NDE Publications: 1982

Leonard Mordfin, Editor

U.S. DEPARTMENT OF COMMERCE
National Bureau of Standards
Center for Materials Science
Office of Nondestructive Evaluation
Gaithersburg, MD 20899

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1. Introduction

This is the sixth in a series of bibliographies of NBS publications on nondestructive evaluation (NDE). Previous reports in this series have been:

- NBSIR 80-2080, "NDE Publications: 1978",
- NBSIR 81-2351, "NDE Publications: 1979",
- NBSIR 81-2364, "NDE Publications: 1980", and
- NBSIR 83-2741, "NDE Publications: 1981".

This report provides bibliographic citations for publications that appeared in the open literature during the calendar year 1982. Also included are citations for several publications that appeared in previous years but were not listed in the earlier compilations.

Almost all of these publications were authored by members of the NBS staff and include papers published in non-NBS media as well as papers and reports from the NBS publications series. A few were written for NBS media by non-NBS authors. Many of the publications cited are based on research that was supported, in whole or in part, by the NBS Office of Nondestructive Evaluation.

These publications address a wide variety of NDE methods, both those that are well established in industry and some that are relatively new. For completeness, several publications dealing with technologies that directly support NDE, such as resistivity measurement and scattering theory, have been included.

The format of this report is the same as that used previously. Brief, edited abstracts are provided for most of the publications cited. The bibliography and the abstracts comprise Section 2 of the report. The 124 entries of the bibliography are listed in alphabetical order by the surname of the first author.
Section 3 of the report is a subject index for the publications listed. This index is quite comprehensive and, when used together with the abstracts and the alphabetical bibliography, may be expected to enable readers to locate publications of interest without difficulty.

The last section of the report provides some assistance to readers wishing to obtain copies of specific publications listed.
2. Bibliography and Abstracts


A sample was placed on the neutron diffractometer in a special fixture and subjected to compressive loads while changes in the Bragg peak positions were observed separately for the SiC and the Al reflections.


The location of faults in underground transmission lines is difficult and time-consuming. DOE has sponsored research in the development of instrumentation to detect and locate incipient fault sites. Some of these methods rely on reflectometry techniques in either the time or frequency domain. NBS has investigated the feasibility of using such methods in extruded polyethylene cables.


This bibliography reflects the mission of the Division, which is to develop and maintain competence as an applied resource in mechanical measurements for NBS. These competences include generalized wave scattering and inverse scattering, vibration analysis, acoustics research, and calibrations of acceleration, surface texture, acoustics and optics. These competences are applied to problems in inspection technology to improve productivity and quality.


This paper describes a state-of-the-art facility for measuring the gas transmission characteristics of polymer films. Sensitive electronic manometers are used to monitor the rate at which gas passes through a film into an initially evacuated receiving volume. The recent recertification of SRM 1470 for permeances and time-lags of He, CO2, O2, and N2 is described to illustrate the capabilities of the apparatus.

An application of energy dispersive diffractometry to the measurement of residual strains (stresses) in the interior of industrial materials is described with particular emphasis on the use of high energy (up to 250 keV) x-ray photons. The use of high energy photons permits better penetration into materials. Hence diffraction data for evaluating bulk residual strains can be obtained in the transmission geometry in contrast with the conventional angular dispersive diffractometry, which uses Bragg reflections from the surface of materials. The reliability and sensitivity of the method are demonstrated through its application to mapping of residual stress distributions across weld zones in Alaskan pipe line segments.


Ultrasonic shear and longitudinal waves are used to evaluate the elasticity and attenuation of titanium weld and plate alloy. Wave speeds are used to measure the materials' elasticity and anisotropy, and the wave amplitude is used to measure relative levels of scattering in the weld and plate regions. Results obtained on a representative weld are compared with results obtained on oxygen contaminated specimens.


