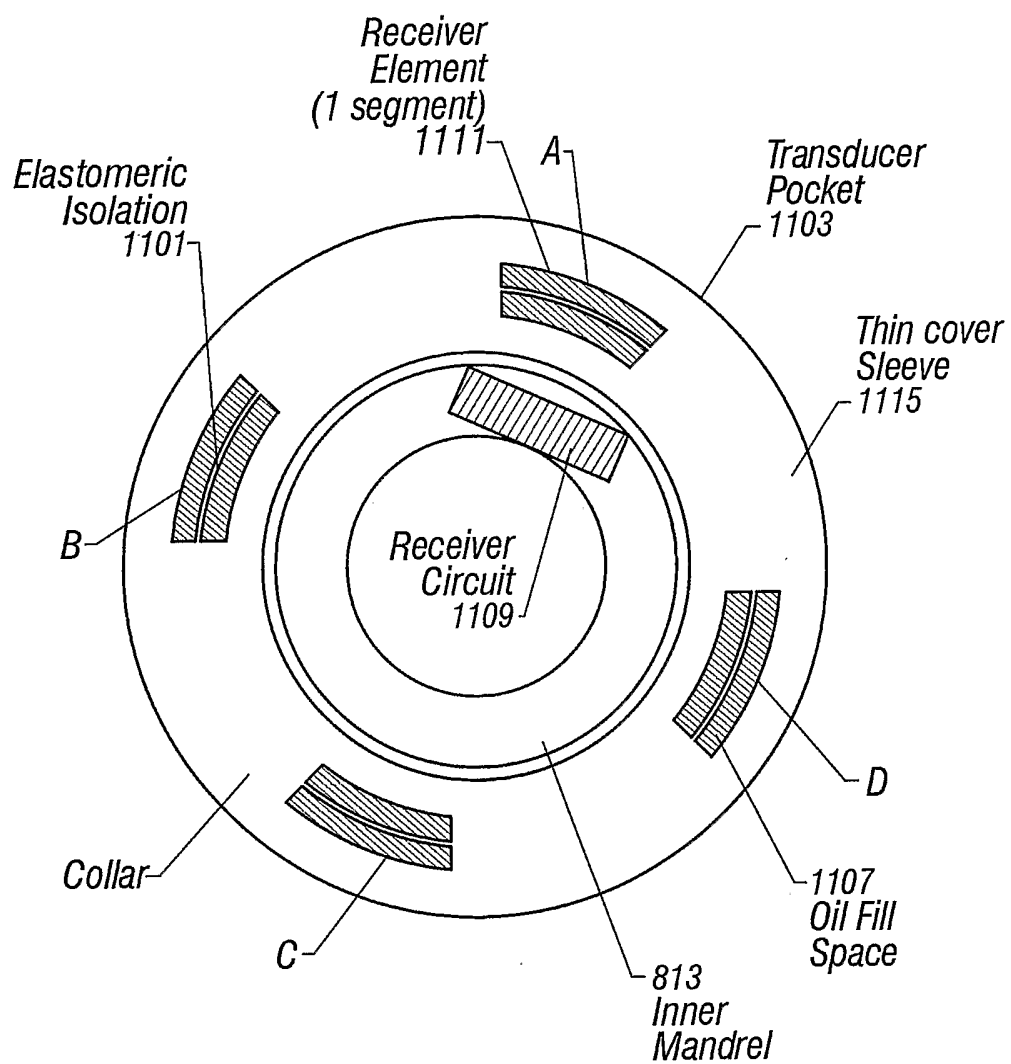
FIG. 6B

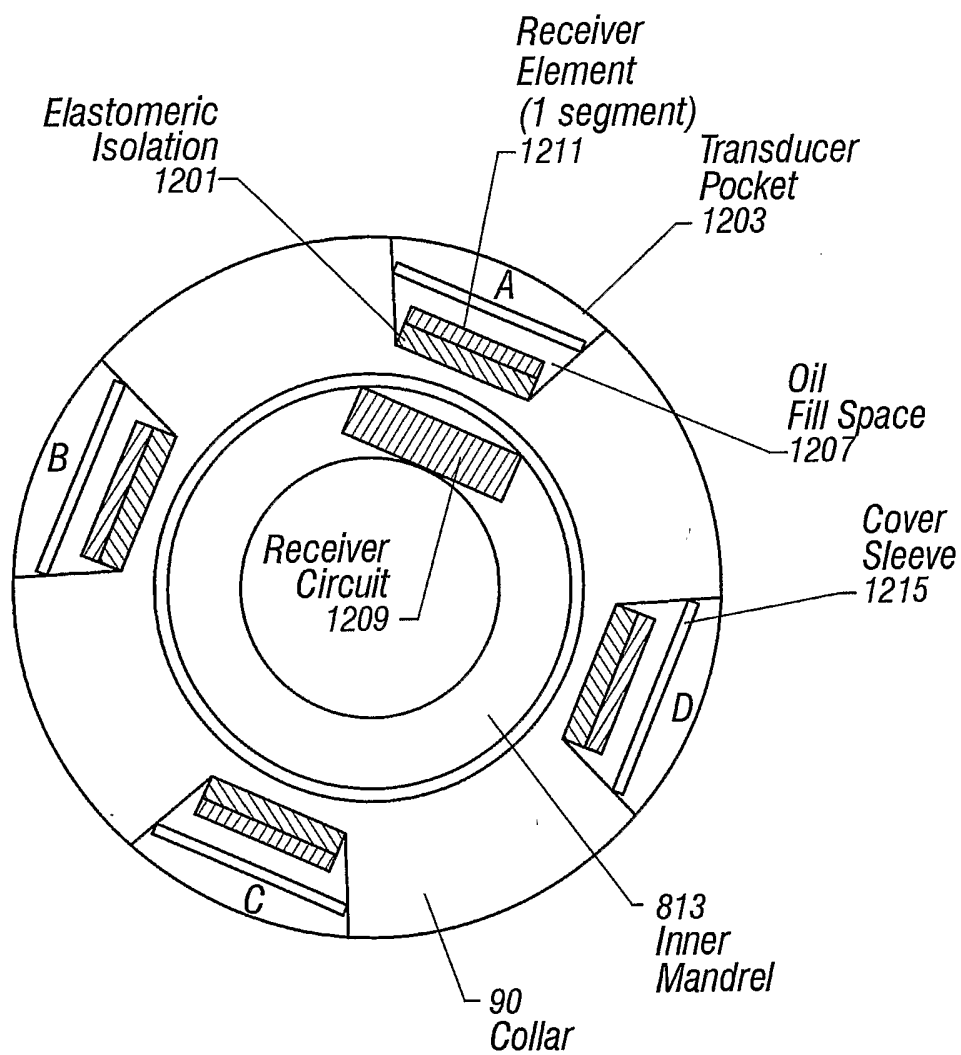
