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Nucleation dynamics of single crystal WS₂ from droplet precursors uncovered by *in-situ* monitoring

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Transition metal dichalcogenides (TMDs) attract intense attention due to its unique optoelectrical features. Recent progress in production stage of TMD enables us to synthesis uniform and large area TMD with mono layer thickness. Elucidation of growth mechanism is a challenge to improve the crystallinity of TMD, which is regarded as a next crucial subject in the production stage. Here we report novel diffusion and nucleation dynamics during tungsten disulphide (WS₂) growth. The diffusion length (L_d) of the precursors have been measured with unique nucleation control methods. It was revealed that the L_d reaches up to ~750 μm . This ultra-long diffusion can be attributed to precursor droplets observed during *in-situ* monitoring of WS₂ growth. The integrated synthesis of >35,000 single crystals and monolayer WS₂ was achieved at the wafer scale based on this model. Our findings are highly significant for both the fundamental study of droplet-mediated crystal growth and the industrial application of integrated single-crystal TMDs.

Transition metal dichalcogenides (TMDs) are among the most well-known layered materials. They have various features that are desirable in semiconductors, including stable neutral and charged excitons, valley polarisation capability, and superconductivity^{1–3}. Recent progress with molten salt-assisted growth^{4,5} in the production stage enabled us to synthesise uniform polycrystalline films on a large scale. Attaining better crystallinity in single crystal films with large domain sizes, uniform edge structures, and fewer vacancies is our next challenge. For this purpose, a deep understanding of the TMD crystal growth mechanism is crucial. The effects of the sulfur/molybdenum (S/Mo) ratio⁶ in MoS₂, the step edge of the substrate⁷, the carrier gas⁸ and nucleation promoters⁹ have been investigated. A theoretical model has also been established using a thermodynamic approach^{10,11}. However, little is known about TMD growth dynamics, their precursors and nucleation in particular, which are important for the synthesis of high-quality single crystals. Herein we report novel diffusion and nucleation dynamics during tungsten disulfide (WS₂) growth. Accurate nucleation-controlled growth enabled us to determine the diffusion length (L_d) of the precursors. L_d reached ~750 μm , nearly two orders of magnitude longer than that of conventional semiconductors such as Si¹², GaAs¹³ and SiC¹⁴. This ultra-long diffusion was attributed to precursor droplets observed during *in-situ* monitoring of WS₂ growth. The integrated synthesis of >35,000 single crystals and monolayer WS₂ was achieved at the wafer scale based on this model. Our findings are highly significant for both the fundamental study of droplet-mediated crystal growth and the industrial application of integrated single-crystal TMDs.

Control of nucleation sites^{15,16} is useful for studying the growth dynamics of 2D crystals. In this study, we used Au dots to precisely control WS₂ nucleation and site density (Fig. 1a–c, Supplementary Fig. 1). Figure 1d shows the results of WS₂ synthesis on a substrate containing an array of Au dots, for which the distance between the centres of the Au dots (L_{Au}) was 20 μm . Triangular WS₂ crystals were grown at the Au sites, thereby demonstrating that precise control of the nucleation sites and their density was possible.

Diffusion length (L_d), an important kinetic parameter of crystal growth, was determined experimentally (Fig. 1c). WS₂ growth was observed only at Au sites, while the SiO₂ substrate remained bare between the Au dots (Fig. 1d). This suggested two nucleation mechanisms were possible. If nearly all of the precursor material delivered to the substrate from the vapor phase was effectively trapped by the Au dots and used for WS₂ growth, L_d could be estimated by Eq. (1).

