Contents

Volume 1

Preface *xiii*

Part I Silicon Carbide (SiC) *1*

1 **Dislocation Formation During Physical Vapor Transport Growth of 4H-SiC Crystals** *3*
Noboru Ohtani

2 **Industrial Perspectives of SiC Bulk Growth** *33*
Adrian R. Powell

3 **Homoepitaxial Growth of 4H-SiC on Vicinal Substrates** *47*
Birgit Kallinger

4 **Industrial Perspective of SiC Epitaxy** *75*
Albert A. Burk, Jr., Michael J. O'Loughlin, Denis Tsvetkov, and Scott Ustin

5 **Status of 3C-SiC Growth and Device Technology** *93*
Peter Wellmann, Michael Schöler, Philipp Schuh, Mike Jennings, Fan Li, Roberta Nipoti, Andrea Severino, Ruggero Anzalone, Fabrizio Roccaforte, Massimo Zimbone, and Francesco La Via

6 **Intrinsic and Extrinsic Electrically Active Point Defects in SiC** *137*
Ulrike Grossner, Joachim K. Grillenberger, Judith Woerle, Marianne E. Bathen, and Johanna Müting

7 **Dislocations in 4H-SiC Substrates and Epilayers** *169*
Balaji Raghothamachar and Michael Dudley

8 **Novel Theoretical Approaches for Understanding and Predicting Dislocation Evolution and Propagation** *199*
Binh Duong Nguyen and Stefan Sandfeld

9 **Gate Dielectrics for 4H-SiC Power Switches: Understanding the Structure and Effects of Electrically Active Point Defects at the 4H-SiC/SiO_2 Interface** *225*
Gregor Pobegen and Thomas Aichinger

10 **Epitaxial Graphene on Silicon Carbide as a Tailorable Metal–Semiconductor Interface** *249*
Michael Krieger and Heiko B. Weber

11 **Device Processing Chain and Processing SiC in a Foundry Environment** *271*
Arash Salemi, Minseok Kang, Woongje Sung, and Anant K. Agarwal

12 **Unipolar Device in SiC: Diodes and MOSFETs** *319*
Sei-Hyung Ryu

Volume 2

13 **Ultra-High-Voltage SiC Power Device** *353*
Yoshiyuki Yonezawa and Koji Nakayama
13.1 Introduction *353*
13.2 Ultra-high-voltage SiC PiN diode and SiC-IGBT *355*
13.3 Reverse Characteristics of SiC Bipolar Device *356*
13.3.1 Relationship Between Thickness and Density of Drift Layer and Breakdown Voltage *356*
13.3.2 Termination Structure of SiC Bipolar Devices *357*
13.4 Carrier Lifetime Dependence on the Characteristics of Bipolar Device *358*
13.4.1 Forward Characteristics of pn Diode *360*
13.4.1.1 Analysis of Characteristics Under Low-Level Injection *360*
13.4.1.2 Analysis of Carriers in the Drift Layer Under High-Level Injection *362*
13.4.1.3 Relationship Between Carrier Life, Drift Layer Thickness, and Drift Layer Voltage Drop *363*
13.4.2 Reverse Characteristics of pn Diode *365*

13.4.2.1 Reverse Leakage Current Characteristics *365*
13.4.3 Dynamic Characteristics of pn Diode *365*
13.4.3.1 Reverse and Forward Recovery of Characteristics *365*
13.4.3.2 Open-Circuit Voltage Decay *366*
13.4.3.3 Comparison of Reverse and Forward Recovery Characteristics and OCVD *368*
13.5 Design and Device Performance of Bipolar Device *370*
13.5.1 Carrier lifetime dependence *371*
13.5.2 Loss Estimation of Bipolar Device *373*
13.6 Current Status of SiC Bipolar Device *377*
13.6.1 Device Performance of 16 kV Class SiC-IGBT *378*
13.6.2 Device Characteristics of higher-than-20 kV Class SiC-IGBT *382*
13.6.3 Other Bipolar Devices Issues *383*
References *384*