ASTM-type aluminum ultrasonic reference blocks have served as useful standards in materials evaluations for over 20 years. While much effort has been expended to improve this practice, in fact the block variability tolerances have increased substantially over the years. The many system variables which have caused this to happen will be outlined and discussed quantitatively. Specific results on an anomalous block set will be presented.
The variables affecting ultrasonic reference block calibrations are many. Of these, the transducer has received the most attention. Sophisticated approaches toward parameterizing its behavior, however, have met with limited success. We present a relatively simple empirical approach whereby the peak amplitude of the transducer's far-field center lobe is normalized and correction factors applied. An example follows, together with a discussion of the other principal system variables.

An X-ray optical configuration for real time synchrotron radiation topography is described. Video images of moving magnetic domain walls under a varying magnetic field were obtained from Ni single crystals in the anomalous transmission geometry.

Theoretical calculations have indicated that hybrid instrumentation using both radiation and electromagnetic interrogation for measurement of the integrity of bridge footings is feasible.

A system for calibrating transducers as receivers of elastic waves at the surface of a solid medium has been developed and is now in use at NBS. The method provides the voltage output of the transducer when mounted on a surface whose motion is known. An error analysis is given.

The stability of poly(ethylene terephthalate) is being studied in order to predict its long term behavior as the base of the film and tape used to record archival information.

This chapter discusses the origins of systematic errors in optical linewidth measurement systems, outlines advances in modeling the linewidth measurement process including imaging in the optical
microscope, describes a primary linewidth measurement system in use at NBS and discusses the use of primary measurements to calibrate less accurate systems conventionally used for linewidth measurements.


Ultra-drawn polyvinylidene fluoride transducers have been fabricated from pellet resin material. The samples were mechanically ultra-drawn beyond their natural 4:1 draw ratio in order to enhance the molecular orientation and thereby optimize the piezoelectric activity.


The effects of the angle of incidence on the ellipsometric determination of thickness and refractive index of oxide and nitride films on a silicon substrate are analyzed. It is found that the accuracy of a determination of a film's parameters depends as much on the accuracy of the angle of incidence as on the accuracy of the ellipsometric angles.


The variations of the intensity of the reflected light near null are compared for three ellipsometric techniques. The highest accuracy of the film thickness measurement is obtained when the angle of incidence is equal to the principal angle.


A comparative evaluation of various portable infrared sensing systems used for detecting heat loss anomalies within building envelopes was performed. The results of infrared surveys carried out by thermographic surveying firms and those by the National Bureau of Standards were analyzed and compared. Through the comparison, the degree of completeness of inspecting the residences thoroughly was evaluated to be the most important factor for defect identification.

The effort on this project included the initial tomographic reconstruction of a nuclear waste container.


Neutron-activation autoradiography extends the range of information that can be obtained with x-rays by being able to measure the distribution of several pigments other than lead and at the same time identify the elementary composition of the painting. The NBS reactor thermal column with modifications can provide a thermal neutron field suitable for studies of paintings while minimizing the radiation dose.


We report here on the modeling of oil shale retorts to obtain useful information about the contents of the retort (e.g., rubble size, void ratio, etc.) by means of electromagnetic probes. The results indicate feasibility of determining the void ratio by remote electromagnetic measurements.


See abstract for No. 26.


The objectives of this report are: (1) to identify NDE methods which can help building inspectors determine the quality and uniformity of in-place materials; and (2) to develop guidelines to assist inspectors in selecting appropriate NDE methods.


A review of methods developed for the nondestructive evaluation of building materials is presented. The generic features of NDE methods are discussed. This is followed by descriptions of specific methods. The principles underlying the operation of the methods are
described, along with their typical applications, advantages, and limitations. A table is included summarizing the characteristics of various NDE methods.


Isothermal tempering induced acoustic emission activity in A533B steel during indentation loading. Hydrogen charging prior to testing greatly enhanced the acoustic emission activity. This process can continue after unloading the indenter due to hydrogen diffusion to the residual stress field.


Manuscripts are provided of 36 presentations which detail progress in mass spectrometer measurements and calibration of internal package moisture and in increased assurance with moisture sensors.


