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(54) **Title:** THIN FILM ELECTROLYTE FOR THIN FILM BATTERIES

(57) **Abstract:** The invention relates to a solid-state lithium-ion thin-film electrolyte that, compared to the current state-of-the-art thin-film electrolyte, Lipon, exhibits an equal or larger electrochemical stability window (0-5.5 V vs. Li⁺/Li), an equal or smaller electronic conductivity (10⁻¹⁴ S/cm at 25°C), the same ideal transference number for Li⁺ ions (t=1.000), and a 10x higher Li⁺ ion conductivity at -400C. Latter provides thin-film batteries (TFBs) with at least a 5x higher power performance at -400C over the current state-of-the-art Lipon TFBs.

THIN FILM ELECTROLYTE FOR THIN FILM BATTERIES

RELATED APPLICATIONS

[0001] The present application is related to and claims the benefit under 35 U.S.C. § 119 of U.S. provisional patent application Ser. No. 61/022,904, entitled "Thin Film Electrolyte for Thin Film Batteries," filed January 23, 2008, and is a continuation-in-part, and claims the benefit under 35 U.S.C. § 120, of U.S. patent application Ser. No. 12/339,361, entitled "Method for Sputter Targets for Electrolyte Films," filed December 19, 2008, which claims the benefit under 35 U.S.C. § 119 of U.S. provisional patent application Ser. No. 61/016,038, entitled "Method for Sputter Targets for Electrolyte Films," filed December 21, 2007, all of which are incorporated herein in their entirety by reference.

FIELD OF THE INVENTION

[0002] The present invention relates to a solid-state lithium-ion thin-film electrolyte with, for example, increased lithium ion conductivity that lends itself preferably to higher power performance and extended shelf life in thin-film batteries and a method of fabricating the electrolyte.

BACKGROUND OF THE INVENTION

[0003] Solid-state lithium-ion thin-film batteries (TFBs) that are configured with a Lipon (Lithium phosphorus oxynitride—a potent lithium-ion thin-film electrolyte having the formula of $\sim\text{Li}_{3.1}\text{PO}_{3.3}\text{N}_{0.5}$) electrolyte exhibit acceptable internal cell resistances over a wide temperature range while showing electrochemical stability in contact with very reducing electrodes, such as the metallic lithium anode, and very oxidizing electrodes, such as a charged $\text{Li}_{0.5}\text{CoO}_2$ cathode at 4.2V versus Li/Li^+ . In addition, Lipon has one of the lowest electronic conductivities of all known room-temperature lithium-ion electrolytes, thereby providing Lipon TFBs with a 10+ year shelf-life and an extremely low capacity loss per year (<1%) under ambient conditions.

[0004] Currently known lithium compounds, however, have internal cell impedances that can become undesirably large when Lipon TFBs are operated below 0°C , and in particular when employed in the -40°C range, such as required in military or aerospace applications and by other government agencies. This characteristic is due to the bulk ionic conductivity of the Lipon electrolyte and its charge transfer resistances at both the cathode and the anode interface becoming undesirably large at low temperatures. The inverse of the

internal cell impedance, the current rate capability of a cell, for instance, may be rated at 50 mA at 25°C in the 4.2–2.0V voltage window for a standard single-cell 1 in² TFB while increasing to more than 2000 mA for a few seconds at 100°C, but may be limited to 0.3 mA at -40°C.

5 **[0005]** From these performance data points, there exists a need to equip TFBs with an alternative, improved solid-state lithium-ion thin-film electrolyte. Particularly, there is a need for an electrolyte that possesses an equal or better electrochemical stability than Lipon versus highly reducing and oxidizing electrodes while providing a substantially enhanced low temperature performance.

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SUMMARY OF THE INVENTION

[0006] The solid-state thin-film electrolyte of the present invention preferably exhibits, for example when compared to Lipon, an equal or larger electrochemical stability window (0–5.5 V vs. Li⁺/Li), an equal or smaller electronic conductivity (10⁻¹⁴ S/cm at 15 25°C), the same ideal transference number for Li⁺ ions (t = 1.000), and an equal or higher Li⁺ ion conductivity over the entire envisioned operation range of the battery (-50°C to +200°C).

[0007] In one embodiment of the present invention, a solid-state, inorganic electrolyte with glassy or amorphous morphology shows a lithium-ion conductivity of greater than 5*10⁻⁶ S/cm at 25°C and has a chemical composition comprising at least the elements 20 lithium, oxygen, nitrogen, and at least one element selected from the group of aluminum, silicon, phosphorus, sulfur, scandium, yttrium, lanthanum, zirconium, magnesium, and calcium. In a further embodiment, this electrolyte may be chemically stable in contact with metallic lithium. The electrolyte may also be chemically stable in contact with positive cathode materials that are charged to at least +3.9V versus a metallic lithium reference 25 electrode.

[0008] In another embodiment, the electrolyte may comprise a thickness of less than 5µm. In a further embodiment, the electrolyte may comprise a change in chemical composition between one electrolyte interface and the opposing other.

