Fault Modeling

- Introduction
- **Fault Models**
  - Stuck-at fault (1961)
  - Bridging fault (1973)
  - Delay fault (1974)
  - **Transistor-level fault**
    - **Stuck-open (1978)**
    - **Stuck-on**
    - **Cell-aware (2009)**
  - **Review**
- Fault Detection
- Fault Coverage
- Conclusion

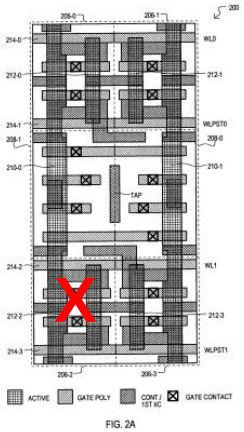
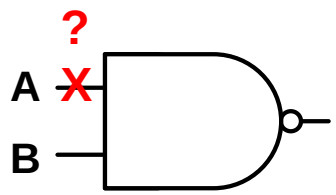


FIG. 2A

Why Faulty NAND Has Memory ?

- Stanford Murphy Experiment [Li 01]
  - *Sequence Dependency*: Test result depends on test sequence
- Example: NAND gate
  - Same test patterns {11, 01, 00}, but in different sequence
  - Sequence 1 fails; Sequence 2 passes
  - Is it A SA1 or not?



Sequence 1

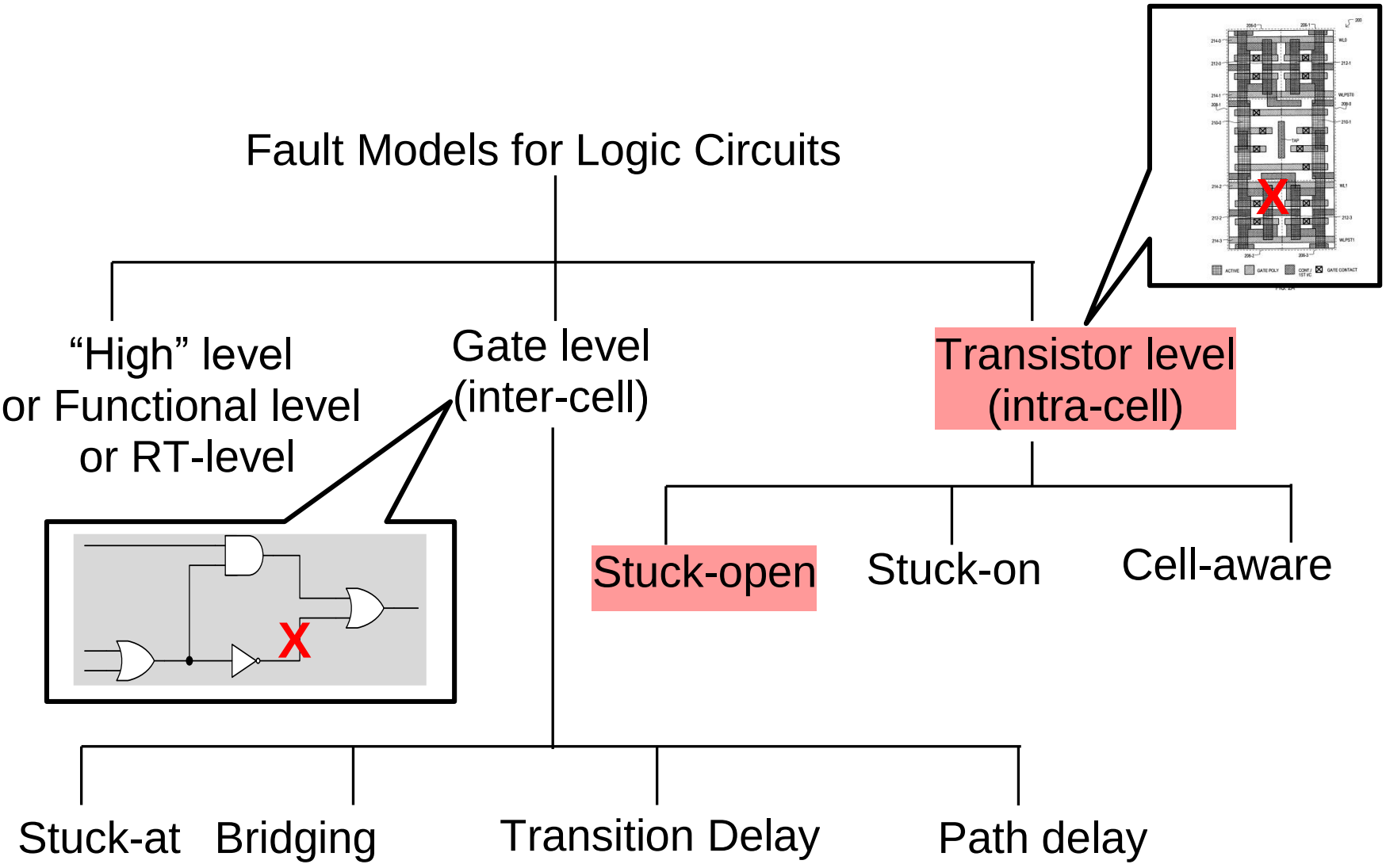
A	B	Out_{good}	Out_{faulty}	
1	1	0	0	
0	1	1	0	← A SA1 ?
0	0	1	1	

