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(54) **FUSION FORMABLE SODIUM FREE GLASS**

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(57) **ABSTRACT**

A compositional range of fusion-formable, high strain point sodium free, silicate, aluminosilicate and boroaluminosilicate glasses are described herein. The glasses can be used as substrates for photovoltaic devices, for example, thin film photovoltaic devices such as CIGS photovoltaic devices. These glasses can be characterized as having strain points $\geq$ 540° C., thermal expansion coefficient of from 6.5 to 10.5 ppm/ $^{\circ}$  C., as well as liquidus viscosities in excess of 50,000 poise. As such they are ideally suited for being formed into sheet by the fusion process.

## FUSION FORMABLE SODIUM FREE GLASS

### CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application is a continuation of U.S. application Ser. No. 15/651,654 filed on Jul. 17, 2017, which is a continuation of U.S. application Ser. No. 15/041,697 filed Feb. 11, 2016, now abandoned, which is a continuation of U.S. application Ser. No. 12/788,763 filed on May 27, 2010, now U.S. Pat. No. 9,371,247, which claims the benefit of priority to U.S. Provisional Application No. 61/182404 filed on May 29, 2009.

### BACKGROUND

#### Field

[0002] Embodiments relate generally to sodium free glasses and more particularly to fusion formable sodium free glasses which may be useful in photochromic, electrochromic, Organic Light Emitting Diode (OLED) lighting, or photovoltaic applications, for example, thin film photovoltaics.

#### Technical Background

[0003] The fusion forming process typically produces flat glass with optimal surface and geometric characteristics useful for many electronics applications, for instance, substrates used in electronics applications, for example, display glass for LCD televisions.

[0004] Over the last 10 years, Corning fusion glass products include 1737<sup>TM</sup>, 1737G<sup>TM</sup>, Eagle2000<sup>TM</sup>, EagleXG<sup>TM</sup>, Jade<sup>TM</sup>, and Codes 1317 and 2317 (Gorilla Glass<sup>TM</sup>). Efficient melting is generally believed to occur at a temperature corresponding to a melt viscosity of about 200 poise (p). These glasses share in common 200p temperatures in excess of 1600° C., which can translate to accelerated tank and electrode corrosion, greater challenges for fining due to still more elevated finer temperatures, and/or reduced platinum system life time, particularly around the finer. Many have temperatures at 3000 poise in excess of about 1300° C., and since this is a typical viscosity for an optical stirrer, the high temperatures at this viscosity can translate to excessive stirrer wear and elevated levels of platinum defects in the body of the glass.

[0005] Many of the above described glasses have delivery temperatures in excess of 1200° C., and this can contribute to creep of isopipe refractory materials, particularly for large sheet sizes.

[0006] These attributes combine so as to limit flow (because of slow melt rates), to accelerate asset deterioration, to force rebuilds on timescales much shorter than product lifetimes, to force unacceptable (arsenic), expensive (capsule) or unwieldy (vacuum fining) solutions to defect elimination, and thus contribute in significant ways to the cost of manufacturing glass.

[0007] In applications in which rather thick, comparatively low-cost glass with less extreme properties is required, these glasses are not only overkill, but prohibitively expensive to manufacture. This is particularly true when the competitive materials are made by the float process, a very good process for producing low cost glass with rather conventional properties. In applications that are cost sensitive, such as large-area photovoltaic panels and OLED

lighting, this cost differential is so large as to make the price point of LCD-type glasses unacceptable.

[0008] To reduce such costs, it is advantageous to drive down the largest overall contributors (outside of finishing), and many of these track directly with the temperatures used in the melting and forming process. Therefore, there is a need for a glass that melts at a lower temperature than those aforementioned glasses.

[0009] Further, it would be advantageous to have a glass useful for low temperature applications, for instance, photovoltaic and OLED light applications. Further, it would be advantageous to have a glass whose processing temperatures were low enough that the manufacturing of the glass would not excessively consume the energy that these applications are aiming to save.

### SUMMARY

[0010] A compositional range of fusion-formable, high strain point sodium free, silicate, aluminosilicate and boroaluminosilicate glasses useful, for example, for thin-film photovoltaic applications are described herein. More specifically, these glasses are advantageous materials to be used in copper indium gallium diselenide (CIGS) photovoltaic modules where the sodium required to optimize cell efficiency is not to be derived from the substrate glass but instead from a separate deposited layer consisting of a sodium containing material such as NaF. Current CIGS module substrates are typically made from soda-lime glass sheet that has been manufactured by the float process. However, use of higher strain point glass substrates can enable higher temperature CIGS processing, which is expected to translate into desirable improvements in cell efficiency. Moreover, it may be that the smoother surface of fusion-formed glass sheets yields additional benefits, such as improved film adhesion, etc.

[0011] Accordingly, the sodium free glasses described herein can be characterized by strain points 540° C., for example, 560° C. so as to provide advantage with respect to soda-lime glass and/or liquidus viscosity 30,000 poise to allow manufacture via the fusion process. In order to avoid thermal expansion mismatch between the substrate and CIGS layer, the inventive glasses are further characterized by a thermal expansion coefficient in the range of from 6.5 to 10.5 ppm/<sup>o</sup> C.

[0012] One embodiment is a glass comprising, in weight percent:

- [0013] 35 to 75 percent SiO<sub>2</sub>;
- [0014] 0 to 15 percent Al<sub>2</sub>O<sub>3</sub>;
- [0015] 0 to 20 percent B<sub>2</sub>O<sub>3</sub>;
- [0016] 3 to 30 percent K<sub>2</sub>O;
- [0017] 0 to 15 percent MgO;
- [0018] 0 to 10 percent CaO;
- [0019] 0 to 12 percent SrO;
- [0020] 0 to 40 percent BaO; and
- [0021] 0 to 1 percent SnO<sub>2</sub>,

[0022] wherein the glass is substantially free of Na<sub>2</sub>O.

[0023] In another embodiment, the glass comprises, in weight percent:

- [0024] 35 to 75 percent SiO<sub>2</sub>;
- [0025] greater than 0 to 15 percent Al<sub>2</sub>O<sub>3</sub>;
- [0026] greater than 0 to 20 percent B<sub>2</sub>O<sub>3</sub>;
- [0027] 3 to 30 percent K<sub>2</sub>O;
- [0028] greater than 0 to 15 percent MgO;
- [0029] greater than 0 to 10 percent CaO;