**FIG. 7**

**FIG. 8**

**FIG. 9**



**FIG. 11**

**FIG. 12**

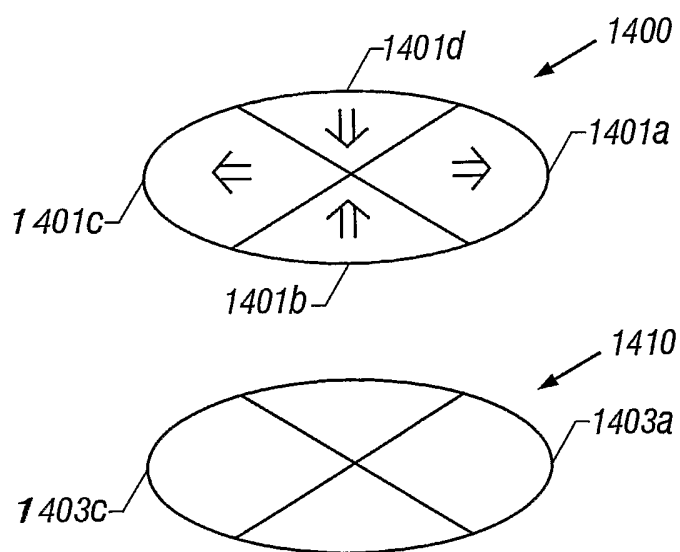