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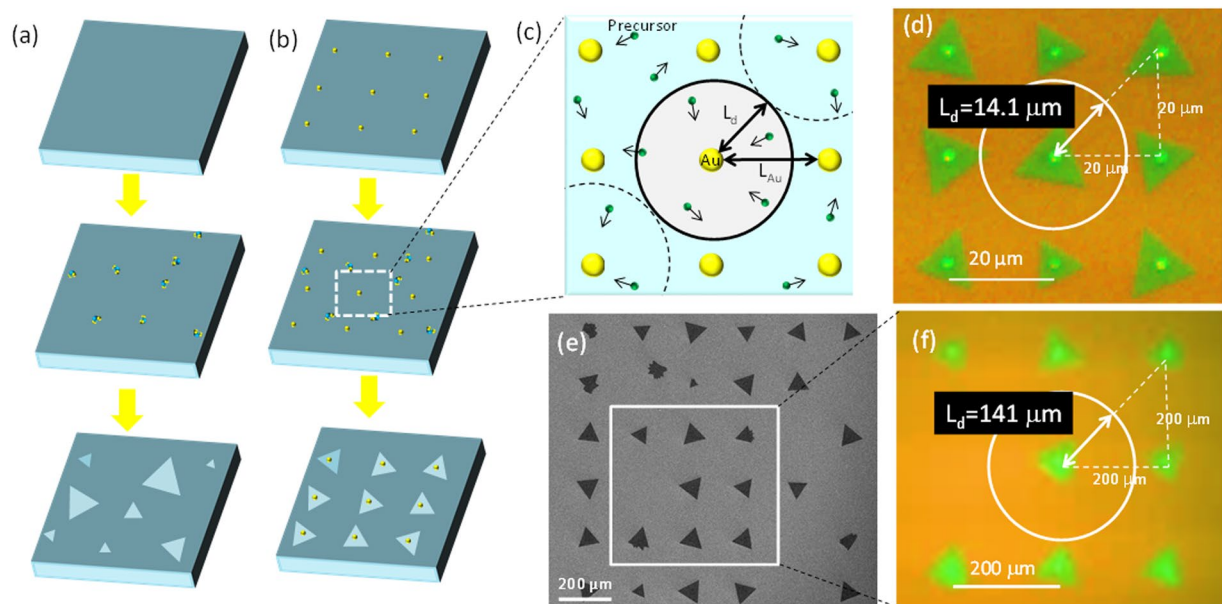


Figure 1. Nucleation control with Au dots. Schematic illustration of TMD growth (a) without and (b) with Au nucleation centre. (c) Correlation between L_d and L_{Au} . (d,f) Optical microscope and (e) SEM images of monolayer and single WS_2 crystals grown on Au pre-patterned substrate, where L_{Au} equals (d) $20\ \mu\text{m}$ and (e,f) $200\ \mu\text{m}$.

$$L_d \approx \sqrt{2}L_{Au}/2. \quad (1)$$

Interestingly, nucleation of single WS_2 crystals was observed only at Au sites even when $L_{Au} \leq 200\ \mu\text{m}$ (Fig. 1e,f), indicating the maximum L_d would be $\geq 140\ \mu\text{m}$. This was surprising, considering the L_d of conventional semiconductor materials such as Si^{12} , $GaAs^{13}$ and SiC^{14} ranges from 0.2 to $30\ \mu\text{m}$ (Supplementary Table 1). It should be noted that if precursors could immediately desorb from the substrate before being trapped by Au, L_d determined by eq. (1) could be an overestimate.

To more accurately determine L_d and observe ultra-long precursor diffusion, we placed diffusion barriers around the Au dots (Fig. 2a). Crystal growth was terminated at the initial growth stage, when the length of each side of the triangular WS_2 crystal (L_{WS_2}) increased with growth time. L_{WS_2} was related to $(\Gamma_{eff}t)^{0.5}$ in our model, where Γ_{eff} and t were the effective precursor flux to the growth edge of WS_2 and growth time, respectively. Γ_{eff} was proportional to $\pi\Gamma_0L_d^2$, where Γ_0 was the influx of vapor-phase precursors to the substrate per unit area (Supplementary Fig. 2). Γ_{eff} was influenced by the length of the diffusion barrier wall (L_{BW}), so L_{WS_2} would change as a function of L_{BW} (Fig. 2a,b). Based on this model, we predicted a region in which L_{WS_2} growth would transition from a quadratic function of L_{BW} to a saturated state (Fig. 2b). L_{BW} would equal $2L_d$ at the inflection point in Fig. 2b.