- [0030] greater than 0 to 12 percent SrO;
- [0031] greater than 0 to 40 percent BaO; and
- [0032] greater than 0 to 1 percent SnO<sub>2</sub>,
- [0033] wherein the glass is substantially free of Na<sub>2</sub>O.
- [0034] In another embodiment, the glass comprises, in weight percent:
  - [0035] 39 to 75 percent SiO<sub>2</sub>;
  - [0036] 2 to 13 percent Al<sub>2</sub>O<sub>3</sub>;
  - [0037] 1 to 11 percent B<sub>2</sub>O<sub>3</sub>;
  - [0038] 3 to 30 percent K<sub>2</sub>O;
  - [0039] 0 to 7 percent MgO;
  - [0040] 0 to 10 percent CaO;
  - [0041] 0 to 12 percent SrO;
  - [0042] 0 to 40 percent BaO; and
  - [0043] 0 to 1 percent SnO<sub>2</sub>,
- [0044] wherein the glass is substantially free of Na<sub>2</sub>O.
- [0045] In another embodiment, the glass comprises, in weight percent:
  - [0046] 50 to 70 percent SiO<sub>2</sub>;
  - [0047] 2 to 13 percent Al<sub>2</sub>O<sub>3</sub>;
  - [0048] 1 to 11 percent B<sub>2</sub>O<sub>3</sub>;
  - [0049] 3 to 30 percent K<sub>2</sub>O;
  - [0050] 0 to 7 percent MgO;
  - [0051] 0 to 7 percent CaO;
  - [0052] 0 to 5 percent SrO;
  - [0053] 1 to 40 percent BaO; and
  - [0054] 0 to 0.3 percent SnO<sub>2</sub>,
- [0055] wherein the glass is substantially free of Na<sub>2</sub>O.
- [0056] Another embodiment is a glass consisting essentially of, in weight percent:
  - [0057] 35 to 75 percent SiO<sub>2</sub>;
  - [0058] 0 to 15 percent Al<sub>2</sub>O<sub>3</sub>;
  - [0059] 0 to 20 percent B<sub>2</sub>O<sub>3</sub>;
  - [0060] 3 to 30 percent K<sub>2</sub>O;
  - [0061] 0 to 15 percent MgO;
  - [0062] 0 to 10 percent CaO;
  - [0063] 0 to 12 percent SrO;
  - [0064] 0 to 40 percent BaO; and
  - [0065] 0 to 1 percent SnO<sub>2</sub>,
- [0066] wherein the glass is substantially free of Na<sub>2</sub>O.
- [0067] Another embodiment is a glass comprising, in weight percent:
  - [0068] 45 to 75 percent SiO<sub>2</sub>;
  - [0069] 3 to 15 percent Al<sub>2</sub>O<sub>3</sub>;
  - [0070] 0 to 20 percent B<sub>2</sub>O<sub>3</sub>;
  - [0071] 14 to 25 percent K<sub>2</sub>O;
  - [0072] 0 to 15 percent MgO;
  - [0073] 0 to 10 percent CaO;
  - [0074] 0 to 12 percent SrO;
  - [0075] 0 to 40 percent BaO; and
  - [0076] 0 to 1 percent SnO<sub>2</sub>,
- [0077] wherein the glass is substantially free of Na<sub>2</sub>O and wherein the glass is fusion formable and has a strain point of 540° C. or greater, a coefficient of thermal expansion of 50×10<sup>-7</sup> or greater, T<sub>200</sub> less than 1630° C., and having a liquidus viscosity of 150,000 poise or greater.
- [0078] Additional features and advantages will be set forth in the detailed description which follows, and in part will be readily apparent to those skilled in the art from the description or recognized by practicing the invention as described in the written description and claims hereof.
- [0079] It is to be understood that both the foregoing general description and the following detailed description are merely exemplary of the invention, and are intended to

provide an overview or framework for understanding the nature and character of the invention as it is claimed.

#### DETAILED DESCRIPTION

[0080] Reference will now be made in detail to various embodiments of the invention.

[0081] As used herein, the term "substrate" can be used to describe either a substrate or a superstrate depending on the configuration of the photovoltaic cell. For example, the substrate is a superstrate, if when assembled into a photovoltaic cell, it is on the light incident side of a photovoltaic cell. The superstrate can provide protection for the photovoltaic materials from impact and environmental degradation while allowing transmission of the appropriate wavelengths of the solar spectrum. Further, multiple photovoltaic cells can be arranged into a photovoltaic module. Photovoltaic device can describe either a cell, a module, or both.

[0082] As used herein, the term "adjacent" can be defined as being in close proximity. Adjacent structures may or may not be in physical contact with each other. Adjacent structures can have other layers and/or structures disposed between them.

[0083] One embodiment is a glass comprising, in weight percent:

- [0084] 35 to 75 percent SiO<sub>2</sub>;
- [0085] 0 to 15 percent Al<sub>2</sub>O<sub>3</sub>;
- [0086] 0 to 20 percent B<sub>2</sub>O<sub>3</sub>;
- [0087] 3 to 30 percent K<sub>2</sub>O;
- [0088] 0 to 15 percent MgO;
- [0089] 0 to 10 percent CaO;
- [0090] 0 to 12 percent SrO;
- [0091] 0 to 40 percent BaO; and
- [0092] 0 to 1 percent SnO<sub>2</sub>,

[0093] wherein the glass is substantially free of Na<sub>2</sub>O.

[0094] Another embodiment is a glass comprising, in weight percent:

- [0095] 45 to 75 percent SiO<sub>2</sub>;
- [0096] 3 to 15 percent Al<sub>2</sub>O<sub>3</sub>;
- [0097] 0 to 20 percent B<sub>2</sub>O<sub>3</sub>;
- [0098] 14 to 25 percent K<sub>2</sub>O;
- [0099] 0 to 15 percent MgO;
- [0100] 0 to 10 percent CaO;
- [0101] 0 to 12 percent SrO;
- [0102] 0 to 40 percent BaO; and
- [0103] 0 to 1 percent SnO<sub>2</sub>,

[0104] wherein the glass is substantially free of Na<sub>2</sub>O and wherein the glass is fusion formable and has a strain point of 540° C. or greater, a coefficient of thermal expansion of 50×10<sup>-7</sup> or greater, T<sub>200</sub> less than 1630° C., and having a liquidus viscosity of 150,000 poise or greater.

[0105] In another embodiment, the glass consists essentially of in weight percent:

- [0106] 45 to 75 percent SiO<sub>2</sub>;
- [0107] 3 to 15 percent Al<sub>2</sub>O<sub>3</sub>;
- [0108] 0 to 20 percent B<sub>2</sub>O<sub>3</sub>;
- [0109] 14 to 25 percent K<sub>2</sub>O;
- [0110] 0 to 15 percent MgO;
- [0111] 0 to 10 percent CaO;
- [0112] 0 to 12 percent SrO;
- [0113] 0 to 40 percent BaO; and
- [0114] 0 to 1 percent SnO<sub>2</sub>,

[0115] wherein the glass is substantially free of Na<sub>2</sub>O and wherein the glass is fusion formable and has a strain point of 540° C. or greater, a coefficient of thermal expansion of

$50 \times 10^{-7}$  or greater,  $T_{200}$  less than 1630° C., and having a liquidus viscosity of 150,000 poise or greater.

[0116] The glass is substantially free of  $\text{Na}_2\text{O}$ , for example, the content of  $\text{Na}_2\text{O}$  can be 0.05 weight percent or less, for example, zero weight percent. The glass, according to some embodiments, is free of intentionally added sodium.

[0117] In some embodiments, the glass comprises greater than 3 percent  $\text{K}_2\text{O}$ , for example, greater than 5 percent  $\text{K}_2\text{O}$ , for example, greater than 10 percent  $\text{K}_2\text{O}$ , for example, greater than 12 percent  $\text{K}_2\text{O}$ , for example greater than 13.5 percent  $\text{K}_2\text{O}$ , for example, greater than 15 percent  $\text{K}_2\text{O}$ .

[0118] Since the glass is substantially free of  $\text{Na}_2\text{O}$ , in some embodiments, the weight percent of the combination of  $\text{Na}_2\text{O}$  and  $\text{K}_2\text{O}$  is greater than 3 percent, for example, greater than 5 percent, for example, greater than 10 percent, for example, greater than 12 percent, for example greater than 13.5 percent, for example, greater than 15 percent.

[0119] In some embodiments, the glass comprises at least 45 percent  $\text{SiO}_2$ , for example, at least 50 percent  $\text{SiO}_2$ , for example, at least 60 percent  $\text{SiO}_2$ .

