

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
29 January 2004 (29.01.2004)

PCT

(10) International Publication Number
WO 2004/010509 A2

(51) International Patent Classification⁷: **H01L 33/00**

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(21) International Application Number:

PCT/US2003/021909

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(22) International Filing Date: 15 July 2003 (15.07.2003)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:

10/200,244 22 July 2002 (22.07.2002) US
60/450,960 28 February 2003 (28.02.2003) US

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU,
AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU,
CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH,
GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC,
LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW,
MX, MZ, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC,
SD, SE, SG, SK, SL, SY, TJ, TM, TN, TR, TT, TZ, UA,
UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(84) Designated States (*regional*): ARIPO patent (GH, GM,
KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW),
Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM),
European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE,
ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO,
SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM,
GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

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Published:

— *without international search report and to be republished
upon receipt of that report*

*For two-letter codes and other abbreviations, refer to the "Guid-
ance Notes on Codes and Abbreviations" appearing at the begin-
ning of each regular issue of the PCT Gazette.*

(54) Title: LIGHT EMITTING DIODES INCLUDING BARRIER LAYERS/SUBLAYERS AND MANUFACTURING METH-
ODS THEREFOR

(57) Abstract: Semiconductor light emitting devices, such as light emitting diodes, include a substrate, an epitaxial region on the substrate that includes a light emitting region such as a light emitting diode region, and a multilayer conductive stack including a reflector layer, on the epitaxial region. A barrier layer is provided on the reflector layer and extending on a sidewall of the reflector layer. The multilayer conductive stack can also include an ohmic layer between the reflector and the epitaxial region. The barrier layer further extends on a sidewall of the ohmic layer. The barrier layer can also extend onto the epitaxial region outside the multilayer conductive stack. The barrier layer can be fabricated as a series of alternating first and second sublayers.



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LIGHT EMITTING DIODES INCLUDING BARRIER LAYERS/SUBLAYERS AND MANUFACTURING METHODS THEREFOR

Field of the Invention

This invention relates to microelectronic devices and fabrication methods therefor, and more particularly to light emitting devices, such as light emitting diodes (LEDs) and manufacturing methods therefor.

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Background of the Invention

Light emitting diodes are widely used in consumer and commercial applications. As is well known to those having skill in the art, a light emitting diode generally includes a diode region on a microelectronic substrate. The microelectronic
10 substrate may comprise, for example, gallium arsenide, gallium phosphide, alloys thereof, silicon carbide and/or sapphire. Continued developments in LEDs have resulted in highly efficient and mechanically robust light sources that can cover the visible spectrum and beyond. These attributes, coupled with the potentially long service life of solid state devices, may enable a variety of new display applications,
15 and may place LEDs in a position to compete with the well entrenched incandescent and fluorescent lamps.

Gallium Nitride (GaN)-based LEDs typically comprise an insulating or semiconducting substrate such as silicon carbide (SiC) or sapphire on which a plurality of GaN-based epitaxial layers are deposited. The epitaxial layers comprise
20 an active or diode region having a p-n junction which emits light when energized.

LEDs may be mounted substrate side down onto a submount, also called a package or lead frame (hereinafter referred to as a "submount"). In contrast, flip-chip mounting of light emitting diodes involves mounting the LED onto the submount with the substrate side facing up (i.e. away from the submount). Light may be extracted
25 and emitted through the substrate. Flip chip mounting may be an especially desirable technique for mounting SiC-based LEDs. In particular, since SiC has a higher index of refraction than GaN, light generated in the active or diode region generally does not totally internally reflect (i.e. reflect back into the GaN-based layers) at the

GaN/SiC interface. Flip chip mounting of SiC-based LEDs also can improve the effect of certain substrate-shaping techniques known in the art. Flip chip packaging of SiC LEDs may have other benefits, such as improved heat dissipation, which may be desirable depending on the particular application for the LED.

5 Because of the high index of refraction of SiC, light passing through an SiC substrate tends to be totally internally reflected into the substrate at the surface of the substrate unless the light strikes the surface at a fairly low angle of incidence (i.e. fairly close to normal). The critical angle for total internal reflection generally depends on the material with which SiC forms an interface. It is possible to increase
10 the light output from an SiC-based LED by shaping the SiC substrate in a manner that limits total internal reflection by causing more rays to strike the surface of the SiC at low angles of incidence. A number of such shaping techniques and resulting devices are taught in U.S. Patent Application Serial No. 10/057,821 to Slater et al, corresponding to U.S. Publication No. US 2002/0123164 A1, published September 5,
15 2002, entitled *Light Emitting Diodes Including Modifications for Light Extraction and Manufacturing Methods Therefor*.

 One potential problem with flip-chip mounting is that when an LED is mounted on a submount using conventional techniques, a conductive die attach material such as silver epoxy is deposited on the LED and/or on the package, and the
20 LED and the submount are pressed together. This can cause the viscous conductive die attach material to squeeze out and make contact with the N-type substrate and/or layers in the device, thereby forming a Schottky diode connection that can short-circuit the p-n junction in the active region.

 Metal-metal bonds formed by soldering, thermosonic scrubbing and/or
25 thermocompression bonding are alternative attach techniques. However, tin (Sn) is a component of most types of solder, and migration of Sn from the bonded surface into the device can cause unwanted degradation of the device. Such migration can interfere with metal-semiconductor interfaces such as ohmic contacts and/or the function of metal-metal interfaces such as reflective interfaces that serve as mirrors.

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Summary of the Invention

Semiconductor light emitting devices such as light emitting diodes, according to some embodiments of the present invention, include a substrate, an epitaxial region on the substrate that includes therein a light emitting region such as a light emitting

diode region, and a multilayer conductive stack comprising a reflector layer including a reflector layer sidewall, on the epitaxial region. A barrier layer is provided on the reflector layer and extending on the reflector layer sidewall. In other embodiments, the multilayer conductive stack further comprises an ohmic layer, including an ohmic layer sidewall, between the reflector and the epitaxial region. The barrier layer further extends on the ohmic layer sidewall. In still other embodiments of the present invention, the barrier layer further extends onto the epitaxial region outside the multilayer conductive stack.

In other embodiments of the present invention, the barrier layer comprises a plurality of first and second alternating sublayers. In some embodiments, the first sublayers include grain boundaries therein and the second sublayers are substantially free of grain boundaries. In other embodiments, the first sublayers include grain boundaries that are arranged such that the grain boundaries define an offset brick wall structure of the first sublayers. In still other embodiments, the first sublayers comprise titanium tungsten and the second sublayers comprise platinum, titanium and/or nickel.

In some embodiments, the first sublayers are configured to reduce migration of metal from the reflector layer, and the second sublayers are configured to prevent at least some grain boundaries in the first sublayers for propagating thereacross. In other embodiments, the plurality of first and second alternating sublayers define first and second outer sublayers that comprise the first sublayer. In still other embodiments, the second outer sublayer is thicker than the first outer sublayer.

Other embodiments of the invention provide methods of reducing migration of metal from the reflective layer into the epitaxial region of a semiconductor light emitting device, by forming a barrier layer on the reflector layer that extends on the reflector layer sidewall. In other embodiments, the barrier layer is formed to extend on the ohmic layer sidewall. In still other embodiments, the barrier layer extends onto the epitaxial region outside the multilayer conductive stack.

Still other embodiments of the present invention form the barrier layer as a plurality of alternating first and second sublayers, which can reduce cracking of the barrier layer adjacent the reflector layer sidewall. The first and second sublayers can define an offset brick wall structure that can terminate with a first sublayer, to define an outer sublayer, wherein the second sublayers are thinner than the first sublayers and the outer sublayer is thicker than the first sublayers.

Brief Description of the Drawings

Figures 1-10 are cross-sectional views of light emitting diodes according to some embodiments of the present invention during intermediate fabrication steps according to some embodiments of the present invention.

Figures 11A-12D graphically illustrate test results for light emitting diodes according to some embodiments of the present invention.

Figures 13-15 are cross-sectional views of light emitting diodes according to other embodiments of the present invention.

Figures 16 and 17 are SEM images of light emitting diodes according to other embodiments of the present invention.

Detailed Description of Preferred Embodiments

The present invention now will be described more fully hereinafter with reference to the accompanying figures, in which embodiments of the present invention are shown. This invention may, however, be embodied in many alternate forms and should not be construed as limited to the embodiments set forth herein.

Accordingly, while the present invention is susceptible to various modifications and alternative forms, specific embodiments thereof are shown by way of example in the drawings and will herein be described in detail. It should be understood, however, that there is no intent to limit the present invention to the particular forms disclosed, but on the contrary, the present invention is to cover all modifications, equivalents, and alternatives falling within the spirit and scope of the present invention as defined by the claims. Like numbers refer to like elements throughout the description of the figures. In the figures, the dimensions of layers and regions may be exaggerated for clarity. It will also be understood that when an element, such as a layer, region or substrate, is referred to as being "on" another element, it can be directly on the other element or intervening elements may also be present. In contrast, when an element, such as a layer, region or substrate, is referred to as being "directly on" another element, there are no intervening elements present. Moreover, each embodiment described and illustrated herein includes its complementary conductivity type embodiment as well.

Embodiments of the present invention now will be described generally with reference to gallium nitride-based light emitting diodes on silicon carbide-based

substrates. However, it will be understood by those having skill in the art that many embodiments of the present invention may employ any combination of a substrate that is non-absorbing or transparent to the emitted light and an index matched light emitting diode epitaxial layer. In some embodiments of the present invention, the refractive index of the substrate is greater than that of the diode. Accordingly, combinations can include an AlGaInP diode on a GaP substrate; an InGaAs diode on a GaAs substrate; an AlGaAs diode on a GaAs substrate; an SiC diode on an SiC substrate, an SiC diode on a sapphire (Al_2O_3) substrate; and/or a nitride-based diode on a gallium nitride, silicon carbide, aluminum nitride, zinc oxide and/or other substrate. Finally, it will be understood that although embodiments of the present invention are described herein with respect to light emitting diodes having an epitaxial region that includes therein a light emitting diode region, other embodiments of the present invention may be used with other semiconductor light emitting devices such as lasers, wherein an epitaxial region includes therein a light emitting region such as a laser diode region.

