

Advanced Microelectronic Materials and Devices Mini-Symposium

Room 318 - Session AM2+EM+TF-FrM

Devices II

Moderators: Samantha Jaszewski, Sandia National Labs, Somil Rath, Arizona State University

10:30am AM2+EM+TF-FrM-10 Development of Metallic Gate Stacks at Atomic Scale : Application to Advanced FD-SOI Transistors, Elouan Le Cun, Julien Patouillard, Rémy Gassilloud, Mathieu Bernard, Zdenek Chalupa, Krunoslav Romanjek, Wissem Baik, William Vandendaele, Elhadji-Alhousseyni Diallo, Tadeu Mota Frutuoso, Pauline Hauchecorne, Virginie Loup, Théo Cabaret, Frédérique Glowacki, Mouaad Yassine Aliouat, Elise Arnoux, Gennie Garnier, Marie-Claire Cyrille, Olivier Renault, Claire Fenouillet-Béranger, CEA-LETI, France

Fully-Depleted Silicon On Insulator (FDSOI) planar technology - an alternative to FinFET (3D field effect transistors) - address technologies involving very high energy efficiency, ultralow power consumption and cost reduction. 10 nm FD-SOI transistor requires complex metal on insulator (MOS) gate stacks. The MOS structure is composed of doped titanium nitride layers as metal gates, and SiON/HfON as gate-dielectric[1]. SiON is also called gate interlayer (IL). Thinning TiN layers results in better MOS performances. This is due to a known phenomenon called IL scavenging, where TiN acts as an oxygen reducer of the IL, which in turn reduces the IL thickness[2]. The targeted TiN thickness in the 10 nm-node FDSOI is closed to 2 nm, and the required equivalent oxide thickness (the electrical thickness of the IL/HfON insulator stack) is below 0,8 nm. As the layers thicknesses reach the nm-scale, it introduces new challenges regarding the electrical behavior of the MOSFET due to the heterogeneity of the materials in the gate stacks.

To address those challenges, the developments of an ultra-thin 2 nm metallic gate stack with sub-stoichiometric titanium nitride (TiN_{x-1}) are required. CEA-Leti has acquired a PVD deposition tool by co-sputtering to deposit complex metallic layers on 300 mm silicon wafers with an atomic-scale thickness control.

This study examines TiN_x ultra-thin films with thicknesses below 5 nm. TiN_x structural, optical and electrical properties are evaluated by X-Ray Reflectivity (XRR), stress measurements, sheet resistance measurements, spectroscopic ellipsometry, X-Ray Photoelectron Spectroscopy (XPS) and X-Ray Diffraction (XRD). TiN_x layer composition is investigated by Elastic Recoil Detection Analysis (ERDA) and X-Ray Fluorescence (XRF) analysis. Those layers have been integrated on simplified electrical devices to evaluate their impact on transistor key performance parameters (EOT, Vt, Jg, ...).

This work was carried out in the framework of the FAMES Pilot Line of the Chips JU and the Platform for Nanocharacterisation (PFNC) funded by Horizon Europe grant 101182279, ANR NextGen project ANR-22-NEXTG-001, ANR programs "Recherche Technologique de Base" and "France 2030 - ANR-22-PEEL-0014".

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References:

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[2] T. Ando et al., *Ultimate Scaling of High-k Gate Dielectrics: Higher-k or Interfacial Layer Scavenging, Materials* 2012, 5, 478-500

10:45am AM2+EM+TF-FrM-11 Towards Ordered Growth of Complex Oxide Thin Films for Memristive Devices, Michael Mitchell, Xianchao Dong, Shweta Joshi, Tianshu Li, Gina Adam, George Washington University

We present progress towards the ordered growth of the entropy-stabilized oxide, $(\text{MgNiCoCuZn})_{0.2}\text{O}$, via reactive magnetron sputtering for the fabrication of memristive devices. To produce this film, the authors leveraged a custom-designed AJA ATC system with off-axis capabilities to reduce deposited atom kinetic energy and improve film crystallinity. The proposed methodology uses co-sputtering of multiple metal alloy targets in an oxygen-rich environment. Depositions are conducted at multiple substrate temperatures to identify phase transition temperatures. In Friday Morning, November 13, 2026

