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Semiconductor device and method for fabricating the same

Abstract

A semiconductor device may include: a plurality of first conductive lines; a plurality of second conductive lines disposed over the first conductive lines to be spaced apart from the first conductive line, a variable resistance layer disposed above the first conductive line and below the second conductive line; at least one of a first interlayer dielectric layer or a second interlayer dielectric layer; at least one of a first contact or a second contact, wherein the first selector layer is disposed in a portion of the first interlayer dielectric layer below the first contact and the second selector layer is disposed in a portion of the second dielectric layer below the second contact, wherein the first selector layer includes a dielectric material of the first interlayer dielectric layer and a dopant, and the second selector layer includes a dielectric material of the second interlayer dielectric layer and a dopant.

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Background/Summary

PRIORITY CLAIM AND CROSS-REFERENCE TO RELATED APPLICATION

(1) This patent document claims the priority and benefits of Korean Patent Application No. 10-2021-0145480 filed on Oct. 28, 2021, which is incorporated herein by reference in its entirety.

TECHNICAL FIELD

(2) This patent document relates to memory circuits or devices and their applications in electronic

devices or systems.

BACKGROUND

(3) The recent trend toward miniaturization, low power consumption, high performance, and multi-functionality in the electrical and electronics industry has compelled the semiconductor manufacturers to focus on high-performance, high capacity semiconductor devices. Examples of such high-performance, high capacity semiconductor devices include memory devices that can store data by switching between different resistance states according to an applied voltage or current. The semiconductor devices may include an RRAM (resistive random access memory), a PRAM (phase change random access memory), an FRAM (ferroelectric random access memory), an MRAM (magnetic random access memory), and an electronic fuse (E-fuse).

SUMMARY

(4) The disclosed technology in this patent document includes memory circuits or devices and their applications in electronic devices or systems and various implementations of an electronic device that can improve the performance of a semiconductor device and reduce manufacturing defects.

(5) In one aspect, a semiconductor device may include: a plurality of first conductive lines; a plurality of second conductive lines disposed over the first conductive lines to be spaced apart from the first conductive line, a variable resistance layer disposed above the first conductive line and below the second conductive line; at least one of a first interlayer dielectric layer or a second interlayer dielectric layer, wherein the first interlayer dielectric layer includes a first hole disposed between the first conductive line and the variable resistance layer and the second interlayer dielectric layer includes a second hole disposed between the variable resistance layer and the second conductive line; at least one of a first contact or a second contact, wherein the first contact is disposed in the first hole and the second contact is disposed in the second hole; and at least one of a first selector layer or a second selector layer, wherein the first selector layer is disposed in a portion of the first interlayer dielectric layer below the first contact and the second selector layer is disposed in a portion of the second dielectric layer below the second contact, wherein the first selector layer includes a dielectric material of the first interlayer dielectric layer and a dopant, and the second selector layer includes a dielectric material of the second interlayer dielectric layer and a dopant.

(6) In another aspect, a semiconductor device may include: a plurality of first conductive lines; a plurality of second conductive lines disposed over the first conductive lines to be spaced apart from the first conductive lines; a variable resistance layer disposed above the first conductive line and below the second conductive line; at least one of a first interlayer dielectric layer or a second interlayer dielectric layer, wherein the first interlayer dielectric layer surrounds sidewalls of the first conductive line and the second interlayer dielectric layer surrounds sidewalls of the variable resistance layer; and at least one of a first selector layer or a second selector layer, wherein the first selector layer is disposed above the first conductive line and the first interlayer dielectric layer and below the variable resistance layer and the second interlayer dielectric layer, and the second selector layer is disposed selector layer above the variable resistance layer and the second interlayer dielectric layer and below the second conductive line.

(7) In another aspect, a semiconductor device may include: a first conductive line; a second conductive line disposed over the first conductive line to be spaced apart from the first conductive line; a variable resistance layer disposed above the first conductive line and below the second conductive line; a first selector layer disposed between the first conductive line and the variable resistance layer; and a second selector layer disposed between the variable resistance layer and the second conductive line, wherein each of the first selector layer and the second selector layer includes a dielectric material and a dopant.

(8) In another aspect, a method for fabricating a semiconductor device may include: forming a first conductive line over a substrate; forming a second conductive line over the first conductive line to be spaced apart from the first conductive line; forming a variable resistance layer above the first

conductive line and below the second conductive line; forming an interlayer dielectric layer including a hole between the first conductive line and the variable resistance layer, between the variable resistance layer and the second conductive line, or both between the first conductive line and the variable resistance layer and between the variable resistance layer and the second conductive line; and performing an ion implantation of a dopant into a portion of the interlayer dielectric layer below the hole and upper portions of the interlayer dielectric layer on both sides of the hole to convert the portion of the interlayer dielectric layer below the hole into a selector layer.

(9) In another aspect, a method for fabricating a semiconductor device may include: forming a first conductive line over a substrate; forming a second conductive line over the first conductive line to be spaced apart from the first conductive line; forming a variable resistance layer between the first conductive line and the second conductive line; forming at least one of a first interlayer dielectric layer or a second interlayer dielectric layer, wherein the first interlayer dielectric layer surrounds sidewalls of the first conductive line and the second interlayer dielectric layer surrounds sidewalls of the variable resistance layer; forming at least one of a first dielectric layer or a second dielectric layer, wherein the first dielectric layer is disposed above the first conductive line and the first interlayer dielectric layer and below the variable resistance layer and the second interlayer dielectric layer, and the second dielectric layer is disposed above the variable resistance layer and the second interlayer dielectric layer and below the second conductive line; and performing an ion implantation process on at least one of the first dielectric layer or the second dielectric layer to form at least one of a first selector layer or a second selector layer, wherein the first selector layer is disposed above the first conductive line and the first interlayer dielectric layer and below the variable resistance layer and the second interlayer dielectric layer and the second selector layer is disposed above the variable resistance layer and the second interlayer dielectric layer and below the second conductive line, and the first selector layer and the second selector layer include a dielectric material and a dopant, respectively.

Description

BRIEF DESCRIPTION OF THE DRAWINGS

- (1) FIGS. 1A and 1B illustrate a semiconductor device based on some implementations of the disclosed technology.
- (2) FIG. 1C illustrates an example of Magnetic Tunnel Junction (MTJ) structure included in a variable resistance layer based on some implementations of the disclosed technology.
- (3) FIGS. 2A to 2H are cross-sectional views illustrating an example method for fabricating a semiconductor device based on some implementations of the disclosed technology.
- (4) FIGS. 3A to 3I are cross-sectional views illustrating another example method for fabricating a semiconductor device based on some implementations of the disclosed technology.
- (5) FIGS. 4A to 4G are cross-sectional views illustrating another example method for fabricating a semiconductor device based on some implementations of the disclosed technology.
- (6) FIGS. 5A to 5G are cross-sectional views illustrating another example method for fabricating a semiconductor device based on some implementations of the disclosed technology.

DETAILED DESCRIPTION

- (7) Hereinafter, various embodiments of the disclosure will be described in detail with reference to the accompanying drawings.
- (8) FIGS. 1A and 1B illustrate a semiconductor device based on some implementations of the disclosed technology. FIG. 1A is a plan view, and FIG. 1B is a cross-sectional view taken along line A-A' of FIG. 1A.
- (9) Referring to FIGS. 1A and 1B, the semiconductor device may include a cross-point structure including a substrate **100**, first conductive lines **110** formed over the substrate **100** and extending in

a first direction, second conductive lines **130** formed over the first conductive lines **110** to be spaced apart from the first conductive lines **110** and extending in a second direction crossing the first direction, and memory cells **120** disposed at intersections of the first conductive lines **110** and the second conductive lines **130** between the first conductive lines **110** and the second conductive lines **130**.

(10) The substrate **100** may include a semiconductor material such as silicon. A required lower structure (not shown) may be formed in the substrate **100**. For example, the substrate **100** may include a driving circuit (not shown) electrically connected to the first conductive lines **110** and/or the second conductive lines **130** to control operations of the memory cells **120**. In this patent document, the conductive lines can indicate conductive structures that electrically connect two or more circuit elements in the semiconductor device. In some implementations, the conductive lines include word lines that are used control access to memory cells in the memory device and bit lines that are used to read out information stored in the memory cells. In some implementations, the conductive lines include interconnects that carry signals between different circuit elements in the semiconductor device.

(11) The first conductive line **110** and the second conductive line **130** may be connected to a lower end and an upper end of the memory cell **120**, respectively, and may provide a voltage or a current to the memory cell **120** to drive the memory cell **120**. When the first conductive line **110** functions as a word line, the second conductive line **130** may function as a bit line. Conversely, when the first conductive line **110** functions as a bit line, the second conductive line **130** may function as a word line. The first conductive line **110** and the second conductive line **130** may include a single-layer or multilayer structure including one or more of various conductive materials. Examples of the conductive materials may include a metal, a metal nitride, or a conductive carbon material, or a combination thereof, but are not limited thereto. For example, the first conductive line **110** and the second conductive line **130** may include tungsten (W), titanium (Ti), tantalum (Ta), platinum (Pt), aluminum (Al), copper (Cu), zinc (Zn), nickel (Ni), cobalt (Co), lead (Pb), tungsten nitride (WN), tungsten silicide (WSi), titanium nitride (TiN), titanium silicon nitride (TiSiN), titanium aluminum nitride (TiAlN), tantalum nitride (TaN), tantalum silicon nitride (TaSiN), tantalum aluminum nitride (TaAlN), carbon (C), silicon carbide (SiC), or silicon carbon nitride (SiCN), or a combination thereof.