Some embodiments of the present invention provide a metal stack with a passivation layer on its perimeter that defines a bonding region on LED devices that can be well suited for die attachment via soldering and/or thermosonic scrub bonding. Other embodiments of the present invention provide LED devices that can be flip chip mounted using soldering and/or thermosonic bonding, and that include a barrier layer that can reduce or eliminate unwanted degradation of the metal and/or semiconductor layers of the LED. Still other embodiments of the present invention can provide both the passivation layer and the barrier layer. Yet other embodiments of the present invention provide methods of fabricating these LED devices. Passivation layers according to some embodiments of the present invention can provide means for preventing a short circuit across the diode region. Moreover, barrier layers according to some embodiments of the present invention can provide means for reducing migration of tin and/or other undesired materials into the LED.

In a conventional sapphire-based approach, an LED, also referred to as a chip or die, is attached to a submount with a clear epoxy. In the case of LEDs having conductive SiC substrates, a conducting silver filled epoxy is typically used to attach the LED and the submount to one another. Conventional nitride-based LEDs on SiC or sapphire substrates generally are packaged with the epitaxial side up and with the substrate bonded to the submount.

Some embodiments of conventional SiC-based LEDs have an n-type conductive substrate and an epitaxial region on the substrate that includes one or more n-type epitaxial layers and one or more p-type epitaxial layers to define a diode region. A transparent ohmic contact may be formed on the p-type epitaxial LED surface. As discussed in U.S. Patent Application Serial No. 10/057,821, corresponding to U.S. Publication No. US 2002/0123164 A1, referenced above, it may be beneficial to form a reflector layer over the thin transparent ohmic contact to improve light extraction from the device. The reflective layer can serve to spread electric current uniformly across the thin contact, and also to reflect light back into the substrate, away from the submount.

Unfortunately, if Sn and/or other contaminants from a solder or thermosonic/thermocompression bond migrates from the bonding surface to the reflector layer, the reflector layer may become less reflective. Moreover, if the contaminants migrate beyond the reflector to the transparent ohmic contact, the transparent ohmic contact may develop a higher specific contact resistivity, thus increasing the forward voltage (V_F) of the device. Both of these results may be characterized as degradation of the device.

A reflective layer may comprise Ag and/or Al, and the thin transparent ohmic layer can comprise Pt, Pd, Ni, Ti, Au or a combination of these elements. Unfortunately, Sn readily forms alloys with Ag, Pt, Au and with numerous other metals used in semiconductor manufacturing.

A first portion of a series of conductive layers (referred to herein as a "multilayer conductive stack") that may be formed on the p-type surface of an LED according to some embodiments of the present invention comprises an ohmic layer, a reflector layer, and a barrier layer. In some embodiments, the barrier layer comprises a thin layer of titanium, titanium/tungsten (TiW) and/or titanium nitride/tungsten (TiNW). In other embodiments, the barrier layer comprises a first layer of titanium/tungsten and a second layer comprising nickel on the first layer. In still other embodiments, the barrier layer extends onto the sidewalls of the ohmic layer and the reflector layer and/or includes an alternating stack of a barrier metal layer and a second metal.

In some embodiments of the present invention, this portion of the multilayer conductive stack and the top of the device are passivated with a passivation layer, such as an insulating layer to which a solder or eutectic die attach material will not

wet. The passivation layer can be formed by conventional spin-on or deposition techniques such as Chemical Vapor Deposition (CVD) and/or reactive sputtering, and it can comprise an insulating oxide and/or nitride such as silicon dioxide and/or silicon nitride.

5 In some embodiments of the present invention, an opening in the passivation layer is then formed with lateral dimensions (i.e. surface area) that are smaller than the lateral dimensions of the barrier layer such that only a portion of the surface of the barrier layer is exposed. Such an opening can be produced using conventional photolithography and etching techniques. An optional adhesion layer that may
10 comprise Ti, is formed in the opening and a thick bonding layer that may comprise Au, Sn and/or AuSn also is formed. In other embodiments, an optional solder wetting layer is provided between the adhesion layer and the bonding layer. The solder wetting layer can provide an enhanced mechanical connection between the solder and the LED, which can increase the shear strength of the connection.

15 In some embodiments of the present invention, the bonding layer can serve to protect the barrier layer if mechanical stress is to be applied to the multilayer conductive stack by a probe tip during electrical tests. Furthermore, in other embodiments of the present invention, the Au in the bonding layer can serve to protect the barrier layer from oxidation. In yet other embodiments of the present
20 invention, AuSn may be employed in the bonding layer as a eutectic die attach material that may be used to bond an LED and a submount to one another via thermosonic or thermocompression bonding as an alternative to solder bonding.

 Multilayer conductive stacks according to some embodiments of the present invention can be well suited for solid state devices in that some embodiments of the
25 present invention can provide a stack that is considerably thinner than may be achieved if a solder barrier is formed using Ni or NiV. In some embodiments of the present invention, a barrier layer comprising W, TiW and/or TiNW and/or W and Ni layers can be less than half of the thickness that may be used if only Ni were used as the barrier layer. This may be advantageous when considering the generally small
30 lateral dimensions of solid state devices and when considering the potential difficulty associated with the use of conventional fabrication techniques if large topographical dimensions are present. The barrier layer also can provide a desired vertical barrier against Sn and/or other undesired migration.

Passivation layers according to some embodiments of the invention can cover the entire epitaxial surface of the LED except for a reduced area opening that exposes the barrier layer, and can provide a dam to reduce or prevent Sn and/or other undesired migration into the reflective mirror layer or the ohmic contact, or down the edges of the metal stack. In the case of an LED having a conducting substrate, passivation layers according to some embodiments of the invention also can serve to keep the die attach material from contacting the substrate which could produce undesired effects such as formation of a parasitic Schottky diode.

Large area LEDs operating at high power levels may use packaging that has low thermal resistance to reduce or prevent degradation of the device performance. Epoxy based die attach materials may have high thermal resistance in comparison to metal die attach materials. In a flip-chip configuration, the p-n junction region of an LED is mounted extremely close to the heat sinking package, which can bypass the thermal resistance of the substrate. This may be used for large-area SiC-based LEDs in some embodiments of the present invention, despite the low thermal resistance of SiC. The metal-metal bond provided by some embodiments of the present invention also may be used in LEDs having sapphire substrates, due to the high thermal resistance of sapphire. Consequently, some embodiments of the present invention may be used for large area LEDs, which may benefit from employing a junction down (flip-chip) metal-metal die attach configuration. Other embodiments of the present invention may be used with small-area LEDs.

Some embodiments of the present invention also may increase the permissible temperature range that the device can withstand during subsequent packaging, assembly and re-work/repair steps. Metal-metal bonds can be engineered for subsequent thermal cycles, for example, where the LED is mounted to a printed circuit board. If the LED die is attached to its submount with a AuSn thermosonic or thermocompression bond at 300°C or by SnAg solder at 230°C, subsequent processing cycles using SnPb solder at 200°C may not cause mechanical failure by reflowing the die attach bond. That is, subsequent processing at elevated temperatures may not cause the LED die to detach from the submount. In contrast, LEDs using epoxy based die attach methods may not withstand high thermal cycles. Moreover, clear epoxy can become discolored during thermal processing, resulting in unwanted light attenuation.

Some embodiments of the present invention may also increase the shear strength of resulting bonds between the LED and the submount. Inclusion of a solder barrier layer which reduces or prevents tin and/or other unwanted materials from reaching the epitaxial layers of the device can preserve the adhesive strength of the metal-semiconductor interface and can result in a more robust, mechanically stable device. In particular, it has been found that embodiments that include a nickel solder wetting layer beneath a gold bonding layer may exhibit superior shear strength. The shear strength may also be maintained through thermal cycles during subsequent packaging, assembly and re-work/repair steps.

In addition, some embodiments of the present invention may improve the thermal conductivity of the resulting device. This effect may be particularly apparent in so-called "power" or large area LEDs which may carry a substantially higher current than conventional LEDs. In such LEDs, some embodiments of the present invention can prevent or reduce "voiding" within the metallic layers. Voiding refers to the formation of physical voids or spaces within a metallic region. Some embodiments of the present invention may serve to maintain a tight grain structure within such metallic layers, thereby allowing the device to maintain a high thermal conductivity despite operation at high power levels with correspondingly high junction temperatures. Improved thermal conductivity also may help reduce degradation of encapsulant materials in which LEDs, and in particular power LEDs, are packaged. Such encapsulants are typically sensitive to heat and may yellow and become less transparent after exposure to high temperatures for extended periods of time. By improving the thermal conductivity of the LED mount interface, less heat may be dissipated through the encapsulant, which can result in reduced degradation.

Figure 1 illustrates an LED device precursor **10** according to some embodiments of the present invention, comprising a substrate **20** having first and second opposing faces **20a** and **20b**, respectively, and an epitaxial region **22** formed on the first face **20a** of the substrate **20**. Substrate **20** may comprise silicon carbide, sapphire, aluminum nitride, gallium nitride or any other suitable conductive or non-conductive substrate material. In some embodiments of the present invention, the substrate **20** comprises conductively doped SiC. In some embodiments of the present invention, the substrate **20** is transparent to optical radiation in a predetermined wavelength range. In some embodiments of the present invention, epitaxial region **22** comprises a conductive buffer layer and a plurality of Group III-nitride epitaxial

layers, at least some of which provide a diode region. The dimensions of the substrate, epitaxial layers and metal layers shown in Figures 1-10 are not drawn to scale but are exaggerated for illustrative purposes. A thin SiO₂ and/or other layer (not shown) may optionally be formed, for example, by Plasma Enhanced Chemical Vapor
5 Deposition (PECVD) on the surface of the epitaxial region **22** to protect it during subsequent processing and cleaning steps.

Subsequent to deposition of the epitaxial region **22**, the epitaxial region **22** is patterned as shown in Figure 2 to form a plurality of mesas **30** each having sidewalls **30a**, **30b**. Although not illustrated in Figure 2, the mesas **30** may extend into the
10 substrate **20**. Moreover, in some embodiments of the present invention, the mesas **30** may be formed by selective epitaxial growth through openings in a mask, rather than blanket epitaxial growth and etching.

