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(54) Title: LOW-LIGHT-FAILURE HIGH-POWER LED ROAD LAMP AND MANUFACTURING METHOD THEREFOR

(54) 发明名称: 一种低光衰大功率 LED 路灯及其制作方法

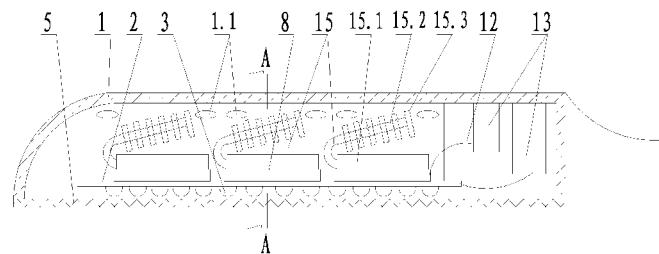


图 1 / Fig.1

(57) Abstract: Disclosed are a low-light-failure high-power LED road lamp and a manufacturing method therefor. The method comprises: making a colour mark in advance on a tail end surface used for manufacturing N-type semiconductor elements (6) or P-type semiconductor elements (7); and arranging the N-type semiconductor elements (6) and the P-type semiconductor elements (7) in a matrix form between an upper beryllium-oxide ceramic chip (8) and a lower beryllium-oxide ceramic chip (9) which are provided with conductive circuits, to make the head end of each column of N-type semiconductor elements (6) connected in series connect to the tail end of the P-type semiconductor elements (7) or the tail end of each column of N-type semiconductor elements (6) connect to the head end of the P-type semiconductor elements (7), then attaching the lower beryllium-oxide ceramic chip (9) to the back surface of a circuit board (2) equipped with LED bulbs (3) through a graphene heat conduction grease layer (4), installing radiators (15) on the upper beryllium-oxide ceramic chip (8), and then installing both the circuit board (2) and the radiators (15) in a road lamp housing (1).

(57) 摘要:

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- 包括国际检索报告(条约第 21 条(3))。

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一种低光衰大功率 LED 路灯及其制作方法，预先将制作 N 型半导体元件 (6) 或 P 型半导体元件 (7) 的尾端面上作色标记号；然后将该 N 型半导体元件 (6) 和 P 型半导体元件 (7) 按矩阵排列的方式排列在设有导电电路的上氧化铍陶瓷片 (8) 与下氧化铍陶瓷片 (9) 之间，使每一列串联的 N 型半导体元件 (6) 的头端与 P 型半导体元件 (7) 的尾端相连接或 N 型半导体元件 (6) 的尾端与 P 型半导体元件 (7) 的头端相连接，然后将下氧化铍陶瓷片 (9) 通过石墨烯导热脂层 (4) 贴合在安装有 LED 灯泡 (3) 的电路板 (2) 的背面上，并且在上氧化铍陶瓷片 (8) 上安装上散热器 (15)，然后将电路板 (2) 连同散热器 (15) 全部安装在路灯罩壳 (1) 内即成。

## **LOW LIGHT FAILURE, HIGH POWER LED STREET LAMP AND METHOD FOR MANUFACTURING THE SAME**

### **TECHNICAL FIELD**

[0001] The present invention relates to a low light failure, high power LED street lamp and a method for manufacturing the same, which belongs to the technical field of high power LED street lamps.

### **BACKGROUND**

[0002] Currently, light emitting diode (Light Emitting Diode, LED) has been widely applied as the light source for illumination due to the advantages such as energy saving, high brightness and small size. However, in the prior art, the heat dissipation structure of the LED light source generally adopts a cooling fin of aluminum alloy structure or adopts a heavier aluminum pouring piece for heat dissipation. Although these structures seem simple, but there exist disadvantages such as poor heat dissipation effect, high manufacturing cost, unable to effectively cool the LED lamps during operation etc, the performance is poor, thus are not suitable for high power LED lamps with power higher than 150W. Besides, since profile aluminum will generate cascade temperatures while dissipating heat, an LED may operate under the temperature higher than 70°C, which accelerates the aging of the LED, substantial light failure phenomenon will occur and the luminous efficiency significantly reduces, thereby increasing power consumption of the LED, shortening the service life and increasing the costs. Moreover, in order to meet the requirement of heat dissipation of high power LED street lamps, the cooling fin must be manufactured large, thus there also exist problems such as large size and heavy weight etc. Therefore, the structure style of current LED street lamps adopting LED as the

light source is undesirable, which cannot sufficiently achieve power saving advantage of the LED light source.