[0120] The glass, in one embodiment, is rollable. The glass, in one embodiment, is down-drawable. The glass can be slot drawn or fusion drawn, for example. According to another embodiment the glass can be float formed.

[0121] The glass can further comprise 3 weight percent or less, for example, 0 to 3 weight percent, for example, greater than 0 to 3 weight percent, for example, 1 to 3 weight percent of  $\text{TiO}_2$ ,  $\text{MnO}$ ,  $\text{ZnO}$ ,  $\text{Nb}_2\text{O}_5$ ,  $\text{MoO}_3$ ,  $\text{Ta}_2\text{O}_5$ ,  $\text{WO}_3$ ,  $\text{ZrO}_2$ ,  $\text{Y}_2\text{O}_3$ ,  $\text{La}_2\text{O}_3$ ,  $\text{HfO}_2$ ,  $\text{CdO}$ ,  $\text{SnO}_2$ ,  $\text{Fe}_2\text{O}_3$ ,  $\text{CeO}_2$ ,  $\text{As}_2\text{O}_3$ ,  $\text{Sb}_2\text{O}_3$ ,  $\text{Cl}$ ,  $\text{Br}$ , or combinations thereof.

[0122] In some embodiments, the glass is substantially free of  $\text{ZrO}_2$ . In some embodiments, the glass is substantially free of  $\text{ZnO}$ . The glass, in one embodiment, comprises 3 weight percent or less, for example, 0 to 3 weight percent, for example, greater than 0 to 3 weight percent, for example, 1 to 3 weight percent of  $\text{TiO}_2$ .

[0123] As mentioned above, the glasses, according some embodiments, comprise greater than 0 weight percent  $\text{B}_2\text{O}_3$ , for example, 1 weight percent or more, or, for example, 0 to 11 weight percent, for example, greater than 0 to 11 weight percent  $\text{B}_2\text{O}_3$ , for example, 0.5 to 11 weight percent  $\text{B}_2\text{O}_3$ , for example 1 to 11 weight percent  $\text{B}_2\text{O}_3$ .  $\text{B}_2\text{O}_3$  is added to the glass to reduce melting temperature, to decrease liquidus temperature, to increase liquidus viscosity, and to improve mechanical durability relative to a glass containing no  $\text{B}_2\text{O}_3$ .

[0124] According to some embodiments, the glass is substantially free of  $\text{B}_2\text{O}_3$ . In some embodiments, the glass is substantially free of  $\text{B}_2\text{O}_3$  and comprises at least 45 percent  $\text{SiO}_2$ , for example, at least 50 percent  $\text{SiO}_2$ , for example, at least 60 percent  $\text{SiO}_2$ .

[0125] The glass, according to some embodiments, comprises 30 weight percent total RO or less wherein RO is R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr, for example, 20 weight percent total RO or less, for example, 15 weight percent total RO or less, for example, 13.5 weight percent total RO or less.

[0126] The glass can comprise, for example, 0 to 15, greater than 0 to 15 weight percent, for example, 1 to 15 weight percent  $\text{MgO}$ . The glass can comprise, for example, 0 to 7, greater than 0 to 7 weight percent, for example, 1 to 7 weight percent  $\text{MgO}$ .  $\text{MgO}$  can be added to the glass to reduce melting temperature and to increase strain point. It can disadvantageously lower CTE relative to other alkaline

earths (e.g.,  $\text{CaO}$ ,  $\text{SrO}$ ,  $\text{BaO}$ ), and so other adjustments may be made to keep the CTE within the desired range. Examples of suitable adjustments include increase  $\text{SrO}$  at the expense of  $\text{CaO}$ , increasing alkali oxide concentration, and replacing a smaller alkali oxide in part with a larger alkali oxide.

[0127] According to another embodiment, the glass is substantially free of  $\text{BaO}$ . For example, the content of  $\text{BaO}$  can be 0.05 weight percent or less, for example, zero weight percent.

[0128] In some embodiments, the glass is substantially free of  $\text{Sb}_2\text{O}_3$ ,  $\text{As}_2\text{O}_3$ , or combinations thereof, for example, the glass comprises 0.05 weight percent or less of  $\text{Sb}_2\text{O}_3$  or  $\text{As}_2\text{O}_3$  or a combination thereof. For example, the glass can comprise zero weight percent of  $\text{Sb}_2\text{O}_3$  or  $\text{As}_2\text{O}_3$  or a combination thereof.

[0129] The glasses, in some embodiments, comprise 0 to 10 weight percent  $\text{CaO}$ , for example, 0 to 7 weight percent  $\text{CaO}$ , or, for example, greater than 0, for example, 1 to 10 weight percent  $\text{CaO}$ , for example, 1 to 7 weight percent  $\text{CaO}$ . Relative to alkali oxides or  $\text{SrO}$ ,  $\text{CaO}$  contributes to higher strain point, lower density, and lower melting temperature.

[0130] The glasses can comprise, in some embodiments, 0 to 12 weight percent  $\text{SrO}$ , for example, greater than zero to 12 weight percent, for example, 1 to 12 weight percent  $\text{SrO}$ , or for example, 0 to 5 weight percent  $\text{SrO}$ , for example, greater than zero to 5 weight percent, for example, 1 to 5 weight percent  $\text{SrO}$ . In certain embodiments, the glass contains no deliberately batched  $\text{SrO}$ , though it may of course be present as a contaminant in other batch materials.  $\text{SrO}$  contributes to higher coefficient of thermal expansion, and the relative proportion of  $\text{SrO}$  and  $\text{CaO}$  can be manipulated to improve liquidus temperature, and thus liquidus viscosity.  $\text{SrO}$  is not as effective as  $\text{CaO}$  or  $\text{MgO}$  for improving strain point, and replacing either of these with  $\text{SrO}$  tends to cause the melting temperature to increase.

[0131] Alkali cations such as K raise the CTE steeply, but also lower the strain point and, depending upon how they are added, increase melting temperatures. The least effective alkali oxide for CTE is  $\text{Li}_2\text{O}$ , and the most effective alkali oxide is  $\text{Cs}_2\text{O}$ .

[0132] Another embodiment is a glass consisting essentially of, in weight percent:

[0133] 35 to 75 percent  $\text{SiO}_2$ ;

[0134] 0 to 15 percent  $\text{Al}_2\text{O}_3$ ;

[0135] 0 to 20 percent  $\text{B}_2\text{O}_3$ ;

[0136] 3 to 30 percent  $\text{K}_2\text{O}$ ;

[0137] 0 to 15 percent  $\text{MgO}$ ;

[0138] 0 to 10 percent  $\text{CaO}$ ;

[0139] 0 to 12 percent  $\text{SrO}$ ;

[0140] 0 to 40 percent  $\text{BaO}$ ; and

[0141] 0 to 1 percent  $\text{SnO}_2$ ,

[0142] wherein the glass is substantially free of  $\text{Na}_2\text{O}$ .

[0143] The glass, according to some embodiments, is down-drawable; that is, the glass is capable of being formed into sheets using down-draw methods such as, but not limited to, fusion draw and slot draw methods that are known to those skilled in the glass fabrication arts. Such down-draw processes are used in the large-scale manufacture of ion-exchangeable flat glass.

[0144] The fusion draw process uses a drawing tank that has a channel for accepting molten glass raw material. The channel has weirs that are open at the top along the length of the channel on both sides of the channel. When the

channel fills with molten material, the molten glass overflows the weirs. Due to gravity, the molten glass flows down the outside surfaces of the drawing tank. These outside surfaces extend down and inwardly so that they join at an edge below the drawing tank. The two flowing glass surfaces join at this edge to fuse and form a single flowing sheet. The fusion draw method offers the advantage that, since the two glass films flowing over the channel fuse together, neither outside surface of the resulting glass sheet comes in contact with any part of the apparatus. Thus, the surface properties are not affected by such contact.

