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Murtthy et al.

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(54) **SEMICONDUCTOR DEVICE HAVING DOPED EPITAXIAL REGION AND ITS METHODS OF FABRICATION**

(75) Inventors: **Anand S. Murtthy**, Portland, OR (US); **Daniel Bourne Aubertine**, North Plains, OR (US); **Tahir Ghani**, Portland, OR (US); **Abhijit Jayant Pethe**, Hillsboro, OR (US)

(73) Assignee: **Intel Corporation**, Santa Clara, CA (US)

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H01L 21/20 (2006.01)

(52) **U.S. Cl.**
USPC **438/300**; 257/E21.431; 257/E21.634

(58) **Field of Classification Search**
USPC 257/289, 401; 438/300, 198
See application file for complete search history.

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Primary Examiner — Matthew W Such

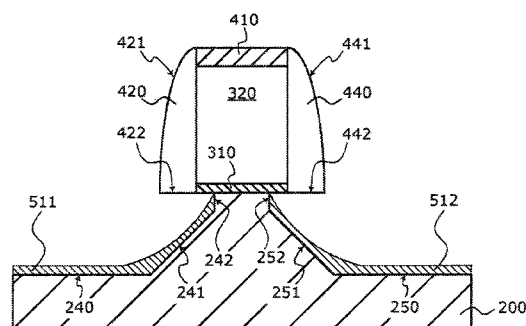
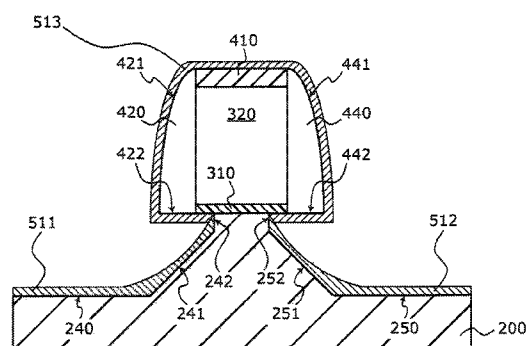
Assistant Examiner — Abul Kalam

(74) *Attorney, Agent, or Firm* — Blakely, Sokoloff, Taylor & Zafman LLP

(57) **ABSTRACT**

Embodiments of the present invention describe a epitaxial region on a semiconductor device. In one embodiment, the epitaxial region is deposited onto a substrate via cyclical deposition-etch process. Cavities created underneath the spacer during the cyclical deposition-etch process are back-filled by an epitaxial cap layer. The epitaxial region and epitaxial cap layer improves electron mobility at the channel region, reduces short channel effects and decreases parasitic resistance.

