



US006861680B2

(12) **United States Patent**
Ker et al.

(10) **Patent No.:** **US 6,861,680 B2**
(45) **Date of Patent:** **Mar. 1, 2005**

(54) **SILICON-ON-INSULATOR DIODES AND ESD PROTECTION CIRCUITS**

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(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

(21) Appl. No.: **10/315,158**

(22) Filed: **Dec. 10, 2002**

(65) **Prior Publication Data**

US 2003/0080386 A1 May 1, 2003

Related U.S. Application Data

(62) Division of application No. 09/783,870, filed on Feb. 15, 2001, now abandoned.

(51) **Int. Cl.**⁷ **H01L 31/072**

(52) **U.S. Cl.** **257/199; 257/212; 257/603; 257/551; 257/347; 257/349; 327/504; 327/584; 327/586; 438/311**

(58) **Field of Search** **257/199, 212, 257/603, 551, 347, 349; 327/504, 584, 586; 438/311**

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Primary Examiner—Nathan J. Flynn

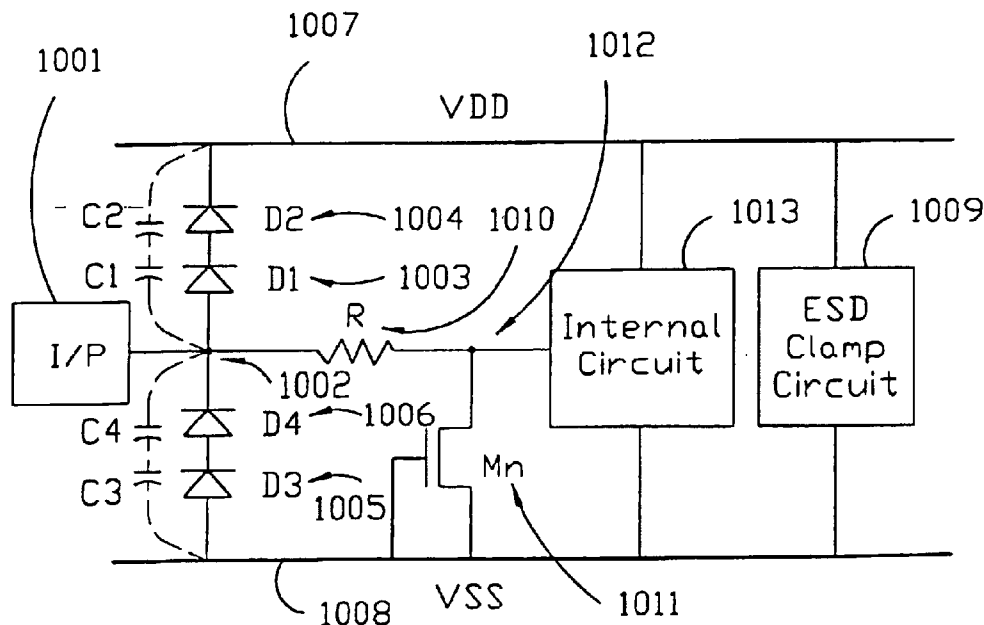
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(57) **ABSTRACT**

A silicon-on-insulator (SOI) gated diode and non-gated junction diode are provided. The SOI gated diode has a PN junction at the middle region under the gate, which has more junction area than a normal diode. The SOI non-gated junction diode has a PN junction at the middle region thereof, and also has more junction area than a normal diode. The SOI diodes of the present invention improve the protection level offered for electrical overstress (EOS)/electrostatic discharge (ESD) due to the low power density and heating for providing more junction area than normal ones. The I/O ESD protection circuits, which comprise primary diodes, a first plurality of diodes, and a second plurality of diodes, all of which are formed of the present SOI diodes, could effectively discharge the current when there is an ESD event. And the ESD protection circuits, which comprise more primary diodes, could effectively reduce the parasitic input capacitance, so that they can be used in the RF circuits or HF circuits. The proposed gated diode and non-gated diode can be fully process-compatible to general partially-depleted or fully-depleted silicon-on-insulator CMOS processes.

