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Source/drain silicide for multigate device performance and method of fabricating thereof

Abstract

Source/drain silicide that improves performance and methods for fabricating such are disclosed herein. An exemplary device includes a first channel layer disposed over a substrate, a second channel layer disposed over the first channel layer, and a gate stack that surrounds the first channel layer and the second channel layer. A source/drain feature disposed adjacent the first channel layer, second channel layer, and gate stack. The source/drain feature is disposed over first facets of the first channel layer and second facets of the second channel layer. The first facets and the second facets have a (111) crystallographic orientation. An inner spacer disposed between the gate stack and the source/drain feature and between the first channel layer and the second channel layer. A silicide feature is disposed over the source/drain feature where the silicide feature extends into the source/drain feature towards the substrate to a depth of the first channel layer.

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Background/Summary

PRIORITY DATA (1) The present application is a divisional application of U.S. patent application Ser. No. 17/231,925, filed on Apr. 15, 2021, which is herein incorporated by reference in its entirety.

BACKGROUND

(1) The electronics industry has experienced an ever-increasing demand for smaller and faster electronic devices that are simultaneously able to support a greater number of increasingly complex and sophisticated functions. To meet these demands, there is a continuing trend in the integrated circuit (IC) industry to manufacture low-cost, high-performance, and low-power ICs. Thus far, these goals have been achieved in large part by reducing IC dimensions (for example, minimum IC feature size), thereby improving production efficiency and lowering associated costs. However, such scaling has also increased complexity of the IC manufacturing processes. Thus, realizing continued advances in IC devices and their performance requires similar advances in IC manufacturing processes and technology.

(2) Recently, multigate devices have been introduced to improve gate control. Multigate devices have been observed to increase gate-channel coupling, reduce OFF-state current, and/or reduce short-channel effects (SCEs). One such multigate device is the gate-all around (GAA) device, which includes a gate structure that can extend, partially or fully, around a channel region to provide access to the channel region on at least two sides. GAA devices enable aggressive scaling down of IC technologies, maintaining gate control and mitigating SCEs, while seamlessly integrating with conventional IC manufacturing processes. As GAA devices continue to scale, challenges have arisen with the addition of multiple stacked channel layers, which challenges have been observed to degrade performance of the GAA devices.

Description

BRIEF DESCRIPTION OF THE DRAWINGS

(1) The present disclosure is best understood from the following detailed description when read with the accompanying figures. It is emphasized that, in accordance with the standard practice in the industry, various features are not drawn to scale and are used for illustration purposes only. In fact, the dimensions of the various features may be arbitrarily increased or reduced for clarity of discussion.

(2) FIG. 1 is a flow chart of a method for fabricating a multigate device according to various aspects of the present disclosure.

(3) FIGS. 2A-2H are diagrammatic cross-sectional views of a multigate device at various fabrication stages (such as those associated with the method in FIG. 1) according to various aspects of the present disclosure.

(4) FIGS. 3A-3I are diagrammatic cross-sectional views of a multigate device at various fabrication stages (such as those associated with the method of FIG. 1) according to another embodiment of the present disclosure.

DETAILED DESCRIPTION

(5) The present disclosure relates generally to integrated circuit devices, and more particularly, to multigate devices, such as gate-all-around (GAA) devices.

(6) The following disclosure provides many different embodiments, or examples, for implementing different features. Reference numerals and/or letters may be repeated in the various examples described herein. This repetition is for the purpose of simplicity and clarity and does not in itself dictate a relationship between the various disclosed embodiments and/or configurations. Further, specific examples of components and arrangements are described below to simplify the present disclosure. These are, of course, merely examples and are not intended to be limiting. For example, the formation of a first feature over or on a second feature in the description that follows may include embodiments in which the first and second features are formed in direct contact, and may also include embodiments in which additional features may be formed between the first and second features, such that the first and second features may not be in direct contact. Moreover, the formation of a feature on, connected to, and/or coupled to another feature in the present disclosure may include embodiments in which the features are formed in direct contact, and may also include embodiments in which additional features may be formed interposing the features, such that the features may not be in direct contact.

(7) Further, spatially relative terms, for example, “lower,” “upper,” “horizontal,” “vertical,” “above,” “over,” “below,” “beneath,” “up,” “down,” “top,” “bottom,” etc. as well as derivatives thereof (e.g., “horizontally,” “downwardly,” “upwardly,” etc.) are used herein for ease of description to describe one element or feature's relationship to another element(s) or feature(s). The spatially relative terms are intended to encompass different orientations than as depicted of a device (or system or apparatus) including the element(s) or feature(s), including orientations associated with the device's use or operation. The apparatus may be otherwise oriented (rotated 90 degrees or at other orientations) and the spatially relative descriptors used herein may likewise be interpreted accordingly.

(8) FIG. 1 is a flow chart of a method **100** for fabricating a multigate device according to various aspects of the present disclosure. In some embodiments, method **100** fabricates a multi-gate device that includes multiple voids in the source/drain region. At block **102**, form a first semiconductor layer stack over a substrate, a second semiconductor layer stack over the substrate, and a source/drain recess between the first semiconductor layer stack and the second semiconductor layer stack. Form gate structures, including dummy gate stacks, over the first semiconductor layer stack and over the second semiconductor layer stack. The first and second semiconductor layer stacks including first semiconductor layers and second semiconductor layers stacked vertically in an alternating configuration. At block **104**, form inner spacers along sidewalls of first semiconductor layers in the first semiconductor layer stack and the second semiconductor layer stack. At block **106**, etch the second semiconductor layers in the first semiconductor layer stack and the second semiconductor layer stack to form facets having a (111) crystallographic orientation. At block **108**, form a source/drain feature having voids therein in the source/drain recess, wherein the source/drain feature is grown from the facets of the second semiconductor layers. At block **110**, replace the dummy gate stacks and the first semiconductor layers with metal gate stacks. At block **112**, form a source/drain contact opening, wherein the source/drain contact exposes at least one of the voids in the source/drain feature. At block **114**, form a silicide feature in the source/drain contact opening over the source/drain feature, wherein the silicide feature fills the exposed at least

one void. At block **116**, form a source/drain contact in the source/drain contact opening on the silicide feature.

(9) FIGS. **2A-2H** are diagrammatic cross-sectional views of a multigate device **200** at various stages of fabrication (such as those associated with method **100** in FIG. **1**) according to various aspects of the present disclosure. Multigate device **200** may be included in a microprocessor, a memory, and/or other IC device. In some embodiments, multigate device **200** is a portion of an IC chip, a system on chip (SoC), or portion thereof, that includes various passive and active microelectronic devices such as resistors, capacitors, inductors, diodes, p-type field effect transistors (PFETs), n-type field effect transistors (NFETs), metal-oxide semiconductor field effect transistors (MOSFETs), complementary metal-oxide semiconductor (CMOS) transistors, bipolar junction transistors (BJTs), laterally diffused MOS (LDMOS) transistors, high voltage transistors, high frequency transistors, other suitable components, or combinations thereof. In some embodiments, multigate device **200** is included in a non-volatile memory, such as a non-volatile random access memory (NVRAM), a flash memory, an electrically erasable programmable read only memory (EEPROM), an electrically programmable read-only memory (EPROM), other suitable memory type, or combinations thereof. FIGS. **2A-2H** have been simplified for the sake of clarity to better understand the inventive concepts of the present disclosure. Additional features can be added in multigate device **200**, and some of the features described below can be replaced, modified, or eliminated in other embodiments of multigate device **200**.

(10) Turning to FIG. **2A**, multigate device **200** includes a substrate (wafer) **202**. In the depicted embodiment, substrate **202** includes silicon. Alternatively or additionally, substrate **202** includes another elementary semiconductor, such as germanium; a compound semiconductor, such as silicon carbide, gallium arsenide, gallium phosphide, indium phosphide, indium arsenide, and/or indium antimonide; an alloy semiconductor, such as silicon germanium (SiGe), GaAsP, AlInAs, AlGaAs, GaInAs, GaInP, and/or GaInAsP; or combinations thereof. Alternatively, substrate **202** is a semiconductor-on-insulator substrate, such as a silicon-on-insulator (SOI) substrate, a silicon germanium-on-insulator (SGOI) substrate, or a germanium-on-insulator (GOI) substrate. Semiconductor-on-insulator substrates can be fabricated using separation by implantation of oxygen (SIMOX), wafer bonding, and/or other suitable methods. Substrate **202** can include various doped regions depending on design requirements of multigate device **200**.

(11) In some embodiments, a substrate extension **204** may be formed over substrate **202**. Substrate extension **204** may include silicon or another elementary semiconductor as described above with respect to substrate **202**. Substrate extension **204** and substrate **202** may be formed of the same semiconductor material. Substrate extension **204** and substrate **202** may be formed of different semiconductor material.

(12) A semiconductor layer stack **205A** and a semiconductor layer stack **205B** are disposed over respective substrate extensions **204** in channel regions C of multigate device **200**. Channel regions C are disposed between respective source/drain S/D regions of multigate device **200**.

Semiconductor layer stacks **205A**, **205B** include semiconductor layers **206** and semiconductor layers **208** stacked vertically (e.g., along the z-direction) in an interleaving or alternating configuration from a surface of substrate **202**. In some embodiments, semiconductor layers **206** and semiconductor layers **208** are epitaxially grown in the depicted interleaving and alternating configuration. For example, a first one of semiconductor layers **206** is epitaxially grown on substrate **202**, a first one of semiconductor layers **208** is epitaxially grown on the first one of semiconductor layers **206**, a second one of semiconductor layers **206** is epitaxially grown on the first one of semiconductor layers **208**, and so on until semiconductor layer stacks **205A**, **205B** have a desired number of semiconductor layers **206** and semiconductor layers **208**. In such embodiments, semiconductor layers **206** and semiconductor layers **208** can be referred to as epitaxial layers. In some embodiments, epitaxial growth of semiconductor layers **206** and semiconductor layers **208** is achieved by a molecular beam epitaxy (MBE) process, a chemical

vapor deposition (CVD) process, a metalorganic chemical vapor deposition (MOCVD) process, other suitable epitaxial growth process, or combinations thereof.

(13) A composition of semiconductor layers **206** is different than a composition of semiconductor layers **208** to achieve etching selectivity and/or different oxidation rates during subsequent processing. In some embodiments, semiconductor layers **206** have a first etch rate to an etchant and semiconductor layers **208** have a second etch rate to the etchant, where the second etch rate is less than the first etch rate. In some embodiments, semiconductor layers **206** have a first oxidation rate and semiconductor layers **208** have a second oxidation rate, where the second oxidation rate is less than the first oxidation rate. In the depicted embodiment, semiconductor layers **206** and semiconductor layers **208** include different materials, constituent atomic percentages, constituent weight percentages, thicknesses, and/or characteristics to achieve desired etching selectivity during an etching process, such as an etching process implemented to form suspended channel layers in channel regions of multigate device **200**. For example, where semiconductor layers **206** include silicon germanium and semiconductor layers **208** include silicon, a silicon etch rate of semiconductor layers **208** is less than a silicon germanium etch rate of semiconductor layers **206**. In some embodiments, semiconductor layers **206** and semiconductor layers **208** can include the same material but with different constituent atomic percentages to achieve the etching selectivity and/or different oxidation rates. For example, semiconductor layers **206** and semiconductor layers **208** can include silicon germanium, where semiconductor layers **206** have a first silicon atomic percent and/or a first germanium atomic percent and semiconductor layers **208** have a second, different silicon atomic percent and/or a second, different germanium atomic percent. The present disclosure contemplates that semiconductor layers **206** and semiconductor layers **208** include any combination of semiconductor materials that can provide desired etching selectivity, desired oxidation rate differences, and/or desired performance characteristics (e.g., materials that maximize current flow), including any of the semiconductor materials disclosed herein.