27 Claims, 20 Drawing Sheets



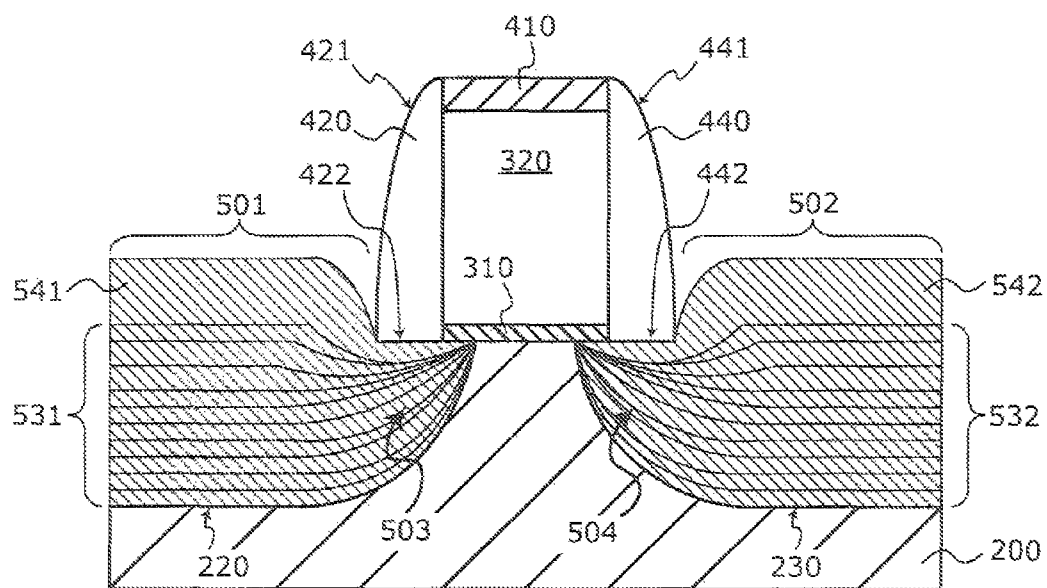


FIGURE 1

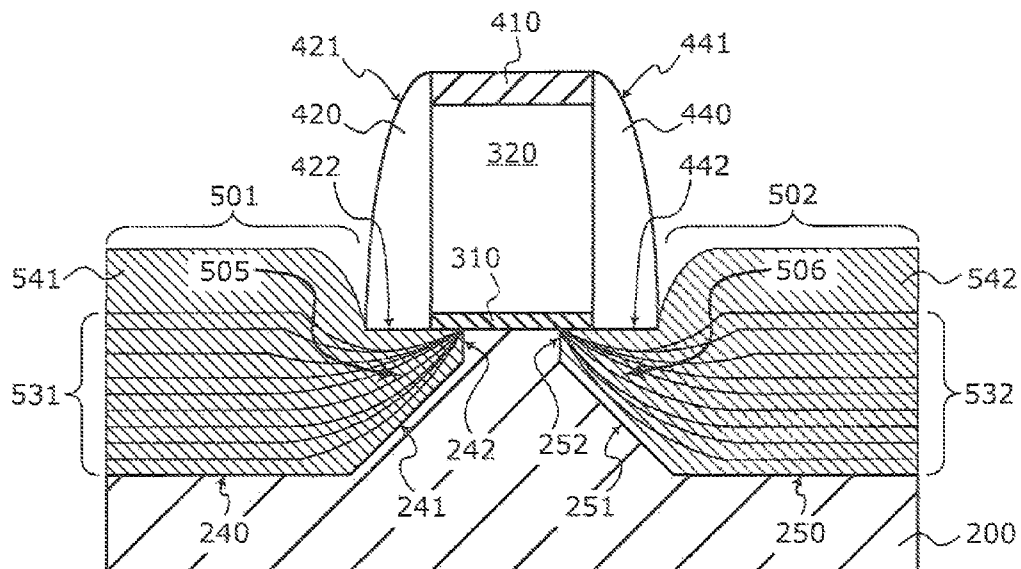


FIGURE 2

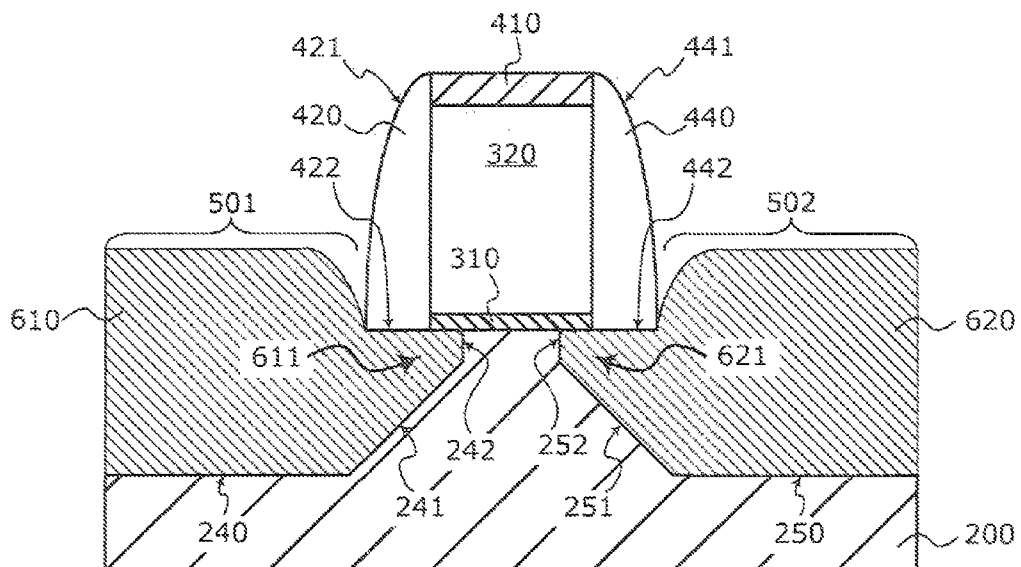


FIGURE 3

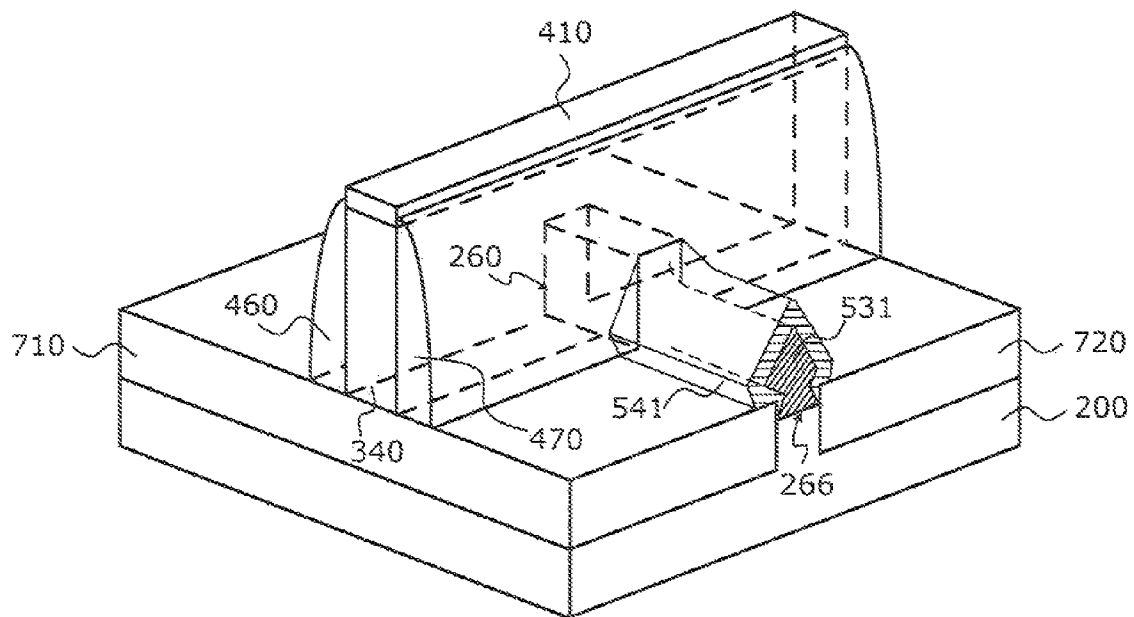


FIGURE 4

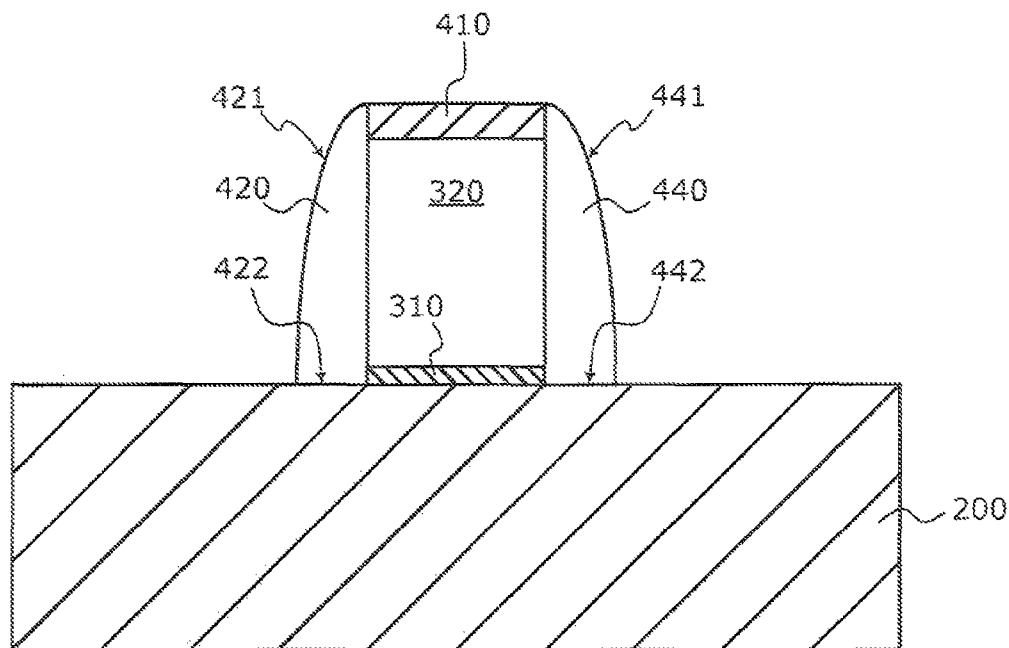


FIGURE 5A

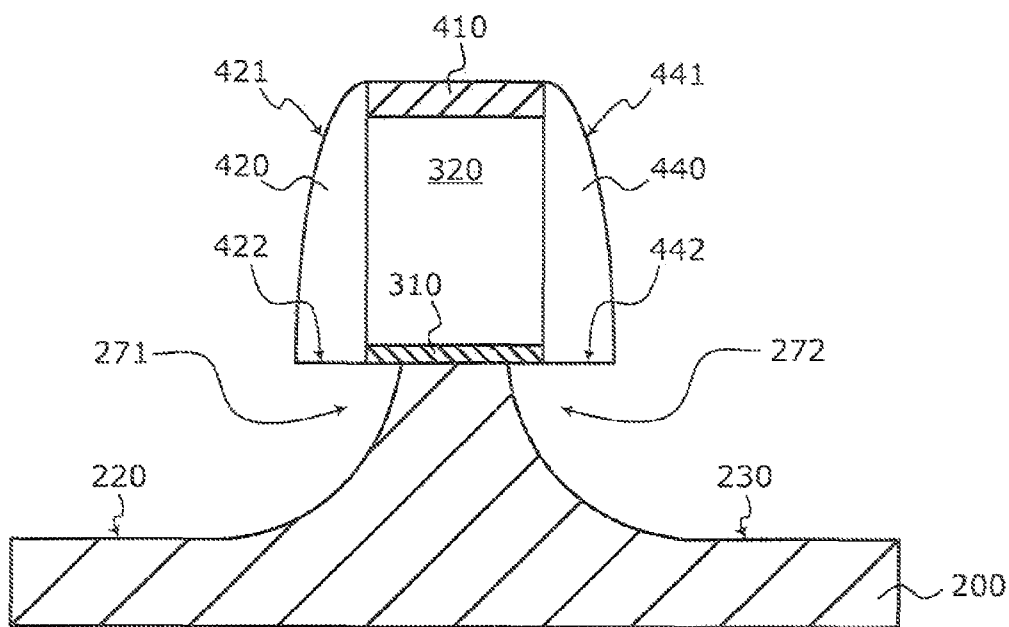


FIGURE 5B

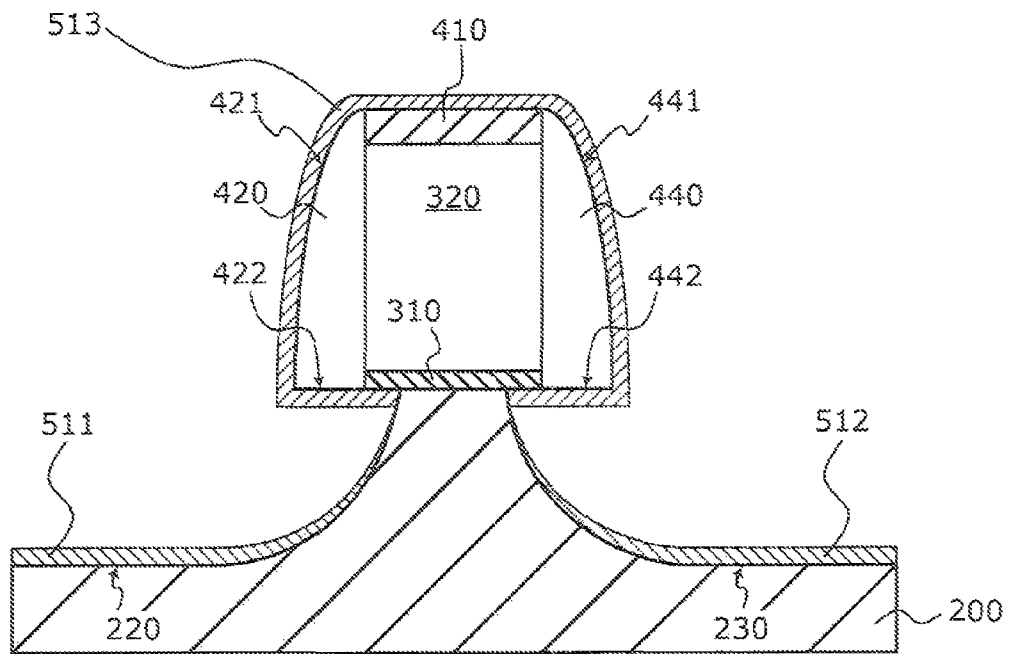


FIGURE 5C

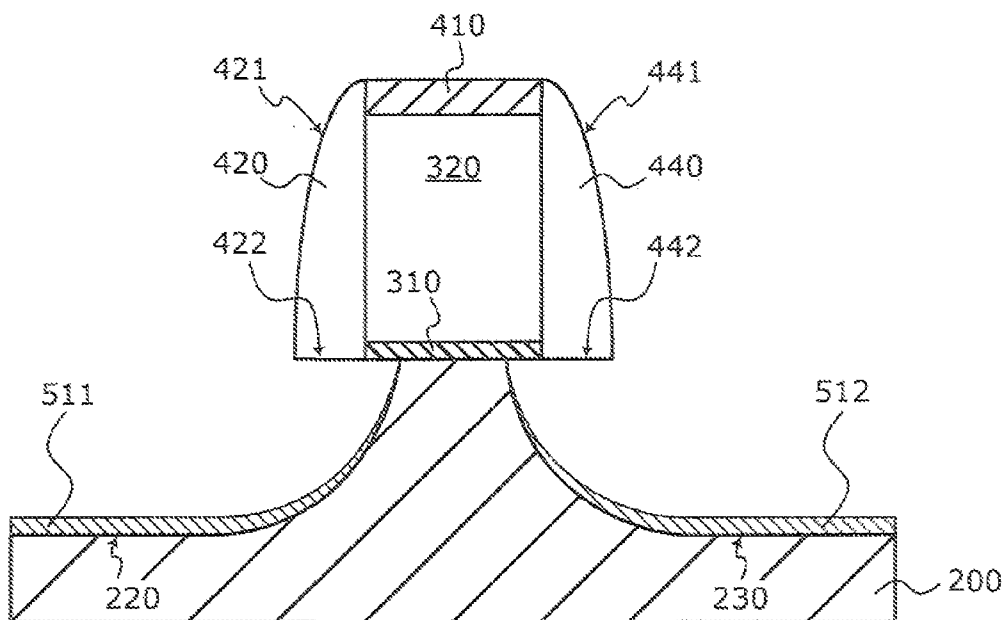


FIGURE 5D

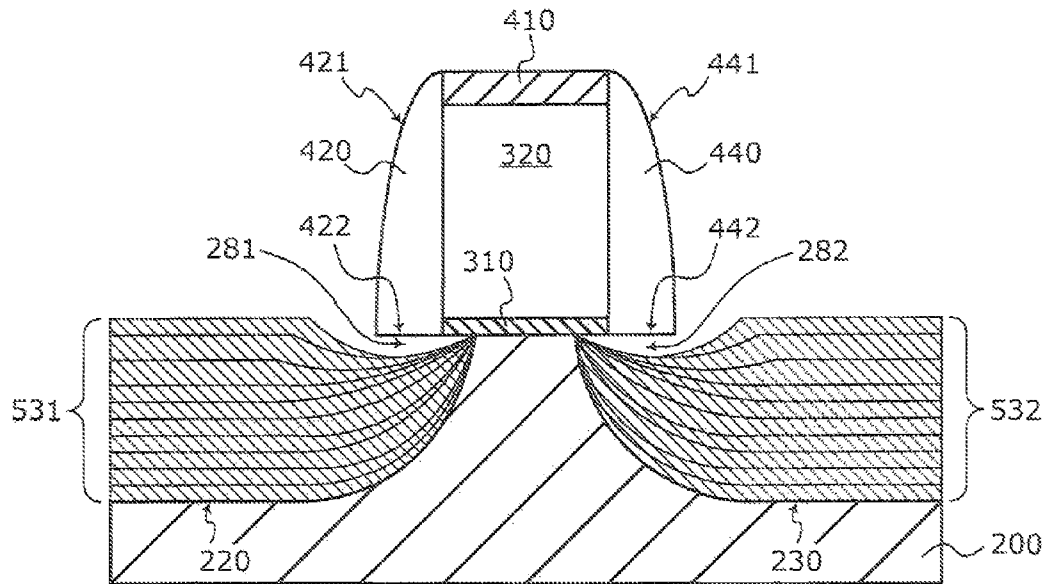


FIGURE 5E

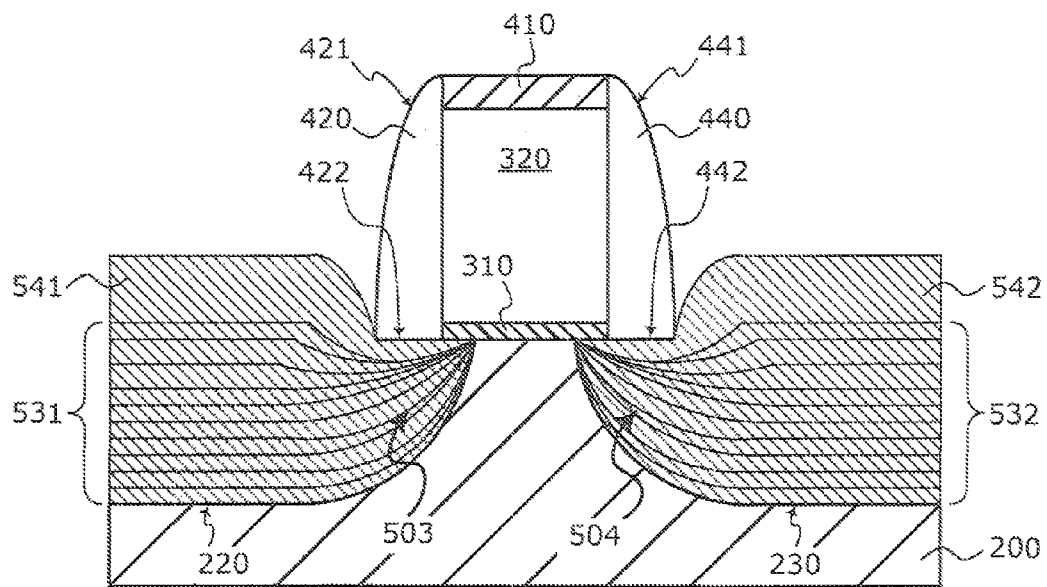


FIGURE 5F