Optical Microscope Linewidth-Measurement Standards, SRM-474 and SRM-475, have been developed by NBS for optical imaging systems capable of making line-spacing and linewidth measurements on IC photomasks. Each artifact affords a means of reducing systematic errors and keeping the optical system in statistical control. Procedures are given for accomplishing these goals along with a discussion of the uncertainty of the calibrated values.


The diffraction of SH waves by surface cracks in plates is studied in two different ways. First, a variational integral expression is used to calculate the reflection coefficients of the propagating modes. The scattered fields away from the crack are then obtained using modal superposition. Second, a finite element-analytical technique is used to calculate the scattered fields. The results of the two calculations are compared for the case of shallow cracks in the long wavelength limit. The theoretical results are also compared with experimental data. It is shown that SH waves may be
particularly appropriate for detecting and sizing elongated planar defects in butt welds.


Scattering of horizontally polarized shear (SH) waves by edge cracks of different orientations relative to the free surface of the half-space is studied. A technique is presented that is suitable for analyzing scattering by cracks or inhomogeneities in a semi-infinite elastic medium. Numerical results are presented for crack opening displacements and scattered fields on the surface. The experimental results are obtained using electromagnetic-acoustic transducers that can efficiently generate and detect low-frequency SH waves in metals. The results are applicable to sizing and characterization of weld defects. Recent experimental evidence suggests that this can be accomplished when the wavelength is of the order of twice the crack length or longer.


An accelerometer is provided which utilizes at least one sheet of piezoelectric polymer film, supported under tension in a frame, for sensing the acceleration-responsive movements of an associated inertial mass and providing an electrical output in accordance therewith.


The work focuses on calibration and sensor activities, characterization of AE sources and determination of source significance. The problem of repeatability of calibrations of certain sensors has been solved. Preliminary results from a second sensor calibration method are promising, showing good agreement in details with the current method. The NBS conical transducer is under development. It faithfully measures dynamic displacement; present sensors only detect a disturbance. A repetitive simulated source for source deconvolution in complex structures is well along in development. A method for repetitively reproducing AE in steel plates has been developed.


The NBS AE transducer calibration service and its relation to other methods are presented. A new piezoelectric AE transducer measures normal surface displacement nearly as faithfully as the NBS standard capacitive transducer but with much greater sensitivity. It holds
promise as a secondary calibration device and for application relying on causal signal processing. A multichannel AE system for characterizing reproducible AE events produced by indentation cracking is being developed.


In this report prepared for the Materials Chemistry Division and the Fracture and Deformation Division of the NBS Center for Materials Science, Professor Evans makes the point that nondestructive methods for probing the structure of green compacts and other pre-sintered forms (e.g., acoustic waves, x-ray and neutron methods) can be an invaluable adjunct to ceramic processing technology.


A variety of techniques is used for the measurement of thin film thicknesses of the order of one micrometer. These techniques include stylus profilometry, multiple beam interferometry, dual beam interferometry, guided waves, channel spectra and ellipsometry. The principles underlying the techniques are discussed and comparisons are presented.


A review is given of the electrical resistance of materials at cryogenic temperatures. Measurement techniques, the data base, and uses of the data are presented.


A conceptual definition of fatigue damage is proposed to assist in the selection of measurement techniques and parameters for correlating damage with fatigue life. A survey of some new techniques for damage monitoring, including the small angle neutron scattering method, is presented and discussed.


An ultrasonic technique is described that allows the determination of the through-thickness dimension and limited localization of planar defects in an isotropic metal plate. The scattering of horizontally polarized shear (SH) plate waves by edge and buried planar defects is investigated using a variational integral expression. It is shown that SH waves are particularly useful for detecting and
sizing of crack-like defects. In addition, it is possible to determine the relative position of a defect from interference phenomena. The results are confirmed experimentally using an electromagnetic-acoustic transducer system to generate and detect wave signals along the normal to the circumference of a steel pipe.


