



# Table of contents

## Semiconductors

### **Subvolume c: Technology of Si, Ge and SiC** (edited by M. SCHULZ · H. WEISS †)

<b>A Introduction (M. SCHULZ)</b>		
1 General remarks . . . . .	1	
2 Frequently used symbols . . . . .	2	
3 Conversion of units . . . . .	5	
4 Abbreviations frequently used in semiconductor technology . . . . .	6	
 <b>B Technology of semiconductors</b>	 Data	 Figures
<b>6 Tetrahedrally bonded semiconductors . . . . .</b>	<b>12</b>	<b>-</b>
<b>6.1 Silicon and germanium . . . . .</b>	<b>12</b>	<b>-</b>
<b>6.1.1 Technological data (A. MÜHLBAUER). . . . .</b>	<b>12</b>	<b>417 ff.</b>
6.1.1.0 Introduction . . . . .	12	-
6.1.1.1 Phase diagrams and liquidus curves . . . . .	12	417 ff.
6.1.1.2 Solubility in solid Si and Ge . . . . .	13	419 ff.
6.1.1.3 Equilibrium distribution coefficient . . . . .	14	420 ff.
6.1.1.4 Melt diffusion coefficient . . . . .	16	423
6.1.1.5 Evaporation rate . . . . .	16	-
6.1.1.6 Tetrahedral covalent radius . . . . .	17	422
6.1.1.7 Thermophysical properties . . . . .	17	421 ff.
6.1.1.8 Properties of liquid Si and Ge . . . . .	19	-
References for 6.1.1 . . . . .	20	-
<b>6.1.2 Crystal growth . . . . .</b>	<b>23</b>	<b>-</b>
<b>6.1.2.1 Deposition of polycrystalline silicon (W. DIETZE). . . . .</b>	<b>23</b>	<b>-</b>
6.1.2.1.0 Introduction . . . . .	23	-
6.1.2.1.1 Deposition technology . . . . .	23	425
6.1.2.1.2 Processes connected to deposition . . . . .	25	425
6.1.2.1.3 Deposition conditions . . . . .	26	426
6.1.2.1.4 Alternative processes . . . . .	26	-
<b>6.1.2.2 Preparation and purification methods of Ge (W. DIETZE). . . . .</b>	<b>28</b>	<b>-</b>
<b>6.1.2.3 Czochralski growth of Si and Ge (W. ZULEHNER). . . . .</b>	<b>28</b>	<b>-</b>
6.1.2.3.0 Introduction . . . . .	28	-
6.1.2.3.1 Czochralski pulling technique . . . . .	28	427 ff.
6.1.2.3.2 Starting materials . . . . .	32	428 ff.
6.1.2.3.3 Crucible materials . . . . .	33	429
6.1.2.3.4 Heating and furnace equipment . . . . .	35	429
6.1.2.3.5 Growth ambients . . . . .	36	447
6.1.2.3.6 Automatic control . . . . .	37	430 ff.
6.1.2.3.7 Recharging methods . . . . .	37	430 ff.
6.1.2.3.8 Czochralski pulling apparatus . . . . .	38	429 ff.
6.1.2.3.9 Impurity incorporation . . . . .	39	432 ff.
6.1.2.3.10 Oxygen incorporation . . . . .	39	429 ff.
<b>6.1.2.4 Zone melting (A. MÜHLBAUER, subsection 6.1.2.4.6 P. GLASOW). . . . .</b>	<b>41</b>	<b>-</b>
6.1.2.4.0 Introduction . . . . .	41	434 ff.
6.1.2.4.1 Silicon float-zone technology . . . . .	41	434 ff.

