
Contents

1 Materials Science and Engineering of Bulk Silicon Carbides	
<i>T. Sudarshan</i>	1
1.1 Introduction	1
1.2 Historical Perspective	2
1.2.1 Construction Materials	5
1.2.2 Growth of SiC from Solution	6
1.2.3 First Demonstration of Single Crystal SiC Ingot or Boule Growth.....	7
1.3 Fundamental Physics and Chemistry Issues Related to Bulk Crystal Growth	8
1.3.1 Source Material and Vapor Composition	8
1.3.2 Mechanism of Growth	10
1.3.3 Seed Surface Effects	14
1.3.4 Polytype Control	14
1.3.5 Bulk Crystal Doping	16
1.4 Theoretical Considerations and Influence of Independent Parameters on Growth Rate	17
1.4.1 Theoretical Considerations Relevant to Growth	17
Supersaturation	17
Mass Transport Process	18
Kinetic Processes	22
Thermal Stresses in the Growing Boule and Defect Initiation	23
1.4.2 Crystal Growth Rate: Influence of Independent Parameters	24
Influence of Temperature on the Growth Rate	25
Source-to-Seed Distance	25
Growth Pressure.....	26
Temperature Gradient	27
1.5 Defect Generation Processes in Silicon Carbide Crystal Growth ..	28
1.5.1 Micropipe Generation	28
1.5.2 Planar Defects	30
1.5.3 Inclusions, Dendrites, and Polytype Inclusions	31

VIII Contents

1.6	Development of Industrial Production of SiC Wafers and Current Status	32
1.6.1	Early Stage Developments	33
1.6.2	Intermediate Stage Development	34
1.6.3	Recent Developments and Current Status of SiC Wafers ..	36
1.6.4	Bulk Crystal Growth of Semi-Insulating SiC	37
1.6.5	SiC Bulk Crystal Growth with p-Type Doping.....	39
1.7	Evaluation and Characterization of SiC Wafers	42
1.7.1	Material Evaluation	42
1.7.2	Defect Characterization	44
1.7.3	Evaluation of Crystalline Quality by Chemical Etching: Destructive Method	47
1.8	Market and Application Needs and Future Prospects	52
	Acknowledgements	55
	References	56

2 Fundamental Properties of SiC: Crystal Structure, Bonding Energy, Band Structure, and Lattice Vibrations

J. Dong, A.-B. Chen	63	
2.1	Introduction	63
2.2	Crystal Structure and Bonding Energy	64
2.3	Electronic Band Structure	70
2.4	Lattice Vibration	75
2.5	Conclusion.....	83
	Acknowledgements	83
	References	83

3 Sublimation Growth of SiC Single Crystals

N. Ohtani, T. Fujimoto, M. Katsuno, H. Yashiro	89	
3.1	Introduction	89
3.2	Polytypism of SiC	91
3.3	Sublimation Growth of SiC	94
3.4	Crystal Diameter Enlargement	96
3.5	Reduction of Micropipe Defects	98
3.6	Improved Mosaicity of Bulk SiC Crystals	104
3.7	SiC Bulk Crystal Growth in Directions Perpendicular to the <i>c</i> -Axis	109
3.8	Summary	116
	Acknowledgements	117
	References	117

4 Crystal Growth of Silicon Carbide: Evaluation and Modeling

E. Pernot, M. Pons, R. Madar	123	
4.1	Introduction	123
4.2	History of Crystal Growth	124

4.3	Modeling and Simulation of the Growth Procedure	126
4.3.1	Introduction	126
4.3.2	Modeling and Databases	127
	Thermodynamic Modeling	127
	Gas and Surface Chemistry	128
	Induction Heating and Temperature Distribution	128
	Multicomponent Fluid Transport	129
4.3.3	Selected Results for Heat Transfer	129
	A General Overview of the Simulation Results	129
	Heat Transfer: Influence of the Diameter of the Pyrometric Holes	131
	Heat Transfer: Influence of the Growing Crystal	133
	Heat Transfer and the Scaling Up of the Reactor	133
4.4	Crystal Evaluation Methods	134
4.4.1	Optical Microscopy	134
	The Polarized-Light Technique	134
	The Rotating-Polarizer Technique	134
4.4.2	X-Ray Diffraction Imaging (Also Called Topography)	135
	Investigation of Ingots	136
	Investigation of Wafers	137
4.4.3	Raman Spectroscopy Imaging	138
4.4.4	Some Conclusions	138
4.5	Results of Modeling and Characterization	138
4.5.1	Introduction	138
4.5.2	Multicomponent Mass Transport and Crystal Growth Rate	139
	Evaluation of Mass Transfer	139
	Geometry Modification and Crystal Shape	140
4.5.3	Ingots Evaluation	140
	Surface Polarity and Polytype	141
	Enlargement Process	142
	Growth of the Polycrystal and Cracks	143
	Defect Propagation	144
4.5.4	Wafer Evaluation	147
	Relations Between Defects and Macroscopic Modeling	147
	Density of Dislocations and Micropipes	151
4.5.5	Evaluation of Stress Patterns	152
	Birefringence Imaging	153
	Raman Imaging	154
	Model Development	155
4.6	Conclusions	156
	References	157

