

INSPECTION OF STRUCTURES

BACKGROUND INFORMATION

5 1. Field:

The present disclosure relates generally to non-destructive inspection and, in particular, to performing non-destructive inspection on a structure. Still more particularly, the present disclosure relates to a method and
10 apparatus for detecting inconsistencies in a structure using a plurality of types of ultrasonic signals substantially simultaneously.

2. Background:

15 In manufacturing aircraft, vehicles, and other structures, inspection of parts used to form these structures is often performed to determine whether the parts will have desired parameters for a desired performance of the part. Additionally, the structures and parts are
20 inspected as part of normal maintenance when the aircraft, vehicles, and other structures are in use.

Non-destructive testing is commonly performed on these parts. Non-destructive testing is used to evaluate the properties of a part without altering the ability to use the
25 part in service.

Ultrasound testing is a type of non-destructive testing. Ultrasound testing is often used to perform inspections on aircraft parts that include, or are comprised of, composite materials. Ultrasound testing involves
30 transmitting acoustic waves through a test object, such as an aircraft part or structure.

Ultrasound testing is commonly performed using a transducer. The transducer is configured to send acoustic

waves into a test object at a near side and detect a response to the acoustic waves. The response to these acoustic waves is analyzed to determine whether inconsistencies are present in the test object.

5 Different types of inconsistencies may be identified using different types of acoustic waves. For example, inconsistencies on a far side of a structure may be identified using shear waves. A far side of the structure is a side of the structure opposite the near side into which
10 the acoustic waves are transmitted. As another example, inconsistencies on a near side of the structure may be identified using surface waves. In conventional ultrasonic inspection, each type of acoustic wave may be detected on a separate pass of the structure. For example, a first pass
15 of the structure may detect surface waves while a second pass of the structure may detect shear waves. However, performing multiple inspection passes of the structure may use an undesirable amount of time, energy, or resources. Therefore, it would be desirable to have a method and
20 apparatus that take into account at least some of the issues discussed above, as well as other possible issues.

SUMMARY

25 In one illustrative embodiment, a method of detecting inconsistencies in a structure is presented. A pulsed laser beam is directed towards the structure. A plurality of types of ultrasonic signals is formed in the structure when radiation of the pulsed laser beam is absorbed by the
30 structure. The plurality of types of ultrasonic signals is detected using a single detector to form data.

In another illustrative embodiment, a method is presented. A pulsed laser beam is directed towards a

structure. The pulsed laser beam is a line on a surface of the structure. A plurality of types of ultrasonic signals is formed in the structure when radiation of the pulsed laser beam is absorbed by the structure. The plurality of types of ultrasonic signals includes at least one of surface waves, shear waves, or longitudinal waves. The plurality of types of ultrasonic signals is detected by a single point detector to form data. An inconsistency is determined to be present in the structure using the data.

In a further illustrative embodiment, an apparatus is presented. The apparatus comprises a structure, a pulsed laser beam forming a line pump on a first surface of the structure, and a pulsed laser beam forming a point detector on the first surface of the structure.

The features and functions can be achieved independently in various embodiments of the present disclosure or may be combined in yet other embodiments in which further details can be seen with reference to the following description and drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

The novel features believed characteristic of the illustrative embodiments are set forth in the appended claims. The illustrative embodiments, however, as well as a preferred mode of use, further objectives and features thereof, will best be understood by reference to the following detailed description of an illustrative embodiment of the present disclosure when read in conjunction with the accompanying drawings, wherein:

Figure 1 is an illustration of an aircraft in which an illustrative embodiment may be implemented;

Figure 2 is an illustration of a block diagram of an inspection environment in accordance with an illustrative embodiment;

Figure 3 is an illustration of a cross-section of a structure being inspected in accordance with an illustrative embodiment;

Figure 4 is an illustration of an ultrasonic pump and probe in accordance with an illustrative embodiment;

Figure 5 is an illustration of a surface wavefield image in accordance with an illustrative embodiment;

Figure 6 is an illustration of an ultrasonic pump and probe positioned relative to a weld in accordance with an illustrative embodiment;

Figure 7 is an illustration of two shear wavefield images in accordance with an illustrative embodiment;

Figure 8 is an illustration of ultrasonic C-scan images of a far side of a structure in accordance with an illustrative embodiment;

Figure 9 is an illustration of a flowchart of a process for detecting inconsistencies in a structure in accordance with an illustrative embodiment;

Figure 10 is an illustration of a flowchart of a process for determining an inconsistency is present in a structure in accordance with an illustrative embodiment;

Figure 11 is an illustration of a data processing system in the form of a block diagram in accordance with an illustrative embodiment;

Figure 12 is an illustration of an aircraft manufacturing and service method in the form of a block diagram in accordance with an illustrative embodiment; and

Figure 13 is an illustration of an aircraft in the form of a block diagram, in which an illustrative embodiment may be implemented.

DETAILED DESCRIPTION

The different illustrative embodiments recognize and take into account one or more different considerations. For example, the illustrative embodiments recognize and take into account that currently existing inspection techniques may have an undesirable level of precision. For example, existing inspection techniques may include contact or airborne ultrasonic probes or ultrasonic 'needle' probes.

These existing detectors may have an undesirable level of precision for some structures. Further, some conventional single point inspection methods, such as x-ray diffraction, may not be suited to production or in-service inspection.

The illustrative embodiments further recognize and take into account that introduction of multiple types of waves into a structure during testing using traditional ultrasonic transducers would typically require multiple, physical transducers. There may not be enough physical space on an inspection system available for those transducers in the inspection region at one time, so multiple inspection passes would be required. Existing solutions can provide inspection of different types of inconsistencies, but not with a single inspection system or method. For example, far side inconsistencies or roughness or corrosion measurements may be detected using traditional ultrasound. However, each of these inconsistencies may not be detected with a single inspection system or method. A separate method would be needed to measure residual stress. For example, x-ray diffraction or surface wave ultrasound may be used to measure residual stresses.

The illustrative embodiments also recognize and take into account that it may be desirable to reduce cost for inspecting for inconsistencies such as joint

inconsistencies, residual stress, corrosion thinning, manufacturing inconsistencies, or other types of inconsistencies. The illustrative embodiments also recognize and take into account that it may be desirable to ensure or improve safety by inspecting for inconsistencies such as joint inconsistencies, residual stress, corrosion thinning, manufacturing inconsistencies, or other types of inconsistencies.