## Table of contents

	Data	Figures
6.1.2.4.2 Forces in a floating zone . . . . .	43	435
6.1.2.4.3 Doping of float-zone grown crystals . . . . .	43	436
6.1.2.4.4 Redistribution of impurities . . . . .	45	436 ff.
6.1.2.4.5 Faceting . . . . .	46	439
6.1.2.4.6 Growth of high purity germanium . . . . .	47	437 ff.
<b>6.1.2.5 Unconventional Si crystallization techniques (M. SCHULZ, E. SIRTL)</b> . . . . .	<b>50</b>	-
6.1.2.5.1 Directional solidification . . . . .	50	441
6.1.2.5.2 Mould casting . . . . .	51	441 ff.
6.1.2.5.3 Sheet growth . . . . .	52	442 ff.
<b>6.1.2.6 Wafer preparation (W. ZULEHNER)</b> . . . . .	<b>54</b>	-
6.1.2.6.1 Ingot preparation . . . . .	54	444 ff.
6.1.2.6.2 Slicing, lapping, and edge rounding . . . . .	55	445
6.1.2.6.3 Etching, polishing, wafer finishing . . . . .	56	445
References for 6.1.2 . . . . .	57	-
<b>6.1.3 Characterization of crystal properties</b> . . . . .	<b>62</b>	-
<b>6.1.3.1 Properties of polycrystalline silicon (W. DIETZE)</b> . . . . .	<b>62</b>	446
<b>6.1.3.2 Properties of Czochralski silicon (W. ZULEHNER)</b> . . . . .	<b>62</b>	-
6.1.3.2.1 Doping profiles . . . . .	63	446 ff.
6.1.3.2.2 Oxygen in CZ silicon . . . . .	64	449 ff.
6.1.3.2.3 Impurities in CZ silicon . . . . .	66	453
6.1.3.2.4 Lattice defects . . . . .	67	453 f.
<b>6.1.3.3 Properties of float-zone silicon (A. MÜHLBAUER)</b> . . . . .	<b>69</b>	-
6.1.3.3.1 Doping profiling . . . . .	69	455 ff.
6.1.3.3.2 Impurity striations . . . . .	70	460 ff.
6.1.3.3.3 Impurities . . . . .	71	462
6.1.3.3.4 Defects . . . . .	72	462 ff.
<b>6.1.3.4 Properties of high purity germanium (P. GLASOW)</b> . . . . .	<b>73</b>	-
6.1.3.4.1 Impurities in the starting material . . . . .	73	-
6.1.3.4.2 Impurities in purified Ge . . . . .	73	465 ff.
<b>6.1.3.5 Diagnostic techniques (A. MÜHLBAUER, subsection 6.1.3.5.3 P. GLASOW)</b> . . . . .	<b>77</b>	-
6.1.3.5.1 Doping profiling . . . . .	77	-
6.1.3.5.2 Impurity and defect analysis . . . . .	77	466
6.1.3.5.3 Characterization – techniques for high purity germanium . . . . .	82	466
References for 6.1.3 . . . . .	83	-
<b>6.1.4 Device technology</b> . . . . .	<b>90</b>	-
<b>6.1.4.0 Basic device structures (H. MADER, subsection 6.1.4.0.9 P. GLASOW)</b> . . . . .	<b>90</b>	-
6.1.4.0.0 Introduction . . . . .	90	467 ff.
6.1.4.0.1 Diodes . . . . .	91	468 ff.
6.1.4.0.2 Transistors . . . . .	94	-
6.1.4.0.3 Bipolar transistors . . . . .	101	470 ff.
6.1.4.0.4 MOS-transistors . . . . .	101	471 ff.
6.1.4.0.5 Thyristors . . . . .	102	473 ff.
6.1.4.0.6 Bipolar integrated circuits . . . . .	102	474 ff.
6.1.4.0.7 MOS-integrated circuits . . . . .	103	476 ff.
6.1.4.0.8 CMOS integrated circuits . . . . .	104	479 ff.
6.1.4.0.9 Nuclear radiation detectors . . . . .	104	481 ff.
References for 6.1.4.0 . . . . .	115	-
<b>6.1.4.1 Diffusion (W. LANGHEINRICH under assistance of K. HABERLE)</b> . . . . .	<b>118</b>	-
6.1.4.1.0 Introduction . . . . .	118	-