[0009] In another embodiment of the present invention, a method for fabricating, by 30 physical vapor deposition (PVD), a solid-state, inorganic electrolyte is described. The method may be utilized to fabricate an electrolyte with glassy or amorphous morphology with lithium ion conductivity of greater than 5*10⁻⁶ S/cm at 25°C and a chemical composition comprising at least the elements lithium, oxygen, nitrogen, and at least one element selected from the group of aluminum, silicon, phosphorus, sulfur, scandium, yttrium, lanthanum,

zirconium, magnesium, and calcium. The method may further comprise changing the chemical composition of the electrolyte from one electrolyte interface to the other.

[0010] In another embodiment of the present invention, a specific glassy or amorphous electrolyte with the composition $\text{Li}_3(\text{Sc}_{2-x}\text{M}_x)(\text{PO}_{4-y}\text{N}_z)_3$ wherein $\text{M} = \text{Al}$ and/or Y , $x \leq 2$, $z \leq 8/3$, and $2y = 3z$ is provided, as described herein in greater detail below.

[0011] In yet another embodiment of the present invention, a specific glassy or amorphous electrolyte with the composition $\text{Li}_{8-3.5x}\text{P}_{1.5x}\text{Zr}_{1-x}\text{O}_{6-y}\text{N}_z$ wherein $x \leq 0.8$, $z \leq 4$, and $2y = 3z$ is provided, as described herein in greater detail below.

[0012] In yet another embodiment of the present invention, a specific glassy or amorphous electrolyte with the composition $\text{Li}_{8-3x}\text{La}_x\text{ZrO}_{6-y}\text{N}_z$ wherein $0 < x \leq 2$, $z \leq 4$, $2y = 3z$ is provided, as described herein in greater detail below.

[0013] In yet another embodiment of the present invention, a specific glassy or amorphous electrolyte with the composition $\text{Li}_{6-0.75x}\text{P}_{1.75x}\text{Zr}_{2-2x}\text{O}_{7-y}\text{N}_z$ wherein $x \leq 0.8$, $z \leq 14/3$, and $2y = 3z$ is provided, as described herein in greater detail below.

[0014] In yet another embodiment of the present invention, a specific glassy or amorphous electrolyte with the composition $\text{Li}_{3-3x}\text{P}_{1-x}\text{Al}_x\text{O}_{4-4x-y}\text{N}_{x+z}$ wherein $0 < x \leq 0.6$, $y \leq 1.6$, and $2y = 3z$ is provided, as described herein in greater detail below.

[0015] It is to be understood that both the foregoing general description and the following detailed description are exemplary and explanatory only and are not restrictive of the invention, as claimed.

DETAILED DESCRIPTION OF THE INVENTION

[0016] It is to be understood that the present invention is not limited to the particular methodology, compounds, materials, manufacturing techniques, uses, and applications described herein, as these may vary. It is also to be understood that the terminology used herein is used for the purpose of describing particular embodiments only, and is not intended to limit the scope of the present invention. It must be noted that as used herein and in the appended claims, the singular forms “a,” “an,” and “the” include the plural reference unless the context clearly dictates otherwise. Thus, for example, a reference to “an element” is a reference to one or more elements and includes equivalents thereof known to those skilled in the art. Similarly, for another example, a reference to “a step” or “a means” is a reference to one or more steps or means and may include sub-steps and subservient means. All conjunctions used are to be understood in the most inclusive sense possible. Thus, the word “or” should be understood as having the definition of a logical “or” rather

than that of a logical “exclusive or” unless the context clearly necessitates otherwise. Structures described herein are to be understood also to refer to functional equivalents of such structures. Language that may be construed to express approximation should be so understood unless the context clearly dictates otherwise.

5 **[0017]** Unless defined otherwise, all technical and scientific terms used herein have the same meanings as commonly understood by one of ordinary skill in the art to which this invention belongs. Preferred methods, techniques, devices, and materials are described, although any methods, techniques, devices, or materials similar or equivalent to those described herein may be used in the practice or testing of the present invention. Structures
10 described herein are to be understood also to refer to functional equivalents of such structures.

[0018] All patents and other publications identified are incorporated herein by reference for the purpose of describing and disclosing, for example, the methodologies described in such publications that might be used in connection with the present invention.
15 These publications are provided solely for their disclosure prior to the filing date of the present application. Nothing in this regard should be construed as an admission that the inventors are not entitled to antedate such disclosure by virtue of prior invention or for any other reason.

[0019] A wide electrochemical stability window can preferably be achieved when
20 basing the chemical composition of the electrolyte of the present invention on a group of principal materials that are known to be either thermodynamically stable with, or least kinetically inert against (in other words, a reaction does not occur due to the existence of a large enough activation energy hindrance between the reaction candidates), metallic lithium or highly oxidizing environments or, most preferably, against both. Then, these base
25 materials may be subjected to a combinatorial chemistry screening, that is, specific compositions of PVD fabricated multinary-element electrolyte compositions, and perhaps also multinary phases, of the principal group materials may be tested electrochemically in asymmetric polarization cells (Li/electrolyte/polarizable metal electrode) using the Hebb-Wagner method (see, for instance, Neudecker et al., 143 J. Electrochem. Soc. 2198 (1996)
30 and Yu et al., 144 J. Electrochem. Soc. 524 (1997)) and cyclic voltammetry (see, for instance, Appetecchi et al., 145 J. Electrochem. Soc. 4126 (1998) and Abraham et al., 147 J. Electrochem. Soc. 1251 (2000)).