(12) The memory cell **120** may be arranged in a matrix having rows and columns along the first direction and the second direction so as to overlap the intersection regions between the first conductive lines **110** and the second conductive lines **130**. In an implementation, each of the memory cells **120** may have a size that is substantially equal to or smaller than that of the intersection region between each corresponding pair of the first conductive lines **110** and the second conductive lines **130**. In another implementation, each of the memory cells **120** may have a size that is larger than that of the intersection region between each corresponding pair of the first conductive lines **110** and the second conductive lines **130**.

(13) Spaces between the first conductive line **110**, the second conductive line **130** and the memory cell **120** may be filled with a dielectric material.

(14) The memory cell **120** may include a stacked structure including a first selector layer **121**, a first contact **122**, a variable resistance layer **123**, a second selector layer **124** and a second contact **125**.

(15) The first contact **122** may be disposed between the first selector layer **121** and the variable resistance layer **123**. The first contact **122** may function as a middle electrode to electrically connect the first selector layer **121** and the variable resistance layer **123** to each other while physically separating the first selector layer **121** and the variable resistance layer **123** from each other.

(16) The second contact **125** may be disposed at an uppermost portion of the memory cell **120** and function as a transmission path of a voltage or a current between the rest of the memory cell **120**

and a corresponding one of the second conductive lines **130**.

(17) The first contact **122** and the second contact **125** may include a single-layer or multilayer structure including various conductive materials such as a metal, a metal nitride, a conductive carbon material, or a combination thereof, respectively. For example, the first contact **122** and the second contact **125** may include tungsten (W), titanium (Ti), tantalum (Ta), platinum (Pt), aluminum (Al), copper (Cu), zinc (Zn), nickel (Ni), cobalt (Co), lead (Pb), tungsten nitride (WN), tungsten silicide (WSi), titanium nitride (TiN), titanium silicon nitride (TiSiN), titanium aluminum nitride (TiAlN), tantalum nitride (Ta₂N₃), tantalum silicon nitride (TaSiN), tantalum aluminum nitride (TaAlN), carbon (C), silicon carbide (SiC), or silicon carbon nitride (SiCN), or a combination thereof.

(18) The first contact **122** and the second contact **125** may include the same material as each other or different materials from each other.

(19) The first contact **122** and the second contact **125** may have the same thickness as each other or different thicknesses from each other.

(20) The variable resistance layer **123** may be used to store data by switching between different resistance states according to an applied voltage or current. The variable resistance layer **123** may have a single-layered structure or a multi-layered structure including at least one of materials used for an RRAM, a PRAM, an MRAM, an FRAM, and others. For example, the variable resistance layer **123** may include a metal oxide such as a transition metal oxide or a perovskite-based oxide, a phase change material such as a chalcogenide-based material, a ferromagnetic material, a ferroelectric material, or others. However, the implementations are not limited thereto, and the memory cell **120** may include other memory layers capable of storing data in various ways instead of the variable resistance layer **123**.

(21) In some implementations, the variable resistance layer **123** may include a magnetic tunnel junction (MTJ) structure. This will be explained with reference to FIG. **1C**.

(22) FIG. **1C** illustrates an example of Magnetic Tunnel Junction (MTJ) structure included in the variable resistance layer **123**.

(23) The variable resistance layer **123** may include an MTJ structure including a free layer **13** having a variable magnetization direction, a pinned layer **15** having a pinned magnetization direction and a tunnel barrier layer **14** interposed between the free layer **13** and the pinned layer **15**.

(24) The free layer **13** may have one of different magnetization directions or one of different spin directions of electrons to switch the polarity of the free layer **13** in the MTJ structure, resulting in changes in resistance value. In some implementations, the polarity of the free layer **13** is changed or flipped upon application of a voltage or current signal (e.g., a driving current above a certain threshold) to the MTJ structure. With the polarity changes of the free layer **13**, the free layer **13** and the pinned layer **15** have different magnetization directions or different spin directions of electron, which allows the variable resistance layer **123** to store different data or represent different data bits. The free layer **13** may also be referred as a storage layer. The magnetization direction of the free layer **13** may be substantially perpendicular to a surface of the free layer **13**, the tunnel barrier layer **14** and the pinned layer **15**. In other words, the magnetization direction of the free layer **13** may be substantially parallel to stacking directions of the free layer **13**, the tunnel barrier layer **14** and the pinned layer **15**. Therefore, the magnetization direction of the free layer **13** may be changed between a downward direction and an upward direction. The change in the magnetization direction of the free layer **13** may be induced by a spin transfer torque generated by an applied current or voltage.

(25) The free layer **13** may have a single-layer or multilayer structure including a ferromagnetic material. For example, the free layer **13** may include an alloy based on Fe, Ni or Co, for example, an Fe—Pt alloy, an Fe—Pd alloy, a Co—Pd alloy, a Co—Pt alloy, a Co—Fe alloy, an Fe—Ni—Pt alloy, a Co—Fe—Pt alloy, a Co—Ni—Pt alloy, or a Co—Fe—B alloy, or others, or may include a stack of metals, such as Co/Pt, or Co/Pd, or others.

(26) The tunnel barrier layer **14** may allow the tunneling of electrons in both data reading and data writing operations. In a write operation for storing new data, a high write current may be directed through the tunnel barrier layer **14** to change the magnetization direction of the free layer **13** and thus to change the resistance state of the MTJ for writing a new data bit. In a reading operation, a low reading current may be directed through the tunnel barrier layer **14** without changing the magnetization direction of the free layer **13** to measure the existing resistance state of the MTJ under the existing magnetization direction of the free layer **13** to read the stored data bit in the MTJ. The tunnel barrier layer **14** may include a dielectric oxide such as MgO, CaO, SrO, TiO, VO, or NbO or others.

(27) The pinned layer **15** may have a pinned magnetization direction, which remains unchanged while the magnetization direction of the free layer **13** changes. The pinned layer **15** may be referred to as a reference layer. In some implementations, the magnetization direction of the pinned layer **15** may be pinned in a downward direction. In some implementations, the magnetization direction of the pinned layer **15** may be pinned in an upward direction.

(28) The pinned layer **15** may have a single-layer or multilayer structure including a ferromagnetic material. For example, the pinned layer **15** may include an alloy based on Fe, Ni or Co, for example, an Fe—Pt alloy, an Fe—Pd alloy, a Co—Pd alloy, a Co—Pt alloy, a Co—Fe alloy, an Fe—Ni—Pt alloy, a Co—Fe—Pt alloy, a Co—Ni—Pt alloy, or a Co—Fe—B alloy, or may include a stack of metals, such as Co/Pt, or Co/Pd or others.

(29) If a voltage or current is applied to the variable resistance layer **123**, the magnetization direction of the free layer **13** may be changed by spin torque transfer. In some implementations, when the magnetization directions of the free layer **13** and the pinned layer **15** are parallel to each other, the variable resistance layer **123** may be in a low resistance state, and this may indicate digital data bit “0.” Conversely, when the magnetization directions of the free layer **13** and the pinned layer **15** are anti-parallel to each other, the variable resistance layer **123** may be in a high resistance state, and this may indicate a digital data bit “1.” In some implementations, the variable resistance layer **123** can be configured to store data bit ‘1’ when the magnetization directions of the free layer **13** and the pinned layer **15** are parallel to each other and to store data bit ‘0’ when the magnetization directions of the free layer **13** and the pinned layer **15** are anti-parallel to each other.

(30) In some implementations, the variable resistance layer **123** may further include one or more layers performing various functions to improve a characteristic of the MTJ structure. For example, the variable resistance layer **123** may further include at least one of a buffer layer **11**, an under layer **12**, a spacer layer **16**, a magnetic correction layer **17** and a capping layer **18**.

(31) The under layer **12** may be disposed under the free layer **13** and serve to improve perpendicular magnetic crystalline anisotropy of the free layer **13**. The under layer **12** may have a single-layer or multilayer structure including a metal, a metal alloy, a metal nitride, or a metal oxide, or a combination thereof.

(32) The buffer layer **11** may be disposed below the under layer **12** to facilitate crystal growth of the under layer **12**, thus improving perpendicular magnetic crystalline anisotropy of the free layer **13**. The buffer layer **11** may have a single-layer or multilayer structure including a metal, a metal alloy, a metal nitride, or a metal oxide, or a combination thereof. Moreover, the buffer layer **11** may be formed of or include a material having a good compatibility with a bottom electrode (not shown) in order to resolve the lattice constant mismatch between the bottom electrode and the under layer **12**. For example, the buffer layer **11** may include tantalum (Ta).

(33) The spacer layer **16** may be interposed between the magnetic correction layer **17** and the pinned layer **15** and function as a buffer between the magnetic correction layer **17** and the pinned layer **15**. The spacer layer **16** may be used to improve characteristics of the magnetic correction layer **17**. The spacer layer **16** may include a noble metal such as ruthenium (Ru).

(34) The magnetic correction layer **17** may be used to offset the effect of the stray magnetic field produced by the pinned layer **15**. In this case, the effect of the stray magnetic field of the pinned

layer **15** can decrease, and thus a biased magnetic field in the free layer **13** can decrease. The magnetic correction layer **17** may have a magnetization direction anti-parallel to the magnetization direction of the pinned layer **15**. In the implementation, when the pinned layer **15** has a downward magnetization direction, the magnetic correction layer **17** may have an upward magnetization direction. Conversely, when the pinned layer **15** has an upward magnetization direction, the magnetic correction layer **17** may have a downward magnetization direction. The magnetic correction layer **17** may be exchange coupled with the pinned layer **15** via the spacer layer **16** to form a synthetic anti-ferromagnet (SAF) structure. The magnetic correction layer **17** may have a single-layer or multilayer structure including a ferromagnetic material.