(14) As described further below, semiconductor layers **208** or portions thereof form channel regions of multigate device **200**. In the depicted embodiment, semiconductor layer stack **205** includes three semiconductor layers **206** and three semiconductor layers **208** configured to form three semiconductor layer pairs disposed over substrate **202**, each semiconductor layer pair having a respective semiconductor layer **206** and a respective semiconductor layer **208**. After undergoing subsequent processing, such configuration will result in multigate device **200** having three channels. However, the present disclosure contemplates embodiments where semiconductor layer stack **205** includes more or less semiconductor layers, for example, depending on a number of channels desired for multigate device **200** (e.g., a GAA transistor) and/or design requirements of multigate device **200**. For example, semiconductor layer stack **205** can include two to ten semiconductor layers **206** and two to ten semiconductor layers **208**.

(15) Gate structures **210A**, **210B** are disposed over semiconductor layer stacks **205A**, **205B**, respectively. In some embodiments, gate structures **210A**, **210B** extend substantially parallel to one another along an x-direction, having a length defined in the x-direction, a width defined in a y-direction, and a height defined in a z-direction. In such embodiments, in the Y-Z plane, gate structures **210A**, **210B** are disposed over top surfaces of respective channel regions C of multigate device **200**, such that gate structures **210A**, **210B** interpose respective source/drain regions S/D, such as depicted in FIG. 2A. In furtherance of such embodiments, in the X-Z plane, gate structures **210A**, **210B** wrap top surfaces and sidewall surfaces of semiconductor layer stacks **205A**, **205B** and, in some embodiments, sidewall surfaces of substrate extensions **204**. Each of gate structures **210A**, **210B** includes a dummy gate stack **212** and gate spacers **214**. Dummy gate stacks **212** include a dummy gate electrode, and in some embodiments, a dummy gate dielectric. The dummy gate electrode includes a suitable dummy gate material, such as a polysilicon layer. In embodiments where dummy gate stacks **212** include a dummy gate dielectric disposed between the dummy gate electrode and semiconductor layer stacks **205A**, **205B**, the dummy gate dielectric includes a

dielectric material, such as silicon oxide, a high-k dielectric material, other suitable dielectric material, or combinations thereof. Examples of high-k dielectric material include HfO₂, HfSiO, HfSiON, HfTaO, HfTiO, HfZrO, zirconium oxide, aluminum oxide, hafnium dioxide-alumina (HfO₂-Al₂O₃) alloy, other suitable high-k dielectric materials, or combinations thereof. In some embodiments, the dummy gate dielectric includes an interfacial layer (including, for example, silicon oxide) disposed over semiconductor layer stacks **205A**, **205B** and a high-k dielectric layer disposed over the interfacial layer. Dummy gate stacks **212** can include numerous other layers, for example, capping layers, interface layers, diffusion layers, barrier layers, hard mask layers, or combinations thereof. For example, dummy gate stacks **212** can further include a hard mask layer disposed over the dummy gate electrode.

(16) Gate spacers **214** are disposed adjacent to (i.e., along sidewalls of) respective dummy gate stacks **212**. Gate spacers **212** are formed by any suitable process and include a dielectric material. The dielectric material can include silicon, oxygen, carbon, nitrogen, other suitable material, or combinations thereof (e.g., silicon oxide, silicon nitride, silicon oxynitride (SiON), silicon carbide, silicon carbon nitride (SiCN), silicon oxycarbide (SiOC), silicon oxycarbon nitride (SiOCN)). For example, a dielectric layer including silicon and nitrogen, such as a silicon nitride layer, can be deposited over dummy gate stacks **212** and subsequently etched (e.g., anisotropically etched) to form gate spacers **214**. In some embodiments, gate spacers **214** include a multi-layer structure, such as a first dielectric layer that includes silicon nitride and a second dielectric layer that includes silicon oxide. In some embodiments, more than one set of spacers, such as seal spacers, offset spacers, sacrificial spacers, dummy spacers, and/or main spacers, are formed adjacent to dummy gate stacks **212**. In such implementations, the various sets of spacers can include materials having different etch rates. For example, a first dielectric layer including silicon and oxygen (e.g., silicon oxide) can be deposited and etched to form a first spacer set adjacent to dummy gate stacks **212**, and a second dielectric layer including silicon and nitrogen (e.g., silicon nitride) can be deposited and etched to form a second spacer set adjacent to the first spacer set.

(17) At the stage of processing in FIG. 2A, source/drain recesses **215** have been formed in source/drain regions S/D of multigate device **200**, for example, by an etching process. Gate structures **210A**, **210B** are thus disposed between respective source/drain recesses **215**. In the depicted embodiment, source/drain recesses **215** are formed by an etching process that completely removes a portion of semiconductor layers **206** and semiconductor layers **208** in source/drain regions S/D of multigate device **200** and partially removes a portion of substrate **202** in source/drain regions S/D of multigate device **200**, thereby forming semiconductor layer stacks **205A**, **205B** and substrate extensions **204** in the channel regions C of multigate device **200**. After the source/drain etching process, source/drain recesses **215** have sidewalls defined by remaining portions of semiconductor layers **206** and semiconductor layers **208** in channel regions C (i.e., semiconductor layer stacks **205A**, **205B**) and bottoms defined by substrate **202**. In some embodiments, the etching process removes some, but not all, of the portion of semiconductor layers **206** and semiconductor layers **208** in source/drain regions S/D, such that source/drain recesses **215** have a bottom defined by one of semiconductor layers **206** or semiconductor layers **208**. In some embodiments, the etching process further removes some, but not all, of substrate **202**, such that source/drain recesses **215** extend below a topmost surface of substrate **202**. The etching process can include a dry etching process, a wet etching process, other suitable etching process, or combinations thereof. In some embodiments, the etching process is a multi-step etch process. For example, the etching process may alternate etchants to separately and alternately remove semiconductor layers **206** and semiconductor layers **208**. In some embodiments, parameters of the etching process are configured to selectively etch semiconductor layers **206** and semiconductor layers **208** with minimal (to no) etching of dummy gate stacks **212** and gate spacers **214**. In some embodiments, a lithography process, such as those described herein, is performed to form a patterned mask layer that covers dummy gate stacks **212** and gate spacers **214** and the etching

process uses the patterned mask layer as an etch mask.

(18) After forming source/drain recesses **215**, the present disclosure proposes using a facet etch process to configure surfaces of semiconductor layers **208** in a manner that enhances subsequent semiconductor growth, such as epitaxial semiconductor growth, from semiconductor layers **208** when forming epitaxial source/drain features. For example, the facet etch process is tuned to minimally etch semiconductor layers **208** to achieve facets of semiconductor layers **208** in source/drain recesses **215** that promote epitaxial growth that will merge in portions of source/drain recesses **215** without merging in other portions of source/drain recesses **215**, such that voids can be formed in epitaxial source/drain features. In the depicted embodiment, after the facet etch process, semiconductor layers **208** of semiconductor layer stack **205A** have facets **218A** and facets **218B**, and semiconductor layers **208** of semiconductor layer stack **205B** have facets **218C** and facets **218D**. Each of facets **218A-218D** have a (111) crystallographic orientation, which facilitates subsequent growth of epitaxial source/drain features in a manner as described herein. An angle $\alpha 1$ is between facets **218A** and facets **218B**, and an angle $\alpha 2$ is between facets **218C** and facets **218D**. In some embodiments, angle $\alpha 1$ and angle $\alpha 2$ are about 90° to about 130°. In some embodiments, semiconductor layers **208** of semiconductor layer stacks **205A**, **205B** may begin with three facets, such as a first facet having a (100) crystallographic orientation, a second facet having a (110) crystallographic orientation, and a third facet having a (100) crystallographic orientation, where the second facet extends from the first facet to the third facet. In such embodiments, the facet etch process is controlled to remove portions of semiconductor layers **208** and achieve facets **218A-218D** having the (111) crystallographic orientation. Various etch parameters can be tuned to achieve the desired facet etching of semiconductor layers **208**, such as etch gas composition, carrier gas composition, etch gas flow rate, carrier gas flow rate, etch time, etch pressure, etch temperature, source power, radio frequency (RF) and/or direct current (DC) bias voltage, RF and/or DC bias power, other suitable etch parameters, or combinations thereof. In some embodiments, a wet etching process is performed that uses one or more wet etch chemicals such as ozone (O₃), SCA (H₂O₂ based), ammonium hydroxide (NH₄OH), tetramethylammonium hydroxide (TMAH), or other suitable wet etch chemical, to selectively etch the semiconductor layers **208** to expose facets **218A-218D** having the (111) crystallographic orientation.

(19) After forming facets **218A-218D**, inner spacers **216** are formed along sidewalls of semiconductor layers **206** of semiconductor layer stacks **205A**, **205B** by an inner spacer deposition and etch process. For example, a first etching process is performed that selectively etches semiconductor layers **206** exposed by source/drain recesses **215** with minimal (to no) etching of semiconductor layers **208**, such that gaps are formed between semiconductor layers **208** and between semiconductor layers **208** and substrate **202** under gate spacers **214**. Portions (edges) of semiconductor layers **208** are thus suspended under gate spacers **214**. In some embodiments, the gaps extend partially under dummy gate stacks **212**. The first etching process is configured to laterally etch (e.g., along the y-direction) semiconductor layers **206**, thereby reducing a length of semiconductor layers **206** along the y-direction. The first etching process is a dry etching process, a wet etching process, other suitable etching process, or combinations thereof. A deposition process then forms a spacer layer over dummy gate stacks **212**, gate spacers **214**, and over features defining source/drain recesses **215** (e.g., semiconductor layers **208**, semiconductor layers **206**, and substrate **202**), such as CVD, PVD, ALD, HDPCVD, MOCVD, RPCVD, PECVD, LPCVD, ALCVD, APCVD, plating, other suitable methods, or combinations thereof. The spacer layer partially (and, in some embodiments, completely) fills the source/drain recesses **215**. The deposition process is configured to ensure that the spacer layer fills the gaps between semiconductor layers **208** and between semiconductor layers **208** and substrate **202** under gate spacers **214**. A second etching process is then performed that selectively etches the spacer layer to form inner spacers **210** as depicted in FIG. 2A with minimal (to no) etching of semiconductor layers **208**, dummy gate stacks **212**, and gate spacers **214**. In some embodiments, the spacer layer is removed from sidewalls of

gate spacers **214**, sidewalls of semiconductor layers **208**, dummy gate stacks **212**, and substrate **202**. The spacer layer (and thus inner spacers **216**) includes a material that is different than a material of semiconductor layers **208** and a material of gate spacers **214** to achieve desired etching selectivity during the second etching process. In some embodiments, the spacer layer includes a dielectric material that includes silicon, oxygen, carbon, nitrogen, other suitable material, or combinations thereof (for example, silicon oxide, silicon nitride, silicon oxynitride, silicon carbide, or silicon oxycarbonitride). In some embodiments, the spacer layer includes a low-k dielectric material, such as those described herein. In some embodiments, dopants (for example, p-type dopants, n-type dopants, or combinations thereof) are introduced into the dielectric material, such that spacer layer includes a doped dielectric material.