Sequence 2

A	B	Out_{good}	Out_{faulty}	
0	0	1	1	
0	1	1	1	← Not A SA1 ??
1	1	0	0	

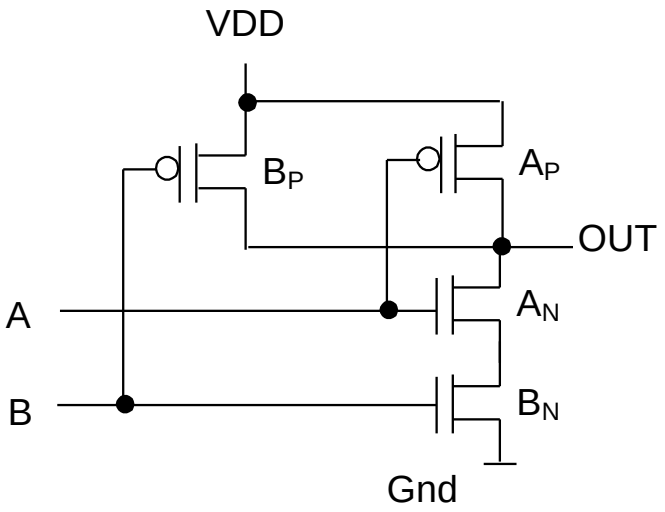
SSF Cannot Explain Seq. Dep.

Classification of Fault Models



Stuck-open Fault [Wadsack 78]

- *Stuck-open (SOP) fault*
  - Faulty transistors is always off
- Example: NAND
  - 11→01 detects A_P SOP
  - Totally 4 faults: A_P B_P A_N B_N



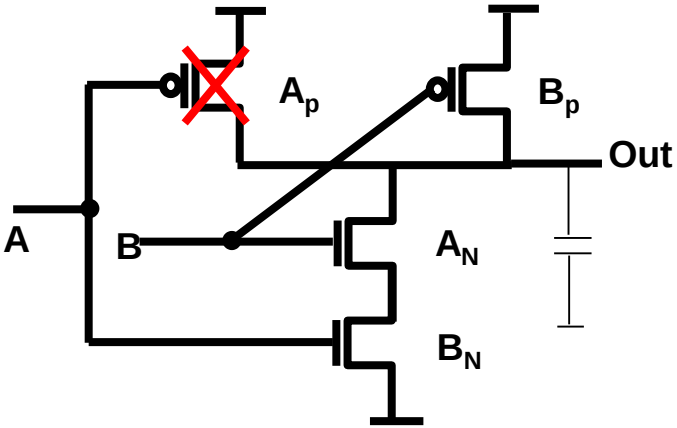
Input A B	Fault-free Output	Faulty Outputs A_P	A_N	B_P	B_N
0 0	1	1	1	1	1
0 1	1	Z	1	1	1
1 0	1	1	1	Z	1
1 1	0	0	Z	0	Z

Z = high impedance

SOP Requires 2-pattern Test

Sequence Dependency

- SOP Faulty circuit has *memory* (due to parasitic capacitor)
  - Test results depend on sequence of test patterns
- Example: A_p stuck-open fault,
  - Same test patterns{11, 01, 00}, but different sequence
  - Sequence 1 fails; Sequence 2 passes (test escape)



Sequence 1

A	B	Out_{good}	Out_{faulty}
1	1	0	0
0	1	1	0
0	0	1	1

FAIL:
Fault detected

Sequence 2

A	B	Out_{good}	Out_{faulty}
0	0	1	1
0	1	1	1
1	1	0	0

PASS:
Fault undetected
(test escape)

Simulation Results [Millman 89]

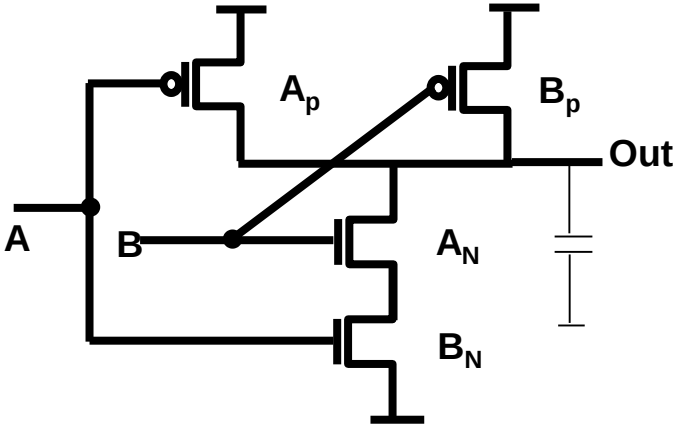
- Q: How effective is SSF test sets for stuck-open faults?
- 74LS181 ALU
  - Total 426 stuck-open faults
  - 100% SSF tests cannot achieve 100% SOP fault coverage