14 SiC Reliability Aspects *387*
Josef Lutz and Thomas Basler
14.1 Ruggedness and Overload Events *387*
14.1.1 Short-circuit Ruggedness of SiC MOSFETs *387*
14.1.2 Surge-current Ruggedness *394*
14.1.3 Avalanche Capability *403*
14.2 Cosmic-Ray Stability *412*
14.3 Thermomechanical Reliability *414*
14.3.1 Temperature-sensitive Electrical Parameters *416*
14.3.2 Execution of Power-cycling Tests *419*
14.3.3 Evaluation of SiC Power-cycling Tests *421*
14.4 New Power-module Technologies with Sufficient Reliability *422*
14.4.1 Improved Die-attach Technologies *422*
14.4.2 Improved Top-Side Interconnections *424*
Acknowledgments *426*
References *426*

15 Industrial Systems Using SiC Power Devices *433*
Nando Kaminski
15.1 Introduction *433*
15.1.1 Benefits of SiC Devices *433*
15.1.2 Competition by Other Technologies *436*
15.2 DC/DC Converters *437*
15.3 Solid-State Transformer (SST) *443*
15.3.1 Traction *443*
15.3.2 Power Grid *444*
15.4 Wireless Charging *445*

15.5 Inductive Heating *446*
15.5.1 Domestic Systems *446*
15.5.2 Industrial Systems *446*
15.6 Photovoltaic *447*
15.6.1 Residential Systems *447*
15.6.2 Commercial, Industrial, and Utility Size Systems *449*
15.7 DC Grids *451*
15.7.1 Low- and Medium-Voltage DC Grids *451*
15.7.2 DC Breakers *452*
15.8 High-Voltage DC (HVDC) *452*
15.8.1 HVDC Transmission *452*
15.8.2 HVDC Breakers *454*
15.9 Drives *455*
15.9.1 Industrial Drives *455*
15.9.2 Wind Energy *457*
15.9.3 Traction *458*
15.10 Conclusions *459*
Acknowledgements *460*
References *460*

16 Special Focus on HEV and EV Applications: Activities of Automotive Industries Applying SiC Devices for Automotive Applications *467*
Kimimori Hamada, Keiji Toda, Hiromichi Nakamura, Shigeharu Yamagami, and Kazuhiro Tsuruta
16.1 Background (PDPlus LLC) *467*
16.2 The Challenge of SiC Power Devices Introductions on Prototype HEVs and FCVs (TOYOTA MOTOR CORPORATION) *469*
16.2.1 Progress of Electrification *469*
16.2.2 Demonstration of Electrified Vehicles *470*
16.3 Introduction of Boost Converter Using SiC Semiconductor for New FCV Drive (HONDA MOTOR CO., LTD.) *472*
16.3.1 Introduction *472*
16.3.2 Configuration of the Electric Power Plant System for New FCV *472*
16.3.3 FCVCU *473*
16.3.3.1 Circuit Configuration *473*
16.3.3.2 Full SiC-IPM *473*
16.3.3.3 Magnetic Coupling and Interleave Operation *474*
16.3.3.4 Control Methods *475*
16.3.3.5 Effects on Smaller Size and Higher Efficiency *477*
16.3.3.6 Quietness *478*
16.3.3.7 Noise Countermeasures *478*

16.3.3.8 Structure of the FCVCU *479*
16.3.4 Conclusions *480*
16.4 Development of Module Technologies to Bring Out SiC Power Device Performances (TOYOTA MOTOR CORPORATION) *481*
16.4.1 Power Card Structure for Double-Side Cooling Technology *481*
16.4.2 New Transient Liquid Phase Structure for High-Temperature Applications *481*
16.4.3 Ni Micro-Plating Bonding *483*
16.5 SiC-MOSFET Switching Characteristics and Gate Driver Circuits for Automotive Application (NISSAN MOTOR CO., LTD.) *485*
16.5.1 Introduction *485*
16.5.2 Basics of Switching Characteristics *485*
16.5.3 Various Gate Driver Circuits *487*
16.5.4 Conclusion *489*
16.6 R&D of SiC Power Devices for Automotive Applications (DENSO CORPORATION) *489*
16.6.1 Introduction *489*
16.6.2 Ultra-Low-Loss SiC-MOSFET for Cost Reduction *491*
16.6.3 Proposed 4H-SiC Trench MOSFET Structure *491*
16.6.4 Characteristics of the Developed MOSFET *494*
16.6.4.1 Static Characteristics of the Optimized Structure *494*
16.6.4.2 Dynamic Behavior of the Optimized Structure *495*
16.6.5 Measurements of Reliability *497*
16.6.6 Suppression of Bipolar Degradation in the Presented MOSFETs [30] *497*
16.6.7 Summary *500*
Acknowledgments *500*
References *501*