Inspection of austenitic stainless steel weldments by conventional ultrasonic means is fundamentally limited by the textured, columnar grain structure of the weld metal. It is shown that, for selected angles of incidence, shear waves normally polarized with respect to the columnar grains can pass through the weld metal-base metal interface without partial reflection. As a consequence, the inspectability of stainless steel weldments can be improved.


A new ultrasonic inspection technique is described to detect elongated defects in butt welds. The technique uses noncoupling, electromagnetic-acoustic transducers which can operate on most unprepared surfaces and under adverse environmental conditions. The technique is demonstrated in the context of the detection and sizing of defects in girth welds of cross-country pipeline. The inspection is carried out using shear wave signals polarized in the plane of the weld (SH waves). The advantage of inspections at low frequencies is that the reflected amplitude is relatively insensitive to defect orientation and surface roughness. Since SH waves can propagate at near-grazing angles, the sensitivity to through-wall two-dimensional defects can be maximized.


See abstract for No. 43.


A new ultrasonic inspection method is described that permits complete volumetric inspection of girth welds. The system uses noncontacting electromagnetic-acoustic transducers that operate at low ultrasonic frequencies (454 kHz). Theoretical models of the measurements are developed and verified experimentally. In addition, practical performance limits of the new system are established in terms of minimum flaw sizes that can be detected. The results
are related to accept-reject curves based on a model of the failure processes. An inspection protocol for field applications is also described.


In order to provide a basis for intercomparison of procedural standards in the field of eddy-current testing, several standards of ASTM and of GOST are identified. A brief description is provided of the contents of each.


This brief report summarizes research efforts in physical acoustics at NBS which were partially supported by the Office of Naval Research. It summarizes many of the major accomplishments at NBS in the area of physical acoustics from 1948 to 1981. The published literature documenting these successes is listed.


This article reviews recent developments in thermographic standards for inspection of the building envelope. The purpose of the standards is explained, their general content outlined and how they are to be used is discussed. The results of a field evaluation of the accuracy of thermographic inspectors in locating insulation voids in cavity walls are summarized. The reasons for observed inconsistencies in inspections of the same building by different thermographic inspectors are given. It must be concluded that improvements in inspection techniques are needed before thermographic inspections can be considered accurate.


This report presents reviews of various measurement and inspection techniques appropriate for assessing the thermal performance of the exterior envelopes of federal buildings. The inspection techniques include ground-based infrared thermographic surveys, aerial infrared surveys, tracer gas air infiltration measurement, pressurization tests for measuring the tightness of the building envelope, and spot radiometer surveys for detecting gross defects. For each technique recommended procedures are provided; they include equipment requirements, conditions under which the techniques can be carried out, calibration, accuracy, and limitations.
The objective was to develop tests to determine the integrity of large hybrid packages under various thermal and mechanical stresses that may be encountered during assembly, during installation in systems, or in operation. Emphasis was placed on acoustic-emission test procedures. The accomplishments were: (1) The effects of vibration on the seals of hybrid packages mounted on printed-circuit boards were determined. (2) A small acoustic-emission detector was developed that is sensitive to surface waves, but relatively insensitive to vibration induced cable noise. (3) A high-temperature open-package helium leak test method was successfully developed to observe marginal seal damage. (4) An acoustic-emission test for inspection of hybrid packages during thermal shock was developed. (5) A study of damage to seals during thermocompression and thermal-sonic bonding during assembly operations was carried out. There is little correlation between visual inspection failures of glass seals and their hermeticity.

This paper gives a brief introduction to acoustic-emission (AE) based tests applied to quality control in the electronics industry and describes some recent research on this testing technique. Equipment and circuits are described that may be used to implement such AE-monitored testing. Acoustic-emission-monitored test systems to determine the inner lead bond quality for Tape Automated Bonding (TAB) have been developed. These include a pull tester and a micro-fatigue tester for off-line evaluation of bond quality and metallurgical system reliability as well as an automatic on-line production bond quality tester.

An acoustic-emission monitored hot-stage shock test was developed that detects weak package seals. There is little correlation between visual inspection failures of glass seals and their hermeticity.