(35) In this implementation, the magnetic correction layer **17** is located above the pinned layer **15**, but the magnetic correction layer **17** may be disposed at a different location. For example, the magnetic correction layer **17** may be located above, below, or next to the MTJ structure while the magnetic correction layer **17** is patterned separately from the MTJ structure.

(36) The capping layer **18** may be used to protect the variable resistance layer **123** and/or function as a hard mask for patterning the variable resistance layer **123**. In some implementations, the capping layer **18** may include various conductive materials such as a metal. In some implementations, the capping layer **18** may include a metallic material having almost none or a small number of pin holes and high resistance to wet and/or dry etching. In some implementations, the capping layer **18** may include a metal, a nitride, or an oxide, or a combination thereof. For example, the capping layer **18** may include a noble metal such as ruthenium (Ru).

(37) The capping layer **18** may have a single-layer or multilayer structure. In some implementations, the capping layer **18** may have a multilayer structure including an oxide, or a metal, or a combination thereof. For example, the capping layer **18** may have a multilayer structure of an oxide layer, a first metal layer and a second metal layer.

(38) A material layer (not shown) for resolving the lattice structure differences and the lattice constant mismatch between the pinned layer **15** and the magnetic correction layer **17** may be interposed between the pinned layer **15** and the magnetic correction layer **17**. For example, this material layer may be amorphous and may include a metal, a metal nitride, or metal oxide.

(39) The first and the second selector layers **121** and **124** may be used to control access to the variable resistance layer **123**. To this end, the first and the second selector layers **121** and **124** may be used to adjust the flow of a current according to the magnitude of the applied voltage or a current, that is, for blocking or substantially limiting a current flowing through the memory cell **120** when a magnitude of an applied voltage is less than a predetermined threshold value and for allowing a current flowing through the memory cell **120** to abruptly increase when the magnitude of the applied voltage is equal to or greater than the threshold value. The first and the second selector layers **121** and **124** may include an MIT (Metal Insulator Transition) material such as NbO_{2-x} , TiO_2 , VO_2 , WO_2 , or others, an MIEC (Mixed Ion-Electron Conducting) material such as $\text{ZrO}_2(\text{Y}_2\text{O}_3)_x$, $\text{Bi}_2\text{O}_3\text{—BaO}$,

$(\text{La}_2\text{O}_3)_x(\text{CeO}_2)_{1-x}$, or others, an OTS (Ovonic Threshold Switching) material including a chalcogenide material such as GeSbTe , AsTe , AsSe , or others, or a tunneling insulating material such as silicon oxide, silicon nitride, a metal oxide, or others. A thickness of the tunneling insulating layer is sufficiently small to allow tunneling of electrons under a given voltage or a given current. The first and the second selector layers **121** and **124** may include a single-layer or multilayer structure. In various implementations, the first and the second selector layers **121** and **124** may be a blanket-doped layer at a region which is doped uniformly within that region without using any mask or pattern within that doped region.

(40) In one implementation, the first and the second selector layers **121** and **124** may be configured to perform a threshold switching operation for turning on or off the conduction of an electric current through the first and the second selector layers **121** and **124** while an external voltage is

being applied to the first and the second selector layers **121** and **124** at a voltage value with respect to a threshold voltage. The absolute value of the external voltage may be controlled to gradually increase or decrease. When the absolute value of the external voltage applied to the first and the second selector layers **121** and **124** increases, the first and the second selector layers **121** and **124** may be turned on to be electrically conductive, when the absolute value of the external voltage is greater than a first threshold voltage, once turned on, the increase of this external voltage causes an operation current to increase nonlinearly. When the absolute value of the external voltage applied to the first and the second selector layers **121** and **124** decreases after the first and the second selector layers **121** and **124** are turned on, the operation current flowing through or between the first and the second blanket-doped selector layers **121** and **124** decreases nonlinearly until the applied voltage value reaches a second threshold voltage below which the first and the second selector layers **121** and **124** may be turned off (i.e., electrically non-conductive). As such, the first and the second selector layers **121** and **124** performing the threshold switching operation may have a non-memory operation characteristic.

(41) In some implementations, the first and the second selector layers **121** and **124** may include a dielectric material having incorporated dopants. The first and the second selector layers **121** and **124** may include an oxide with dopants, a nitride with dopants, or an oxynitride with dopants, or a combination thereof such as silicon oxide, titanium oxide, aluminum oxide, tungsten oxide, hafnium oxide, tantalum oxide, niobium oxide, silicon nitride, titanium nitride, aluminum nitride, tungsten nitride, hafnium nitride, tantalum nitride, niobium nitride, silicon oxynitride, titanium oxynitride, aluminum oxynitride, tungsten oxynitride, hafnium oxynitride, tantalum oxynitride, or niobium oxynitride, or a combination thereof. The dopants doped into the first and the second selector layers **121** and **124** may include an n-type dopant or a p-type dopant and be incorporated for example, by ion implantation process. Examples of the dopants may include one or more of boron (B), nitrogen (N), carbon (C), phosphorous (P), arsenic (As), aluminum (Al), silicon (Si) and germanium (Ge). For example, the first and the second selector layers **121** and **124** may include As-doped silicon oxide or Ge-doped silicon oxide.

(42) Conventionally, the first and the second selector layers **121** and **124** including a doped dielectric material may be formed by forming a separate blanket dielectric layer for forming the first and the second selector layers **121** and **124**, incorporating a dopant into the dielectric layer by an ion implantation process, and performing an etch process for patterning the first and the second selector layers **121** and **124**. A separate sidewall passivation process may be required to protect other layers such as the variable resistance layer **123** during the etch process. In this case, various problems may be caused by the etch process and the passivation process. In particular, since an etch process margin for pillar formation is reduced as a pitch is decreased, it is difficult to control sidewall damage due to the etch process.

(43) In order to overcome these problems, in implementations of the disclosed technology, the first and the second selector layers **121** and **124** may be formed by incorporating a dopant into an interlayer dielectric layer **102** remaining below a hole for forming the first contact **122** and an interlayer dielectric layer **103** remaining a hole for forming the second contact **125** by an ion implantation process, instead of forming a separate dielectric layer for forming the first and the second selector layers **121** and **124**. Accordingly, since a forming process of a separate dielectric layer and a separate patterning process are not performed for forming the first and the second selector layers **121** and **124**, a height of the memory cell **120** may not be increased, thereby improving the etch process margin. Also, it is possible to easily control sidewall damage generated during patterning of the first and the second selector layers **121** and **124**. Moreover, a separate passivation process for protecting other layers such as the variable resistance layer **123** during the patterning process may be omitted.

(44) Forming of the first and the second selector layers **121** and **124** may be described in detail with reference to FIGS. 2A to 2H, FIGS. 3A to 3I, FIGS. 4A to 4G, and FIGS. 5A to 5G.

(45) In some implementations, the first and the second selector layers **121** and **124** may perform a threshold switching operation through a doped region formed in material layers for the first and the second selector layers **121** and **124**. Thus, a size of the threshold switching operation region may be controlled by a distribution area of the dopants. The dopants may form trap sites for charge carriers in the material layers for the first and the second selector layers **121** and **124**. The trap sites may capture the charge carriers moving in the first and the second selector layers **121** and **124**, based on an external voltage applied to the first and the second selector layers **121** and **124**. The trap sites thereby are used to perform a threshold switching operation.

(46) In some implementations, each of the memory cell **120** may include the first selector layer **121**, the first contact **122**, the variable resistance layer **123**, the second selector layer **124** and the second contact **125** which are sequentially stacked. However, the memory cells **120** may have different structures. In some implementations, at least one of the first contact **122** and the second contact **125** may be omitted. In some implementations, at least one of the first selector layer **121** and the second selector layer **124** may be omitted. In some implementations, for example, when the buffer layer **11** included in the variable resistance layer **123** may function as an electrode (e.g., middle electrode), the contact **122** may be omitted. In some implementations, in addition to the layers **121** to **125** shown in FIG. 1B, the memory cells **120** may further include one or more layers (not shown) that can be used to enhance characteristics of the memory cells **120** or reduce manufacturing defects.

(47) In some implementations, neighboring memory cells of the plurality of memory cells **120** may be spaced apart from each other at a predetermined interval, and trenches may be present between the plurality of memory cells **120**. A trench between neighboring memory cells **120** may have a height to width ratio (i.e., an aspect ratio) in a range from 1:1 to 40:1, from 10:1 to 40:1, from 10:1 to 20:1, from 5:1 to 10:1, from 10:1 to 15:1, from 1:1 to 25:1, from 1:1 to 30:1, from 1:1 to 35:1, or from 1:1 to 45:1.

(48) In some implementations, the trench may have sidewalls that are substantially perpendicular to an upper surface of the substrate **100**. In some implementations, neighboring trenches may be spaced apart from each other by an equal or similar distance.

(49) In some implementations, the semiconductor device may include further layers in addition to the first conductive line **110**, the memory cell **120** and the second conductive line **130**.

(50) Although one cross-point structure has been described, two or more cross-point structures may be stacked in a vertical direction perpendicular to a top surface of the substrate **100**.

(51) A method for fabricating a semiconductor device will be explained with reference to FIGS. 2A to 2H.

(52) FIGS. 2A to 2H are cross-sectional views illustrating an example method for fabricating a semiconductor device based on some implementations of the disclosed technology.

(53) Referring to FIG. 2A, first conductive lines **210** may be formed over a substrate **200** in which a predetermined structure is formed. The first conductive lines **210** may be formed by forming an interlayer dielectric layer **201** having a trench for forming the first conductive lines **210** over the substrate **200**, forming a conductive layer for the first conductive lines **210**, and etching the conductive layer using a mask pattern in a line shape extending in a first direction.

