
Contents

Author Biographies	ix
Preface	xiii
1 Introduction	1
<i>Hartmut Brauer</i>	
1.1 Electromagnetic testing	9
1.1.1 Brief historical review	10
1.1.2 Electromagnetic NDT methods	11
1.1.3 Capabilities of electromagnetic techniques	14
1.1.4 Present state of eddy current inspection	15
1.2 Eddy current testing	18
1.2.1 Eddy current and ECT	18
1.2.2 ECT principles	19
1.2.3 Applications	34
1.3 Motion-induced ECT	35
1.3.1 Introduction	35
1.3.2 Lorentz force eddy current testing	36
1.3.3 Theory	38
1.3.4 Experiments	39
1.3.5 Comparison of ECT and LET	43
2 Forward simulation methods	47
<i>Marek Ziolkowski, Mladen Zec and Konstantin Weise</i>	
2.1 Moving coordinate systems—transformations	48
2.2 Semianalytical methods used in LET systems	51
2.2.1 Calculation of forces in 2D LET systems	51
2.2.2 Lorentz forces acting on 3D permanent magnets above moving conducting plate without defects	62
2.2.3 Calculation of forces in 3D LET systems	70
2.2.4 Oscillatory motion of permanent magnets above a conducting plate	75
2.2.5 The simplest approach to calculate DRS	100
2.2.6 A hole in a thin, large, conductive sheet	103
2.2.7 An extended area approach in the calculation of DRS	105
2.3 Surface charge simulation method	110

2.4	Numerical simulations with FEM	116
2.4.1	Introduction and motivation	116
2.4.2	Computation of eddy current distributions including moving parts	117
2.4.3	Numerical modeling of conductivity anomalies	120
2.4.4	Comparison of numerical approaches	129
3	Sensors for MIECT	137
<i>Matthias Carlstedt, Hartmut Brauer and Konstantin Weise</i>		
3.1	Force measurement systems	137
3.1.1	Principles of force transducers	137
3.1.2	Differential Lorentz force eddy current testing sensor	141
3.1.3	Characteristics and calibration of force measurement systems	146
3.2	Optimization of PM systems	147
3.2.1	Introduction and motivation	147
3.2.2	Methods	147
3.2.3	Optimization results and discussion	162
3.2.4	Prototypes of optimized LET magnet systems	168
3.2.5	Defect depth study	171
3.2.6	Conclusions	173
4	Experiments and LET measurements	175
<i>Matthias Carlstedt and Konstantin Weise</i>		
4.1	Measurement procedure	175
4.1.1	Measurement principle	176
4.1.2	Measurement method	176
4.1.3	Experimental setup	179
4.2	Validation procedure	186
4.2.1	DSP and basic statistics	186
4.2.2	Autocorrelation on typical force signals	190
4.2.3	Program flowchart for DSP	192
4.2.4	Experimental study	198
4.2.5	Uncertainty analysis	204
5	Lorentz force evaluation	227
<i>Hartmut Brauer</i>		
5.1	Identification of conductivity anomalies	227
5.2	Inverse solution techniques	229
5.2.1	Theory	229
5.2.2	Classification of inverse problems	230
5.2.3	Regularization	235
5.3	Lorentz force evaluation	236
5.4	Summary	242

6 Applications	243
<i>Robert P. Uhlig, Hartmut Brauer, Konstantin Weise and Marek Ziolkowski</i>	
6.1 Sigmometry	243
6.1.1 Introduction and motivation	243
6.1.2 Basic principle	244
6.1.3 Semianalytical and numerical calibration	246
6.1.4 Experimental validation	248
6.1.5 Findings	254
6.2 Defectoscopy of multilayered structures	255
6.2.1 LET measurements of alucobond specimen	255
6.2.2 Forward simulations	256
6.2.3 Defect identification	259
6.2.4 Results and discussion	261
6.3 Inspection of composites	265
6.3.1 Composite material	265
6.3.2 Glass laminate aluminum reinforced epoxy (GLARE)	267
6.3.3 Carbon fiber reinforced polymer (CFRP)	280
6.4 Defectoscopy of friction stir welding	290
6.4.1 Friction stir welding (FSW)	290
6.4.2 FSW experiments	294
6.4.3 NDT of friction stir welds	295
6.4.4 MIECT measurements of friction stir welds	298
6.4.5 Potential applications of MIECT	302
6.5 Application to ferromagnetic materials	303
References	307
Index	337