This Standard Reference Material is a renewal of SRM 485, and is intended for the calibration of x-ray diffraction equipment used in determining the amount of retained austenite in hardened steels.

This Standard Reference Material is intended for the calibration of x-ray diffraction equipment used in determining the amount of retained austenite in hardened steels.


This paper addresses the problem of determining the AE source time-function from the detected AE signal with a sensor located a short distance away. The solution is in the form of an inverse filter. In other words, by removing the effects of the reverberations of the structure and the particular characteristics of the sensor, the filter recovers the AE source signature which characterizes the source mechanism alone.


This paper specifically addresses the question of how to produce a known stress-state reference sample, and ultrasonically determine its zero stress state. A shrink-fit ring-plug assembly was fabricated from carefully screened aluminum bar stock, forming a disk suitable for both longitudinal and shear wave calibration.


A laboratory evaluation of infrared thermography for detecting moisture in roofing specimens is presented. For steady state heat flow, and in a few cases, transient heat flow, the effects of moisture on the surface temperature of the specimens were determined by thermography.


Optical microscopes fitted with a micrometer attachment are commonly used to measure small linewidths and other critical dimensions on integrated-circuit photomasks. In the absence of calibrated linewidth standards, users have experienced systematic measurement errors much larger than required manufacturing tolerances. This report discusses the results of an interlaboratory study to evaluate a
prototype calibration standard for linewidth measurements and procedures for adjusting and calibrating optical-microscope systems. A linewidth calibration significantly reduced systematic errors for most systems. This study led to the issuance of NBS Standard Reference Material 474 (Optical Microscope Linewidth-Measurement Standard).


A report will be presented of calculations of eddy currents in the vicinity of a crack in a plane slab of conducting material. The problem was solved by a boundary integral equation method. The induced currents at the surface and on the crack will be shown for all ranges of the ratio of crack depth to the electromagnetic skin depth and for selected angles of crack inclination.


A robot sensory system for industrial robotics, employing structured light vision techniques, is described.


A variational solution is obtained for scattering of horizontally polarized shear waves from cracks in plates. Numerical results are presented for edge cracks.


This study was performed to develop methods of measuring the cumulative damage of steel reinforced concrete slabs subjected to repeated impact. Cumulative damage was monitored by measuring the crater depth and the reduction in ultrasonic pulse velocity across the impact region. The reduction in velocity generally increased with number of impacts up to about 40 percent or more of the total
number of impacts to failure. Beyond that, interpretation of the ultrasonic results with respect to the failure mechanism appears necessary.


A procedure was developed, using a heat-flow meter apparatus (ASTM C 518 type), to carry out thermal conductance tests on roofing specimens containing moisture. Relationships between the thermal conductance and moisture content are presented.


This paper describes a nondestructive technique that can be used to measure the degree of degradation of the fiber or matrix stiffnesses. This is accomplished by monitoring the direction of propagation of an acoustic beam as a function of the degree of elastic anisotropy of the composite.


For studying welds nondestructively using elastic waves, we describe the importance of knowing the material's single-crystal elastic constants. Where these are not known, we give guidelines for estimating them from polycrystalline elastic constants such as Young's modulus and the shear modulus.


The reflection of a monochromatic plane wave falling obliquely upon the surface of an arbitrary, flat, depth-dependent material is investigated theoretically. The reflection coefficients can be obtained directly without having to solve Maxwell's equations for the internal field configurations.

This journal provides for original papers concerned with the development and application of ultrasonic techniques, with emphasis on medical diagnosis. Papers deal with theoretical and experimental aspects of advanced methods and instrumentation for imaging, computerized tomography, Doppler measurements, signal processing, pattern recognition, microscopy, and measurements of ultrasonic parameters.


We present a critical summary of the methods that have been developed to measure the various ultrasonic parameters. The three major interactions amenable to measurement—velocity, attenuation/absorption, and scattering—are discussed, followed by a brief mention of pattern recognition approaches.


See abstract for No. 72.