7 Claims, 7 Drawing Sheets



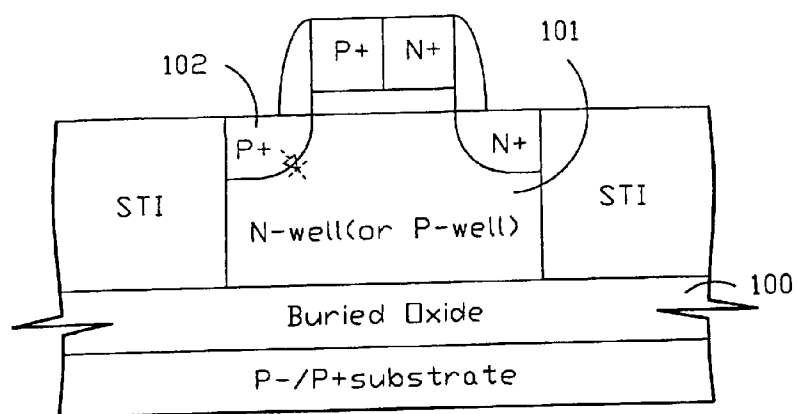


FIG.1(PRIOR ART)

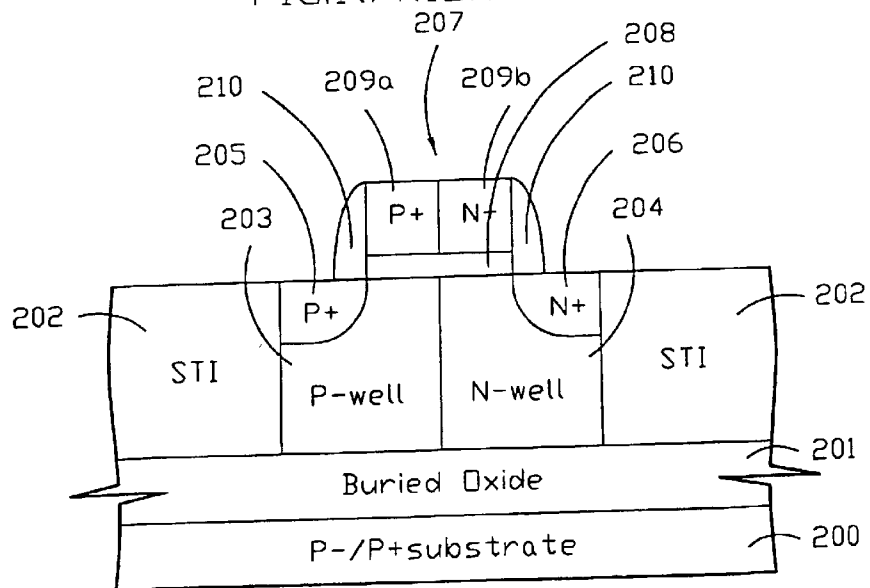