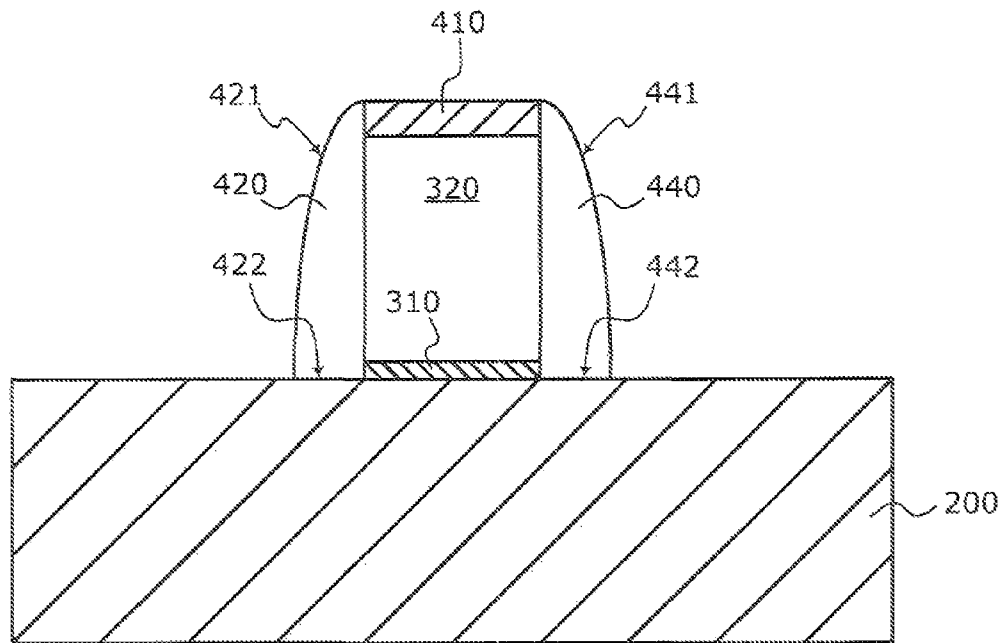


FIGURE 6A

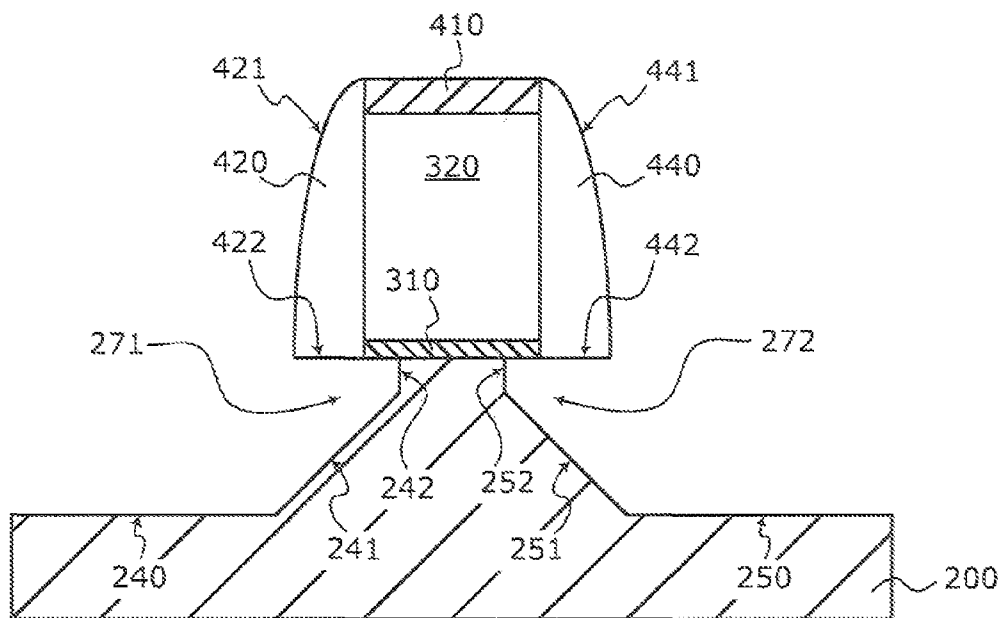


FIGURE 6B

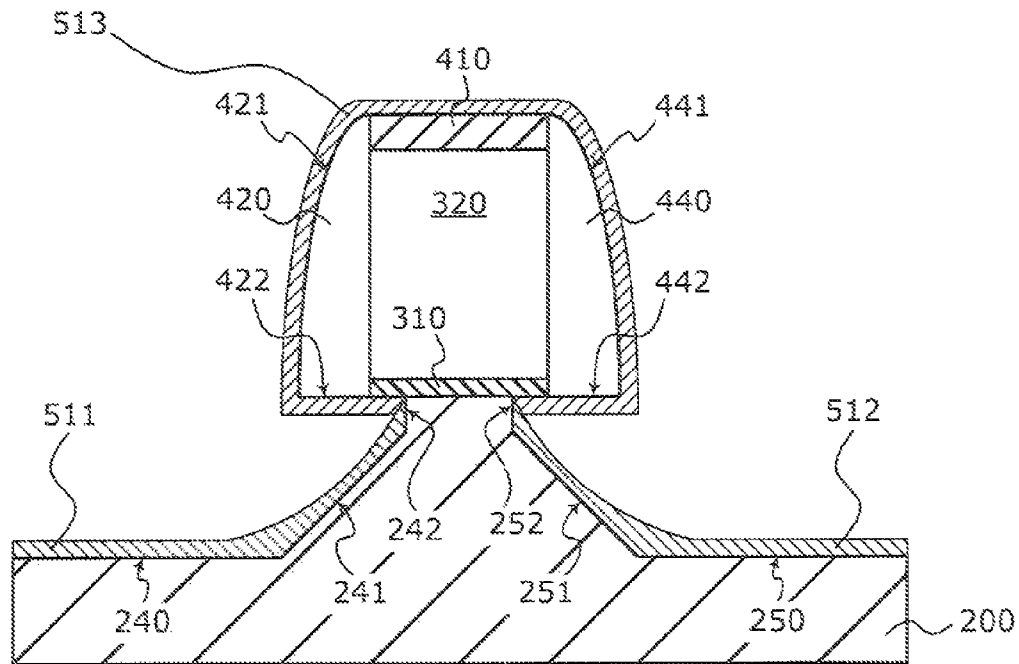


FIGURE 6C

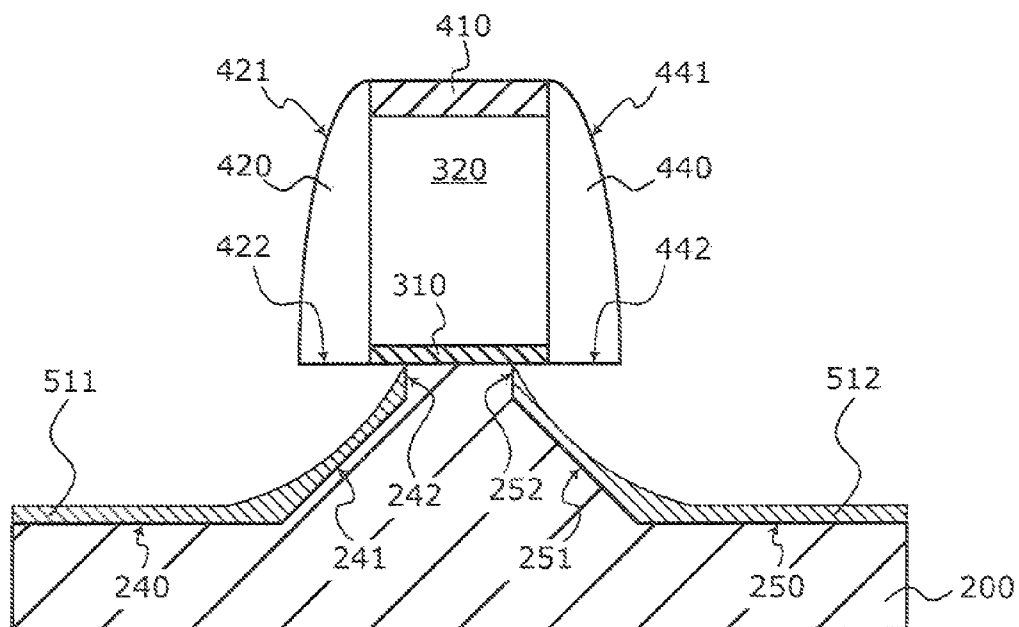


FIGURE 6D

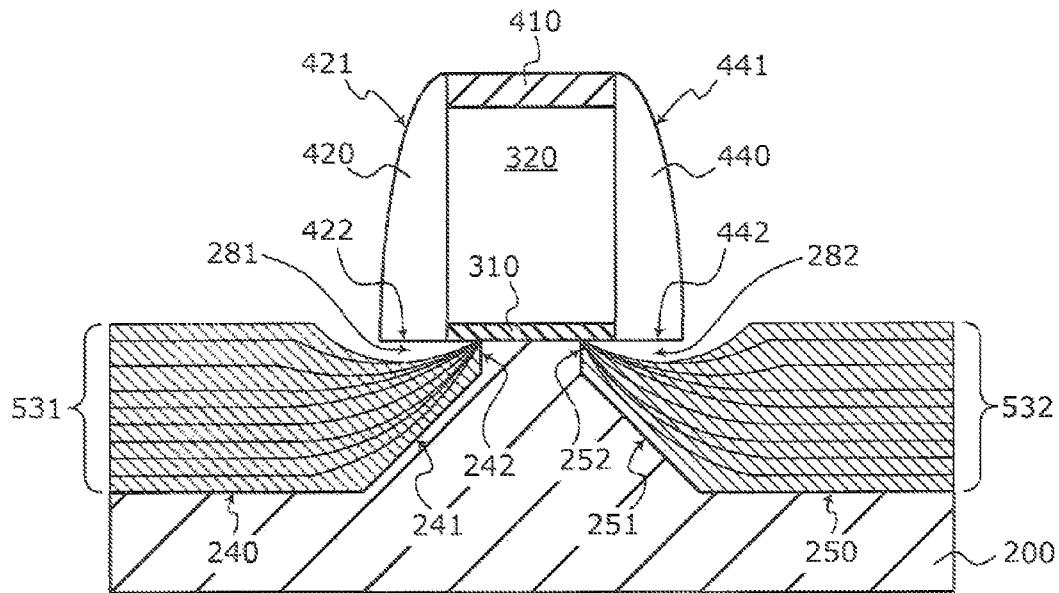


FIGURE 6E

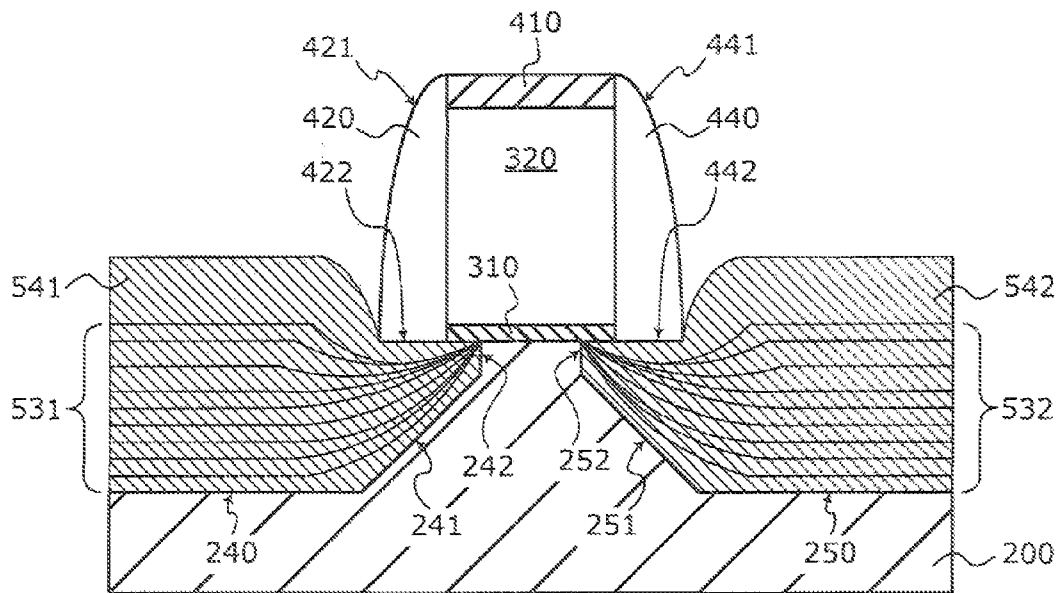


FIGURE 6F

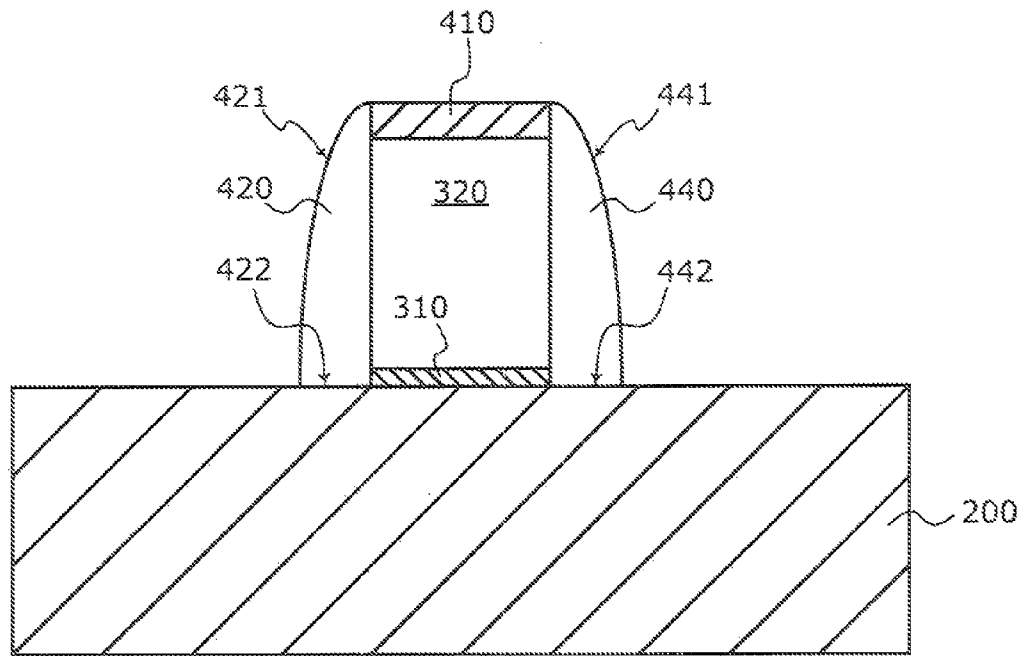


FIGURE 7A

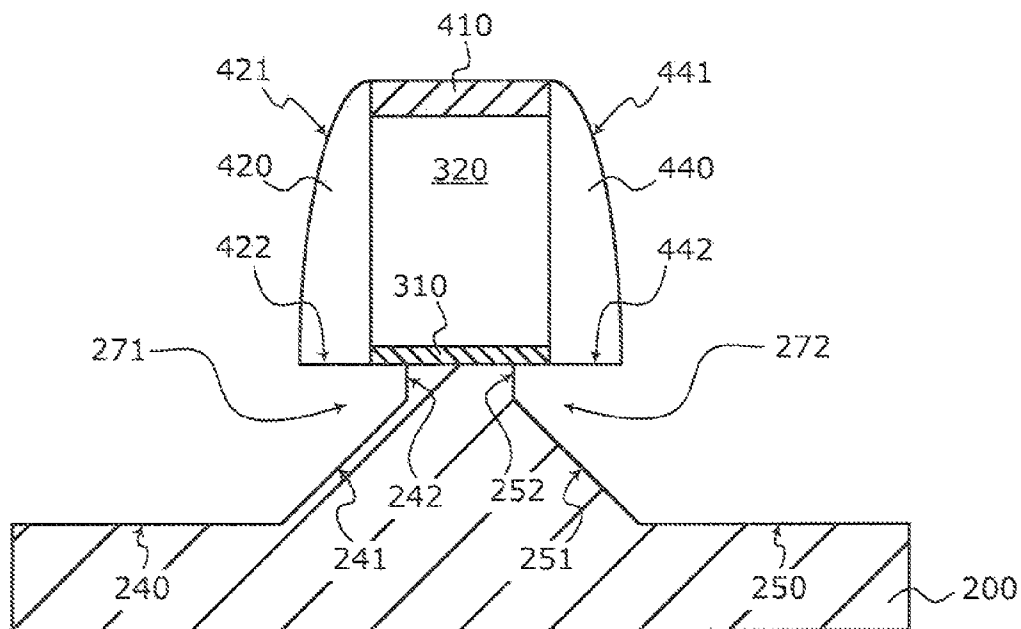


FIGURE 7B

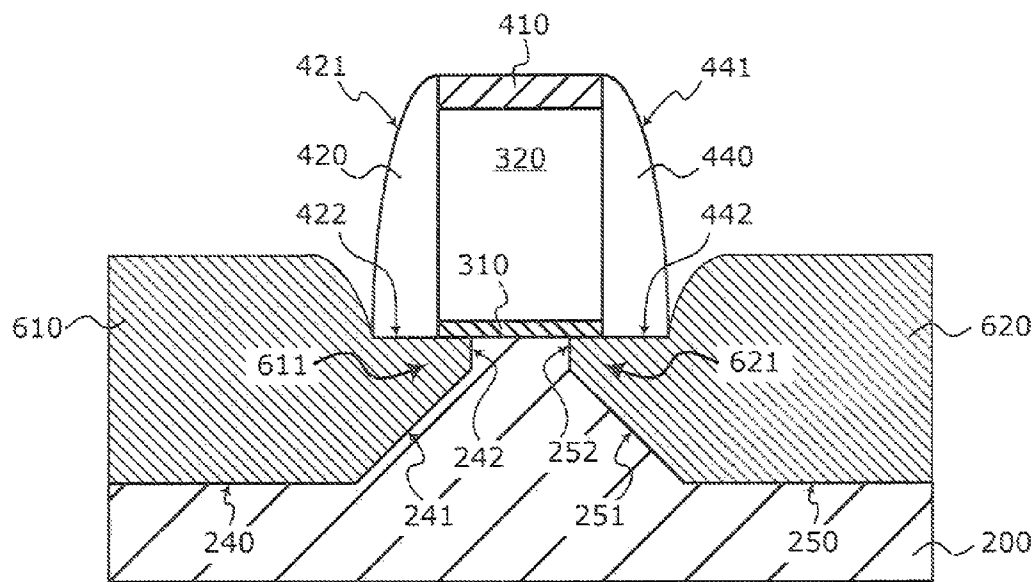


FIGURE 7C

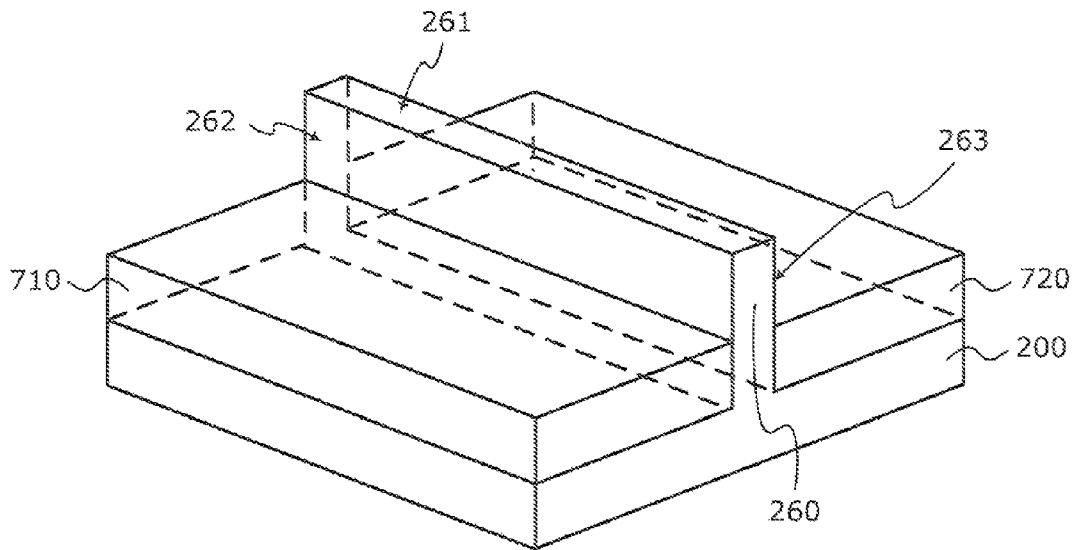


FIGURE 8A

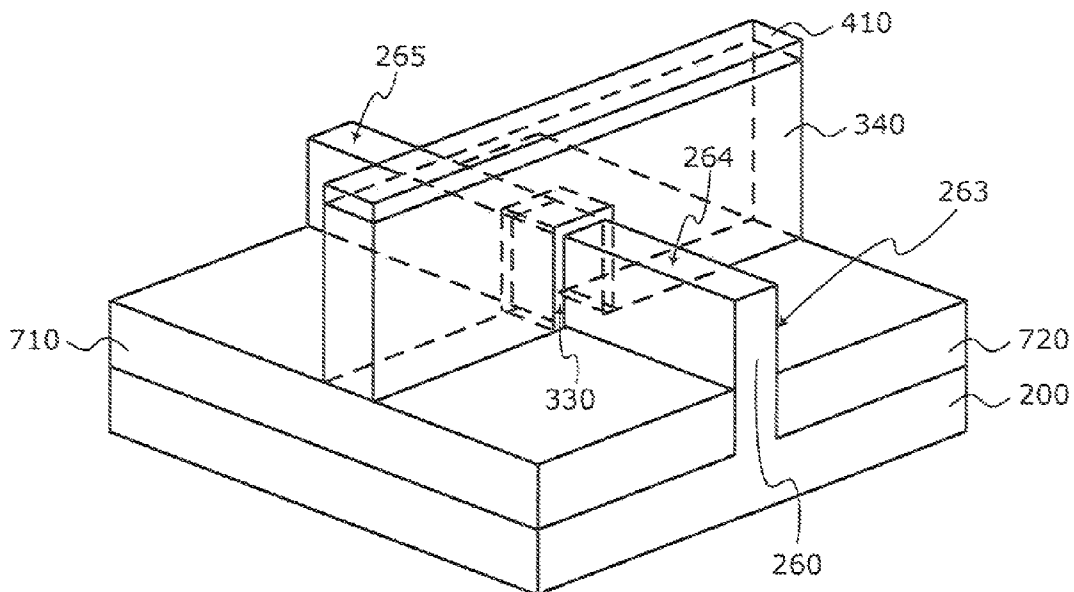