[0020] The PVD combinatorial chemistry screening may be easily and inexpensively accomplished by employing, for example, a magnetron sputter target (sputter-

up configuration) that may be composed of a selected and readily available principal material, for instance Li_3PO_4 , upon which flat pressed powder pellets of one or more different principal materials are placed. The so-constructed multinary element target may then be magnetron-sputtered, which will deposit a specific multinary film composition onto a given substrate.

5 **[0021]** The group of preferred principal materials comprise, but are not limited to, Li_5AlO_4 , Li_4SiO_4 , Li_2SiO_3 , Li_3PO_4 , Li_2SO_4 , LiScO_2 , LiYO_2 , LiLaO_2 , $\text{Li}_6\text{Zr}_2\text{O}_7$, Li_8ZrO_6 , Al_2O_3 , SiO_2 , P_2O_5 , Y_2O_3 , La_2O_3 , ZrO_2 , Li_2O , MgO , and CaO (cf., Neudecker et al., 143 J. Electrochem. Soc. 2198 (1996)). The PVD deposition of these materials may preferably result in predominantly glassy or amorphous thin films (e.g., materials that exhibit a
10 crystallinity / crystallographic long-range order of about 0 – 100 Å or more) whose composition may be further modified and fine-tuned by the introduction of, for example, preferably, nitride doping through variations in the sputter atmosphere, such as, for instance, sputtering in Ar/N_2 mixtures.

[0022] To maximize the power performance of a thin cell battery, it is preferred to
15 keep the internal cell resistance as small as possible. Thickness of the thin-film electrolyte is one factor that can contribute to internal cell resistance. For example, the internal cell resistance of a Lipon cell at 25°C increases by at least a factor of three when going from 1µm Lipon to 5µm Lipon. Thus, it is preferable to have an electrolyte layer of a minimum thickness. In addition, thin-film layers are fairly cost-sensitive compared to battery
20 materials/layers fabricated by wet chemistry, such as the cell phone batteries.

[0023] An electrolyte in a TFB may, for example, preferably be only about 1µm thick. Due to this thinness, particularly in a TFB that is, for example, equipped with a metallic lithium anode, the electrolyte is preferably not crystalline or exhibit any substantial grain boundary morphology. Such a condition may allow or potentially cause metallic
25 lithium anode material to creep along the electrolyte grain boundaries and eventually reach the cathode, thereby resulting in a short-circuit within the TFB. The reason for this potential creep tendency of metallic lithium along the grain boundaries of the electrolyte lies in the higher impurity concentration and off-composition in those electrolyte locations with which the metallic lithium partially reacts while forming pathways for additional metallic lithium to
30 follow. This creep phenomenon is analogous to dendrite growth in liquid or polymeric electrolyte technology.

[0024] Although some embodiments of the present invention contain a single-phase electrolyte material that preferably can withstand direct contact (i.e., among other things, avoid the creeping problem discussed above) to both the highly reducing anode and the

highly oxidizing cathode in high-performance TFBs, other embodiments contain a graded or stepped thin-film electrolyte composition to serve this purpose. This graded or stepped electrolyte may be designed to be stable with, or inert against, metallic lithium at the anode interface while gradienting or step-changing its composition in a suitable manner along its thickness axis, thereby rendering it stable with, or inert against, a highly oxidizing cathode such as, for example, one that is charged to at least +3.9V in comparison to a metallic lithium reference electrode. The gradienting or composition stepping may be accomplished, for example, through sputter depositing the thin-film electrolyte either from one sputter target by changing the sputter gas composition or by using more than one sputter targets over which the growing thin-film electrolyte is placed in a sequential or alternating manner. Relative to the finished electrolyte film, the graded principle was realized by Eveready (Jones et al., 53-56 Solid State Ionics 628 (1992)) and ORNL (Bates, U.S. Pat. No. 5,314,765 (1994)) by interposing a protection layer between the reducing anode and the solid state electrolyte, which could be considered an electrolyte with different interface compositions.

[0025] A further, in certain circumstances, relatively important or useful property of the electrolyte of the present invention is, for example, its potential increased Li^+ ion conductivity compared to Lipon. This increased Li^+ ion conductivity may provide TFBs with a much improved low temperature power performance. The theory for solid-state lithium-ion electrolytes was mainly developed between about 1970–1995; the latter date being associated with the introduction of the Lipon electrolyte into TFBs. In this time frame, papers on entirely inorganic, solid-state Li^+ ion electrolytes from A.R. West, R.A. Huggins, C.C. Liang, P. Hagemuller, J. B. Bates, and M. Greenblatt (to name a few) taught certain techniques for building those electrolytes and how to change the parameters of the Li^+ ion conductivity, which in turn is given by

$$\sigma_{\text{Li}^+} = A/T * \exp (-E_a/RT)$$

wherein σ_{Li^+} is the Li^+ ion conductivity at a given temperature T[K], R represents the gas constant while the factor A denotes the pre-exponential factor, a measure for the theoretically maximally achievable Li^+ ion conductivity. This conductivity would be realized if the activation enthalpy for Li^+ ion conduction, E_a (chemical barrier inside the electrolyte network for Li^+ ion conduction), did not exist in the solid-state glass (or crystalline) network of the electrolyte, which then under TFB operation would allow all Li^+ ion jump attempts from one electrolyte network site to another to become successful.