With reference now to the figures, and in particular, with reference to **Figure 1**, an illustration of an aircraft is depicted in which an illustrative embodiment may be implemented. In this illustrative example, aircraft **100** has wing **102** and wing **104** attached to body **106**. Aircraft **100** includes engine **108** attached to wing **102** and engine **110** attached to wing **104**.

Body **106** has tail section **112**. Horizontal stabilizer **114**, horizontal stabilizer **116**, and vertical stabilizer **118** are attached to tail section **112** of body **106**.

Aircraft **100** is an example of an aircraft having composite structures or structures formed of other materials that may be inspected with a laser ultrasound inspection system in accordance with an illustrative embodiment. For example, at least one of wing **102** or wing **104** may be inspected using a laser ultrasound inspection system.

As used herein, the phrase "at least one of," when used with a list of items, means different combinations of one or more of the listed items may be used, and only one of each item in the list may be needed. In other words, "at least one of" means any combination of items and number of items may be used from the list, but not all of the items in the list are required. The item may be a particular object, thing, or a category.

For example, "at least one of item A, item B, or item C" may include, without limitation, item A, item A and item B, or item B. This example also may include item A, item B, and item C or item B and item C. Of course, any
5 combinations of these items may be present. In other examples, "at least one of" may be, for example, without limitation, two of item A; one of item B; and ten of item C; four of item B and seven of item C; or other suitable combinations.

10 This illustration of aircraft **100** is provided for purposes of illustrating one environment in which the different illustrative embodiments may be implemented. The illustration of aircraft **100** in **Figure 1** is not meant to imply architectural limitations as to the manner in which
15 different illustrative embodiments may be implemented. For example, aircraft **100** is shown as a commercial passenger aircraft. The different illustrative embodiments may be applied to other types of aircraft, such as a private passenger aircraft, a rotorcraft, or other suitable types of
20 aircraft.

Although the illustrative examples for an illustrative embodiment are described with respect to an aircraft, an illustrative embodiment may be applied to other types of platforms. The platform may be, for example, a mobile
25 platform, a stationary platform, a land-based structure, an aquatic-based structure, or a space-based structure. More specifically, the platform may be a surface ship, a tank, a personnel carrier, a train, a spacecraft, a space station, a satellite, a submarine, an automobile, a manufacturing
30 facility, a building, or other suitable platforms.

Further, although the structures may be formed of composite materials, a multi-modal inspection may be performed for any desirable type of material. For example,

a plurality of waves may be used to inspect ceramics or metals.

Yet further, an illustrative embodiment may be applied to other types of structures. For example, structures other than platforms may be inspected for material changes using a laser ultrasound inspection system. Structures other than platforms may include medical devices, prosthetic limbs, or any other desirable products for the screening, diagnosis, treatment, or prevention or any combination or sub-combination thereof of physical or mental health conditions in human beings or animals.

With reference now to **Figure 2**, an illustration of a block diagram of an inspection environment is depicted in accordance with an illustrative embodiment. As depicted, inspection environment **200** includes structure **202**. Structure **202** may take any number of forms. For example, structure **202** may be a part for an aircraft.

Structure **202** may be inspected using laser ultrasound inspection system **204**. As depicted, laser ultrasound inspection system **204** includes movement system **206**, number of detectors **208**, light source **210**, and controller **212**.

In these illustrative examples, controller **212** controls the operation of laser ultrasound inspection system **204**. Controller **212** may be implemented using hardware, software, firmware, or a combination thereof.

In these illustrative examples, controller **212** may be implemented within computer system **214**. Computer system **214** may be one or more computers. When more than one computer is present in computer system **214**, those computers may be in communication with each other through a communications medium such as a network.

When software is used, the operations performed by the controller may be implemented using, for example, without

limitation, program code configured to run on a processor unit, such as processor **215**. When firmware is used, the operations performed by the controller may be implemented using, for example, without limitation, program code and
5 data stored in persistent memory to run on a processor unit.

When hardware is employed, the hardware may include one or more circuits that operate to perform the operations performed by the controller. Depending on the implementation, the hardware may take the form of a circuit
10 system, an integrated circuit, an application specific integrated circuit (ASIC), a programmable logic device, or some other suitable type of hardware device configured to perform any number of operations.

A programmable logic device may be configured to
15 perform certain operations. The device may be permanently configured to perform these operations or may be reconfigurable. A programmable logic device may take the form of, for example, without limitation, a programmable logic array, a programmable array logic, a field
20 programmable logic array, a field programmable gate array, or some other type of programmable hardware device.

In some illustrative examples, the operations and/or processes performed by the controller may be performed using organic components integrated with inorganic components. In
25 some cases, the operations and/or processes may be performed by entirely organic components, excluding a human being. As one illustrative example, circuits in organic semiconductors may be used to perform these operations and/or processes.

Movement system **206** is configured to move light source
30 **210** and number of detectors **208** relative to structure **202**. Movement system **206** may be implemented using a number of different types of systems. For example, movement system **206** may be a robot. The robot may be, for example, a

robotic arm that may move number of detectors **208** about a number of axes. Movement system **206** also may be, for example, without limitation, a gantry robot, a hand-operated scanning head, and other suitable types of movement systems.

5 Light source **210** is configured to transmit first light **216** onto surface **218** of structure **202**. In some illustrative examples, light source **210** may be laser **219**. More specifically, laser **219** may be a diode-pumped nanosecond laser.

10 When light source **210** takes the form of laser **219**, first light **216** may be pulsed laser beam **220**. In this illustrative example, first light **216** is transmitted in a manner that forms first pattern **222** on surface **218** of structure **202**. In these illustrative examples, first
15 pattern **222** of first light **216** is a plurality of areas on which first light **216** illuminates on surface **218**. In some illustrative examples, first pattern **222** may take the form of line **223** on surface **218**. When first pattern **222** takes the form of line **223**, first light **216** has a width larger
20 than its thickness, in order to create a linear impingement on surface **218** of structure **202**.

 When first light **216** takes the form of line **223** on surface **218**, line **223** may be referred to as a line pump. "Pump" may be a term indicating laser-induced generation of
25 a stress wave.