Test set	Krish	Br2	Goel	Mc1	Hugh
Test Length	12	14	35	124	135
SSF fault coverage %	100	100	100	100	100
SOP fault coverage %	79.3	79.6	90.8	87.1	93.4

SSF Not Enough for SOP

SOP ≠ TDF [Li 02]

- TDF is correlated with SOP fault, but they are NOT the same
- {11→01, 01→10, 00→11} has 100% TDF coverage
  - but only 75% SOP fault coverage (missed B_P)



$A_1B_1 \rightarrow A_2B_2$	Out_{good}	Detected SOP	Detected TDF
11→01	0→1	A_P	A STF; Out STR
10→01	1→1	-	A STF
11→10	0→1	B_P	B STF; Out STR
01→10	1→1	-	B STF
00→11	1→0	A_N B_N	A STR; B STR Out STF

TDF Not Enough for SOP, Either

Experimental Results [Woodhal 87] [Li 01]

- 1 μm CMOS [Woodhal 87]
  - Total population: 4,552 chips (passed parametric test)
    - 1,225 chips failed stuck-at test
    - 44 chips (3.6% of 1225) failed stuck-open test
    - 4 chips failed stuck-open test escaped stuck-at test
- 0.7μm CMOS, *Stanford Murphy experiment* [Li 01]
  - Total population 5.5K chips tested
    - 116 defective chips
    - 7 single stuck-open fault diagnosed
    - 2 multiple faults (stuck-at + stuck-open)

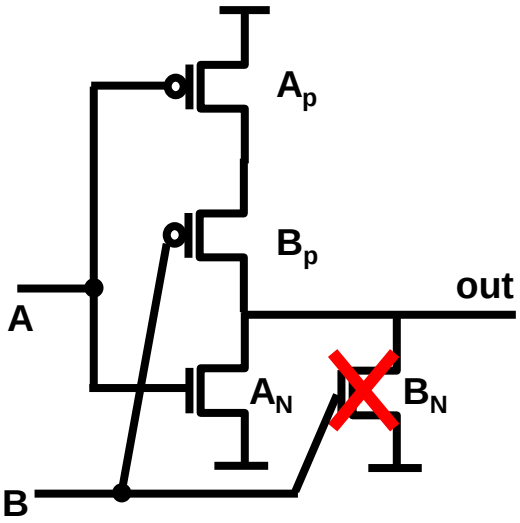
- About 5% of failed chips are stuck-open

Stuck-open Cannot be Ignored

Quiz

Q1: Find a sequence of 2 patterns to detect B_N SOP fault in NOR
A:

Q2: Find a sequence of 2 patterns that cannot detect B_N SOP fault (test escape)
A:



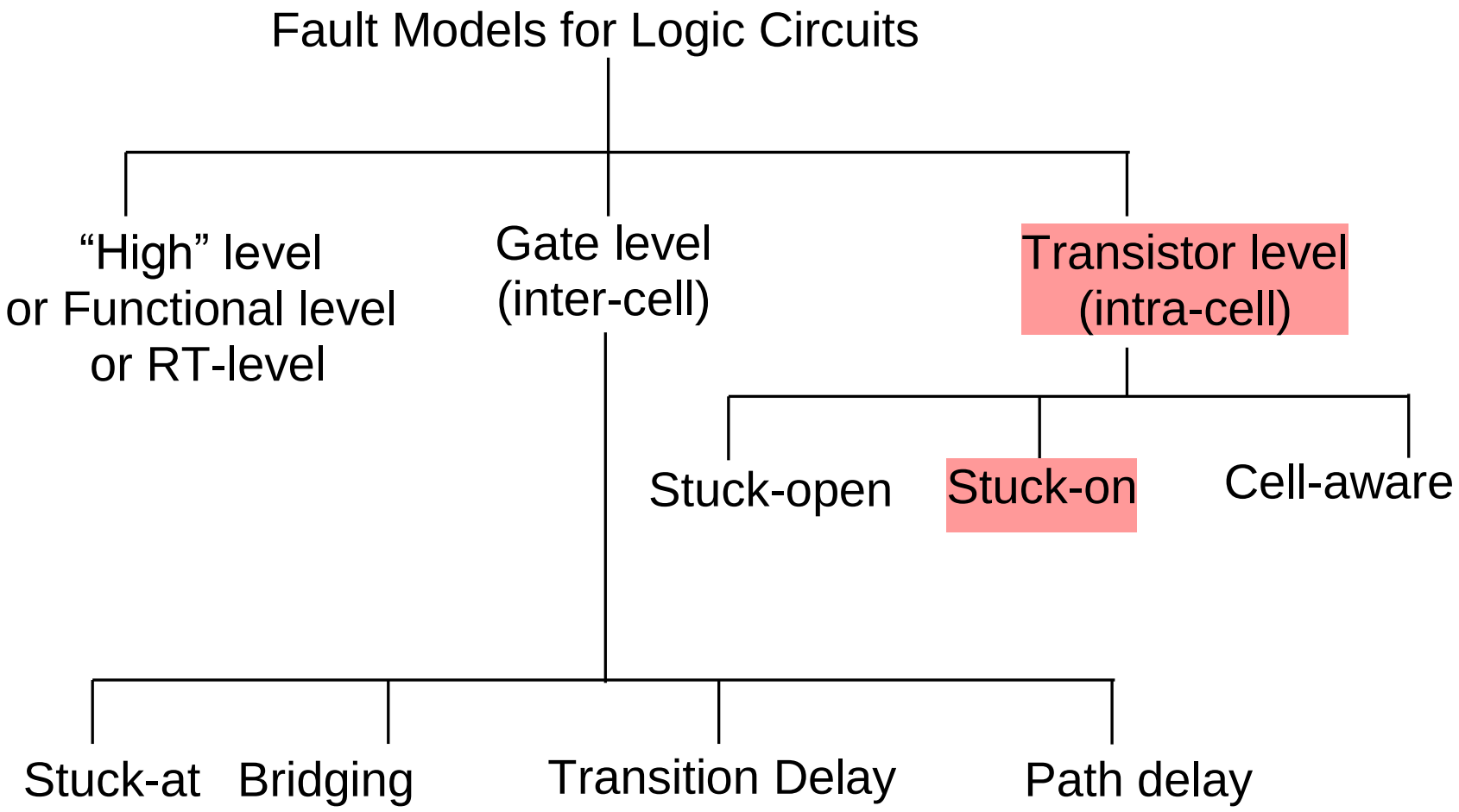
Sequence 1

A	B	Out_{good}	Out_{faulty}

Sequence 2

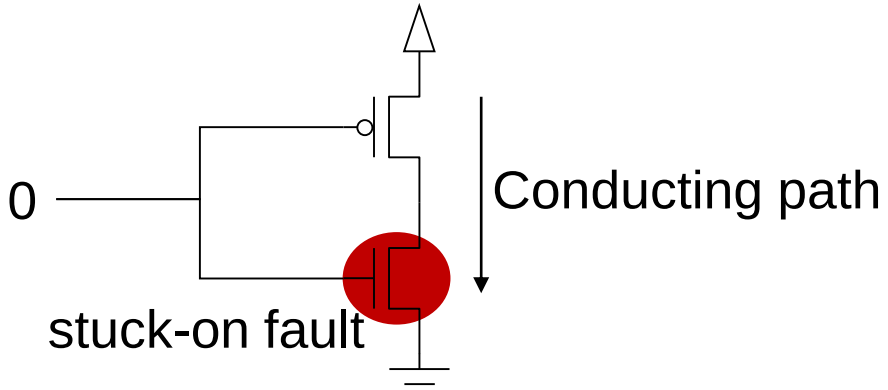
A	B	Out_{good}	Out_{faulty}

Classification of Fault Models



Stuck-On Fault

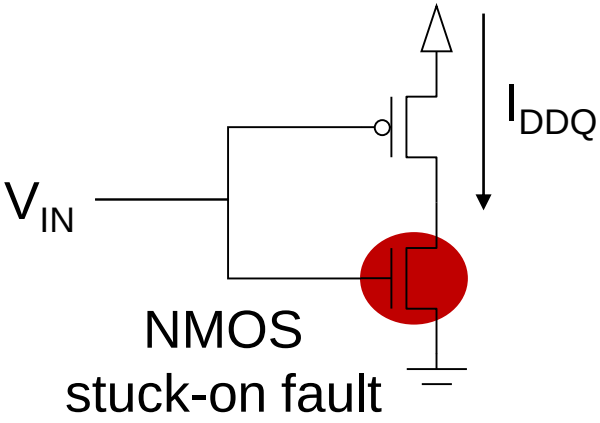
- Faulty transistor is always on
  - Form a conducting path between Vdd and Gnd in static state
- Stuck-on fault may NOT be detected by Boolean testing
  - Output logic values depends on relative impedance of transistors
- Stuck-on fault can be detected by I_{DDQ} testing
  - Apply test pattern
  - Wait for a while
  - Measure *quiescent current* from power supply

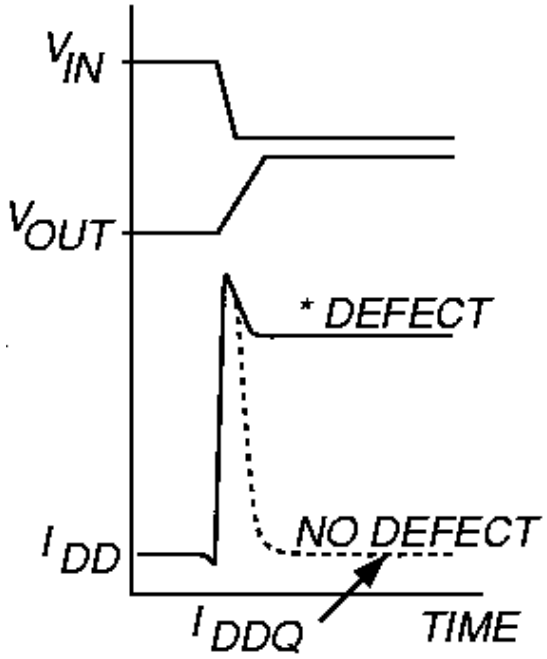


I_{DDQ} Testing [Mark 81]