(20) Turning to FIGS. **2B-2E**, processing proceeds with forming epitaxial source/drain features in source/drain recesses **215**. As described below, the epitaxial source/drain features have characteristics that improve/enhance contact formation and improve performance of multigate device **200**. For example, referring to FIGS. **2B-2D**, a first epitaxial layer **220** is formed in source/drain recesses **215**. First epitaxial layer **220** partially fills source/drain recesses **215**. For example, a semiconductor material is epitaxially grown from portions of substrate **202** and semiconductor layers **208** exposed by source/drain recesses **215**, forming first epitaxial layer **220** in source/drain recesses **215**. An epitaxy process can use CVD deposition techniques (for example, VPE and/or UHV-CVD), molecular beam epitaxy, other suitable epitaxial growth processes, or combinations thereof. The epitaxy process can use gaseous and/or liquid precursors, which interact with the composition of substrate **202** and/or semiconductor layers **208**. First epitaxial layer **220** may be doped with n-type dopants and/or p-type dopants. In some embodiments, for n-type GAA transistors, first epitaxial layer **220** includes silicon. In such embodiments, first epitaxial layer **220** can be doped with carbon, phosphorous, arsenic, other n-type dopant, or combinations thereof (for example, forming Si:C epitaxial source/drain features, Si:P epitaxial source/drain features, or Si:C:P epitaxial source/drain features). In some embodiments, for p-type GAA transistors, first epitaxial layer **220** includes silicon germanium or germanium. In such embodiments, first epitaxial layer **220** can be doped with boron, other p-type dopant, or combinations thereof (for example, forming Si:Ge:B epitaxial source/drain features). In some embodiments, first epitaxial layer **220** includes more than one epitaxial semiconductor layer, where the epitaxial semiconductor layers can include the same or different materials and/or dopant concentrations. In some embodiments, first epitaxial layer **220** includes materials and/or dopants that achieve desired tensile stress and/or compressive stress in channel regions. In some embodiments, first epitaxial layer **220** is doped during deposition by adding impurities to a source material of the epitaxy process (i.e., in-situ). In some embodiments, first epitaxial layer **220** is doped by an ion implantation process subsequent to a deposition process. In some embodiments, annealing processes (e.g., rapid thermal annealing (RTA) and/or laser annealing) are performed to activate dopants in first epitaxial layer **220** and/or other source/drain regions (for example, heavily doped source/drain regions and/or lightly doped source/drain (LDD) regions). In some embodiments, first epitaxial layer **220** is formed in separate processing sequences, for example, each of FIGS. **2B-2D** may depict a separate step in the epitaxy process. In other embodiments, first epitaxial layer **220** is formed in a single process, for example FIGS. **2B-2D** may collectively depict the epitaxy process when configured as one-step.

(21) Turning to FIG. **2B**, first epitaxial layer **220** is formed on semiconductor layers **208** (in particular, on (111) facets **218A-218D** of semiconductor layers **208**) and on substrate **202** in source/drain recesses **215**. In some embodiments, the epitaxy process is performed until first epitaxial layer **220** covers exposed surfaces of semiconductor layers **208** and substrate **202** in source/drain recesses **215**. In the depicted embodiment, first epitaxial layer **220** includes separate portions that are not connected (or merged) to one another. For example, since first epitaxial layer **220** is not formed on inner spacers **216**, portions of first epitaxial layer **220** disposed on adjacent semiconductor layers **208** are not connected to one another and portions of first epitaxial layer **220**

formed on substrate **202** are not connected to portions of first epitaxial layer **220** formed on semiconductor layers **208**. In some embodiments, first epitaxial layer **220** has a first thickness t_1 on facets **218A-218D**. In FIG. **2B**, the source/drain recesses **215** are now defined by first epitaxial layer **220** and inner spacers **216**.

(22) Turning to FIG. **2C**, first epitaxial layer **220** formation continues in the source/drain recesses **215**, such that the portions of first epitaxial layer **220** merge into a continuous layer in source/drain recesses **215**. In some embodiments, first epitaxial layer **220** has a thickness t_2 that is greater than thickness t_1 . In some embodiments, first epitaxial layer **220** may be formed to thickness t_2 as part of the same process used to form first epitaxial layer **220** to thickness t_1 . In some embodiments, first epitaxial layer **220** may be formed to thickness t_2 in a separate process than used to form first epitaxial layer **220** to thickness t_1 . The source/drain recesses **215** are now defined solely by the first epitaxial layer **220**.

(23) Turning to FIG. **2D**, first epitaxial layer **220** formation continues in the source/drain recesses **215**. In some embodiments, the first epitaxial layer **220** has a thickness t_3 that is greater than thickness t_2 . In some embodiments, thickness t_3 is about 2 nm to about 10 nm. In some embodiments, first epitaxial layer **220** may be formed to thickness t_3 in the same process used to form first epitaxial layer **220** to thickness t_2 . In some embodiments, first epitaxial layer **220** may be formed to thickness t_3 in a separate process than used to form first epitaxial layer **220** to thickness t_2 . First epitaxial layer **220** has facets **222A**, facets **222B**, facets **222C**, facets **222D**, facets **224A**, and facets **224B**. In the depicted embodiment, facets **222A-222D** of first epitaxial layer **220** have a (111) crystallographic orientation and facets **224A-224B** of first epitaxial layer **220** have a (100) crystallographic orientation. Facets **222A** and facets **222D** extend along a first direction, and facets **222B** and facets **222C** extend along a second direction that is different than the first direction. In some embodiments, facets **222A** and facets **222D** are substantially parallel to one another, and facets **222B** and facets **222C** are substantially parallel to one another. Facets **222A** and facets **222C** are separated by a distance D_1 , and facets **222B** and facets **222D** are separated by a distance D_2 . Distance D_1 increases along a direction perpendicular to a top surface of substrate **202** (for example, the z -direction). Distance D_2 decreases along the direction perpendicular to the top surface of substrate **202**. An angle α_3 is between facets **222A** and facets **222B**, and an angle α_4 is between facets **222C** and facets **222D**. In some embodiments, angle α_3 and angle α_4 are about 90° to about 130° . In the depicted embodiment, facets **222A-222D** of first epitaxial layer **220** define a void portion **226A**, a void portion **226B**, and a void portion **226C** of source/drain recesses **215**. For example, each of void portions **226A-226C** is defined by a respective one of facets **222A**, a respective one of facets **222B**, a respective one of facets **222C**, and a respective one of facets **222D**. In some embodiments, void portions **226A-226C** have a diamond-like shape. Facets **224A**, **224B** of first epitaxial layer **220** are disposed between facets **222A-222D** and void portions **226A-226C**. For example, facets **224A** extend from facets **222B** to facets **222A** and facets **224B** extend from facets **222D** to facets **222C**. Facets **224A** and facets **224B** are separated by a distance D_3 , which is less than distance D_1 and distance D_2 . In the depicted embodiment, facets **222A-222D** and facets **224A**, **224B** of first epitaxial layer **220** define three void portions **226A-226C** of source/drain recesses **215**, though the present disclosure contemplates embodiments where more or less void portions are defined by first epitaxial layer **220**. The epitaxy process of first epitaxial layer **220** is tuned to ensure that distance D_3 is sufficiently small compared to distance D_2 and distance D_1 to achieve merging of a subsequently formed epitaxial layer between facets **224A**, **224B** before filling void portions **226A-226C**. For example, a growth rate and/or growth time of a first epitaxial material of first epitaxial layer **220** can be controlled to achieve desired distance D_3 , distance D_1 , and/or distance D_2 . In some embodiments, various parameters of the epitaxy process, such as time, temperature, and pressure may be tuned to achieve the desired distances D_1 , D_2 , and D_3 . Source/drain recesses **215** are now defined by first epitaxial layer **220**.

(24) Turning to FIG. **2E**, second epitaxial layer **230** is formed on first epitaxial layer **220** in

source/drain recesses **215**. Second epitaxial layer **230** fills a remainder of source/drain recesses **215** and, in the depicted embodiment, overfills source/drain recesses **215**, such that a portion of second epitaxial layer **230** is disposed between gate structures **210A**, **210B**. Second epitaxial layer **230** and first epitaxial layer **220** collectively form epitaxial source/drain features **232** of multigate device **200**. An epitaxy process can use CVD deposition techniques (for example, VPE and/or UHV-CVD), molecular beam epitaxy, other suitable epitaxial growth processes, or combinations thereof. The epitaxy process can use gaseous and/or liquid precursors, which interact with the composition of first epitaxial layer **220**. Second epitaxial layer **230** may be doped with n-type dopants and/or p-type dopants. In some embodiments, for n-type GAA transistors, second epitaxial layer **230** includes silicon. In such embodiments, second epitaxial layer **230** can be doped with carbon, phosphorous, arsenic, other n-type dopant, or combinations thereof (for example, forming Si:C epitaxial source/drain features, Si:P epitaxial source/drain features, or Si:C:P epitaxial source/drain features). In some embodiments, for p-type GAA transistors, second epitaxial layer **230** includes silicon germanium or germanium. In such embodiments, second epitaxial layer **230** can be doped with boron, other p-type dopant, or combinations thereof (for example, forming Si:Ge:B epitaxial source/drain features). In some embodiments, second epitaxial layer **230** includes more than one epitaxial semiconductor layer, where the epitaxial semiconductor layers can include the same or different materials and/or dopant concentrations. In some embodiments, second epitaxial layer **230** includes materials and/or dopants that achieve desired tensile stress and/or compressive stress in channel regions. In some embodiments, second epitaxial layer **230** is doped during deposition by adding impurities to a source material of the epitaxy process (i.e., in-situ). In some embodiments, second epitaxial layer **230** is doped by an ion implantation process subsequent to a deposition process. In some embodiments, annealing processes (e.g., rapid thermal annealing (RTA) and/or laser annealing) are performed to activate dopants in second epitaxial layer **230** and/or other source/drain regions (for example, heavily doped source/drain regions and/or lightly doped source/drain (LDD) regions).

(25) In some embodiments, second epitaxial layer **230** is formed of the same material as the first epitaxial layer **220**. In some embodiments, second epitaxial layer **230** is formed of a different material than first epitaxial layer **220**. In some embodiments, a doping concentration of a dopant in second epitaxial layer **230** is different (for example, greater or less) than a doping concentration of the dopant in first epitaxial layer **220**. During the epitaxy process, because distance **D3** is less than distance **D1** and distance **D2**, second epitaxial layer **230** merges between facets **224A** and facets **224B** of first epitaxial layer **220** before completely filling void portions **226A-226C** of source/drain recesses **215**, thereby forming void **226A'**, void **226B'**, and **226C'** in second epitaxial layer **230**. The epitaxy process of first epitaxial layer **220** is tuned to ensure that distance **D3** between facets **224A**, **224B** is sufficiently small compared to distance **D2** and distance **D1** so that second epitaxial layer **230** merges between facets **224A**, **224B** before filling void portions **226A-226C**. Voids **226A'-226C'** (also referred to as air gaps) are a remainder of void portions **226A-226C** that are not filled by second epitaxial layer **230** and are separated by merged portions of second epitaxial layer **230**. In the depicted embodiment, each of voids **226A'-226C'** is defined between a respective pair of inner spacers **216** and semiconductor layers **206**, while each of the merged portions of second epitaxial layer **230** is defined between a respective pair of semiconductor layers **208**. Voids **226A'-226C'** have any suitable shape depending on desired silicide formation, as described further below, and voids **226A'-226C'** can have the same shape/profile or different shapes/profiles. In the depicted embodiment, void **226A'** is oval-shaped while void **226B'** and void **226C'** are diamond-shaped. In some embodiments, voids **226A'-226C'** are all diamond-shaped. In some embodiments, voids **226A'-226C'** are all oval-shaped. The present disclosure contemplates various shapes for voids **226A'-226C'**. In some embodiments, a vertical spacing **D4** between adjacent voids is about 5 nm to about 10 nm.