 First light **216** is configured to form acoustic waves **224** within structure **202** when first light **216** encounters structure **202**. Acoustic waves **224** may occur when first light **216** is transmitted onto surface **218** of structure **202**.
30 For example, energy in first light **216** may cause thermoelastic expansion in structure **202**. The thermoelastic expansion may result in acoustic waves **224** in structure **202**.

In these illustrative examples, acoustic waves **224** may be ultrasound sound waves. Thus, acoustic waves **224** may be ultrasonic signals. More specifically, acoustic waves **224** may take the form of wide-band ultrasonic signals. Acoustic waves **224** may have, for example, a frequency from about 20 kilohertz to about 100 megahertz depending on the particular implementation. The frequency for acoustic waves **224** may depend on the material used to form structure **202**, the pulse width of the laser excitation, and other suitable factors.

Acoustic waves **224** may include a plurality of different types of waves. For example, acoustic waves **224** may take the form of plurality of types of ultrasonic signals **225**. Plurality of types of ultrasonic signals **225** include at least one of shear waves **226**, surface waves **227**, or longitudinal waves **228**.

Additionally, number of detectors **208** is configured to detect first response **229** to acoustic waves **224**. First response **229** includes acoustic waves **230** that may occur as a result of scattering, reflection, modulation, and other changes to acoustic waves **224** traveling within structure **202**. First response **229** is comprised of acoustic waves **230** that occur in response to acoustic waves **224**. In this illustrative example, first response **229** is detected by number of detectors **208**.

At least one of number of detectors **208** may take the form of optical detector **231**. In some illustrative examples, at least one of number of detectors **208** may be point detector **232** formed on surface **218** of structure **202**. In one example, number of detectors **208** may comprise any form of interferometer. For example, number of detectors **208** may include a fiber-optic modified Sagnac interferometer for non-contact detection of backscattered ultrasound. Number of detectors **208** may transmit second light **234** onto

surface **218** of structure **202** and detect second response **236** to second light **234**.

In one illustrative example, second light **234** also may be transmitted in the form of second pattern **238** onto
5 surface **218** of structure **202**. In this illustrative example, second pattern **238** may take the form of a point.

Second response **236** is second light **234** that has been deflected by first response **229** in this illustrative example. First response **229**, caused by acoustic waves **224**
10 traveling within structure **202**, may reach surface **218** and may be detected. First response **229** may be detected using an interferometer that sends a reference light, such as second light **234** and detects the mechanical vibrations on surface **218** in second response **236**. Number of detectors **208**
15 may include any desirable form of interferometer.

Point detector **232** may be spaced apart from line **223** on surface **218** such that plurality of types of ultrasonic signals **225** may be detected. For example, point detector **232** may be spaced apart from line **223** on surface **218** such
20 that plurality of types of ultrasonic signals **225** may be detected substantially simultaneously.

Shear waves **226** may move through thickness **239** of structure **202** at a diagonal. For example, shear waves **226** may move from surface **218** towards far side **240** of structure
25 **202** at a diagonal. Shear waves **226** may then reflect from far side **240** of structure **202** towards surface **218**.

Surface waves **227** may travel along surface **218** of structure **202**. Surface waves **227** may not travel through thickness **239** of structure **202**.

30 Longitudinal waves **228** may travel substantially perpendicular to surface **218** through thickness **239**. For example, longitudinal waves **228** may move longitudinally from

surface **218** to far side **240** and be reflected longitudinally back towards surface **218**.

Number of detectors **208** sends data **241** to controller **212** when second response **236** is detected. Data **241** is used
5 by controller **212** to generate output **242**. Data **241** may include a full-bandwidth signal for a location of structure **202** being inspected. As laser ultrasound inspection system **204** is scanned across structure **202**, data **241** for a plurality of locations on structure **202** is collected.

10 As depicted, output **242** may indicate whether inconsistency **244** is present in structure **202**. Inconsistency **244** may be, for example, without limitation, crack **245**, joint inconsistency **246**, corrosion **247**, or far side inconsistency **248**. Far side inconsistency **248** may be
15 on far side **240** of structure **202**.

Data **241** representative of shear waves **226** may be used to identify far side inconsistency **248** or corrosion **247** on far side **240** of structure **202**. Data **241** representative of surface waves **227** may be used to identify crack **245** or joint
20 inconsistency **246**. Joint inconsistency **246** may be present in joint **249**. Joint **249** may join two components of structure **202**. In some illustrative examples, joint **249** may take the form of weld **250**. In these illustrative examples, joint inconsistency **246** may be an inconsistency in weld **250**.
25 In these illustrative examples, joint inconsistency **246** may result from the welding process.

Output **242** may take a number of different forms. For example, output **242** may take the form of alert **251**. Alert **251** may indicate whether inconsistency **244** is present.
30 Alert **251** may be displayed on display device **252** within computer system **214**.

In another illustrative example, output **242** may be image **253**. Image **253** also may be displayed on display

device **252**. Image **253** may be an image of a portion or all of structure **202** with graphical indicator **254** when inconsistency **244** is present in structure **202**. Graphical indicator **254** may be displayed in a location in image **253** corresponding to a location in structure **202** where inconsistency **244** is detected. In other illustrative examples, if inconsistency **244** is absent, graphical indicator **254** may be displayed to indicate an absence of inconsistency **244**.

In some illustrative examples, image **253** may be optical image **256**. Optical image **256** may be an image of surface **218** of structure **202**. In other illustrative examples, image **253** may be a representation of a portion of structure **202**.

As still another illustrative example, output **242** may take the form of report **270**. Report **270** may identify any inconsistencies in structure **202**. Report **270** also may include other information, such as locations of inconsistencies, types of inconsistencies, sizes of inconsistencies, and other suitable types of information.

Structure **202** may be formed of any desirable material. Structure **202** may be formed of at least one of a composite, a metal, a ceramic, a polymeric material, a semi-conductor material, or a glass material.

In some illustrative examples, structure **202** is homogenous material **272**. Homogeneous material **272** may be a uniform material with the same properties at each location of the material. However, structure **202** need not be formed of homogeneous material **272**.