[0145] The slot draw method is distinct from the fusion draw method. Here the molten raw material glass is provided to a drawing tank. The bottom of the drawing tank has an open slot with a nozzle that extends the length of the slot. The molten glass flows through the slot/nozzle and is drawn downward as a continuous sheet therethrough and into an annealing region. Compared to the fusion draw process, the slot draw process provides a thinner sheet, as only a single sheet is drawn through the slot, rather than two sheets being fused together, as in the fusion down-draw process.

[0146] In order to be compatible with down-draw processes, the glass described herein has a high liquidus viscosity. In one embodiment, the glass has a liquidus viscosity of 50,000 poise or greater, for example, 150,000 poise or greater, for example, 200,000 poise or greater, for example, 250,000 poise or greater, for example, 300,000 poise or greater, for example, 350,000 poise or greater, for example, 400,000 poise or greater, for example, greater than or equal to 500,000 poise. The liquidus viscosities of some exemplary glasses are closely correlated with the difference between the liquidus temperature and the softening point. For downdraw processes, some exemplary glasses advantageously have liquidus—softening point less than about 230° C., for example, less than 200° C.

[0147] Accordingly, in one embodiment, the glass has a strain point of 540° C. or greater, for example, 550° C. or greater, for example, 560° C. or greater, or for example, from 540° C. to 650° C. In some embodiments, the glass has a coefficient of thermal expansion of  $50 \times 10^{-7}$  or greater, for example,  $60 \times 10^{-7}$  or greater, for example,  $70 \times 10^{-7}$  or greater, for example,  $80 \times 10^{-7}$  or greater. In one embodiment, the glass has a strain point of from  $50 \times 10^{-7}$  to  $90 \times 10^{-7}$ .

[0148] In one embodiment, the glass has a coefficient of thermal expansion of  $50 \times 10^{-7}$  or greater and a strain point of 540° C. or greater. In one embodiment, the glass has a coefficient of thermal expansion of  $50 \times 10^{-7}$  or greater and a strain point of 560° C. or greater.

[0149] According to one embodiment, the glass is ion exchanged in a salt bath comprising one or more salts of alkali ions. The glass can be ion exchanged to change its mechanical properties. For example, smaller alkali ions, such as lithium can be ion-exchanged in a molten salt containing one or more larger alkali ions, such as potassium, rubidium or cesium. If performed at a temperature well below the strain point for sufficient time, a diffusion profile will form in which the larger alkali moves into the glass surface from the salt bath, and the smaller ion is moved from the interior of the glass into the salt bath. When the sample is removed, the surface will go under compression, producing enhanced toughness against damage. Such toughness may be desirable in instances where the glass will be exposed to adverse environmental conditions, such as photo-

to voltaic grids exposed to hail. A large alkali already in the glass can also be exchanged for a smaller alkali in a salt bath. If this is performed at temperatures close to the strain point, and if the glass is removed and its surface rapidly reheated to high temperature and rapidly cooled, the surface of the glass will show considerable compressive stress introduced by thermal tempering. This will also provide protection against adverse environmental conditions. It will be clear to one skilled in the art that any monovalent cation can be exchanged for alkalis already in the glass, including copper, silver, thallium, etc., and these also provide attributes of potential value to end uses, such as introducing color for lighting or a layer of elevated refractive index for light trapping.

[0150] According to another embodiment, the glass can be float formed as known in the art of float forming glass.

[0151] In one embodiment, the glass is in the form of a sheet. The glass in the form of a sheet can be thermally tempered.

[0152] In one embodiment, an Organic Light Emitting Diode device comprises the glass in the form of a sheet.

[0153] The glass, according to one embodiment, is transparent.

[0154] In one embodiment, a photovoltaic device comprises the glass in the form of a sheet. The photovoltaic device can comprise more than one of the glass sheets, for example, as a substrate and/or as a superstrate. In one embodiment, the photovoltaic device comprises the glass sheet as a substrate and/or superstrate, a conductive material adjacent to the substrate, and an active photovoltaic medium adjacent to the conductive material. In one embodiment, the active photovoltaic medium comprises a CIGS layer. In one embodiment, the active photovoltaic medium comprises a cadmium telluride (CdTe) layer. In one embodiment, the photovoltaic device comprises a functional layer comprising copper indium gallium diselenide or cadmium telluride. In one embodiment, the photovoltaic device the functional layer is copper indium gallium diselenide. In one embodiment, the functional layer is cadmium telluride.

[0155] The photovoltaic device, according to one embodiment, further comprises a barrier layer disposed between or adjacent to the superstrate or substrate and the functional layer. In one embodiment, the photovoltaic device further comprises a barrier layer disposed between or adjacent to the superstrate or substrate and a transparent conductive oxide (TCO) layer, wherein the TCO layer is disposed between or adjacent to the functional layer and the barrier layer. A TCO may be present in a photovoltaic device comprising a CdTe functional layer. In one embodiment, the barrier layer is disposed directly on the glass.

[0156] In one embodiment, the glass sheet is transparent. In one embodiment, the glass sheet as the substrate and/or superstrate is transparent.

[0157] According to some embodiments, the glass sheet has a thickness of 4.0 mm or less, for example, 3.5 mm or less, for example, 3.2 mm or less, for example, 3.0 mm or less, for example, 2.5 mm or less, for example, 2.0 mm or less, for example, 1.9 mm or less, for example, 1.8 mm or less, for example, 1.5 mm or less, for example, 1.1 mm or less, for example, 0.5 mm to 2.0 mm, for example, 0.5 mm to 1.1 mm, for example, 0.7 mm to 1.1 mm. Although these are exemplary thicknesses, the glass sheet can have a thickness of any numerical value including decimal places in the range of from 0.1 mm up to and including 4.0 mm.

**[0158]** In one embodiment, an electrochromic device comprises the glass in the form of a sheet. The electrochromic device can be, for example, an electrochromic window. In one embodiment, the electrochromic window comprises one or more of the glass sheets, such as in a single, double, or triple pane window.

**[0159]** The fusion-formable glasses of this invention, by virtue of their relatively high strain point, represent advantaged substrate materials for CIGS photovoltaic modules as they can enable higher temperature processing of the critical semiconductor layers. When manufactured by the fusion process, their superior surface quality relative to that of float glass may also result in further improvements to the photovoltaic module making process. Advantageous embodiments of this invention are characterized by liquidus viscosity in excess of 400,000 poise, thereby enabling the fabrication of the relatively thick glass sheet that may be required by some module manufacturers. Finally, the most advantageous embodiments of this invention comprise glasses for which the 200 poise temperature is less than 1580° C., providing for the possibility of significantly lower cost melting/forming.

#### EXAMPLES

**[0160]** The following is an example of how to fabricate a sample of an exemplary glass, according to one embodiment of the invention, as shown in Table 1. This composition corresponds to composition number 22 shown in Table 5.

TABLE 1

oxide	mol %
SiO <sub>2</sub>	64.93
Al <sub>2</sub> O <sub>3</sub>	0
MgO	17.5
CaO	0
SrO	0
B <sub>2</sub> O <sub>3</sub>	0
K <sub>2</sub> O	17.5
SnO <sub>2</sub>	0.10
BaO	0

**[0161]** In some embodiments, the total does not add up to 100%, since certain tramp elements are present at non-negligible concentrations.