17 Point Defects in Silicon Carbide for Quantum Technology *503*
András Csóré and Adam Gali
17.1 Introduction *503*
17.2 Silicon Carbide: Polytypes and Types of Relevant Point Defects *504*
17.3 Point Defect Single Photon Sources and Quantum Bits *507*
17.3.1 Divacancy *508*
17.3.2 Si-vacancy *510*
17.3.3 Carbon Antisite–Vacancy Pair *513*
17.3.4 Nitrogen-Vacancy Pair *514*
17.3.5 Other Defects *515*
17.4 Conclusion *517*
Acknowledgments *518*
References *518*

Part II Gallium Nitride (GaN), Diamond, and Ga_2O_3 *529*

18 Ammonothermal and HVPE Bulk Growth of GaN *531*
Robert Kucharski, Tomasz Sochacki, Boleslaw Lucznik, Mikolaj Amilusik, Karolina Grabianska, Malgorzata Iwinska, and Michal Bockowski
18.1 Introduction *531*
18.2 HVPE Method – History and State of the Art *533*
18.3 Ammonothermal Method – History and State of the Art *536*
18.4 HVPE-GaN-on-Ammono-GaN – State of the Art *542*
18.4.1 Bulk Growth – Challenges *543*
18.4.2 Doping *546*
18.4.2.1 Doping with Donors *546*
18.4.2.2 Doping with Acceptors *549*
18.5 Summary *550*
Acknowledgments *551*
References *551*

19 GaN on Si: Epitaxy and Devices *555*
Hidekazu Umeda
19.1 Introduction *555*
19.2 GaN Epitaxy on Si Substrate *556*
19.2.1 GaN Epitaxial Method and Doping *556*
19.2.1.1 Metal–Organic Chemical Vapor Deposition (MOCVD) *556*
19.2.1.2 N, P-Type Doping *556*
19.2.1.3 Doping for Semi-insulation Layer *557*
19.2.2 Substrates for GaN Epitaxy *557*
19.2.2.1 GaN *557*
19.2.2.2 Sapphire *558*
19.2.2.3 SiC *558*
19.2.2.4 Si *559*
19.2.3 Epitaxial Growth Technology on Si Substrate *559*
19.2.3.1 Crystal Orientation of Si Substrate *559*
19.2.3.2 Nucleation Layer *559*
19.2.3.3 Buffer Layer *560*
19.2.3.4 AlGaN/GaN Active Layer with Polarization Effect *561*
19.3 Lateral GaN Devices on Si Substrate *564*
19.3.1 Device Structure and Fabrication Process *564*
19.3.2 Structures for E-Mode Operation *566*
19.3.3 E-Mode GaN Gate-Injection Transistor (GIT) on Si Substrate *567*
19.3.3.1 Device Structure and Operational Principle *567*
19.3.3.2 DC Performance of GIT *568*
19.3.3.3 Switching Performance of GIT *570*

19.4 Application of GaN HFET *571*
19.5 Integration of Lateral GaN Devices *573*
19.6 Summary *576*
Acknowledgments *577*
References *577*