(26) Turning to FIG. 2F, an inter-level dielectric (ILD) layer **234** is formed over epitaxial

source/drain features **232** (in particular, second epitaxial layer **230**), dummy gates **212**, and gate spacers **214**, for example, by a deposition process (such as CVD, PVD, ALD, HDPCVD, MOCVD, RPCVD, PECVD, LPCVD, ALCVD, APCVD, plating, other suitable methods, or combinations thereof). In some embodiments, ILD layer **234** is formed by a flowable CVD (FCVD) process that includes, for example, depositing a flowable material (such as a liquid compound) over multigate device **200** and converting the flowable material to a solid material by a suitable technique, such as thermal annealing and/or ultraviolet radiation treating. ILD layer **234** includes a dielectric material including, for example, silicon oxide, silicon nitride, silicon oxynitride, TEOS formed oxide, PSG, BPSG, low-k dielectric material, other suitable dielectric material, or combinations thereof.

Exemplary low-k dielectric materials include FSG, carbon doped silicon oxide, Black Diamond® (Applied Materials of Santa Clara, California), Xerogel, Aerogel, amorphous fluorinated carbon, Parylene, BCB, SiLK (Dow Chemical, Midland, Michigan), polyimide, other low-k dielectric material, or combinations thereof. In the depicted embodiment, ILD layer **234** is a dielectric layer that includes a low-k dielectric material (generally referred to as a low-k dielectric layer). ILD layer **234** can include a multilayer structure having multiple dielectric materials. In some embodiments, a contact etch stop layer (CESL) is disposed between ILD layer **234** and second epitaxial layer **230** and between ILD layer **234** and gate spacers **214**. The CESL includes a material different than ILD layer **234**, such as a dielectric material that is different than the dielectric material of ILD layer **234**. For example, where ILD layer **234** includes a low-k dielectric material, the CESL includes silicon and nitrogen, such as silicon nitride or silicon oxynitride. Subsequent to the deposition of ILD layer **234** and/or the CESL, a CMP process and/or other planarization process can be performed until reaching (exposing) a top portion (or top surface) of dummy gate stacks **214**. In some embodiments, the planarization process removes hard mask layers to expose underlying dummy gate electrodes of dummy gate stacks **214**, such as polysilicon gate electrode layers.

(27) ILD layer **234** may be a portion of a multilayer interconnect (MLI) feature disposed over substrate **202**. The MLI feature electrically couples various devices (for example, p-type GAA transistors and/or n-type GAA transistors of multigate device **200**, transistors, resistors, capacitors, and/or inductors) and/or components (for example, gate structures and/or epitaxial source/drain features of multigate device **200**), such that the various devices and/or components can operate as specified by design requirements of multigate device **200**. The MLI feature includes a combination of dielectric layers and electrically conductive layers (e.g., metal layers) configured to form various interconnect structures. The conductive layers are configured to form vertical interconnect features, such as device-level contacts and/or vias, and/or horizontal interconnect features, such as conductive lines. Vertical interconnect features typically connect horizontal interconnect features in different layers (or different planes) of the MLI feature. During operation, the interconnect features are configured to route signals between the devices and/or the components of multigate device **200** and/or distribute signals (for example, clock signals, voltage signals, and/or ground signals) to the devices and/or the components of multigate device **200**.

(28) Continuing with FIG. 2F, dummy gate stacks **212** are removed to form gate trenches that expose semiconductor layer stacks **205A**, **205B** in channel regions C of multigate device **200**. In some embodiments, an etching process completely removes dummy gate stacks **212** to expose semiconductor layers **206** and semiconductor layers **208** of semiconductor layer stacks **205A**, **205B**. The etching process is a dry etching process, a wet etching process, other suitable etching process, or combinations thereof. In some embodiments, the etching process is a multi-step etch process. For example, the etching process may alternate etchants to separately remove various layers of dummy gate stacks **212**, such as the dummy gate electrode layers, the dummy gate dielectric layers, and/or the hard mask layers. In some embodiments, the etching process is configured to selectively etch dummy gate stacks **212** with minimal (to no) etching of other features of multigate device **200**, such as ILD layer **234**, gate spacers **214**, semiconductor layers **206**, and semiconductor layers **208**. In some embodiments, a lithography process, such as those

described herein, is performed to form a patterned mask layer that covers ILD layer **234** and/or gate spacers **214**, and the etching process uses the patterned mask layer as an etch mask.

(29) Continuing with FIG. **2F**, semiconductor layers **206** exposed by the gate trenches are then selectively removed from the channel regions C of multigate device **200**, thereby leaving suspended, channel layers **208'**. In the depicted embodiment, removing semiconductor layers **206** provides three channel layers **208'** through which current will flow between respective epitaxial source/drain features during operation of multigate device **200**. In some embodiments, this process may be referred to as a channel nanowire release process, where each channel layer **208'** has nanometer-sized dimensions and can be referred to as a nanowire. "Nanowire" generally refers to a channel layer suspended in a manner that will allow a metal gate to physically contact at least two sides of the channel layer, and in GAA transistors, will allow the metal gate to physically contact at least four sides of the channel layer (i.e., surround the channel layer). In such embodiments, a vertical stack of suspended channel layers can be referred to as a nanostructure. In some embodiments, after removing semiconductor layers **206**, an etching process is performed to modify a profile of channel layers **208'** to achieve desired dimensions and/or desired shapes (e.g., cylindrical-shaped (e.g., nanowire), rectangular-shaped (e.g., nanobar), sheet-shaped (e.g., nanosheet), etc.). The present disclosure further contemplates embodiments where the channel layers **208'** (nanowires) have sub-nanometer dimensions depending on design requirements of multigate device **200**.

(30) In some embodiments, an etching process selectively etches semiconductor layers **206** with minimal (to no) etching of semiconductor layers **208** and, in some embodiments, minimal (to no) etching of gate spacers **214** and/or inner spacers **216**. Various etching parameters can be tuned to achieve selective etching of semiconductor layers **206**, such as etchant composition, etching temperature, etching solution concentration, etching time, etching pressure, source power, RF bias voltage, RF bias power, etchant flow rate, other suitable etching parameters, or combinations thereof. For example, an etchant is selected for the etching process that etches the material of semiconductor layers **206** (e.g., silicon germanium) at a higher rate than the material of semiconductor layers **208** (e.g., silicon) (i.e., the etchant has a high etch selectivity with respect to the material of semiconductor layers **206**). The etching process is a dry etching process, a wet etching process, other suitable etching process, or combinations thereof. In some embodiments, a dry etching process (such as an RIE process) utilizes a fluorine-containing gas (for example, SF₆) to selectively etch semiconductor layers **206**. In some embodiments, a ratio of the fluorine-containing gas to an oxygen-containing gas (for example, O₂), an etching temperature, and/or an RF power may be tuned to selectively etch silicon germanium or silicon. In some embodiments, a wet etching process utilizes an etching solution that includes ammonium hydroxide (NH₄OH) and water (H₂O) to selectively etch semiconductor layers **206**. In some embodiments, a chemical vapor phase etching process using hydrochloric acid (HCl) selectively etches semiconductor layers **206**.

(31) Metal gate stacks, which include a gate dielectric **236** (for example, a gate dielectric layer) and a gate electrode **238** (for example, a work function layer and a bulk conductive layer), are then formed in the gate trenches. In FIG. **2F**, metal gate stacks wrap (surround) channel layers **208'**, where gate dielectric **236** is disposed between gate electrode **238** and channel layers **208'**. Metal gate stacks may include numerous other layers, for example, capping layers, interface layers, diffusion layers, barrier layers, hard mask layers, or combinations thereof. In the depicted embodiment, gate dielectric **236** includes a high-k dielectric layer, which includes a high-k dielectric material, such as HfO₂, HfSiO, HfSiO₄, HfSiON, HfLaO, HfMO, HfTiO, HfZrO, HfAlO_x, ZrO, ZrO₂, ZrSiO₂, AlO, AlSiO, Al₂O₃, TiO, TiO₂, LaO, LaSiO, Ta₂O₃, Ta₂O₅, Y₂O₃, SrTiO₃, BaZrO, BaTiO₃ (BTO), (Ba,Sr)TiO₃ (BST), Si₃N₄, hafnium dioxide-alumina (HfO₂—Al₂O₃) alloy, other suitable high-k dielectric material, or combinations thereof. High-k

dielectric material generally refers to dielectric materials having a high dielectric constant, for example, greater than that of silicon oxide ($k \approx 3.9$). The high-k dielectric layer is formed by any of the processes described herein, such as ALD, CVD, PVD, oxidation-based deposition process, other suitable process, or combinations thereof. In some embodiments, gate dielectric **236** includes an interfacial layer disposed between the high-k dielectric layer and channel layers **208'**.

(32) Gate electrode **238** includes a conductive material, such as polysilicon, Al, Cu, Ti, Ta, W, Mo, Co, TaN, NiSi, CoSi, TiN, WN, TiAl, TiAlN, TaCN, TaC, TaSiN, other conductive material, or combinations thereof. In some embodiments, the work function layer is a conductive layer tuned to have a desired work function (e.g., an n-type work function or a p-type work function), and the conductive bulk layer is a conductive layer formed over the work function layer. In some embodiments, the work function layer is an n-type work function layer and includes any suitable work function material, such as Ti, Al, Ag, Mn, Zr, TiAl, TiAlC, TiAlSiC, TaC, TaCN, TaSiN, TaAl, TaAlC, TaSiAlC, TiAlN, other n-type work function material, or combinations thereof. In some embodiments, the work function layer includes a p-type work function material such as Ru, Mo, Al, TiN, TaN, WN, ZrSi.sub.2, MoSi.sub.2, TaSi.sub.2, NiSi.sub.2, WN, other suitable p-type work function materials, or combinations thereof. The bulk (or fill) conductive layer includes a suitable conductive material, such as Al, W, and/or Cu. The bulk conductive layer may additionally or collectively include polysilicon, Ti, Ta, metal alloys, other suitable materials, or combinations thereof. The work function layer and/or the conductive bulk layer are formed by any of the processes described herein, such as ALD, CVD, PVD, plating, other deposition process, or combinations thereof.