5 Lattice Dynamics of Defects and Thermal Properties of 3C-SiC	
<i>D.N. Talwar</i>	161
5.1 Introduction	161
5.1.1 Polymorphic Forms of SiC	162
5.1.2 Issues Related to Defects and Polytypism	162
5.1.3 Structural and Dynamical Properties of 3C-SiC	163
5.2 Theoretical Background	165
5.2.1 Atomic Configuration of Defects	166
5.2.2 Geometrical Configuration of Defects	167
5.2.3 Lattice Relaxation and Distortion	171
5.3 Lattice Dynamical Models	172
5.3.1 The Second-Neighbor Rigid-Ion Model	173
5.3.2 The Phonon-Model Parameters	176
5.3.3 Pressure Dependent and Thermo-Dynamical Properties ..	176
5.4 The Green's Function Method	177
5.4.1 The Lattice Green's Function	178
5.4.2 The Impurity Green's Function	178
5.4.3 Impurity Perturbation	179
Substitutional Defects	180
Complex Defect Centers	181
Interstitial Defect Centers	183
Lattice Distortion	183
5.5 Numerical Computations and Results	183
5.5.1 Dynamical Properties of Perfect 3C-SiC	184
5.5.2 Debye Temperature, Mode Grüneisen Parameters and Thermal Expansion	187
5.5.3 Dynamical Properties of Defects in 3C-SiC	190
Isolated Single Substitutional Defect	191
Dynamical Properties of Pair and Complex Defects in 3C-SiC	194
5.6 Summary and Conclusion	198
Acknowledgments	201
References	202
6 Optical and Interdisciplinary Analysis of Cubic SiC Grown on Si by Chemical Vapor Deposition	
<i>Z.C. Feng</i>	209
6.1 Introduction	209
6.2 Experiment	211
6.2.1 Sample Growth	211
6.2.2 Materials Analysis Techniques	212
6.2.3 Absorption Coefficients	212
6.3 General Materials Characterization of 3C-SiC	213
6.3.1 X-ray Diffraction	213

6.3.2	Photoluminescence	214
6.3.3	Raman Scattering	216
6.3.4	UV–Vis Optical Spectroscopy	217
6.3.5	Infrared Transmission and Reflectance	217
6.4	Surface Science and Nuclear-Physics Analysis	219
6.4.1	X-Ray Photoelectron Spectroscopy	219
6.4.2	Secondary-Ion Mass Spectrometry	221
6.4.3	Rutherford Backscattering	222
6.4.4	Ion Channeling	223
6.5	Theoretical Aspects of Layer Stress and Strain in 3C-SiC/Si	223
6.5.1	Generalized Axial Stress and Strain	223
	Stress Tensor	223
	Strain Tensor	224
	Conversion Between S_{ij} and C_{ij}	225
	Poisson Ratio	225
	Volume Dilation	226
6.5.2	Axial-Stress-Induced Raman Shifts	226
	Secular Equation	226
	Raman Optical-Phonon Frequencies from Axial Strains	227
	Raman Stress Coefficients η_S and η_H	227
	Mode Grüneisen Parameter	228
	General Raman Stress Coefficients η	228
	LO–TO Phonon Splitting	228
6.5.3	Axial-Strain-Induced Energy Gap Variations	230
	Strain Hamiltonian	230
	Axial-Strain Hamiltonian	230
	Energy Band Splitting	231
6.6	Raman Analysis of the 3C-SiC/Si Structure	232
6.6.1	Evaluation of Raman Stress Coefficients and Elastic Constants of 3C-SiC	232
6.6.2	Raman Determination of Stress and Strain in 3C-SiC/Si	233
6.6.3	Active Raman Studies of 3C-SiC/Si	235
6.6.4	Raman Mode Intensity Variation of 3C-SiC with and Without Si Substrate	236
	Raman Selection Rule for 3C-SiC/Si	237
	Selection Rule Broken	238
	Enhancements of Si and SiC Raman Signals	238
	Multiple Reflections and Forward Scattering	239
6.6.5	Raman Cross Section of 3C-SiC	241
	The Variation of Raman Signal Strength with Excitation Intensity	241
	A Simple Experimental Determination of the Raman Cross Section	242
6.6.6	Raman Defect Modes	242
6.6.7	Second-Order Raman Scattering of 3C-SiC	244