[0026] In the instant thin-film electrolyte compositions of certain embodiments, the activation enthalpy for Li^+ ion conduction E_a may be reduced by adequate electrolyte network

vacancy and interstitial doping approaches (e.g., aliovalent doping of Li_3PO_4 with Li_4SiO_4) as well as by reducing the pinning electrostatic forces (e.g., replacing some of the more electronegative oxide ions by less electronegative nitride ions, as very successfully realized in Lipon over Li_3PO_4) that the Li^+ ion encounters when moving through the electrolyte network.

5 Because all sputter deposited thin-film electrolyte compositions may, in certain embodiments, be expected to be glassy or amorphous in their as-fabricated state, which by definition is more disordered than their crystalline counterparts, a substantial Li^+ ion conductivity boost may be anticipated, as previously demonstrated for crystalline Li_3PO_4 (Y-W. Hu et al., 11 Materials Research Bulletin, 1227 (1976)) versus sputter deposited glassy Li_3PO_4 (Bates et al., 53–56 Solid State Ionics, 647 (1992)).

10 [0027] The additional desirable properties, a low electronic conductivity, a high temperature stability, and a transference number of unity, are preferably given by the specific choice of the principal materials listed above, because they are preferably (i) high-temperature compounds, and so are their multinary derivatives, such as Li_4SiO_4 doped
15 Li_3PO_4 , (ii) strong electronic insulators, and (iii) composed of highly charged, and thus immobile ions except for the singly charged, small and thus very mobile Li^+ ion, which, for example, results in the Li^+ ion being the only mobile species in the electrolyte network, which in turn leads to a Li^+ ion transference number of unity.

20 [0028] As mentioned above, the charge transfer resistances to both the anode and cathode may contribute substantially to the overall cell impedance. One exemplary approach regarding how to limit these cell impedance contributors to a minimum may be to maximize the contact area at the thin-film electrolyte interfaces by optimizing the thin-film deposition process of both the thin-film electrolyte onto the cathode and subsequently the anode deposition process onto the thin-film electrolyte surface.

25 [0029] Previously crystalline $\text{Li}_3(\text{Sc}_{2-x}\text{M}_x)(\text{PO}_4)_3$ ($\text{M} = \text{Al}^{3+}, \text{Y}^{3+}$) was found to potentially exhibit Li^+ ion conductivities in excess of 10^{-5} S/cm at room temperature for $x = 0.4$, which is approximately more than five times the Li^+ ion conductivity of Lipon (Amatucci et al., Solid State Ionics 60 (1993) 357). Through sputter depositing
30 $\text{Li}_3(\text{Sc}_{2-x}\text{M}_x)(\text{PO}_4)_3$ ($\text{M} = \text{Al}^{3+}, \text{Y}^{3+}$), a glassy or amorphous morphology of this electrolyte material may be achieved, which may be beneficial when using it in thin film batteries in conjunction with the metallic lithium anode as explained above while, in addition, the glassiness alone may increase the Li^+ ion conductivity of the electrolyte by more than one order of magnitude. In certain embodiments, doping the composition with nitride ions that may replace some of the oxygen ions in the glass network may enhance the Li^+ ion

conductivity of the thin-film electrolyte through reduction of the activation enthalpy for Li^+ ion conduction E_a , in addition to rendering the electrolyte material more stable with, or inert against, a metallic lithium anode. Although the use of a single-piece sputter target of this 5 to 7 element material may be preferred, one may sputter deposit from a suitable sputter target in reactive N_2 atmosphere, with or without any additional admixed gases such as, for instance, argon. A suitable sputter target may be a readily available Li_3PO_4 sputter target onto whose sputter surface a specific number of pressed powder pellets of Al_2O_3 , Sc_2O_3 , and Y_2O_3 of a given footprint are located in order to attain the desired film composition and electrochemical properties in the Li-Sc-Al-Y-P-O-N system. The resulting, so-deposited, typically glassy, thin-film electrolyte may be described to have the composition $\text{Li}_3(\text{Sc}_{2-x}\text{M}_x)(\text{PO}_{4-y}\text{N}_z)_3$ wherein $\text{M} = \text{Al}$ and/or Y , $x \leq 2$, $z \leq 8/3$, and $2y = 3z$.