For the experiment, square diffusion barriers of various sizes were placed on the substrate. Each diffusion barrier was centred around a single Au dot (Fig. 2c). As expected, there was an obvious relationship between L_{WS_2} and L_{BW} (Fig. 2d–g). When L_{BW} was small, L_{WS_2} increased with L_{BW} and reached a point of saturation after reaching the critical threshold of L_{BW} . This indicated the size of WS_2 crystals was governed by diffusion, and that L_d could be determined by the L_{BW} threshold. We found that variation in L_d depended on the position of nucleation on the substrate (P1, P2, P3, P4) within the region where the temperature decreased from $\sim 721\ ^\circ\text{C}$ to $\sim 654\ ^\circ\text{C}$. The maximum L_d of $\sim 750\ \mu\text{m}$ was observed at $721\ ^\circ\text{C}$ (P1) and $698\ ^\circ\text{C}$ (P2) (Fig. 2d,e). The observed ultra-long diffusion was consistent with estimations based on L_{Au} (Fig. 1f). This was the first experimental determination of L_d during TMD growth. The Arrhenius-type correlation can be observed between P2 and P4 positions, where activation energy can be estimated as $\sim 1.1\ \text{eV}$ (Supplementary Fig. S3). This shows the thermal activation of precursors can enhance the diffusion by overcoming the diffusion barriers. Since the L_d is almost same between P1 and P2, which may be decided by the balance between enhancement of L_d with thermal activation and decreasing L_d due to acceleration of desorption from the substrate.

Hopping transport is the predominating model for conventional semiconductors, in which precursors jump between nearest-neighbour (NN) stable sites. Diffusion occurs over a few micrometres within the limited travelling time^{12–14}. When we tried to explain the ultra-long diffusion of WS_2 precursors with this model, the distance covered in a single jump was over 100 times larger than the distance between NN sites. Although ‘long jumping’ during the diffusion of W on a substrate surface has been reported, the longest jumps were only a few times longer than the distance between NN sites^{17,18}. Ultra-long jumps ($100 \times$ NN length) have not been reported for any materials, suggesting that WS_2 precursors diffuse by a different mechanism. A possible mechanism for ultra-long precursor diffusion will be discussed later.