- **Measure static power supply current, with test patterns applied**
  - **I_{DD} = power supply current from V_{DD}**
  - **Q = quiescent**
- **Very commonly used in CMOS technology***
- **Example: NMOS stuck-on fault**

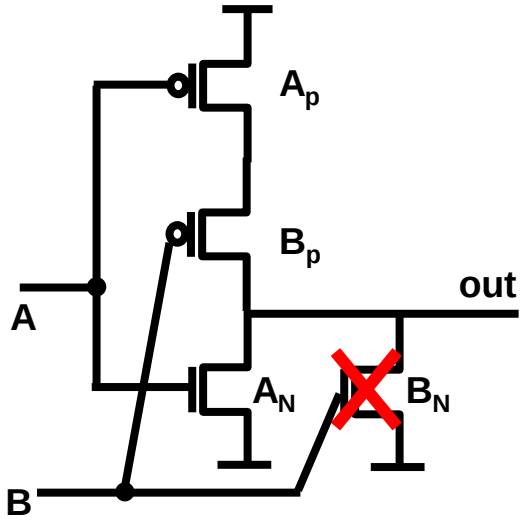
*but I_{DDQ} less effective for new technologies due to leakage



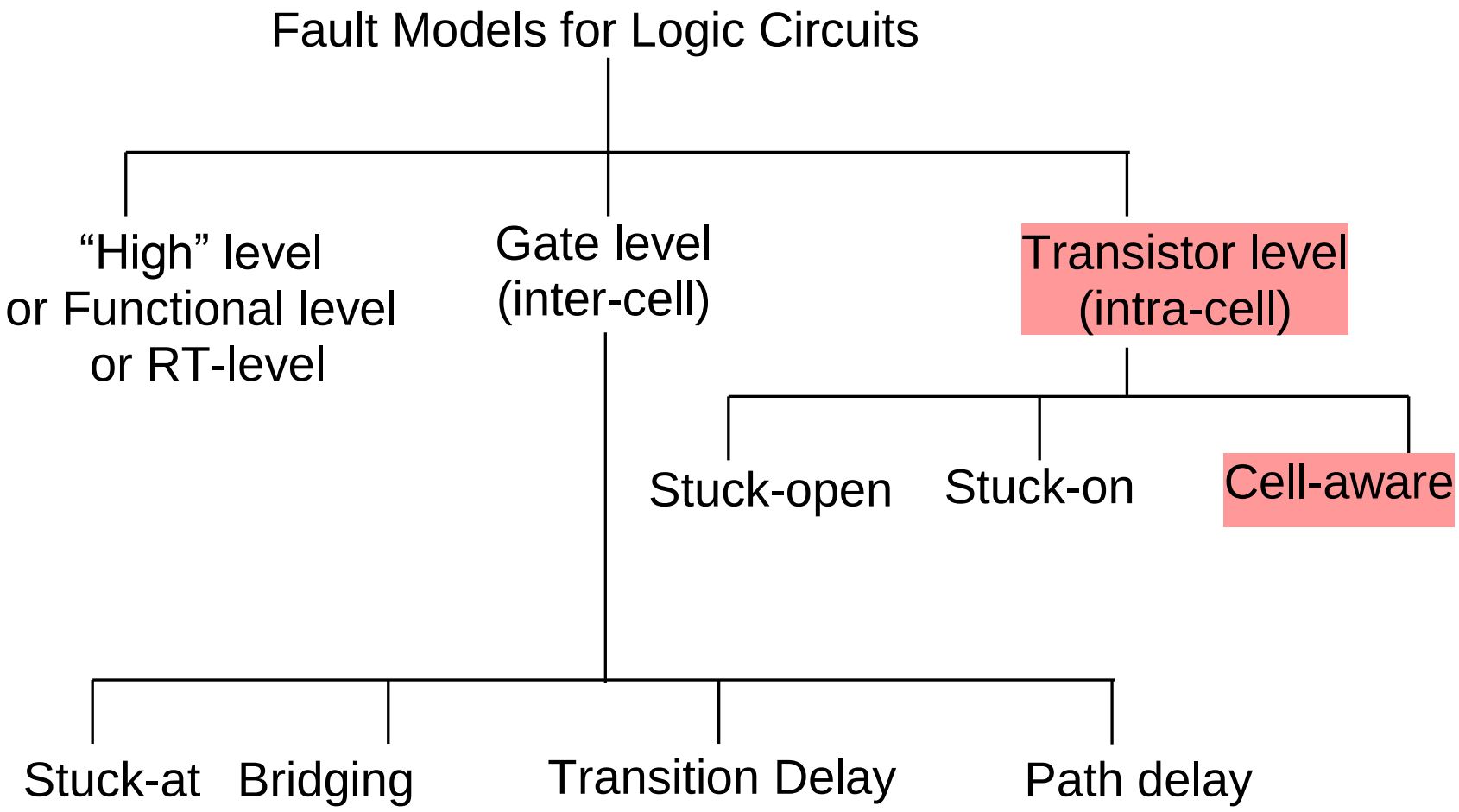


Quiz

Q: Find a test pattern to detect B_N Stuck-on fault in NOR by I_{DDQ}
A:

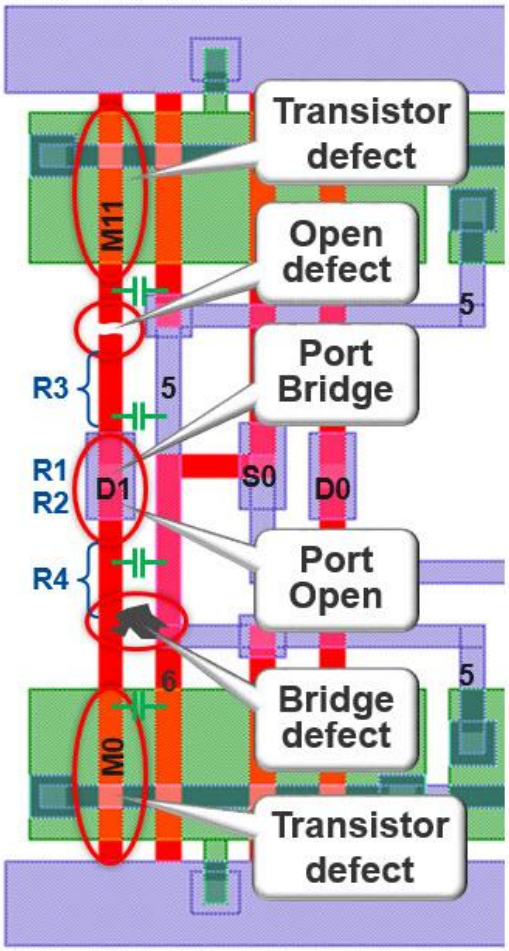


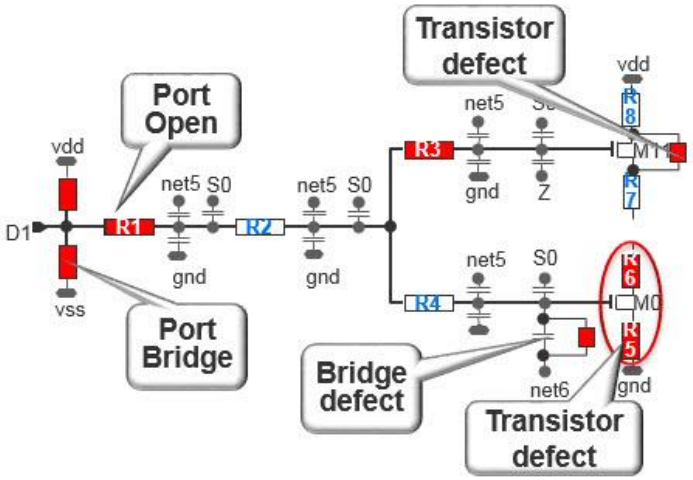
Classification of Fault Models



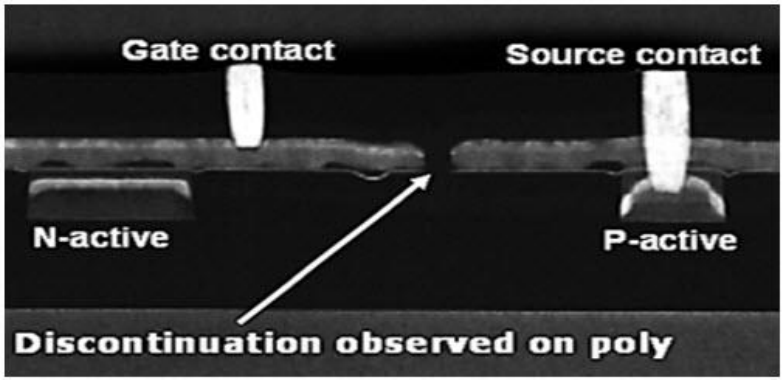
Cell-aware Test (CAT) [Hapke 09]

- Consider different defects types inside cell: open, bridge, transistor
- Need *layout extraction* and *analog fault simulation*





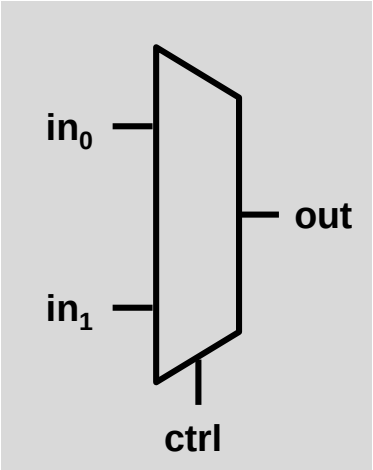
PFA proven CAT only detected defect



[Mentor website]

Why CAT more Effective?