When a wave interacts with an obstacle, the scattered and transmitted fields can be found by solving a system of integral equations for two unknown fields defined on the surface of the body. By choosing a more appropriate unknown function, the system of equations is reduced to a single singular integral equation of the first kind.


The theory of dyadic Green functions for a transient electromagnetic field is presented within the framework of the theory of distributions. First, the elementary solution of the scalar wave equation is derived, and then it is used to find the general solution of that equation. After establishing the equivalence between Maxwell's equations and the time-dependent vector wave equation, the dyadic elementary solution is derived and applied to solve the equation. The paper includes a collection of formulas from the theory of distributions intended to help readers who are not familiar with the subject.

This section describes the nature and functions of hermetic seals, and methods for both "gross" and "fine" leak testing of hermetically sealed devices such as electronic components and integrated circuit packages.


A Briefing/Workshop on Process Control Sensors for the Steel Industry was convened and attended by 160 people on July 27–28, 1982, at NBS in Gaithersburg, Maryland. It was sponsored by the American Iron and Steel Institute, the Defense Advanced Research Projects Agency, and NBS. The aim of the Briefing/Workshop was to provide scientists and engineers in industry, universities, and government with specific process control sensor needs of the steel industry and to seek immediate input and future research and development involvement from a broad spectrum of disciplines to facilitate development of sensors. This report is the proceedings of the deliberations from the Workshop portion of the meeting.


The cooperation between specialists in fatigue and in nondestructive testing is marked as a noteworthy milestone in an era in which closer cooperation between these two groups will be needed in order to achieve enhanced quality in materials and manufactured products. Experiences with an unusual form of damage in pultruded guys for antenna support systems are described to show that the development of meaningful test methods for composites may benefit from unconventional approaches.


This paper is a status report on the growing national effort to develop voluntary consensus standards to enhance the reproducibility of residual stress measurements. This effort has achieved noteworthy progress in only a few years, but it has also become evident that further progress will be increasingly more difficult because our understanding of some residual stress phenomena is limited. There is need for a national research effort to parallel and to support the standardization effort.

80. Mordfin, L. Advanced diffraction techniques for the nondestructive evaluation of internal residual stresses, Proc. Seventh Int. Conf. on Experimental Stress Analysis, pp. 602–603 (The Technion, Israel Institute of Technology, Haifa, Israel, 1982).

These techniques, which are based upon Bragg diffraction, use thermal neutrons and high-energy x-rays to achieve depths of penetration not attainable by conventional x-ray diffraction techniques.

The limits imposed on the spatial resolution obtained with screen-film systems for low contrast images are determined primarily by x-ray quantum noise rather than by the spatial response (MTF curve) of the system.


The scattering of sound waves by isolated inhomogeneities in a solid is examined using the Born approximation. A procedure is developed to extract information about the effective volume and shape of the scatterer. A scheme is described which permits the characterization of the scatterer in terms of an equivalent ellipsoid.


Assuming that the index of refraction deviates from its mean on the order of the small quantity epsilon, we derive expressions for the refracted ray path whose departure from a straight line is first order in epsilon. We obtain a time-delay correction of order epsilon squared arising from the deviation of the refracted ray from a straight line. The expression is also used to obtain explicit corrections for phase-cancellation and beam-displacement errors that affect attenuation measurements when transducers of finite extent are employed. Because of refraction, large aperture transducers are susceptible to an arrival-time uncertainty in a time-of-flight measurement; a first-order expression for the maximum value of this uncertainty is derived. In both two and three dimensions, the perturbation approach is much simpler computationally than numerical ray tracing methods.


Coherent edge detection methods have been developed for the measurement of line objects on integrated-circuit photomasks and wafers. This paper presents a generalization of the coherent threshold
equation which allows the extension to any state of partial coherence of the illumination as well as extension to the measurement of nonplanar objects.


Measurements of leakage fields from cylindrical defects were obtained in a geometry which permitted simultaneous measurement of the magnetic induction of the material. The results are compared with calculations using a nonlinear finite difference method. Both the experiments and the calculations indicate that the leakage field continues to grow nearly in proportion with the applied field well into the saturation region of the magnetic material. The implications for magnetic particle inspection are discussed.


