

# Contents

## 1 Transistors and Atoms

<i>J. Dąbrowski, E.R. Weber, H.-J. Müssig, W. Schröter</i> .....	1
1.1 Introduction .....	1
1.2 MOS Technology .....	4
1.2.1 The MOS Transistor .....	4
1.2.2 Technological MOS Processes .....	6
1.2.3 Trends in CMOS Miniaturization .....	9
1.3 Technological Progress and Challenges for Modeling .....	10
1.3.1 Crystal Growth.....	10
1.3.2 Lithography .....	11
1.3.3 Implantation and Diffusion.....	12
1.3.4 Gate Oxides .....	14
1.3.5 Deposition and Etch .....	15
1.3.6 Contacts and Interconnects .....	16
1.3.7 Yield and Contamination Control .....	18
1.3.8 Planarization.....	20
1.3.9 Assembly and Packaging.....	21
1.4 The Environment for Process Simulation .....	21
1.5 What TCAD Can Deliver and What it Can Not.....	24
1.6 Atomistic Theory.....	27
1.6.1 Accuracy in Ab-initio Methods .....	29
1.7 Conclusions.....	31
References .....	32

## 2 Atomistic Simulations of Processes at Surfaces

<i>P. Kratzer</i> .....	39
2.1 Introduction .....	39
2.2 Simulation Methods .....	44
2.3 Total-energy and Force Calculations .....	45
2.3.1 Analytical Potentials .....	47
2.3.2 Tight-binding Molecular Dynamics .....	49
2.3.3 Density-Functional Theory and Other Quantum-Chemical Ab-initio Methods .....	51
2.4 Selected Applications of Molecular Dynamics Simulations.....	56
2.4.1 Molecular Dynamics Simulations of Surface Melting....	56

2.4.2	Molecular Dynamics Simulations of Surface Reactions ..	57
2.5	Kinetic Monte Carlo Simulations for Modeling of Molecular Beam Epitaxy .....	60
2.6	Concluding Remarks .....	68
	References .....	69

### 3 Atomistic Simulations in Materials Processing

<i>M. Jaraiz</i> .....		73
3.1	Introduction .....	73
3.2	The Facts: Diffusion and Defects in Silicon .....	74
3.2.1	Si Self-Defects .....	75
3.2.2	V and I Point Defects .....	75
3.2.3	Foreign Atoms .....	84
3.2.4	Deep Sub-Micron Si Device Processing .....	85
3.3	The Models: Atomistic Kinetic Monte Carlo .....	86
3.3.1	The KMC Concept .....	86
3.3.2	An Atomistic KMC Simulator (DADOS) .....	88
3.4	Benchmarking: Simulation Examples .....	98
3.4.1	Ion Implantation: The “+1” Model .....	98
3.4.2	{311} Defects and Dislocation Loops .....	100
3.4.3	Amorphization and Recrystallization .....	101
3.4.4	Impurity Diffusion/Clustering Mechanisms .....	102
3.4.5	Fermi Level Effects .....	105
3.4.6	Device-Size Simulations .....	105
3.4.7	Conclusions .....	107
	References .....	107

### 4 Atomistic Simulation of Decanano MOSFETs

<i>A. Asenov, A.R. Brown, S. Kaya</i> .....		111
4.1	Introduction .....	111
4.2	Random Dopant Fluctuations .....	113
4.2.1	Fluctuation Problem .....	114
4.2.2	Simulation Approach .....	117
4.2.3	Conventional Structures .....	124
4.2.4	Fluctuation Resistant Architectures .....	129
4.2.5	The Effect of the Poly-Si Gate .....	130
4.2.6	Quantum Mechanical Corrections .....	132
4.2.7	Comparative Analysis .....	135
4.3	Single Charge Trapping .....	139
4.3.1	Simulation Approach .....	139
4.3.2	Continuous Doping .....	140
4.3.3	Discrete Dopant Simulations .....	141
4.4	Oxide Thickness Variations .....	143

4.4.1	Interface Reconstruction . . . . .	144
4.4.2	Implications for Decanano MOSFETs . . . . .	145
4.5	Line Edge Roughness . . . . .	150
4.6	Challenges Ahead . . . . .	152
4.7	Conclusions . . . . .	152
4.8	List of Acronyms and Symbols . . . . .	154
	References . . . . .	154