## SUMMARY

[0003] An embodiment of the present invention seeks to provide a low light

5 failure, high power LED street lamp and a method for manufacturing the same, which is of simple structure, small size, light weight and has advantages such as high light emitting efficiency, long service life and lower power consumption.

[0004] Alternatively or additionally, an embodiment of the present invention seeks to at least provide the public with a useful choice.

10 [0005] A first aspect of the present invention provides a method for manufacturing a low light failure high power LED street lamp according to the present invention includes: adopting an N-type semiconductor element and a P-type semiconductor element as cooling elements for heat dissipation of the circuit board mounted with an LED bulb, wherein, when adopting the N-type semiconductor element and P-type  
15 semiconductor element as the cooling elements, processing a crystal bar for manufacturing the N-type semiconductor element or the P-type semiconductor element in advance to be a cone shaped crystal bar with one end big and the other end small, then cutting the cone shaped crystal bar into slices to obtain wafers with the same thickness, in which the surface with a smaller diameter is regarded as a head end and the surface with a larger diameter is regarded as a tail end, making a color mark  
20 on the tail end surface for each wafer; then cutting and granulating the conical surface of each wafer to the same polygonal cylinder shapes, the semiconductor with the polygonal cylinder shape is the N-type or P-type semiconductor element with the head end and the tail end, then arranging the N-type semiconductor element and  
25 P-type semiconductor element in a manner of matrix between an upper beryllium-oxide ceramic wafer and a lower beryllium-oxide ceramic wafer, both the upper beryllium-oxide ceramic wafer and the lower beryllium-oxide ceramic wafer

are provided with a conductive circuit, so that the N-type semiconductor element and the P-type semiconductor element in each column are connected in series, when connecting in series, the head end of the N-type semiconductor element is connected with the tail end of the P-type semiconductor element or the tail end of the N-type semiconductor element is connected with the head end of the P-type semiconductor element, then attaching the lower beryllium-oxide ceramic wafer, through a graphene thermal conductive grease layer, on the backside of the circuit board which is mounted with the LED bulb, and mounting a heat sink on the upper beryllium-oxide ceramic wafer, then mounting the circuit board together with the heat sink into a street lamp housing.

**[0006]** A further aspect of the present invention provides a low light failure, high power LED street lamp, comprising: a street lamp housing, a circuit board mounted with an LED bulb and a direct current power source, wherein, the circuit board is connected with the direct current power source via a conductive wire, and the circuit board and the direct current power source are mounted in the street lamp housing, a transparent cover is provided at the bottom of the street lamp housing, wherein, at least one lower beryllium-oxide ceramic wafer is connected with a backside of the circuit board through a graphene thermal conductive grease layer, an upper beryllium-oxide ceramic wafer is provided on the lower beryllium-oxide ceramic wafer, an N-type semiconductor element and a P-type semiconductor element are connected between the upper beryllium-oxide ceramic wafer and the lower beryllium-oxide ceramic wafer in a manner of rectangular shape, an end of both the N-type semiconductor and the P-type semiconductor is provided with a conductive color mark, the end with the color mark is regarded as the tail end of the N-type semiconductor element or the P-type semiconductor element, the end without the color mark is regarded as the head end of the N-type semiconductor element or the P-type semiconductor element, each column of N-type semiconductor element and each column of P-type semiconductor element are connected in series respectively through an upper conductive plate provided on the upper beryllium-oxide ceramic

wafer and through a lower conductive plate provided on the lower beryllium-oxide ceramic wafer, and the head end of each column of N-type semiconductor element is connected with the tail end of each column of P-type semiconductor element or the tail end of each column of N-type semiconductor element is connected with the head 5 end of each column of P-type semiconductor element, each column of N-type semiconductor element and each column of P-type semiconductor element are connected with the direct current power source through a conductive wire on the upper conductive plate or the lower conductive plate provided at two outmost ends of the column; a beryllium copper plate pressing block is attached on the upper surface 10 of each upper beryllium-oxide ceramic wafer, a heat sink is mounted on the beryllium copper plate pressing block.