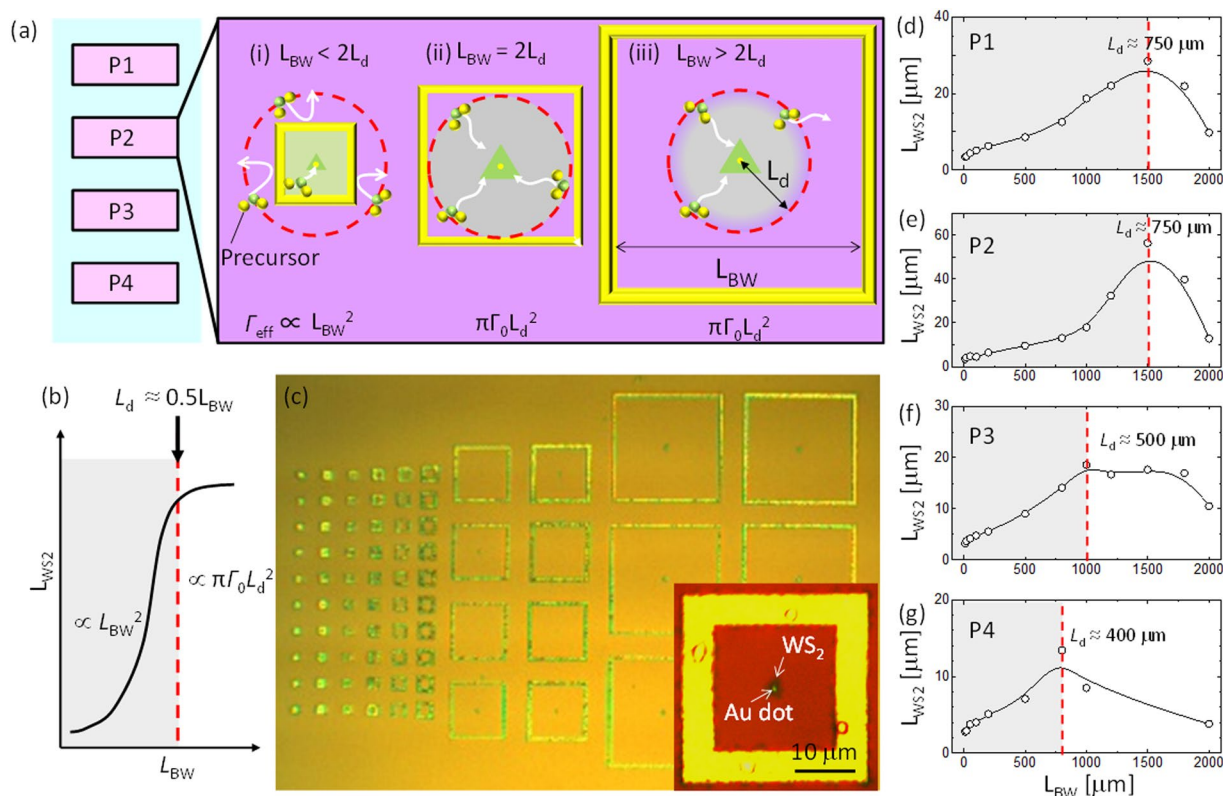


Figure 2. Direct measurement of L_d . (a) The growth region on a single Au dot is surrounded by a square diffusion barrier made by Au. The relationships between L_{WS2} and L_{BW} are (i) $L_{BW} < 2L_d$; (ii) $L_{BW} = 2L_d$; and (iii) $L_{BW} \gg 2L_d$. The effective influx contributing to WS₂ growth (Γ_{eff}) is governed by (i) L_{BW}^2 and (ii, iii) L_d^2 . (b) The predicted relationship between L_{WS2} and L_{BW} . (c) Optical microscope image showing substrate surface after WS₂ growth with the diffusion barriers. Inset in (c) shows the high magnification image of typical WS₂ grown inside of diffusion barrier. Plots of experimental L_{WS2} vs. L_{BW} in different regions of the substrate: (d) P1, (e) P2, (f) P3 and (g) P4, where the temperature was 721, 698, 675, 654 °C, respectively.

To reveal WS₂ growth dynamics, understanding the nucleation phase is important. We varied Au dot shape and diameter (D_{Au}) in a combinatorial experiment (see Methods) to gain insight into the nucleation dynamics of WS₂ (Fig. 3a). There was a strong correlation between nucleus structure and nucleation probability (Fig. 3a,b and Supplementary Fig. S4). Surprisingly, however, the crystallinity of monolayer WS₂ was independent of Au dot shape, and WS₂ single crystals grew on circular, triangular, square, and linear bar-shaped sites. We then varied the D_{Au} of circular Au dots, and WS₂ growth was carried out at different temperatures using a combinatorial method (see Methods, Supplementary Fig. S5). The single WS₂ crystal concentration was higher when growth occurred on smaller Au dots ($D_{Au} \sim 1 \mu\text{m}$) than it was when $D_{Au} \approx 4 \mu\text{m}$ (Fig. 3c). We then changed L_{WS2} by adjusting the growth temperature (Supplementary Figs S5 and S6). When we plotted the single crystal concentration as a function of L_{WS2}/D_{Au} , a clear correlation was observed. The concentration of WS₂ single crystals increased with L_{WS2}/D_{Au} and reached saturation when $(L_{WS2}/D_{Au}) > 6$ (Fig. 3d).

Based on these results, we concluded (i) precursor diffusion length was ultra-long ($\sim 750 \mu\text{m}$); (ii) single crystals could grow on Au dot structures with various shapes; and (iii) there was a clear correlation between single crystal concentration and L_{WS2}/D_{Au} . We could then propose a plausible model for the diffusion and nucleation of precursors (Fig. 3e). Since the shapes of the Au dots were not sensitive to the WS₂ structure (Fig. 3a,b), we surmised that a circular precursor puddle could form around the Au dot prior to the initiation of 2D growth. Polycrystalline WS₂ would grow when the diameter of the precursor puddle was less than D_{Au} (Supplementary Fig. S6). Following this logic, precursors would diffuse on the substrate in droplet form rather than as single molecules. This could explain the ultra-long diffusion of precursors on the SiO₂ substrate (Fig. 2). It is known that interaction between droplets and the substrate occurs via physisorption rather than chemisorption^{19,20}. This is completely different from atomic and molecular diffusion, where NN hopping is dominant due to strong chemical interactions with the substrate surface^{12–14}. Physisorbed droplets move easily on the SiO₂ surface for a relatively long time^{19,20}, which would enable ultra-long diffusion. The stability of droplets can be evaluated by the Young-Laplace (YL) equation²¹:

$$\Delta P = 2\gamma/r. \quad (2)$$

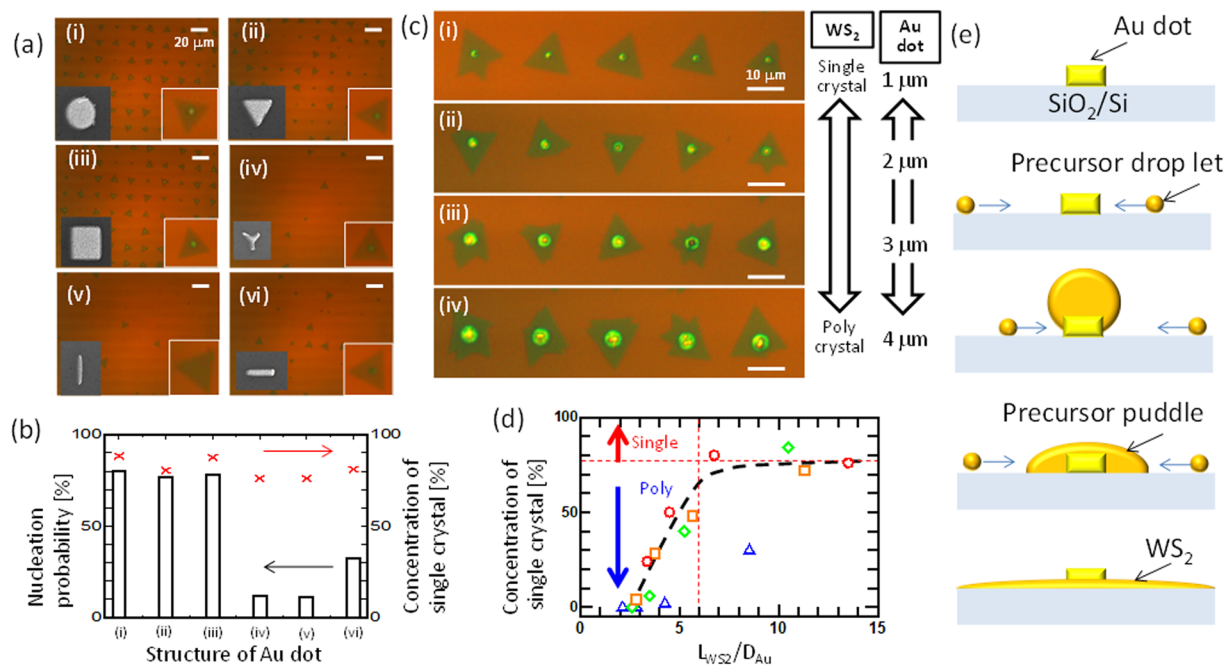


Figure 3. Nucleation of WS₂ at Au sites. **(a)** Optical microscope images of WS₂ grown from various Au dot structures (i–vi). Left and right of inset in (i–vi) show the SEM image of Au dot structures used for each growth and typical WS₂ grown from each Au dot, respectively. **(b)** Dependence of WS₂ growth shape on Au dot size. **(c)** Optical microscope images of WS₂ grown on Au dots of varying size (D_{Au}): (i) 1 μm, (ii) 2 μm, (iii) 3 μm and (iv) 4 μm. **(d)** Concentration of single WS₂ crystals as a function of L_{WS_2}/D_{Au} . Growth temperatures: ○ 816 °C, □ 800 °C, ◇ 795 °C, △ 773 °C. **(e)** Schematic illustration of droplet-induced nucleation dynamics.

Here, ΔP is the difference between the droplet pressure (P_{in}) and vapor pressure (P_{out}) at the interface; γ is the surface tension of the droplet; and r is the droplet radius. For the droplet to be stable, ΔP should be as small as possible. This means that materials with low γ are more stable, especially at the nanoscale ($r < 500$ nm). The γ of molten metal droplets can be reduced by increasing the temperature²², reducing droplet size²³, and mixing with oxygen²⁴. It can be surmised that nanoscale droplets containing $W_xS_yO_z$ at high temperatures would exhibit very low surface tension, making them candidate precursor droplets. Since the physical properties of nanoscale droplets themselves are not yet fully understood²⁵, the identification of precursor droplet components is an important step for achieving a detailed understanding of WS₂ growth dynamics.