Still referring to Figure 2, in some embodiments of the present invention, a layer of photoresist **24** and/ or other material is formed on the surface of the precursor
15 **10** and patterned to expose the surface of the mesas **30**, thereby defining a first reduced area **30c** on the surface of the mesas **30**. If an optional SiO₂ layer is present, it may be etched through the openings in the photoresist **24** to expose the first reduced area **30c** on the epitaxial surface layer of the epitaxial region **22** in the mesa **30**.

A multilayer conductive stack **35** is then formed on the first reduced areas **30c**
20 of the mesas **30** using, for example, conventional lift-off techniques. As shown in Figure 3, the multilayer conductive stack **35** includes an ohmic layer **32**, a reflector layer **34** and a barrier layer **36**. In some embodiments of the present invention, the ohmic layer **32** comprises platinum, but in other embodiments it may comprise palladium, nickel/gold, nickel oxide/gold, nickel oxide/platinum, titanium and/or
25 titanium/gold. Other embodiments of ohmic layers are described in the above-referenced U.S. Publication No. US 2002/0123164 A1. If the ohmic layer **32** comprises Pt, it is about 25Å thick in some embodiments of the present invention. The reflector layer **34** may comprise any suitable reflective metal, and may comprise Al or Ag. The reflector layer **34** is about 1000Å thick in some embodiments of the
30 present invention. Other embodiments of reflector layers are described in the above-referenced Application Serial No. 10/057,821, corresponding to U.S. Publication No. US 2002/0123164 A1.

In some embodiments of the present invention, the barrier layer **36** can be a solder barrier layer to prevent solder metals such as tin from reacting with the

reflector layer **34** and/or ohmic layer **32**. The barrier layer **36** comprises W, TiW and/or TiN/W and is between about 500Å and about 50,000Å thick in some embodiments of the present invention, and is about 5000Å thick in other embodiments of the present invention. In other embodiments of the invention, the
5 barrier layer **36** may comprise TiW having a composition of about 5% Ti and about 95% W.

Other embodiments of the barrier layer **36** that comprise tungsten or titanium/tungsten and that are between about 500Å thick to about 3000Å thick, may be used when a solder bonding operation (described below) is performed at a reflow
10 temperature of less than about 210°C. For example, when eutectic gold/lead/tin solders are used at reflow temperatures of about 190°C to about 210°C, a barrier layer comprising between about 500Å and about 3000Å of titanium/tungsten may be used, according to some embodiments of the present invention.

In other embodiments of the present invention, higher reflow temperatures
15 may be used to accommodate other solders, such as solders comprising tin, silver and antimony, that have a reflow temperature of about 220°C to about 260°C. One example of these solders is a Kester brand R276AC silver-tin solder paste that is about 96.5% tin and about 3.5% silver. Accordingly, in some embodiments of the present invention, the barrier layer **36** comprises a first layer of tungsten or
20 titanium/tungsten **36a** that is about 5000Å thick, and a second layer **36b** comprising nickel that is about 2000Å thick, on the first layer, **36a**. It has been found that some of these embodiments of the present invention can withstand temperatures of between about 325° and about 350°C, for about five minutes, without substantially increasing the forward voltage (V_F) or reduce the light output of the LED. Thus, in some
25 embodiments of the present invention, a multilayer barrier layer **36** comprising a layer of tungsten or titanium/tungsten **36a** and a layer of nickel **36b** is used with solders that have a reflow temperature of more than about 200°C. In other embodiments of the present invention, these multilayer barrier layers may be used with solders that have a reflow temperature of more than about 250°C.

30 In some embodiments of the present invention, tungsten, silver and platinum are deposited, for example, using an e-beam technique. TiW may be deposited using an e-beam technique, but in other embodiments of the present invention, Ti and W are simultaneously sputter deposited. In addition, the TiW may be sputter deposited in

the presence of nitrogen to form a TiN/TiW layer that also forms a barrier to Sn diffusion, in other embodiments of the present invention.

In yet other embodiments of the present invention, the barrier layer **36** may consist essentially of nickel or NiV. In other embodiments of the present invention, the barrier layer **36** may comprise a 2500Å nickel solder barrier covered completely with a layer of gold between about 500Å and 10,000Å thick. The gold layer can prevent the nickel layer from oxidizing. However, the use of a nickel barrier layer may result in unacceptably high degradation of optical and electrical performance at elevated temperature and current levels due to tin migration. Moreover, thicker films of nickel may be difficult to use since the film stress may be high. This may create concern with respect to delamination of the nickel from the adjacent reflective and/or ohmic layers. Moreover, the presence of Au at the edges of the barrier layer may create a path for Sn to migrate down and around the edges of the barrier.

Referring now to Figure 4, in some embodiments of the present invention, a passivation layer **40** is deposited or otherwise formed on the first (or epitaxial-side) surface **20a** of device precursor **10**. In some embodiments of the present invention, passivation layer **40** may comprise SiO₂ and/or SiN (which may be deposited in stoichiometric or non-stoichiometric amounts) and may be deposited by conventional techniques such as PECVD and/or reactive sputtering. The passivation layer **40** is about 1500 Å thick in some embodiments of the present invention. As also shown in Figure 4, this blanket deposition also forms the passivation layer on the sidewalls of the mesas **30** and the multilayer conductive stack **35**, and on the exposed surface of the barrier layer **36**.

Referring now to Figure 5, the passivation layer **40** is patterned with an etch mask (such as a photoresist) to provide a first patterned passivation layer **40a** and to selectively reveal a second reduced area portion **36c** of the surface of barrier layer **36**. In other embodiments of the present invention, a lift off technique may be used to expose the second reduced area portion **36c** of the surface of the barrier layer **36**. In still other embodiments of the present invention, selective deposition of the passivation layer **40a** may be used so that a separate patterning step need not be used.

Still referring to Figure 5, an optional adhesion layer **55** comprising, for example, Ti is then deposited on the second reduced area **36c** of the barrier layer **36** and a bonding layer **60** is deposited on the adhesion layer **55**. These depositions may be performed using the patterned passivation layer **40a** as a mask and/or using lift-off

techniques. The adhesion layer **55** is about 1000 Å thick in some embodiments of the present invention. The bonding layer **60** may comprise Au, Sn and/or AuSn and is about 1000Å thick in some embodiments. The bonding layer **60** may be up to about 1µm thick (if Au) or about 1.7µm thick (if AuSn) in some embodiments of the present invention. However, in some embodiments, use of a layer of Au that is thicker than about 1000Å may lead to inconsistent solder reflow processing or Au embrittlement of the solder attachment, which may result in low shear strength. As shown, the patterned passivation layer **40a** also is on the sidewalls of the adhesion layer **55** and the bonding layer, according to some embodiments of the present invention. In other embodiments, the patterned passivation layer **40a** does not extend on the sidewalls of the adhesion layer **55** and the bonding layer **60**. In these embodiments, the passivation layer may extend on the sidewalls of the conductive stack **35**. According to other embodiments of the present invention, the bonding layer **60** extends away from the multilayer conductive stack **35**, to beyond the patterned passivation layer **40a**. In yet other embodiments, the bonding layer **60** does not extend to beyond the outer surface of the patterned passivation layer **40a**.

For devices formed on conductive substrates, ohmic contacts and a wire bond pad (not shown) are formed on the second substrate face **20b** opposite the epitaxial region to form a vertically-conductive device. Many such embodiments are described in Application Serial No. 10/057,821, corresponding to U.S. Publication No. US 2002/0123164 A1. For devices formed on non-conductive substrates, ohmic contacts and metal bonding layers (not shown) may be formed on an n-type epitaxial region of the device to form a horizontally-conductive device. Many such embodiments also are shown in Application Serial No. 10/057,821, corresponding to U.S. Publication No. US 2002/0123164 A1.

Referring now to Figure 6, the precursor **10** is diced into individual light emitting diodes **100**. Figure 6 also shows that LEDs **100** may be sawed such that they have a beveled sidewall configuration **70** to increase light extraction. Many other embodiments of substrate shaping are described in Application Serial No. 10/057,821, corresponding to U.S. Publication No. US 2002/0123164 A1.

Accordingly, Figure 6 illustrates light emitting diodes **100** according to some embodiments of the present invention that include a substrate **20**, an epitaxial region (referred to previously as a mesa) **30** on the substrate **20** that includes therein a diode region, a multilayer conductive stack **35** on the epitaxial region **30** opposite the

substrate **20**, and a passivation layer **40b** that extends at least partially on the multilayer conductive stack **35** opposite the epitaxial region **30**, to define a reduced area bonding region **36c** on the multilayer conductive stack **35** opposite the epitaxial region **30**. In some embodiments, the passivation layer **40b** also extends across the multilayer conductive stack **35**, across the epitaxial region **30**, and onto the first substrate face **20a**. As also shown in Figure 6, in some embodiments of the present invention, the multilayer conductive stack **35** and the epitaxial region **30** both include sidewalls, and the passivation layer **40b** extends on the sidewalls of the multilayer conductive stack **35** and of the epitaxial region **30**. As also shown in Figure 6, a bonding layer **60** is provided on the bonding region **36c**. The bonding layer **60** also includes a bonding layer sidewall, and the passivation layer **40b** may or may not extend onto the bonding layer sidewall. Finally, an adhesion layer **55** may be provided between the multilayer conductive stack **35** and the bonding layer **60**, and the passivation layer **40b** also may or may not extend onto the sidewall of the adhesion layer **55** and/or the bonding layer **60**.

Still referring to Figure 6, in some embodiments of the present invention, the substrate **20** includes a first face **20a** adjacent the epitaxial region **30** and a second face **20b** opposite the epitaxial region. As illustrated in Figure 6, the bonding layer **60** has smaller surface area than the multilayer conductive stack **35** and the multilayer conductive stack **35** has smaller surface area than the epitaxial region **30**. The epitaxial region **30** has smaller surface area than the first face **20a**. The second face **20b** also has smaller surface area than the first face **20a**.