20 Growth of Single Crystal Diamond Wafers for Future Device Applications *583*
Matthias Schreck
20.1 Introduction *583*
20.2 High-Pressure High-Temperature (HPHT) Synthesis *584*
20.2.1 Basic Concepts and Technical Realizations *584*
20.2.2 The Temperature Gradient Method *586*
20.2.3 Chemical Purity and Classification *587*
20.2.4 Morphology and Structural Quality *588*
20.2.5 State of the Art in Crystal Size *589*
20.2.6 Boron Doping *590*
20.3 Chemical Vapor Deposition (CVD) *591*
20.3.1 Basic Principles *591*
20.3.1.1 The Mechanism of Diamond Growth by CVD *591*
20.3.1.2 Gas Mixtures for Diamond CVD *593*
20.3.1.3 The Role of Trace Gases *594*
20.3.1.4 Experimental Setups *595*
20.3.1.5 Growth Rate and Gas Temperature *598*
20.3.1.6 Nucleation by Seeding *599*
20.3.1.7 Bias-Enhanced Nucleation (BEN) *599*
20.3.2 Examples of Polycrystalline CVD Diamond Layers *601*
20.3.3 CVD Growth of Single Crystals *602*
20.3.4 Homoepitaxy *603*
20.3.4.1 Homoepitaxial Growth on Different Crystals Faces *603*
20.3.4.2 Single Crystal Seed Recovery *604*
20.3.4.3 Size Increase and Mosaic Growth *605*
20.3.5 Heteroepitaxy *605*
20.3.5.1 Growth Substrates for Heteroepitaxy *605*
20.3.5.2 Bias-Enhanced Nucleation on Iridium: Phenomenology and Mechanism *607*
20.3.5.3 Structural Improvement with Film Thickness *609*
20.3.5.4 Multilayer Substrates for Scaling to Wafer Size *611*
20.3.5.5 The State of the Art in Scaling and Mosaic Spread *613*
20.3.5.6 Intrinsic Stress and Its Correlation with Dislocations *614*
20.3.5.7 Heteroepitaxy on (111)-Oriented Substrates *614*
20.3.5.8 The Microneedle Approach *615*

20.3.6 Advanced Concepts for Structural Improvement *617*
20.3.6.1 Epitaxial Lateral Overgrowth *617*
20.3.6.2 Dislocation Stopping by W or Ta Atoms *618*
20.4 State of the Art and Outlook *619*
Acknowledgments *619*
References *619*

21 Diamond Wafer Technology, Epitaxial Growth, and Device Processing *633*
Hideaki Yamada, Hiromitsu Kato, Shinya Ohmagari, and Hitoshi Umezawa
21.1 Diamond Epitaxial Growth and Wafers *633*
21.2 n-Type Doping and Processing *638*
21.3 p-Type Doping and Processing *642*
21.4 Devices *645*
References *650*

22 Gallium Oxide: Material Properties and Devices *659*
Masataka Higashiwaki
22.1 Introduction *659*
22.2 Physical Properties of Ga_2O_3 *660*
22.2.1 Polymorphs *660*
22.2.2 Material Properties of β-Ga_2O_3 *660*
22.3 Melt Bulk Growth *662*
22.4 Epitaxial Growth *662*
22.4.1 MBE *663*
22.4.2 HVPE *664*
22.4.3 MOCVD *664*
22.4.4 Mist CVD *665*
22.5 Vertical Diodes *665*
22.5.1 SBD with HVPE-Grown Drift Layer *665*
22.5.2 Field-Plated SBD *666*
22.5.3 Field-Plated SBD with Guard Ring Formed by Nitrogen-Ion Implantation *666*
22.5.4 Trench SBD *667*
22.5.5 α-Ga_2O_3 SBD *667*
22.5.6 Heterojunction p-Amorphous Oxide/n-Ga_2O_3 Diode *668*
22.6 Lateral FETs *668*
22.6.1 MESFET *668*
22.6.2 Depletion-Mode MOSFET *669*
22.6.3 Field-Plated MOSFET *671*
22.6.4 Modulation-Doped FET *671*
22.6.5 Normally Off FET *672*

22.7 Vertical FETs *672*
22.7.1 Current Aperture FET *673*
22.7.2 Fin Channel FET *673*
22.8 Summary *674*
References *674*