In some illustrative examples, structure **202** is single layer **274**. By structure **202** being single layer **274**, boundaries between multiple layers may not reflect or refract plurality of types of ultrasonic signals **225**. For example, structure **202** may be a composite laminate formed of

one type of composite material and forming single layer **274**. When structure **202** is single layer **274**, there are not any bonds or joints between surface **218** and far side **240**.

The illustration of inspection environment **200** in **Figure 2** is not meant to imply physical or architectural limitations to the manner in which an illustrative embodiment may be implemented. Other components in addition to or in place of the ones illustrated may be used. Some components may be unnecessary. Also, the blocks are presented to illustrate some functional components. One or more of these blocks may be combined, divided, or combined and divided into different blocks when implemented in an illustrative embodiment.

For example, although individual detectors are not depicted in laser ultrasound inspection system **204**, laser ultrasound inspection system **204** may include any desirable quantity of detectors. For example, number of detectors **208** may include a first detector that detects second response **236** generated by shear waves **226** and surface waves **227**, while a second detector detects second response **236** generated by longitudinal waves **228**.

As another example, number of detectors **208** may comprise a plurality of receivers. In this example, number of detectors **208** may detect second response **236** generated by shear waves **226**, surface waves **227**, and longitudinal waves **228**. In this example, second response **236** generated by shear waves **226** and surface waves **227** may be detected by a first receiver of number of detectors **208** while second response **236** generated by longitudinal waves **228** may be detected by a different receiver of number of detectors **208**.

Further, inconsistency **244** may include any other type of inconsistencies. For example, although crack **245** is depicted as a possibility for inconsistency **244**,

inconsistency **244** may instead be any type of detectable near-surface inconsistency.

Turning now to **Figure 3**, an illustration of a cross-section of a structure being inspected is depicted in accordance with an illustrative embodiment. Structure **300** may be a physical implementation of structure **202** of Figure 2.

Structure **300** has surface **302**, far side **304**, and thickness **306**. Line pump **308** may induce plurality of types of ultrasonic signals **310** in structure **300**. Line pump **308** may be generated on surface **302** of structure **300** using a pulsed laser beam, such as pulsed laser beam **220** of **Figure 2**. Plurality of types of ultrasonic signals **310** may include at least one of longitudinal waves **312**, shear waves **314**, and surface waves **316**. In this illustrative example, shear waves **314** and surface waves **316** are detected by point detector **317** on surface **302**. Line pump **308** and point detector **317** may be spaced distance **318** apart such that shear waves **314** and surface waves **316** may both be detected by point detector **317**. Distance **318** may be changed for different structures. For example, distance **318** may be selected based on thickness **306**.

As can be seen in **Figure 3**, the size of point detector **317** is significantly smaller than distance **318**. Due to at least one of the size or the location of point detector **317**, multiple types of ultrasonic signals may be detected in a single pass of structure **300**. For example, due to size of point detector **317**, multiple receivers may be present.

Longitudinal waves **312** may be detected by a receiver positioned at substantially the same location as line pump **308**. In some illustrative examples, point detector **317** and the receiver for longitudinal waves **312** may be different receivers of the same detector. In some illustrative

examples, point detector **317** and the receiver for longitudinal waves **312** may be two different detectors. In each of the examples regardless of the quantity of detectors, longitudinal waves **312**, shear waves **314**, and
5 surface waves **316** may be detected at substantially the same time.

In some illustrative examples, longitudinal waves **312**, shear waves **314**, and surface waves **316** may all be detected in the same "pass" of structure **300**. However, due to the
10 distances traveled by each of longitudinal waves **312**, shear waves **314**, and surface waves **316**, at least one of longitudinal waves **312**, shear waves **314**, or surface waves **316** may be detected at a different time than another of longitudinal waves **312**, shear waves **314**, or surface waves
15 **316**.

Shear waves **314** may be used to detect inconsistencies **320** on far side **304** of structure **300**. In this illustrative example, inconsistencies **320** take the form of pores on far side **304** of structure **300**. More specifically, data
20 representative of shear waves **314** sent from point detector **317** may be used to detect inconsistencies.

Surface waves **316** may be used to detect inconsistencies between line pump **308** and point detector **317**. More specifically, data representative of surface waves **316** sent
25 from point detector **317** may be used to detect inconsistencies. In this illustrative example, no inconsistencies are depicted between line pump **308** and point detector **317**. Inconsistencies detected using surface waves **316** may be referred to as near surface inconsistencies.

30 Longitudinal waves **312** may be used to detect inconsistencies through thickness **306** of structure **300**. More specifically, data representative of longitudinal waves **312** sent from a receiver positioned near line pump **308** may

be used to detect inconsistencies. In this illustrative example, no inconsistencies are depicted through thickness **306** of structure **300** beneath line pump **308**.

Turning now to **Figure 4**, an illustration of an ultrasonic pump and probe is depicted in accordance with an illustrative embodiment. View **400** may be a top view of surface **302** of structure **300** of Figure 3.

In view **400**, line pump **308** is visible on surface **302** of structure **300**. In view **400**, line pump **308** has a width larger than its thickness, in order to create a linear impingement on surface **302** of structure **300**. Line pump **308** may be formed by directing a pulsed laser beam towards structure **300**. As depicted, the pulsed laser beam is a line on surface **302** of structure **300**.

In view **400**, point detector **317** is visible on surface **302** of structure **300**. As can be seen in view **400**, point detector **317** is significantly smaller than distance **318** between line pump **308** and point detector **317**.

In this illustrative example, structure **300** does not include a visible joint. However, as depicted, inconsistency **402** is present on surface **302** of structure **300**. As depicted, inconsistency **402** may take the form of a crack. In other illustrative examples, inconsistency **402** may take the form of any surface or near surface inconsistency. In some illustrative examples, inconsistency **402** may not be visible to the eye.

During inspection of structure **300**, shear waves **314** and surface waves **316** of **Figure 3** may travel in direction **404** from line pump **308** to point detector **317**. To inspect multiple locations of structure **300**, line pump **308** and point detector **317** may move in direction **404** along surface **302**. Movement of line pump **308** and point detector **317** during

inspection of structure **300** may be referred to as "scanning."

Turning now to **Figure 5**, an illustration of a surface wavefield image is depicted in accordance with an illustrative embodiment. Image **500** may be an example of image **253** of Figure 2. Image **500** may be formed from data **241** of Figure 2. Image **500** may be formed from data detected by point detector **317** of Figures 3 and 4. Image **500** may be formed from data representative of surface waves **316**.