FIGURE 8B

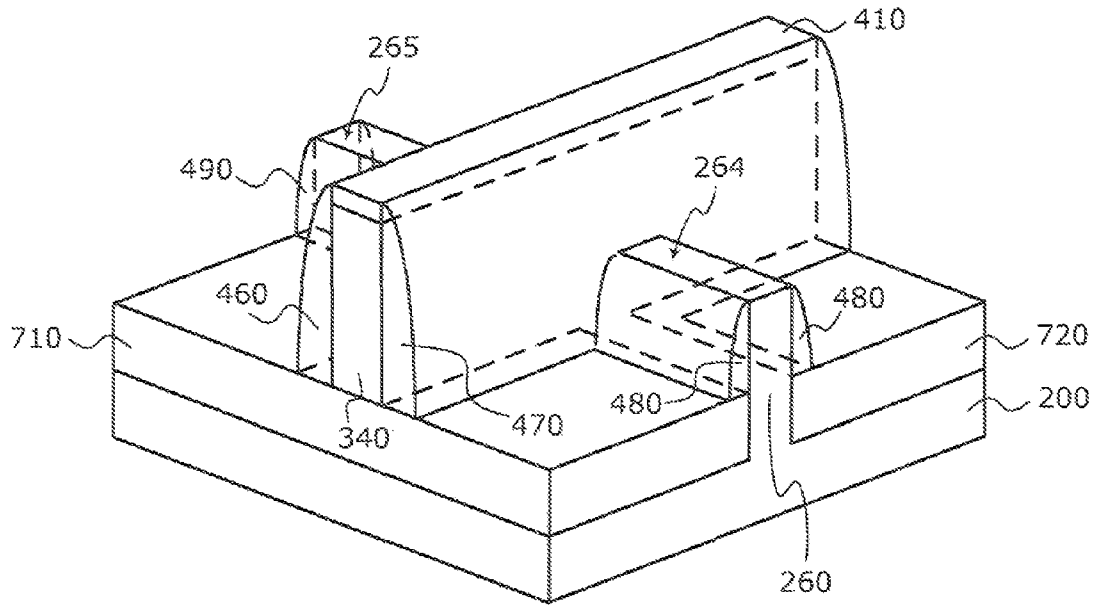


FIGURE 8C

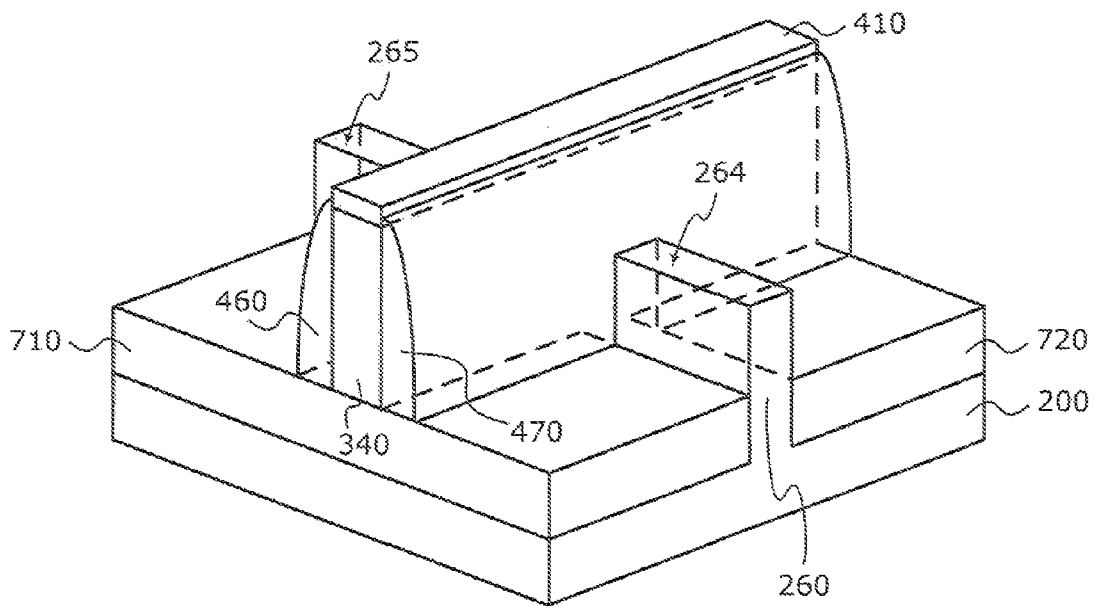


FIGURE 8D

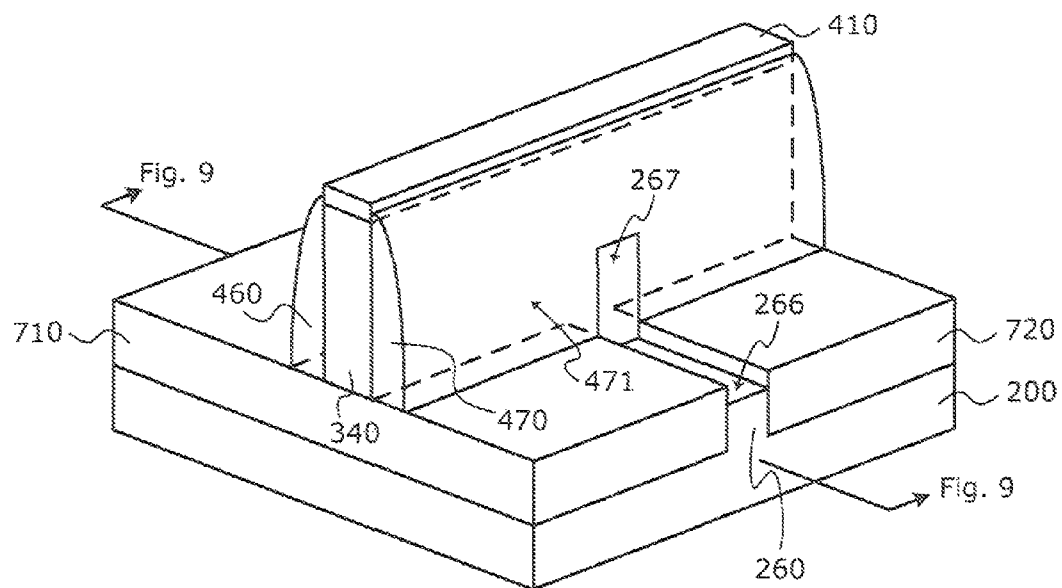


FIGURE 8E

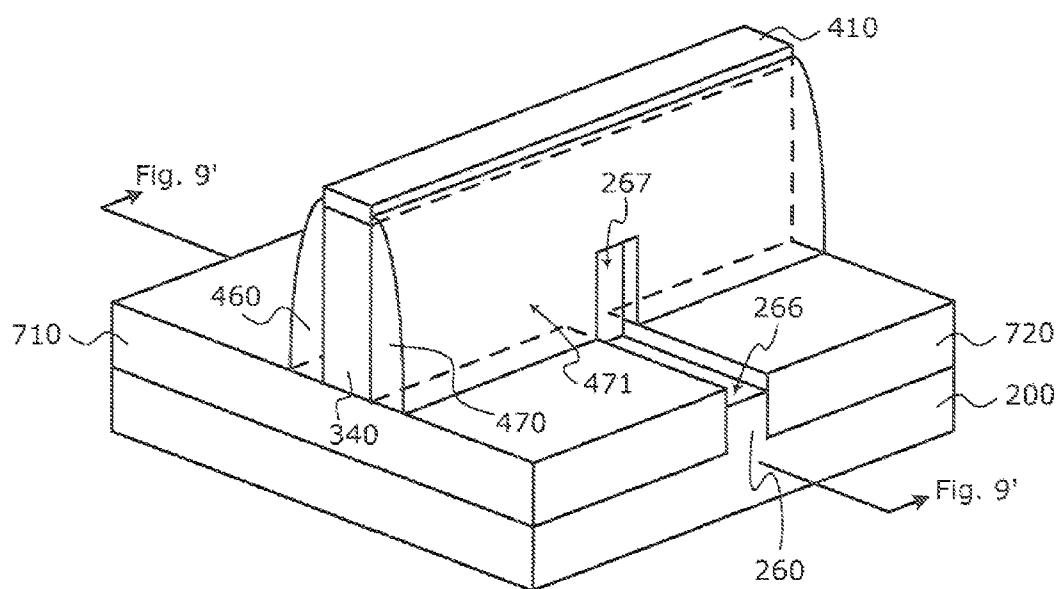


FIGURE 8E'

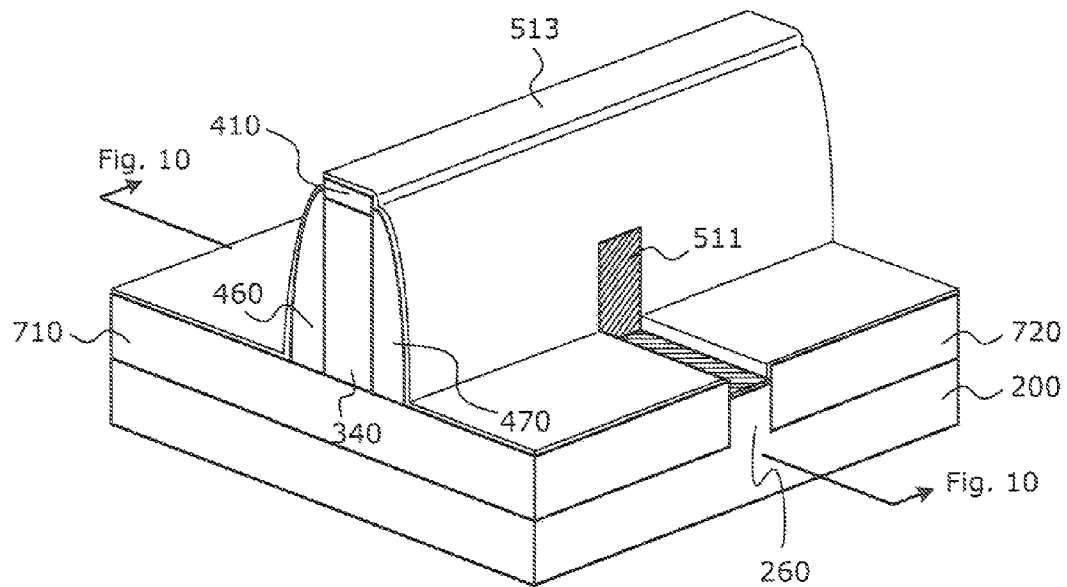


FIGURE 8F

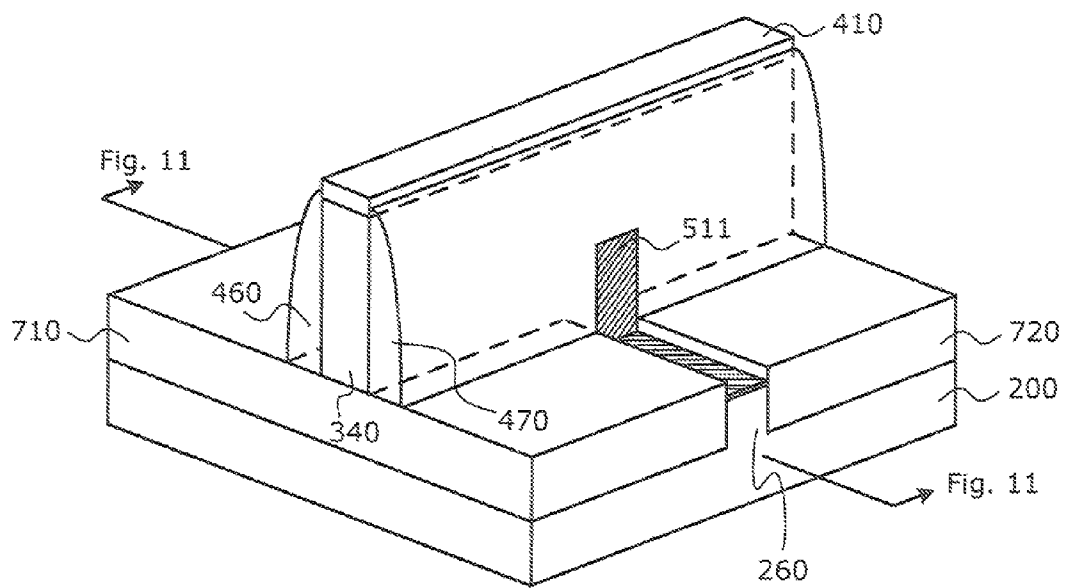


FIGURE 8G

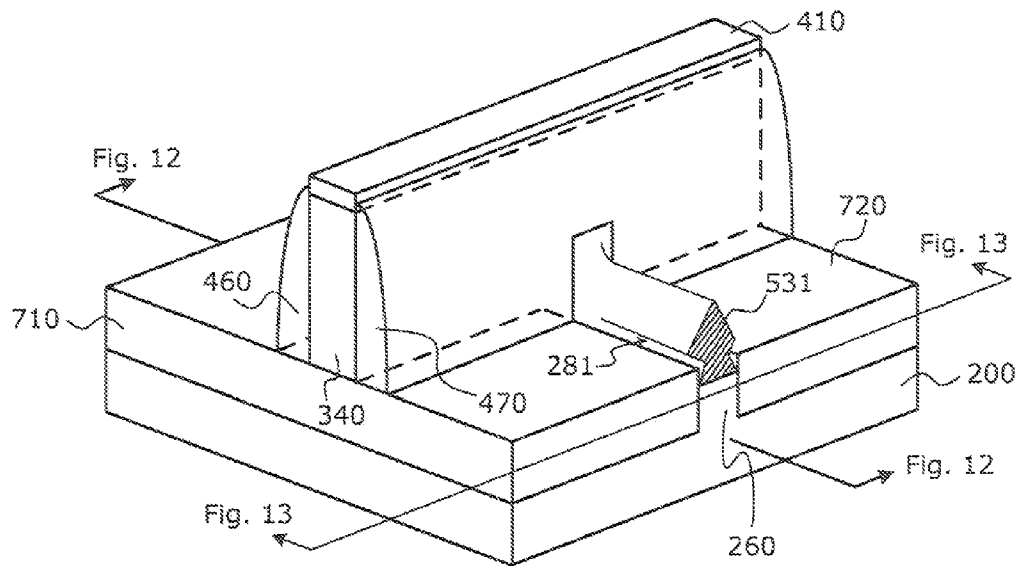


FIGURE 8H

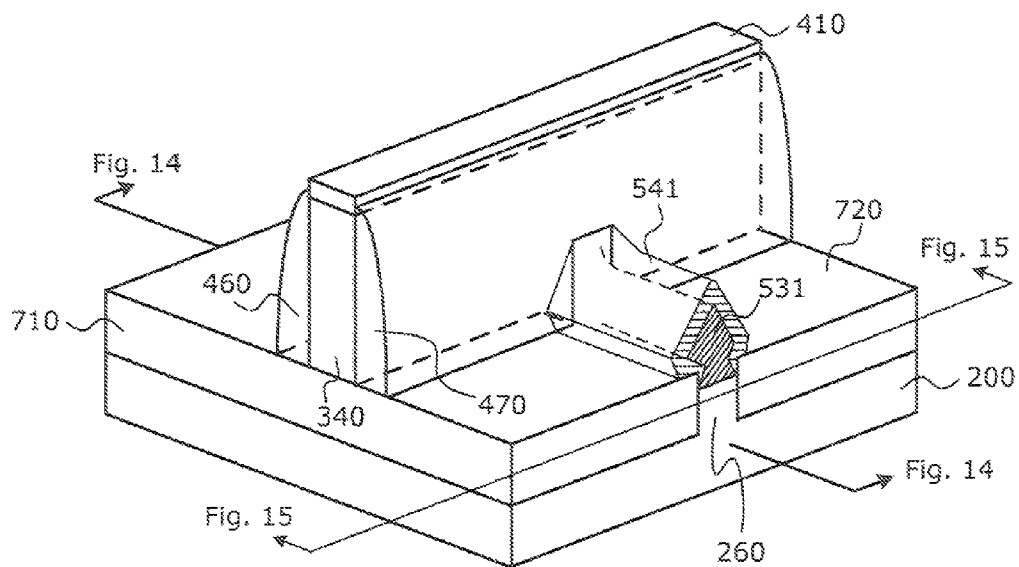


FIGURE 8I

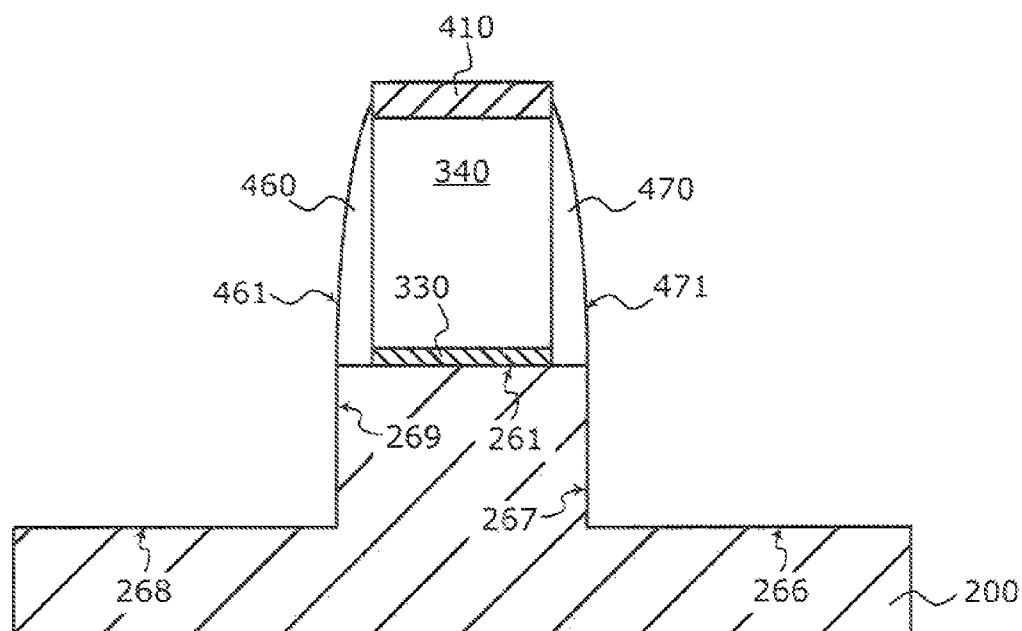


FIGURE 9

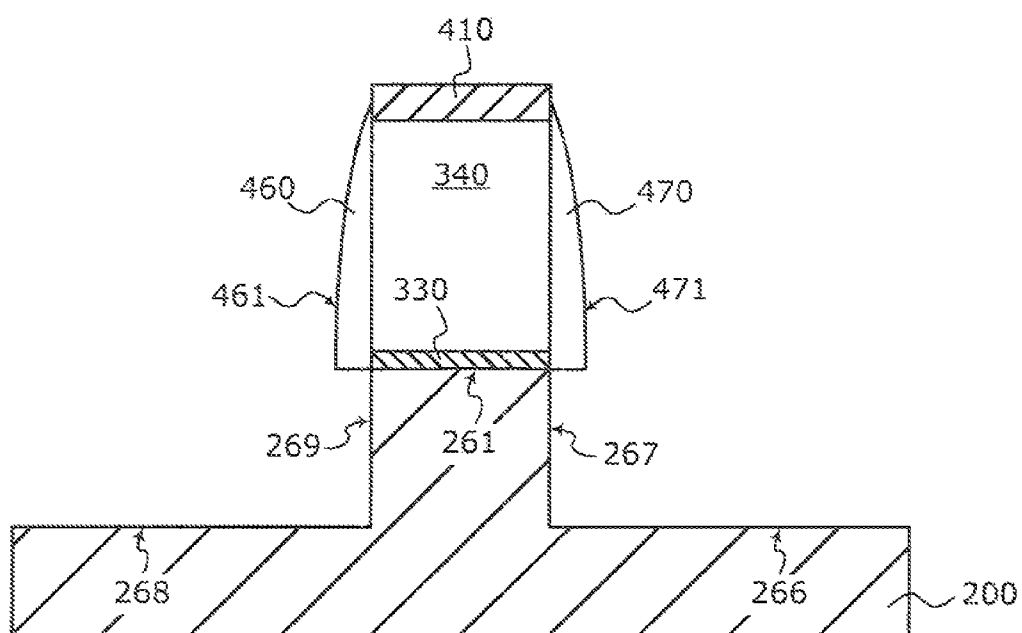


FIGURE 9'