Index *681*

Contents

Volume 1

Preface *xiii*

Part I Silicon Carbide (SiC) *1*

1 Dislocation Formation During Physical Vapor Transport Growth of 4H-SiC Crystals *3*
Noboru Ohtani
1.1 Introduction *3*
1.2 Formation of Basal Plane Dislocations During PVT Growth of 4H-SiC Crystals *5*
1.2.1 Plan-View X-ray Topography Observations of Growth Front *5*
1.2.2 Cross-Sectional X-ray Topography Observations of Growth Front *9*
1.2.3 Characteristic BPD Distribution in PVT-Grown 4H-SiC Crystals *13*
1.2.4 BPD Multiplication During PVT Growth *15*
1.3 Dislocation Formation During Initial Stage of PVT Growth of 4H-SiC Crystals *18*
1.3.1 Preparation of 4H-SiC Wafers with Beveled Interface Between Grown Crystal and Seed Crystal *18*
1.3.2 Determination of Grown-Crystal/Seed Interface by Raman Microscopy *19*
1.3.3 X-ray Topography Observations of Dislocation Structure at Grown-Crystal/Seed Interface *22*
1.3.4 Formation Mechanism of BPD Networks and Their Migration into Seed Crystal *23*
1.4 Conclusions *28*
References *30*

2 Industrial Perspectives of SiC Bulk Growth *33*
Adrian R. Powell
2.1 Introduction *33*

2.2 SiC Substrates for GaN LEDs *33*
2.3 SiC Substrates for Power SiC Devices *34*
2.4 SiC Substrates for High-Frequency Devices *35*
2.5 Cost Considerations for Commercial Production of SiC *35*
2.6 Raw Materials *36*
2.7 Reactor Hot Zone *37*
2.8 System Equipment *39*
2.9 Yield *39*
2.10 Turning Boules into Wafers *41*
2.11 Crystal Grind *41*
2.12 Wafer Slicing *42*
2.13 Wafer Polish *44*
2.14 Summary *44*
Acknowledgments *45*
References *45*

3 Homoepitaxial Growth of 4H-SiC on Vicinal Substrates *47*
Birgit Kallinger
3.1 Introduction *47*
3.2 Fundamentals of 4H-SiC Homoepitaxy for Power Electronic Devices *47*
3.2.1 4H-SiC Polytype Replication for Homoepitaxial Growth on Vicinal Substrates *48*
3.2.2 Homoepitaxial Growth by Chemical Vapor Deposition (CVD) Process *52*
3.2.3 Doping in Homoepitaxial Growth *53*
3.3 Extended Defects in Homoepitaxial Layers *55*
3.3.1 Classification of Extended Defects According to Glide Systems in 4H-SiC *56*
3.3.2 Dislocation Reactions During Epitaxial Growth *57*
3.3.3 Characterization Methods for Extended Defects in 4H-SiC Epilayers *59*
3.4 Point Defects and Carrier Lifetime in Epilayers *62*
3.4.1 Classification and General Properties of Point Defects in 4H-SiC *62*
3.4.2 Basics on Recombination Carrier Lifetime in 4H-SiC *64*
3.4.3 Carrier Lifetime-Affecting Point Defects *65*
3.4.4 Carrier Lifetime Measurement in Epiwafers and Devices *68*
3.5 Conclusion *69*
Acknowledgments *70*
References *70*

4 Industrial Perspective of SiC Epitaxy *75*
Albert A. Burk, Jr., Michael J. O'Loughlin, Denis Tsvetkov, and Scott Ustin
4.1 Introduction *75*
4.2 Background *76*
4.3 The Basics of SiC Epitaxy *76*
4.4 SiC Epi Historical Origins *78*
4.5 Planetary Multi-wafer Epitaxial Reactor Design Considerations *80*

4.5.1 Rapidly Rotating Reactors *81*
4.5.2 Horizontal Hot-Wall Reactors *82*
4.6 Latest High-Throughput Epitaxial Reactor Status *82*
4.7 Benefits and Challenges for Increasing Growth Rate in all Reactors *86*
4.8 Increasing Wafer Diameters, Device Processing Considerations, and Projections *86*
4.9 Summary *89*
Acknowledgment *90*
References *90*