[0030] In another embodiment of the present invention, the parent compound Li_8ZrO_6 (cf., e.g., Scholder et al., Zeitschrift für Anorganische und Allgemeine Chemie, Band 362 (1968) 149; Delmas et al., Materials Research Bulletin 14 (1979) 619; Ohno et al., Journal of Nuclear Materials 132 (1985) 222), which is stable against both metallic lithium and high oxidation environments, that is, high positive voltages against a lithium reference electrode, may be aliovalently doped at the cation and anion positions in order to substantially enhance its lithium ionic conductivity. Preferred doping materials comprise Li_3PO_4 , which can formally be rewritten as “ $\text{Li}_{4.5}\text{P}_{1.5}\text{O}_6$ ”, and nitrogen, wherein the latter replaces some of the oxide ions in the so-doped, final compound whose composition may be described as $(1-x) \text{Li}_8\text{ZrO}_6 * x \text{Li}_{4.5}\text{P}_{1.5}\text{O}_6 : \text{N}$ or, more precisely, $\text{Li}_{8-3.5x}\text{P}_{1.5x}\text{Zr}_{1-x}\text{O}_{6-y}\text{N}_z$ wherein $x \leq 0.8$, $z \leq 4$, and $2y = 3z$.

[0031] The nitrogen doping may be accomplished in a thin-film electrolyte that may be fabricated through a reactive sputter deposition from a sputter target material of the composition $(1-x) \text{Li}_8\text{ZrO}_6 * x \text{Li}_{4.5}\text{P}_{1.5}\text{O}_6$ in a reactive N_2 atmosphere, with or without any additional admixed gases such as, for instance, argon. This film may be glassy or amorphous and therefore exhibit no substantial grain boundaries, which is the preferred morphology for some embodiments of the thin-film electrolytes as explained above.

[0032] Instead of the Li_3PO_4 doping approach from above, which aliovalently doped the parent compound at the high-valence position, the zirconium position, one may aliovalently dope Li_8ZrO_6 at the lithium position with, for instance, lanthanum, thereby arriving at chemical compositions that may be described by $\text{Li}_{8-3x}\text{La}_x\text{ZrO}_{6-y}\text{N}_z$ wherein $z \leq 4$, $2y = 3z$, and preferably $0 < x \leq 2$.

[0033] The nitrogen doping may be accomplished in a thin-film electrolyte that may be fabricated through a reactive sputter deposition from a sputter target material of the composition $\text{Li}_{8-3x}\text{La}_x\text{ZrO}_6$ in a reactive N_2 atmosphere, with or without any additional admixed gases such as, for instance, argon. This film may be glassy or amorphous and therefore exhibit no substantial grain boundaries, which is the preferred morphology for thin-film electrolytes as explained above.

[0034] The substantially glassy or amorphous compound of the present invention $\text{Li}_{8-3x}\text{La}_x\text{ZrO}_{6-y}\text{N}_z$ wherein $z \leq 4$, $2y = 3z$, and preferably $0 < x \leq 2$ that does not show substantial grain boundaries and thus differs substantially from the specific crystalline Garnet compounds that Weppner et al. describes in WO 2005/085138 A1, US 2007/0148553, and DE 10 2007 030 604 A1. These crystalline Garnet compounds may not be used in thin-film batteries wherein the thin-film electrolyte may be thinner than or equal to $5\mu\text{m}$. Otherwise, specifically lithium from the anode may creep along the crystalline grain boundaries of this rather thin electrolyte layer and eventually create an electronic leakage current path or even short-circuit with the cathode, resulting in destruction of the thin-film battery. Furthermore, PVD deposited oxide and oxy-nitride films of the present invention typically deposit in glassy or amorphous morphology so that an undesirable heat treatment would be necessary to crystallize these films, which in itself, however, is undesirable for the reasons given above. Notwithstanding the undesired crystalline morphology for thin-film electrolytes, a crystallizing heat treatment may additionally cause an unwanted chemical reaction of the electrolyte with the anode and/or cathode. As previously discussed, crystalline thin-film electrolyte films have numerous drawbacks that are preferably to be avoided. On the other hand, PVD processes, such as magnetron sputter deposition, lead to glassy or amorphous thin-film electrolytes that may not need any further heat treatment but, in view of best TFB operation, may already be their preferred morphological state immediately after their fabrication.

[0035] In yet another embodiment of the present invention one may use a related lithium zirconium oxide as a starting compound, such as $\text{Li}_6\text{Zr}_2\text{O}_7$ (cf. Abrahams et al., Journal of Solid State Chemistry 104 (1993) 197), which could be considered to formally consist of $3\text{Li}_2\text{O} * 2\text{ZrO}_2$ or $(1.5\text{Li}_2\text{O} * \text{ZrO}_2)_2$, which therefore possesses only 1.5/4 or 38% of the formal Li_2O residing in Li_8ZrO_6 , which in turn may formally be described as $4\text{Li}_2\text{O} * \text{ZrO}_2$. When doped with Li_3PO_4 and nitrogen, we obtain compounds whose formulae can be represented by $\text{Li}_{6-0.75x}\text{P}_{1.75x}\text{Zr}_{2-2x}\text{O}_{7-y}\text{N}_z$ wherein $z \leq 14/3$, $2y = 3z$, and preferably $x \leq 0.8$.