**[0162]** Batch materials, as shown in Table 2 were weighed and added to a 4 liter plastic container:

TABLE 2

Batch Components
sand
Magnesia
Potassium carbonate

TABLE 2-continued

Batch Components
10% SnO <sub>2</sub> and 90% sand

**[0163]** It should be appreciated that in the batch, limestone, depending on the source can contain tramp elements and/or vary amounts of one or more oxides, for example, MgO and/or BaO. The sand is advantageously beneficiated so that at least 80% by mass passes 60 mesh, for example 80 mesh, for example 100 mesh. The SnO<sub>2</sub> added, in this example, was pre-mixed with sand at a level of 10% by weight so as to ensure homogeneous mixing with the other components. The bottle containing the batch materials was mounted to a tumbler and the batch materials were mixed so as to make a homogeneous batch and to break up soft agglomerates. The mixed batch was transferred to a 1800cc platinum crucible and placed into a high-temperature ceramic backer. The platinum in its backer was loaded into a glo-bar furnace idling at a temperature of 1600° C. After 16 hours, the crucible+backer was removed and the glass melt was poured onto a cold surface, such as a steel plate, to form a patty, and then transferred to an annealer held at a temperature of 615° C. The glass patty was held at the annealer temperature for 2 hours, then cooled at a rate of 1° C. per minute to room temperature. [0062]Table 3, Table 4, Table 5, Table 6, Table 7, Table 8, and Table 9 show exemplary glasses, according to embodiments of the invention, and made according to the above example. Properties data for some exemplary glasses are also shown in Table 3, Table 4, Table 5, Table 6, Table 7, Table 8, and Table 9.

**[0164]** In the Tables  $I_{str}$ (° C.) is the strain point which is the temperature when the viscosity is equal to  $10^{14.7}$  P as measured by beam bending or fiber elongation.  $T_{ann}$ (° C.) is the annealing point which is the temperature when the viscosity is equal to  $10^{13.18}$  P as measured by beam bending or fiber elongation.  $T_s$ (° C.) is the softening point which is the temperature when the viscosity is equal to  $10^{7.6}$  P as measured by beam bending or fiber elongation.  $\alpha(10^{-7}/° C.)$  or  $\alpha(10^{-7}/° C.)$  in the Tables is the coefficient of thermal expansion (CTE) which is the amount of dimensional change from either 0 to 300° C. or 25 to 300° C. depending on the measurement. CTE is typically measured by dilatometry.  $r(g/cc)$  is the density which is measured with the Archimedes method (ASTM C693).  $T_{200}$ (° C.) is the two-hundred Poise (P) temperature. This is the temperature when the viscosity of the melt is 200P as measured by HTV (high temperature viscosity) measurement which uses concentric cylinder viscometry.  $T_{liq}$ (° C.) is the liquidus temperature. This is the temperature where the first crystal is observed in a standard gradient boat liquidus measurement (ASTM C829-81). Generally this test is 72 hours but can be as short as 24 hours to increase throughput at the expense of accuracy (shorter tests could underestimate the liquidus temperature).  $\eta_{liq}$ (° C.) is the liquidus viscosity. This is the viscosity of the melt corresponding to the liquidus temperature.

TABLE 3

Example	1	2	3	4	5	6	7	8	9	10
<u>Composition (mol %)</u>										
K <sub>2</sub> O	3	4.5	6	4.95	12.1	12.1	12	12	12	10
MgO	0	0	0	0	1.7	3.38	3.8	4.4	4	5.2
CaO	0	0	0	0	6.76	3.38	3.8	4.4	4	5.2
SrO	0.41	0.31	0.21	0.28	0	1.7	1.9	2.2	2	2.6
BaO	20.29	15.19	10.12	13.67	0	0	0	0	0	0
B <sub>2</sub> O <sub>3</sub>	18.67	14	9.33	12.6	3.03	3.03	3	1.5	1.5	1.5
Al <sub>2</sub> O <sub>3</sub>	3	4.5	6	4.95	4.88	4.88	4	4	5	4
SiO <sub>2</sub>	54.67	61.5	68.33	63.55	71.43	71.43	71.4	71.4	71.4	71.4
SnO <sub>2</sub>	0	0	0	0.1	0.1	0.1	0.1	0.1	0.1	0.1
<u>Composition (wt %)</u>										
K <sub>2</sub> O	3.4	5.35	7.52	5.97	17.2	17.1	17.1	17	14.4	
MgO	0	0	0	0	1.04	2.05	2.32	2.68	2.43	3.2
CaO	0	0	0	0	5.73	2.84	3.21	3.73	3.37	4.46
SrO	0.51	0.41	0.29	0.37	0	2.64	2.97	3.44	3.11	4.12
BaO	37.3	29.4	20.7	26.9	0	0	0	0	0	0
B <sub>2</sub> O <sub>3</sub>	15.6	12.3	8.64	11.2	3.18	3.16	3.15	1.58	1.57	1.6
Al <sub>2</sub> O <sub>3</sub>	3.68	5.79	8.14	6.46	7.53	7.46	6.16	6.17	7.66	6.24
SiO <sub>2</sub>	39.4	46.6	54.6	48.9	64.9	64.3	64.7	64.9	64.5	65.6
SnO <sub>2</sub>	0	0	0	0.19	0.23	0.23	0.23	0.23	0.23	0.23
T <sub>str</sub> (°C.)	578	~580	584	588	597	591	591	595	604	606
T <sub>ann</sub> (°C.)	616	~620	627	625	644	640	638	645	655	657
T <sub>s</sub> (°C.)	754	770	815	790						
a (10 <sup>-7</sup> /°C.)	71.9	70.6	65.3	66.8	79.9	79.6	80.2	82.5	80.5	76
r (gm/cc)				2.901	2.446	2.462	2.472	2.483	2.473	2.493
T <sub>200</sub> (°C.)	1111	1254	1443	1410	1595	1624	1589	1617	1622	1613
T <sub>liq</sub> (°C.)	885	905	910	910	1060	975	950	995	1085	1050
η <sub>liq</sub> (kp)	37	110	724	235	129	1221	1675	910	156	298