(54) An interlayer dielectric layer **202** may be formed over the first conductive lines **210** and the interlayer dielectric layer **201**. Then, a hole or recess **H1** may be formed in the interlayer dielectric layer **202** and a portion of the interlayer dielectric layer **202** below the hole **H1** may remain after the formation of the hole **H1**. The remaining portion of the interlayer dielectric layer **202** may have a predetermined thickness.

(55) The hole **H1** may be a space in which a first contact (e.g., **222** of FIG. 2D) is formed in a subsequent process. Accordingly, a height for the hole **H1** may be adjusted in consideration of a height of the first contact **222** and a subsequent planarization process (see FIG. 2C).

(56) The portion of the interlayer dielectric layer **202** below the hole **H1** may be a portion to be

converted into a first selector layer (e.g., **221** of FIG. 2B) in a subsequent process. Therefore, when forming the hole **H1** in the interlayer dielectric layer **202** by an etch process, the etch process may be performed to a certain depth on the interlayer dielectric layer **202** so that a lower portion of the interlayer dielectric layer **202** may remain under the hole **H1** after the etch process. The remaining lower portion of the interlayer dielectric layer **202** may have a predetermined thickness. That is, the etch process for forming the hole **H1** in the interlayer dielectric layer **202** may be performed by an LD etch (low depth etch).

(57) The interlayer dielectric layer **202** may include a dielectric material. For example, the interlayer dielectric layer **202** may include an oxide, a nitride, an oxynitride, or a combination thereof. Examples of the oxide, the nitride and/or the oxynitride may include silicon oxide, tungsten oxide, titanium oxide, vanadium oxide, chromium oxide, platinum oxide, aluminum oxide, copper oxide, zinc oxide, nickel oxide, cobalt oxide, lead oxide, manganese oxide, niobium oxide, hafnium oxide, silicon nitride, tungsten nitride, titanium nitride, vanadium nitride, chromium nitride, platinum nitride, aluminum nitride, copper nitride, zinc nitride, nickel nitride, cobalt nitride, lead nitride, manganese nitride, niobium nitride, hafnium nitride, silicon oxynitride, tungsten oxynitride, titanium oxynitride, vanadium oxynitride, chromium oxynitride, Platinum oxynitride, aluminum oxynitride, copper oxynitride, zinc oxynitride, nickel oxynitride, cobalt oxynitride, lead oxynitride, manganese oxynitride, niobium oxynitride, or hafnium oxynitride, or a combination thereof.

(58) Referring to FIG. 2B, an ion implantation process may be performed on the structure of FIG. 2A. Through the ion implantation process, a dopant may be incorporated into upper portions of the interlayer dielectric layer **202** on both sides of the hole **H1** and the portion of the interlayer dielectric layer **202** under the hole **H1**. The portion of the interlayer dielectric layer **202** under the hole **H1** may be converted into the first selector layer **221** by incorporating the dopant through the ion implantation process.

(59) The dopant incorporated by the ion implantation process may include one or more of boron (B), nitrogen (N), carbon (C), phosphorous (P), arsenic (As), aluminum (Al), silicon (Si) and germanium (Ge).

(60) Since the first selector layer **221** may be formed without a separate patterning process, an interface between the selector layer **221** and the interlayer dielectric layer **202** may be an interface that is separated depending on the presence or absence of the dopant, not an interface that is physically separated by etching.

(61) Referring to FIG. 2C, a planarization process such as a CMP (Chemical Mechanical Planarization) process may be performed to remove the doped upper portions of the interlayer dielectric layer **202** on both sides of the hole **H1**. In this case, a portion of the hole **H1** may remain.

(62) In some implementations, a cleaning process may be further performed before and/or after the planarization process.

(63) A height t_2 of the first selector layer **221** may be referred to as a height of the first selector layer **221** after performing of the planarization process, while a height t_1 (see, FIG. 2B) of the first selector layer **221** may be referred to as a height of the first selector layer **221** before performing of the planarization process.

(64) In some implementations, the height t_2 of the first selector layer **221** may be lower than the height t_1 of the first selector layer **221**.

(65) Referring to FIG. 2D, a first contact **222** may be formed in the hole **H1**.

(66) The first contact **222** may be formed by forming a conductive layer for forming the first contact **222** in the hole **H1** and performing a planarization process such as a CMP process. The first contact **222** may include a single-layer or multilayer structure including various conductive materials such as a metal, a metal nitride, a conductive carbon material, or a combination thereof. For example, the first contact **222** may include tungsten (W), titanium (Ti), tantalum (Ta), platinum (Pt), aluminum (Al), copper (Cu), copper (Cu), zinc (Zn), nickel (Ni), cobalt (Co), lead (Pb),

tungsten nitride (WN), tungsten silicide (WSi), titanium nitride (TiN), titanium silicon nitride (TiSiN), titanium aluminum nitride (TiAlN), tantalum nitride (TaN), tantalum silicon nitride (TaSiN), tantalum aluminum nitride (TaAlN), carbon (C), silicon carbide (SiC), or silicon carbon nitride (SiCN), or a combination thereof.

(67) Referring to FIG. 2E, a variable resistance layer **223** may be formed on the first contact **222**.

(68) The variable resistance layer **223** may be formed by forming material layers for the variable resistance layer **223** and etching the material layers using a mask (not shown).

(69) An interlayer dielectric layer **203** may be formed over the structure of FIG. 2D. Then, a hole H2 may be formed in the interlayer dielectric layer **203** and a portion of the interlayer dielectric layer **203** below the hole H2 may remain under the hole H2. The portion of the interlayer dielectric layer **203** may have a predetermined thickness.

(70) The hole H2 may be a space in which a second contact (e.g., **225** of FIG. 2H) is formed in a subsequent process. The portion of the interlayer dielectric layer **203** below the hole H2 may be a portion to be converted into a second selector layer (e.g., **224** of FIG. 2H) in a subsequent process. Therefore, when forming the hole H2 in the interlayer dielectric layer **203** by an etch process, the etch process may be performed to a certain depth on the interlayer dielectric layer **203** so that a lower portion of the interlayer dielectric layer **203** may remain under the hole H2 after the etch process. The remaining lower portion of the interlayer dielectric layer **203** may have a predetermined thickness. That, the etch process for forming the hole H2 in the interlayer dielectric layer **203** may include a low depth (LD) etch process.

(71) The interlayer dielectric layer **203** may include a dielectric material. For example, the interlayer dielectric layer **202** may include an oxide, a nitride, an oxynitride, or a combination thereof. Examples of the oxide, the nitride and/or the oxynitride may include silicon oxide, tungsten oxide, titanium oxide, vanadium oxide, chromium oxide, platinum oxide, aluminum oxide, copper oxide, zinc oxide, nickel oxide, cobalt oxide, lead oxide, manganese oxide, niobium oxide, hafnium oxide, silicon nitride, tungsten nitride, titanium nitride, vanadium nitride, chromium nitride, platinum nitride, aluminum nitride, copper nitride, zinc nitride, nickel nitride, cobalt nitride, lead nitride, manganese nitride, niobium nitride, hafnium nitride, silicon oxynitride, tungsten oxynitride, titanium oxynitride, vanadium oxynitride, chromium oxynitride, Platinum oxynitride, aluminum oxynitride, copper oxynitride, zinc oxynitride, nickel oxynitride, cobalt oxynitride, lead oxynitride, manganese oxynitride, niobium oxynitride, or hafnium oxynitride, or a combination thereof.

(72) Referring to FIG. 2F, an ion implantation process may be performed on the structure of FIG. 2F. Through the ion implantation process, a dopant may be incorporated into upper portions of the interlayer dielectric layer **203** on both sides of the hole H2 and the portion of the interlayer dielectric layer **203** under the hole H2. The portion of the interlayer dielectric layer **203** under the hole H2 may be converted into a second selector layer **224** by incorporating the dopant through the ion implantation process.

(73) The dopant incorporated by the ion implantation process may include one or more of boron (B), nitrogen (N), carbon (C), phosphorous (P), arsenic (As), aluminum (Al), silicon (Si) and germanium (Ge).

(74) In some implementations, the second selector layer **224** and the first selector layer **221** may include the same material as each other.

(75) Since the second selector layer **224** may be performed without a separate patterning process, an interface between the second selector layer **224** and the interlayer dielectric layer **203** may be an interface that is separated depending on the presence or absence of the dopant, not an interface that is physically separated by etching.

(76) Referring to FIG. 2G, a planarization process such as a CMP (Chemical Mechanical Planarization) process may be performed to remove the doped upper portions of the interlayer dielectric layer **203** on both sides of the hole H2. In this case, a portion of the hole H2 may remain.


(77) In some implementations, a cleaning process may be further performed before and/or after the planarization process.

(78) A height t_4 of the second selector layer **224** may be referred to as a height of the second selector layer **224** after performing of the planarization process, while a height t_3 (see, FIG. 2F) of the second selector layer **224** may be referred to as a height of the second selector layer **224** before performing of the planarization process.

(79) In some implementations, the height t_4 of the second selector layer **224** may be lower than the height t_3 of the second selector layer **224**.

(80) Referring to FIG. 2H, a second contact **225** may be formed in the hole H2.