Figure 6 also illustrates light emitting diodes according to some embodiments of the invention that include a substrate **20** having first and second opposing faces **20a** and **20b**, respectively, the second face **20b** having smaller surface area than the first face. An epitaxial region **30** is on the first face **20a**, and includes therein a diode region. An ohmic layer **32** is on the epitaxial region **30** opposite the substrate **20**. A reflector layer **34** is on the ohmic layer **32** opposite the epitaxial region **30**. A barrier layer **36** is on the reflector layer **34** opposite the ohmic layer **32**. An adhesion layer **55** is on the barrier layer **36** opposite the reflector layer **34**. Finally, a bonding layer **60** is on the adhesion layer **55** opposite the barrier layer **36**.

As also shown in Figure 6, in some embodiments of the present invention, the barrier layer **36** comprises tungsten, titanium/tungsten and/or titanium nitride/tungsten. In other embodiments of the present invention, the tin barrier layer

36 comprises a first layer **36a** comprising tungsten and a second layer **36b** comprising nickel on the first layer **36a** comprising tungsten.

As also shown in Figure 6, in some embodiments of the present invention, the epitaxial region **30** has smaller surface area than the first face **20a**. The barrier layer **36**, the reflector layer **34** and the ohmic layer **32** have same surface area, that surface area being less than that of the epitaxial region **30**. The adhesion layer **55** and the bonding layer **60** have same surface area, that surface area being smaller than that of the barrier layer **36**, the reflector layer **34** and the ohmic layer **32**.

Finally, as also shown in Figure 6, in some embodiments of the invention, the epitaxial region **30**, the ohmic layer **32**, the reflector layer **34**, the barrier layer **36**, the adhesion layer **55** and the bonding layer **60** each include a sidewall and the light emitting diode **100** further includes a passivation layer **40b** on the sidewalls of the epitaxial region **30**, the ohmic layer **32**, the reflector layer **34** and the barrier layer **36**. The passivation layer also may or may not extend onto the sidewalls of the adhesion layer **55** and/or the bonding layer **60**. The passivation layer **40b** also may extend on the first face **20a** of the substrate **20**.

Figure 7 illustrates other embodiments of the present invention in which the bonding layer **60** comprises a solder wetting layer **62** and a wetting passivation layer **64**. In some embodiments, the solder wetting layer **62** comprises nickel and is about 2000Å thick. In some embodiments, the wetting passivation layer **64** comprises Au and is about 500Å thick. Use of the nickel solder wetting layer **62** can provide an enhanced mechanical bond to the solder, which can increase the shear strength of the connection and can reduce the possibility of mechanical failure, according to some embodiments of the invention.

Figure 8 illustrates other embodiments of the present invention in which the bonding layer **60** and optional adhesion layer **55** do not extend beyond the outer edge **40c** of the passivation layer **40b**. This configuration may be used when solder bonding is used to mount the LED to a lead frame, according to some embodiments of the invention.

Figures 1-8 also illustrate methods of fabricating a plurality of light emitting diodes according to some embodiments of the present invention. These methods comprise epitaxially forming a plurality of spaced apart mesa regions **30** on a substrate **20**, the mesa regions including therein a diode region (Figure 2). A first reduced area region **30c** is defined on the mesa regions (Figure 2). A multilayer

conductive stack **35** that includes a barrier layer, is formed on the first reduced area regions **30c** of the mesa regions **30** (Figure 3). A passivation layer **40a** is formed on the substrate **20** between the mesa regions **30**, on exposed portions of the mesa regions and on exposed portions of the multilayer stack **35**, the passivation layer **40a** defining a second reduced area region **36c** on the multilayer conductive stack **35** (Figures 4 and 5). A bonding layer **60** then is formed on the second reduced area regions **36c** of the multilayer conductive stacks **35** (Figure 5). The substrate **20** is diced between the mesas **30** to produce the plurality of light emitting diodes **100** (Figure 6).

Referring now to Figures 9 and 10, once the LED **100** has been diced, the LED and a conductive submount **75** are attached to one another as illustrated in Figures 9 and 10. Figure 9 illustrates embodiments of the present invention in which the LED **100** is mounted in a "flip-chip" configuration with the epitaxial side down, via thermosonic and/or thermocompression bonding. That is, instead of using an epoxy or a solder to form a mechanical connection or bond between the LED **100** and the submount **75**, the bonding layer **60** of LED **100** is thermosonically or thermocompressively bonded directly to the submount **75** as described, for example, in United States Provisional Application Serial No. 60/307,234 and U.S. Publication No. US 2003/0042507 A1.

In some embodiments of thermosonic or thermocompression bonding according to some embodiments of the present invention, the LED chip **100** is placed into mechanical contact with the submount and subjected to mechanical and/or sonic stimulation at a temperature greater than the eutectic temperature of the bonding metal. The bonding metal thus forms a bond with the metallic submount, which provides an electromechanical connection between the LED and the submount. In embodiments of the present invention in which the bonding layer **60** has an Au/Sn relative composition of about 80%/20%, the temperature used for thermosonic bonding may be approximately 300 °C.

The presence of the barrier layer **36** and/or the passivation layer **40b** can reduce or prevent unwanted interaction between metals in the bonding layer **60** with the reflective layer **34** and/or the ohmic layer **32**. The barrier layer **36** and/or the passivation layer **40** may also serve to retard or inhibit unwanted migration of metal along the edge of the metal stack **35**.

In other embodiments of the present invention, the LED **100** may be mounted on the submount **75** using a metal solder **80** such as SnAg, SnPb and/or other solders as illustrated in Figure 10. The passivation layer **40b** can reduce or prevent Sn from solder **80** from migrating to (and thereby potentially degrading) the reflective layer **34** and/or ohmic layer **32**. The passivation layer **40b** also can reduce or prevent conductive solder **80** from contacting the substrate **20** and mesa sidewalls, which may otherwise result in the formation of unwanted parasitic Schottky contacts to n-type regions of the device **100**. Other bonding techniques that may be used, according to other embodiments of the present invention, are disclosed in the above-cited Provisional Application Serial No. 60/307,311 and U.S. Publication No. 2003/0045015 A1.

Test Results

The following test results are illustrative and shall not be construed as limiting the scope of the present invention. Figures 11A-11D graphically illustrate test results for a 2500Å Ni solder barrier while Figures 12A-12D graphically illustrate results for a 5000Å TiW barrier.

In a first test, the high temperature operating life (HTOL) of a number of LED samples was measured. In this test, twenty LEDs were fabricated with TiW solder barriers **36**, SiN passivation layers **40b** and gold bonding layers **60**. Twenty LEDs also were fabricated with the same structure except that they used an Ni solder barrier. The devices were mounted on silver-plated 5mm radial lead frames via solder bonding. The devices were then operated at a forward current of 20mA while being maintained at a temperature of 85°C. Optical output power and V_F were measured after 24, 168, 336, 504, 672, 864 and 1008 hours. As shown in Figures 11A and 12A, the devices with the Ni barrier exhibited larger degradation in light output, compared to the devices with the TiW barrier. Moreover, V_F increased more in the Ni barrier devices (Figure 11B) than in the TiW barrier devices (Figure 12B).

In a second test, twenty LEDs were fabricated with TiW solder barriers **36**, SiN passivation layers **40b** and gold bonding layers **60**, and twenty LEDs were fabricated with the same structure except that they used the Ni barrier. The devices were mounted as described above in reference to the HTOL tests and operated at a pulsed forward current of 70 mA (25% duty cycle at 4 kHz) for a period of 504 hours while being maintained at a temperature of 85°C and a relative humidity of 85%.

Optical output power and V_F were measured after 24, 168, 336, 504, 672, 864 and 1008 hours. As shown in Figures 11C and 12C, larger degradation in light output occurred with the Ni barrier and, as shown in Figures 11D and 12D, a larger increase in V_F occurred with the Ni barrier.

5

Barrier Layer/Sublayer Structures and Fabrication Methods

It is desirable to limit migration of metal from the reflector layer **34**, also referred to as a mirror **34**, since such metal can short circuit the pn junction of the device if it comes into contact with the mesa **30**. This is particularly true when the
10 mirror **34** comprises silver, which tends to migrate easily at relatively low temperatures. See, for example, the textbook entitled *Corrosion and Environmental Degradation, Vol. II*, to Schütze, 2000, pp. 451-452. In the presence of surface moisture and an electric field, silver ions can form at positive (anodic) metallizations due to oxidation and/or corrosion. When the silver ions migrate to negative (cathodic)
15 metallizations, they can plate out in the form of a dendrite (i.e., a branching structure). The dendrite may eventually bridge the gap between the anode and cathode of the LED and cause a short circuit.

In order to limit migration of the mirror metal **34** to the mesa **30**, according to some embodiments of the invention, it may be desirable to extend the barrier layer **36**
20 over the sidewalls of the reflector layer **34**, as illustrated in Figure 13. This may be accomplished by performing an additional photolithography step to form the ohmic contact layer **32** and the reflector layer **34** to have a reduced width compared to the width of barrier layer **36**, and/or using other conventional techniques. Thus, when barrier layer **36** is formed, e.g., deposited, it may contact the sidewalls of reflector
25 layer **34** and ohmic contact **32** as well as a portion of the surface of mesa **30** surrounding the ohmic contact **32** and reflector layer **34**.

If the barrier layer **36** is formed in such a way as to cover the sidewalls of reflector layer **34** as illustrated in Figure 13, it is possible for cracks in the barrier layer to form near the sidewalls of the reflector layer **34**. Such cracks may provide a
30 migration path for silver from the reflector layer **34** to escape and potentially migrate to the mesa **30**. The formation of cracks is illustrated in Figure 14, which shows a mesa **30** on which a thin ohmic contact layer **32** has been formed. A silver reflector layer **34** is formed on the ohmic contact layer **32**, and the entire structure is covered with a layer **36** of a barrier metal such as TiW. As can be seen in Figure 14, when the

TiW barrier metal layer **36** is deposited, it forms vertically oriented grains **47** separated by grain boundaries **49**. Misalignment of the grains **47** at the corners of the reflector layer **34** may cause cracks **51** to form, which may provide a migration path for metal from the reflector layer **34** to escape and potentially migrate to the mesa **30**.