TABLE 4

Example	11	12	13	14	15	16	17	18	19	20
<u>Composition (mol %)</u>										
K <sub>2</sub> O	12	12	12	12	10	12	12	12	12	12
MgO	3.4	3	4.2	4.8	5.6	4	4.4	5	3.67	1.84
CaO	3.4	3	4.2	4.8	5.6	4	4.4	5	5.5	7.33
SrO	1.7	1.5	2.1	2.4	2.8	2	2.2	2.5	1.82	1.82
BaO	0	0	0	0	0	0	0	0	0.01	0.01
B <sub>2</sub> O <sub>3</sub>	4	4	3	1.5	1.5	4	3	1.5	1.5	1.5
Al <sub>2</sub> O <sub>3</sub>	4	5	3	3	3	2.5	2.5	2.5	4	4
SiO <sub>2</sub>	71.4	71.4	71.4	71.4	71.4	71.4	71.4	71.4	71.4	71.4
SnO <sub>2</sub>	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1
<u>Composition (wt %)</u>										
K <sub>2</sub> O	17	16.9	17.2	17.2	14.5	17.2	17.2	17.3	17.1	17
MgO	2.07	1.81	2.57	2.94	3.47	2.46	2.7	3.07	2.24	1.12
CaO	2.87	2.52	3.57	4.1	4.83	3.41	3.76	4.28	4.67	6.2
SrO	2.65	2.33	3.3	3.78	4.46	3.15	3.47	3.95	2.86	2.85
BaO	0	0	0	0	0	0	0	0	0.02	0.02
B <sub>2</sub> O <sub>3</sub>	4.19	4.17	3.17	1.59	1.61	4.23	3.18	1.6	1.58	1.58
Al <sub>2</sub> O <sub>3</sub>	6.15	7.64	4.64	4.65	4.71	3.87	3.88	3.89	6.17	6.15
SiO <sub>2</sub>	64.6	64.2	65.1	65.3	66	65.3	65.4	65.6	65	64.7
SnO <sub>2</sub>	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23
T <sub>str</sub> (°C.)	585	590	585	592	602	582	586	588	598	600
T <sub>ann</sub> (°C.)	632	638	631	640	651	627	632	636	647	648
T <sub>s</sub> (°C.)										
a (10 <sup>-7</sup> /°C.)	79.4	78.1	79.5	83.8	77	81.9	81.5	84.4	82	84.2
r (gm/cc)	2.466	2.451	2.483	2.494	2.502	2.485	2.489	2.497	2.478	2.492
T <sub>200</sub> (°C.)	1596	1625	1553	1553	1556	1527	1508	1523	1585	1549
T <sub>liq</sub> (°C.)	<900	940	<950	960	1040	<850	870	940	985	1030
η <sub>liq</sub> (kp)	>2000	2143	>1000	1080	202	>7000	6297	1385	660	179

TABLE 5

Example	21	22	23	24	25	26	27	28	29	30
<u>Composition (mol %)</u>										
K <sub>2</sub> O	12	17.5	14.94	10.8	9.6	12.47	13.6	12.6	13.35	11.77
MgO	1.83	17.5	1.37	5.17	4.59	11.02	12.9	13.9	13.7	11.94
CaO	5.5	0	1.11	6.21	10.18	3.13	2.4	2.4	1.75	0.86
SrO	3.65	0	0.77	1.4	1.24	1.01	1.45	1.45	1.1	0.66
BaO	0.02	0	0	0	0	0	0	0	0	3.04
B <sub>2</sub> O <sub>3</sub>	1.5	0	0.4	3.52	6.24	1.64	0.4	0.4	1.9	3.11
Al <sub>2</sub> O <sub>3</sub>	4	0	4.17	4.32	3.84	3.13	2.35	2.35	2.3	2.76
SiO <sub>2</sub>	71.4	64.93	77.17	68.51	64.24	67.53	66.8	66.8	65.8	65.79
SnO <sub>2</sub>	0.1	0.07	0.07	0.07	0.07	0.07	0.1	0.1	0.1	0.07
<u>Composition (wt %)</u>										
K <sub>2</sub> O	16.8	26.3	21	15.6	13.9	18.3	20	18.7	19.7	16.7
MgO	1.1	11.2	0.82	3.18	2.85	6.93	8.13	8.83	8.67	7.24
CaO	4.59	0	0.93	5.32	8.78	2.73	2.11	2.13	1.54	0.73
SrO	5.63	0	1.19	2.22	1.98	1.64	2.34	2.36	1.79	1.03
BaO	0.05	0	0	0	0	0	0	0	0	7.02
B <sub>2</sub> O <sub>3</sub>	1.56	0	0.42	3.74	6.69	1.78	0.44	0.44	2.08	3.25
Al <sub>2</sub> O <sub>3</sub>	6.07	0	6.33	6.73	6.03	4.98	3.74	3.78	3.68	4.23
SiO <sub>2</sub>	63.8	62.1	69	62.9	59.4	63.3	62.8	63.3	62.1	59.5
SnO <sub>2</sub>	0.22	0.17	0.16	0.16	0.16	0.16	0.24	0.24	0.24	0.16
T <sub>str</sub> (°C.)	593	610	565	592	594	595	594	602	592	576
T <sub>ann</sub> (°C.)	641	661	616	638	634	647	649	656	641	624
T <sub>s</sub> (°C.)	879	847	847	815	866	874	879	858	835	
a (10 <sup>-7</sup> /°C.)	84	104.1	88.6	78	77.8	85	89.9	85.7	87.9	83.7
r (gm/cc)	2.523	2.444	2.418	2.483	2.512	2.472	2.483	2.485	2.468	2.558
T <sub>200</sub> (°C.)	1547			1535		1531			1502	1473
T <sub>liq</sub> (°C.)	1010	<1150	<950	1050	1080	1075	1080	1080	1060	990
η <sub>liq</sub> (kp)	251			103		109	~75	~86	106	290

TABLE 6

Example	31	32	33	34	35	36	37	38	39	40
<u>Composition (mol %)</u>										
K <sub>2</sub> O	14	12	11.76	11.73	10.96	16	14.61	12.19	14.1	14.1
MgO	2.9	3.9	3.82	6.57	6.14	0	1.38	3.79	1.33	0
CaO	2.85	3.65	3.58	5.77	5.39	5	5.32	5.89	5.14	5.13
SrO	0.7	0.9	0.88	1.88	1.75	0	0	1.03	0	1.33
BaO	0	0	0	0	0	0	0	0	0	0
B <sub>2</sub> O <sub>3</sub>	3.03	3.03	5	1.55	1.45	3	3.14	3.38	3.03	3.03
Al <sub>2</sub> O <sub>3</sub>	4.9	4.9	4.8	2.91	2.72	5.34	5.06	4.59	4.89	4.88
SiO <sub>2</sub>	71.52	71.52	70.06	69.5	71.5	70.56	70.39	69.06	71.49	71.42
SnO <sub>2</sub>	0.1	0.1	0.1	0.1	0.1	0	0.1	0.1	0.1	0.1
<u>Composition (wt %)</u>										
K <sub>2</sub> O	19.7	17.1	16.7	17	16	22.2	20.5	17.4	19.9	19.6
MgO	1.75	2.38	2.33	4.07	3.83	0	0.83	2.31	0.8	0
CaO	2.39	3.09	3.02	4.98	4.67	4.13	4.45	4.99	4.31	4.25
SrO	1.08	1.41	1.38	2.99	2.8	0	0	1.62	0	2.04
BaO	0	0	0	0	0	0	0	0	0	0
B <sub>2</sub> O <sub>3</sub>	3.14	3.18	5.25	1.66	1.56	3.07	3.26	3.55	3.16	3.12
Al <sub>2</sub> O <sub>3</sub>	7.46	7.55	7.39	4.57	4.29	8	7.69	7.07	7.45	7.36
SiO <sub>2</sub>	64.1	64.9	63.5	64.3	66.4	62.4	62.8	62.7	64.2	63.4
SnO <sub>2</sub>	0.23	0.23	0.23	0.23	0.23	0	0.23	0.23	0.22	0.21
T <sub>str</sub> (°C.)	597	613	608	598	607	565	588	594	595	590
T <sub>ann</sub> (°C.)	645	663	658	646	658	611	633	640	640	635
T <sub>s</sub> (°C.)										
a (10 <sup>-7</sup> /°C.)	84.8	78.1	74.7	85.1	81.1	90	88	82.3	86.1	86
r (gm/cc)	2.446	2.441	2.434	2.498	2.48		2.452	2.473	2.446	2.475
T <sub>200</sub> (°C.)	1624	1649	1648	1515	1557		1554	1558	1594	1567
T <sub>liq</sub> (°C.)	1010	1010	960	1010	1010	1040	1035	990	980	
η <sub>liq</sub> (kp)	376	886	2729	270	479	105	169	394	407	