To confirm the unique growth dynamics of droplet-induced nucleation, we attempted to observe the nucleation phase directly via *in-situ* monitoring (see Methods, Supplementary Fig. S7). The increase of L_{WS_2} was observed in real time, confirming that *in-situ* monitoring of WS₂ crystal growth was possible (Fig. 4a–c, Supplementary Fig. S8, Supplementary Movie). To the best of our knowledge, this is the first result realizing the *in-situ* monitoring of TMD growth as real time optical images. When we carefully examined the nucleation with high-magnification images, an interesting transformation was observed (Fig. 4d–f). At the initiation of growth, circular structures formed around the naturally existing nucleation centre (Fig. 4d,g). These changed to triangular shapes during the growth stage (Fig. 4e,f,h,i). This was consistent with the model shown in Fig. 3e, indicating the precursor puddle formed just after nucleation around the nucleation centre. Similar transformations from precursor puddles to WS₂ were observed at many nucleation sites (Fig. 4j, Supplementary Fig. S9). This established the veracity of droplet-induced growth dynamics (Figs 3e and 4g–i). We also found that ~41% of the precursor puddles transformed to WS₂ during the growth stage. The state of the precursor puddle and the driving force causing the transformation from liquid to solid should be important factors in deciding this transformation. Further studies are needed to clarify these fundamental subjects. It should be noted that some WS₂ crystals began to grow without the obvious formation of a precursor puddle, suggesting several growth models could apply to the nucleation of TMD. Recently, a vapor-liquid-solid (VLS) growth model was reported for the catalyst-guided growth of MoS₂ nanoribbons²⁶. In the growth of 2D WS₂ demonstrated in our study, it was not a catalyst but the precursor itself in liquid form that diffused over long distances. This differed significantly from the mechanism of nanoribbon growth.

Based on our growth model, precise adjustments of D_{Au} , L_{Au} and growth temperature were made in a combinatorial experiment (see Methods, Supplementary Fig. S10). These systematic adjustments produced the conditions required for integrated synthesis of single WS₂ crystals, which was governed by a balance between nucleation probability and single crystal growth (Supplementary Fig. S11). Under the most suitable growth conditions, integrated WS₂ was grown on a 1.5 cm × 1.5 cm region that covered the entire substrate (Fig. 5a). Optical microscope (Fig. 5b) and scanning electron microscope (SEM) (Fig. 5c) images indicated that triangular WS₂ crystals grew on the Au dots in high yields (>87%). Measurement by atomic force microscopy (AFM) revealed the thickness