	Data	Figures
6.1.4.1.1 Diffusion coefficients . . . . .	119	494 ff.
6.1.4.1.2 Introduction of impurities by diffusion . . . . .	129	497 ff.
6.1.4.1.3 Properties of diffusion source material . . . . .	134	502
6.1.4.1.4 Diffusion in the system SiO <sub>2</sub> /Si . . . . .	135	499 ff.
6.1.4.1.5 Diffusion profiles . . . . .	139	500 ff.
6.1.4.1.6 Properties of masking layers . . . . .	141	502 ff.
6.1.4.1.7 Gettering . . . . .	144	504 ff.
References for 6.1.4.1 . . . . .	145	–
<b>6.1.4.2 Ion implantation (H. RUNGE) . . . . .</b>	<b>150</b>	–
6.1.4.2.0 Introduction . . . . .	150	–
6.1.4.2.1 Depth distribution of implanted ions . . . . .	150	506 ff.
6.1.4.2.2 Annealing . . . . .	154	–
6.1.4.2.3 Implantation of dopants in Si . . . . .	154	507 ff.
6.1.4.2.4 Implantation of dopants in Ge . . . . .	156	–
6.1.4.2.5 Useful formulas . . . . .	156	509 ff.
6.1.4.2.6 Range tables . . . . .	157	–
6.1.4.2.7 Evaluation of ion implanted layers . . . . .	166	511
6.1.4.2.8 Implantation apparatus . . . . .	170	511 ff.
References for 6.1.4.2 . . . . .	179	–
<b>6.1.4.3 Nuclear transmutation doping (M. SCHNÖLLER) . . . . .</b>	<b>185</b>	–
6.1.4.3.0 Introduction . . . . .	185	513 ff.
6.1.4.3.1 Nuclear transmutation . . . . .	185	–
6.1.4.3.2 Radiation defects . . . . .	185	–
6.1.4.3.3 Side reactions of neutron irradiation . . . . .	186	–
6.1.4.3.4 Irradiation exposure time . . . . .	188	514
6.1.4.3.5 Selection and preparation of the starting silicon . . . . .	188	514
6.1.4.3.6 Neutron irradiation . . . . .	188	515
6.1.4.3.7 Radioactivity of the irradiated silicon . . . . .	189	515
6.1.4.3.8 Annealing . . . . .	189	515 ff.
References for 6.1.4.3 . . . . .	190	–
<b>6.1.4.4 Silicon epitaxy (A. LUDSTECK) . . . . .</b>	<b>192</b>	–
6.1.4.4.1 Introduction . . . . .	192	–
6.1.4.4.2 Basic technology . . . . .	193	517
6.1.4.4.3 Scope of the data collection . . . . .	196	–
6.1.4.4.4 Properties of materials used in Si epitaxy . . . . .	197	518 ff.
6.1.4.4.5 Epitaxial silicon growth . . . . .	202	527 ff.
6.1.4.4.6 Doping during epitaxy . . . . .	205	528
6.1.4.4.7 Low-pressure deposition . . . . .	206	–
6.1.4.4.8 Defects in epitaxial layers . . . . .	207	528
6.1.4.4.9 Evaluation of epitaxial silicon films . . . . .	207	528
References for 6.1.4.4 . . . . .	210	–
<b>6.1.4.5 Fabrication of layers (subsections 6.1.4.5.0–7, E. DOERING, 6.1.4.5.8–12 L. SCHLEICHER) . . . . .</b>	<b>213</b>	529 ff.
6.1.4.5.0 Introduction to insulating films . . . . .	213	–
6.1.4.5.1 Thermal oxidation of silicon . . . . .	213	529 ff.
6.1.4.5.2 Modified thermal oxidation processes . . . . .	217	533 ff.
6.1.4.5.3 Chemical vapour deposition . . . . .	219	538 ff.
6.1.4.5.4 Evaporation . . . . .	223	–
6.1.4.5.5 Sputtering . . . . .	224	541
6.1.4.5.6 Anodization . . . . .	225	–
6.1.4.5.7 Properties of insulating films . . . . .	225	541
References for 6.1.4.5.0–6.1.4.5.7 . . . . .	233	–
6.1.4.5.8 Requirements on metal layers . . . . .	593	624
6.1.4.5.9 Metal deposition . . . . .	595	625 ff.
6.1.4.5.10 Properties of metals used for deposition . . . . .	604	634 ff.
6.1.4.5.11 Intrinsic properties of metal layers . . . . .	610	636 ff.