[0036] Nitrogen doping may be accomplished in a thin-film electrolyte that may be fabricated through a reactive sputter deposition from a sputter target material of the composition $\text{Li}_{6-0.75x}\text{P}_{1.75x}\text{Zr}_{2-2x}\text{O}_7$ in a reactive N_2 atmosphere, with or without any additional admixed gases such as, for instance, argon. This film may be glassy or amorphous and therefore exhibit no substantial grain boundaries, which is the preferred morphology for thin-film electrolytes as explained above.

[0037] Yet another embodiment of the present invention relates to AlN doped Li_3PO_4 , which introduces vacancies at the Li^+ ion cation position and the oxygen anion position while replacing some of the Li^+ ion pinning, electron rich oxygen ions and their 2p atomic orbitals with the less Li^+ ion pinning, less electron rich, 2p nitrogen orbitals, according to the formula $\text{Li}_{3-3x}\text{P}_{1-x}\text{Al}_x\text{O}_{4-4x}\text{N}_x$ wherein preferably $0 < x \leq 0.6$.

[0038] Sputtering AlN doped Li_3PO_4 material, for instance, in a reactive N_2 atmosphere, with or without any additional admixed gases such as, for instance, argon, may allow the fabrication of an electrolyte film that is further doped with nitrogen and may be described by a composition of $\text{Li}_{3-3x}\text{P}_{1-x}\text{Al}_x\text{O}_{4-4x-y}\text{N}_{x+z}$ wherein preferably $0 < x \leq 0.6$, $y \leq 1.6$, and $2y = 3z$. This film may be glassy or amorphous and therefore exhibit no substantial grain boundaries, which is the preferred morphology for thin-film electrolytes as explained above.

[0039] All of the various compositions of the thin-film electrolyte of the present invention are thermally stable up to at least 150°C while some specific compositions may be thermally stable well above 300°C or even above 500°C . This thermal property may allow the use of the thin-film electrolyte of the present invention in TFBs that are exposed to higher (up to 150°C) to high (above 150°C) temperature environments for extended periods of time, such as days or even months or years. It is to be understood, however, that the thermal stability of a TFB is not solely dependent on the thermal stability of the electrolyte but may also be determined by, for instance, the thermal stability of the packaging of the TFB or the state of charge of the positive cathode material when exposed to higher or high temperatures.

EXAMPLES

[0040] Example 1: In a particular embodiment of the present invention, the Li^+ ion conductivity of the electrolyte is demonstrated in a conductivity test cell using two sandwiching inert metal electrodes. The electrolyte exhibits an improved activation enthalpy E_a of less than 0.5eV (compared to Lipon $E_a = 0.514\text{eV}$) that leads to a Li^+ ion conductivity of greater than $5 \times 10^{-6}\text{ S/cm}$ at 25°C . The electrolyte possesses a Li^+ ion conductivity at 0°C of $1.48 \times 10^{-6}\text{ S/cm}$, which is five times higher than that of Lipon ($2.95 \times 10^{-7}\text{ S/cm}$) and ten

times higher (8.1×10^{-8} S/cm) at -40°C (Lipon: 8.1×10^{-9} S/cm). The electrolyte of the present invention has at least an electrochemical stability window from 0–5.5V vs. Li^+/Li before the electrolyte breaks down and shows a substantial electronic conductivity of more than 1×10^{-6} S/cm.

5 **[0041]** Example 2: In a further embodiment, a 1 in² large TFB fabricated with the electrolyte of the present invention supplies 700 μAh at 1/2C rate at 25°C in the voltage range 4.2–2.0V and delivers 250 μAh at 100 mA (140C rate) at the same temperature and within the same voltage window. This TFB is fabricated onto 50 μm metal foil substrate, which also serves as the positive terminal, together with 0.5 μm conductive barrier layer,
10 3.5 μm LiCoO_2 positive cathode, 1.2 μm electrolyte of the present invention, $\sim 9\mu\text{m}$ Li anode, and a standard metal foil encapsulation.

[0042] Example 3: A further embodiment of the present invention encompasses fabricated TFBs that supply 700 μAh at 1/2C rate at 25°C in the voltage range 4.2–2.0V and are capable of delivering a continuous current of 0.4 mA within the same voltage window but
15 at -40°C .

[0043] Example 4: The thin-film electrolyte of the composition $\text{Li}_3(\text{ScAl})(\text{PO}_{3.4}\text{N}_{0.4})_3$, formally comprising $\text{Li}_3\text{PO}_4 \cdot \text{P}_2\text{O}_5 \cdot 1/2 \text{Sc}_2\text{O}_3 \cdot 1/2 \text{Al}_2\text{O}_3 \cdot \text{N}$, is fabricated in a RF magnetron sputter deposition using “sputter-up” configuration in an 10 mTorr N_2 reactive atmosphere onto a graphite substrate by employing a 4 inch diameter
20 Li_3PO_4 sputter target whose sputter surface is covered by approximately 33% with about 2mm thick and about 1cm² in diameter large, pressed and sintered powder pellets of P_2O_5 , by approximately 17% with about 2mm thick and about 1cm² in diameter large, pressed and sintered powder pellets of Al_2O_3 , and by approximately 17% with about 2mm thick and about 1cm² in diameter large, pressed and sintered powder pellets of Sc_2O_3 . The resulting,
25 deposited thin-film electrolyte film at a distance of 7.5cm from the Li_3PO_4 target surface is XRD amorphous and may be analyzed by quantitative EDS and/or quantitative RBS to exhibit a Sc:Al:P:O:N stoichiometric ratio of 1 : 1 : 1 : 3.4 : 0.4. The stoichiometric factor of lithium may be obtained via back-calculation using the chemical electro-neutrality rule and the known formal valence states of $\text{Li}(+1)$, $\text{Sc}(+3)$, $\text{Al}(+3)$, $\text{P}(+5)$, $\text{O}(-2)$, and $\text{N}(-3)$.