Image **500** has x-axis **502** of distance in millimeters and y-axis **504** of time in microseconds. In image **500**, line **506** is visible. Break **508** in line **506** may be indicative of an inconsistency. In this illustrative example, break **508** may be indicative of inconsistency **402** of Figure 4.

Turning now to **Figure 6**, an illustration of an ultrasonic pump and probe positioned relative to a weld is depicted in accordance with an illustrative embodiment. View **600** may be a top view of surface **218** of structure **202** of Figure 2.

View **600** depicts structure **602** having joint **604**. In some illustrative examples, joint **604** may be a weld.

Line pump **606** may be a physical implementation of line **223** of **Figure 2**. Point detector **608** may be a physical implementation of point detector **232**. In some illustrative examples, line pump **606** may be the same as line pump **308** in **Figure 3**. In some illustrative examples, point detector **608** may be the same as point detector **317** of **Figure 3**.

To inspect joint **604**, line pump **606** is set-up such that line pump **606** is perpendicular to direction **610** of joint **604**. By positioning line pump **606** perpendicular to direction **610**, ultrasonic signals may travel entirely through joint **604**, when point detector **317** is positioned over joint **604**.

In other illustrative examples, line pump **606** may be positioned parallel to direction **610**. When line pump **606** is positioned parallel to direction **610**, some inconsistencies may be more difficult to detect.

5 In some illustrative examples, the position of line pump **606** may be positioned based on the type of material of structure **602**. For example, some materials for structure **602** may be anisotropic. An anisotropic material is direction dependent. As a result, changing the position of
10 line pump **606** relative to structure **602** may also change the wave measurements from line pump **606**.

 In some illustrative examples, a material for structure **602** may be isotropic. Accordingly, wave measurements in structure **602** without inconsistencies may be isotropic.
15 However, results for inconsistencies in structure **602** may be anisotropic. For example, wave measurements for an inconsistency in structure **602** may be anisotropic. For example, a wave speed may be dependent on the direction of line pump **606** when an inconsistency is present.

20 Accordingly, a first inspection may be performed with a plurality of types of ultrasonic signals in a first direction. Afterwards, a second inspection may be performed with a plurality of types of ultrasonic signals in a second direction. In some illustrative examples, the first
25 direction and the second direction may have a ninety degrees difference.

 During operation, surface waves propagate from line pump **606** to point detector **608**. Surface waves may be detected by point detector **608** and recorded. Shear wave
30 measurements may be displayed in any desirable format. For example, surface wave measurements through joint **604** may be displayed in an amplitude versus arrival time graph.

The waveform recorded for propagation of the surface waves through a region of structure **602** outside of joint **604** may be compared to the waveform recorded for propagation of the surface waves through a region within joint **604**. At least one of the amplitude or arrival time of the surface wave waveforms may be different for propagation through joint **604** compared to propagation outside joint **604**. For example, surface wave waveforms within joint **604** may have a smaller amplitude than surface wave waveforms outside of joint **604**. As another example, arrival time of the surface wave waveforms for propagation through joint **604** may be greater than the arrival time of surface wave waveforms for propagation outside of joint **604**.

In another example, the surface wave measurements may be displayed in a graph for wave speed as a function of position. The wave speed may have any desirable measurements, including in m/sec. In some illustrative examples, the surface wave measurements may be for a one-dimensional (line) scan across joint **604**. Joint **604** may be identified as a region with reduced surface wave wave speed. This graph may be an example of one line within image **253** of **Figure 2**.

A quality of joint **604** may be estimated based on changes in the surface wave speed between the material outside joint **604** and that within joint **604**. For example, the magnitude of surface wave speed differences through joint **604** may be compared to guidelines for joints of acceptable quality. If the magnitude of surface wave speed differences are outside the guidelines, the joint **604** may be identified as having undesirable quality.

Turning now to **Figure 7**, an illustration of two shear wave wavefield images is depicted in accordance with an illustrative embodiment. View **700** depicts image **702** and

image **704**. Image **702** and image **704** may each be an example of image **253** of **Figure 2**. Image **702** and image **704** may be formed from data **241** of **Figure 2**. Image **702** and image **704** may be formed from data detected by point detector **317** of
5 **Figures 3** and **4**. Image **702** and image **704** may be formed from data representative of shear waves **314**.

Image **702** has x-axis **706** of scanning distance in millimeters. Image **702** has y-axis **708** of time index in points. Image **702** depicts data for a portion of a
10 structure, such as structure **202** or structure **300** having a far side without any detected inconsistencies.

Image **704** has x-axis **710** of scanning distance in millimeters. Image **704** has y-axis **712** of time index in points. Image **704** depicts data for a portion of a
15 structure, such as structure **202** or structure **300** having a far side with detected inconsistencies **714**. Inconsistencies **714** may include inconsistency **716**, inconsistency **718**, and inconsistency **720**. Inconsistencies **714** may include any type of detectable far side inconsistencies. For example,
20 inconsistencies **714** may be at least one of corrosion, pores, or other types of inconsistencies. As depicted, the surface of the structure may not have any inconsistencies.

Turning now to **Figure 8**, an illustration of ultrasonic C-scan images of a far side of a structure is depicted in
25 accordance with an illustrative embodiment. View **800** depicts image **802** and image **804**. Image **802** and image **804** may each be an example of image **253** of **Figure 2**. Image **802** and image **804** may be formed from data **241** of **Figure 2**. Image **802** and image **804** may be formed from data detected by
30 point detector **317** and a point detector at line pump **308** of **Figures 3** and **4**. Image **802** and image **804** may be formed from data representative of shear waves **314**.

Image **702** and image **704** of **Figure 7** may be further processed to produce clear images of inconsistencies within a structure. Both the arrival time and amplitude of the shear wave signal associated with reflections from a far side of the structure can be used to image the far side of the structure.