**[0007]** In an embodiment, the heat sink consists of a heat dissipating aluminum base, a thermal conductive pipe and a cooling fin, the heat dissipating aluminum base is pressed on the beryllium copper plate pressing block, a lower portion of the thermal 15 conductive pipe is made to be a flat shape and is embedded into a hole at the bottom of the heat dissipating aluminum base, and the flat shaped surface of the lower portion of the thermal conductive pipe is attached on the beryllium copper plate pressing block, the cooling fin is connected with an upper portion of the thermal conductive pipe, and is arranged above the heat dissipating aluminum base, the heat dissipating 20 aluminum base is fixed on the circuit board with screws.

**[0008]** In an embodiment, the thermal conductive pipe of the heat sink is filled with thermal conductive liquid.

**[0009]** In an embodiment, a heat dissipation hole is provided on sides of the street lamp housing.

25 **[0010]** Due to the adoption of the above technical solutions, based on the conventional manufacturing of N-type semiconductor element and P-type semiconductor element, the semiconductor crystal bar is made with a color mark after being cut, so that the head end and tail end of the N-type semiconductor element or the P-type semiconductor element can be distinguished in a convenient way, and the

arranging orientation of the head end or tail end is in consistent with that of the crystal bar before being cut. As such, when forming semiconductor cold dome couple element adopting the N-type semiconductor element and P-type semiconductor element, it is easy to distinguish the tail end and the head end, thereby avoiding the  
5 situation in the prior art that the tail and head ends are connected disorderly due to the indistinguishable head and tail ends, when connecting the N-type semiconductor element and P-type semiconductor element, and the operating efficiency of the semiconductor cold dome couple element formed is reduced. When manufacturing cold elements adopting the N-type semiconductor element and P-type semiconductor  
10 element of the present invention, it is convenient to achieve an ordered connection of the head end and the tail end, which will increase operating efficiency of each N-type semiconductor element and P-type semiconductor element, and effectively increase refrigerating effect of the whole refrigerating and cooling device. When the semiconductor cold dome couple element formed adopting the N-type semiconductor  
15 element and P-type semiconductor element of the present invention is in operation, the temperature difference between the cold end and the hot end ranges between 73-78 °C, the refrigerating effect is significantly superior to those in the prior art. Additionally, in the present invention, through directly cooling and refrigerating the circuit board of the LED light source adopting the N-type semiconductor element and  
20 P-type semiconductor element or performing thermal neutralization, the operating temperature of the circuit board of the LED light source can be significantly reduced. In the present invention, during operation, it is only needed to put mains supply on the direct current power source for normal operation, at this time, the LED bulb on the circuit board of the LED light will operate normally, and the semiconductor cold  
25 dome couple element formed by the N-type semiconductor element and P-type semiconductor element will begin to refrigerate, during operation, the cold end of the semiconductor cold dome couple element will cool and refrigerate the circuit board of the LED light source, and the heat generated by the hot end of the semiconductor cold dome couple element is transmitted to the cooling fin through the thermal conductive

pipe of the heat sink, the cooling fin dissipates the heat into the air. After testing, when the power of the circuit of the LED light source is 200W, under the situation of cooling and heat dissipating using the method of the present invention, after continuous operation of 9000 hours, the temperature of the LED on the circuit board of the LED light source will not exceed 60°C, light failure phenomenon of the LED does not occur. The weight of the low light failure LED street lamp of 200W is less than 5kg, which is 1/3 of the conventional LED street lamp of the same power, the size thereof is 1/2 of the conventional LED street lamp of the same power. Therefore, comparing with the prior art, the present invention has advantages, such as good heat dissipation effect, significantly reducing operating temperature of the LED light source, no light failure, long service life, good operating stability and increasing operating efficiency of the LED bulb etc.

#### BRIEF DESCRIPTION OF DRAWINGS

[0011] FIG. 1 is a schematic structural diagram of the present invention;

15 [0012] FIG. 2 is a schematic sectional view taken along the line A-A of FIG. 1 after removing a housing and a transparent cover for a street lamp.