(33) Turning to FIG. 2G, a source/drain contact opening **240** is formed that exposes one of epitaxial source/drain features **232**. For example, an etching process removes a portion of ILD layer **234** to expose epitaxial source/drain feature **232** disposed between gate structure **210A** and gate structure **210B**. The etching process also partially etches epitaxial source/drain feature **232** (for example, second epitaxial layer **230** and first epitaxial layer **220**) until reaching first void **226A'**. In the depicted embodiment, the etching process is tuned to etch second epitaxial layer **230** and first epitaxial layer **220** to expose void **226A'** without exposing void **226B'** or void **226C'**. In some embodiments, the etching process is tuned to etch second epitaxial layer **230** and/or first epitaxial layer **220** to expose void **226B'** or void **226C'**. The etching process may be one of the etch processes discussed above or any other suitable etch process. The etching process may be performed as a single step or may be performed as multiple steps to etch ILD layer **234**, second epitaxial layer **230**, and first epitaxial layer **220** individually. The etching process is tuned to remove each of ILD layer **234**, second epitaxial layer **230**, and first epitaxial layer **220** with minimal (to no) etching of gate spacers **214**, gate dielectrics **236**, and gate electrodes **238**. In some embodiments, first epitaxial layer **220** has a first etch rate to an etchant and second epitaxial layer **230** has a second etch rate to the etchant, where the first etch rate is less than the second etch rate. In other embodiments, the first etch rate is the same or greater than the second etch rate.

(34) Turning to FIG. 2H, a silicide **242** is formed in the source/drain contact opening **240** and over epitaxial source/drain feature **232**. Silicide **242** fills void **226A'**. Silicide **242** includes a silicide top portion **242A** and a silicide extension **242B**. Silicide top portion **242A** is formed between the topmost channel layers **208'**. First epitaxial layer **220** is disposed along an upper portion of silicide top portion **242A** and second epitaxial layer **230** is disposed along a lower portion of silicide top portion **242A**. Silicide extension **242B** is formed below silicide top portion **242A** and between the inner spacers **216**. In the depicted embodiment, silicide extension **242B** further extends between middle channel layers **208'**. In some embodiments, a top surface of silicide **242** is lower than a bottom surface of gate spacers **214** and a top surface of the top channel layers **208'**. In some embodiments, the top surface of silicide **242** is above the top surface of the top channel layers **208'**. Referring to an enlarged portion A of silicide **242**, silicide top portion **242A** has a width w_1 and a height h_1 and silicide extension portion has a width w_2 and a height h_2 . In the depicted

embodiment, width w_1 is greater than width w_2 . In some embodiments, width w_1 is about 1 nm to about 20 nm, and width w_2 is about 1 nm to about 10 nm. In some embodiments, height h_1 is about 1 nm to about 10 nm, and height h_2 is about 1 nm to about 20 nm. In some embodiments, a sum of height h_1 and height h_2 is greater than at least a sum of a thickness of one of channel layers **208'** and one of inner spacers **216**.

(35) Silicide **242** may be formed by depositing a metal layer over first and second epitaxial layers **220**, **230** and heating multigate device **200** (for example, subjecting multigate device **200** to an annealing process) to cause constituents of first epitaxial layer **220** and/or second epitaxial layer **230** (for example, silicon and/or germanium) to react with metal constituents of the metal layer. The metal layer includes any metal constituent suitable for promoting silicide formation, such as nickel, platinum, palladium, vanadium, titanium, cobalt, tantalum, ytterbium, zirconium, other suitable metal, or combinations thereof. Silicide **242** thus includes a metal constituent and a constituent of first epitaxial layer **220** and/or second epitaxial layer **230**, such as silicon and/or germanium. In some embodiments, silicide **242** includes nickel silicide, titanium silicide, or cobalt silicide. Any un-reacted metal, such as remaining portions of the metal layer, may be selectively removed relative to silicide **242** and/or a dielectric material, for example, by an etching process.

(36) Continuing with FIG. 2H, a source/drain contact **244** is then formed on silicide **242** and fills a remainder of source/drain contact opening **240**. Source/drain contact **244** includes a contact isolation layer **246**, a contact barrier layer **248**, and a contact bulk layer **286**. In some embodiments, contact isolation layer **246** is formed on silicide **242** and on sidewalls of gate spacers **214**. In some embodiments, where source/drain contact opening **240** does not expose gate spacers **214**, ILD layer **234** is disposed between source/drain contact **244** (here, in particular, contact isolation layer **246**) and gate spacers **214**. In the depicted embodiment, contact isolation layer **246** is also disposed on exposed first epitaxial layer **220**. Contact barrier layer **248** is formed on silicide **242** and on contact isolation layer **246**. Contact bulk layer **250** is formed on contact barrier layer **248**. In the depicted embodiment, silicide **242** is disposed along a bottom of contact barrier layer **248** and sidewalls of contact barrier layer, such that silicide **242** is disposed between sidewalls of contact barrier layer **282** and epitaxial source/drain feature **232** (in particular, first epitaxial layer **220**). In some embodiments, width w_1 of silicide top portion **242A** is greater than a width of a conductive portion of source/drain contact **240** (in particular, a sum of a width of contact bulk layer **250** and a thickness of contact barrier layer **282**). In some embodiments, source/drain contact **244** is formed by performing a first deposition process to form a contact isolation material over second epitaxial layer **230** and on sidewalls of gate spacers **214**, where the contact isolation material partially fills source/drain contact opening **240**; performing a second deposition process to form a contact barrier material over the contact isolation material, where the contact barrier material partially fills source/drain contact opening **240**; and performing a third deposition process to form a contact bulk material over the contact barrier material, where the contact bulk material fills a remainder of source/drain contact opening **240**. In such embodiments, contact barrier material and contact bulk material are disposed in source/drain contact opening **240** and over the top surface of silicide **242**. The first deposition process, the second deposition process, and the third deposition process can include CVD, PVD, ALD, HDPCVD, MOCVD, RPCVD, PECVD, LPCVD, ALCVD, APCVD, PEALD, electroplating, electroless plating, other suitable deposition methods, or combinations thereof. In some embodiments, contact barrier layer **248** has a substantially uniform thickness along sidewalls of contact isolation layer **246** and along the top of silicide **242**. Contact barrier layer **248** may thus be formed by a conformal deposition process. A CMP process and/or other planarization process is performed to remove excess contact bulk material, contact barrier material, and/or contact isolation material, for example, from over the top surface of ILD layer **234** and gate structures **210A**, **210B**, resulting in source/drain contact **244** (in other words, contact isolation layer **246**, contact barrier layer **248**, and contact bulk layer **250** filling source/drain contact opening **240**).

(37) Contact barrier layer **248** includes a material that promotes adhesion between a surrounding

dielectric material (here, contact isolation layer **246**) and contact bulk layer **250**. The material of contact barrier layer **248** may further prevent diffusion of metal constituents (for example, metal atoms/ions) from source/drain contact **244** into the surrounding dielectric material. In some embodiments, contact barrier layer **248** includes titanium, titanium alloy, tantalum, tantalum alloy, cobalt, cobalt alloy, ruthenium, ruthenium alloy, molybdenum, molybdenum alloy, palladium, palladium alloy, other suitable constituent configured to promote and/or enhance adhesion between a metal material and a dielectric material and/or prevent diffusion of metal constituents from the metal material to the dielectric material, or combinations thereof. For example, contact barrier layer **248** includes tantalum, tantalum nitride, tantalum aluminum nitride, tantalum silicon nitride, tantalum carbide, titanium, titanium nitride, titanium silicon nitride, titanium aluminum nitride, titanium carbide, tungsten, tungsten nitride, tungsten carbide, molybdenum nitride, cobalt, cobalt nitride, ruthenium, palladium, or combinations thereof. In some embodiments, contact barrier layer **248** includes multiple layers. For example, contact barrier layer **248** may include a first sub-layer that includes titanium and a second sub-layer that includes titanium nitride. In another example, contact barrier layer **248** may include a first sub-layer that includes tantalum and a second sub-layer that includes tantalum nitride. Contact bulk layer **250** includes tungsten, ruthenium, cobalt, copper, aluminum, iridium, palladium, platinum, nickel, low resistivity metal constituent, alloys thereof, or combinations thereof. In the depicted embodiment, contact bulk layer **250** includes tungsten, ruthenium, and/or cobalt. In some embodiments, source/drain contact **244** does not include contact barrier layer **248** (i.e., source/drain contact **244** is a barrier-free contact), such that contact bulk layer **250** physically contacts silicide **242**, contact isolation layer **246**, and/or epitaxial source/drain feature **232** (in particular, second epitaxial layer **230**). In some embodiments, source/drain contact **244** is partially barrier-free, where contact barrier layer **248** is disposed between contact isolation layer **246** and a portion of contact bulk layer **250**. In some embodiments, contact bulk layer **250** includes multiple layers.

(38) Gate all around (GAA) devices are becoming more popular. In GAA devices, the channel layers have limited current conducting capability. This leads to adding more horizontal stacked channel layers to improve conductivity. In conventional GAA device source/drain and contact formation techniques, the silicide is typically disposed between only the topmost channel layer. As GAA devices incorporate more channel layers, the lower channel layers (for example, a middle channel layer and a bottom channel layer in a three channel GAA device) suffer from poor current to voltage potential drop due to the long conduction paths. Additionally, the lower channel layers (e.g. middle channel layer and bottom channel layer) suffer from poor fringing capacitances. Traditional solutions to these problems have included forming thicker inner spacer layers to prohibit the source/drain encroachment. However, thicker inner spacer layers require stronger etching processes which cause punch-through leakage as the source/drain is etched deeper. By contrast, the proposed source/drain and contact formation techniques do not require stronger etching processes and therefore avoid the problem of punch-through leakage. Furthermore, the proposed source/drain and contact formation techniques allow for the formation of larger silicide features. The larger silicide extends beyond the top channel layer providing an increased contact landing area. The increased contact landing area reduces the parasitic resistance between contact and epitaxial source/drain features. Another advantage of some embodiments of the proposed techniques is the formation of voids in the epitaxial source/drain feature. The presence of at least one void in the epitaxial source/drain feature reduces parasitic capacitances.

(39) FIGS. 3A-3I are diagrammatic cross-sectional views of a multigate device **300** at various stages of fabrication (such as those associated with method **100** in FIG. 1) according to various aspects of the present disclosure. Multigate device **300** may be included in a microprocessor, a memory, and/or other IC device. In some embodiments, multigate device **300** is a portion of an IC chip, a system on chip (SoC), or portion thereof, that includes various passive and active microelectronic devices such as resistors, capacitors, inductors, diodes, p-type field effect

transistors (PFETs), n-type field effect transistors (NFETs), metal-oxide semiconductor field effect transistors (MOSFETs), complementary metal-oxide semiconductor (CMOS) transistors, bipolar junction transistors (BJTs), laterally diffused MOS (LDMOS) transistors, high voltage transistors, high frequency transistors, other suitable components, or combinations thereof. In some embodiments, multigate device **300** is included in a non-volatile memory, such as a non-volatile random access memory (NVRAM), a flash memory, an electrically erasable programmable read only memory (EEPROM), an electrically programmable read-only memory (EPROM), other suitable memory type, or combinations thereof. FIGS. 3A-3I have been simplified for the sake of clarity to better understand the inventive concepts of the present disclosure. Additional features can be added in multigate device **300**, and some of the features described below can be replaced, modified, or eliminated in other embodiments of multigate device **300**.