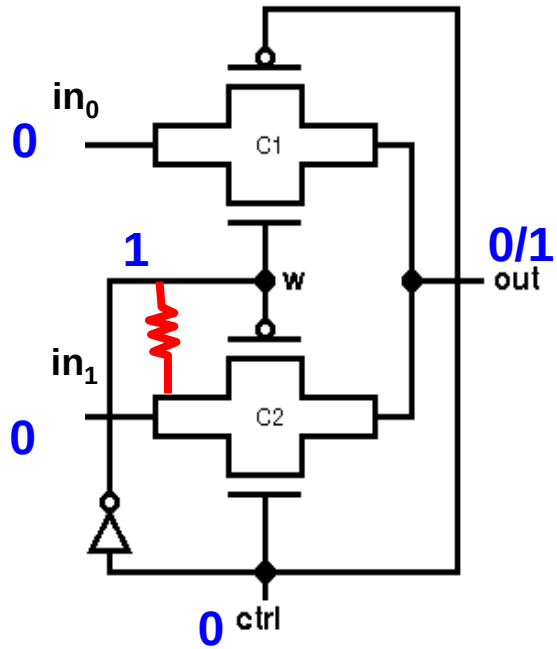
- 4 test patterns detect 8 SSF at MUX I/O pins
  - 100% SSF coverage



in_0	in_1	ctrl	out	detected SSF
0	1	0	0	ctrl SA1, out SA1, in_0 SA1
1	0	0	1	in_1 SA1
1	0	1	0	ctrl SA0, out SA0, in_0 SA0
1	1	1	1	in_1 SA0

- CAT adds {000} to detect in_1/w bridging

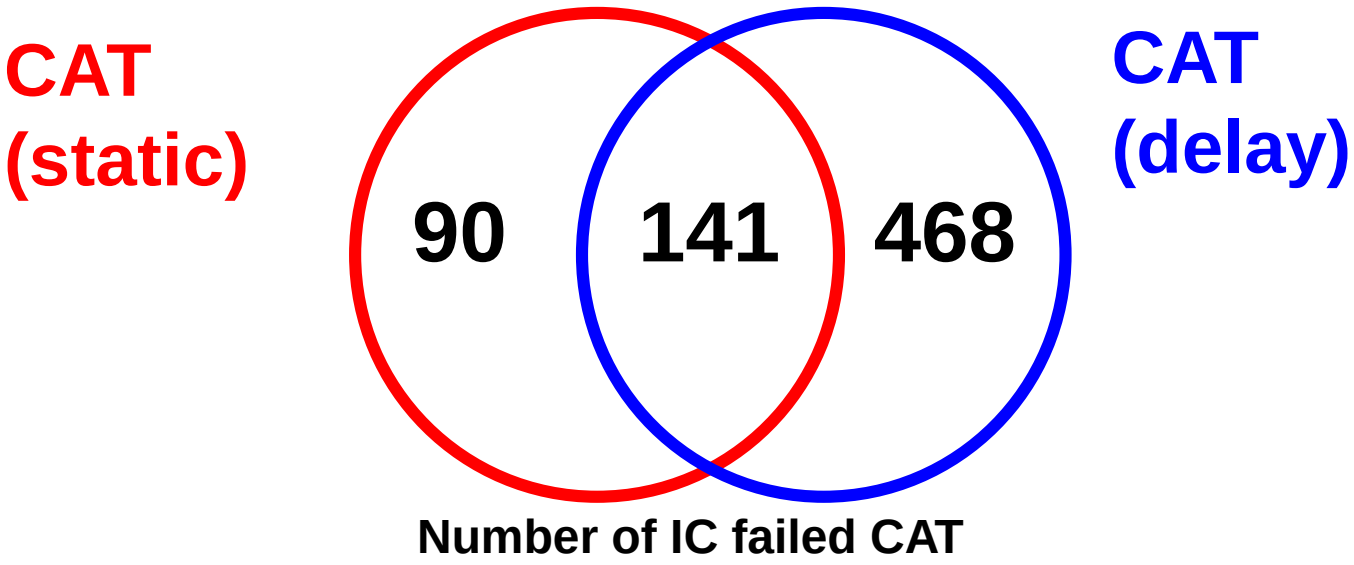
in_0	in_1	ctrl	out
0	1	0	0
1	0	0	1
1	0	1	0
1	1	1	1
0	0	0	0/1



CAT is Effective but Longer

Experimental Results [Hapke 14]

- AMD 32 nm, total 800K IC tested
- 699 IC failed only CAT, passed other tests



CAT Improves 885DPM

Fault Modeling

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- **Fault Models**
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  - Bridging fault (1973)
  - Delay fault (1974)
  - Transistor-level fault (1978)
  - **Review**
- Fault Detection
- Fault Coverage
- Conclusion