FIG.2

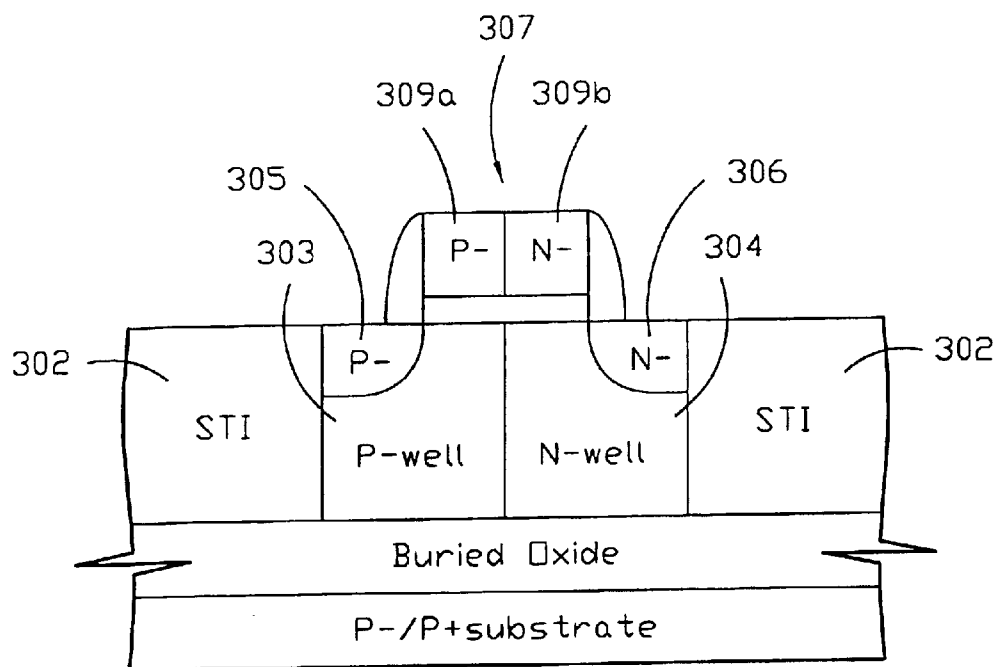


FIG. 3

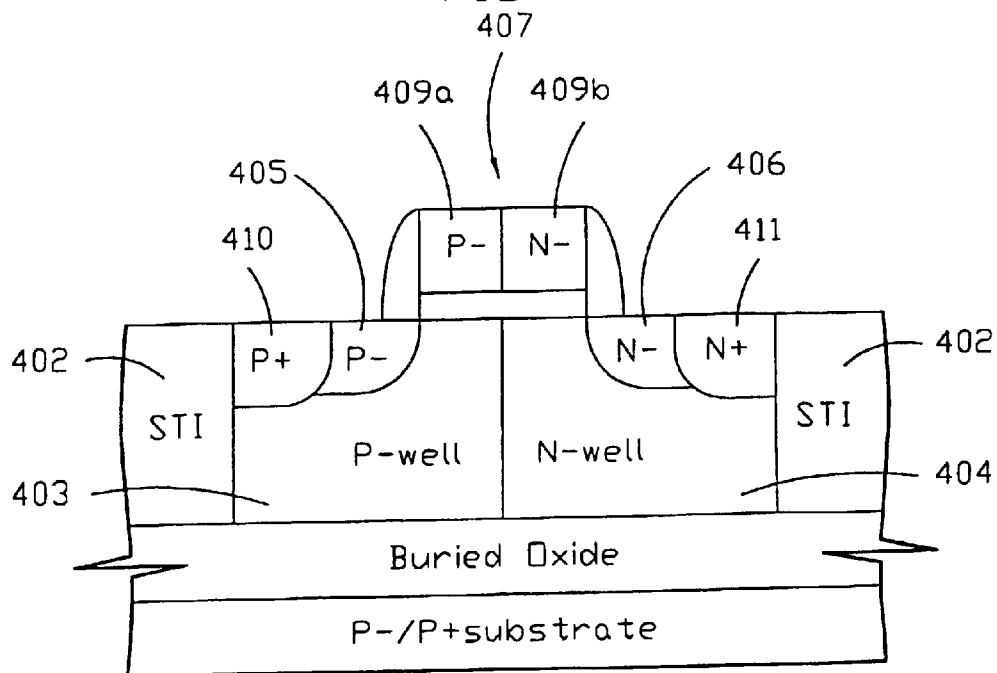