The use of ultrasonic flaw detectors to detect the presence and location of discontinuities is well known. The solid-liquid interface in a melting or freezing metal can also be considered a discontinuity, in that there is a measurable difference in both sound velocity and density across the interface. For normal incidence of longitudinal waves in a typical case, about 10 percent of the pressure amplitude of the incident wave would be expected to be reflected. Thus such a technique, if it worked, could be considered as a method for measurement, feedback, and closed-loop process control in such applications as continuous casting of metals. To examine the feasibility of this technique, the melting and freezing of 99.9 Sn has been studied at NBS using pulse-echo equipment. NBS work is focused on the study of the measurement factors inherent in possible use of the method for process control, as well as possible use for interface characterization.

90. Placious, R. C. Radiographic variables and weld flaw analysis, Failure Prevention in Ground Transportation Systems. NBS SP 621. 1982 October. 165-173.

The limits on accuracy of flaw depth analysis, due to radiographic variables, are analyzed in this paper.


A piezoelectric transducer has been designed and developed that has promise of being a high fidelity acoustic emission transducer. Small transducer contact area, elimination of acoustical interference effects associated with certain geometries, and redistribution of the arrival times of reflected signals originating from various elements of the transducer were the guiding criteria in the design. This transducer consists of a conical active element and an extended
backing. The transducer's performance indicates an amplitude response which is flat within ±3 dB for the range of 50 kHz to 1 MHz. Factors that influence frequency response, such as backing geometry and aperture size, have been experimentally investigated.


We have developed a piezoelectric transducer that responds with a high degree of accuracy to normal surface displacement over the frequency range of 50 kHz to 1 MHz. We have found it extremely useful for investigating transfer functions in AE work. Its faithful time wave response opens many new avenues for investigation.


Accurate dimensional measurements are vital to quality control in the semiconductor industry. This paper presents a method for estimating the dollar cost-savings from improving integrated-circuit photomask linewidth measurements. The method is illustrated with a case study of a hypothetical semiconductor device manufacturer who uses a Standard Reference Material developed at NBS for optical microscope calibration.


This section describes techniques of leak testing with halogen compound tracer gases, including common refrigerant gases. The first two parts of this section are introductory in nature. The later parts provide standard recommended practices and techniques for leak testing with halogen tracer gases.


This report describes the theory, design, construction, and testing of an electromagnetic coal interface detector. The purpose of this type detector is measuring the thickness of roof coal left during underground mining operations.

This section presents an introduction to the art and science of leak testing, a basic form of nondestructive testing and materials evaluation. Basic principles of leak testing and test methods, equipment and techniques, and hazards to be controlled during leak testing are summarized.


This section presents an introduction to the nature of leakage flow of gases and the factors that control leakage and influence measurements of leakage. This discussion is basic to all leak testing since tracer gases provide higher test sensitivity than do liquid tracers in detection of very small leaks.


This section describes reference leaks fabricated for purposes of evaluating the sensitivity of leak testing systems and leak detection instruments. These reference leaks are used to provide known rates of leakage which can be used to adjust leak detector sensitivity, ensure that specified maximum rates of allowable leakage can be detected reliably, and provide standardization of leak testing operations in various locations. In many cases, leakage from the artificial leak is used to calibrate scales on leak detector instruments and, in combination with unknown leakage from test objects or systems, permits quantitative measurement of leakage rates.


The present investigation has demonstrated the feasibility of a dynamic ultrasonic NDE method for monitoring the precipitation hardening process, over a wide temperature interval, in aluminum alloys during its progress.


Crystallization kinetics in amorphous metallic ribbons was studied by means of laser-generated and piezoelectrically detected ultrasonic waves whereby the extensional wave velocities, and consequently the Young's moduli, could be determined accurately. Corroboration was obtained with optical metallography.