(81) The second contact **225** may be formed by forming a conductive layer for forming the second contact **225** in the hole H2 and performing a planarization process such as a CMP process. The second contact **225** may include a single-layer or multilayer structure including various conductive materials such as a metal, a metal nitride, a conductive carbon material, or a combination thereof. For example, the second contact **225** may include tungsten (W), titanium (Ti), tantalum (Ta), platinum (Pt), aluminum (Al), copper (Cu), zinc (Zn), nickel (Ni), cobalt (Co), lead (Pb), tungsten nitride (WN), tungsten silicide (WSi), titanium nitride (TiN), titanium silicon nitride (TiSiN), titanium aluminum nitride (TiAlN), tantalum nitride (TaN), tantalum silicon nitride (TaSiN), tantalum aluminum nitride (TaAlN), carbon (C), silicon carbide (SiC), or silicon carbon nitride (SiCN), or a combination thereof.

(82) Through the processes described above, a memory cell **220** including first selector layer **221**, first contact **222**, variable resistance layer **223**, second selector layer **224**  second contact **225** may be formed.

(83) Second conductive lines **230** may be formed on the second contact **225** and the interlayer dielectric layer **203**.

(84) The second conductive lines **230** may be formed by forming a conductive layer for forming the second conductive lines **230** on the second contact **225** and the interlayer dielectric layer **203** and etching the conductive layer using a mask pattern in a line shape extending in a second direction.

(85) The substrate **200**, the first conductive lines **210**, the first selector layer **221**, the first contact **222**, the variable resistance layer **223**, the second selector layer **224**, the second contact **225** and the second conductive lines **230** illustrated in FIG. 2H may correspond to the substrate **100**, the first conductive lines **110**, the first selector layer **121**, the first contact **122**, the variable resistance layer **123**, the second selector layer **124**, the second contact **125** and the second conductive lines **130** illustrated in FIG. 1B, respectively.

(86) The semiconductor device formed by the method illustrated in FIGS. 2A to 2H may include the substrate **200**, the first conductive lines **210**, the memory cell **220** and the second conductive lines **230**. The memory cell **220** may include the first selector layer **221**, the first contact **222**, the variable resistance layer **223**, the second selector layer **224** and the second contact **225**.

(87) The semiconductor device may include two selector layers, that is, the first selector layer **221** and the second selector layer **224**. The first selector layer **221** and the second selector layer **224** may be formed of the same material as each other and/or may have the same operation characteristic and device operation conditions as each other. In this case, a durability defect rate may be reduced arithmetically by half. Therefore, even if any one of the selector layers **221** and **224** is not operated, it is possible to preserve bit cell operation at a corresponding address.

(88) The semiconductor device includes both the first selector layer **221** and the second selector layer **224**. However, the semiconductor device may include any one of the first selector layer **221** and the second selector layer **224**.

(89) The semiconductor device includes both the first contact **222** and the second contact **225**. However, the semiconductor device may include any one of the first contact **222** and the second contact **225**. For example, when the buffer layer **11** included in the variable resistance layer **223**

may function as a middle electrode, the first contact **222** may be omitted.

(90) In accordance with the implementations, the first and the second selector layers **221** and **224** may be formed by incorporating the dopant into the interlayer dielectric layer **202** below the first contact **222** and the interlayer dielectric layer **203** below the second contact **225** through the ion implantation processes, instead of forming separate dielectric layers and patterning the dielectric layers. Accordingly, it is possible to prevent etch damage caused by an etch process for forming the selector layers **221** and **224**. Further, a sidewall passivation process may be omitted, thereby improving process efficiency.

(91) FIGS. **3A** to **3I** are cross-sectional views illustrating another example method for fabricating a semiconductor device based on some implementations of the disclosed technology.

(92) The implementations illustrated in FIGS. **3A** to **3I** will be described focusing on differences from the implementations illustrated in FIGS. **2A** to **2H**.

(93) Referring to FIG. **3A**, first conductive lines **310** may be formed over a substrate **300** in which a predetermined structure is formed. The first conductive lines **310** may be formed by forming an interlayer dielectric layer **301** having a trench for forming the first conductive lines **310** over the substrate **300**, forming a conductive layer for the first conductive lines **310**, and etching the conductive layer using a mask pattern in a line shape extending in a first direction.

(94) An interlayer dielectric layer **302** may be formed over the first conductive lines **310** and the interlayer dielectric layer **301**. Then, a hole **H3** may be formed in the interlayer dielectric layer **302** and a portion of the interlayer dielectric layer **302** below the hole **H3** may remain. The remaining portion of the interlayer dielectric layer **302** may have a predetermined thickness. The portion of the interlayer dielectric layer **302** below the hole **H3** may be a portion to be converted into a first selector layer (e.g., **321** of FIG. **3B**) in a subsequent process. Therefore, when forming the hole **H3** in the interlayer dielectric layer **302** by an etch process, the etch process may be performed to a certain depth on the interlayer dielectric layer **302** so that the interlayer dielectric layer **302** may remain under the hole **H3** after the etch process. The remaining lower portion of the interlayer dielectric layer **302** may have a predetermined thickness. That is, the etch process for forming the hole **H3** in the interlayer dielectric layer **302** may include a low depth (LD) etch process.

(95) Referring to FIG. **3B**, an ion implantation process may be performed on the structure of FIG. **3A**. Through the ion implantation process, a dopant may be incorporated into upper portions of the interlayer dielectric layer **302** on both side of the hole **H3** and the portion of the interlayer dielectric layer **302** under the hole **H3**. The portion of the interlayer dielectric layer **302** under the hole **H3** may be converted into the first selector layer **321** by incorporating the dopant through the ion implantation process.

(96) Since the first selector layer **321** may be formed without a separate patterning process, an interface between the selector layer **321** and the interlayer dielectric layer **302** may be an interface that is separated depending on the presence or absence of the dopant, not an interface that is physically separated by etching.

(97) Referring to FIG. **3C**, a planarization process such as a CMP (Chemical Mechanical Planarization) process may be performed to remove the doped upper portions of the interlayer dielectric layer **302**. Through the planarization process, the **H3** and the doped upper portion of the interlayer dielectric layer **302** on both sides of the hole **H3** may be removed. After the planarization process, the first selector layer **321** and the interlayer dielectric layer **302** may have upper surfaces at the same level as each other.

(98) A height **t4** of the first selector layer **321** may be referred to as a height of the first selector layer **321** after performing of the planarization process, while a height **t3** (see, FIG. **3B**) of the first selector layer **321** may be referred to as a height of the first selector layer **321** before performing of the planarization process.

(99) In some implementations, the height **t4** of the selector layer **321** may be lower than the height **t3** of the first selector layer **321**.

(100) Referring to FIG. 3D, a material layer **322A** for a first contact (e.g., **322** of FIG. 3E) and a material layer **323A** for a variable resistance layer (e.g., **323** of FIG. 3E) may be sequentially formed on the structure of FIG. 3C.

(101) The material layer **322A** may be converted into the first contact **322** by patterning in a subsequent process. The material layer **322A** may include a single-layer or multilayer structure including various conductive materials such as a metal, a metal nitride, a conductive carbon material, or a combination thereof.

(102) The material layer **323A** may be converted into the variable resistance layer **323** by patterning in a subsequent process.

(103) Referring to FIG. 3E, the first contact **322** and the variable resistance layer **323** may be formed by sequentially etching the material layer **323A** and the material layer **322A** using a mask (not shown).

(104) The first contact **322** may be disposed between the first selector layer **321** and the variable resistance layer **323** and function as a middle electrode to electrically connect the first selector layer **321** and the variable resistance layer **323** to each other while physically separating the first selector layer **321** and the variable resistance layer **323** from each other.

(105) In the implementations, the first contact **322** may be formed between the first selector layer **321** and the variable resistance layer **323**. However, in some implementations, the first contact **322** may be omitted. For example, when the buffer layer included in the variable resistance layer **323** may function as a middle electrode, the first contact **322** may be omitted.

(106) Referring to FIG. 3F, an interlayer dielectric layer **303** may be formed over the structure of FIG. 3E. Then, a hole **H4** may be formed in the interlayer dielectric layer **303** and a portion of the interlayer dielectric layer **303** below the hole **H4** may remain. The remaining portion of the interlayer dielectric layer **303** may have a predetermined thickness.

(107) The hole **H4** may be a space in which a second contact (e.g., **325** of FIG. 3I) is formed in a subsequent process. The portion of the interlayer dielectric layer **303** below the hole **H4** may be a portion to be converted into a second selector layer (e.g., **324** of FIG. 3G) in a subsequent process. Therefore, when forming the hole **H4** in the interlayer dielectric layer **303** by an etch process, the etch process may be performed to a certain depth on the interlayer dielectric layer **303** so that a lower portion of the interlayer dielectric layer **303** may remain under the hole **H4** after the etch process. The remaining lower portion of the interlayer dielectric layer **303** may have a predetermined thickness under the hole **H4**. That, the etch process for forming the hole **H4** in the interlayer dielectric layer **303** may include a low depth (LD) etch.

(108) Referring to FIG. 3G, an ion implantation process may be performed on the structure of FIG. 3F. Through the ion implantation process, a dopant may be incorporated into upper portions of the interlayer dielectric layer **303** on both sides of the hole **H4** and the portion of the interlayer dielectric layer **303** under the hole **H4**. The portion of the interlayer dielectric layer **303** under the hole **H4** may be converted into a second selector layer **324** by incorporating the dopant through the ion implantation process.

(109) Since the second selector layer **324** may be performed without a separate patterning process, an interface between the second selector layer **324** and the interlayer dielectric layer **303** may be an interface that is separated depending on the presence or absence of the dopant, not an interface that is physically separated by etching.

(110) The second selector layer **324** and the first selector layer **321** may include the same material as each other.

(111) Referring to FIG. 3H, a planarization process such as a chemical mechanical planarization (CMP) process may be performed to remove the doped upper portions of the interlayer dielectric layer **303** on both sides of the hole **H2**. In this case, a portion of the hole **H4** may remain.