[0013] Reference signs: 1- Street lamp housing, 1.1- Heat dissipation hole, 2- Circuit board, 3- LED bulb, 4- Graphene thermal conductive grease layer, 5- Transparent cover, 6- N-type semiconductor element, 7- P-type semiconductor element, 8- Upper beryllium-oxide ceramic wafer, 9- Lower beryllium-oxide ceramic wafer, 10- Upper conductive plate, 11- Lower conductive plate, 12- Conductive wire, 13- Direct current power source, 14- Beryllium copper plate pressing block, 15- Heat sink, 15.1- Heat dissipating aluminum base, 15.2- Thermal conductive pipe, 15.3- Cooling fin, 15.4- Thermal conductive liquid, 16- Screw.

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#### DESCRIPTION OF EMBODIMENTS

[0014] The present invention is described below in further detail, by way of

non-limiting example only, with reference to accompanying drawings and embodiments.

[0015] Embodiment of the present invention: a method for manufacturing a low light failure high power LED street lamp includes: adopting N-type semiconductor

5 element and P-type semiconductor element as cooling elements for heat dissipation of the circuit board mounted with the LED bulb, when adopting the N-type semiconductor element and P-type semiconductor element as the cooling elements,

the crystal bar for manufacturing the N-type semiconductor element or the P-type semiconductor element is processed in advance to be a cone shaped crystal bar with

10 one end big and the other end small (diameter of the small end of the crystal bar can be determined according to actual needs, its taper degree can be controlled within the range of 2-5 degrees), then the cone shaped crystal bar is cut into slices to obtain

wafers with the same thickness, in which the surface with a smaller diameter is regarded as the head end and the surface with a larger diameter is regarded as the tail end, a color mark is made on the tail end surface for each wafer; then the conical

15 surface of each wafer is cut and granulated to the same polygonal cylinder shapes, the semiconductor with the polygonal cylinder shape is the N-type or P-type semiconductor element with head end and tail end, then the N-type semiconductor

element and P-type semiconductor element are arranged in a manner of matrix between an upper beryllium-oxide ceramic wafer and a lower beryllium-oxide

20 ceramic wafer, both of which are provided with conductive circuit, so that the N-type semiconductor element and the P-type semiconductor element in each column are connected in series, when connecting in series, the head end of the N-type

semiconductor element is connected with the tail end of the P-type semiconductor element or the tail end of the N-type semiconductor element is connected with the

25 head end of the P-type semiconductor element, then the lower beryllium-oxide ceramic wafer is attached, through a graphene thermal conductive grease layer, on the backside of the circuit board which is mounted with LED bulbs, and a heat sink is

mounted on the upper beryllium-oxide ceramic wafer, then the circuit board is

mounted together with the heat sink into the street lamp housing.

[0016] The structure of a low light failure, high power LED street lamp constructed according to the above method is as shown in FIG. 1 and FIG. 2, the low light failure, high power LED street lamp includes a street lamp housing 1, a circuit

5 board 2 mounted with LED bulbs 3 and a direct current power source 13, all of which can adopt products in the prior art. The street lamp housing can adopt street lamp housing product made of plastic or metal material and is provided with a tail seat connecting with an electrical pole holder. The circuit board 2 is connected with the

10 direct current power source 13 via a conductive wire, and the circuit board 2 and the direct current power source 13 are mounted in the street lamp housing 1. At least one lower beryllium-oxide ceramic wafer 9 (the number of the lower beryllium-oxide ceramic wafer 9 connected with the backside of the circuit board 2 can be determined according to the area of the circuit board 2 used, during producing, the backside of the circuit board 2 is preferably fully attached with lower beryllium-oxide ceramic wafers

15 9) is connected with the backside of the circuit board 2 through a graphene thermal conductive grease layer 4. Then the upper beryllium-oxide ceramic wafer 8 is provided on the lower beryllium-oxide ceramic wafer 9, meanwhile the N-type semiconductor element 6 and P-type semiconductor element 7 arranged in a manner of a conventional rectangular shape are connected between the upper beryllium-oxide