	Data	Figures
6.1.4.5.12 Residual gas dependent properties of metal layers . . . . .	613	639 ff.
References for 6.1.4.5.8 . . . . .	621	-
<b>6.1.4.6 Litography (H. MADER) . . . . .</b>	<b>250</b>	<b>542 ff.</b>
6.1.4.6.0 Introduction . . . . .	250	542 ff.
6.1.4.6.1 Resists . . . . .	250	543 ff.
6.1.4.6.2 Photolithography . . . . .	251	542 ff.
6.1.4.6.3 Electron-beam lithography . . . . .	260	548 ff.
6.1.4.6.4 X-ray lithography . . . . .	265	551 ff.
6.1.4.6.5 Ion-beam lithography . . . . .	270	553 ff.
References for 6.1.4.6 . . . . .	274	-
<b>6.1.4.7 Etching processes (H. MADER) . . . . .</b>	<b>280</b>	<b>556 ff.</b>
6.1.4.7.1 Wet etching . . . . .	280	-
6.1.4.7.2 Wet etching techniques . . . . .	281	-
6.1.4.7.3 Wet etching processes for pattern generation . . . . .	281	556
6.1.4.7.4 Wet etchants . . . . .	282	-
References for 6.1.4.7.1 . . . . .	301	-
6.1.4.7.5 Dry etching . . . . .	305	-
6.1.4.7.6 Ion etching processes . . . . .	307	556 ff.
6.1.4.7.7 Reactive dry etching processes . . . . .	319	558 ff.
6.1.4.7.8 Systems used for reactive dry etching . . . . .	325	566 ff.
6.1.4.7.9 Gases used in reactive dry etching . . . . .	328	-
References for 6.1.4.7.5 . . . . .	351	-
<b>6.1.4.8 Final device preparation (E. UDEN) . . . . .</b>	<b>367</b>	<b>569 ff.</b>
6.1.4.8.1 Survey of package groups . . . . .	367	569 ff.
6.1.4.8.2 Package components and materials . . . . .	375	569 ff.
6.1.4.8.3 Assembly methods . . . . .	387	571 ff.,
6.1.4.8.4 Properties of packages . . . . .	395	584
References for 6.1.4.8 . . . . .	398	-
<b>6.2 Silicon carbide (W. v. MÜNCH) . . . . .</b>	<b>403</b>	<b>585 ff.</b>
<b>6.2.0 Introduction . . . . .</b>	<b>403</b>	<b>-</b>
<b>6.2.1 Technological data . . . . .</b>	<b>404</b>	<b>585 ff.</b>
6.2.1.1 Figures of merit for devices . . . . .	404	-
6.2.1.2 SiC phase diagram . . . . .	404	585
6.2.1.3 Solubility of carbon in silicon . . . . .	404	585
6.2.1.4 Vapour pressure of silane compounds . . . . .	404	586
<b>6.2.2 Crystal growth . . . . .</b>	<b>404</b>	<b>585 ff.</b>
6.2.2.0 Introductory remarks . . . . .	404	-
6.2.2.1 Melt growth . . . . .	405	585 ff.
6.2.2.2 Vapour growth . . . . .	405	586 ff.
6.2.2.2.1 Deposition of polycrystalline SiC . . . . .	405	586
6.2.2.2.2 Lely technique . . . . .	406	586 ff.
<b>6.2.3 Characterization of crystal properties . . . . .</b>	<b>407</b>	<b>587 ff.</b>
6.2.3.1 Polytype verification and crystal defects . . . . .	407	587
6.2.3.2 Electrical properties . . . . .	408	587 ff.
6.2.3.3 Luminescence . . . . .	408	588
<b>6.2.4 Devices technology . . . . .</b>	<b>408</b>	<b>588 ff.</b>
6.2.4.0 Introductory remarks . . . . .	408	588 ff.
6.2.4.0.1 General processing steps . . . . .	408	-
6.2.4.0.2 Diode-(rectifier)-fabrication . . . . .	409	588
6.2.4.0.3 Field-effect transistor fabrication . . . . .	409	589
6.2.4.0.4 Light-emitting diode fabrication . . . . .	409	589
6.2.4.1 Diffusion . . . . .	410	589 ff.
6.2.4.2 Ion implantation . . . . .	410	590
6.2.4.3 Epitaxy . . . . .	411	590 ff.

	Data	Figures
6.2.4.3.1 Vapour-phase epitaxy (VPE) . . . . .	411	590ff.
6.2.4.3.2 Liquid-phase epitaxy (LPE) . . . . .	412	591
6.2.4.4 Thermal oxidation . . . . .	412	591 ff.
6.2.4.5 Surface preparation . . . . .	413	592
6.2.4.5.0 Introductory remarks. . . . .	413	592
6.2.4.5.1 Gaseous etching . . . . .	413	592
6.2.4.5.2 Molten salt etching. . . . .	414	592
6.2.4.5.3 Electrolytic etching. . . . .	414	-
6.2.4.6 Contact fabrication . . . . .	414	-
References for 6.2 . . . . .	415	-