XII Contents

6.7	Penetrative Luminescence Analysis	246
6.7.1	Effects of a Tensile Biaxial Stress on Bound-Exciton Transitions	246
	Shifts of N-BE Lines	246
	Layer Stress and Deformation Potentials	247
	Influence of Spin-Orbit Splitting on the Energy Gap Shift	248
	Effects on the BE Line Intensities	250
6.7.2	Crystallinity Dependent Luminescence Characteristics and Defect Bands	250
	TEM and Defect W-band at 2.15 eV	251
	Intensity Ratio ρ – a Figure of Merit of Film Quality	251
	Spectral Comparison of Luminescence from 3C-SiC Films with and Without Si Substrate	252
	D _I Line at 1.972 eV	252
	Dislocation- and Extended-Defect-Related G Band	254
6.7.3	Photoluminescence Excitation, Time-Resolved, and Infrared Transmission Studies	256
6.7.4	Bound Electronic States of Isolated Single and Paired Native Defects	258
	Native Defects and DLTS Results	258
	Tight-Binding Calculation in the Framework of the Green's Function	259
	Other Theoretical Calculations	259
	Interpretation of PL and DLTS Data on Native Defect Centers	260
	Sharp 1.913 eV PL Line from Electron-Irradiated 3C-SiC .	261
6.8	Infrared Reflectance Spectroscopy Analysis	261
6.8.1	Basic Theoretical Model	261
6.8.2	Effect of Surface Roughness	263
6.8.3	Damping of Interference Fringes	264
6.9	Additional Issues	264
6.9.1	Combined PL-Raman Spectroscopy under UV Excitation .	264
6.9.2	Large-Diameter Thick 3C-SiC Epitaxially Grown on Si .	265
6.9.3	Epitaxial Lateral Overgrowth of 3C-SiC on Si	266
6.9.4	Excellent Reviews of Materials Characterization of SiC .	267
6.10	Conclusion	267
	Acknowledgments	268
	References	268
7	Electron Paramagnetic Resonance Characterization of SiC	
<i>M.E. Zvanut</i>	277
7.1	Introduction	277
7.1.1	The Technique	278
7.1.2	Collaborative Techniques	283

7.2	Intrinsic Defects	285
7.2.1	As-Grown SiC	285
7.2.2	Implantation-Induced Defects	291
7.3	Impurity-Related Defects	293
7.3.1	Shallow Impurities	293
7.3.2	Transition Metal Impurities: Vanadium and Other Elements	296
7.4	Concluding Comments	298
	References	299

8 Material Selection and Interfacial Reaction in Ohmic-Contact Formation on SiC

<i>W. Lu, W.E. Collins, W.C. Mitchel</i>	303	
8.1	Introduction	303
8.2	Classical Theory and the Critical Factors in Ohmic Contact Formation on SiC	304
8.3	Interfacial Reactions of Ohmic Contact Metals on SiC	307
8.3.1	Silicides and Carbon in Metal/SiC	307
8.3.2	Silicides and Carbides in Metal/SiC	312
8.3.3	Silicon and Carbides in Al/SiC and Al-Alloy/SiC	315
8.4	Compounds Used for Ohmic Contacts	319
8.4.1	Silicides	319
8.4.2	Carbides	320
8.4.3	Nitrides	321
8.4.4	Borides	322
8.4.5	Composite Structures	322
8.5	Recent Advances and Challenging Issues	324
8.5.1	Toward Understanding in the Ohmic Contact Mechanism	324
8.5.2	Catalytic Graphitization Effects of Metals	326
8.5.3	Structural Characterizations at Atomic and Nanometer Scales	335
8.5.4	Thermal Stability	336
8.6	Conclusion	338
	Acknowledgments	338
	References	338