30 **[0044]** Example 5: The thin-film electrolyte of Example 4 may be heat treated in an inert argon atmosphere continuously at 150°C for 7 days without substantially changing its Li:Sc:Al:P:O:N stoichiometric ratio of 3 : 1 : 1 : 1 : 3.4 : 0.4.

[0045] The embodiments described above are exemplary only. One skilled in the art may recognize variations from the embodiments specifically described here, which are

intended to be within the scope of this disclosure. As such, the invention is limited only by the following claims. Thus, it is intended that the present invention cover the modifications of this invention provided they come within the scope of the appended claims and their equivalents. Further, specific explanations of theories regarding the formation or
5 performance of electrochemical devices according to the present invention are presented for explanation only and are not to be considered limiting with respect to the scope of the present disclosure or the claims.

What is claimed is:

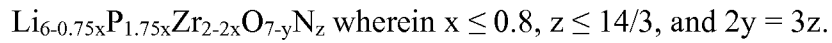
1. A solid-state, inorganic, electrolyte comprising:
a chemical composition comprising lithium, oxygen, nitrogen, and at least one element selected from the group of: aluminum, silicon, phosphorus, sulfur, scandium, yttrium, lanthanum, zirconium, magnesium, calcium;
wherein said electrolyte has a crystallinity of about 0 – 100 Å; and
wherein said electrolyte has a lithium ion conductivity of greater than 5×10^{-6} S/cm at 25°C.
2. The electrolyte of claim 1 further adapted to be substantially kinetically inert with a metallic lithium anode.
3. The electrolyte of claim 1 further adapted to be substantially kinetically inert with a positive cathode charged to a potential of about +3.9V, said potential measured in comparison to a metallic lithium reference electrode.
4. The electrolyte of claim 1 further adapted to be substantially thermally stable at ambient temperatures up to about 150°C.
5. The electrolyte of claim 1 further adapted to be substantially kinetically inert with metallic lithium at ambient temperatures of up to about 150°C.
6. The electrolyte of claim 1 further adapted to be substantially kinetically inert with positive cathode materials that are charged to a potential of about +3.9V at ambient temperatures of up to about 150°C, said potential measured in comparison to a metallic lithium reference electrode.
7. The electrolyte of claim 1 further comprising a thickness of said electrolyte of less than about 5µm.
8. The electrolyte of claim 1 wherein said electrolyte further comprises:
a first electrolyte-electrode interface comprising a first electrolyte chemical composition,
and
a second electrolyte-electrode interface comprising a second electrolyte chemical composition,

wherein said first electrolyte chemical composition and said second electrolyte chemical composition are different chemical compositions.

9. The electrolyte of claim 1 further comprising a chemical composition described by $\text{Li}_3(\text{Sc}_{2-x}\text{M}_x)(\text{PO}_{4-y}\text{N}_z)_3$ wherein $x \leq 2$, $z \leq 8/3$, $2y = 3z$, and M is selected from the group of Al, Y, and $\text{Al}_{1-a}\text{Y}_a$ wherein $a < 1$.
10. The electrolyte of claim 1 further comprising a chemical composition described by $\text{Li}_{8-3.5x}\text{P}_{1.5x}\text{Zr}_{1-x}\text{O}_{6-y}\text{N}_z$ wherein $x \leq 0.8$, $z \leq 4$, and $2y = 3z$.
11. The electrolyte of claim 1 further comprising a chemical composition described by $\text{Li}_{8-3x}\text{La}_x\text{ZrO}_{6-y}\text{N}_z$ wherein $0 < x \leq 2$, $z \leq 4$, and $2y = 3z$.
12. The electrolyte of claim 1 further comprising a chemical composition described by $\text{Li}_{6-0.75x}\text{P}_{1.75x}\text{Zr}_{2-2x}\text{O}_{7-y}\text{N}_z$ wherein $x \leq 0.8$, $z \leq 14/3$, and $2y = 3z$.
13. The electrolyte of claim 1 further comprising a chemical composition described by $\text{Li}_{3-3x}\text{P}_{1-x}\text{Al}_x\text{O}_{4-4x-y}\text{N}_{x+z}$ wherein $0 < x \leq 0.6$, $y \leq 1.6$, and $2y = 3z$.
14. A method of fabricating a solid-state, inorganic electrolyte comprising
 - providing a vacuum chamber;
 - providing at least one deposition substrate in said chamber;
 - providing at least one deposition target in said chamber, said at least one deposition target comprising at least one target material;
 - providing a deposition gas atmosphere in said vacuum chamber;
 - evaporating said at least one target material into said deposition gas atmosphere;
 - forming a deposition material within said deposition gas atmosphere; and
 - depositing said deposition material onto said at least one deposition substrate;
 whereby said electrolyte has a crystallinity of about 0 – 100 Å,
 whereby said deposited material has a lithium ion conductivity of greater than $5 \cdot 10^{-6}$ S/cm at 25°C, and
 whereby said deposition material has a chemical composition comprising at least the elements lithium, oxygen, nitrogen, and at least one element selected from the group of aluminum, silicon, phosphorus, sulfur, scandium, yttrium, lanthanum, zirconium, magnesium, and calcium.