View **800** includes image **802** and image **804**. Image **802** and image **804** depict a region of a structure having three inconsistencies on a far side of the structure. Image **802** and image **804** may be images of far side **304** of structure **300** of **Figure 3**. Image **802** may be an arrival time image. Image **804** may be an amplitude image. Inconsistency **806**, inconsistency **808**, and inconsistency **810** may be observable in both image **802** and image **804**. In some illustrative examples, inconsistency **806**, inconsistency **808**, and inconsistency **810** may be images of inconsistency **716**, inconsistency **718**, and inconsistency **720**. Image **802** and image **804** demonstrate that inconsistencies on a far side of the structure may be visible in at least one of an arrival time image or an amplitude image.

The different components shown in **Figure 1** and **Figures 3-8** may be combined with components in **Figure 2**, used with components in **Figure 2**, or a combination of the two. Additionally, some of the components in **Figure 1** and **Figures 3-8** may be illustrative examples of how components shown in block form in **Figure 2** may be implemented as physical structures.

Turning now to **Figure 9**, an illustration of a flowchart of a process for detecting inconsistencies in a structure in accordance with an illustrative embodiment. The process illustrated in **Figure 9** may be implemented in an ultrasound inspection system such as laser ultrasound inspection system **204** in **Figure 2**. The process illustrated in **Figure 9** may

detect inconsistency **244** in structure **202** using data **241** formed by detecting plurality of types of ultrasonic signals **225**.

Process **900** begins by directing a pulsed laser beam
5 towards the structure, wherein a plurality of types of ultrasonic signals is formed in the structure when radiation of the pulsed laser beam is absorbed by the structure (operation **902**). The plurality of types of ultrasonic signals may include at least one of shear waves, surface
10 waves, or longitudinal waves. In some illustrative examples, the structure may include a joint. In these illustrative examples, the surface waves are transmitted through the joint in the structure. In some illustrative examples, the pulsed laser beam is a line on a surface of
15 the structure.

Process **900** then detects the plurality of types of ultrasonic signals to form data (operation **904**). Afterwards the process terminates. The plurality of types of ultrasonic signals may be detected by a number of detectors.
20 In some illustrative examples, the plurality of types of ultrasonic signals may be detected by a single detector. In some illustrative examples, the plurality of types of ultrasonic signals is detected by a single point detector. In some illustrative examples, the pulsed laser beam and the
25 single point detector are spaced apart such that the plurality of types of ultrasonic signals is detected.

In other illustrative examples, the number of detectors may include two detectors. The first detector may detect surface and shear waves while the second detector detects
30 longitudinal waves.

In some illustrative examples, the structure is a homogenous material. In some illustrative examples, the structure may be formed of at least one of a composite, a

metal, a ceramic, a polymeric material, or a glass material. In some illustrative examples, the structure is a single layer.

Turning now to **Figure 10**, an illustration of a
5 flowchart of a process for determining an inconsistency is present in a structure is depicted in accordance with an illustrative embodiment. The process illustrated in **Figure 10** may be implemented in an ultrasound inspection system such as laser ultrasound inspection system **204** in **Figure 2**.
10 The process illustrated in **Figure 10** may detect inconsistency **244** in structure **202** using data **241** formed by detecting plurality of types of ultrasonic signals **225**.

Process **1000** may begin by directing a pulsed laser beam towards the structure, wherein the pulsed laser beam is a
15 line on a surface of the structure, wherein a plurality of types of ultrasonic signals is formed in the structure when radiation of the pulsed laser beam is absorbed by the structure, and wherein the plurality of types of ultrasonic signals includes at least one of surface waves, shear waves,
20 or longitudinal waves (operation **1002**). In some examples, the structure is formed of a single layer.

Process **1000** may then detect the plurality of types of ultrasonic signals to form data (operation **1004**). The plurality of types of ultrasonic signals may be detected by
25 a number of detectors. In some illustrative examples, the plurality of types of ultrasonic signals may be detected by a single detector. In some illustrative examples, the plurality of types of ultrasonic signals is detected by a single point detector. In some illustrative examples, the
30 pulsed laser beam and the single point detector are spaced apart such that the plurality of types of ultrasonic signals is detected.

In other illustrative examples, the number of detectors may include two detectors. The first detector may detect surface and shear waves while the second detector detects longitudinal waves.

5 Process **1000** then determines an inconsistency is present in the structure using the data (operation **1006**). Afterwards the process terminates. In some illustrative examples, the inconsistency includes at least one of a joint inconsistency, corrosion, an inconsistency on a far side of
10 the structure, or a crack.

 In some illustrative examples, an inconsistency may be detected in the structure by comparing the data to reference data from a reference standard. The reference standard does not contain any inconsistencies. Differences between data
15 and reference data may indicate the presence of an inconsistency in the structure.

 The flowcharts and block diagrams in the different depicted embodiments illustrate the architecture, functionality, and operation of some possible
20 implementations of apparatus and methods in an illustrative embodiment. In this regard, each block in the flowcharts or block diagrams may represent a module, a segment, a function, and/or a portion of an operation or step.

 In some alternative implementations of an illustrative
25 embodiment, the function or functions noted in the blocks may occur out of the order noted in the figures. For example, in some cases, two blocks shown in succession may be executed substantially concurrently, or the blocks may sometimes be performed in the reverse order, depending upon
30 the functionality involved. Also, other blocks may be added in addition to the illustrated blocks in a flowchart or block diagram.

For example, process **900** may further include identifying a crack in the structure using the data representing the surface waves. As another example, process **900** may include identifying corrosion in the structure using
5 data representing the shear waves. As yet a further example, process **900** may also include identifying inconsistencies on a far side of the structure using the data representing the shear waves.

Turning now to **Figure 11**, an illustration of a data
10 processing system in the form of a block diagram is depicted in accordance with an illustrative embodiment. Data processing system **1100** may be used to implement computer system **214** of **Figure 2**. Data processing system **1100** may be used to process data as described in **Figure 3** and display
15 output as depicted in **Figures 4-8**. As depicted, data processing system **1100** includes communications framework **1102**, which provides communications between processor unit **1104**, storage devices **1106**, communications unit **1108**, input/output unit **1110**, and display **1112**. In some cases,
20 communications framework **1102** may be implemented as a bus system.

Processor unit **1104** is configured to execute instructions for software to perform a number of operations. Processor unit **1104** may comprise a number of processors, a
25 multi-processor core, and/or some other type of processor, depending on the implementation. In some cases, processor unit **1104** may take the form of a hardware unit, such as a circuit system, an application specific integrated circuit (ASIC), a programmable logic device, or some other suitable
30 type of hardware unit.