5 Status of 3C-SiC Growth and Device Technology *93*
Peter Wellmann, Michael Schöler, Philipp Schuh, Mike Jennings, Fan Li, Roberta Nipoti, Andrea Severino, Ruggero Anzalone, Fabrizio Roccaforte, Massimo Zimbone, and Francesco La Via
5.1 Introduction, Motivation, Short Review on 3C-SiC *93*
5.2 Nucleation and Epitaxial Growth of 3C-SC on Si *95*
5.2.1 Growth Process *95*
5.2.2 Defects *98*
5.2.3 Stress *102*
5.3 Bulk Growth of 3C-SiC *103*
5.3.1 Sublimation Growth of (111)-oriented 3C-SiC on Hexagonal SiC Substrates *104*
5.3.2 Sublimation Growth of 3C-SiC on 3C-SiC CVD Seeding Layers *105*
5.3.3 Continuous Fast CVD Growth of 3C-SiC on 3C-SiC CVD Seeding Layers *110*
5.4 Processing and Testing of 3C-SiC Based Power Electronic Devices *117*
5.4.1 Prospects for 3C-SiC Power Electronic Devices *117*
5.4.2 3C-SiC Device Processing *117*
5.4.3 MOS Processing *118*
5.4.4 3C-SiC/SiO_2 Interface Passivation *120*
5.4.5 Surface Morphology Effects on 3C-SiC Thermal Oxidation *121*
5.4.6 Thermal Oxidation Temperature Effects for 3C-SiC *122*
5.4.7 Ohmic Contact Metalization *123*
5.4.8 N-type 3C-SiC Ohmic Contacts *126*
5.4.9 Ion Implantation *126*
5.5 Summary *127*
Acknowledgements *127*
References *127*

6 Intrinsic and Extrinsic Electrically Active Point Defects in SiC *137*
Ulrike Grossner, Joachim K. Grillenberger, Judith Woerle, Marianne E. Bathen, and Johanna Müting
6.1 Characterization of Electrically Active Defects *141*
6.1.1 Deep Level Transient Spectroscopy *141*
6.1.1.1 Profile Measurements *143*

6.1.1.2 Poole–Frenkel Effect 143
6.1.1.3 Laplace DLTS 143
6.1.2 Low-energy Muon Spin Rotation Spectroscopy 144
6.1.2.1 μSR and Semiconductors 144
6.1.3 Density Functional Theory 145
6.2 Intrinsic Electrically Active Defects in SiC 146
6.2.1 The Carbon Vacancy, V_C 147
6.2.2 The Silicon Vacancy, V_{Si} 152
6.3 Transition Metal and Other Impurity Levels in SiC 153
6.4 Summary 159
References 163

7 Dislocations in 4H-SiC Substrates and Epilayers *169*
Balaji Raghothamachar and Michael Dudley
7.1 Introduction 169
7.2 Dislocations in Bulk 4H-SiC 170
7.2.1 Micropipes (MPs) and Closed-core Threading Screw Dislocations (TSDs) 170
7.2.2 Basal Plane Dislocations (BPDs) 171
7.2.3 Threading Edge Dislocations (TEDs) 171
7.2.4 Interaction between BPDs and TEDs 171
7.2.4.1 Hopping Frank–Read Source of BPDs 171
7.2.5 Threading Mixed Dislocations (TMDs) in 4H-SiC 173
7.2.5.1 Reaction Between Threading Dislocations with Burgers Vectors of $-c+a$ and c + a Wherein the Opposite c-Components Annihilate Leaving Behind the Two a-Components 174
7.2.5.2 Reaction Between Threading Dislocations with Burgers Vectors of $-c$ and $c+a$ Leaving Behind the a-Component 175
7.2.5.3 Reaction Between Opposite-sign Threading Screw Dislocations with Burgers Vectors c and $-c$ 175
7.2.5.4 Nucleation of Opposite Pair of $c+a$ Dislocations and Their Deflection 175
7.2.5.5 Deflection of Threading $c+a$, c and Creation of Stacking Faults 177
7.2.6 Prismatic Slip during PVT growth 4H-SiC Boules 180
7.2.7 Relationship Between Local Basal Plane Bending and Basal Plane Dislocations in PVT-grown 4H-SiC Substrate Wafers 181
7.2.8 Investigation of Dislocation Behavior at the Early Stage of PVT-grown 4H-SiC Crystals 181
7.3 Dislocations in Homoepitaxial 4H-SiC 184
7.3.1 Conversion of BPDs into TEDs 184
7.3.2 Susceptibility of Basal Plane Dislocations to the Recombination-Enhanced Dislocation Glide in 4H Silicon Carbide 184
7.3.3 Nucleation of TEDs, BPDs, and TSDs at Substrate Surface Damage 188
7.3.4 Nucleation Mechanism of Dislocation Half-Loop Arrays in 4H-SiC Homo-Epitaxial Layers 191