(112) In some implementations, a cleaning process may be further performed before and/or after the planarization process.

(113) A height **t6** of the second selector layer **324** may be referred to as a height of the second selector layer **324** after performing of the planarization process, while a height **t5** (see, FIG. 3G) of the second selector layer **324** may be referred to as a height of the second selector layer **324** before performing of the planarization process.

(114) In some implementations, the height **t6** of the second selector layer **324** may be lower than the height **t5** of the second selector layer **324**.

(115) Referring to FIG. 3I, a second contact **225** may be formed in the hole **H4**. The second contact **325** may be formed by forming a conductive layer for forming the second contact **325** in the hole **H4** and performing a planarization process such as a CMP process.

(116) The second contact **325** may include a single-layer or multilayer structure including various conductive materials such as a metal, a metal nitride, a conductive carbon material, or a combination thereof.

(117) Through the above-described processes, a memory cell **320** including the first selector layer **321**, the first contact **322**, the variable resistance layer **323**, the second selector layer **324** and the second contact **325** may be formed.

(118) Second conductive lines **330** may be formed on the second contact **325** and the interlayer dielectric layer **303**.

(119) The second conductive lines **330** may be formed by forming a conductive layer for forming the second conductive lines **330** on the second contact **325** and the interlayer dielectric layer **303** and etching the conductive layer using a mask pattern in a line shape extending in a second direction.

(120) The substrate **300**, the first conductive lines **310**, the first selector layer **321**, the first contact **322**, the variable resistance layer **323**, the second selector layer **324**, the second contact **325** and the second conductive lines **330** illustrated in FIG. 3I may correspond to the substrate **100**, the first conductive lines **110**, the first selector layer **121**, the first contact **122**, the variable resistance layer **123**, the second selector layer **124**, the second contact **125** and the second conductive lines **130** illustrated in FIG. 1B, respectively, and the substrate **200**, the first conductive lines **210**, the first selector layer **221**, the first contact **222**, the variable resistance layer **223**, the second selector layer **224**, the second contact **225** and the second conductive lines **230** illustrated in FIG. 2H, respectively.

(121) The semiconductor device formed by the method illustrated in FIGS. 3A to 3I may include the substrate **300**, the first conductive lines **310**, the memory cell **320** and the second conductive lines **330**. The memory cell **320** may include the first selector layer **321**, the first contact **222**, the variable resistance layer **323**, the second selector layer **324** and the second contact **325**.

(122) The semiconductor device may include two selector layers, that is, the first selector layer **321** and the second selector layer **324**. The first selector layer **321** and the second selector layer **324** may be formed of the same material as each other and may have the same operation characteristic and device operation conditions as each other. In this case, a durability defect rate may be reduced arithmetically by half. Therefore, even if any one of the selector layers **321** and **224** is not operated, it is possible to preserve bit cell operation at a corresponding address.

(123) The semiconductor device includes both the first selector layer **321** and the second selector layer **324**. However, the semiconductor device may include any one of the first selector layer **321** and the second selector layer **224**.

(124) The semiconductor device includes both the first contact **322** and the second contact **325**. However, the semiconductor device may include any one of the first contact **322** and the second contact **325**. For example, when the buffer layer **11** included in the variable resistance layer **323** may function as a middle electrode, the first contact **322** may be omitted.

(125) In accordance with the implementations, the first and the second selector layers **321** and **324** may be formed by incorporating the dopant into the interlayer dielectric layer **302** below the first contact **322** and the interlayer dielectric layer **303** below the second contact **325** through the ion

implantation processes, instead of forming separate dielectric layers and patterning the dielectric layers. Accordingly, it is possible to prevent etch damage caused by an etch process for forming the selector layers **321** and **324**. Further, a sidewall passivation process may be omitted, thereby improving process efficiency.

(126) In the above-described implementations, the selector layers **121**, **124**, **221** and **224** may be formed by incorporating the dopant into the interlayer dielectric layers **102**, **103**, **202** and **203** below holes **H1**, **H2**, **H3** and **H4** for forming the contacts **122**, **125**, **222** and **225**, respectively through the ion implantation processes, instead of forming separate dielectric layers for forming the selector layers **121**, **124**, **221** and **224**. However, in some implementations in which a semiconductor device does not include a contact, a selector layer may be formed by forming a dielectric layer and incorporating a dopant into the dielectric layer. This will be described in detail with reference to FIGS. **4A** to **4G**, and FIGS. **5A** to **5G**.

(127) FIGS. **4A** to **4G** are cross-sectional views illustrating another example method for fabricating a semiconductor device based on some implementations of the disclosed technology.

(128) The implementations illustrated in FIGS. **4A** to **4G** will be described focusing on differences from the implementations illustrated in FIGS. **2A** to **2H** and FIGS. **3A** to **3I**.

(129) Referring to FIG. **4A**, first conductive lines **410** may be formed over a substrate **400** in which a predetermined structure is formed. The first conductive lines **410** may be formed by forming an interlayer dielectric layer **401** having a trench for forming the first conductive lines **410** over the substrate **400**, forming a conductive layer for the first conductive lines **410**, and etching the conductive layer using a mask pattern in a line shape extending in a first direction.

(130) A dielectric layer **421A** for forming a first selector layer (e.g., **421** of FIG. **4B**) may be formed over the first conductive lines **410** and the interlayer dielectric layer **401**.

(131) The dielectric layer **421A** may include a dielectric material. For example, the dielectric layer **421A** may include an oxide, a nitride, an oxynitride, or a combination thereof. Examples of the oxide, the nitride and/or the oxynitride may include silicon oxide, tungsten oxide, titanium oxide, vanadium oxide, chromium oxide, platinum oxide, aluminum oxide, copper oxide, zinc oxide, nickel oxide, cobalt oxide, lead oxide, manganese oxide, niobium oxide, hafnium oxide, silicon nitride, tungsten nitride, titanium nitride, vanadium nitride, chromium nitride, platinum nitride, aluminum nitride, copper nitride, zinc nitride, nickel nitride, cobalt nitride, lead nitride, manganese nitride, niobium nitride, hafnium nitride, silicon oxynitride, tungsten oxynitride, titanium oxynitride, vanadium oxynitride, chromium oxynitride, Platinum oxynitride, aluminum oxynitride, copper oxynitride, zinc oxynitride, nickel oxynitride, cobalt oxynitride, lead oxynitride, manganese oxynitride, niobium oxynitride, or hafnium oxynitride, or a combination thereof.

(132) Referring to FIG. **4B**, an ion implantation process may be performed on the dielectric layer **421A** to incorporate a dopant into the dielectric layer **421A**. As a result, a first selector layer **421** may be formed over the first conductive lines **410** and the interlayer dielectric layer **401**.

(133) The dopant incorporated by the ion implantation process may include one or more of boron (B), nitrogen (N), carbon (C), phosphorous (P), arsenic (As), aluminum (Al), silicon (Si) and germanium (Ge).

(134) Referring to FIG. **4C**, a material layer **422A** for a middle electrode layer (e.g., **422** of FIG. **4D**) and a material layer **423A** for a variable resistance layer (e.g., **423** of FIG. **4D**) may be sequentially formed over the first selector layer **421**.

(135) The material layer **422A** may be converted into the middle electrode layer **422** by patterning in a subsequent process. The material layer **422A** may include a single-layer or multilayer structure including various conductive materials such as a metal, a metal nitride, a conductive carbon material, or a combination thereof. For example, the material layer **422A** may include tungsten (W), titanium (Ti), tantalum (Ta), platinum (Pt), aluminum (Al), copper (Cu), copper (Cu), zinc (Zn), nickel (Ni), cobalt (Co), lead (Pb), tungsten nitride (WN), tungsten silicide (WSi), titanium nitride (TiN), titanium silicon nitride (TiSiN), titanium aluminum nitride (TiAlN), tantalum nitride

(TaN), tantalum silicon nitride (TaSiN), tantalum aluminum nitride (TaAlN), carbon (C), silicon carbide (SiC), or silicon carbon nitride (SiCN), or a combination thereof.

(136) The material layer **423A** may be converted into the variable resistance layer **423** by patterning in a subsequent process.

(137) Referring to FIG. **4D**, the middle electrode layer **422** and the variable resistance layer **423** may be formed by sequentially etching the material layer **423A** and the material layer **422A** using a mask (not shown).

(138) The middle electrode layer **422** may be used to electrically connect the first selector layer **421** and the variable resistance layer **423** to each other while physically separating the first selector layer **421** and the variable resistance layer **423** from each other.

(139) In the implementations, the middle electrode layer **422** may be formed between the first selector layer **421** and the variable resistance layer **423**. However, in some implementations, the middle electrode layer **422** may be omitted. For example, when the buffer layer included in the variable resistance layer **423** may function as a middle electrode, the middle electrode layer **422** may be omitted.

(140) Referring to FIG. **4E**, an interlayer dielectric layer **402** may be formed to cover the structure of FIG. **4D** and a planarization process may be performed. Then, a dielectric layer **424A** for forming a second selector layer (e.g., **424** of FIG. **4F**) may be formed over the interlayer dielectric layer **402** and the variable resistance layer **423**.

(141) The dielectric layer **424A** may include a dielectric material. For example, the dielectric layer **424A** may include an oxide, a nitride, an oxynitride, or a combination thereof.

(142) The dielectric layer **424A** for forming the second selector layer **424** and the dielectric layer **421A** for forming the first selector layer **421** may include the same material as each other.

(143) Referring to FIG. **4F**, an ion implantation process may be performed on the structure of FIG. **4E**. Through the ion implantation process, a dopant may be incorporated into the dielectric layer **424A** to form the second selector layer **424**. The second selector layer **424** may be formed over the interlayer dielectric layer **402** and the variable resistance layer **423**.