Instructions for the operating system, applications, and/or programs run by processor unit **1104** may be located in storage devices **1106**. Storage devices **1106** may be in

communication with processor unit **1104** through communications framework **1102**. As used herein, a storage device, also referred to as a computer readable storage device, is any piece of hardware capable of storing
5 information on a temporary and/or permanent basis. This information may include, but is not limited to, data, program code, and/or other information.

Memory **1114** and persistent storage **1116** are examples of storage devices **1106**. Memory **1114** may take the form of, for
10 example, a random access memory or some type of volatile or non-volatile storage device. Persistent storage **1116** may comprise any number of components or devices. For example, persistent storage **1116** may comprise a hard drive, a flash memory, a rewritable optical disk, a rewritable magnetic
15 tape, or some combination of the above. The media used by persistent storage **1116** may or may not be removable.

Communications unit **1108** allows data processing system **1100** to communicate with other data processing systems and/or devices. Communications unit **1108** may provide
20 communications using physical and/or wireless communications links.

Input/output unit **1110** allows input to be received from and output to be sent to other devices connected to data processing system **1100**. For example, input/output unit **1110**
25 may allow user input to be received through a keyboard, a mouse, and/or some other type of input device. As another example, input/output unit **1110** may allow output to be sent to a printer connected to data processing system **1100**.

Display **1112** is configured to display information to a
30 user. Display **1112** may comprise, for example, without limitation, a monitor, a touch screen, a laser display, a holographic display, a virtual display device, and/or some other type of display device.

In this illustrative example, the processes of the different illustrative embodiments may be performed by processor unit **1104** using computer-implemented instructions. These instructions may be referred to as program code, computer usable program code, or computer readable program code, and may be read and executed by one or more processors in processor unit **1104**.

In these examples, program code **1118** is located in a functional form on computer readable media **1120**, which is selectively removable, and may be loaded onto or transferred to data processing system **1100** for execution by processor unit **1104**. Program code **1118** and computer readable media **1120** together form computer program product **1122**. In this illustrative example, computer readable media **1120** may be computer readable storage media **1124** or computer readable signal media **1126**.

Computer readable storage media **1124** is a physical or tangible storage device used to store program code **1118** rather than a medium that propagates or transmits program code **1118**. Computer readable storage media **1124** may be, for example, without limitation, an optical or magnetic disk or a persistent storage device that is connected to data processing system **1100**.

Alternatively, program code **1118** may be transferred to data processing system **1100** using computer readable signal media **1126**. Computer readable signal media **1126** may be, for example, a propagated data signal containing program code **1118**. This data signal may be an electromagnetic signal, an optical signal, and/or some other type of signal that can be transmitted over physical and/or wireless communications links.

The illustration of data processing system **1100** in **Figure 11** is not meant to provide architectural limitations

to the manner in which the illustrative embodiments may be implemented. The different illustrative embodiments may be implemented in a data processing system that includes components in addition to or in place of those illustrated
5 for data processing system **1100**. Further, components shown in **Figure 11** may be varied from the illustrative examples shown.

Illustrative embodiments of the disclosure may be described in the context of aircraft manufacturing and
10 service method **1200**, as shown in **Figure 12**, and aircraft **1300**, as shown in **Figure 13**. Turning first to **Figure 12**, an illustration of an aircraft manufacturing and service method is depicted in accordance with an illustrative embodiment. During pre-production, aircraft manufacturing and service
15 method **1200** may include specification and design **1202** of aircraft **1300** and material procurement **1204**.

During production, component and subassembly manufacturing **1206** and system integration **1208** of aircraft **1300** take place. Thereafter, aircraft **1300** may go through
20 certification and delivery **1210** in order to be placed in service **1212**. While in service **1212** by a customer, aircraft **1300** is scheduled for routine maintenance and service **1214**, which may include modification, reconfiguration, refurbishment, and other maintenance or service.

Each of the processes of aircraft manufacturing and service method **1200** may be performed or carried out by a system integrator, a third party, and/or an operator. In these examples, the operator may be a customer. For the
25 purposes of this description, a system integrator may include, without limitation, any number of aircraft
30 manufacturers and major-system subcontractors; a third party may include, without limitation, any number of vendors, subcontractors, and suppliers; and an operator may be an

airline, a leasing company, a military entity, a service organization, and so on.

With reference now to **Figure 13**, an illustration of an aircraft is depicted in which an illustrative embodiment may be implemented. In this example, aircraft **1300** is produced by aircraft manufacturing and service method **1200** in **Figure 12**, and may include airframe **1302** with plurality of systems **1304** and interior **1306**. Examples of plurality of systems **1304** include one or more of propulsion system **1308**, electrical system **1310**, hydraulic system **1312**, and environmental system **1314**. Any number of other systems may be included. Although an aerospace example is shown, different illustrative embodiments may be applied to other industries, such as the automotive industry.

Apparatuses and methods embodied herein may be employed during at least one of the stages of aircraft manufacturing and service method **1200** in **Figure 12**. One or more illustrative embodiments may be used during component and subassembly manufacturing **1206** in **Figure 12**. For example, laser ultrasound inspection system **204** in **Figure 2** may be used to inspect structures during component and subassembly manufacturing **1206**. Further, laser ultrasound inspection system **204** in **Figure 2** may be used to inspect an assembly during maintenance and service **1214** in **Figure 12**. For example, structures of aircraft **1300** may be inspected during scheduled maintenance for aircraft **1300** using laser ultrasound inspection system **204**.

Further, the disclosure comprises embodiments according to the following clauses:

Clause 1. A method of detecting inconsistencies in a structure, the method comprising: directing a pulsed laser beam towards the structure, wherein a plurality of types of ultrasonic signals is formed in the structure when radiation

of the pulsed laser beam is absorbed by the structure; and detecting the plurality of types of ultrasonic signals to form data.

Clause 2. The method of Clause 1, wherein the plurality
5 of types of ultrasonic signals includes at least one of surface waves, shear waves, or longitudinal waves.

Clause 3. The method of Clause 2 further comprising:
identifying a crack in the structure using the data
representing the surface waves.

10 Clause 4. The method of Clause 2, wherein the surface waves are transmitted through a joint in the structure.

Clause 5. The method of Clause 2 further comprising:
identifying corrosion in the structure using data
representing the shear waves.