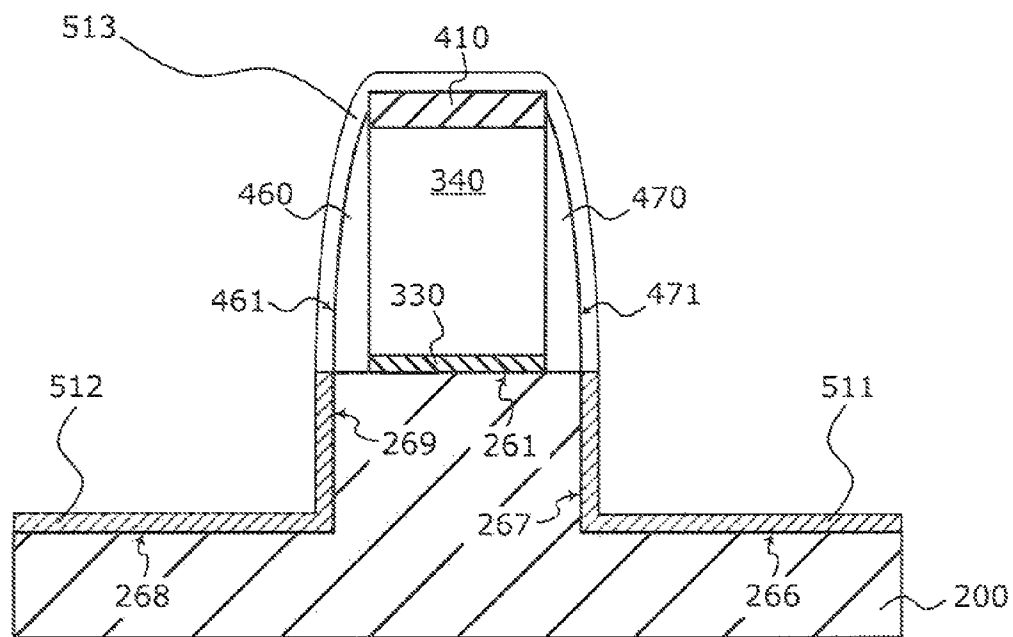


FIGURE 10

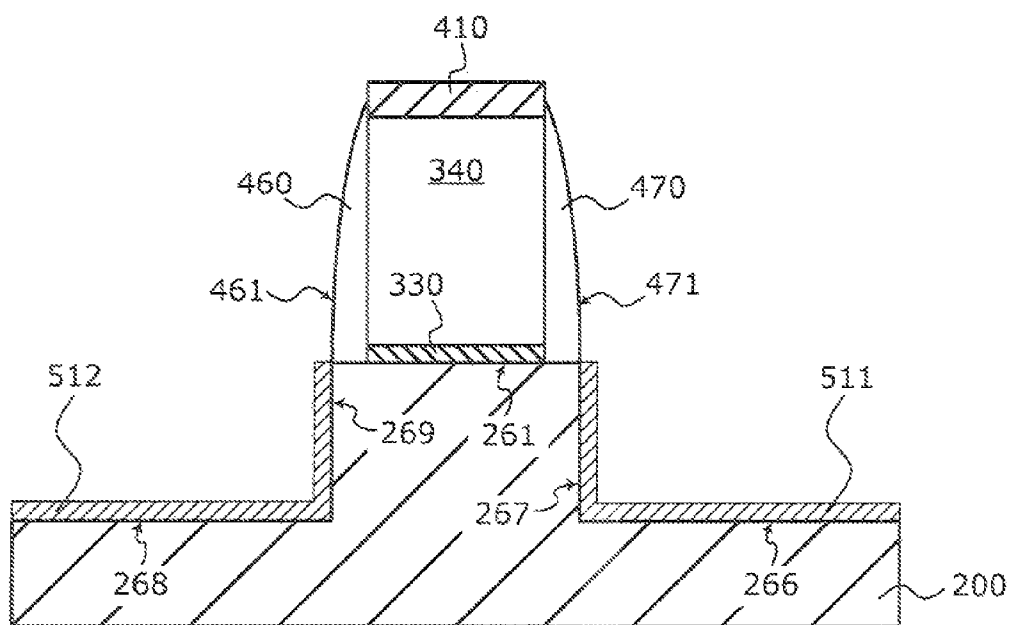


FIGURE 11

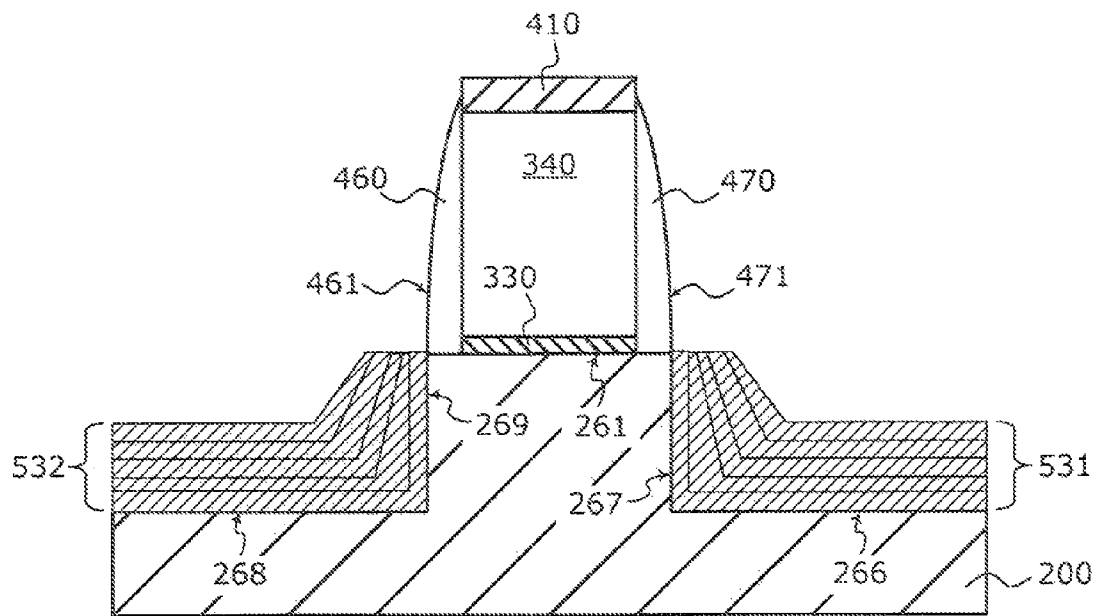


FIGURE 12

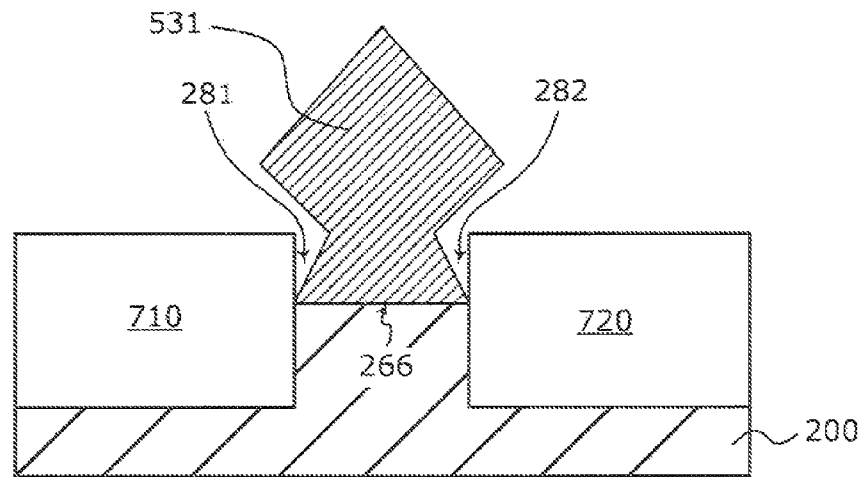


FIGURE 13

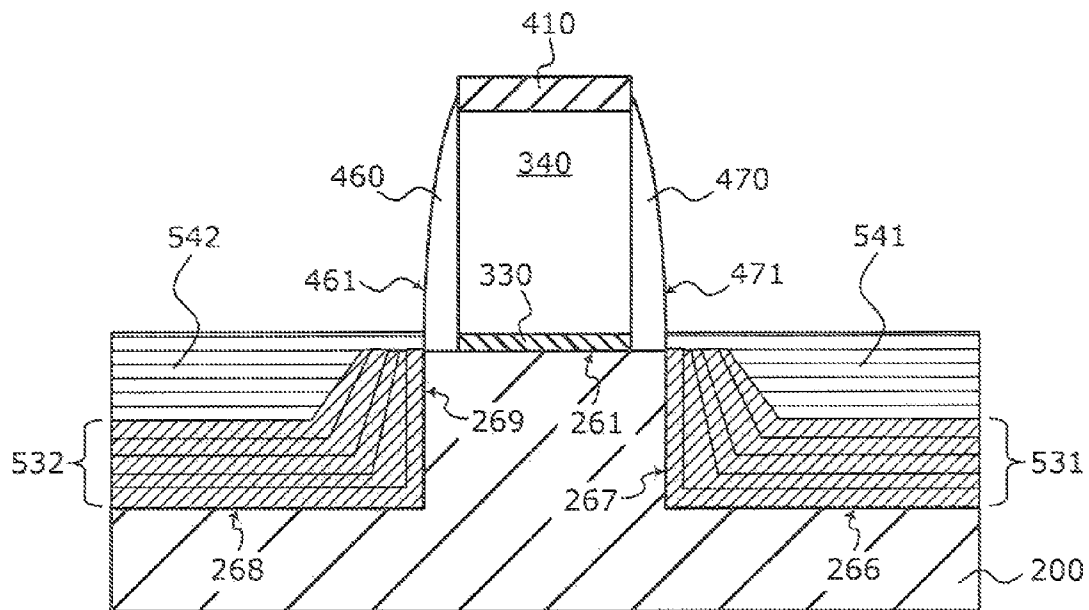


FIGURE 14

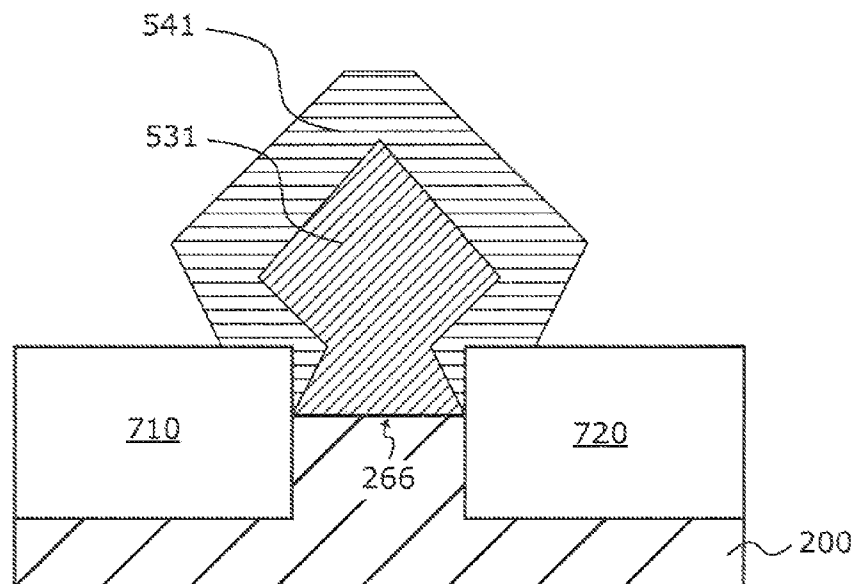


FIGURE 15

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SEMICONDUCTOR DEVICE HAVING DOPED
EPITAXIAL REGION AND ITS METHODS OF
FABRICATION

BACKGROUND

1. Field

The present invention relates to the field of semiconductor processing and more particularly to a semiconductor device having doped epitaxial regions and its methods of fabrication.

2. Discussion of Related Art

Increasing the performance of semiconductor devices, in particular transistors, has always been a major consideration in the semiconductor industry. For example, during the design and fabrication of metal oxide semiconductor field effect transistors (MOSFETs), it has always been a common goal to increase the electron mobility of the channel region and to reduce the parasitic resistance to improve device performance.

Other methods of improving device performance include, for example, reducing the overall resistance of the MOSFET by doping the region between the source/drain regions and the channel region, which is referred to as the 'tip' or source/drain extension regions of the MOSFET. For example, a dopant is implanted in the source/drain regions and an annealing step diffuses the dopant towards the channel region. However, there are limits to controlling the dopant concentration and location. Furthermore, the implant and diffusion method does not address the issues of lateral undercut or parasitic resistance at the tip regions.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a cross-sectional view that illustrates a semiconductor device in accordance with one embodiment of the present invention.

FIG. 2 is a cross-sectional view that illustrates a semiconductor device in accordance with another embodiment of the present invention.

FIG. 3 is a cross-sectional view that illustrates a semiconductor device in accordance with another embodiment of the present invention.

FIG. 4 is a perspective view that illustrates a semiconductor device in accordance with another embodiment of the present invention.

FIGS. 5A-5F are cross-sectional views that illustrate the method of fabricating the semiconductor device shown in FIG. 1.

FIGS. 6A-6F are cross-sectional views that illustrate the method of fabricating the semiconductor device shown in FIG. 2.

FIGS. 7A-7C are cross-sectional views that illustrate the method of fabricating the semiconductor device shown in FIG. 3.

FIGS. 8A-8I are perspective views that illustrate the method of fabricating the semiconductor device shown in FIG. 4.

FIGS. 9-15 are cross-sectional views of the semiconductor device shown in FIGS. 8E-8I.

FIG. 8E' is a perspective view that illustrates an alternative embodiment of the semiconductor device shown in FIG. 8E.

FIG. 9' is a perspective view that illustrates an alternative embodiment of the semiconductor device shown in FIG. 9.

DETAILED DESCRIPTION

A semiconductor device having doped epitaxial regions and its method of fabrication are described. In the following

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description, numerous specific details are set forth in order to provide a thorough understanding of the present invention. In other instances, well known semiconductor processing techniques and features have not been described in particular detail in order not to unnecessarily obscure the present invention.

Embodiments of the present invention describe a method of forming epitaxial regions on a semiconductor device. In one embodiment, the epitaxial region is an in-situ carbon and phosphorus doped silicon ($\text{Si}_3(\text{C,P})_{1-y}$) region deposited via cyclical deposition-etch process. Cavities created underneath the spacer during the cyclical deposition-etch process are backfilled by a very highly phosphorus doped silicon ($\text{Si}_3\text{P}_{1-y}$) epitaxial cap layer. The fabrication of the epitaxial region and cap layer stack in a Self-aligned Epi Tip (SET) architecture provides a dramatic transistor performance gain due to combined effects of increased electron mobility gain at channel region, reduced short channel effects (due to carbon suppressing phosphorus diffusion), and reduced parasitic resistance provided by very high phosphorus doping in the ($\text{Si}_3\text{P}_{1-y}$) epitaxial cap layer.

FIG. 1 illustrates a cross-sectional view of a semiconductor device in accordance with one embodiment of the present invention. The semiconductor device comprises a substrate 200 made of a semiconductor material such as, but not limited to, monocrystalline silicon. In one embodiment, the substrate 200 is the silicon film of a silicon on insulator (SOI) substrate, or a multi-layered substrate comprising silicon, silicon germanium, germanium, III-V compound semiconductors.

A gate dielectric 310 is formed over a channel region of the substrate 200. In one embodiment, the dielectric layer 310 is made from any well known insulative material, such as but not limited to silicon oxide (e.g., SiO_2). In another embodiment, the dielectric layer 310 is made of a high-k dielectric material having a substantially higher dielectric constant than silicon dioxide (i.e. $k > 3.9$). Examples of high-k dielectric materials include but are not limited to tantalum oxide (Ta_2O_5), titanium oxide (TiO_2) and hafnium oxide (HfO_2).

A gate electrode 320 is formed over the gate dielectric 310. In one embodiment, the gate electrode 320 is made of an well known materials, such as but not limited to polysilicon. In other embodiments, the gate electrode 320 is made of a metal or metal alloy material such as, but not limited to, platinum, tungsten or titanium.

In one embodiment, a hard mask 410 is formed on to of the gate electrode 320, in one embodiment, hard mask 410 is made of a material such as but not limited to silicon nitride or silicon oxynitride. Spacers 420, 440 are formed on opposite sidewalls of the gate electrode 320. In one embodiment, spacers 420, 440 are formed along the entire sidewall width of the gate electrode 320. Spacers 420, 440 comprise sidewalls 421, 441, and bottom surfaces 422, 442. In one embodiment, the spacers 420, 440 are made of a material such as but not limited to a silicon nitride, silicon dioxide or silicon oxynitride.

In an embodiment of the present invention, a recessed source interface 220 and a recessed drain interface 230 are formed on the substrate 200 at opposite sides of the gate electrode 320. In one embodiment, a portion of the recessed source interface 220 extends laterally beneath the bottom surface 422 of the spacer 420 and beneath a portion of the gate electrode 320. Similarly, a portion of the recessed drain interface 230 extends laterally beneath the bottom surface 442 of the spacer 440 and beneath a portion of the gate electrode 320.

A source region 501 is formed over the recessed source interface 220. In an embodiment of the present invention, the source region 501 comprises an epitaxial region 531 formed over the recessed source interface 220. A cap layer 541 is

formed over the epitaxial region **531**. The source region **501** comprises a source epi-tip region **503** that includes portions of the epitaxial region **531** and cap layer **541** formed directly beneath the spacer **420** and gate dielectric **310**

A drain region **502** is formed over the recessed drain interface **230**. In one embodiment, the drain region **502** comprises an epitaxial region **532** formed over the recessed drain interface **230**. A cap layer **542** is formed over the epitaxial region **532**. The drain region **502** comprises a drain epi-tip region **504** that includes portions of the epitaxial region **532** and cap layer **542** formed directly beneath the spacer **440** and gate dielectric **310**. By forming the source and drain epi-tip regions **503**, **504** in relatively close proximity to the channel region, a larger hydrostatic stress is induced on the channel region, resulting in higher electron mobility and increasing drive current.