(40) Multigate device **300** and its fabrication is similar to multigate device **200** and its fabrication in many respects. Accordingly, for clarity and simplicity, similar features in multigate device **200** in FIGS. 2A-2H and multigate device **300** in FIGS. 3A-3I are identified by the same reference numerals. Turning to FIG. 3A, multigate device **300** is initially formed in a similar manner as described above with respect to multigate device **200** illustrated in FIG. 2A. For example, in FIG. 3A, after a source/drain recess process and an inner spacer fabrication process, multigate device **300** includes substrate **202**, semiconductor layer stack **205A** disposed over a respective substrate extension **204**, and semiconductor layer stack **205B** disposed over a respective substrate extension **204**. Semiconductor layer stacks **205A**, **205B** include semiconductor layers **206** and semiconductor layers **208** stacked vertically (e.g., along the z-direction) in an interleaving or alternating configuration from a surface of substrate **202**. Gate structures **210A**, **210B** are disposed over semiconductor layer stacks **205A**, **205B**, respectively. Each of gate structures **210A**, **210B** includes a dummy gate stack **212** and gate spacers **214**. Multigate device **300** further contains source/drain recesses **215** and inner spacers **216** disposed on semiconductor layers **206** in source/drain recesses **215**.

(41) Consistent with the processing of multigate device **200**, after the inner spacer etch process performed on multigate device **300**, semiconductor layers **208** of semiconductor layer stack **205A** have facets **218A** and facets **218B**, and semiconductor layers **208** of semiconductor layer stack **205B** have facets **218C** and **218D**. Each of facets **218A-218D** have a (111) crystallographic orientation, which facilitates subsequent growth of epitaxial source/drain features in a manner as described herein. An angle $\alpha 1$ is between facets **218A** and facets **218B**, and an angle $\alpha 2$ is between facets **218C** and facets **218D**. In some embodiments, angle $\alpha 1$ and $\alpha 2$ are about 90° to about 130°.

(42) Turning to FIGS. 3B-3F, processing proceeds with forming epitaxial source/drain features in source/drain recesses **215**. As described below, the epitaxial source/drain features have characteristics to improve/enhance contact formation and improve formation of multigate device **300**. For example, referring to FIGS. 3B-3D, first epitaxial layer **220** is formed in source/drain recesses **215**. First epitaxial layer **220** partially fills source/drain recesses **215**. For example, a semiconductor material is epitaxially grown from portions of substrate **202** and semiconductor layers **208** exposed by source/drain recesses **215**, forming first epitaxial layer **220** in source/drain recesses **215**. The epitaxy process is performed in a similar manner as described above with respect to multigate device **200** illustrated in FIG. 2B-2D.

(43) Turning to FIG. 3B, first epitaxial layer **220** is formed on semiconductor layers **208** (in particular, on (111) facets **218A-218D** of semiconductor layers **208**) and on substrate **202** in source/drain recesses **215**. In some embodiments, the epitaxy process is performed until first epitaxial layer **220** covers exposed surfaces of semiconductor layers **208** and substrate **202** in source/drain recesses **215**. In the depicted embodiment, first epitaxial layer **220** includes separate portions that are not connected (or merged) to one another. For example, since first epitaxial layer **220** is not formed on inner spacers **216**, portions of first epitaxial layer **220** disposed on adjacent semiconductor layers **208** are not connected to one another and portions of first epitaxial layer **220**

formed on substrate **202** are not connected to portions of first epitaxial layer **220** formed on semiconductor layers **208**. In some embodiments, first epitaxial layer **220** has a thickness t_4 on facets **218A-218D**. In some embodiments, thickness t_4 is less than thickness t_1 of first epitaxial layer **220** of multigate device **200**. The source/drain recesses **215** are now defined by first epitaxial layer **220** and inner spacers **216**.

(44) Turning to FIG. **3C**, first epitaxial layer **220** formation continues in the source/drain recesses **215**. In some embodiments, first epitaxial layer **220** is formed to a thickness t_5 that is greater than thickness t_4 . In some embodiments, thickness t_5 is less than thickness t_2 of first epitaxial layer **220** of multigate device **200**. In some embodiments, first epitaxial layer **220** is formed to thickness t_5 as part of the same process used to form first epitaxial layer **220** to thickness t_4 . In some embodiments, first epitaxial layer **220** is formed to thickness t_5 in a separate process than used to form first epitaxial layer **220** to thickness t_4 . In the depicted embodiment, the epitaxy process is performed until first epitaxial layer **220** covers a portion of inner spacers **216** with another portion of inner spacers **216** still exposed in source/drain recesses **215**. In this embodiment, first epitaxial layer **220** includes separate portions that are not connected (or merged) to one another. The source/drain recesses **215** are now defined by first epitaxial layer **220** and the exposed portion of inner spacers **216**.

(45) Turning to FIG. **3D**, first epitaxial layer **220** formation continues in the source/drain recesses **215**. In some embodiments, first epitaxial layer **220** has a thickness t_6 that is greater than thickness t_5 . In some embodiments, thickness t_6 is less than thickness t_3 of first epitaxial layer **220** of multigate device **200**. In some embodiments, thickness t_6 is about 2 nm to about 10 nm. In some embodiments, first epitaxial layer may be formed to thickness t_6 in the same process used to form first epitaxial layer **220** to thickness t_5 . In some embodiments, first epitaxial layer **220** may be formed to thickness t_6 in a separate process than used to form first epitaxial layer **220** to thickness t_5 . First epitaxial layer **220** has facets **222A**, facets **222B**, facets **222C**, facets **222D**, facets **224A**, and facets **224B**. In the depicted embodiment, facets **222A-222D** of first epitaxial layer **220** have a (111) crystallographic orientation and facets **224A**, **224B** of first epitaxial layer **220** have a (100) crystallographic orientation. Facets **222A** and facets **222D** extend along a first direction, and facets **222B** and facets **222C** extend along a second direction that is different than the first direction. In some embodiments, facets **222A** and facets **222D** are substantially parallel to one another, and facets **222B** and facets **222C** are substantially parallel to one another. Facets **222A** and facets **222C** are separated by a distance D_5 , and facets **222B** and facets **222D** are separated by a distance D_6 . Distance D_5 increases along a direction perpendicular to a top surface of substrate **202** (for example, the z-direction). Distance D_6 decreases along the direction perpendicular to the top surface of substrate **202**. An angle α_5 is between facets **222A** and facets **222B**, and an angle α_6 is between facets **222C** and **222D**. In some embodiments, angle α_5 and angle α_6 are about 90° to about 130°. In the depicted embodiment, facets **222A-222D** of first epitaxial layer **220** define a void portion **326A**, a void portion **326B**, and a void portion **326C** of source/drain recesses **215**. For example, each of void portions **326A-326C** is defined by a respective one of facets **222A**, a respective one of facets **222B**, a respective one of facets **222C**, and a respective one of facets **222D**. In some embodiments, void portions **326A-326C** have a diamond-like shape.

(46) Facets **224A**, **224B** of first epitaxial layer **220** are disposed between facets **222A-222D** and void portions **326A-326C**. For example, facets **224A** extend from facets **222B** to facets **222A** and facets **224B** extend from facets **222D** to facets **222C**. Facets **224A** and facets **224B** are separated by a distance D_7 , which is less than distance D_5 and distance D_6 . In the depicted embodiment, facets **222A-222D** and facets **224A**, **224B** of first epitaxial layer **220** define three void portions **326A-326C** of source/drain recesses **215**, though the present disclosure contemplates embodiments where more or less void portions are defined by first epitaxial layer **220**. The epitaxy process of first epitaxial layer **220** is tuned to ensure that distance D_7 is sufficiently small compared to distance D_6 and distance D_5 to achieve merging of a subsequently formed epitaxial layer between facets **224A**,

224B before filling void portions 326A-326C. For example, a growth rate and/or growth time of a first epitaxial material of first epitaxial layer 220 can be controlled to achieve desired distance D7, distance D5, and/or distance D6. In some embodiments, various parameters of the epitaxy process, such as time, temperature, and pressure may be tuned to achieve the desired distances D5, D6, and D7. Source/drain recesses 215 are now defined by first epitaxial layer 220.

(47) Turning to FIG. 3E, second epitaxial layer 330 is formed on first epitaxial layer 220 in source/drain recesses 215. In some embodiments, second epitaxial layer 330 includes separate portions that are not connected (or merged) to one another. In the depicted embodiment, the epitaxy process is performed until second epitaxial layer 330 merges into a continuous layer over first epitaxial layer 220 in source/drain recesses 215. The epitaxy process is performed in a similar manner as described above with respect to multigate device 200 illustrated in FIG. 2E.

(48) Second epitaxial material 330 disposed over facets 222A and facets 222C are separated by a distance D8 that is less than distance D5 by about a thickness t_7 . Distance D8 increases along the direction perpendicular to the top surface of substrate 202. Second epitaxial material 330 disposed over facets 222B and facets 222D are separated by a distance D9 is less than distance D6 by about thickness t_7 . Distance D9 decreases along the direction perpendicular to the top surface of substrate 202. Second epitaxial layer 330 has facets 344A and facets 344B. In the depicted embodiment, facets 344A, 344B of second epitaxial layer 330 have a (110) crystallographic orientation. Facets 344A, 344B are disposed over facets 224A, 224B of first epitaxial layer 220 and between void portions 326A-326C. Facets 344A and facets 344B are separated by a distance D10 which is less than distance D7. The epitaxy process of second epitaxial layer 330 is tuned to ensure that distance D10 is sufficiently small compared to distance D8 and distance D9 to achieve merging of subsequently formed second epitaxial layer 330 before filling void portions 326A-326C.

Source/drain recesses 215 are now defined by second epitaxial layer 330.

(49) Turning to FIG. 3F, second epitaxial layer 330 formation continues in source/drain recesses 215 such that second epitaxial layer 330 merges between facets 344A and facets 344B before filling void portions 326A-326C. Second epitaxial layer 330 and first epitaxial layer 220 collectively form epitaxial source/drain features 332 of multigate device 300. In the depicted embodiment, second epitaxial layer 330 overfills source/drain recesses 215, such that a portion of second epitaxial layer 330 is disposed between gate structures 210A, 210B. In some embodiments, second epitaxial layer 330 is formed and merges, forming voids 326A'-326C', as part of a single process. In some embodiments, second epitaxial material 330 is formed and merges, forming voids 326A'-326C', in separate processes. Voids 326A'-326C' (also referred to as air gaps) are a remainder of void portions 326A-326C that are not filled by second epitaxial layer 330 and are separated by merged portions of second epitaxial layer 330. In the depicted embodiment, each of voids 326A'-326C' is defined between a respective pair of inner spacers 216 and semiconductor layers 206, while each of the merged portions of second epitaxial layer 330 is defined between a respective pair of semiconductor layers 208. Voids 326A'-326C' have any suitable shape depending on desired silicide formation, as described further below, and voids 326A'-326C' can have the same shape/profile or different shapes/profiles. In the depicted embodiment, voids 326A'-326C' are all oval shaped. In some embodiments, vertical spacing D11 between adjacent voids is less than about 5 nm.