FIG. 13A

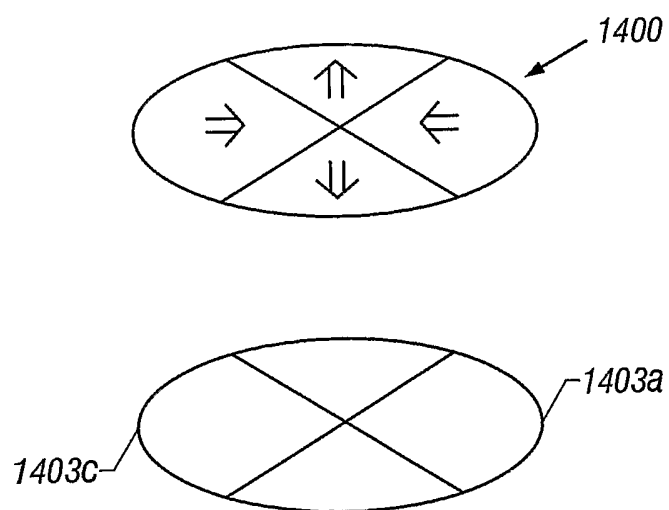
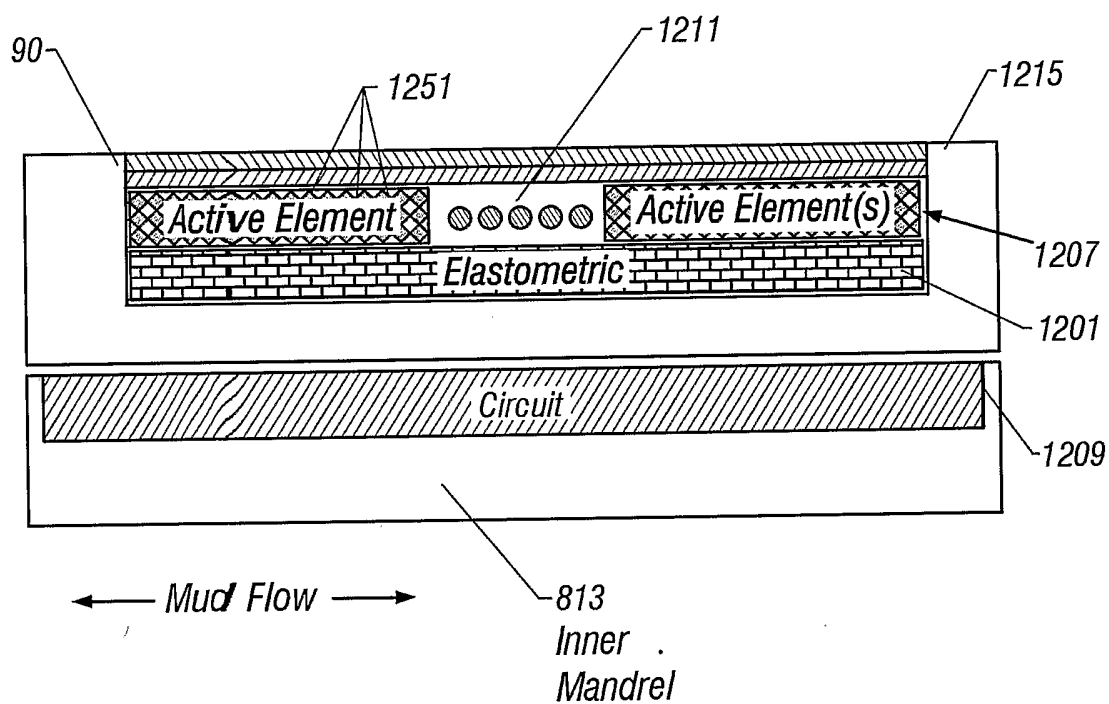