In an embodiment of the present invention, the epitaxial regions **531**, **532** comprise silicon and carbon doped with phosphorus. In this case, the semiconductor device shown in FIG. 1 is a NMOS planar or trigate transistor with a Self-aligned Epi Tip (SET) architecture. In one embodiment, the epitaxial regions **531**, **532** comprise silicon having a carbon concentration of about 0.5 atomic % to 4 atomic % and a phosphorus concentration of about $9\text{E}19\text{ cm}^{-3}$ to $3\text{E}21\text{ cm}^{-3}$. In a specific embodiment, the epitaxial regions **531**, **532** comprise silicon having a carbon concentration of 2.2 atomic % and a phosphorus concentration of $2\text{E}20\text{ cm}^{-3}$. The substitutional carbon (over 2 atomic %) in the epitaxial regions **531**, **532** of the source and drain regions **501**, **502** impart hydrostatic stress on the channel region, which enhances electron mobility. Furthermore, the substitutional carbon suppresses any phosphorus diffusion during any subsequent thermal anneals, thus reducing short channel effects.

In an embodiment of the present invention, the cap layers **541**, **542** are epitaxial layers comprising silicon doped with phosphorus. In one embodiment, the cap layers **541**, **542** comprise silicon having a phosphorus concentration of about $8\text{E}19\text{ cm}^{-3}$ to $3\text{E}21\text{ cm}^{-3}$. In a specific embodiment, the cap layers **541**, **542** comprise silicon has phosphorus concentration of $2\text{E}21\text{ cm}^{-3}$. The high phosphorus concentration level in the cap layers **541**, **542** reduces parasitic resistance, particularly in contact resistance between salicide and source/drain regions **501**, **502**.

FIG. 2 illustrates a cross-sectional view of a semiconductor device similar to FIG. 1. The substrate **200** is made of {001} silicon, and comprises a recessed source interface **240** having a {111} facet **41** in the {111} crystallographic plane of the {001} silicon substrate **200**, and a recessed drain interface **250** having a {111} facet **251** in the {111} crystallographic plane of the {001} silicon substrate **200**. The {111} facets **241**, **251** provide reduced volume in depletion and corresponding improved control of short channel effects. In one embodiment, the recessed source and drain interfaces **240**, **250** each further comprises a {010} facet **242**, **252** in the {010} crystallographic plane of the {001} silicon substrate **200**, where the {010} facets **242**, **252** extend, directly beneath the gate electrode **320**. The {010} facets **242**, **252** contribute to more precisely defining the metallurgical channel length of the semiconductor device and reduce short channel effects.

Similar to FIG. 1, the semiconductor device shown in FIG. 2 comprises a source region **501** and a drain region **502**, each having an epitaxial region **531**, **532** and a cap layer **541**, **542**. Epitaxial regions **531**, **532** and cap layers **541**, **542** are formed over the recessed source and drain interfaces **240**, **250** including their {111} facets **241**, **251** and {010} facets **242**, **252**. The source region **501** comprises a source epi-tip region **505** that includes portions of the epitaxial region **531** and cap layer

541 surrounded by the spacer **420**, the gate dielectric **310** and the {111}, {010} facets **241**, **242**. The drain region **502** comprises a drain epi-tip region **506** that includes portions of the epitaxial region **532** and cap layer **541** surrounded by the spacer **440**, the gate dielectric **310** and the {111}, {010} facets **251**, **252**. Forming the source and drain epi-tip regions **505**, **506** in relatively close proximity to the channel region induces a larger hydrostatic stress on the channel region, thus increasing electron mobility which results in higher drive current.

FIG. 3 illustrates a cross-sectional view of a semiconductor device similar to FIG. 2. In one embodiment, the source and drain regions **501**, **502** each comprises an epitaxial layer **610**, **620** formed over the recessed source and drain interfaces **240**, **250** including their {111} facets **241**, **251** and {010} facets **242**, **252**.

The source region **501** comprises a source epi-tip region **611** that includes portions of the epitaxial layer **610** surrounded by the spacer **420**, the gate dielectric **310** and the {111}, {010} facets **241**, **242**. The drain region comprises a drain epi-tip region **621** that includes portions of the epitaxial layer **610** surrounded by the spacer **440**, the gate dielectric **310** and the {111}, {010} facets **251**, **252**. Forming the source and drain epi-tip regions **611**, **621** in relatively close proximity to the channel region induces a larger hydrostatic stress on the channel region, thus increasing electron mobility which results in higher drive current.

In an embodiment of the present invention, the epitaxial layer **610**, **620** comprises silicon doped with phosphorus. In one embodiment, the epitaxial layers **610**, **620** comprise silicon having a phosphorus concentration of about $8\text{E}19\text{ cm}^{-3}$ to $3\text{E}21\text{ cm}^{-3}$. In a specific embodiment the epitaxial layers **610**, **620** comprise silicon having a phosphorus concentration of $2\text{E}2\text{ cm}^{-3}$. The high phosphorus concentration level in the epitaxial layers **610**, **620** reduces parasitic resistance, particularly in contact resistance between salicide and source/drain regions **501**, **502**.

FIGS. 1, 2 and 3 illustrate the application of epitaxial regions in planar transistors to enhance electron mobility at the channel region or to reduce contact resistance at the source/drain regions. It can be appreciated that the epitaxial regions are not limited to planar transistors but can be fabricated on other devices, such as but not limited to a tri-gate transistor. FIG. 4 illustrates a perspective view of a tri-gate device comprising a substrate **200** having a semiconductor body or fin **260** (represented by dashed lines). A gate electrode **340** is formed over 3 surfaces of the fin **260** to form 3 gates. A hard mask **410** is formed on top of the gate electrode **340**. Gate spacers **460**, **470** are formed at opposite sidewalls of the gate electrode **340**. The source region comprises the epitaxial region **531** formed on a recessed source interface **266** and on a fin **260** sidewall. The cap layer **541** is deposited over the epitaxial region **531**.

FIGS. 5A-5F illustrate a method of forming the semiconductor device as discussed in relation to FIG. 1. The fabrication of the semiconductor device begins by providing the substrate **200** as shown in FIG. 5A. The gate dielectric **310** is formed over a desired, channel region of the substrate **200**. In one embodiment, the gate dielectric **310** is formed by any well known methods, such as but not limited to physical vapor deposition (PVD), chemical vapor deposition (CVD) or atomic layer deposition (ALD).

The gate electrode **320** is formed over the gate dielectric **310**. In an embodiment of the present invention, the gate electrode **320** is a sacrificial gate electrode that is subsequently replaced by an actual gate electrode in a replacement gate process. The hard mask **410** is formed on top of the gate

electrode **32**). In an embodiment of the present invention, gate electrode **320** and hard mask **410** are deposited using PVD or CVD, and then patterned using well known photolithography and etching techniques.

Spacers **420**, **440** are then formed on opposite sidewalls of the gate electrode **320**. Spacers **420**, **440** comprises sidewalls **421**, **441**, and bottom surfaces **422**, **442** that are formed on the top surface of the substrate **200**. In one embodiment, the spacers **420**, **440** are formed by using well known techniques, such as depositing a layer of spacer material over the entire substrate **200** including the gate electrode **320**, and then anisotropically etching the layer of spacer material to form the spacers **420**, **440** on the sidewalls of gate electrode **320**.

Next, a source region and a drain region are formed on the substrate **200**. In an embodiment of the present invention, fabrication of the source and drain regions begins by recessing portions of the substrate **200** using well known etching techniques, such as but not limited to dry etching or wet etching. In an embodiment of the present invention, a wet etching comprising an etchant chemistry that is substantially selective to the substrate **200** is utilized to recess the substrate **200** so as to form a recessed source interface **220** and a recessed drain interface **230** as shown in FIG. **5B**.

In one embodiment, the wet etching undercuts the spacers **420**, **440** and forms a source epi-tip cavity **271** between the bottom surface **422** of spacer **420** and the recessed source interface **220**, and forms a drain epi-tip cavity **272** between the bottom surface of spacer **440** and the recessed drain interface **230**. As a result, the source epi-tip cavity **271** and drain epi-tip cavity **272** expose the bottom surfaces **422**, **442** of the spacers **420**, **440**. In one embodiment, the source epi-tip cavity **271** and drain epi-tip cavity **272** also expose portions of the gate dielectric **310**. As a result, a portion of the recessed source interface **220** extends laterally beneath the spacer **420** and beneath a portion of the gate electrode **320**. Similarly, a portion of the recessed drain interface **230** extends laterally beneath the spacer **440** and beneath a portion of the gate electrode **320**.

It can be appreciated that the wet etching can be controlled (e.g. by adjusting the etching duration) so that the source and drain epi-tip cavities **271**, **272** do not expose the gate dielectric **310**. For instance, the recessed source interface **220** only extends laterally beneath the spacer **420**, and the recessed drain interface **230** only extends laterally beneath the spacer **440**.

In an embodiment of the present invention, the recessed source and drain interfaces **220**, **230** define the channel region of the semiconductor device. The channel region refers to the portion of the substrate **200** located directly beneath the gate dielectric **310** and between the recessed source and drain interfaces **220**, **230**.

Next, an epitaxial region is deposited over each of the recessed source and drain interfaces **220**, **230** by alternating exposing the substrate **200** to a first precursor and a second precursor. Fabrication of the epitaxial region begins, in FIG. **5C**, by exposing the entire substrate **200** to the first precursor so as to deposit epitaxial films **511**, **512** on the recessed source and drain interfaces **220**, **230**. In the case where the substrate **200** is made of monocrystalline silicon, the recessed source and drain interfaces **220**, **230** are monocrystalline surfaces that allow epitaxial growth of the epitaxial films **511**, **512** thereon. On the other hand, the hard mask **410**, the spacers **420**, **440**, and the gate dielectric **310** are non-crystalline surfaces. As a result, an amorphous layer **513** is deposited on the top surface of the hard mask **410**, on the sidewalls **421**, **441** and bottom surfaces **422**, **442** of the spacers **420**, **440**, and on portions of the bottom surface of the gate dielectric **310**.

In an embodiment of the present invention, the first precursor comprises a silicon-containing compound, a carbon-containing compound, and a dopant. In one embodiment, the silicon-containing compound includes, but not limited to, silanes and halogenated silanes. Such silicon-containing compound includes silane (SiH_4), disilane (Si_2H_6), trisilane (Si_3H_8), dichlorosilane (SiH_2Cl_2), and penta-chloro silane.

In one embodiment, the carbon-containing compound includes, but not limited to, organosilanes. For example, the carbon-containing compound comprises mono-methyl silane ($\text{CH}_3\text{—SiH}_3$). In one embodiment, the carbon-containing compound is mixed with hydrogen (H_2) or argon. For example, mono-methyl silane ($\text{CH}_3\text{—SiH}_3$) is mixed with hydrogen (H_2) or argon with the $\text{CH}_3\text{—SiH}_3$ concentration in the range of 0.5% to 20%.

In an embodiment of the present invention, the dopant is a n-type dopant such as, but not limited to, phosphorus or arsenic. In one embodiment, the Phosphorus dopant is incorporated in the epitaxial film using phosphine (PH_3) without any dilution in Hydrogen or an inert gas, such as N_2 or Ar. In another embodiment, the phosphine gas is mixed with hydrogen, for example as a mixture of 3% phosphine (PH_3) in hydrogen (H_2).

In one embodiment, the first precursor is delivered or released onto the substrate **200** with a carrier gas. In one embodiment, the carrier gas includes, but is not limited to, hydrogen (H_2), or any inert gas such as nitrogen (N_2) argon and helium and any combinations thereof.

In an embodiment of the present invention, the substrate **200** is exposed to the first precursor at a temperature of about 500 to 700 degrees Celsius, at a pressure of about 5 to 300 torr, and for a time duration of about 3 to 60 seconds. In a specific embodiment, the substrate **200** is exposed to the first precursor at a temperature of 600 degrees Celsius, at a pressure of 30 torr, and for a time duration of 15 seconds.

In one embodiment, the epitaxial films **511**, **512** are grown to have a thickness of about 6 to 100 Angstroms. In a specific embodiment, the epitaxial films **511**, **512** are grown to have a thickness of 50 Angstroms. In the case where the first precursor uses a phosphorus dopant, the deposited epitaxial films **511**, **512** are crystalline films containing silicon and carbon doped with phosphorus (i.e. in-situ carbon and phosphorus doped silicon layer). The amorphous layer **513** contains silicon and carbon doped with phosphorus.

An optional surface pre-treatment can be performed on the substrate **200** before exposing it to the first precursor to facilitate epitaxial growth and reduce surface defects. In an embodiment of the present invention, the surface pre-treatment includes a hydrogen bake treatment performed on the substrate **200** (in FIG. **5B**) to clean the recessed source and drain interfaces **220**, **230**. The hydrogen bake treatment desorbs oxygen and renders surface reconstruction so that the epitaxial films **511**, **512** can readily nucleate without formation of defects. In one embodiment, the hydrogen bake treatment is performed at around 700 to 1050 degrees Celsius for a duration of about 10 to 120 seconds. In an embodiment of the present invention, hydrogen chloride (HCl) is added to the hydrogen bake treatment. The hydrogen chloride (HCl) enables removal of about 1 to 3 monolayers of the recessed source and drain in surfaces **220**, **230** so that they are free of oxygen, hydrocarbons and any other contaminants. In one embodiment, the hydrogen bake treatment with hydrogen chloride (HC) is performed at a lower temperature of around 700 to 900 degrees Celsius for a duration of about 10 to 120 seconds. Alternatively chlorine (Cl_2), germane (GeH_4) or phosphine (PH_3) can be used as an additional or alternative chemical compound for hydrogen chloride (HCl).

In an alternative embodiment, the surface pretreatment utilizes an etch step to clean the recessed source and drain interfaces **220, 230**. In one embodiment, the etch step uses an etchant gas, such as but not limited to hydrogen (H_2), anhydrous hydrochloric acid (HCl), or a mixture of germane (GeH_4) and hydrogen (H_2). In another embodiment, the surface pre-treatment uses a combination of the etch step and the hydrogen bake treatment.

Before exposing the substrate **200** to the second precursor, a purging process can be performed to remove the first precursor and other by-products from the substrate **200**. In one embodiment, the purging process injects an inert gas, such as but not limited to nitrogen (N_2), helium or argon to remove any unreacted first precursor or by-products.

Next, in FIG. **5D**, the entire substrate **200** is exposed to the second precursor to remove the amorphous layer **513** from the sidewalls **421, 441** and bottom surfaces **422, 442** of the spacers **420, 440**. Furthermore, the second precursor also removes any amorphous layer **513** formed on the hard mask **410** and beneath the gate dielectric **310**. In one embodiment, the second precursor **900** uses an etchant chemistry that etches the amorphous layer **513** faster than the epitaxial films **511, 512**. In one embodiment, the second precursor **900** is an etchant gas, such as but not limited to hydrogen (H_2), anhydrous hydrochloric acid (HCl), and a mixture of germane (GeH_4) and hydrogen (H_2). Germane (GeH_4) enables etch through catalysis, thus providing high etch rate at low temperatures.

In one embodiment, the substrate **200** is exposed to the second precursor at a pressure of about 30 to 300 torr, and for a time duration of about 5 to 60 seconds. In a specific embodiment, the substrate **200** is exposed to the second precursor at a pressure of 80 torr, and for a time duration of 20 seconds. In one embodiment, the temperature is maintained at substantially the same level when exposing the substrate **200** to both the first precursor and the second precursor.

Due to the weak chemical bonding between the amorphous layer **513** and the hard mask **410**, spacers **420, 440** and gate dielectric **310**, the second precursor easily removes the amorphous layer **513** deposited thereon. The second precursor reacts with the amorphous layer **513** to convert it into by-product, thus removing the amorphous layer **513** from the hard mask **410**, spacers **420, 440** and gate dielectric **310**.

On the other hand, the epitaxial films **511, 512** have strong chemical bonds with the recessed source and drain interfaces **220, 230**. Due to the strong chemical bonds, only small portions of the epitaxial films **511, 512** are removed by the second precursor. In one embodiment, the thickness of the epitaxial films **511, 512** deposited during FIG. **5C** or the duration of exposing the second precursor to the substrate **200** in FIG. **5D** can be adjusted so as to effectively remove the amorphous layer **513** while maintaining sufficient thickness for the epitaxial films **511, 512**.

FIGS. **5C** and **5D** illustrate one deposition-etch cycle of forming the epitaxial films **511, 512** over the recessed source and drain interfaces **220, 230**. In one embodiment, the deposition-etch cycle is repeated using the same type of first and second precursors until a desired number of epitaxial films are deposited. For example, FIG. **5E** shows epitaxial regions **531, 532** containing ten epitaxial films each.

It can be appreciated that the epitaxial regions **531, 532** are not limited to only ten layers of epitaxial films each. In one embodiment, about 3 to 100 deposition-etch cycles are performed to form the epitaxial regions **531, 532**. In a specific embodiment, 30 deposition-etch cycles are performed to form the epitaxial regions **531, 532** having a thickness of around 30 nanometers.