(144) The dopant incorporated by the ion implantation process may include one or more of boron (B), nitrogen (N), carbon (C), phosphorous (P), arsenic (As), aluminum (Al), silicon (Si) and germanium (Ge).

(145) The dopant incorporated into the dielectric layer **424A** and the dopant incorporated into the dielectric layer **421A** may be the same as each other.

(146) The second selector layer **424** and the first selector layer **421** may include the same material as each other.

(147) Through the above-described processes, a memory cell (e.g., **420** of FIG. **4G**) including the first selector layer **421**, the middle electrode layer **422**, the variable resistance layer **423** and the second selector layer **424**.

(148) Referring to FIG. **4G**, second conductive lines **430** may be formed on the second selector layer **424**.

(149) The second conductive lines **430** may be formed by forming a conductive layer for forming the second conductive lines **430** on the second selector layer **424** and etching the conductive layer using a mask pattern in a line shape extending in a second direction.

(150) The semiconductor device illustrated in FIGS. **4A** to **4G** may include the substrate **400**, the first conductive lines **410**, the memory cell **420** and the second conductive lines **430**. The memory cell **420** may include the first selector layer **421**, the middle electrode layer **422**, the variable resistance layer **423** and the second selector layer **424**.

(151) The first selector layer **421** may be formed above the interlayer dielectric layer **401** and the first conductive lines **410** and below the interlayer dielectric layer **402** and the middle electrode layer **422**. The second selector layer **424** may be formed above the interlayer dielectric layer **402** and the variable resistance layer **423** and below the second conductive lines **430**.

(152) The first selector layer **421** and the second selector layer **424** may be formed of the same material as each other and have the same operation characteristic and device operation conditions as each other. In this case, a durability defect rate may be reduced arithmetically by half. Therefore, even if any one of the selector layers **421** and **424** is not operated, it is possible to preserve bit cell operation at a corresponding address.

(153) The semiconductor device includes both the first selector layer **421** and the second selector layer **424**. However, the semiconductor device may include any one of the first selector layer **421** and the second selector layer **424**.

(154) The semiconductor device includes the middle electrode layer **422**. However, the semiconductor device may not include middle electrode layer **422**. For example, when the buffer layer **11** included in the variable resistance layer **423** may function as a middle electrode, the middle electrode layer **422** may be omitted.

(155) In accordance with the implementations, the first and the second selector layers **421** and **424** may be formed without performing separate patterning processes. Accordingly, it is possible to prevent etch damage caused by an etch process for forming the selector layers **421** and **424**. Further, a sidewall passivation process may be omitted, thereby improving process efficiency.

(156) FIGS. 5A to 5G are cross-sectional views illustrating another example method for fabricating a semiconductor device based on some implementations of the disclosed technology.

(157) The implementations illustrated in FIGS. 5A to 5G will be described focusing on differences from the implementations illustrated in FIGS. 2A to 2H, FIGS. 3A to 3I and FIGS. 4A to 4G.

(158) Referring to FIGS. 5A to 5C, an interlayer dielectric layer **501** and first conductive lines **501** may be formed over a substrate **500**, and a dielectric layer **521A** for forming a first selector layer **521** may be formed over the dielectric layer **521A** and the first conductive lines **501** by a method similar to those described in FIGS. 4A to 4C.

(159) An ion implantation process may be performed on the dielectric layer **521A**. Through the ion implantation process, a dopant may be incorporated into the dielectric layer **521A** to form an initial first selector layer **521B**.

(160) A material layer **522A** for forming a middle electrode layer (e.g., **522** of FIG. 5D) and a material layer **523A** for forming a variable resistance layer (e.g., **523** of FIG. 5D) may be sequentially formed over the initial first selector layer **521B**.

(161) Referring to FIG. 5D, the first selector layer **521**, the middle electrode layer **522** and the variable resistance layer **523** may be formed by sequentially etching the material layer **523A**, the material layer **522A** and the initial first selector layer **521B** using a mask (not shown).

(162) Referring to FIG. 5E, an interlayer dielectric layer **502** may be formed to cover the structure of FIG. 5D and a planarization process may be performed. Then, a dielectric layer **524A** for a second selector layer (e.g., **524** of FIG. 5G) may be formed on the interlayer dielectric layer **502** and the variable resistance layer **523**.

(163) The dielectric layer **524A** for the second selector layer **524** and the dielectric layer **521A** for the first selector layer **521** may include the same material as each other.

(164) Referring to FIG. 5F, an ion implantation process may be performed on the structure of FIG. 5E. Through the ion implantation process, a dopant may be incorporated into the dielectric layer **524A** to form an initial second selection element **524B**.

(165) The dopant incorporated into the dielectric layer **524A** and the dopant incorporated into the dielectric layer **521A** may be the same as each other.

(166) Referring to FIG. 5G, the second selector layer **524** may be formed by etching the initial second selector layer **524B** by using a mask (not shown).

(167) The second selector layer **524** and the first selector layer **521** may include the same material as each other.

(168) Through the above-described processes, a memory cell **520** including the first selector layer **521**, the middle electrode layer **522**, the variable resistance layer **523** and the second selector layer

524 may be formed.

(169) Then, an interlayer dielectric layer 503 may be formed to cover the second selector layer 524 and a planarization process may be performed. Then, second conductive lines 530 may be formed on the second selector layer 524 and the interlayer dielectric layer 503.

(170) The semiconductor device illustrated in FIGS. 5A to 5G may include the substrate 500, the first conductive lines 510, the memory cell 520 and the second conductive lines 530. The memory cell 520 may include the first selector layer 521, the middle electrode layer 522, the variable resistance layer 523 and the second selector layer 524.

(171) The first selector layer 521 may be formed above the first conductive lines 510 and below the middle electrode layer 522. Side walls of the first selector layer 521 may be in contact with the interlayer dielectric layer 502. The second selector layer 524 may be formed above the variable resistance layer 523 and below the second conductive lines 530. Sidewalls of the second selector layer 524 may be in contact with the interlayer dielectric layer 503.

(172) The first selector layer 521 and the second selector layer 524 may be formed of the same material as each other and have the same operation characteristic and device operation conditions as each other. In this case, a durability defect rate may be reduced arithmetically by half. Therefore, even if any one of the selector layers 521 and 524 is not operated, it is possible to preserve bit cell operation at a corresponding address.

(173) The semiconductor device includes both the first selector layer 521 and the second selector layer 524. However, the semiconductor device may include any one of the first selector layer 521 and the second selector layer 524.

(174) The semiconductor device includes the middle electrode layer 522. However, the semiconductor device may not include middle electrode layer 522. For example, when the buffer layer 11 included in the variable resistance layer 523 may function as a middle electrode, the middle electrode layer 522 may be omitted.

(175) The substrate 500, the first conductive lines 510, the middle electrode layer 522 and the variable resistance layer 523 illustrated in FIG. 5G may correspond to the substrate 400, the first conductive lines 410, the first selector layer 421, the middle electrode layer 422, the variable resistance layer 423 and the second selector layer 424 illustrated in FIG. 4G, respectively. The first selector layer 521 and the second selector layer 524 illustrated in FIG. 5G may be formed by an etch process, while the first selector layer 421 and the second selector layer 424 may be formed without performing a patterning process.

(176) While this patent document contains many specifics, these should not be construed as limitations on the scope of any disclosure or of what may be claimed, but rather as descriptions of features that may be specific to particular embodiments of particular disclosures. Certain features that are described in this patent document in the context of separate embodiments can also be implemented in combination in a single embodiment. Conversely, various features that are described in the context of a single embodiment can also be implemented in multiple embodiments separately or in any suitable sub combination. Moreover, although features may be described above as acting in certain combinations and even initially claimed as such, one or more features from a claimed combination can in some cases be excised from the combination, and the claimed combination may be directed to a sub combination or variation of a sub combination.

(177) Similarly, while operations are depicted in the drawings in a particular order, this should not be understood as requiring that such operations be performed in the particular order shown or in sequential order, or that all illustrated operations be performed, to achieve desirable results. Moreover, the separation of various system components in the embodiments described in this patent document should not be understood as requiring such separation in all embodiments.

(178) Only a few embodiments and examples are described. Enhancements and variations of the disclosed embodiments and other embodiments can be made based on what is described and illustrated in this patent document.