5 In order to reduce or avoid the formation of cracks **51**, a barrier layer **36** according to some embodiments of the present invention may comprise a plurality of alternating sublayers of a barrier metal **36A** such as TiW and a second metal **36B** such as platinum, as illustrated in Figure 15. Suitable metals for second metal **36B** are Pt, Ti, Ni and/or other metals. Metal **36B** should not be susceptible to migration in the
10 LED structure and should have a melting point higher than any of the processing steps subsequently used in the fabrication of the LED (in some embodiments at least about 200°C). In one embodiment, barrier layer **36** comprises alternating sublayers of about 1000Å of TiW and about 500Å of platinum repeated at least two times with the top and bottom sublayers of the stack both comprising TiW. In other words, the plurality
15 of first and second alternating sublayers define first and second outer sublayers that comprise the first sublayer. In addition, the second (final) outer layer of TiW in the stack may be made approximately 5000Å thick to act as a solder barrier. In one embodiment, the TiW/Pt layer stacks are repeated six times with the final (terminating) layer of TiW being about 5000Å thick. Many other thicknesses of the
20 barrier metal **36A** and the second metal **36B** may be used in other embodiments of the invention. In general, barrier metal **36A** should be sufficiently thin to reduce or prevent cracking, but sufficiently thick to provide an effective barrier, while the second metal **36B** should be sufficiently thin so as not to degrade the resistance of the contact, but sufficiently thick to prevent cracks in the barrier metal layer **36A** from
25 propagating across the second barrier layer.

As illustrated in Figure 15, the grain boundaries **49** of successive layers of TiW do not necessarily align vertically, thereby inhibiting the formation of long cracks through the barrier layer **36** that may otherwise provide a migration path for the reflector metal. In that regard, the successive TiW layers may form a pattern that
30 generally resembles a brick wall with stacks of offset grains in each layer.

This effect is illustrated in Figures 16 and 17, which are 40,000X SEM images of a metal stack fabricated in accordance with the embodiments illustrated in Figures 14 and 15, respectively. In the structure shown in Figure 16, a TiW barrier layer **36** is deposited as a single layer over a reflector **34** and ohmic contact **32**. Vertical grain

boundaries **49** are visible within the barrier layer **36**. In addition, a crack **51** is visible extending from the edge of the reflector layer **34** to the surface of the barrier layer.

In contrast, in the structure shown in Figure 17, the barrier layer **36** comprises a plurality of alternating layers of TiW **36A** and platinum **36B**. The grain boundaries
5 **49** in the alternating layers of TiW **36A** can be clearly seen to form a brick wall pattern over the reflector layer **34** and mesa **30**. In contrast to the structure shown in Figure 16, no cracking is evident in the barrier layer **36**.

In the drawings and specification, there have been disclosed embodiments of the invention and, although specific terms are employed, they are used in a generic
10 and descriptive sense only and not for purposes of limitation, the scope of the invention being set forth in the following claims.

What is Claimed is:

1. A semiconductor light emitting device comprising:
a substrate;
an epitaxial region on the substrate that includes therein a light-emitting
5 region;
a multilayer conductive stack comprising a reflector layer including a reflector
layer sidewall, on the epitaxial region; and
a barrier layer on the reflector layer and extending on the reflector layer
sidewall.
10
2. A light-emitting device according to Claim 1:
wherein the multilayer conductive stack further comprises an ohmic layer
including an ohmic layer sidewall, between the reflector layer and the epitaxial
region; and
15 wherein the barrier layer further extends on the ohmic layer sidewall.
3. A light emitting device according to Claim 1 wherein the barrier layer
further extends onto the epitaxial region outside the multilayer conductive stack.
- 20 4. A light emitting device according to Claim 2 wherein the barrier layer
further extends onto the epitaxial region outside the multilayer conductive stack.
5. A light emitting device according to Claim 1 wherein the barrier layer
comprises a plurality of first and second alternating sublayers.
25
6. A light emitting device according to Claim 5 wherein the first
sublayers include grain boundaries therein and wherein the second sublayers are
substantially free of grain boundaries.
- 30 7. A light emitting device according to Claim 5 wherein the first
sublayers include grain boundaries therein that are arranged such that the grain
boundaries define an offset brick wall structure in the first sublayers.

8. A light emitting device according to Claim 5 wherein the first sublayers comprise titanium tungsten and wherein the second sublayers comprise platinum, titanium and/or nickel.
- 5 9. A light emitting device according to Claim 7 wherein the first sublayers comprise titanium tungsten and wherein the second sublayers comprise platinum, titanium and/or nickel.
- 10 10. A light emitting device according to Claim 5 wherein the first sublayers are configured to reduce migration of metal from the reflector layer and wherein the second sublayers are configured to prevent at least some grain boundaries in the first sublayers from propagating thereacross.
- 15 11. A light emitting device according to Claim 7 wherein the first sublayers are configured to reduce migration of metal from the reflector layer and wherein the second sublayers are configured to prevent at least some grain boundaries in the first sublayers from propagating thereacross.
- 20 12. A light emitting device according to Claim 5 wherein the second sublayers are thinner than the first sublayers.
- 25 13. A light emitting device according to Claim 5 wherein the plurality of first and second alternating sublayers define first and second outer sublayers that comprise the first sublayer.
- 30 14. A light emitting device according to Claim 13 wherein the first outer sublayer is adjacent the reflector layer and the second outer sublayer is remote from the reflector layer and wherein the second outer sublayer is thicker than the first outer sublayer.
15. A light emitting device according to Claim 9 wherein the second sublayers are thinner than the first sublayers.

16. A light emitting device according to Claim 15 wherein the plurality of first and second alternating sublayers define first and second outer sublayers that comprise the first sublayer.
- 5 17. A light emitting device according to Claim 16 wherein the first outer sublayer is adjacent the reflector layer and the second outer sublayer is remote from the reflector layer and wherein the second outer sublayer is thicker than the first outer sublayer.
- 10 18. A light emitting device according to Claim 5 wherein the first sublayers comprise titanium tungsten sublayers that are about 1000Å thick and wherein the second sublayers comprise platinum sublayers that are about 500Å thick.
- 15 19. A light emitting device according to Claim 17 wherein the first sublayers comprise titanium tungsten sublayers that are about 1000Å thick, wherein the second sublayers comprise platinum sublayers that are about 500Å thick, wherein the first outer sublayer comprises a titanium tungsten sublayer that is about 1000Å thick and wherein the second outer sublayer comprises a titanium tungsten sublayer that is about 5000Å thick.
- 20 20. A light emitting device according to Claim 1 wherein the barrier layer is configured to prevent at least some cracks from occurring therein, adjacent the reflector layer sidewall.
- 25 21. A light emitting device according to Claim 1 wherein the substrate comprises silicon carbide and the epitaxial region comprises gallium nitride.
- 30 22. A light emitting diode according to Claim 1 wherein the ohmic layer comprises platinum, palladium, nickel/gold, nickel oxide/gold, nickel oxide/platinum, titanium and/or titanium/gold and wherein the reflector layer comprises aluminum and/or silver.
23. A light emitting device according to Claim 1 wherein the reflector layer comprises silver.

24. A light emitting device according to Claim 5 wherein the first sublayers are sufficiently thick to reduce migration of metal from the reflector but sufficiently thin to prevent at least some cracking of the first sublayers and wherein the second sublayers are sufficiently thick to prevent at least some grain boundaries in the first sublayers from propagating thereacross but sufficiently thin so as not to degrade resistance of the multilayer conductive stack.

25. In a semiconductor light emitting device that includes a substrate, an epitaxial region on the substrate that includes therein a device region and a multilayer conductive stack comprising a reflector layer including a reflector layer sidewall, on the epitaxial region, a method of reducing migration of metal from the reflector layer into the epitaxial region, the method comprising:
forming a barrier layer on the reflector layer that extends on the reflector layer sidewall.

26. A method according to Claim 25 wherein the multilayer conductive stack further comprises an ohmic layer including an ohmic layer sidewall, between the reflector layer and the epitaxial region, the forming further comprising:
forming a barrier layer on the reflector layer and extending on a sidewall of the reflector layer sidewall and on the ohmic layer sidewall.

27. A method according to Claim 26 wherein the forming further comprises:
forming a barrier layer on the reflector layer and extending on the reflector layer sidewall, on the ohmic layer sidewall and onto the epitaxial region outside the multilayer conductive stack.

28. A method according to Claim 25 further comprising:
forming the barrier layer as a plurality of alternating first and second sublayers.

29. A method according to Claim 28 wherein the first sublayers include grain boundaries therein that are arranged such that the grain boundaries define an offset brick wall structure of the first sublayers.

5 30. A method according to Claim 28 wherein the forming the barrier layer as a plurality of first and second alternating sublayers further comprises forming the second sublayers to be thinner than the first sublayers.

31. A method according to Claim 28 further comprising:
10 terminating the plurality of alternating first and second sublayers with a first sublayer to define an outer sublayer.