In an embodiment of the present invention, the epitaxial regions **531, 532** are deposited with a graded concentration of carbon or phosphorus. The carbon and phosphorus concentration of each epitaxial film deposition can be optimized to provide optimal selectivity and defect-free epitaxy. Furthermore, the graded carbon or phosphorus concentration promotes the removal of the amorphous material during the deposition-etch cycles. In one embodiment, the graded carbon concentration of the epitaxial regions **531, 532** (shown in FIG. **5E**) begins at around 0.5 atomic % for the lowest epitaxial film and is gradually increased to a desired level of about 2 atomic % in the uppermost epitaxial film. In another embodiment, the graded phosphorus concentration level of the epitaxial regions **531, 532** begins at around $8E19\text{ cm}^{-3}$ for the lowest epitaxial film and is gradually increased to a desired level of around $2E21\text{ cm}^{-3}$ in the uppermost epitaxial film. In one embodiment, the epitaxial regions **531, 532** are deposited with a combination of graded carbon concentration (0.5-2 atomic %) and graded phosphorus concentration ($8E19$ - $2E21\text{ cm}^{-3}$).

The epitaxial regions **531, 532** are selectively formed over the recessed source and drain interfaces **220, 230** as shown in FIG. **5E**. However, the removal of the amorphous layer **513** during each deposition-etch cycle results in voids or cavities **281, 282** formed between the bottom surfaces **422, 442** of spacers **420, 440** and the top surfaces of the epitaxial regions **531, 532**. In one embodiment, the cavities **281, 282** also extend between portions of the gate dielectric **310** and the epitaxial regions **531, 532**. The cavities **281, 282** may cause detrimental effects on the transistor performance, and thus need to be eliminated. In an embodiment of the present invention, the cavities **281, 282** are substantially backfilled by cap layers **541, 542** selectively deposited over the epitaxial regions **531, 532** as shown in FIG. **5F**.

In an embodiment of the present invention, the cap layers **541, 542** are selectively deposited over the epitaxial regions **531, 532** in a single deposition process by exposing the substrate **200** to a third precursor. In one embodiment, the third precursor comprises the same silicon-containing compound and dopant of the first precursor, and the same etchant gas of the second precursor.

In the case where the epitaxial regions **531, 532** are crystalline films having silicon and carbon doped with phosphorus, the third precursor uses the same phosphorus dopant to form cap layers **541, 542**. The crystalline surfaces of the epitaxial layers **531, 532** allow epitaxial growth of cap layers **541, 542** thereon, and as a result, the cap layers **541, 542** are epitaxial layers containing silicon doped with phosphorus. Apart from backfilling the cavities, the phosphorus doped silicon cap layers **541, 542** provides an advantage of inducing tensile stress on the channel region, thereby increasing electron mobility and improving the device performance.

In one embodiment, a co-flown deposition technique is used to expose the substrate **200** to the silicon-containing compound, the dopant and the etchant gas at the same time. In one embodiment, the etchant gas does not include germane (GeH_4). During deposition, the etchant gas easily removes any silicon and phosphorus-containing compound that are weakly bonded on the hard mask **410** and spacers **420, 440** so that the cap layers **541, 542** are deposited over the epitaxial regions **531, 532** and not deposited on the hard mask **410** or the spacers **420, 440**.

In an embodiment of the present invention, the substrate **200** is exposed to the third precursor at a temperature of about 550 to 800 degrees Celsius, at a pressure of about torr to atmospheric pressure, and for a time duration of about 30 to 900 seconds. In a specific embodiment, the substrate **200** is

exposed to the first precursor at a temperature of 635 degrees Celsius, at a pressure of 600 torr, and for a time duration of 180 seconds. In one embodiment, the cap layers **541**, **542** are grown to have a thickness of about 50 to 500 Angstroms. In a specific embodiment, the cap layers **541**, **542** are grown to have a thickness of 300 Angstroms.

Portions of the epitaxial region **531** and cap layer **541** directly beneath the spacer **420** and gate dielectric **310** forms the source epi-tip region **503**. Similarly, portions of the epitaxial region **532** and cap layer **542** directly beneath the spacer **440** and gate dielectric **310** forms the drain epi-tip region **504**. By forming the source and drain epi-tip regions **503**, **504** in relatively close proximity to the channel region, a larger hydrostatic stress is induced on the channel region, resulting in higher electron mobility and increasing drive current. The stress can be further amplified by increasing the carbon concentrations of the source and drain epi-tip regions **503**, **504** during fabrication of the epitaxial regions **531**, **532**. Furthermore, the carbon concentrations of the source and drain epi-tip regions **503**, **504** also help to suppress any phosphorus diffusion during subsequent thermal anneals.

In an embodiment of the present invention, the gate electrode **320** is a sacrificial gate electrode that is subsequently replaced by an actual gate electrode in a replacement gate process. In one embodiment, the replacement gate process begins by depositing a mask on the cap layers **541**, **542** and then planarizing the mask to be coplanar with the hard mask **410** (not shown). Next, the hard mask **410** and gate electrode **320** are removed using well known etching techniques. After removing the hard mask **410** and gate electrode **320**, the actual gate electrode is then deposited on the gate dielectric **310**. In one embodiment, the actual gate electrode is a metal gate electrode comprising materials such as, but not limited to, platinum, tungsten or titanium. This completes the fabrication of the semiconductor device shown in FIG. 1.

FIGS. 6A-6F illustrate a method of forming the semiconductor device as discussed in relation to FIG. 2. The fabrication of the semiconductor device begins by providing the substrate **200** as shown in FIG. 6A. The semiconductor device shown in FIG. 6A is the same as FIG. 5A, and thus will not be discussed in detail. Briefly, the semiconductor device comprises the gate dielectric **310** formed over a desired channel region of the substrate **200**. The gate electrode **320** is formed over the gate dielectric **310**. In an embodiment of the present invention, the gate electrode **320** is a sacrificial gate electrode that is subsequently replaced by an actual gate electrode in a replacement gate process. Hard mask **410** is formed on top of the gate electrode and spacers **420**, **440** are formed at the sidewalls of the gate electrode **320**.

Next, a source region and a drain region are formed on the substrate **200**. In an embodiment of the present invention, fabrication of the source and drain regions begins by recessing portions of the substrate **200** using well known etching techniques, such as but not limited to dry etching or wet etching. In an embodiment of the present invention, a wet etching that is substantially selective to the substrate **200** is utilized to recess the substrate **200** so as to form a recessed source interface **240** and a recessed drain interface **250** as shown in FIG. 6B.

In an embodiment of the present invention, the substrate **200** is made of {001} silicon. The wet etch uses an etchant chemistry that etches the {001} silicon substrate **200** based on crystallographic direction, and in particular etches the {001} silicon substrate **200** much more slowly along its {111} crystallographic plane to form the {111} facets **241**, **251** as the etch proceeds much more rapidly in other crystallographic directions. As a result, a source epi-tip cavity **271** is formed

between the bottom surface **422** of spacer **420** and the {111} facet **241**. A drain epi-tip cavity **272** is formed between the bottom surface of spacer **440** and the {111} facet **251**.

The wet etch chemistry includes, but not limited to, an ammonia-based or amine-based etchant. Examples of ammonia-based etchants are ammonium hydroxide (NH₄OH), tetramethylammonium hydroxide (TMAH) and benzyltrimethylammonium hydroxide (BTMH). The wet etch chemistry includes other types of etchants, such as potassium hydroxide (KOH) and sodium hydroxide (NaOH).

In one embodiment, the wet etch further creates {010} facets **242**, **252** in the channel region of the {001} silicon substrate **200**. The {010} facets **242**, **252** extends directly beneath the gate dielectric **310**. In a specific embodiment, {010} facets **242**, **252** are formed up to a length of around 3 nanometers from the gate dielectric **310**.

Next, an epitaxial region is deposited over each of the recessed source and drain interfaces **240**, **250** by alternating exposing the substrate **200** to a first precursor and a second precursor. The method of fabricating the epitaxial region, as illustrated in FIGS. 6C, 6D and 6E, is similar to the methods of fabrication discussed in FIGS. 5C, 5D and 5E. Before exposing the substrate **200** to the first precursor, an optional surface pre-treatment can be performed on the substrate **200** to facilitate epitaxial growth and reduce surface defects. In one embodiment, the surface pre-treatment comprises a hydrogen bake treatment and/or etching step as previously discussed in FIG. 5C to clean the recessed source and drain interfaces **240**, **250**.

Beginning from FIG. 6C, the entire substrate **200** is exposed to the first precursor so as to deposit epitaxial films **511**, **512** on the recessed source and drain interfaces **240**, **250**. The recessed source and drain interfaces **240**, **250**, including their {111} facets **241**, **251** and {010} facets **242**, **252**, are monocrystalline surfaces that allow epitaxial growth of the epitaxial films **511**, **512** thereon. On the other hand, the hard mask **410**, the spacers **420**, **440**, and the gate dielectric **310** are non-crystalline surfaces, and thus the amorphous layer **513** is deposited thereon. The same first precursor and process conditions, as discussed in relation to FIG. 5C, are applicable here and will not be discussed.

Next in FIG. 6D, the entire substrate **200** is similarly exposed to the second precursor to remove the amorphous layer **513** from the sidewalls **421**, **441** and bottom surfaces **422**, **442** of the spacers **420**, **440**. Furthermore, the second precursor also removes any amorphous layer **513** formed on the hard mask **410** and beneath the gate dielectric **310**. The same second precursor and process conditions, as discussed in relation to FIG. 5D, are applicable here and will not be discussed.

FIGS. 6C and 6D illustrate one deposition-etch cycle of forming the epitaxial films **511**, **512** over the recessed source and drain interfaces **240**, **250** including their {111} facets **241**, **251** and {010} facets **242**, **252**. The deposition-etch cycle is repeated until a desired number of epitaxial films are deposited. For illustration purposes, FIG. 6E shows epitaxial regions **531**, **532** containing ten epitaxial films each. In an embodiment of the present invention, the epitaxial regions **531**, **532** are deposited with a graded concentration of carbon or phosphorus as previously described in FIG. 5E. For example, the epitaxial regions **531**, **532** (shown in FIG. 6E) are deposited with a graded carbon concentration of around 0.5 atomic % for the lowest epitaxial film and are gradually increased to a desired level of about 2 atomic % for the uppermost epitaxial film. Alternatively, the epitaxial regions **531**, **532** are deposited with a graded phosphorus concentration level of around 8E19 cm⁻³ for the lowest epitaxial film

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and are gradually increased to a desired level of around $2\text{E}21\text{ cm}^{-3}$ for the uppermost epitaxial film. In one embodiment, the epitaxial regions **531**, **532** are deposited with a combination of graded carbon concentration (0.5-2 atomic %) and graded phosphorus concentration ($8\text{E}19\text{-}2\text{E}21\text{ cm}^{-3}$).

The removal of the amorphous layer **513** during each deposition-etch cycle similarly results in cavities **281**, **282** formed between the bottom surfaces **422**, **442** of spacers **420**, **440** and the top surfaces of the epitaxial regions **531**, **532**. The cavities **281**, **282** are substantially backfilled by the cap layers **541**, **542** selectively deposited over the epitaxial regions **531**, **532** as shown in FIG. 6F.

In one embodiment, the cap layers **541**, **542** are selectively deposited over the epitaxial regions **531**, **532** in a single deposition process by exposing the substrate **200** to a third precursor. The same third precursor and process conditions, as discussed in relation to FIG. 5F, are applicable here. In the case where the epitaxial regions **531**, **532** are crystalline films having silicon and carbon doped with phosphorus, the third precursor uses the same phosphorus dopant to form cap layers **541**, **542**. The crystalline surfaces of the epitaxial regions **531**, **532** allow epitaxial growth of cap layers **541**, **542** thereon, and as a result, the cap layers **541**, **542** are epitaxial layers containing silicon doped with phosphorus. This completes the fabrication of the semiconductor device shown in FIG. 2.

FIGS. 7A-7C illustrate a method of forming the semiconductor device as discussed in relation to FIG. 3. Beginning from FIG. 7A, the fabrication of the semiconductor device begins by providing the substrate **200**. The semiconductor device shown in FIG. 7A is the same as FIG. 5A, and thus will not be discussed here.

Next, a source region and a drain region are formed on the substrate **200**. In an embodiment of the present invention, fabrication of the source and drain regions begins by recessing portions of the substrate **200** using well known etching techniques, such as but not limited to dry etching or wet etching. In one embodiment, the wet etching used in FIG. 6B is similarly applied here to recess the substrate **200** so as to form a recessed source interface **240** and a recessed drain interface **250**, as shown in FIG. 7B. The wet etch uses the same etchant chemistry as described in relation to FIG. 6B to form $\{111\}$ facets **241**, **251** in the $\{111\}$ crystallographic plane of the $\{001\}$ silicon substrate **200**. In one embodiment, the wet etch further creates $\{010\}$ facets **242**, **252** in the channel region of the $\{001\}$ silicon substrate **200**.

Next epitaxial layers **610**, **620** are selectively deposited over the recessed source and drain interfaces **240**, **250** as shown in FIG. 7C. In an embodiment of the present invention, the epitaxial layers **610**, **620** are selectively deposited in a single deposition process by exposing the substrate **200** to a precursor comprising an etchant gas.

In one embodiment, the precursor comprises the silicon-containing compound and dopant similarly described in FIG. 5C. In one embodiment the silicon-containing compound includes, but not limited to, silanes and halogenated silanes. Such silicon-containing compound includes silane (SiH_4), disilane (Si_2H_6), trisilane (Si_3H_8), dichlorosilane (SiH_2Cl_2), and penta-chloro silane. In an embodiment of the present invention, the dopant is a n-type dopant such as, but not limited to, phosphorus or arsenic. In one embodiment, the phosphorus dopant is introduced into the epitaxial layers using phosphine (PH_3) without any dilution in Hydrogen or an inert gas, such as N_2 or Ar. In another embodiment, the phosphine gas is mixed with hydrogen, for example as a mixture of 3% phosphine (PH_3) in hydrogen (H_2). In one

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embodiment, the etchant gas of the precursor includes, but is not limited to hydrogen (H_2) and anhydrous hydrochloric acid (HCl).

In one embodiment, a co-flown deposition technique is used to deliver the precursor, including the etchant gas to the substrate **200** at the same time. In one embodiment, the substrate **200** is exposed to the precursor at a temperature of about 550 to 800 degrees Celsius, at a pressure of about 10 torr to atmospheric pressure, and for a time duration of about 30 to 2000 seconds. In a specific embodiment, the substrate **200** is exposed to the first precursor at a temperature of 635 degrees Celsius, at a pressure of 600 torr, and for a time duration of 800 seconds.

In one embodiment, the epitaxial layers **610**, **620** are grown to have a thickness of about 30 to 2000 Angstroms. In a specific embodiment, the epitaxial layers **610**, **620** are grown to have a thickness of 750 Angstroms. In the case where a phosphorus dopant is used, the epitaxial layers **610**, **620** comprise silicon doped with phosphorus.

In the case where the substrate **200** is made of monocrystalline silicon, the recessed source and drain interfaces **240**, **250** including their $\{111\}$ facets **241**, **251** and $\{010\}$ facets **242**, **252** are monocrystalline surfaces that allow epitaxial growth of the epitaxial layers **610**, **620** thereon. Since the hard mask **410** and spacers **420**, **440** have non-crystalline surfaces, the etchant gas easily removes any silicon and phosphorus-containing compound that are weakly bonded on the hard mask **410** and spacers **420**, **440** during deposition so that the epitaxial layers **610**, **620** are deposited over the recessed source and drain interfaces **240**, **250** and not deposited on the hard mask **410** or spacers **420**, **440**.

Portions of the epitaxial layer **610** deposited between the spacer **420** and $\{111\}$, $\{010\}$ facets **241**, **242** form the source epi-tip region **611**. Similarly, portions of the epitaxial layer **620** deposited between the spacer **440** and $\{111\}$, $\{010\}$ facets **251**, **252** form the drain epi-tip region **621**. By forming the source and drain epi-tip regions **611**, **621** in relatively close proximity to the channel region, a larger hydrostatic stress is induced on the channel region, resulting in higher electron mobility. Furthermore, the phosphorus doped silicon epitaxial layers **610**, **620** induces tensile stress on the channel region, thereby increasing electron mobility and improving the device performance. This completes the fabrication of the semiconductor device shown in FIG. 3.

In addition, an optional surface pre-treatment can be performed on the substrate **200** before exposing it to the precursor to facilitate epitaxial growth and reduce surface defects. For example, a similar hydrogen bake treatment described in relation to FIG. 5C is performed on the substrate **200** (in FIG. 7B) to clean the recessed source and drain interfaces **240**, **250** including their $\{111\}$ facets **241**, **251** and $\{010\}$ facets **242**, **252**.