addition to 100-oriented silicon, substrates composed of materials with improved lattice matching to literature values of $(\text{MgNiCoCuZn})_{0.2}\text{O}$ are employed, and the relationship between substrate material and phase transition temperature is investigated. Various microscopic and spectroscopic characterization techniques, including Atomic Force Microscopy (AFM) and Energy Dispersive X-ray Spectroscopy (EDS), etc., were used to determine the film growth rate and stoichiometry. Molecular Dynamics simulations, with interatomic interactions provided by fine-tuned machine learning models, are employed to study the relationship between phase transition temperature and substrate composition. The computational findings for the influence of substrate composition and deposition stoichiometry on the phase transition temperature are then compared with the experimental results. The pathways for integration of the resulting film into memristive devices are also discussed.

11:00am AM2+EM+TF-FrM-12 Electron beam lithography enabled nano EC-RAM development and fabrication, Stefan Theodoru, Garry Rubloff, UMD College Park; Marshall Schroeder, DEVCOM ARL

The exponential increase of computing demand is currently only being met with <10% improvement of computational power density per chip generation. Improvements in energy consumption have not kept pace with either industry demand or grid capacity. Electrochemical random-access memory (EC-RAM) is well postured to fulfill this demand, boasting six orders of magnitude modeled energy consumption lower than CMOS technology. EC-RAM models predict downscaling energy consumption based on micron scale devices which should at the nano scale deliver atto J cost per computation compared to the current pico J state of the art. Further boons to EC-RAM include its intrinsic non-volatility, analog states, and co-located compute and memory centers. This makes EC-RAM ideal for use in neural network computation. Scaling studies to prove these modeled results have not yet been conducted in the sub 100nm regime however, leaving a large gap between EC-RAM's modeled capabilities, and what has been experimentally proven.

This presentation describes the process development done to fabricate Au, TiO_2 , and LiPON EC-RAM devices and the results of their characterization. We use TiO_2 for its wide range of conductance states as a function of Li content. While LiPON is both well known to the research group, and provides a source of Li provided during the LiPON deposition. Process development was needed to develop sub 100nm feature separation/widths using electron beam lithography, as well as to allow for nanolithography of the reactive LiPON film (Fig.2). Devices built for performance use the vertical architecture, see Fig.1, which minimizes the ion diffusion pathway. Devices built to allow for characterization using Raman and Plume SEM use the lateral architecture, see Fig.3. Both architectures have channels defined by the width of the source/drain and their separation, and have asymmetric and symmetric variants which allow us to test the impact of having a Li reservoir on device performance. The most important parameters for defining EC-RAM performance are state change speed, retention, and cycle life of the device. State change speed is the time it takes to intercalate enough Li^+ ions into the channel that the conductivity, as read by a bias across source and drain, changes to encode a unique conductance state. Retention is defined as the time that a written state endures with no applied gate voltage. The analysis of these characterization results and process development elucidate ideal EC-RAM architecture and fabrication methodology.

11:15am AM2+EM+TF-FrM-13 Limitations of Layered Dielectrics, Peter Dickens, Brianna Klein, Andrew Binder, Sandia National Laboratories, USA

Next-generation power conversion systems increasingly rely on SiC power MOSFETs to minimize switching losses and maximize power density. Conventional SiO_2 gate dielectrics limits maximizing the gate capacitance and drive current, making higher-k dielectrics attractive to improve switching characteristics. However, to date, severe defect densities at the direct high-k/SiC interface has prevented strict high-k adoption. Consequently, recent work has focused on utilizing a dielectric bilayer with SiO_2 serving as the interface dielectric with SiC to enable low defect densities and a high-k stacked on top in an attempt to gain the "best of both worlds". Despite some reported successes, there remain critical gaps discussing what fundamental advantages or limitations exist from this dielectric bilayer approach.

In this presentation, we present analysis of the available design space for layered dielectrics in SiC-based MOSFETs. Our analysis operates under three fundamental assumptions related to applied gate bias, avoidance of time-dependent-dielectric-breakdown (TDDb), and the requirement to be high-k (effective dielectric permittivity greater than the permittivity of the

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semiconductor). We show that when these assumptions are applied then the available design space for layered dielectrics is quite limited and calls into question advantages of a layered approach.