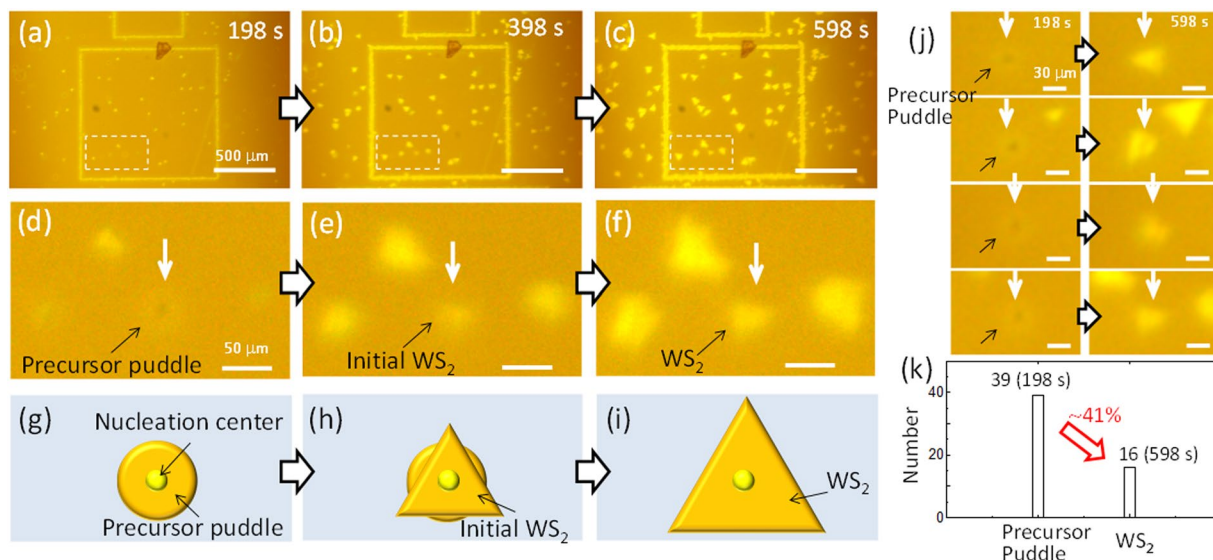


Figure 4. *In-situ* monitoring of WS₂ growth. Low- and high-magnification optical microscope images from *in-situ* monitoring of WS₂ growth at (a,d) 198 s, (b,e) 398 s and (c,f) 598 s. Where growth time: 0 s corresponds to the time when all process temperatures (main furnace, sulphur oven, and AH) were stabilized. Schematic illustration of nucleation model from (g) droplet puddle to (h,i) 2D WS₂. (j), Optical microscope images of typical precursor puddles transferred to WS₂. (k), Number of precursor puddles at 198 s and WS₂ formed from the precursor puddles at 598 s.

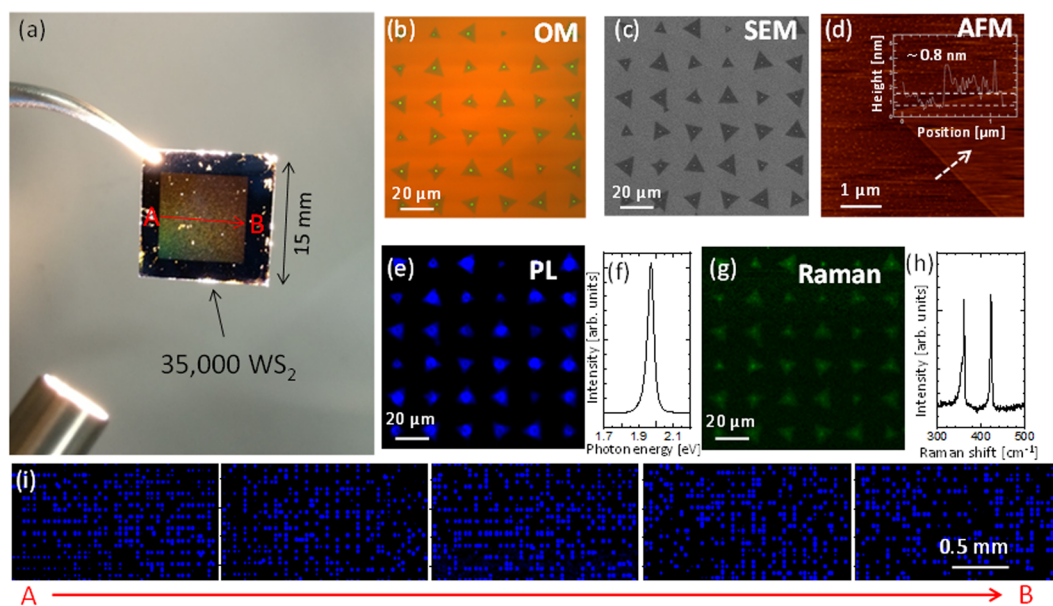


Figure 5. Position selective large-scale synthesis of single WS₂ crystals. (a) Optical microscope image of WS₂ array grown on a 1.5 cm × 1.5 cm wafer substrate. Images of WS₂ array grown on Au dots: (b) optical microscope, (c) SEM, (d) AFM, (e) PL intensity map, (g) Raman intensity map. Raw (f) PL and (h) Raman scattering spectra of WS₂ grown on Au dot. (i) Large-scale WS₂ PL intensity map from A to B on the wafer in (a).