FIG. 13B

**FIG. 14**

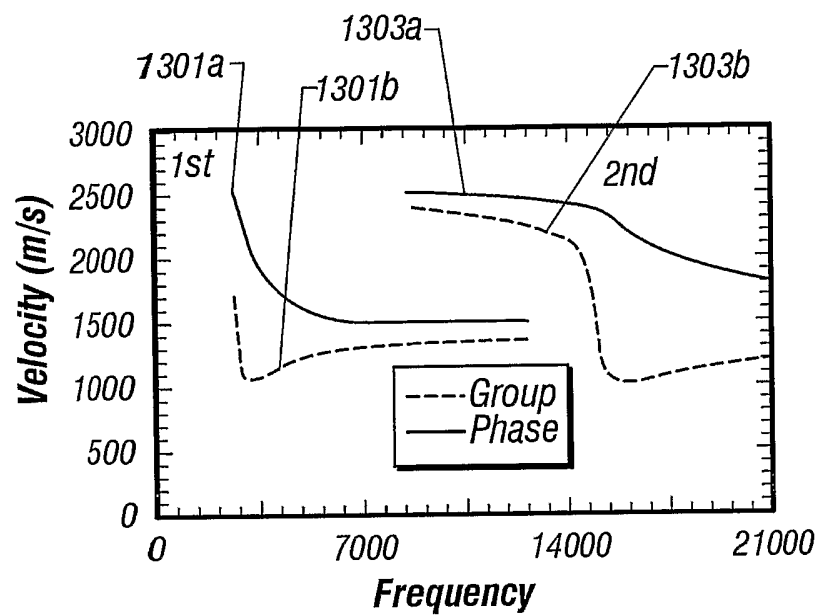


FIG. 15A

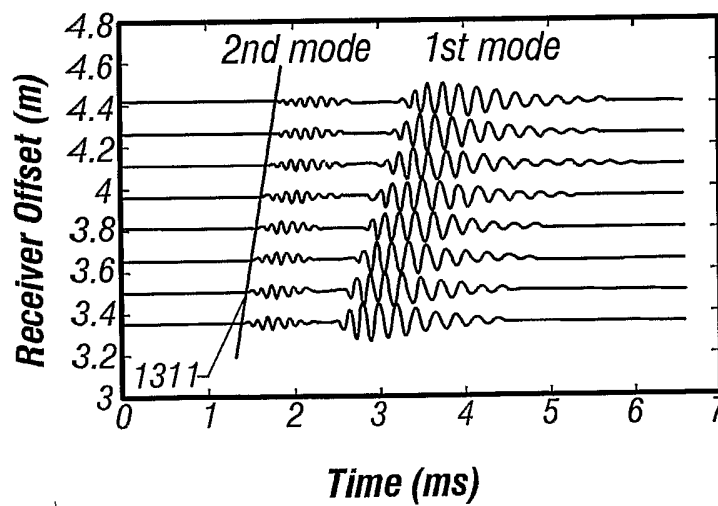
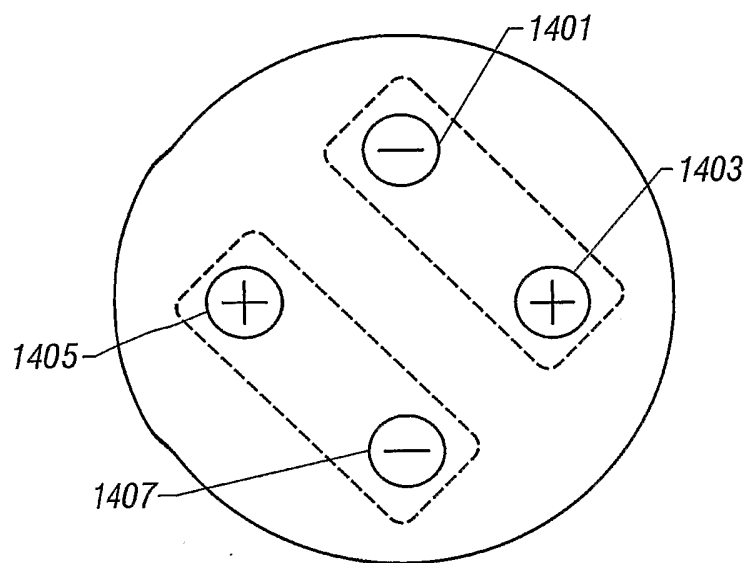