TABLE 7

Example	41	42	43	44	45	46	47	48	49
<u>Composition (mol %)</u>									
K <sub>2</sub> O	12.37	10.32	11.97	13.21	9.21	12.37	4	8	5
MgO	1.17	1.16	1.33	1.24	0	1.17	1.75	12	4
CaO	4.51	4.49	2.13	4.81	5.14	4.51	7.02	1	7
SrO	0	1.18	2.99	0	4.14	0	2.91	7	1
BaO	0	1.18	1.69	0	2	0	3.32	7	12
B <sub>2</sub> O <sub>3</sub>	2.66	2.64	2.99	2.84	3.03	3.36	10.67	1	0
Al <sub>2</sub> O <sub>3</sub>	4.28	4.26	4.99	4.58	4.89	4.28	8.52	0	0
SiO <sub>2</sub>	75.01	74.65	71.81	73.23	71.49	74.01	62.25	64	71
SnO <sub>2</sub>	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1
<u>Composition (wt %)</u>									
K <sub>2</sub> O	17.6	14.5	16.3	18.7	12.5	17.6	5.36	10.7	6.5
MgO	0.71	0.7	0.77	0.75	0	0.71	1.01	6.89	2.22
CaO	3.82	3.75	1.73	4.05	4.16	3.82	5.6	0.8	5.41
SrO	0	1.83	4.47	0	6.2	0	4.3	10.3	1.43
BaO	0	2.71	3.73	0	4.43	0	7.24	15.3	25.4
B <sub>2</sub> O <sub>3</sub>	2.8	2.75	3.01	2.97	3.05	3.54	10.6	0.99	0
Al <sub>2</sub> O <sub>3</sub>	6.59	6.48	7.34	7.02	7.2	6.6	12.4	0	0
SiO <sub>2</sub>	68.1	66.9	62.3	66.1	62.1	67.3	53.2	54.7	58.8
SnO <sub>2</sub>	0.23	0.22	0.22	0.23	0.22	0.23	0.21	0.21	0.21
T <sub>str</sub> (° C.)	602	604	592	599	623	603	582	608	
T <sub>ann</sub> (° C.)	651	653	639	647	672	651	628	656	
T <sub>s</sub> (° C.)									
a (10 <sup>-7</sup> /° C.)	74.2	74.2	81.3	81.2	73.5	78.1	88.9	73	
r (gm/cc)	2.424	2.485	2.451	2.435	2.585	2.428	2.889	2.933	
T <sub>200</sub> (° C.)	1637	1669	1586	1611	1613	1615	1491	1347	1406
T <sub>liq</sub> (° C.)	800	940	980	945	1090	960	1000	1005	
η <sub>liq</sub> (kp)	427,000	4527	301	1829	107	665	59	156	

TABLE 8

Example	50	51	52	53	54	55	56
<u>Composition (mol %)</u>							
K <sub>2</sub> O	11.79	11.91	12.04	11.25	8.96	10.9	10.79
MgO	6.03	4.95	3.87	6.3	7.06	6.11	6.05
CaO	5.64	5.39	5.13	5.53	6.21	5.36	5.31
SrO	1.69	1.32	0.94	1.8	2.01	1.74	1.72
BaO	0	0	0	0	0	0	0
B <sub>2</sub> O <sub>3</sub>	1.66	1.88	2.11	5.55	1.45	1.44	2.44
Al <sub>2</sub> O <sub>3</sub>	3.05	3.32	3.6	2.79	2.72	3.22	3.19
SiO <sub>2</sub>	70.04	71.13	72.21	66.68	71.5	71.13	70.4
SnO <sub>2</sub>	0.1	0.1	0.1	0.1	0.1	0.1	0.1
<u>Composition (wt %)</u>							
K <sub>2</sub> O	17.06	17.18	17.3	16.27	13.22	15.84	15.66
MgO	3.73	3.05	2.38	3.9	4.45	3.8	3.76
CaO	4.86	4.63	4.39	4.76	5.45	4.63	4.59
SrO	2.69	2.1	1.49	2.86	3.26	2.78	2.74
BaO	0	0	0	0	0	0	0
B <sub>2</sub> O <sub>3</sub>	1.78	2.01	2.25	5.93	1.58	1.55	2.62
Al <sub>2</sub> O <sub>3</sub>	4.78	5.18	5.6	4.36	4.34	5.06	5.01
SiO <sub>2</sub>	64.66	65.43	66.18	61.49	67.27	65.91	65.19
SnO <sub>2</sub>	0.23	0.23	0.23	0.23	0.24	0.23	0.23
T <sub>str</sub> (° C.)	596	597	601	612	627	624	622
T <sub>ann</sub> (° C.)	645	646	651	660	679	671	674
T <sub>s</sub> (° C.)							
a (10 <sup>-7</sup> /° C.)	83.3	82.6	82.5	71.9	72.4	78.3	74.9
r (gm/cc)	2.486	2.473	2.458	2.48	2.483	2.477	2.473
T <sub>200</sub> (° C.)	1543	1560	1608	1557	1560	1576	1613
T <sub>liq</sub> (° C.)	995	985	950	1080	1095	1020	1055
η <sub>liq</sub> (kp)	480	688	2361	76	96	553	329

TABLE 9

Example	57	58	59	60	61	62	63
<u>Composition (mol %)</u>							
K <sub>2</sub> O	10.15	9.95	3.35	3.75	4.1	3.64	10.1
MgO	5.69	5.58	5.39	6.04	6.59	5.87	5.66
CaO	4.99	4.89	5.57	6.24	6.81	6.06	4.96
SrO	1.62	1.59	2.3	2.58	2.81	2.51	1.61
BaO	0	2	0	0	0	0	0
B <sub>2</sub> O <sub>3</sub>	1.34	1.31	5.69	5.69	5.69	5.53	1.33
Al <sub>2</sub> O <sub>3</sub>	3	2.94	11.26	10.46	9.78	10.16	3.5
SiO <sub>2</sub>	73.11	71.64	66.37	65.17	64.15	66.17	72.74
SnO <sub>2</sub>	0.1	0.1	0.07	0.07	0.07	0.07	0.1
total	100	100	100	100	100	100.01	100
<u>Composition (wt %)</u>							
K <sub>2</sub> O	14.82	14.14	4.75	5.34	5.86	5.2	14.7
MgO	3.55	3.39	3.27	3.68	4.03	3.58	3.52
CaO	4.34	4.13	4.7	5.29	5.79	5.15	4.3
SrO	2.61	2.49	3.59	4.04	4.41	3.94	2.58
BaO	0	4.62	0	0	0	0	0
B <sub>2</sub> O <sub>3</sub>	1.45	1.38	5.97	5.99	6.01	5.84	1.43
Al <sub>2</sub> O <sub>3</sub>	4.74	4.52	17.3	16.12	15.15	15.7	5.51
SiO <sub>2</sub>	68.09	64.94	60.09	59.2	58.44	60.26	67.54
SnO <sub>2</sub>	0.23	0.23	0.16	0.16	0.16	0.16	0.23
total	99.83	99.84	99.83	99.82	99.85	99.83	99.81
T <sub>str</sub> (° C.)	609	598	660	645	632	645	621
T <sub>ann</sub> (° C.)	658	645	714	694	678	694	671
T <sub>s</sub> (° C.)							
a (10-7/° C.)	76.2	79.7	46.7	52.8	55.5	50	75
r (gm/cc)	2.462	2.544	2.463	2.504	2.517	2.474	2.46
T <sub>200</sub> (° C.)	1605	1569	1609	1597	1555	1600	1613
T <sub>liq</sub> (° C.)	1000	950	1110	1080	1080	1065	1025
n <sub>liq</sub> (kp)	967	2257	287	432	228	695	682

**[0165]** It will be apparent to those skilled in the art that various modifications and variations can be made to the present invention without departing from the spirit or scope of the invention. Thus, it is intended that the present invention cover the modifications and variations of this invention provided they come within the scope of the appended claims and their equivalents.