FIG. 4

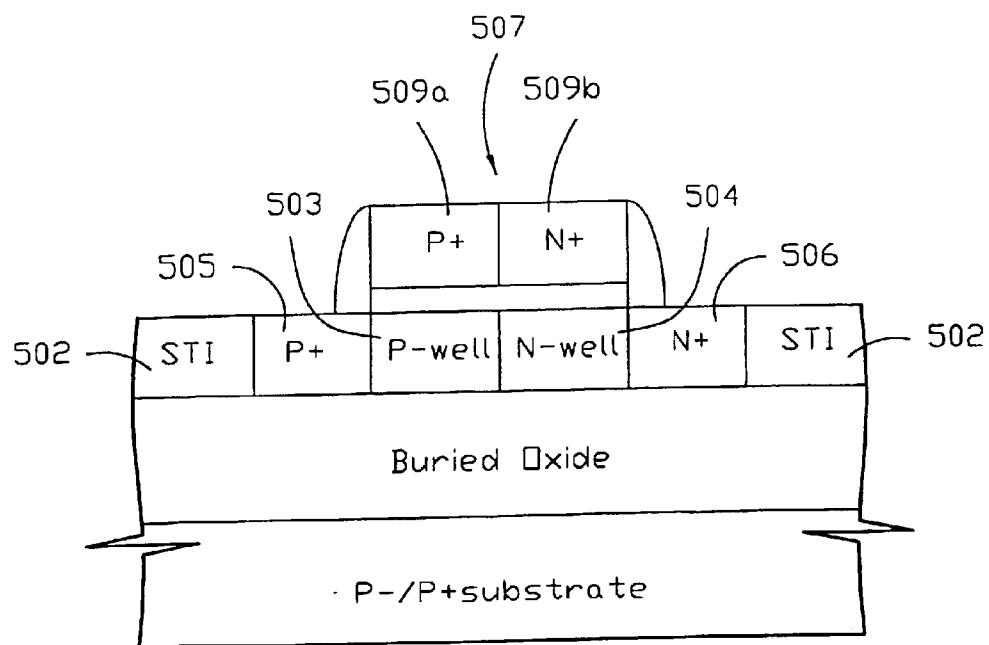
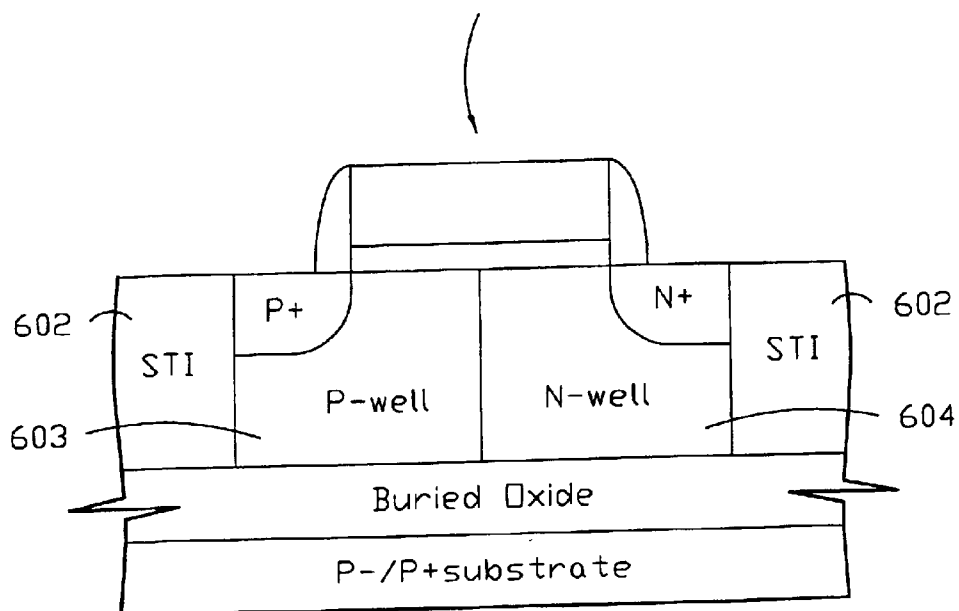
FIG.5
607