Claims

1. A semiconductor device comprising: a plurality of first conductive lines; a plurality of second conductive lines disposed over the first conductive lines to be spaced apart from the first conductive line, a variable resistance layer disposed above the first conductive line and below the second conductive line; at least one of a first interlayer dielectric layer or a second interlayer dielectric layer, wherein the first interlayer dielectric layer includes a first hole disposed between the first conductive line and the variable resistance layer and the second interlayer dielectric layer includes a second hole disposed between the variable resistance layer and the second conductive line; at least one of a first contact or a second contact, wherein the first contact is disposed in the first hole and the second contact is disposed in the second hole; and at least one of a first selector layer or a second selector layer, wherein the first selector layer is disposed in a portion of the first interlayer dielectric layer below the first contact and the second selector layer is disposed in a portion of the second dielectric layer below the second contact, wherein the first selector layer includes a dielectric material of the first interlayer dielectric layer and a dopant, and the second selector layer includes a dielectric material of the second interlayer dielectric layer and a dopant.
2. The semiconductor device according to claim 1, wherein each of the first selector layer, the second selector layer, the first interlayer dielectric layer and the second interlayer dielectric layer includes an oxide, a nitride, an oxynitride, or a combination of two or more of the oxide, the nitride, and the oxynitride.
3. The semiconductor device according to claim 1, wherein the dopant includes one or more of boron (B), nitrogen (N), carbon (C), phosphorous (P), arsenic (As), aluminum (Al), silicon (Si) and germanium (Ge).
4. The semiconductor device according to claim 1, wherein the first contact is configured to function as an electrode that electrically connects the first selector layer to the variable resistance layer.
5. The semiconductor device according to claim 1, wherein the first selector layer and the second selector layer include the same dielectric material and the same dopant as each other.
6. The semiconductor device according to claim 1, wherein each of the first contact and the second contact includes a single-layer or multilayer structure including a metal, a metal nitride, or a conductive carbon material, or a combination of two or more of the metal, the metal nitride, and the conductive carbon material.
7. The semiconductor device according to claim 1, wherein the variable resistance layer includes a material having a variable resistance characteristic used for a resistive random access memory (RRAM), a phase change random access memory (PRAM), a ferroelectric random access memory (FRAM) or a magnetic random access memory (MRAM).
8. A semiconductor device comprising: a plurality of first conductive lines; a plurality of second conductive lines disposed over the first conductive lines to be spaced apart from the first conductive lines; a variable resistance layer disposed above the first conductive line and below the second conductive line; at least one of a first interlayer dielectric layer or a second interlayer dielectric layer, wherein the first interlayer dielectric layer surrounds sidewalls of the first conductive line and the second interlayer dielectric layer surrounds sidewalls of the variable resistance layer; and at least one of a first selector layer or a second selector layer, wherein the first selector layer is disposed above the first conductive line and the first interlayer dielectric layer and below the variable resistance layer and the second interlayer dielectric layer, and the second selector layer is disposed selector layer above the variable resistance layer and the second interlayer dielectric layer and below the second conductive line.
9. The semiconductor device according to claim 8, wherein each of the first selector layer and the second selector layer includes a dielectric material and a dopant.

10. The semiconductor device according to claim 9 wherein the dielectric material includes an oxide, a nitride, an oxynitride, or a combination of two or more of the oxide, the nitride, and the oxynitride.
11. The semiconductor device according to claim 9, wherein the dopant includes one or more of boron (B), nitrogen (N), carbon (C), phosphorous (P), arsenic (As), aluminum (Al), silicon (Si) and germanium (Ge).
12. The semiconductor device according to claim 8, wherein the first selector layer and the second selector layer include the same dielectric material and the same dopant as each other.
13. The semiconductor device according to claim 8, which does not include an upper electrode contact and a lower electrode contact.
14. The semiconductor device according to claim 8, wherein the variable resistance layer includes a material having a variable resistance characteristic used for a resistive random access memory (RRAM), a phase change random access memory (PRAM), a ferroelectric random access memory (FRAM) or a magnetic random access memory (MRAM).
15. A semiconductor device comprising: a first conductive line; a second conductive line disposed over the first conductive line to be spaced apart from the first conductive line; a variable resistance layer disposed above the first conductive line and below the second conductive line; a first selector layer disposed between the first conductive line and the variable resistance layer; and a second selector layer disposed between the variable resistance layer and the second conductive line, wherein each of the first selector layer and the second selector layer includes a dielectric material and a dopant.
16. The semiconductor device according to claim 15, the dielectric material includes an oxide, a nitride, an oxynitride, or a combination of two or more of the oxide, the nitride, and the oxynitride.
17. The semiconductor device according to claim 15, wherein the dopant includes one or more of boron (B), nitrogen (N), carbon (C), phosphorous (P), arsenic (As), aluminum (Al), silicon (Si) and germanium (Ge).
18. The semiconductor device according to claim 15, wherein the first selector layer and the second selector layer include the same dielectric material and the same dopant as each other.
19. The semiconductor device according to claim 15, wherein the semiconductor device does not include an upper electrode contact and a lower electrode contact.
20. The semiconductor device according to claim 15, wherein the variable resistance layer includes a material having a variable resistance characteristic used for a resistive random access memory (RRAM), a phase change random access memory (PRAM), a ferroelectric random access memory (FRAM) or a magnetic random access memory (MRAM).
21. A method for fabricating a semiconductor device comprising: forming a first conductive line over a substrate; forming a second conductive line over the first conductive line to be spaced apart from the first conductive line; forming a variable resistance layer above the first conductive line and below the second conductive line; forming an interlayer dielectric layer including a hole between the first conductive line and the variable resistance layer, between the variable resistance layer and the second conductive line, or both between the first conductive line and the variable resistance layer and between the variable resistance layer and the second conductive line; and performing an ion implantation of a dopant into a portion of the interlayer dielectric layer below the hole and upper portions of the interlayer dielectric layer on both sides of the hole to convert the portion of the interlayer dielectric layer below the hole into a selector layer.
22. The method according to claim 21, wherein each of the selector layer and the interlayer dielectric layer includes an oxide, a nitride, an oxynitride, or a combination of two or more of the oxide, the nitride, and the oxynitride.
23. The method according to claim 21, wherein the dopant includes one or more of boron (B), nitrogen (N), carbon (C), phosphorous (P), arsenic (As), aluminum (Al), silicon (Si) and germanium (Ge).

24. The method according to claim 21, further comprising, after the performing of the ion implantation process, performing a planarization process to remove the upper portions of the interlayer dielectric layer on both sides of the hole in which the dopant is implanted.

25. The method according to claim 24, further comprising, after the performing of the planarization process, forming a contact in the hole.

26. The method according to claim 25, wherein the contact is configured to function as an electrode that electrically connects the selector layer to the variable resistance layer.

27. The method according to claim 21, further comprising, after the performing of the ion implantation process, performing a planarization process to expose a bottom surface of the hole so that upper surfaces of the selector layer and the interlayer dielectric layer are positioned at the same level as each other.

28. The method according to claim 27, further comprising: forming a material layer for forming an electrode layer on the selector layer and the interlayer dielectric layer; and forming an electrode layer by etching the material layer using a mask pattern.

29. The method according to claim 21, wherein, in a case that the semiconductor device includes two selector layers, each of the selector layers includes the same material as each other.

30. The method according to claim 21, wherein the variable resistance layer includes a material having a variable resistance characteristic used for a resistive random access memory (RRAM), a phase change random access memory (PRAM), a ferroelectric random access memory (FRAM) or a magnetic random access memory (MRAM).

31. A method for fabricating a semiconductor device comprising: forming a first conductive line over a substrate; forming a second conductive line over the first conductive line to be spaced apart from the first conductive line; forming a variable resistance layer between the first conductive line and the second conductive line; forming at least one of a first interlayer dielectric layer or a second interlayer dielectric layer, wherein the first interlayer dielectric layer surrounds sidewalls of the first conductive line and the second interlayer dielectric layer surrounds sidewalls of the variable resistance layer; forming at least one of a first dielectric layer or a second dielectric layer, wherein the first dielectric layer is disposed above the first conductive line and the first interlayer dielectric layer and below the variable resistance layer and the second interlayer dielectric layer, and the second dielectric layer is disposed above the variable resistance layer and the second interlayer dielectric layer and below the second conductive line; and performing an ion implantation process on at least one of the first dielectric layer or the second dielectric layer to form at least one of a first selector layer or a second selector layer, wherein the first selector layer is disposed above the first conductive line and the first interlayer dielectric layer and below the variable resistance layer and the second interlayer dielectric layer and the second selector layer is disposed above the variable resistance layer and the second interlayer dielectric layer and below the second conductive line, and the first selector layer and the second selector layer include a dielectric material and a dopant, respectively.

32. The method according to claim 31, wherein the dielectric material includes an oxide, a nitride, an oxynitride, or a combination of two or more of the oxide, the nitride, and the oxynitride.

33. The method according to claim 31, wherein the dopant includes one or more of boron (B), nitrogen (N), carbon (C), phosphorous (P), arsenic (As), aluminum (Al), silicon (Si) and germanium (Ge).

34. The method according to claim 31, further comprising, after the performing of the ion implantation process, performing a planarization process.

35. The method according to claim 31, further comprising, after the forming of the first selector layer, forming a material layer for forming the variable resistance layer on the first selector layer; and forming the variable resistance layer by etching the material layers.

36. The method according to claim 31, further comprising, after the forming of the first selector layer, forming a material layer for forming an electrode layer on the first selector layer; forming a

material layer for forming the variable resistance layer on the material layer for forming the electrode layer; and forming the electrode layer and the variable resistance layer by sequentially etching the material layer for forming the variable resistance layer and the material layer for forming the electrode layer using a mask pattern.

37. The method according to claim 31, further comprising, after the forming of the first selector layer, forming a material layer for forming the variable resistance layer on the first selector layer; and forming the variable resistance layer and a patterned selector layer by etching the material layer for forming the variable resistance layer and the first selector layer using a mask pattern.

38. The method according to claim 31, further comprising, after the forming of the first selector layer, forming a material layer for forming an electrode layer on the first selector layer; forming a material layer for forming the variable resistance layer on the material layer for forming the electrode layer; and forming the variable resistance layer, the electrode layer and a patterned selector layer by etching the material layer for forming the variable resistance layer, the material layer for the electrode layer and the first selector layer through a patterning process.

39. The method according to claim 31, further comprising, after the forming of the second selector layer, forming a patterned selector layer by etching the second selector layer using a mask pattern.

40. The method according to claim 31, wherein the semiconductor device does not include an upper electrode contact and a lower electrode contact.

41. The method according to claim 31, wherein the variable resistance layer includes a material having a variable resistance characteristic used for a resistive random access memory (RRAM), a phase change random access memory (PRAM), a ferroelectric random access memory (FRAM) or a magnetic random access memory (MRAM).