7.3.5 V- and Y-shaped Frank-type Stacking Faults *192*
7.4 Summary *192*
Acknowledgments *195*
References *195*

8 Novel Theoretical Approaches for Understanding and Predicting Dislocation Evolution and Propagation *199*
Binh Duong Nguyen and Stefan Sandfeld
8.1 Introduction *199*
8.2 General Modeling and Simulation Approaches *200*
8.3 Continuum Dislocation Modeling Approaches *201*
8.3.1 Alexander–Haasen Model *201*
8.3.2 Continuum Dislocation Dynamics Models *202*
8.3.2.1 The Simplest Model: Straight Parallel Dislocation with the Same Line Direction *203*
8.3.2.2 The "Groma" Model: Straight Parallel Dislocations with Two Line Directions *203*
8.3.2.3 The Kröner–Nye Model for Geometrically Necessary Dislocations *204*
8.3.2.4 Three-dimensional Continuum Dislocation Dynamics (CDD) *204*
8.4 Example 1: Comparison of the Alexander–Haasen and the Groma Model *206*
8.4.1 Governing Equations *206*
8.4.2 Physical System and Model Setup *206*
8.4.3 Results and Discussion *209*
8.5 Example 2: Dislocation Flow Between Veins *211*
8.5.1 A Brief Introduction to Dislocation Patterning and the Similitude Principle *211*
8.5.2 Physical System and Model Setup *213*
8.5.3 Geometry and Initial Values *214*
8.5.4 Results and Discussion *215*
8.6 Summary and Conclusion *219*
References *220*

9 Gate Dielectrics for 4H-SiC Power Switches: Understanding the Structure and Effects of Electrically Active Point Defects at the 4H-SiC/SiO_2 Interface *225*
Gregor Pobegen and Thomas Aichinger
9.1 Introduction *225*
9.2 Electrical Impact of Traps on MOSFET Characteristics *225*
9.2.1 Sub threshold Sweep Hysteresis *226*
9.2.2 Preconditioning Measurement *231*
9.2.3 Bias Temperature Instability *233*
9.2.4 Reduced Channel Electron Mobility *235*
9.3 Microscopic Nature of Electrically Active Traps Near the Interface *237*
9.3.1 The P_{bC} Defect and the Subthreshold Sweep Hysteresis *237*

9.3.2 The Intrinsic Electron Trap and the Reduced MOSFET Mobility *238*
9.3.3 Point Defect Candidates for BTI *240*
9.4 Conclusions and Outlook *242*
References *243*

10 Epitaxial Graphene on Silicon Carbide as a Tailorable Metal–Semiconductor Interface *249*
Michael Krieger and Heiko B. Weber
10.1 Introduction *249*
10.2 Epitaxial Graphene as a Metal *249*
10.3 Fabrication and Structuring of Epitaxial Graphene *250*
10.3.1 Epitaxial Growth by Thermal Decomposition *250*
10.3.2 Intercalation *251*
10.3.3 Structuring of Epitaxial Graphene Layers and Partial Intercalation *252*
10.4 Epitaxial Graphene as Tailorable Metal/Semiconductor Contact *253*
10.4.1 Ohmic Contacts *254*
10.4.2 Schottky Contacts *256*
10.5 Monolithic Epitaxial Graphene Electronic Devices and Circuits *257*
10.5.1 Discrete Epitaxial Graphene Devices *257*
10.5.2 Monolithic Integrated Circuits *259*
10.6 Novel Experiments on Light–Matter Interaction Enabled by Epitaxial Graphene *260*
10.6.1 High-Frequency Operation and Ultimate Speed Limits of Schottky Diodes *260*
10.6.2 Transparent Electrical Access to SiC for Novel Quantum Technology Applications *263*
10.7 Conclusion *264*
Acknowledgments *265*
References *265*