15. The method of claim 14 wherein said evaporating step comprises a process selected from the group of: RF magnetron sputter deposition, pulsed DC magnetron sputter deposition, RF assisted pulsed DC magnetron sputter deposition, cathodic arc deposition, electron beam evaporation.
16. The method of claim 14 wherein said deposition gas atmosphere comprises materials selected from the group of: argon, nitrogen, oxygen, dinitrogen oxide, and any mixture thereof.
17. The method of claim 14 whereby said electrolyte is substantially thermally stable at ambient temperatures up to 150°C.
18. The electrolyte of claim 14 whereby said electrolyte is substantially kinetically inert with metallic lithium at ambient temperatures up to about 150°C.
19. The electrolyte of claim 14 whereby said electrolyte is substantially kinetically inert with positive cathode materials that are charged to a potential of at least +3.9V at ambient temperatures of up to about 150°C, said potential measured in comparison to a metallic lithium reference electrode.
20. The method of claim 14 wherein said forming step further comprises changing said deposition material during said depositing.
21. The method of claim 14 further comprising providing a chemical composition of $\text{Li}_3(\text{Sc}_{2-x}\text{M}_x)(\text{PO}_{4-y}\text{N}_z)_3$ wherein $0 \leq x \leq 2$, $0 \leq z \leq 8/3$, $2y = 3z$, and M is selected from the group of Al, Y, and $\text{Al}_{1-a}\text{Y}_a$ wherein $a < 1$.
22. The method of claim 14 further comprising providing a chemical composition described by $\text{Li}_{8-3.5x}\text{P}_{1.5x}\text{Zr}_{1-x}\text{O}_{6-y}\text{N}_z$ wherein $x \leq 0.8$, $z \leq 4$, and $2y = 3z$.
23. The method of claim 14 further comprising providing a chemical composition described by $\text{Li}_{8-3x}\text{La}_x\text{ZrO}_{6-y}\text{N}_z$ wherein $0 < x \leq 2$, $z \leq 4$, and $2y = 3z$.

24. The method of claim 14 further comprising providing a chemical composition described by



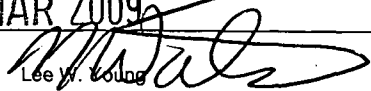
25. The method of claim 14 further comprising providing a chemical composition described by



INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 09/31815

A. CLASSIFICATION OF SUBJECT MATTER IPC(8) - H01M 10/08 (2009.01) USPC - 429/322 According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) IPC(8) - H01M 10/08 (2009.01) USPC - 429/322 Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched IPC(8) - H01M 10/08 (2009.01) USPC - 429/322; 429/305 Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) PubWest (USPT, PGPB, EPAB, JPAB), Google Scholar, WIPO, PubMed Search terms - Solid-state, lithium-ion, thin-film, electrolyte, lithium, oxygen, nitrogen, conductivity, crystallinity, chemical composition, Lipon, TFB, aluminum, silicon, phosphorus, sulfur, scandium, yttrium, lanthanum, zirconium, magnesium, calcium		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 2006/0063074 A1 ("Jenson et al.") 23 March, 2006 (23.03.2006) (para [0152], [0153], [0154], [0155], [0156], [0162], [0172], [0178], [0201], [0214], [0217], [0219], [0223], [0224], [0270], [0283], [0291], [0345], [0346], [0354])	1-25
Y	US 2004/0101761 A1 ("Park et al.") 27 May 2004 (27.05.2004) (para [0055])	1-25
Y	US 2007/0298326 A1 ("Angell et al.") 27 December 2007 (27.12.2007) (para [0015], [0045], [0063])	3-6, 17-19
Y	US 2007/0141468 A1 ("Barker et al.") 21 June 2007 (21.06.2007) (para [0081], [0131], [0139], [0140], [0141], [0259])	9-13, 21-25
Y	US 2002/0004167 A1 ("Jeson et al.") 10 January 2002 (10.01.2002) (para [0269], [0326])	20
<input type="checkbox"/> Further documents are listed in the continuation of Box C. <input type="checkbox"/>		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 25 February 2009 (25.02.2009)		Date of mailing of the international search report 10 MAR 2009
Name and mailing address of the ISA/US Mail Stop PCT, Attn: ISA/US, Commissioner for Patents P.O. Box 1450, Alexandria, Virginia 22313-1450 Facsimile No. 571-273-3201		Authorized officer:  Lee W. Young PCT Helpdesk: 571-272-4300 PCT OSP: 571-272-7774