32. A method according to Claim 31 wherein the outer sublayer is thicker than the first sublayers.

15

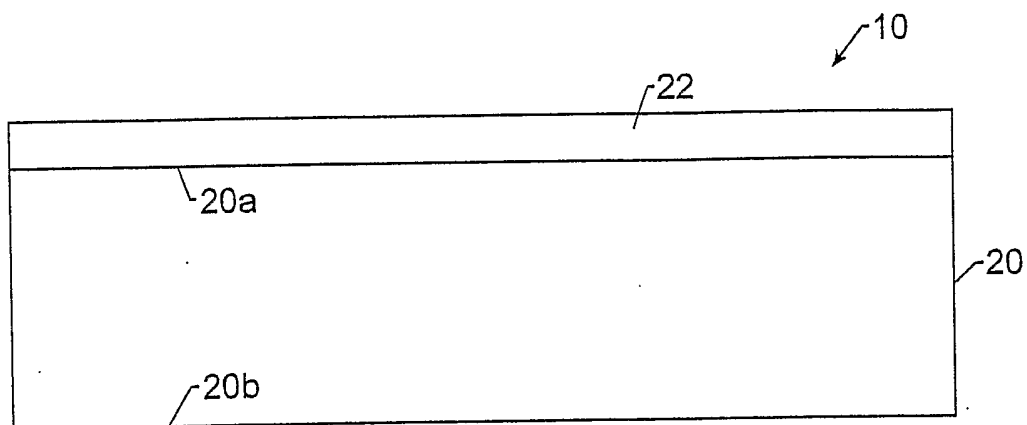
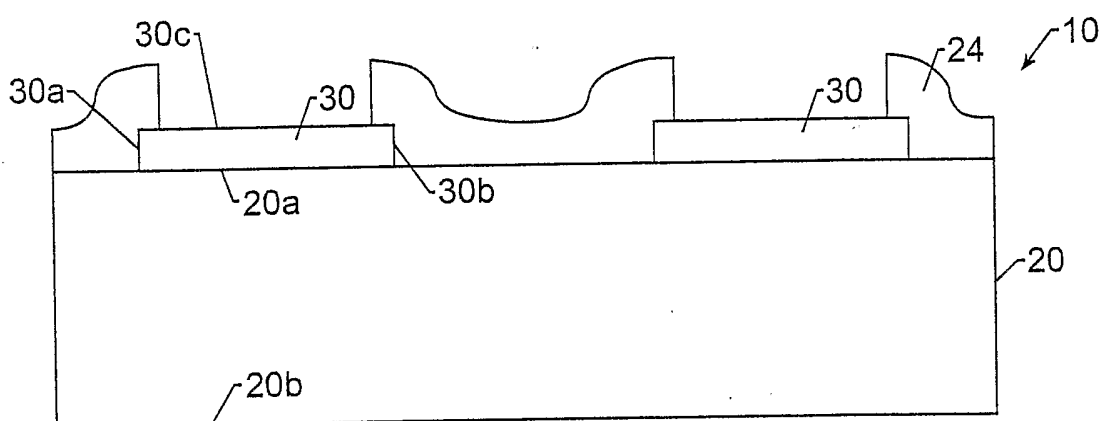
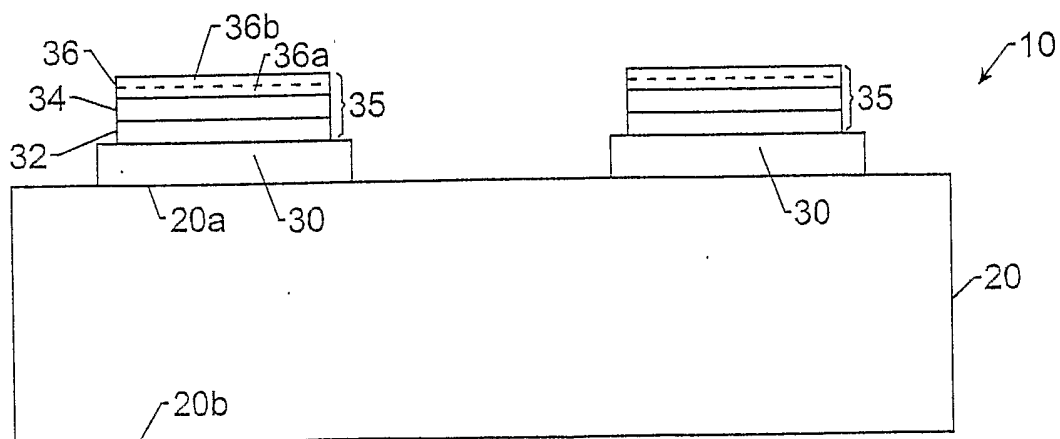
33. A method according to Claim 28 wherein the second sublayers are thinner than the first sublayers.

34. A method according to Claim 28 wherein the substrate comprises
20 silicon carbide and the epitaxial region comprises gallium nitride.

35. A method according to Claim 28 wherein the reflector layer comprises silver.

25 36. A method according to Claim 28 wherein the forming the barrier layer as a plurality of first and second alternating sublayers comprises:

forming the first sublayers sufficiently thick to reduce migration of metal from the reflector but sufficiently thin to prevent cracking of the first sublayers and forming the second sublayers sufficiently thick to prevent at least some grain boundaries in the
30 first sublayers from propagating thereacross but sufficiently thin so as not to degrade resistance of the multilayer conductive stack.

FIG. 1.FIG. 2.FIG. 3.

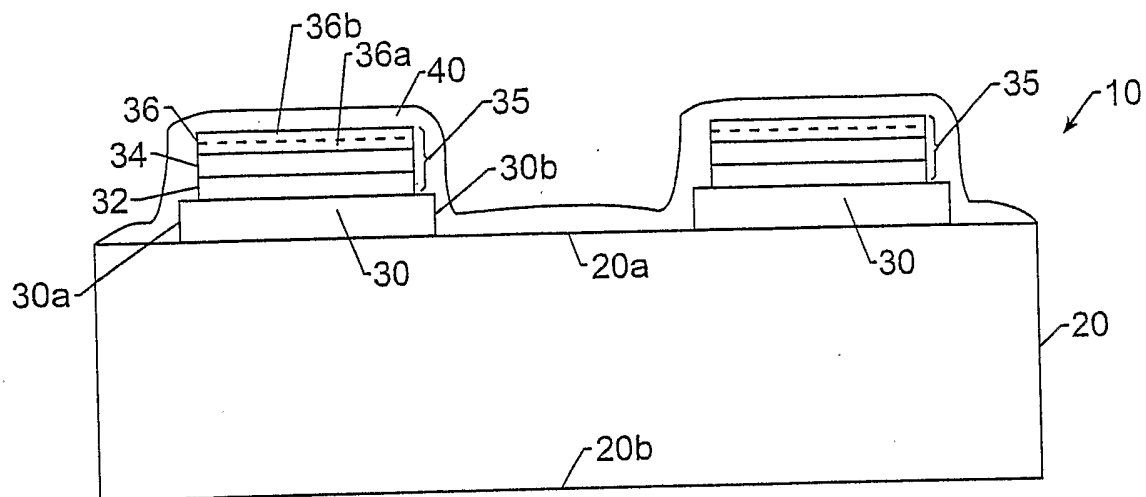


FIG. 4.

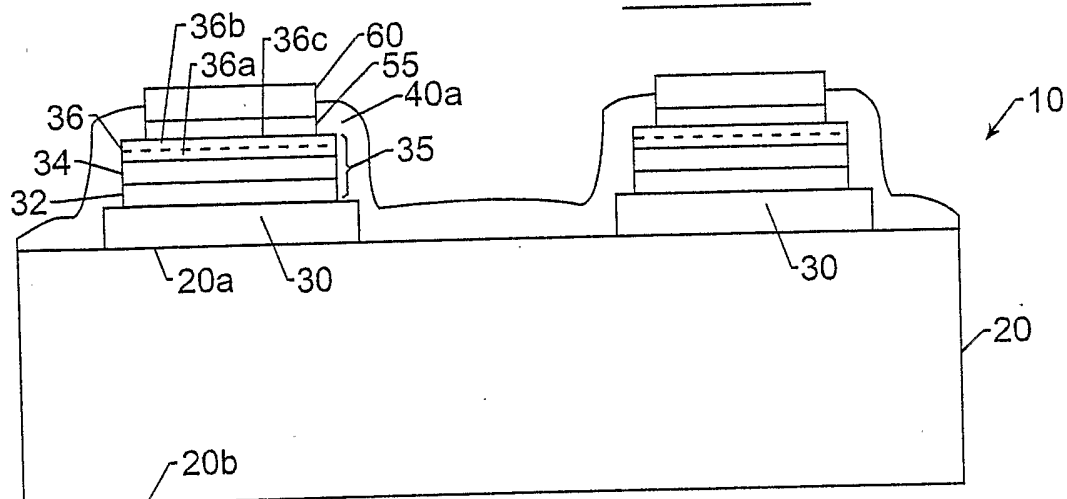


FIG. 5.

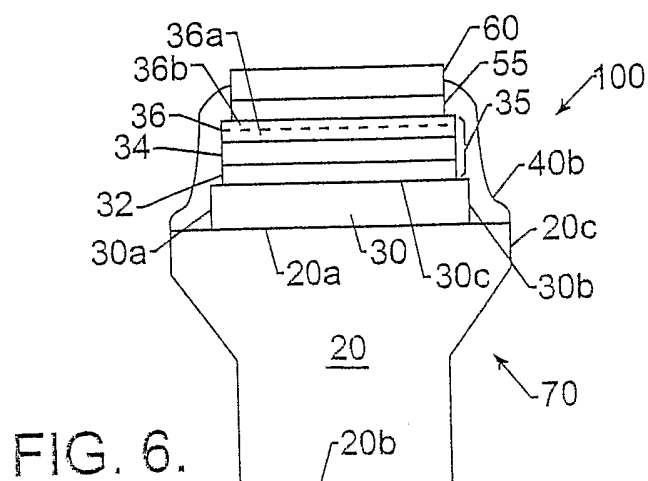


FIG. 6.

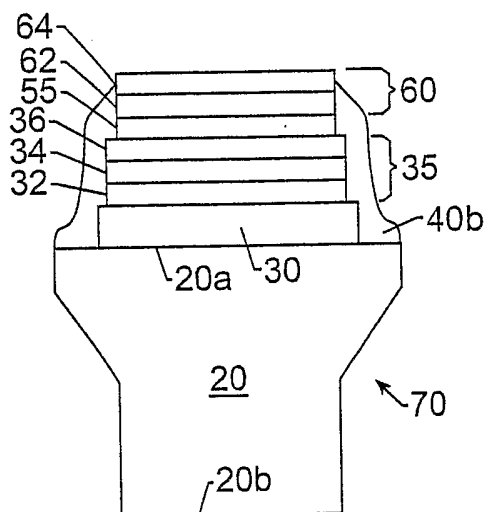


FIG. 7.