FIG. 15B

**FIG. 16**

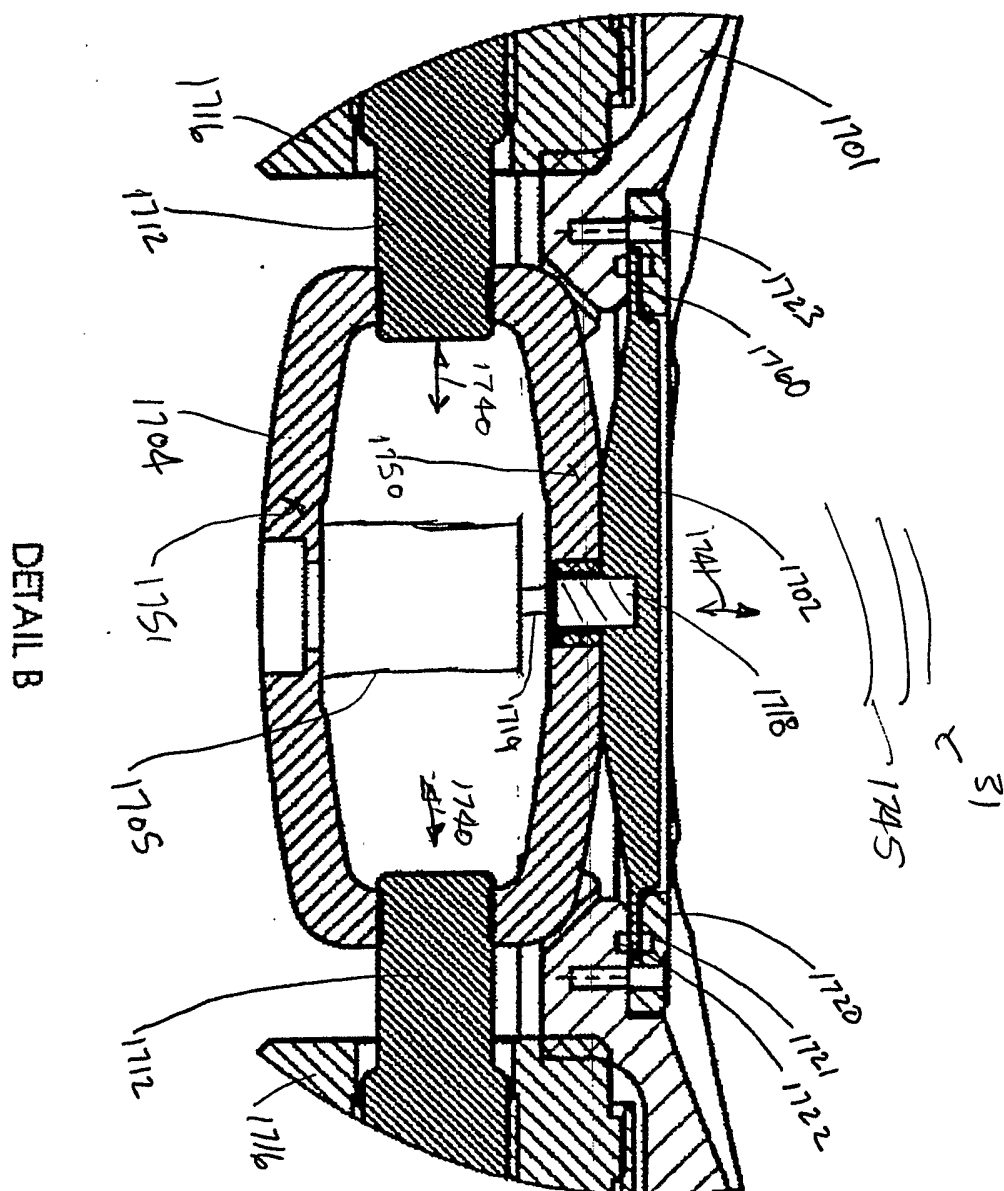


FIG. 17B

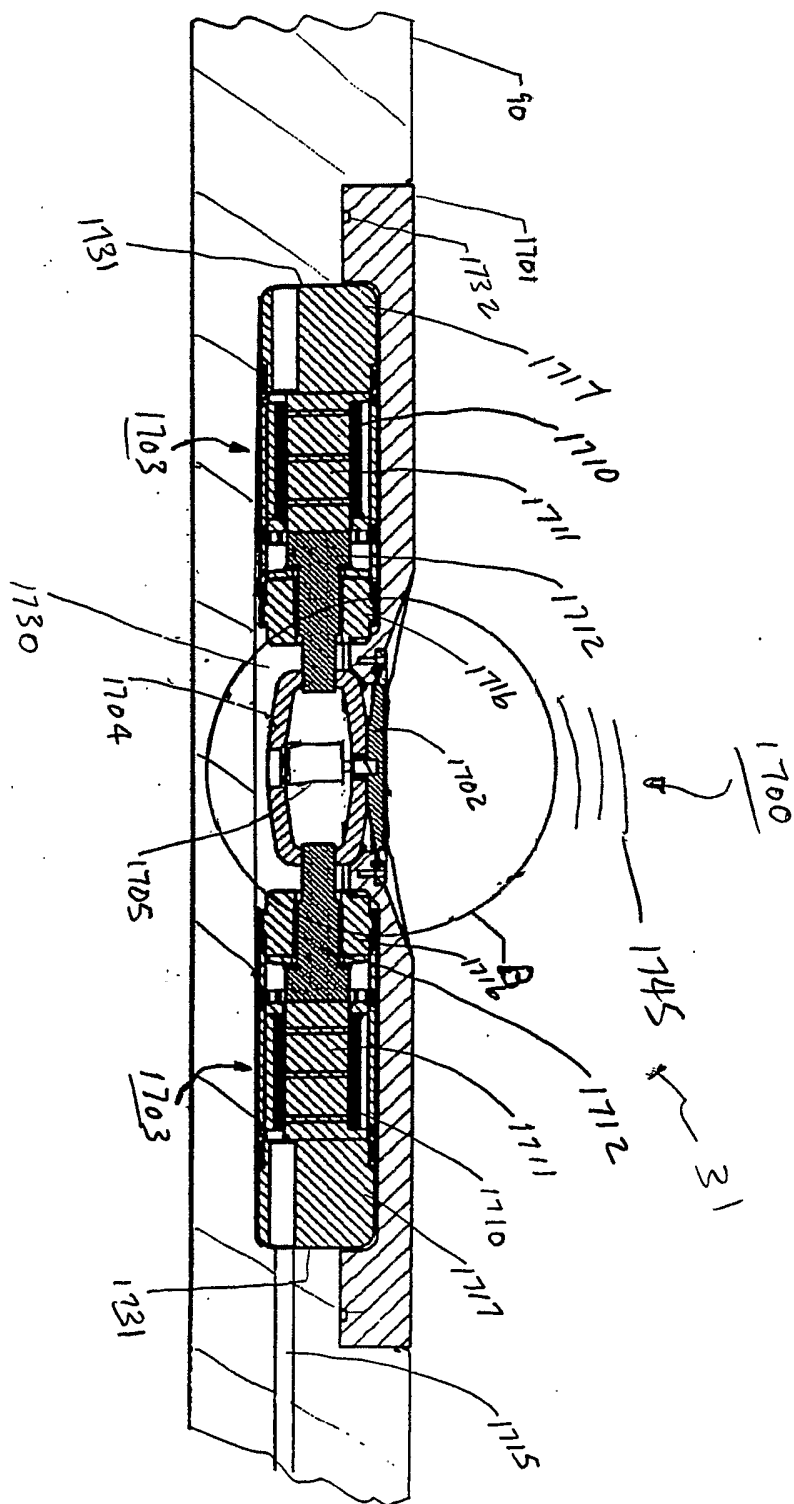


FIG. 17A

INTERNATIONAL SEARCH REPORT

Inter

Application No

PCT/US2005/001383

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 G01V1/52 G10K9/12

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 G10K

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

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

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 6 084 826 A (LEGGETT, III ET AL) 4 July 2000 (2000-07-04) abstract figure 1 figures 4a-5b column 9, line 64 - column 10, line 25	1-16, 18-33, 35-47, 49
A,P	US 6 711 097 B1 (ENGDAHL GOERAN) 23 March 2004 (2004-03-23) abstract figures 1-4 column 1, line 14 - line 33 column 6, line 28 - line 33 column 5, line 17 - line 18 column 2, line 25 - line 26	1-16, 18-33, 35-47, 49

-/--



Further documents are listed in the continuation of box C.



Patent family members are listed in annex.

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Date of the actual completion of the international search

13 July 2005

Date of mailing of the international search report

05/08/2005

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de Heering, Ph.

INTERNATIONAL SEARCH REPORT

Inter: Application No
PCT/US2005/001383

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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Y	"FLEXTENSIONAL TRANSDUCERS FOR UNDERWATER COMMUNICATION" ABB REVIEW, ABB ASEA BROWN BOVERI, ZURICH, CH, no. 8 / 9, January 1990 (1990-01), pages 23-28, XP000172983 ISSN: 1013-3119 abstract Table 1 -----	11-13, 28-30, 41-43
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