(50) As shown in the depicted embodiments, voids 326A'-326C' of multigate device 300 are different than voids 226A'-226C' of multigate device 200. The differences are due to process adjustments that may be made during the formation of multigate device 200 and/or multigate device 300. For example, first epitaxial layer 220 of multigate device 200 is formed to thickness t_3 , which is larger than thickness t_6 of first epitaxial layer 220 of multigate device 300. The difference in thickness t_3 and thickness t_6 causes distances D1, D2, and D3 of multigate device 200 to be smaller than distances D5, D6, and D7 of multigate device 300. This difference in size allows for a different formation process of second epitaxial layer 230 of device 200 as compared to second

epitaxial layer **330** of device **300**. The different formation process may be used to adjust the sizes and shapes of voids **226A'-226C'** of multigate device **200** and voids **326A'-326C'** of multigate device **300**. The difference in size between distances **D1**, **D2**, and **D3** and distances **D5**, **D6**, and **D7** further cause vertical spacing **D4** to be larger than vertical spacing **D11**. Vertical spacing between voids **226A'-226C'**, **326A'-326C'** affects the strength of the source/drain feature **232**, **332** etch process required to expose voids **226A'-226C'**, **326A'-326C'** and which of voids **226A'-226C'**, **326A'-326C'** are exposed during the etch process, such as that used when forming source/drain contacts.

(51) Turning to FIG. **3G**, multigate device **300** is further formed in a similar manner as described above with respect to multigate device **200** illustrated in FIG. **2F**. For example, ILD layer **234** is formed over epitaxial source/drain features **332** (in particular, second epitaxial layer **330**), dummy gates **212**, and gate spacers **214**. Dummy gate stacks **212** are removed to form gate trenches that expose semiconductor layer stacks **2015A**, **205B** in channel regions **C** of multigate device **300**. Semiconductor layers **206** exposed by the gate trenches are then selectively removed from the channel regions **C** of multigate device **300**, thereby leaving suspended, channel layers **208'**. In the depicted embodiment, removing semiconductor layers **206** provides three channel layers **208'** through which current will flow between respective epitaxial source/drain features during operation of multigate device **300**. In some embodiments, this process may be referred to as a channel nanowire release process, where each channel layer **208'** has nanometer-sized dimensions and can be referred to as a nanowire, as described above. In some embodiments, after removing semiconductor layers **206**, an etching process is performed to modify a profile of channel layers **208'** to achieve desired dimensions and/or desired shapes (e.g., cylindrical-shaped (e.g., nanowire), rectangular-shaped (e.g., nanobar), sheet-shaped (e.g., nanosheet), etc.). The present disclosure further contemplates embodiments where the channel layers **208'** (nanowires) have sub-nanometer dimensions depending on design requirements of multigate device **300**. For example, an etching process as described above with respect to FIG. **2F** is performed.

(52) Metal gate stacks, which include gate dielectric **236** (for example, a gate dielectric layer) and gate electrode **238** (for example, a work function layer and a bulk conductive layer), are then formed in the gate trenches. In FIG. **3G**, metal gate stacks wrap (surround) channel layers **208'**, where gate dielectric **236** is disposed between gate electrode **238** and channel layers **208'**. Metal gate stacks may include numerous other layers as described above. In the depicted embodiment, gate dielectric **236** includes a high-k dielectric layer as described above. In some embodiments, gate dielectric **236** includes an interfacial layer disposed between the high-k dielectric layer and channel layers **208'**. Gate electrode **238** includes a conductive material such as those described above.

(53) Turning to FIG. **3H**, a source/drain contact opening **340** is formed that exposes one of epitaxial source/drain features **332**. For example, an etching process removes a portion of ILD layer **234** to expose epitaxial source/drain feature **332** disposed between gate structure **210A** and gate structure **210B**. The etching process also partially etches epitaxial source/drain feature **332** (for example, second epitaxial layer **330** and first epitaxial layer **220**) until reaching void **326A'**. In the depicted embodiment, the etching process is tuned to etch second epitaxial layer **330** and first epitaxial layer **220** to expose voids **326A'-326C'**, resulting in a source/drain contact opening **340** extending into epitaxial source/drain features **332**. For example, source/drain contact opening **340** extends to a depth of bottommost channel layers **208'**. In some embodiments, the etching process is tuned to etch second epitaxial layer **330** and/or first epitaxial layer **220** to expose voids **326A'**, **326B'** without exposing void **326C'**. The etching process may be one of the etch processes discussed above or any other suitable etch process. The etching process may be performed as a single step or may be performed as multiple steps to etch ILD layer **234**, second epitaxial layer **330**, and first epitaxial layer **220** individually. The etching process is tuned to remove each of ILD layer **234**, second epitaxial layer **330**, and first epitaxial layer **220** with minimal (to no) etching of gate spacers

214, gate dielectrics **236**, and gate electrodes **238**. In some embodiments, first epitaxial layer **220** has a first etch rate to an etchant and second epitaxial layer **330** has a second etch rate to the etchant, where the first etch rate is less than the second etch rate. In other embodiments, the first etch rate is the same or greater than the second etch rate.

(54) Turning to FIG. **3I**, a silicide **342** is formed in the source/drain contact opening **340** and over epitaxial source/drain feature **332**. Silicide **342** fills the extension of source/drain contact opening **340** into epitaxial source/drain feature **332** (here, formed by the combination of voids **326A'-326C'**). Silicide **342** includes a silicide top portion **342A** and a silicide extension **342B**. Silicide top portion **342A** is formed between the topmost channel layers **208'**. First epitaxial layer **220** is disposed along an upper portion of silicide top portion **342A** and second epitaxial layer **330** is disposed along a lower portion of silicide top portion **342A**. Silicide extension **342B** is formed below silicide top portion **342A** and between the inner spacers **216**. In the depicted embodiment, silicide extension **342B** further extends between middle channel layers **208'**. In some embodiments, a top surface of silicide **342** is lower than a bottom surface of gate spacers **214** and a top surface of the top channel layers **208'**. In some embodiments, the top surface of silicide **342** is above the top surface of the top channel layers **208'**. Referring to an enlarged portion B of silicide **342**, silicide top portion **342A** has a width w_3 and a height h_3 and silicide extension portion has a width w_4 and a height h_4 . In the depicted embodiment, width w_3 is greater than width w_4 . In some embodiments, width w_3 is about 1 nm to about 20 nm, and width w_4 is about 1 nm to about 20 nm. In some embodiments, height h_3 is about 1 nm to about 20 nm, and height h_4 is about 1 nm to about 70 nm. In some embodiments, a sum of height h_3 and height h_4 is greater than at least a sum of a thickness of two of channel layers **208'** and two of inner spacers **216**. Silicide **342** is formed in a similar manner as described above with respect to multigate device **200** illustrated in FIG. **2H**.

(55) Source/drain contact **244** is then formed on silicide **342** and fills a remainder of source/drain contact opening **340**. Source/drain contact **244** is formed in a similar manner as described above with respect to multigate device **200** illustrated in FIG. **2H**. For example, source/drain contact **244** includes contact isolation layer **246**, contact barrier layer **248**, and contact bulk layer **286**. In some embodiments, contact isolation layer **246** is formed on silicide **342** and on sidewalls of gate spacers **214**. In some embodiments, where source/drain contact opening **340** does not expose gate spacers **214**, ILD layer **234** is disposed between source/drain contact **244** (here, in particular, contact isolation layer **246**) and gate spacers **214**. In the depicted embodiment, contact isolation layer **246** is also disposed on exposed first epitaxial layer **220**. Contact barrier layer **248** is formed on silicide **342** and on contact isolation layer **246**. Contact bulk layer **250** is formed on contact barrier layer **248**. In the depicted embodiment, silicide **342** is disposed along a bottom of contact barrier layer **248** and sidewalls of contact barrier layer, such that silicide **342** is disposed between sidewalls of contact barrier layer **282** and epitaxial source/drain feature **332** (in particular, first epitaxial layer **220**). In some embodiments, width w_3 of silicide top portion **342A** is greater than a width of a conductive portion of source/drain contact **340** (in particular, a sum of a width of contact bulk layer **250** and a thickness of contact barrier layer **282**). In some embodiments, source/drain contact **244** is formed by performing a first deposition process to form a contact isolation material over second epitaxial layer **330** and on sidewalls of gate spacers **214**, where the contact isolation material partially fills source/drain contact opening **340**; performing a second deposition process to form a contact barrier material over the contact isolation material, where the contact barrier material partially fills source/drain contact opening **340**; and performing a third deposition process to form a contact bulk material over the contact barrier material, where the contact bulk material fills a remainder of source/drain contact opening **340**. In such embodiments, contact barrier material and contact bulk material are disposed in source/drain contact opening **340** and over the top surface of silicide **342**. The first deposition process, the second deposition process, and the third deposition process can include CVD, PVD, ALD, HDPCVD, MOCVD, RPCVD, PECVD, LPCVD, ALCVD, APCVD, PEALD, electroplating, electroless plating, other suitable deposition methods, or

combinations thereof. In some embodiments, contact barrier layer **248** has a substantially uniform thickness along sidewalls of contact isolation layer **246** and along the top of silicide **242**. Contact barrier layer **248** may thus be formed by a conformal deposition process. A CMP process and/or other planarization process is performed to remove excess contact bulk material, contact barrier material, and/or contact isolation material, for example, from over the top surface of ILD layer **234** and gate structures **210A**, **210B**, resulting in source/drain contact **244** (in other words, contact isolation layer **246**, contact barrier layer **248**, and contact bulk layer **250** filling source/drain contact opening **340**).

(56) The present disclosure provides for many different embodiments. An exemplary device includes a first channel layer disposed over a substrate and a second channel layer disposed over the first channel layer. A gate stack surrounds the first channel layer and the second channel layer. A source/drain feature is disposed adjacent to the first channel layer, the second channel layer, and the gate stack. The source/drain feature is disposed over first facets of the first channel layer and second facets of the second channel layer. The first facets and the second facets have a (111) crystallographic orientation. The device further includes inner spacers disposed between the gate stack and the source/drain feature and further disposed between the first channel layer and the second channel layer. A silicide feature is disposed over the source/drain feature. The silicide feature extends into the source/drain feature towards the substrate to a depth of the first channel layer. In some embodiments, the depth is greater than a depth of a top surface of the first channel layer. In some embodiments, the silicide feature comprises an upper portion and a lower portion where a width of the upper portion is greater than a width of the lower portion. In some embodiments, the lower portion of the silicide feature extends to the depth where the depth is greater than a depth of a bottom surface of the first channel layer. The device further includes a source/drain contact disposed over the silicide feature.

(57) In some embodiments, the source/drain feature includes a first semiconductor layer and a second semiconductor layer where the first semiconductor layer is disposed over the first facets of the first channel layer, the second facets of the second channel layer, and the inner spacer and where the second semiconductor layer is disposed over the first semiconductor layer. In some embodiments, the first semiconductor layer has third facets and fourth facets where the third facets have a (111) crystallographic orientation and the fourth facets have a (110) crystallographic orientation. In some embodiments, a void is disposed within the source/drain feature, the void being disposed between a set of the (111) facets of the first channel layer and the (111) facets of the second channel layer.