Sandia National Laboratories is a multi-mission laboratory managed and operated by National Technology & Engineering Solutions of Sandia, LLC (NTESS), a wholly owned subsidiary of Honeywell International Inc., for the U.S. Department of Energy's National Nuclear Security Administration (DOE/NNSA) under contract DE-NA0003525.

SAND2026-21413A

11:30am **AM2+EM+TF-FrM-14 From Bulk Screening to Gate Control: Enabling Vapor-Deposited CsGeI₃ Thin-Film Transistors, Azaharuddin Saleem Shaikh**, imec and KU Leuven (University of Leuven), Belgium

The development of low-temperature p-type semiconductors remains a key challenge for back-end-of-line (BEOL)-compatible monolithic three-dimensional (M3D) electronics. Lead-free inorganic halide perovskites are attractive candidates because of their low thermal budget and favorable charge-transport properties; however, transistor operation in many lead-free inorganic compositions remains largely unexplored. Here, we demonstrate the first vapor-deposited CsGeI₃ thin-film transistors fabricated by thermal co-evaporation of CsI and GeI₂ using BEOL-compatible processing temperatures.

Structural characterization confirms the formation of highly textured CsGeI₃ thin films following low-temperature deposition. To elucidate the relationship between film thickness and device operation, the active-layer thickness was systematically varied from ultrathin to bulk-like regimes. Electrical characterization reveals a critical transition near 20 nm, separating a bulk-screened transport regime from a gate-controllable regime. Transmission-line measurements and capacitance-voltage analysis show that increasing film thickness leads to substantially higher carrier concentration and contact resistance, consistent with enhanced electrostatic screening and reduced gate-field penetration into the semiconductor layer.

Below the transition thickness, effective gate control enables near-complete current modulation and robust p-type transistor behavior. Optimized devices with a 15 nm CsGeI₃ channel exhibit saturation mobilities approaching 0.6 cm² V⁻¹ s⁻¹, on/off current ratios approaching 10⁵, and subthreshold swings as low as 0.4 V dec⁻¹. These results establish vapor-deposited CsGeI₃ as a promising lead-free p-type semiconductor platform for low-temperature electronics and provide direct evidence that thickness engineering is a critical design parameter governing transistor operation in CsGeI₃. More broadly, this study highlights a pathway toward integrating halide-perovskite semiconductors into BEOL-compatible device architectures and monolithic 3D electronic systems.

11:45am **AM2+EM+TF-FrM-15 Ambipolar Organic Transistor Based on Polypeptides, Jeyvin Coleman**, University of Nebraska - Lincoln; **Mariam Orabi, Wai Kiat Chin, Peter Dowben**, University of Nebraska-Lincoln, USA

Ambipolar organic field-effect transistors have seen years of development and have been a topic of interest now for several decades. The dual-polarity allows for more simple circuit architecture for organic electronics. Generally, the performance of planar ambipolar organic transistors is poor and requires the deposition of two different organic semiconductors [1-3]. Frequently, the mobility is well below 1 cm² V⁻¹ s⁻¹, usually by orders of magnitude. Here, we look at bio-organic polypeptides to reduce the fabrication steps for flexible electronics. We show that polypeptide-based materials have potential in organic electronic devices, more specifically, they are seen to make excellent organic ambipolar transistors. In this study, organic field-effect ambipolar transistors (OFETs) were fabricated using poly-D-lysine, poly-L-ornithine and poly-L-aspartic acid combined with poly(3,4-ethylenedioxythiophene):polystyrene sulfonate (PEDOT:PSS). Under ambient light, the poly-D-ornithine based devices showed higher overall on-state currents, while the poly-L-lysine-based devices exhibited significantly higher on-state currents under dark conditions, with differences of at least two orders of magnitude. Thus, we have two distinct types of bio-organic ambipolar transistor devices. Both the poly-D-lysine and poly-L-ornithine devices also demonstrated relatively long carrier lifetimes, ranging from 10⁻⁶ to 10⁻³ s, while the bio-organic ambipolar transistor made from poly-L-aspartic acid combined with PEDOT:PSS has a mobility of 1 cm² V⁻¹ s⁻¹. Comparing the calculated and experimentally measured band-gap energies provides complementary information about the electronic structure of the polypeptide materials. Overall, these results demonstrate and highlight the potential of these polypeptide materials for

organic electronic applications and highlight the potential of polypeptides as tunable materials for low-voltage bio-organic ambipolar transistors.

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