FIGS. 8A-8I illustrate a method of forming the tri-gate device as discussed in relation to FIG. 4. The fabrication of the tri-gate device begins by providing the substrate **200** as shown in FIG. 8A. The substrate **200** comprises a semiconductor body or fin **260** extending from the substrate **200** through the isolation regions **710**, **720**. In one embodiment, the isolation regions **710**, **720** are shallow trench isolation (STI) regions formed by common techniques, such as etching the substrate **200** to form trenches, and then depositing oxide material onto the trenches to form the STI regions. The isolation regions **710**, **720** are made from any well known insulative material, such as but not limited to silicon oxide (e.g., SiO_2).

In one embodiment, the fin **260** comprises a top surface **261** above the isolation regions **700**. The fin **260** further includes

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a front surface 262 exposed above the isolation region 710, and a back surface 263 exposed above the isolation region 720. In one embodiment, the fin 260 is made from the same semiconductor materials as the substrate 200.

Next, in FIG. 8B, a gate dielectric 330 is formed over a portion of the top surface 261, the front surface 262 and the back surface 263. In one embodiment, the gate dielectric 330 is formed by any well known methods, such as but not limited to physical vapor deposition (PVD), chemical vapor deposition (CVD) or atomic layer deposition (ALD).

Then, a gate electrode 340 is formed over the gate dielectric 330, and exposing portions 264, 265 of the fin 260 at either sides of the gate electrode 340. In one embodiment, the gate electrode 340 is made of any well known materials, such as but not limited to polysilicon. The gate electrode 340 formed over the top surface 261, the front surface 262 and the back surface 263 creates three gates for the tri-gate device. The hard mask 410 is then formed on top of the gate electrode 320.

Next, gate spacers 460, 470 are deposited on opposite sidewalls of the gate electrode 340 as shown in FIG. 5C. In one embodiment, the spacers 460, 470 are formed by using well known techniques, such as depositing a layer of spacer material over the entire substrate 200 including the gate electrode 320, and then anisotropically etching the layer of spacer material to form the spacers 460, 470 on the sidewalls of gate electrode 340. At the same time, fin spacers 480, 490 are formed on the sidewalls of the exposed portions 264, 265 of the fin 260. In one embodiment, the gate spacers 460, 470 and fin spacers 480, 490 are made of a material such as but not limited to a silicon nitride, silicon dioxide or silicon oxynitride.

Next, a source region and a drain region are formed on the substrate 200. In an embodiment of the present invention, fabrication of the source and drain regions begins in FIG. 8D by removing the fin spacers 480, 490 from the sidewalls of the exposed portions 264, 265 of the fin 260. The fin spacers 480, 490 are removed by well known etching techniques, such as but not limited to dry etching or wet etching.

In one embodiment, an anisotropic wet-etch is used to completely remove the fin spacers 480, 490 from the exposed portions 264, 265 of the fin 260. At the same time, the anisotropic wet-etch also removes portions of the gate spacers 460, 470, thus exposing portions of the hard mask 410 sidewalls. Since the gate spacers 460, 470 have a larger height and thickness than the fin spacers 480, 490, the anisotropic wet-etch removes the fin spacers 480, 490 faster than the gate spacers 460, 470. The anisotropic wet-etch can be controlled to completely remove the fin spacers 480, 490 but leaving sufficient thickness of the gate spacers 460, 470 on the gate electrode 340 so that the gate electrode 340 sidewalls are not exposed.

Next, an etching is performed on the substrate 200 to recess the exposed portions 264, 265 of the fin 260. In an embodiment of the present invention, the etching uses an etchant chemistry that is substantially selective to the fin 260 to recess the exposed portion 264 so as to form a recessed source interface 266 below the top surface of the isolation regions 710, 720, and to form a fin sidewall 267 as shown in FIG. 8E. On the other side of the gate electrode 340, the exposed portion 264 is recessed to form a recessed drain interface 268 and a fin sidewall 269. In one embodiment, the recessed source and drain interfaces 266, 268 are about 100 to 400 Angstroms below the top surface of the isolation regions 710, 720.

FIG. 9 illustrates a cross-sectional view of the tri-gate device showing the fin sidewall 267 extending from the top surface 261 to the recessed source interface 266, and the fin

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sidewall 269 extending from the top surface 261 to the recessed drain interface 268. In an embodiment of the present invention, the fin sidewalls 267, 269 are substantially coplanar or flushed with the gate spacers 460, 470 sidewalls 461, 471. In one embodiment, the fin sidewalls 267, 269 are {110} facets in the {110} crystallographic plane of the substrate 200, and the recessed source and drain interfaces 266, 268 are {100} facets in the {100} crystallographic plane of the substrate 200.

In an alternative embodiment, an isotropic etch is used to form fin sidewalls 267, 269 recessed within the gate spacers 460, 470. FIG. 8E' is a perspective view of the tri-gate device showing the fin sidewall 267 recessed within the gate spacer 470. FIG. 9' is a cross-sectional view showing both the fin sidewalls 267, 269 recessed beneath the gate spacer 460, 470. In one embodiment the fin sidewalls 267, 269 are recessed until about 25 to 200 Angstroms from the gate spacer sidewalls 461, 471.

Continuing from FIG. 8E, an epitaxial region is then deposited over each of the recessed source and drain interfaces 266, 268 by alternating exposing the substrate 200 to a first precursor and a second precursor. The method of fabricating the epitaxial region, as illustrated in FIGS. 8F, 8G and 8H, is similar to the methods of fabrication discussed in FIGS. 5C, 5D and 5E.

Beginning from FIG. 8F, the entire substrate 200 is exposed to the first precursor so as to deposit an epitaxial film 511 on the recessed source interface 266 and fin sidewall 267. At the same time, an epitaxial film 512 is deposited on the recessed drain interface 268 and fin sidewall 269 as shown in cross-sectional view of FIG. 10. The recessed source and drain interfaces 266, 268, and the fin sidewalls 267, 269, are monocrystalline surfaces that allow epitaxial growth of the epitaxial films 511, 512 thereon. On the other hand, the hard mask 410, the gate spacers 460, 470, and isolation regions 710, 720 are non-crystalline surfaces, and thus the amorphous layer 513 is formed thereon. The same first precursor and process conditions, as discussed in relation to FIG. 5C, are applicable here and will not be discussed.

Next, in FIG. 8G, the entire substrate 200 is similarly exposed to the second precursor to remove the amorphous layer 513 from the gate spacers 460, 470, and isolation regions 710, 720. Furthermore, the second precursor also removes any amorphous layer 513 formed on the hard mask 410. FIG. 11 shows a cross-sectional view of the tri-gate device after the amorphous layer 513 has been removed. The same second precursor and process conditions, as discussed in relation to FIG. 5D, are applicable here and will not be discussed.

FIGS. 8F-8G and FIGS. 10-11 illustrate one deposition-etch cycle of forming the epitaxial films 511, 512 over the recessed source and drain interfaces 266, 268 and the fin sidewalls 267, 269. The deposition-etch cycle is repeated until a desired number of epitaxial films are deposited. In one embodiment, the final epitaxial regions 531, 532 comprise five epitaxial films as shown in FIG. 12. In an embodiment of the present invention, the epitaxial regions 531, 532 are deposited with a graded concentration of carbon or phosphorus as previously described in FIG. 5E. For example, the epitaxial regions 531, 532 (shown in FIG. 12) are deposited with a graded carbon concentration of around 0.5 atomic % for the lowest epitaxial film and are gradually increased to a desired level of about 2 atomic % for the uppermost epitaxial film. Alternatively, the epitaxial regions 531, 532 are deposited with a graded phosphorus concentration level of around $8 \times 10^{19} \text{ cm}^{-3}$ for the lowest epitaxial film and are gradually increased to a desired level of around $2 \times 10^{21} \text{ cm}^{-3}$ for the

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uppermost epitaxial film. In one embodiment, the epitaxial regions **531**, **532** are deposited with a combination of graded carbon concentration (0.5-2 atomic %) and graded phosphorus concentration ($8E19-2E21\text{ cm}^{-3}$)

In the alternative embodiment where the fin sidewalls **267**, **269** are recessed within the gate spacers **460**, **470**, the epitaxial regions **531**, **531** are formed in closer proximity to the channel region of the tri-gate device, thus inducing a higher amount of stress on the channel region.

The removal of the amorphous layer **513** during each deposition-etch cycle similarly results in voids or cavities **281**, **282** formed between the epitaxial regions **531**, **532** and the isolation regions **710**, **720** as shown in FIGS. **8H** and **13**. The cavities **281**, **282** are substantially backfilled by the cap layers **541**, **542** selectively deposited over the epitaxial regions **531**, **532** as shown in FIGS. **8I**, **14** and **15**.

In one embodiment, the cap layers **541**, **542** are selectively deposited over the epitaxial regions **531**, **532** in a single deposition process by exposing the substrate **200** to a third precursor. The same third precursor and process conditions, as discussed in relaxation to FIG. **5F**, are applicable here in the case where the epitaxial regions **531**, **532** are crystalline films having silicon and carbon doped with phosphorus, the third precursor uses the same phosphorus dopant to form cap layers **541**, **542**. The crystalline surfaces of the epitaxial regions **531**, **532** allow epitaxial growth of cap layers **541**, **542** thereon, and as a result, the cap layers **541**, **542** are epitaxial layers containing silicon doped with phosphorus. The phosphorus doped silicon cap layers **541**, **542** provide an advantage of inducing tensile stress on the channel region of the semiconductor fin **260**, which increases the electron mobility and improves the device performance. This completes the fabrication of the semiconductor device shown in FIG. **4**.

Several embodiments of the invention have thus been described. However, those ordinarily skilled in the art will recognize that the invention is not limited to the embodiments described, but can be practiced with modification and alteration within the spirit and scope of the appended claims that follow.

We claim:

1. A method of forming a semiconductor device comprising:

providing a substrate having a gate electrode, and a spacer formed on the sidewall of the gate electrode;
etching the substrate to form a recessed interface;
forming an epitaxial region over the recessed interface by alternating exposing the substrate to a first precursor and a second precursor, wherein the alternating exposing the substrate to the first precursor and the second precursor comprises:

exposing the substrate to the first precursor to deposit an epitaxial film over the recessed interface, and to deposit an amorphous layer on the sidewall and bottom surface of the spacer;

exposing the substrate to the second precursor to remove the amorphous layer from the sidewall and bottom surface of the spacer; and

selectively depositing a cap layer over the epitaxial region.

2. The method of claim 1, wherein the first precursor comprises a silicon-containing compound comprising silane; a carbon-containing compound comprising organosilane; and a dopant comprising phosphorus.

3. The method of claim 2, wherein the epitaxial region comprises silicon and carbon doped with phosphorus.

4. The method of claim 1, wherein the second precursor is an etchant gas.

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5. The method of claim 1, wherein forming the epitaxial region over the recessed interface results in a void between the epitaxial region and the bottom surface of the spacer; and wherein the cap layer backfills the void.

6. The method of claim 1, wherein the cap layer is selectively deposited over the epitaxial region by exposing the substrate to a third precursor, the third precursor comprising a silicon-containing compound comprising silane; a dopant comprising phosphorus; and an etchant gas.

7. The method of claim 6, wherein the cap layer comprises silicon doped with phosphorus.

8. The method of claim 1, further comprising: performing a hydrogen bake treatment on the substrate before alternating exposing the substrate to a first precursor and a second precursor.

9. The method of claim 1, wherein etching the substrate to form a recessed interface comprises:

performing a wet etch to form a $\{111\}$ facet in the $\{111\}$ crystallographic plane of the substrate.

10. The method of claim 9, wherein the wet etch forms a $\{010\}$ facet in the $\{010\}$ crystallographic plane of the substrate.

11. The method of claim 9, wherein the wet etch uses an etchant chemistry selected from the group consisting of potassium hydroxide (KOH), sodium hydroxide (NaOH), an ammonia-based etchant or an amine-based etchant.

12. A method of forming a semiconductor device comprising:

providing a substrate having a gate electrode, and a first spacer and a second spacer formed on opposite sidewalls of the gate electrode;

etching the substrate to form a recessed source interface and a recessed drain interface; and

selectively depositing a first epitaxial layer over the recessed source interface and

a second epitaxial layer over the recessed drain interface by alternating exposing the substrate to a first precursor and a second precursor,

wherein the alternating exposing the substrate to the first precursor and the second precursor comprises:

exposing the substrate to the first precursor to deposit an epitaxial film over the recessed interface, and to deposit an amorphous layer on the sidewall and bottom surface of each of the first and second spacers;

exposing the substrate to the second precursor to remove the amorphous layer from the sidewall and bottom surface of each of the first and second spacers.

13. The method of claim 12, wherein the precursor comprises a silicon-containing compound comprising silane; and a dopant comprising phosphorus.

14. The method of claim 13, wherein both the first and second epitaxial layers comprises silicon doped with phosphorus.

15. The method of claim 12, wherein etching the substrate to form a recessed source interface and a recessed drain interface comprises:

performing a wet etch to form a $\{111\}$ facet in the $\{111\}$ crystallographic plane of the substrate at the recessed source interface and the recessed drain interface.

16. The method of claim 15, wherein the wet etch forms a $\{010\}$ facet in the $\{010\}$ crystallographic plane of the substrate at the recessed source interface and the recessed drain interface.

17. The method of claim 15, wherein the wet etch uses an etchant chemistry selected from the group consisting of

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potassium hydroxide (KOH), sodium hydroxide (NaOH), an ammonia-based etchant or an amine-based etchant.

18. A method of forming a semiconductor device comprising:

- providing a substrate having an insulation layer thereon, 5
- and a semiconductor body that extends from the substrate through the insulation layer;
- forming a gate electrode over a portion of the semiconductor body, thereby defining an exposed portion of the 10 semiconductor body;
- depositing a gate spacer on a sidewall of the gate electrode;
- etching the exposed portion of the semiconductor body to form a first surface recessed below the top surface of the insulation layer, and a second surface coplanar with the 15 gate spacer;
- forming an epitaxial region on the first surface and second surface by alternating exposing the substrate to a first precursor comprising and a second precursor,
- wherein the alternating exposing the substrate to the first 20 precursor and the second precursor comprises:
- exposing the substrate to the first precursor to deposit an epitaxial film over the recessed interface, and to deposit an amorphous layer on the sidewall and bottom surface of the spacer;
- 25 exposing the substrate to the second precursor to remove the amorphous layer from the sidewall and bottom surface of the spacer; and
- selectively depositing a cap layer over the epitaxial region.

19. The method of claim **18**, wherein depositing the gate spacer on the sidewall of the gate electrode comprises:

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depositing body spacers on the sidewalls of the exposed portion of the semiconductor body.

20. The method of claim **19**, further comprising:

removing the body spacers from the sidewalls of the exposed portion of the semiconductor body prior to etching the exposed portion of the semiconductor body.

21. The method of claim **18**, further comprising:

etching the second surface so that the second surface is recessed within the gate spacer.

22. The method of claim **18**, wherein forming an epitaxial region on the first surface and second surface results in a void between the epitaxial region and the insulation layer; and wherein the cap layer backfills the void.

23. The method of claim **18**, wherein the first precursor comprises a silicon-containing compound comprising silane; a carbon-containing compound comprising organosilane; and a dopant comprising phosphorus.

24. The method of claim **23**, wherein the epitaxial region comprises silicon and carbon doped with phosphorus.

25. The method of claim **18**, wherein the second precursor is an etchant gas.

26. The method of claim **18**, wherein the cap layer is selectively deposited over the epitaxial region by exposing the substrate to a third precursor, the third precursor comprising a silicon-containing compound comprising silane; a dopant comprising phosphorus; and an etchant gas.

27. The method of claim **26**, wherein the cap layer comprises silicon doped with phosphorus.

* * * * *

UNITED STATES PATENT AND TRADEMARK OFFICE
CERTIFICATE OF CORRECTION

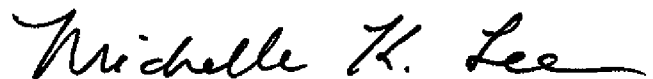
PATENT NO. : 8,598,003 B2
APPLICATION NO. : 12/643912
DATED : December 3, 2013
INVENTOR(S) : Anand S. Murthy et al.

Page 1 of 1

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

Title page Item (75), inventors: please delete "Murtthy" and insert --Murthy--

Signed and Sealed this
Eleventh Day of August, 2015

A handwritten signature in black ink, reading "Michelle K. Lee". The signature is written in a cursive style with a long horizontal flourish at the end.

Michelle K. Lee
Director of the United States Patent and Trademark Office

UNITED STATES PATENT AND TRADEMARK OFFICE
CERTIFICATE OF CORRECTION

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Page 1 of 1

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

Title page Item (12), delete “Murtthy et al.” and insert --Murthy et al.--

Title page Item (75), inventors: please delete “Murtthy” and insert --Murthy--

This certificate supersedes the Certificate of Correction issued August 11, 2015.

Signed and Sealed this
Seventeenth Day of November, 2015

A handwritten signature in black ink, reading "Michelle K. Lee". The signature is fluid and cursive, with the first letters of each name being capitalized and prominent.

Michelle K. Lee
Director of the United States Patent and Trademark Office