11 Device Processing Chain and Processing SiC in a Foundry Environment *271*
Arash Salemi, Minseok Kang, Woongje Sung, and Anant K. Agarwal
11.1 Introduction *271*
11.2 DMOSFET Structure *271*
11.3 Process Integration of SiC MOSFETs *273*
11.3.1 Lithography *283*
11.3.2 SiC Etching *283*
11.3.3 Ion Implantation and Activation Annealing *290*
11.3.4 Oxidation and Oxide *293*
11.3.5 Post Oxidation Annealing *296*
11.3.6 Poly-Si Deposition *298*
11.3.7 Backside Thinning and Waffle Substrates *300*
11.3.8 Ohmic Contacts and Metallization *301*
11.3.9 Polyimide Deposition *302*

11.4 Commercial Foundries for Si and SiC Devices *303*
11.4.1 Cost Model *303*
11.4.1.1 Cost Roadmap for WBG Devices *303*
11.4.2 New Equipment and Processing Requirements *305*
11.5 Dedicated Foundries vs. Commercial Foundries *306*
References *307*

12 Unipolar Device in SiC: Diodes and MOSFETs *319*
Sei-Hyung Ryu
12.1 Introduction *319*
12.2 Unipolar Diodes – 4H-SiC JBS Diodes *320*
12.2.1 Optimization of 4H-SiC JBS Diodes *323*
12.2.1.1 Injection from the p^+ Regions for Surge Operation *324*
12.2.1.2 Trench JBS Diodes *326*
12.2.1.3 Use of Low Work Function Metal for Anode Metal *327*
12.3 Unipolar Switches: Power MOSFETs *329*
12.3.1 4H-SiC Power MOSFET Structures *332*
12.3.1.1 DMOSFETs *332*
12.3.1.2 Trench MOSFETs *337*
12.3.2 Advanced Power MOSFET Structures in 4H-SiC *342*
12.3.2.1 Superjunction MOSFETs in 4H-SiC *342*
12.3.2.2 Integrated JBS Diodes in 4H-SiC Power MOSFETs *345*
12.4 Summary *346*
References *348*

Volume 2

13 Ultra-High-Voltage SiC Power Device *353*
Yoshiyuki Yonezawa and Koji Nakayama

14 SiC Reliability Aspects *387*
Josef Lutz and Thomas Basler

15 Industrial Systems Using SiC Power Devices *433*
Nando Kaminski

16 Special Focus on HEV and EV Applications: Activities of Automotive Industries Applying SiC Devices for Automotive Applications *467*
Kimimori Hamada, Keiji Toda, Hiromichi Nakamura, Shigeharu Yamagami, and Kazuhiro Tsuruta

17 Point Defects in Silicon Carbide for Quantum Technology *503*
András Csóré and Adam Gali

Part II Gallium Nitride (GaN), Diamond, and Ga_2O_3 *529*

18 Ammonothermal and HVPE Bulk Growth of GaN *531*
Robert Kucharski, Tomasz Sochacki, Boleslaw Lucznik, Mikolaj Amilusik, Karolina Grabianska, Malgorzata Iwinska, and Michal Bockowski

19 GaN on Si: Epitaxy and Devices *555*
Hidekazu Umeda

20 Growth of Single Crystal Diamond Wafers for Future Device Applications *583*
Matthias Schreck

21 Diamond Wafer Technology, Epitaxial Growth, and Device Processing *633*
Hideaki Yamada, Hiromitsu Kato, Shinya Ohmagari, and Hitoshi Umezawa

22 Gallium Oxide: Material Properties and Devices *659*
Masataka Higashiwaki

Index *681*