(58) An exemplary method forming a source/drain recess adjacent to a semiconductor layer stack disposed over a substrate. The semiconductor layer stack includes a first semiconductor layer disposed between a second semiconductor layer and a third semiconductor layer. The method further includes performing a deposition process and an etching process to form an inner spacer adjacent to the first semiconductor layer. The etching process is tuned to form first facets of the second semiconductor layer and second facets of the third semiconductor layer where the first facets and the second facets have a (111) crystallographic orientation. In some embodiments, the etching process tuned to form the first facets of the second semiconductor and the second facets of the third semiconductor layer is a wet etch. The method further includes epitaxially growing a source/drain feature from the first facets of the second semiconductor layer and the second facets of the third semiconductor layer where the source/drain feature fills the source/drain recess and a void is disposed in the source/drain feature at a depth of the first semiconductor layer. In some embodiments, epitaxially growing the source/drain feature comprises epitaxially growing a first epitaxial layer in the source/drain recess and epitaxially growing a second epitaxial layer on the first epitaxial layer. In some embodiments, epitaxially growing the first epitaxial layer is controlled to define a first portion of the source/drain recess between third facets of the first epitaxial layer and a second portion of the source/drain recess between fourth facets of the first epitaxial layer

where the third facets have the (111) crystallographic orientation and the fourth facets have the (110) crystallographic orientation. In some embodiments, the epitaxially growing the second epitaxial layer is controlled to achieve filling of the second portion of the source/drain recess without filling the first portion of the source/drain recess, thereby forming the void in the source/drain feature. The method further includes forming a source/drain contact opening that exposes the void in the source/drain feature after replacing the first semiconductor layer with a gate stack. The method further includes forming a source/drain contact in the source/drain contact opening where the source/drain contact includes a silicide feature that fills the void.

(59) In some embodiments, the semiconductor layer stack further includes a fourth semiconductor layer disposed between the third semiconductor layer and a fifth semiconductor layer. In some embodiments, the etching process further forms third facets of the fifth semiconductor layer where the third facets have the (111) crystallographic orientation. In some embodiments, the void is a first void, the source/drain feature further includes a second void and the fourth semiconductor layer is replaced with the gate stack. In some embodiments, the forming the source/drain contact opening does not expose the second void.

(60) In some embodiments, the semiconductor layer stack further includes a fourth semiconductor layer disposed between the third semiconductor layer and a fifth semiconductor layer. In some embodiments, the etching process further forms third facets of the fifth semiconductor layer where the third facets have the (111) crystallographic orientation. In some embodiments, the void is a first void, the source/drain feature further includes a second void, and the fourth semiconductor layer is replaced with the gate stack. In some embodiments, the forming the source/drain contact opening exposes the second void and the silicide feature fills the second void.

(61) Another exemplary device includes a first channel layer disposed over a substrate, a second channel layer disposed over the first channel layer, and a third channel layer disposed over the second channel layer. A gate stack surrounds the first channel layer, the second channel layer, and the third channel layer. The device further includes a source/drain feature disposed adjacent to the first channel layer, the second channel layer, the third channel layer, and the gate stack. The source/drain feature is disposed over first facets of the first channel layer, second facets of the second channel layer, and third facets of the third channel layer where the first facets, the second facets, and the third facets have a (111) crystallographic orientation. The device further includes, a first inner spacer and a second inner spacer disposed between the gate stack and the source/drain feature where the first inner spacer is further disposed between the first channel layer and the second channel layer and the second inner spacer is further disposed between the second channel layer and the third channel layer. A silicide feature is disposed over the source/drain feature where the silicide feature extends into the source/drain feature towards the substrate to a depth below the first channel layer. In some embodiments, the silicide feature comprises an upper portion and a lower portion where a width of the upper portion is greater than a width of the lower portion. In some embodiments, the upper portion of the silicide feature is disposed adjacent the third channel layer. In some embodiments, the lower portion of the silicide feature is disposed adjacent the first channel layer and the second channel layer. The device further includes, a source/drain contact is disposed over the silicide feature.

(62) In some embodiments, the source/drain feature includes a first semiconductor layer and a second semiconductor layer where the first semiconductor layer is disposed over the first facets of the first channel layer, the second facets of the second channel layer, the first inner spacer, and the second inner spacer, and where the second semiconductor layer is disposed over the first semiconductor layer. In some embodiments, the first semiconductor layer has third facets and fourth facets, wherein the third facets have a (111) crystallographic orientation and the fourth facets have a (110) crystallographic orientation.

(63) The foregoing outlines features of several embodiments so that those skilled in the art may better understand the aspects of the present disclosure. Those skilled in the art should appreciate

that they may readily use the present disclosure as a basis for designing or modifying other processes and structures for carrying out the same purposes and/or achieving the same advantages of the embodiments introduced herein. Those skilled in the art should also realize that such equivalent constructions do not depart from the spirit and scope of the present disclosure, and that they may make various changes, substitutions, and alterations herein without departing from the spirit and scope of the present disclosure.

Claims

1. A method comprising: forming a stack of semiconductor layers on a substrate, the stack of semiconductor layers including a first semiconductor layer, a second semiconductor layer disposed over the first semiconductor layer and a third semiconductor layer disposed over the second semiconductor layer; forming a first trench through the stack of semiconductor layers such that a portion of each of the first, second and third semiconductor layers is exposed by the first trench; forming a first epitaxial layer in the first trench; forming a second epitaxial layer on the first epitaxial layer in the first trench, wherein the second epitaxial layer defines a first void, a second void and a third void in the second epitaxial layer such that a bottom surface of the third void is disposed over a portion of the first epitaxial layer; forming a second trench through the first and second epitaxial layers to expose the first void; forming a silicide layer in the second trench; and forming a contact feature directly on the silicide layer, wherein, along a direction perpendicular to a top surface of the substrate, the first void is disposed over the second void and the second void is disposed over the third void.
2. The method of claim 1, further comprising modifying the portions of the first and third semiconductor layers to include facets having a (111) crystallographic orientation prior to forming the first epitaxial layer in the first trench, and wherein the forming of the first epitaxial layer in the first trench includes forming the first epitaxial layer directly on the facets of the first and third semiconductor layers.
3. The method claim 1, wherein the first semiconductor layer is disposed at a first height above the substrate and a portion of the first void is positioned at the first height above the substrate.
4. The method of claim 3, wherein the silicide layer extends within the second trench towards the substrate such that a portion of the silicide layer is positioned at the first height above the substrate.
5. The method of claim 1, wherein the first void, second void and third void are separated from each other by portions of the second epitaxial layer along the direction such that the first, second and third voids are not in communication with each other.
6. The method of claim 5, wherein the second void and third void are still separated from each other by portions of the second epitaxial layer such that the second and third voids are not in communication with each other after the forming of the second trench through the first and second epitaxial layer to expose the first void.
7. The method of claim 1, further comprising: removing a first portion of the second semiconductor layer prior to forming the first epitaxial layer in the first trench; and forming an inner spacer feature directly on a second portion of the second semiconductor layer, the inner spacer feature extending from the first semiconductor layer to the third semiconductor layer.
8. The method of claim 7, further comprising: removing the second portion of the second semiconductor layer to form a space between the first and third semiconductor layers prior to the forming of the second trench through the first and second epitaxial layer to expose the first void; and forming a gate structure in the space between the first and third semiconductor layers.
9. A method comprising: forming a source/drain recess adjacent to a semiconductor layer stack disposed over a substrate, wherein the semiconductor layer stack includes a first semiconductor layer disposed between a second semiconductor layer and a third semiconductor layer; performing a first etching process tuned to form first facets of the second semiconductor layer and second

facets of the third semiconductor layer, wherein the first facets and the second facets have a (111) crystallographic orientation; after forming the first facets and the second facets, performing a deposition process and a second etching process to form inner spacers adjacent to the first semiconductor layer; epitaxially growing a source/drain feature from the first facets of the second semiconductor layer and the second facets of the third semiconductor layer, wherein the source/drain feature fills the source/drain recess and a void is disposed in the source/drain feature at a depth of the first semiconductor layer; after replacing the first semiconductor layer with a gate stack, forming a source/drain contact opening that exposes the void in the source/drain feature; and forming a source/drain contact in the source/drain contact opening, wherein the source/drain contact includes a silicide feature that fills the void.

10. The method of claim 9, wherein epitaxially growing the source/drain feature comprises: epitaxially growing a first epitaxial layer in the source/drain recess; and epitaxially growing a second epitaxial layer on the first epitaxial layer.

11. The method of claim 10, wherein the epitaxially growing the first epitaxial layer is controlled to define a first portion of the source/drain recess between third facets of the first epitaxial layer and a second portion of the source/drain recess between fourth facets of the first epitaxial layer, wherein the third facets have the (111) crystallographic orientation and the fourth facets have the (110) crystallographic orientation.

12. The method of claim 11, wherein the epitaxially growing the second epitaxial layer is controlled to achieve filling of the second portion of the source/drain recess without filling the first portion of the source/drain recess, thereby forming the void in the source/drain feature.

13. The method of claim 9, wherein the first etching process is a wet etch.

14. The method of claim 9, wherein the semiconductor layer stack further includes a fourth semiconductor layer disposed between the third semiconductor layer and a fifth semiconductor layer, wherein the first etching process further forms third facets of the fifth semiconductor layer, wherein the third facets have the (111) crystallographic orientation, wherein the void is a first void, the source/drain feature further includes a second void, and the fourth semiconductor layer is replaced with the gate stack, and wherein the forming the source/drain contact opening does not expose the second void.

15. The method of claim 9, wherein the semiconductor layer stack further includes a fourth semiconductor layer disposed between the third semiconductor layer and a fifth semiconductor layer, wherein the first etching process further forms third facets of the fifth semiconductor layer, wherein the third facets have the (111) crystallographic orientation, wherein the void is a first void, the source/drain feature further includes a second void, and the fourth semiconductor layer is replaced with the gate stack, wherein the forming the source/drain contact opening exposes the second void, and wherein the silicide feature fills the second void.

16. A method comprising: forming a stack of semiconductor layer on a substrate, the stack of semiconductor layers including a first semiconductor layer, a second semiconductor layer disposed over the first semiconductor layer and a third semiconductor layer disposed over the second semiconductor layer, the first semiconductor layer extending to a first height above the substrate, the second semiconductor layer extending to a second height above the substrate and the third semiconductor layer extending to a third height above the substrate, the first, second and third heights being different from each other; forming a first trench through the stack of semiconductor layer such that a portion of each of the first, second and third semiconductor layers is exposed by the first trench; forming a first epitaxial layer in the first trench; forming a second epitaxial layer on the first epitaxial layer in the first trench, wherein the second epitaxial layer defines a first void, a second void and a third void in the second epitaxial layer after the forming of the second epitaxial layer, the first void positioned at least at the first height, the second void positioned at least at the second height and the third void positioned at least at the third height, wherein the first void, second void and third void are separated from each other by portions of the second epitaxial layer

such that the first, second and third voids are not in communication with each other after the forming of the second epitaxial layer on the first epitaxial layer in the first trench; forming a second trench through the first and second epitaxial layers to the expose the third void and the second void; forming a silicide layer in the second trench such that a first portion of the silicide layer is positioned at the second height above the substrate; and forming a contact feature on the silicide layer.

17. The method of claim 16, wherein the forming of the second trench through the first and second epitaxial layers to the expose the third void and the second void further includes the second trench exposing the first void.

18. The method of claim 17, wherein a second portion of the silicide layer is positioned at the first height above the substrate after the forming of the silicide layer in the second trench, and wherein the second portion of the silicide layer is continuous with the first portion of the silicide layer.

19. The method of claim 16, wherein the contact feature interfaces with the silicide layer and the first epitaxial layer after the forming of the contact feature on the silicide layer.

20. The method of claim 16, wherein the second epitaxial layer has a different material composition than the first epitaxial layer.