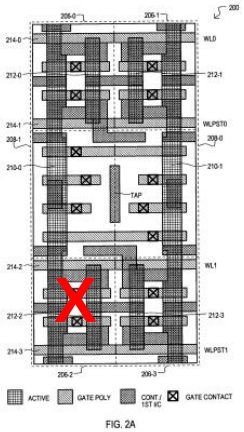
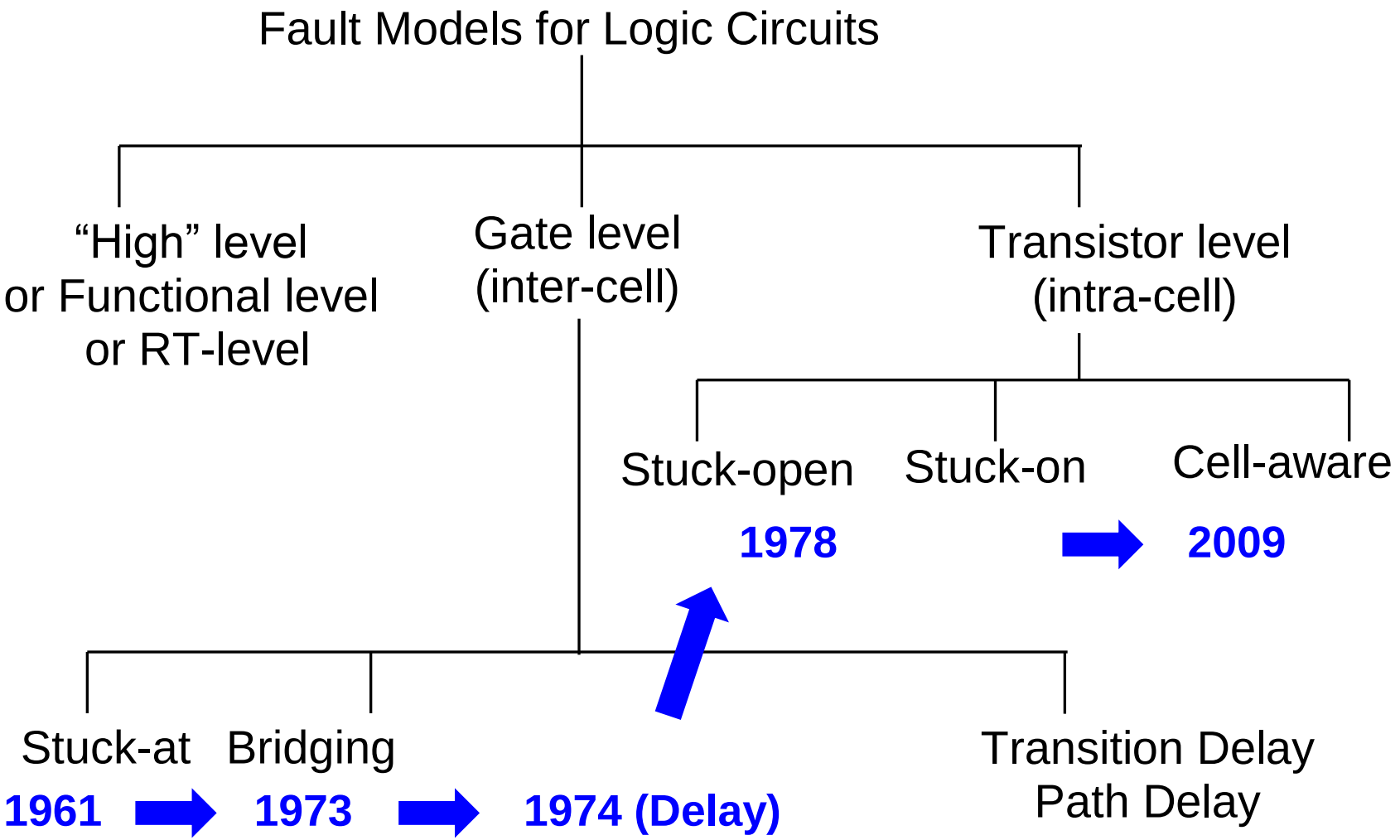


FIG. 2A

Classification of Fault Models



Fault Models Evolve with Technology

More Classifications

- According to timing
  - *AC faults*: timing dependent
    - Delay faults
  - *DC faults*: not timing dependent
    - Stuck-at faults, stuck-open faults …
- According to memory effect
  - *Sequential faults*: faults that increase number of states
    - Stuck-open faults, feedback bridging faults
  - *Combinational faults*: faults do not increase number of states
    - Stuck-at faults, non-feedback bridging faults
- According to circuit under test (CUT)
  - *Memory* fault model (see *memory testing* chapter)
  - *FPGA* fault model
  - …

No Single Best Fault Model for All Circuits

Summary

① **Transistor stuck-open (SOP)**
- **Sequence dependence: faulty comb. logic has memory**
- **TDF ≠ SOP**

② **Transistor stuck-on**
- **I_{DDQ} testing**

③ **Cell-aware testing**
- **layout extraction + analog fault simulation**
- **Improved DPM but longer test**

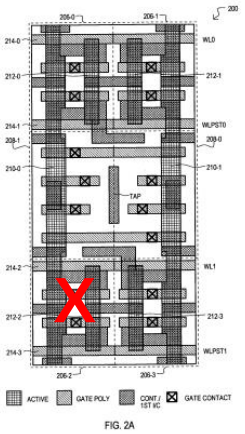


FIG. 2A

- **Fault models evolve with technology**
  - **NO single best fault model for all circuits**
  - **New fault models needed for future technologies!**