20 ceramic wafer 8 and the lower beryllium-oxide ceramic wafer 9. When mounting, an end of both the N-type semiconductor and the P-type semiconductor is provided with a conductive color mark, the end with the color mark is regarded as the tail end of the N-type semiconductor element 6 or the P-type semiconductor element 7, the end without the color mark is regarded as the head end of the N-type semiconductor

25 element 6 or the P-type semiconductor element 7. Then each column of N-type semiconductor element 6 and each column of P-type semiconductor element 7 are connected in series respectively through an upper conductive plate 10 provided on the upper beryllium-oxide ceramic wafer 8 and through a lower conductive plate 11 provided on the lower beryllium-oxide ceramic wafer 9, so that the head end of each

column of N-type semiconductor element 6 is connected with the tail end of each column of P-type semiconductor element 7, each column of N-type semiconductor element 6 and each column of P-type semiconductor element 7 are connected with the direct current power source 13 through a conductive wire 12 on the upper conductive plate 10 or the lower conductive plate 11 provided at two outmost ends of the column.

A beryllium copper plate pressing block 14 with high mechanical strength and conductivity is attached on the upper surface of each upper beryllium-oxide ceramic wafer 8, a heat sink 15 is mounted on the beryllium copper plate pressing block 14.

The heat sink 15 consists of a heat dissipating aluminum base 15.1, a thermal conductive pipe 15.2 and a cooling fin 15.3 (as shown in FIG. 1 and FIG. 2). The heat dissipating aluminum base 15.1 is pressed on the beryllium copper plate pressing block 14, the lower portion of the thermal conductive pipe 15.2 is made to be a flat shape and is embedded into a hole at the bottom of the heat dissipating aluminum base 15.1, meanwhile the flat shaped surface of the lower portion of the thermal conductive pipe 15.2 is attached on the beryllium copper plate pressing block 14, then the cooling fin 15.3 is connected with the upper portion of the thermal conductive pipe 15.2, and the cooling fin 15.3 is arranged above the heat dissipating aluminum base 15.1, then the heat dissipating aluminum base 15.1 is fixed on the circuit board 2 with screws 16

(when connecting, it should be noted that the screw 16 and the circuit board 2 are insulated from each other ). In order to achieve better heat transmission and heat dissipation, thermal conductive liquid 15.4 can be filled in the thermal conductive pipe 15.2, when filling the thermal conductive liquid 15.4, it should be noted that the space in the thermal conductive pipe 15.2 should not be fully filled, there should remain certain space so that the thermal conductive liquid 15.4 flows therein. The thermal conductive liquid 15.4 can be normal water, distilled water or transformer oil.

In order to achieve better heat dissipation, a heat dissipation hole 1.1 can be provided on both symmetrical sides of the street lamp housing 1. At last, a transparent cover 5 is mounted on the bottom of the street lamp housing 1. The transparent cover 5 can be made of glass or organic glass in a conventional manner.

[0017] The term 'comprising' as used in this specification and claims means 'consisting at least in part of'. When interpreting statements in this specification and claims which include the term 'comprising', other features besides the features prefaced by this term in each statement can also be present. Related terms such as  
5 'comprise' and 'comprised' are to be interpreted in similar manner.

[0018] In this specification where reference has been made to patent specifications, other external documents, or other sources of information, this is generally for the purpose of providing a context for discussing the features of the invention. Unless specifically stated otherwise, reference to such external  
10 documents is not to be construed as an admission that such documents, or such sources of information, in any jurisdiction, are prior art, or form part of the common general knowledge in the art.

## CLAIMS

What is claimed is:

1. A method for manufacturing a low light failure, high power LED street lamp,  
5 comprising: adopting an N-type semiconductor element and a P-type semiconductor  
element as cooling elements for heat dissipation of a circuit board mounted with an  
LED bulb, wherein, when adopting the N-type semiconductor element and P-type  
semiconductor element as the cooling elements, processing a crystal bar for  
manufacturing the N-type semiconductor element or the P-type semiconductor  
10 element in advance to be a cone shaped crystal bar with one end bigger and the other  
end smaller, then cutting the cone shaped crystal bar into slices to obtain wafers with  
the same thickness, in which the surface with a smaller diameter is regarded as a head  
end and the surface with a larger diameter is regarded as a tail end, making a color  
mark on the tail end surface for each wafer; then cutting and granulating the conical  
15 surface of each wafer to the same polygonal cylinder shapes, wherein the  
semiconductor with the polygonal cylinder shape is the N-type or P-type  
semiconductor element with the head end and the tail end, then arranging the N-type  
semiconductor element and P-type semiconductor element in a manner of matrix  
between an upper beryllium-oxide ceramic wafer and a lower beryllium-oxide  
20 ceramic wafer, both the upper beryllium-oxide ceramic wafer and the lower  
beryllium-oxide ceramic wafer are provided with a conductive circuit, so that the  
N-type semiconductor element and the P-type semiconductor element in each column  
are connected in series, when connecting in series, the head end of the N-type  
semiconductor element is connected with the tail end of the P-type semiconductor  
25 element or the tail end of the N-type semiconductor element is connected with the  
head end of the P-type semiconductor element, then attaching the lower  
beryllium-oxide ceramic wafer, through a graphene thermal conductive grease layer,  
on the backside of the circuit board which is mounted with the LED bulb, and

mounting a heat sink on the upper beryllium-oxide ceramic wafer, then mounting the circuit board together with the heat sink into a street lamp housing.

2. A low light failure, high power LED street lamp, comprising a street lamp housing, a circuit board mounted with an LED bulb and a direct current power source, wherein, the circuit board is connected with the direct current power source via a conductive wire, and the circuit board and the direct current power source are mounted in the street lamp housing, a transparent cover is provided at the bottom of the street lamp housing, wherein, at least one lower beryllium-oxide ceramic wafer is connected with a backside of the circuit board through a graphene thermal conductive grease layer, an upper beryllium-oxide ceramic wafer is provided on the lower beryllium-oxide ceramic wafer, an N-type semiconductor element and a P-type semiconductor element are connected between the upper beryllium-oxide ceramic wafer and the lower beryllium-oxide ceramic wafer in a manner of rectangular shape, an end of both the N-type semiconductor and the P-type semiconductor is provided with a conductive color mark, the end with the color mark is regarded as the tail end of the N-type semiconductor element or the P-type semiconductor element, the end without the color mark is regarded as the head end of the N-type semiconductor element or the P-type semiconductor element, each column of N-type semiconductor element and each column of P-type semiconductor element are connected in series respectively through an upper conductive plate provided on the upper beryllium-oxide ceramic wafer and through a lower conductive plate provided on the lower beryllium-oxide ceramic wafer, and the head end of each column of N-type semiconductor element is connected with the tail end of each column of P-type semiconductor element or the tail end of each column of N-type semiconductor element is connected with the head end of each column of P-type semiconductor element, each column of N-type semiconductor element and each column of P-type semiconductor element are connected with the direct current power source through a conductive wire on the upper conductive plate or the lower conductive plate provided at two outmost ends of the column; a beryllium copper plate pressing block is

attached on the upper surface of each upper beryllium-oxide ceramic wafer, a heat sink is mounted on the beryllium copper plate pressing block.

3. The low light failure high power LED street lamp according to claim 2,  
5 wherein, the heat sink consists of a heat dissipating aluminum base, a thermal conductive pipe and a cooling fin, the heat dissipating aluminum base is pressed on the beryllium copper plate pressing block, a lower portion of the thermal conductive pipe is made to be a flat shape and is embedded into a hole at the bottom of the heat dissipating aluminum base, and the flat shaped surface of the lower portion of the  
10 thermal conductive pipe is attached on the beryllium copper plate pressing block, the cooling fin is connected with an upper portion of the thermal conductive pipe, and is arranged above the heat dissipating aluminum base, the heat dissipating aluminum base is fixed on the circuit board with screws.

15 4. The low light failure high power LED street lamp according to claim 3,  
wherein, the thermal conductive pipe of the heat sink is filled with thermal conductive liquid.

5. The low light failure high power LED street lamp according to claim 2,  
20 wherein, a heat dissipation hole is provided on sides of the street lamp housing.