**5 Modeling and Simulation  
of Heterojunction Bipolar Transistors**

<i>H. Ünlü</i>	. . . . .	157
5.1	Introduction . . . . .	157
5.2	An Overview of Charge Transport in HBTs . . . . .	160
5.3	Heteroemitter Energy Band Properties . . . . .	163
5.3.1	Temperature, Strain, and Composition Effects . . . . .	164
5.3.2	Conduction and Valence Band Offsets . . . . .	172
5.4	Charge Transport and Boundary Conditions . . . . .	175
5.4.1	Conservation of Charge and Trap Levels . . . . .	177
5.4.2	Boundary Conditions for Electric Potential . . . . .	178
5.4.3	Boundary Conditions for Carrier Products . . . . .	182
5.4.4	Boundary Conditions for Quasi-Fermi Levels . . . . .	183
5.5	The Modeling of Current Transport . . . . .	184
5.5.1	The Heterojunction Recombination Current . . . . .	184
5.5.2	The Minority Carrier Diffusion Currents . . . . .	185
5.6	The Modeling of Current Fluctuations . . . . .	188
5.7	Results and Discussion . . . . .	189
5.8	Summary and Future Trends . . . . .	195
	References . . . . .	197

**6 Gate Oxide Reliability:  
Physical and Computational Models**

<i>A. Ghetti</i>	. . . . .	201
6.1	Introduction . . . . .	201
6.2	Gate Oxide Reliability . . . . .	203
6.2.1	Basic Statistical Concepts . . . . .	203
6.2.2	The Industry Problem . . . . .	206
6.2.3	General Model . . . . .	207
6.3	Electrical Stress and Carrier Energy . . . . .	210
6.3.1	Tunneling . . . . .	210
6.3.2	Self-Consistent Potential Profile . . . . .	211
6.3.3	The Transmission Probability . . . . .	212
6.3.4	Tunneling Current Components . . . . .	215
6.3.5	Fowler–Nordheim Tunneling . . . . .	216
6.3.6	Carrier Separation Experiments . . . . .	218
6.3.7	Trap-Assisted Tunneling . . . . .	221

6.3.8	Interface State Assisted Tunneling	224
6.3.9	Hot Carriers	225
6.4	Critical Trap Density	227
6.4.1	Experimental Evidence	227
6.4.2	Percolation	229
6.4.3	Area and Percentile Scaling	232
6.5	Defect Generation and Lifetime Extrapolation	234
6.5.1	The Anode Hole Injection Model	235
6.5.2	The Anode Hydrogen Release Model	242
6.5.3	The Thermochemical Model	244
6.5.4	Phenomenological Models	245
6.5.5	Reliability Projections	246
6.6	The Breakdown Mode	248
6.7	Summary and Conclusions	252
	References	253

## 7 High- $K$ Dielectrics: The Example of $\text{Pr}_2\text{O}_3$

	<i>H. J. Osten, J. Dqbrowski, H.-J. Müssig, A. Fissel, V. Zavodinsky</i>	259
7.1	Introduction	259
7.2	Alternative (High- $K$ ) Dielectrics	261
7.2.1	General Requirements	261
7.2.2	Available Materials	262
7.2.3	Praseodymium Oxide	265
7.3	Experimental and Theoretical Approach	267
7.4	Results of Structural Investigations	268
7.4.1	Initial Growth	268
7.4.2	Thicker Films	271
7.5	Interface Formation	275
7.6	Layer Stability	282
7.7	Electrical Properties of $\text{Pr}_2\text{O}_3$ on $\text{Si}(001)$	287
7.7.1	Band Structures	287
7.7.2	Gate Capacitance and Gate Leakage Current	289
7.7.3	Gate Dielectric Reliability	291
7.7.4	Thermal Stability	291
7.7.5	Process Integration	291
7.8	Outlook	292
	References	293

## 8 Atomistic Simulation of $\text{Si}_3\text{N}_4$ CVD from Dichlorosilane and $\text{NH}_3$

	<i>A.A. Bagatur'yants, A.K. Minushev, K.P. Novoselov, A.A. Safonov, S.Ya. Umanskiy, A.S. Vladimirov, A. Korokin</i>	295
8.1	Introduction	295
8.2	Theoretical Study of the Mechanism and Kinetics of Gas-Phase Reactions	297