of WS₂ was approximately 0.8 nm (Fig. 5d). The crystalline WS₂ shown in the photoluminescence (PL) intensity map in Fig. 5e exhibited bright PL with a sharp emission peak at 1.97 eV (Fig. 5f). The Raman spectra of WS₂ contained two peaks separated by 61 cm⁻¹ (Fig. 5g,h), indicating WS₂ grown by this method was a monolayered, single-crystal structure¹. PL intensity mapping was performed over a large area between A and B in Fig. 5a, and uniform PL was observed across the whole 1.5 cm width of the substrate (Fig. 5i). These results indicated that >35,000 single WS₂ crystals could be grown with accurate position control. It should be mentioned that the Au dot is remained in the center of WS₂ even after the growth. Detailed analysis around Au dot is shown in supporting information (Fig. S3). Although the PL can be quenched around the Au dot region, the Au dot size can be

minimized below 300 nm through the adjustment of growth temperature (Fig. S10). In the case of relatively long channel device such as thin film transistors, the Au dot below 300 nm may be considered as a small single defect, which may not cause significant depression of whole device performance.

In summary, we have revealed the detailed growth dynamics of monolayer and single-crystal WS₂. Through control of nucleation with Au dots and diffusion barriers, the L_d reach up to ~750 μm, which was almost two orders of magnitude longer than that of conventional semiconductor materials. The combinatorial experiment demonstrated that ultra-long diffusion could be explained by precursor droplet formation. Precursor droplets collected around the Au dots to form precursor puddles before 2D growth commenced. The balance between the size of the puddle and the Au dot was important in determining the probability of single WS₂ crystal growth. *In-situ* monitoring established the accuracy of droplet-induced growth dynamics. Based on this model, integrated synthesis of monolayer and single-crystal WS₂ was realised at the wafer scale. Over 35,000 single crystals and monolayer WS₂ were grown on a 1.5 cm² substrate. This insight into the growth dynamics of single-crystal WS₂ may serve as an impetus to move the study of TMDs from fundamental research to practical applications. Controlling the diffusion of precursor droplets may provide an alternate means of controlling TMD crystallinity.

Methods

Preparation of Au dot arrays. The Au dot arrays were fabricated on a SiO₂/Si substrate by electron beam lithography (EBL) on an ELS-7500 EBL system (ELIONIX Inc., Japan) and thermal evaporation of Au (see Supplementary Information for more details). The thickness of each Au dot was fixed at 50 nm.

Chemical vapor deposition (CVD). WS₂ was synthesised by thermal CVD using WO₃ as a tungsten source. Ar was used as the carrier gas at a flow rate of 150–450 sccm. Sulphur (0.5 g) was placed in the CVD oven (Supplementary Fig. S7), and WO₃ (40 mg) on a quartz boat was set 15 cm downstream in the centre of the CVD furnace. For *in-situ* monitoring, NaCl (6 mg) was mixed into the WO₃ to enhance evaporation.

Combinatorial experiment. An array of Au dots 100, 300, 500, 750 and 1000 nm in diameter was prepared on a large SiO₂/Si substrate (Supplementary Fig. S10) placed 7 cm from the centre of the furnace. Since the temperature in this section decreased sharply from 860 to 700 °C within a 2-cm region with 975 °C of centre of furnace temperature, it was possible to control the growth temperature and Au dot size/shape in the same experiment.

Raman and PL mapping. A J/Y Raman/PL system was used for Raman and PL mapping. He/Ne (632.8 nm) and Ar (488 nm) lasers were used for excitation. Mapping was performed in steps of 200–500 nm.

***In-situ* monitoring.** The optical microscope was set above the quartz tube between the main electrical furnace and additional heater (AH). To maintain the elevated temperature of the substrate, an AH was placed outside the main electrical furnace. The substrate was set between the main furnace and the heater, enabling optical observation of the substrate surface during CVD growth (Supplementary Fig. S7).

Data Availability

The authors declare that the data supporting the findings of this study are available within the article and its supplementary figures, table, and movie files.

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Author Contributions

T. Kato supervised this project and conceived and designed the experiments. C.L., T. Kameyama, T.T. and T. Kato performed the synthesis and characterization of WS₂. T. Kato and T. Kaneko co-wrote the manuscript.

Additional Information

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