1/1

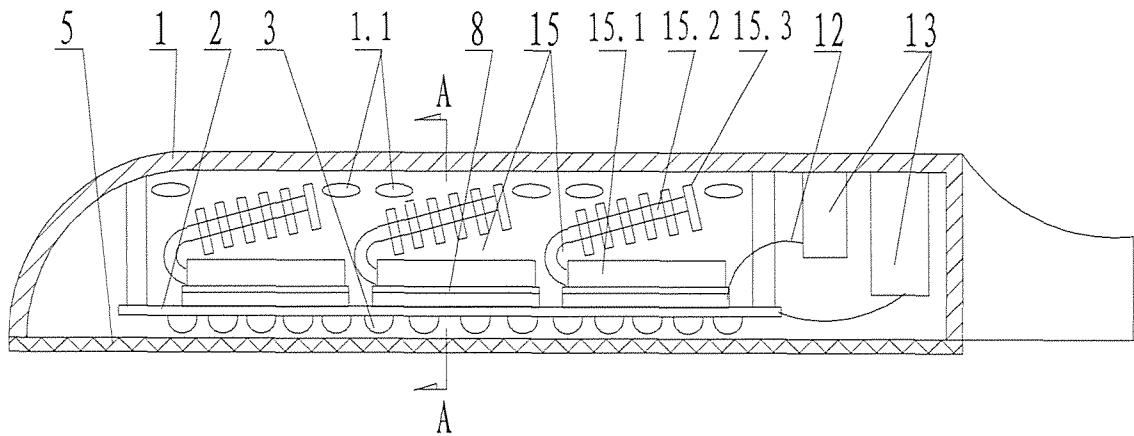


FIG. 1

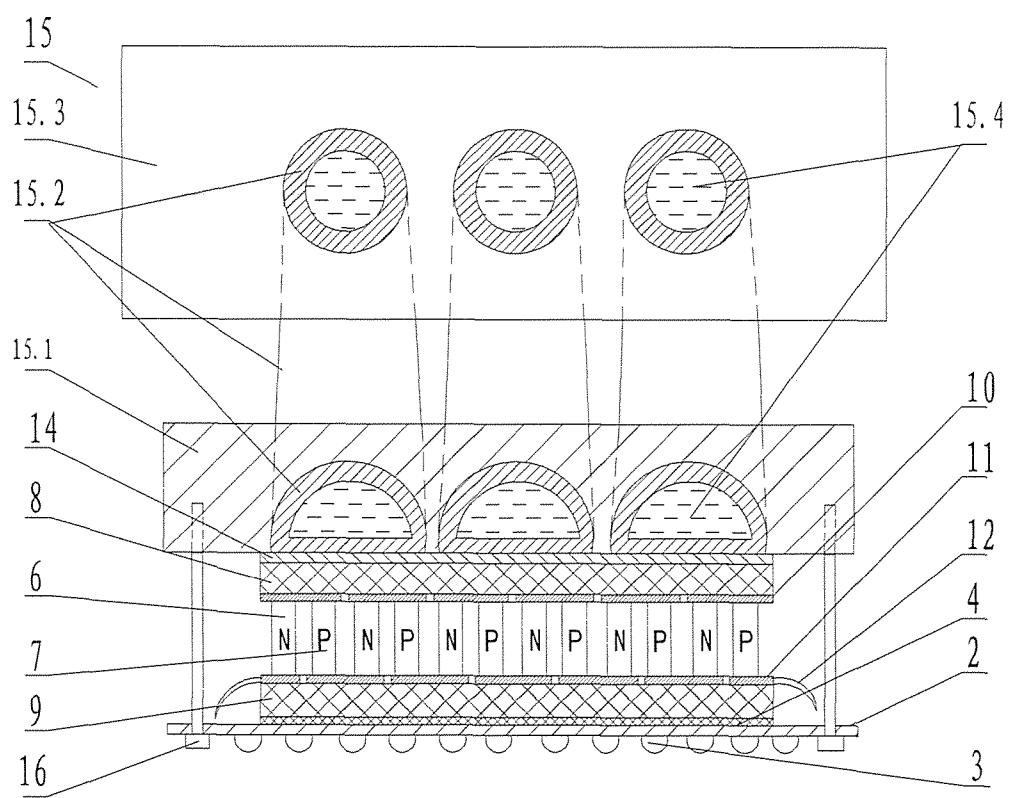


FIG. 2