8.2.1	Introduction .....	297
8.2.2	Computational Details .....	298
8.2.3	Results and Discussion .....	309
8.2.4	Summary and Conclusions .....	329
8.3	Theoretical Study of the $\text{Si}_3\text{N}_4$ Surface Structures and Mechanisms of Some Essential Surface Reactions .....	330
8.3.1	Introduction .....	330
8.3.2	Computational Details .....	330
8.3.3	Results and Discussion .....	331
8.3.4	Conclusions .....	343
8.4	Kinetic Monte Carlo Atomic Scale Simulation of Chemical Vapor Deposition of Silicon Nitride Film .....	344
8.4.1	Introduction .....	344
8.4.2	Method of Kinetic Monte Carlo Simulation of Film Growth .....	344
8.4.3	Reaction Rate Calculations for Elementary Surface Reactions .....	346
8.4.4	Results of Calculations .....	349
8.4.5	Conclusions .....	351
8.5	General Conclusions and Outlook .....	352
	References .....	352
<b>9 Interconnects and Propagation of High Frequency Signals</b>		
	<i>R. Sabelka, C. Harlander, S. Selberherr</i> .....	357
9.1	Introduction .....	357
9.2	Interconnect Modeling .....	359
9.3	Parasitics Extraction .....	362
9.3.1	Capacitance Extraction .....	363
9.3.2	Resistance Extraction .....	367
9.3.3	Substrate Resistance .....	368
9.3.4	Inductance Extraction .....	369
9.4	Partial Element Equivalent Circuits .....	372
9.5	Transmission Line Models .....	373
9.6	Three-Dimensional Analysis .....	374
9.7	Model Order Reduction .....	376
9.8	Reliability .....	377
9.9	Design .....	378
9.10	Software .....	380
9.11	Conclusion and Outlook .....	381
	References .....	382

**10 Modeling of Electromigration in Interconnects**

<i>V. Petrescu, W. Schoenmaker</i> .....	387
10.1 Introduction .....	387
10.1.1 The Physical Basis of Electromigration .....	388
10.1.2 The Influence of Al Microstructure .....	391
10.1.3 Mechanical Stress; Critical Stress .....	392
10.1.4 Elastic Properties of Materials .....	393
10.1.5 Thermal Stress .....	393
10.1.6 Electromigration in Multilayer Metallization Structures ..	394
10.1.7 The Blech Length Concept .....	396
10.1.8 Resistance Change in the Early Phase of Electromigration .....	397
10.1.9 Change of Resistance under Hydrostatic Stress .....	398
10.1.10 The Effect of Cu Precipitation on Resistance .....	398
10.2 Modeling of Electromigration .....	399
10.2.1 Modeling Aspects of Electromigration and Stress Migration .....	401
10.2.2 Stress Generation in a Vacancy Diffusion Model .....	403
10.2.3 Vacancies in Equilibrium .....	407
10.2.4 The Flux of Vacancies .....	408
10.2.5 Kirchheim's Vacancy Continuity Equation .....	410
10.2.6 Kirchheim's Model: Simulation Results .....	411
10.2.7 The Model of Electromigration and Stress Migration of Clement and Thompson .....	413
10.2.8 Hydrodynamic Model .....	417
10.2.9 Vacancies, Stress and Early Resistance Changes .....	420
10.3 Simulation of Electromigration .....	421
10.3.1 Scaling of the Constitutive Equations .....	422
10.3.2 The Discretization Technique .....	425
10.3.3 Simulation Results .....	430
10.3.4 Proof of Blech Length .....	430
10.4 Experimental Validation .....	437
10.4.1 Early Resistance Change Measurements .....	438
10.4.2 The Experimental Set-Up .....	439
10.4.3 The Influence of Cu Addition on the Early Resistance Changes of Al Lines .....	442
10.4.4 Precipitation in Aluminum-Copper Alloys .....	442
10.4.5 Samples Fabrication .....	443
10.4.6 Measurement Results .....	443
10.4.7 Precipitation Hardening .....	446
10.4.8 The Dislocation-Solute Atoms Interaction .....	447
10.4.9 Proof of Blech Length .....	449
10.5 Conclusion .....	453
References .....	453

**11 Predictive Modeling of Transition Metal Gettering:  
Applications and Materials Science Challenges**  
*A.A. Istratov, W. Huber, E.R. Weber*..... 457

11.1 Introduction ..... 457

    11.1.1 Mathematical Basis for Computer Modeling  
    of Gettering ..... 458

    11.1.2 Examples of Applications of the Gettering Simulations . 460

11.2 The Road from Qualitative to Predictive Modeling:  
Materials Science Challenges ..... 462

11.3 Conclusion ..... 466

References ..... 466

**Index** ..... 469