The first part of this report deals with small-angle neutron scattering and describes the small-angle scattering spectrometer and the associated data display and analysis. The second part addresses the neutron time-of-flight facility.


A graphic procedure for solution of the molecular flow approximation for the back pressurization method of hermetic test makes use of a set of characteristic curves and a test line. One set of characteristics is provided specifically for the helium leak detector mode as expressed directly in terms of air leak rate; a second set is provided specifically for the krypton-85 radioisotope mode also in terms of air leak rate; and a third set is retained in the original form for use with any tracer gas.


Range, efficiency, and usefulness are examined for such popular test procedures as the helium leak detector, radioisotope, weight gain, and bubble methods as well as for others such as the tracer probe, differential pressure, and rapid cycle methods that are more appropriate for the larger package.

Many semiconductor devices are encapsulated in plastic as an inexpensive means of protection, but high reliability devices are typically incorporated into hermetic enclosures. The hermeticity must then be assured. The procedures used for semiconductor devices are considered here, and these are also applicable to other hermetically packaged items.


With new developments in instrumentation for angular-vibration measurements, the demand for calibration services is expected to grow. This paper investigates the feasibility of measuring the magnitude of vibratory displacement absolutely. In general, a reciprocity calibration is better suited to angular displacements of low frequency and large amplitude, whereas an interferometric calibration has no practical frequency constraints, but requires that the amplitude of vibration be limited.


An absolute method for measuring the phase component of pickup sensitivity is described. The phase calibration is in terms of the time interval between zero crossings and can be performed along with magnitude calibration on an automated Michelson interferometer.


These proceedings consist of 18 submitted entries from the 31st meeting of the Mechanical Failures Prevention Group. The theme of the symposium was failure prevention in ground transportation systems. Areas of interest included rail vehicles and structures, highway and road bridges, pipeline transportation systems, and motor carriers.


These proceedings consist of 34 submitted entries from the 33rd meeting of the Mechanical Failures Prevention Group. The subject of the symposium was maintenance technology improvement through innovation. Areas of special emphasis included maintenance diagnostics and maintenance indicators.
This report summarizes all those programs which depend on the NBS reactor. It covers the period from July 1980 through June 1981. The programs include neutron radiography and nondestructive evaluation.

NASA is re-examining aerodynamic effects related to model surface topography definition. This paper describes current work at NBS to evaluate the performance of stylus instruments for this application and to develop a light scattering instrument which will yield accurate characterizations of the surface microtopography and overcome the problems associated with stylus profilometry.

Fusion science and engineering requires accurate vacuum measurements. In order to determine what performance can be expected from different ion gages, a gage characterization program has been initiated. This program determines the uniformity, accuracy, and linearity for different gage tubes, and for the more promising candidates further characterizes the sensitivity for different gases and the effects of changing bias voltages and emission currents.

This paper first describes a Q-switched laser for the generation of predictable acoustic emission signals which are used to evaluate multichannel source characterization methods. Second, the laser generation of elastic waves is used to measure the speed of extensional wave propagation in metallic glass ribbons.

A developmental model of a pulsed reflection acoustic microscope was built, and techniques of nondestructive evaluation of surfaces and thin layered structures were studied. The image signal was enhanced
by the application of a quarter-wave acoustic antireflection coating to the surface of the lens. Many integrated circuits and device structures were studied in the scanning mode, leading to acoustic micrographs. Comparisons were made with optical and scanning electron micrographs.


A description is given of a facility for evaluating infrared imaging systems for building applications being constructed at NBS.


This guide provides detailed information for the construction of a single-speed version of Drill-Up and instructions for its installation and operation. Drill-Up is an instrument designed to prevent breakage of small-diameter drills used on automatic-feed drilling machines with a spindle retract ability.


A method for determining drill wear and predicting drill breakage has been implemented by applying time-domain analysis on a signal from an accelerometer mounted on the workpiece. In 49 of 50 cases the system predicted the drill would fail 2 to 20 holes before actual failure.


A review of nondestructive evaluation programs at NBS for FY 1982 is presented in this annual report.
3. Subject Index

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