9 Oxidation, MOS Capacitors, and MOSFETs

<i>S. Dimitrijev, H.B. Harrison, P. Tanner, K.Y. Cheong, J. Han</i>	345	
9.1	Introduction	345
9.2	Gate Oxides on SiC	346
9.2.1	Gate Dielectric Requirements	347
9.2.2	Interface and Near-Interface Traps	348
9.2.3	Electrical Characterization of SiO ₂ -SiC Interfaces	350
	Terman's High-Frequency Capacitance-Voltage (HF C-V) Technique	350

Simultaneous High-Low Capacitance-Voltage (Hi-Lo $C-V$) Technique	350
AC Conductance Technique	351
Room Temperature Photo- CV Technique	351
Hall Effect Technique	353
MOSFET Subthreshold Current Technique.....	353
Other Techniques	355
9.2.4 Electrical Characterization of Defects	
Near the $\text{SiO}_2\text{-SiC}$ Interface	355
Low-Temperature CV Technique	355
Slow-Trap Profiling Technique	356
9.2.5 Processing Techniques for Improvement of Interface Quality	356
9.3 Nitrided Gate Oxides	358
9.3.1 Effects of Nitrogen at the $\text{SiO}_2\text{-SiC}$ Interface	358
9.3.2 Physical Characteristics of Nitrided $\text{SiO}_2\text{-SiC}$ Interfaces ..	358
9.3.3 Electrical Characteristics of MOS Capacitors with Nitrided Gate Oxides	360
9.3.4 Channel-Carrier Mobility in MOSFETs with Nitrided Gate Oxides	361
9.4 Power MOSFETs	365
9.4.1 Device Structures	366
9.4.2 Performance of Power SiC MOSFETs	367
References	368
10 4H-SiC Power-Switching Devices for Extreme-Environment Applications	
<i>Z. Luo, T. Chen, D.C. Sheridan, J.D. Cressler</i>	375
10.1 Introduction	375
10.1.1 Fundamentals of Power Schottky Barrier Diodes	376
10.1.2 The Fundamentals of Radiation	378
10.2 SiC Power Diode Structures.....	379
10.2.1 SBD, pn and JBS diodes.....	379
10.2.2 Edge Termination for Power Diodes	380
Edge Termination Techniques	381
Guard Ring (GR) Structure Optimization.....	383
10.3 Device Fabrication	384
10.3.1 Fabrication of SBD/JBS Diodes with Guard Ring Termination	384
10.3.2 Fabrication of SiC MOS Capacitors	385
10.4 Radiation Effects in SiC Power Switching Diodes and Capacitors .	386
10.4.1 SiC SBD Under Gamma Irradiation	387
10.4.2 Gamma Irradiation of SiC MOS Capacitors	389

10.4.3 SiC SBD/JBS Diodes Under Proton Irradiation	398
DC Performance Under Proton Irradiation	399
AC Performance Under Proton Irradiation	404
10.5 Summary	407
Acknowledgments	408
References	408
11 SiC Nuclear-Radiation Detectors	
<i>N.B. Strokan, A.M. Ivanov, A.A. Lebedev</i>	411
11.1 Introduction	411
11.2 Detector Material Properties	412
11.3 Detection of Short-Range Particles	413
11.3.1 Measurement of SiC Detectors	413
11.3.2 Determining the Average Energy per Electron–Hole Pair ..	415
11.3.3 Determining the Hole Diffusion Length	415
11.3.4 Shape of Amplitude Spectrum for Diffusion and Its Relationship to the Hole Lifetime τ	417
Calculation of the Spectrum Shape	417
Experiment	419
11.3.5 Drift Transport and Carrier Capture Times	419
Calculation	419
Experiment	422
Conclusion	422
11.4 Spectrometry of X-Ray Radiation	423
11.5 Response of SiC Detectors to Electron and Photon Irradiation ..	425
11.6 SiC Detectors for High-Energy Physics Experiments	426
11.7 Operation of SiC Detectors in a Reactor Channel	427
11.8 Radiation Hardness of the SiC Detectors	429
11.8.1 Introduction	429
11.8.2 Experimental Procedure	430
11.8.3 Experimental Results	431
11.8.4 Estimation of the Drift Parameters	435
11.9 Signal Amplification	436
11.9.1 Principle of “Through-Conducting Channel”	436
11.9.2 Amplification in a Triode Structure	437
Experimental Results	438
Phototransistor Model	440
Conclusion	441
11.10 Summary	442
References	442
Index	447