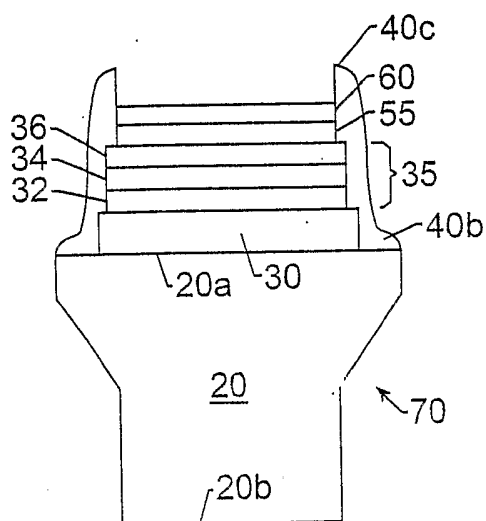
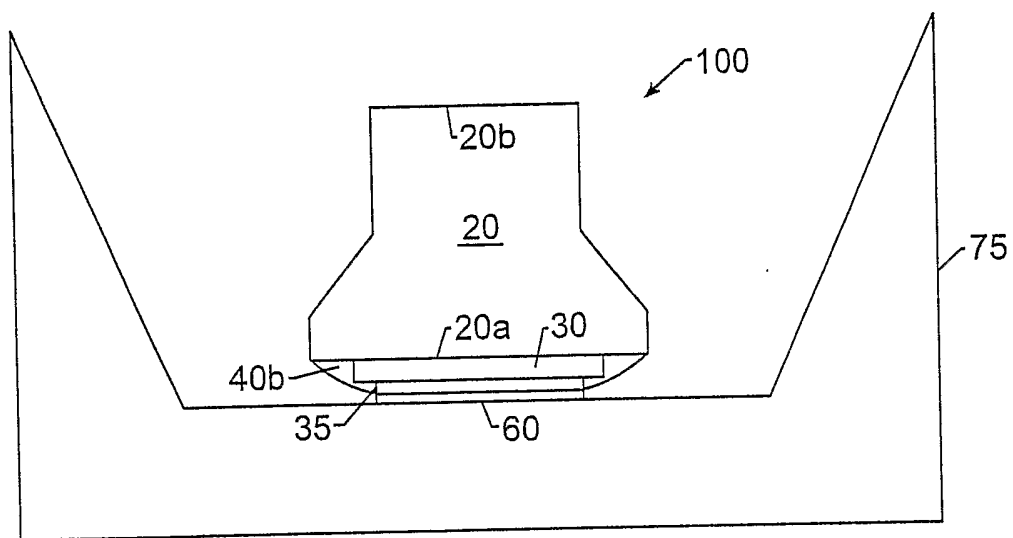
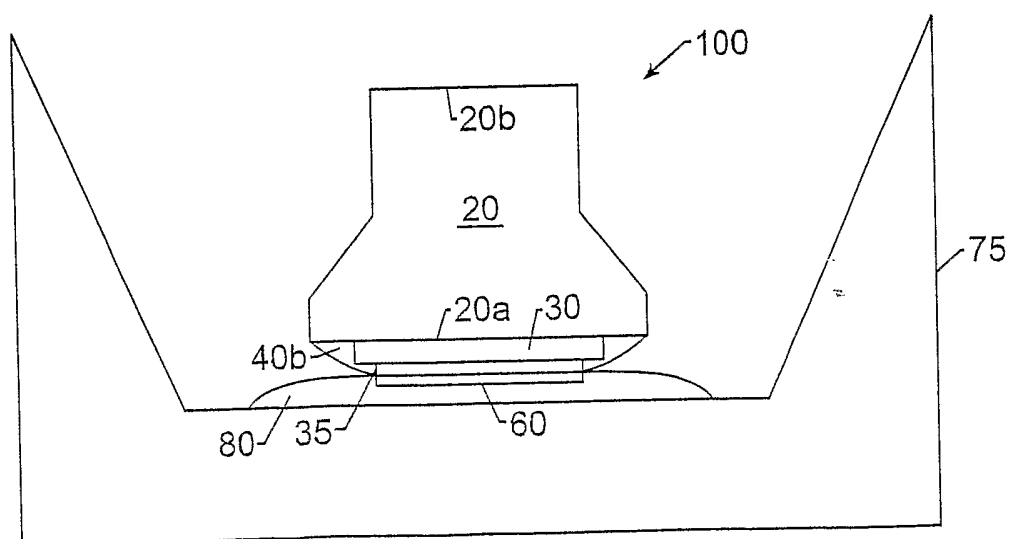
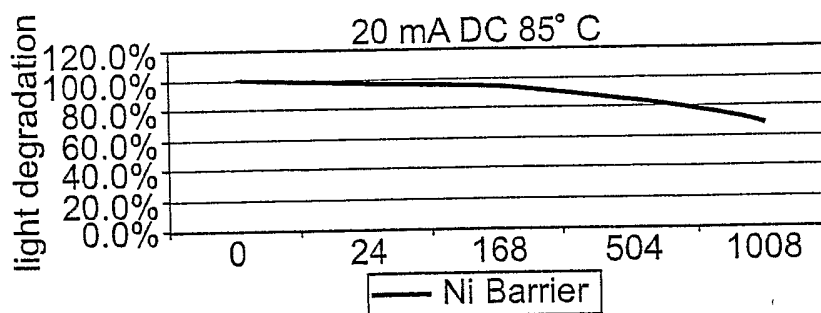
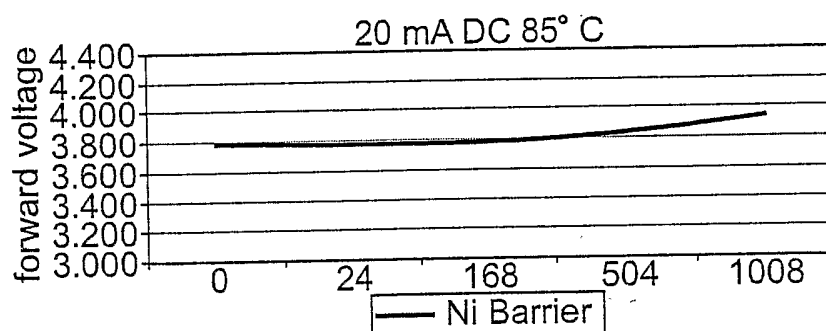
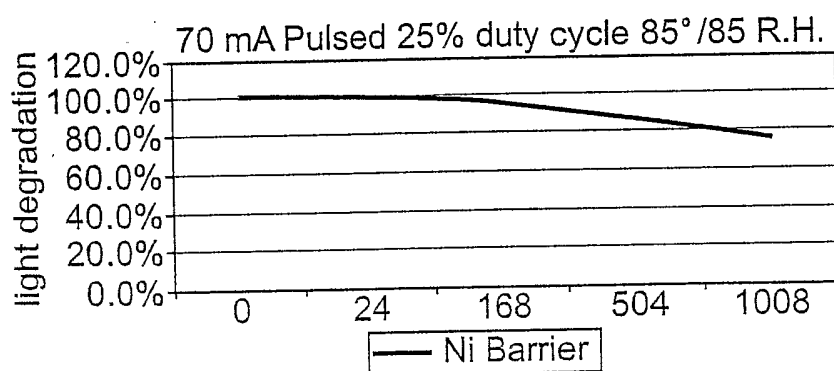
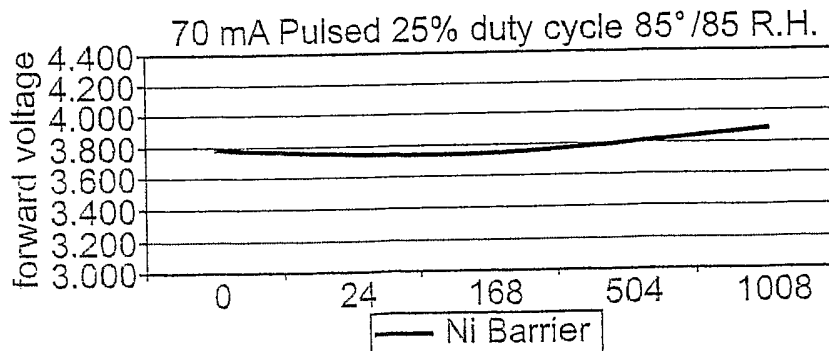
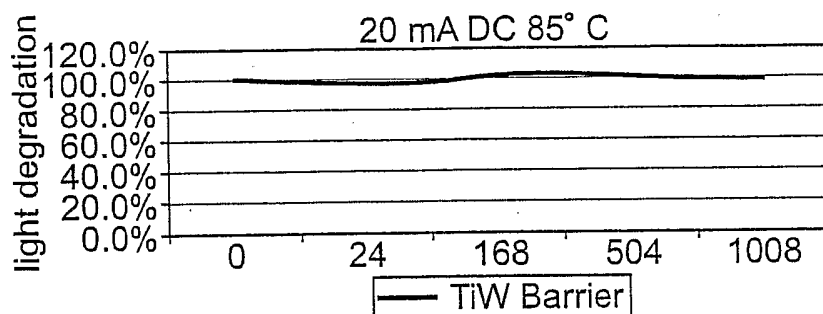
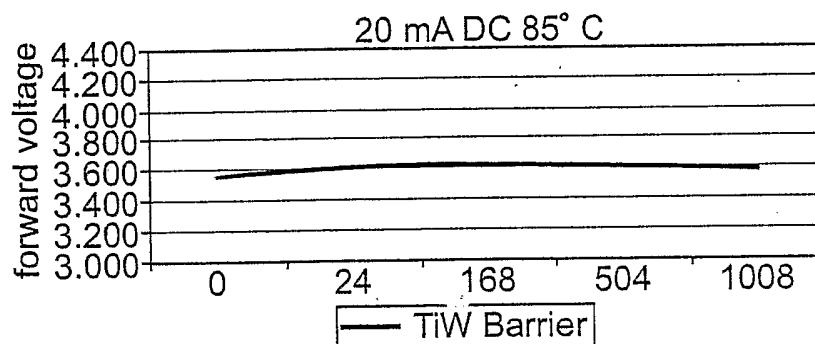
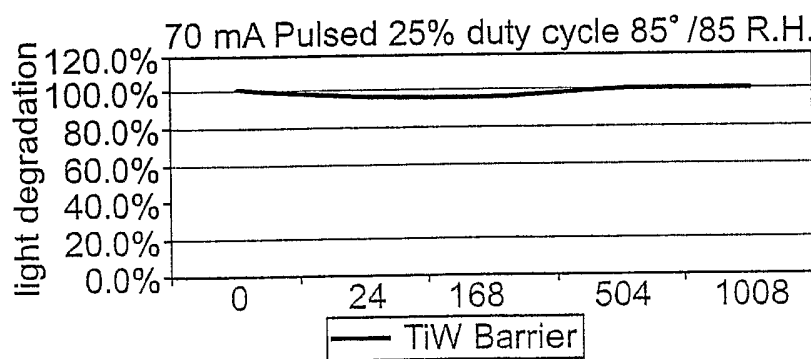
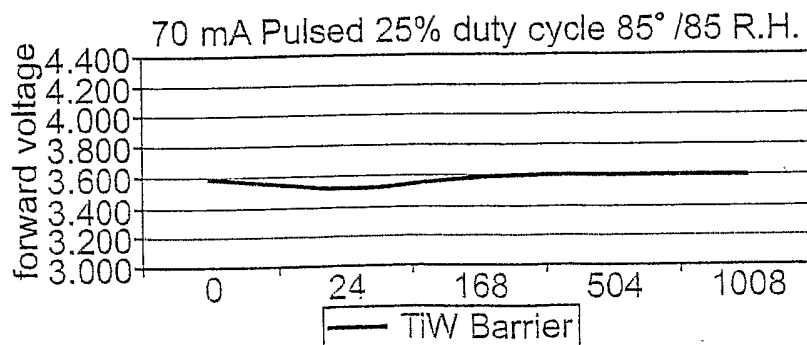


FIG. 8.