15 Clause 6. The method of Clause 2 further comprising:
identifying inconsistencies on a far side of the structure using the data representing the shear waves.

Clause 7. The method of Clause 1, wherein the pulsed laser beam is a line on a surface of the structure.

20 Clause 8. The method of Clause 1, wherein the plurality of types of ultrasonic signals is detected by a point detector.

Clause 9. The method of Clause 8, wherein the pulsed laser beam and the point detector are spaced apart such that
25 the plurality of types of ultrasonic signals is detected.

Clause 10. The method of Clause 1, wherein the structure is a homogenous material.

Clause 11. The method of Clause 1, wherein the structure is formed of at least one of a composite, a metal,
30 a ceramic, a polymeric material, a semi-conductor material, or a glass material.

Clause 12. The method of Clause 1, wherein the structure is a single layer.

Clause 13. A method comprising: directing a pulsed laser beam towards a structure, wherein the pulsed laser beam is a line on a surface of the structure, wherein a plurality of types of ultrasonic signals is formed in the structure when radiation of the pulsed laser beam is absorbed by the structure, and wherein the plurality of types of ultrasonic signals includes at least one of surface waves, shear waves, or longitudinal waves; detecting the plurality of types of ultrasonic signals to form data; and determining an inconsistency is present in the structure using the data.

Clause 14. The method of Clause 13, wherein the pulsed laser beam and a single point detector are spaced apart such that the plurality of types of ultrasonic signals is detected by the single point detector.

Clause 15. The method of Clause 13, wherein the structure is formed of a single layer.

Clause 16. The method of Clause 13, wherein the inconsistency includes at least one of a joint inconsistency, corrosion, an inconsistency on a far side of the structure, or a crack.

Clause 17. An apparatus comprising: a pulsed laser beam forming a line pump on a first surface of a structure; and a pulsed laser beam forming a point detector on the first surface of the structure.

Clause 18. The apparatus of Clause 17, wherein the line pump and the point detector are spaced a distance apart, wherein the distance is selected such that the point detector detects a plurality of types of ultrasonic signals from the structure.

Clause 19. The apparatus of Clause 18, wherein the plurality of types of ultrasonic signals includes at least one of surface waves, shear waves, or longitudinal waves.

Clause 20. The apparatus of Clause 17, wherein the pulsed laser beam forming the line pump is provided by laser ultrasonic equipment.

5 Thus, one or more illustrative embodiments may provide a method and apparatus for determining if inconsistencies are present in a structure. Inconsistencies may be observable using conventional ultrasound techniques. However, inconsistencies through the thickness, near the
10 surface, and on the far side of a structure may each require a separate inspection pass of the structure.

The illustrative embodiments may provide a method and apparatus for detecting inconsistencies using a plurality of types of ultrasonic signals substantially simultaneously.

15 The illustrative embodiments may detect a plurality of types of ultrasonic signals substantially simultaneously. As a result, using the illustrative examples, the inspection time for the structure may be reduced.

The illustrative embodiments may reduce cost for
20 inspecting for inconsistencies such as joint inconsistencies, residual stress, corrosion thinning, manufacturing inconsistencies, or other types of inconsistencies. The illustrative embodiments may ensure or improve safety by increasing ability to detect
25 inconsistencies such as joint inconsistencies, residual stress, corrosion thinning, manufacturing inconsistencies, or other types of inconsistencies.

The description of the different illustrative
embodiments has been presented for purposes of illustration
30 and description, and is not intended to be exhaustive or limited to the embodiments in the form disclosed. Many modifications and variations will be apparent to those of ordinary skill in the art. Further, different illustrative

embodiments may provide different features as compared to other desirable embodiments. The embodiment or embodiments selected are chosen and described in order to best explain the principles of the embodiments, the practical
5 application, and to enable others of ordinary skill in the art to understand the disclosure for various embodiments with various modifications as are suited to the particular use contemplated.

CLAIMS:

What is claimed is:

1. A method of detecting inconsistencies in a structure,
5 the method comprising:
 directing a pulsed laser beam towards the structure,
 wherein a plurality of types of ultrasonic signals is formed
 in the structure when radiation of the pulsed laser beam is
 absorbed by the structure; and
10 detecting the plurality of types of ultrasonic signals
 to form data, wherein the plurality of types of ultrasonic
 signals includes at least one of surface waves, shear waves,
 or longitudinal waves.
- 15 2. The method of claim 1 further comprising:
 identifying a crack in the structure using the data
 representing the surface waves.
3. The method of claim 1 or 2, wherein the surface waves
20 are transmitted through a joint in the structure.
4. The method of any one of claims 1, 2 or 3, further
comprising:
 identifying corrosion in the structure using data
25 representing the shear waves.
5. The method of any one of claims 1 to 4 further
comprising:
 identifying inconsistencies on a far side of the
30 structure using the data representing the shear waves.
6. The method of any one of claims 1 to 5, wherein the
pulsed laser beam is a line on a surface of the structure.

7. The method of any one of claims 1 to 6, wherein the plurality of types of ultrasonic signals is detected by a point detector.

5 8. The method of claim 7, wherein the pulsed laser beam and the point detector are spaced apart such that the plurality of types of ultrasonic signals is detected.

9. The method of any one of claims 1 to 8, wherein the
10 structure is a homogenous material.

10. The method of any one of claims 1 to 9, wherein the structure is formed of at least one of a composite, a metal, a ceramic, a polymeric material, a semi-conductor material,
15 or a glass material.

11. The method of any one of claims 1 to 10, wherein the structure is a single layer.

20 12. An apparatus comprising:
a pulsed laser beam forming a line pump on a first surface of a structure; and
a pulsed laser beam forming a point detector on the first surface of the structure.

25

13. The apparatus of claim 12, wherein the line pump and the point detector are spaced a distance apart, wherein the distance is selected such that the point detector detects a plurality of types of ultrasonic signals from the structure.

30

14. The apparatus of claim 13, wherein the plurality of types of ultrasonic signals includes at least one of surface waves, shear waves, or longitudinal waves.

15. The apparatus any one of claim 12, 13 or 14, wherein the pulsed laser beam forming the line pump is provided by laser ultrasonic equipment.