What is claimed is:

1. A glass comprising, in weight percent:

35 to 75 percent SiO<sub>2</sub>;

0 to 15 percent Al<sub>2</sub>O<sub>3</sub>;

0 to 20 percent B<sub>2</sub>O<sub>3</sub>;

3 to 30 percent K<sub>2</sub>O;

0 to 15 percent MgO;

0 to 10 percent CaO;

0 to 12 percent SrO;

0 to 40 percent BaO; and

0 to 1 percent SnO<sub>2</sub>,

wherein the glass is substantially free of Na<sub>2</sub>O.

2. The glass according to claim 1, comprising:

greater than 0 percent B<sub>2</sub>O<sub>3</sub>.

3. The glass according to claim 1, wherein the glass is substantially free of B<sub>2</sub>O<sub>3</sub>.

4. The glass according to claim 1, comprising:

at least 45 percent SiO<sub>2</sub>.

5. The glass according to claim 1, comprising:

greater than 0 percent MgO, CaO, SrO, or combinations thereof.

6. The glass according to claim 1 comprising, in weight percent:

35 to 75 percent SiO<sub>2</sub>;

greater than 0 to 15 percent Al<sub>2</sub>O<sub>3</sub>;

greater than 0 to 20 percent B<sub>2</sub>O<sub>3</sub>;

3 to 30 percent K<sub>2</sub>O;

greater than 0 to 15 percent MgO;

greater than 0 to 10 percent CaO;

greater than 0 to 12 percent SrO;

greater than 0 to 40 percent BaO; and

greater than 0 to 1 percent SnO<sub>2</sub>,

wherein the glass is substantially free of Na<sub>2</sub>O.

7. The glass according to claim 1, comprising:

39 to 75 percent SiO<sub>2</sub>;

2 to 13 percent Al<sub>2</sub>O<sub>3</sub>;

1 to 11 percent B<sub>2</sub>O<sub>3</sub>;

3 to 30 percent K<sub>2</sub>O;

0 to 7 percent MgO;

0 to 10 percent CaO;

0 to 12 percent SrO;

0 to 40 percent BaO; and

0 to 1 percent SnO<sub>2</sub>,

wherein the glass is substantially free of Na<sub>2</sub>O.

8. The glass according to claim 1, comprising:

50 to 70 percent SiO<sub>2</sub>;

2 to 13 percent Al<sub>2</sub>O<sub>3</sub>;

1 to 11 percent B<sub>2</sub>O<sub>3</sub>;

3 to 30 percent K<sub>2</sub>O;

0 to 7 percent MgO;

0 to 7 percent CaO;

0 to 5 percent SrO;

1 to 40 percent BaO; and

0 to 0.3 percent SnO<sub>2</sub>,

wherein the glass is substantially free of Na<sub>2</sub>O.

**9.** The glass according to claim **1**, wherein the glass is in the form of a sheet.

**10.** The glass according to claim **9**, wherein the sheet has a thickness in the range of from 0.5 mm to 3.0 mm.

**11.** A photovoltaic device comprising the glass according to claim **1**.

**12.** The photovoltaic device according to claim **11**, comprising a functional layer comprising copper indium gallium diselenide or cadmium telluride adjacent to the substrate or superstrate.

**13.** The photovoltaic device according to claim **12**, further comprising a barrier layer disposed between the superstrate or substrate and the functional layer.

**14.** The glass according to claim **1**, having a strain point of 540° C. or greater.

**15.** The glass according to claim **1**, having a coefficient of thermal expansion of  $50 \times 10^{-7}$  or greater.

**16.** The glass according to claim **1**, having a coefficient of thermal expansion in the range of from  $50 \times 10^{-7}$  to  $90 \times 10^{-7}$ .

**17.** The glass according to claim **1**, having a strain point of 560° C. or greater and a coefficient of thermal expansion of  $50 \times 10^{-7}$  or greater.

**18.** The glass according to claim **1**, having a liquidus viscosity of 50,000 poise or greater.

**19.** The glass according to claim **1**, having a  $T_{200}$  less than 1580° C. and a liquidus viscosity of 400,000 poise or greater.

**20.** The glass according to claim **1**, wherein the glass is fusion formable and has a strain point of 540° C. or greater, a coefficient of thermal expansion of  $50 \times 10^{-7}$  or greater,  $T_{200}$  less than 1630° C., and having a liquidus viscosity of 150,000 poise or greater.

**21.** A glass consisting essentially of, in weight percent: 35 to 75 percent  $\text{SiO}_2$ ; 0 to 15 percent  $\text{Al}_2\text{O}_3$ ; 0 to 20 percent  $\text{B}_2\text{O}_3$ ; 3 to 30 percent  $\text{K}_2\text{O}$ ; 0 to 15 percent  $\text{MgO}$ ; 0 to 10 percent  $\text{CaO}$ ; 0 to 12 percent  $\text{SrO}$ ; 0 to 40 percent  $\text{BaO}$ ; and 0 to 1 percent  $\text{SnO}_2$ , wherein the glass is substantially free of  $\text{Na}_2\text{O}$  and wherein the glass is fusion formable and has a strain point of 540° C. or greater, a coefficient of thermal expansion of  $50 \times 10^{-7}$  or greater,  $T_{200}$  less than 1630° C., and having a liquidus viscosity of 150,000 poise or greater.

**22.** A glass comprising, in weight percent: 45 to 75 percent  $\text{SiO}_2$ ; 3 to 15 percent  $\text{Al}_2\text{O}_3$ ; 0 to 20 percent  $\text{B}_2\text{O}_3$ ; 14 to 25 percent  $\text{K}_2\text{O}$ ; 0 to 15 percent  $\text{MgO}$ ; 0 to 10 percent  $\text{CaO}$ ; 0 to 12 percent  $\text{SrO}$ ; 0 to 40 percent  $\text{BaO}$ ; and 0 to 1 percent  $\text{SnO}_2$ , wherein the glass is substantially free of  $\text{Na}_2\text{O}$  and wherein the glass is fusion formable and has a strain point of 540° C. or greater, a coefficient of thermal expansion of  $50 \times 10^{-7}$  or greater,  $T_{200}$  less than 1630° C., and having a liquidus viscosity of 150,000 poise or greater.

**23.** A glass comprising, in weight percent: 45 to 75 percent  $\text{SiO}_2$ ; 3 to 15 percent  $\text{Al}_2\text{O}_3$ ; 0 to 20 percent  $\text{B}_2\text{O}_3$ ; 3 to 30 percent  $\text{K}_2\text{O}$ ; 0 to 15 percent  $\text{MgO}$ ; 0 to 10 percent  $\text{CaO}$ ; 0 to 12 percent  $\text{SrO}$ ; 0 to 40 percent  $\text{BaO}$ ; and 0 to 1 percent  $\text{SnO}_2$ , wherein the glass is substantially free of  $\text{Na}_2\text{O}$  and wherein the glass is fusion formable and has a strain point of 540° C. or greater, a coefficient of thermal expansion of  $50 \times 10^{-7}$  or greater,  $T_{200}$  less than 1630° C., and having a liquidus viscosity of 150,000 poise or greater.

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