FIG. 9.FIG. 10.

FIG. 11A.FIG. 11B.FIG. 11C.FIG. 11D.

FIG. 12A.FIG. 12B.FIG. 12C.FIG. 12D.

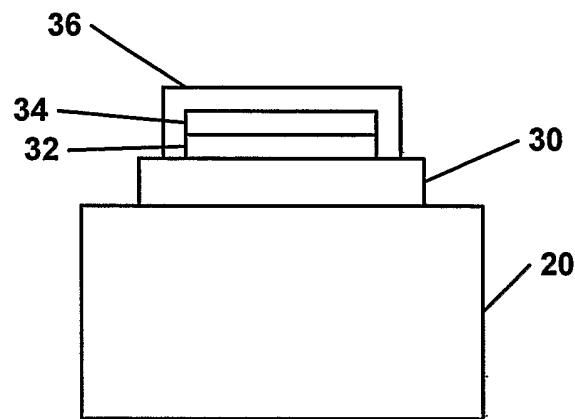


FIGURE 13

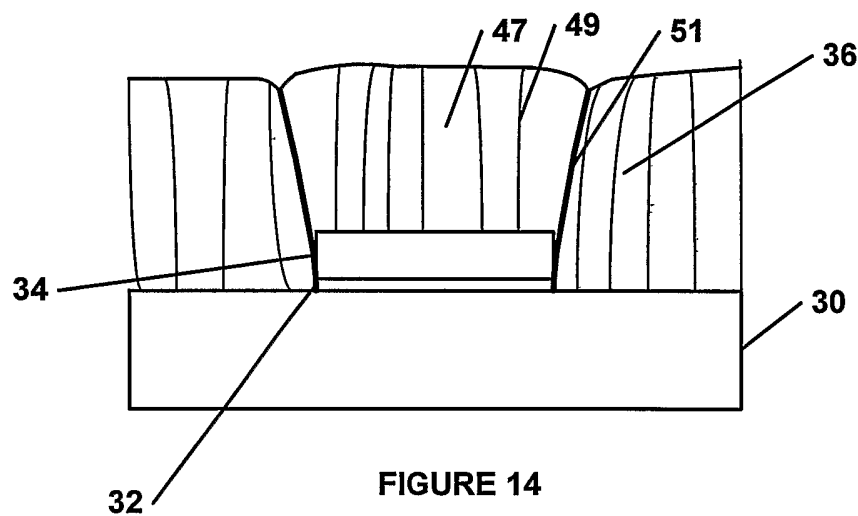


FIGURE 14

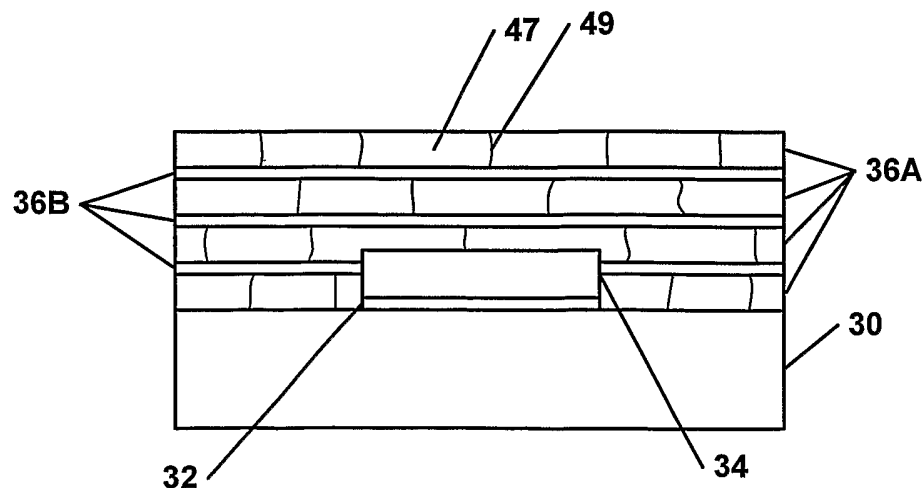


FIGURE 15

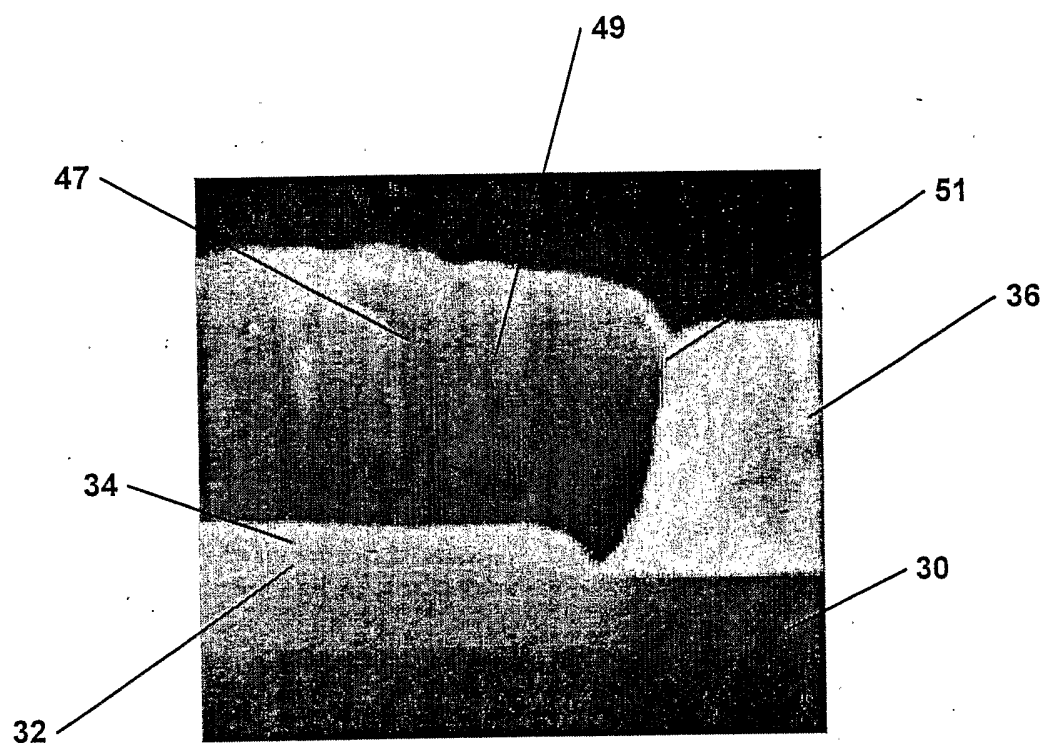


FIGURE 16

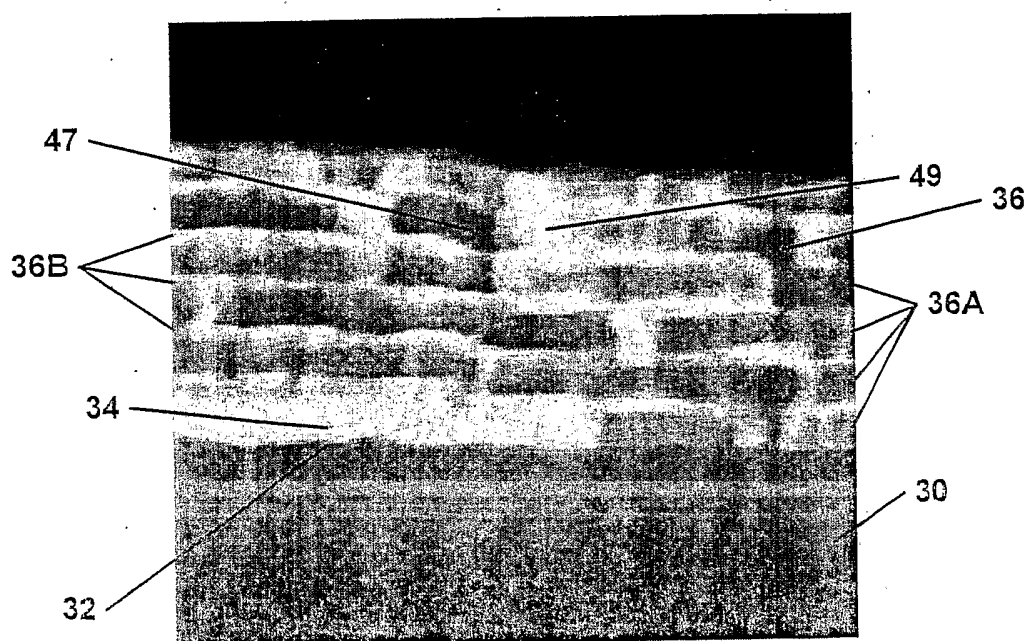


FIGURE 17