FIG.6

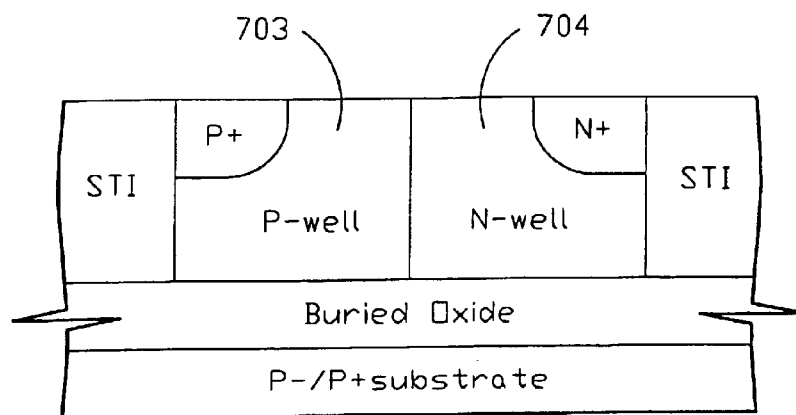


FIG.7

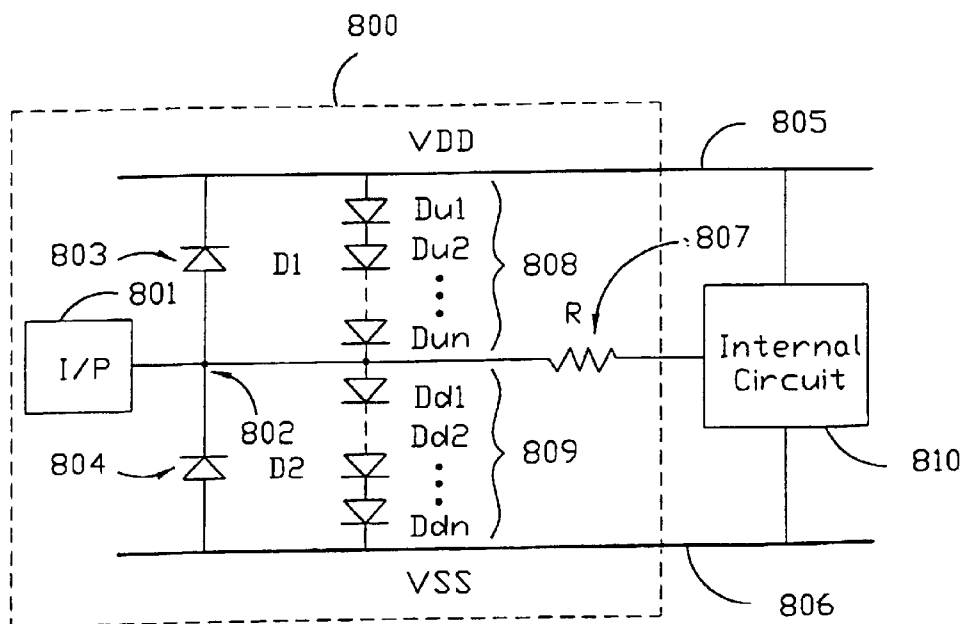


FIG.8

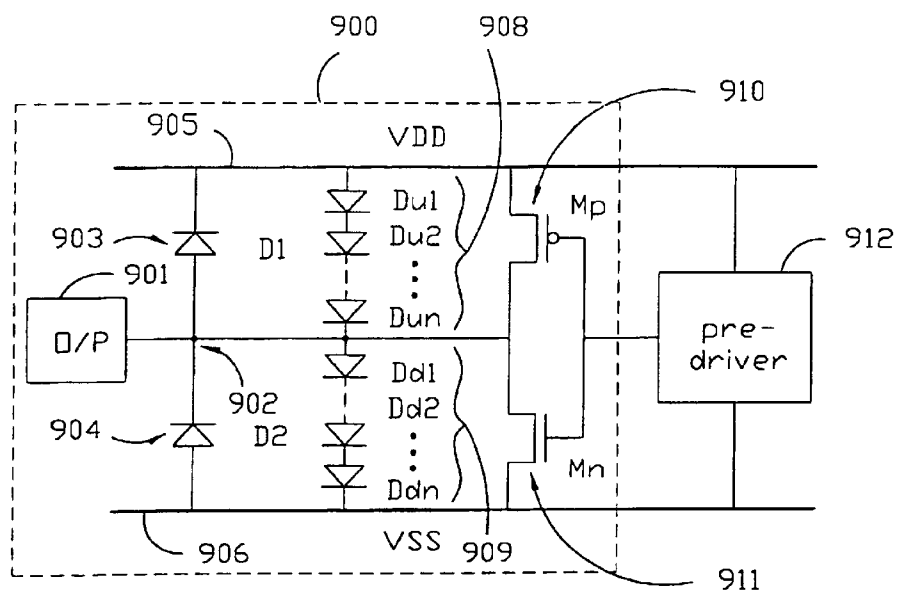


FIG. 9

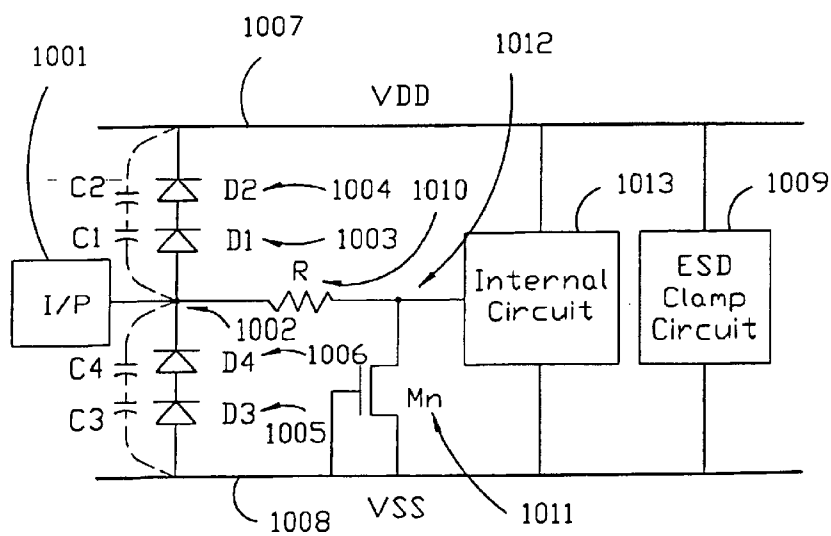


FIG. 10

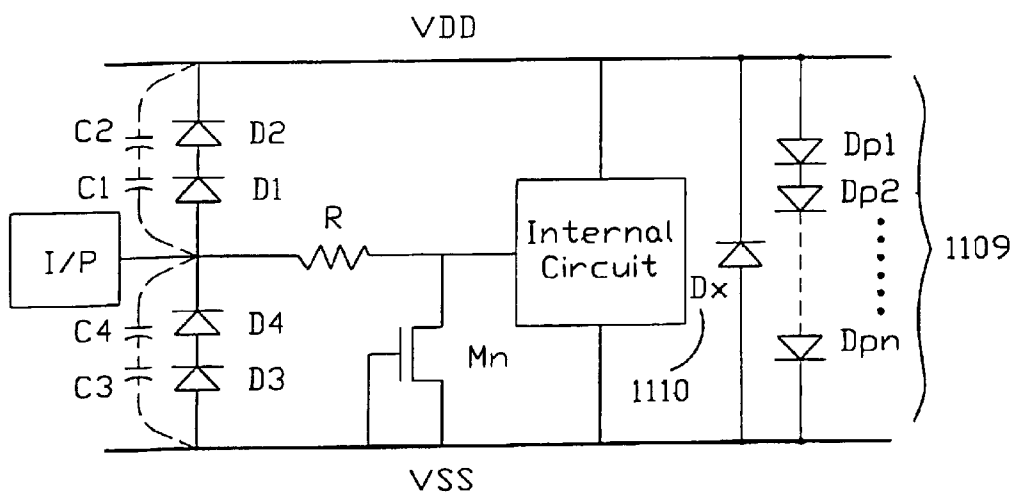


FIG.11

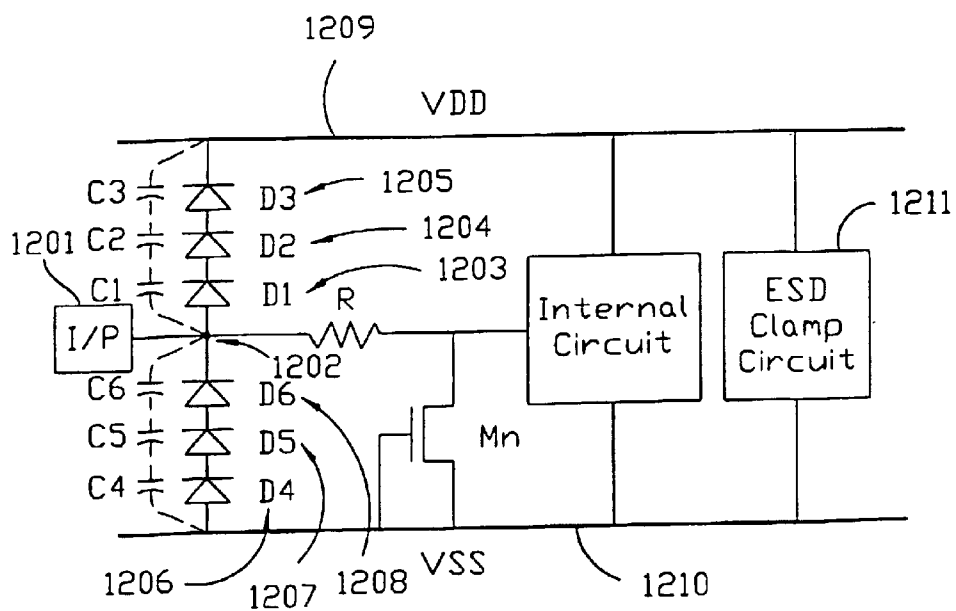


FIG.12

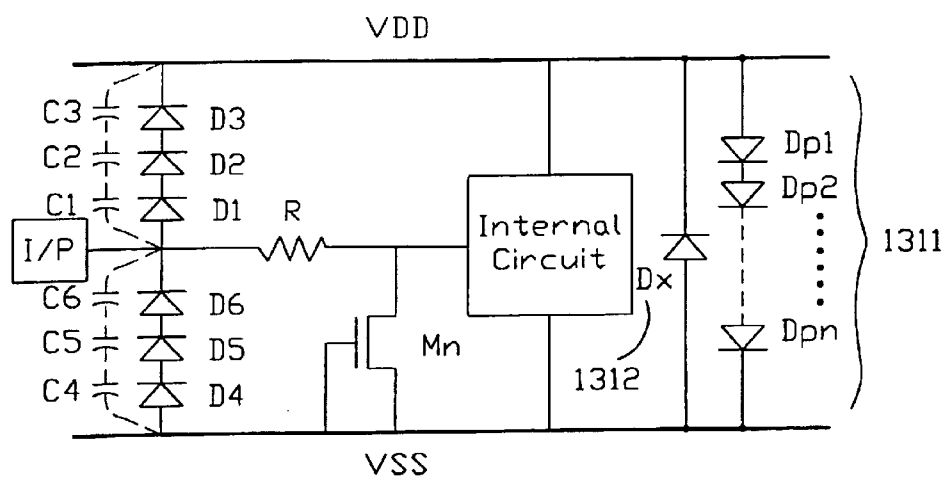


FIG.13

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SILICON-ON-INSULATOR DIODES AND ESD PROTECTION CIRCUITS

This is a division of U.S. Pat. No. 09/783,870 filed Feb. 15, 2001, now abandoned.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to diodes in a silicon-on-insulator (SOI) CMOS process, and more particularly to ESD protection circuits with the diodes in a silicon-on-insulator CMOS process.

2. Description of the Prior Art

Silicon-on-insulator technology is a prime contender for low-voltage, high-speed applications because of its advantages over bulk-Si technology in reduced process complexity, latch-up immunity and smaller junction capacitance. However, electrostatic discharge (ESD) is a major reliability concern for SOI technology.

The protection level provided by an ESD protection device is determined by the amount of current that it can sink. The device failure is initiated by thermal runaway and is followed by catastrophic damage during an ESD pulse. In SOI devices, the presence of the buried oxide layer having a thermal conductivity $1/100^{th}$ of Si causes increased device heating, which in turn accelerates thermal runaway.

FIG. 1 depicts a cross-sectional view of a prior SOI diode, called a Lubistor diode, published in Proc. Of EOS/ESD Symp., 1996, pp. 291–301. If the silicon layer above the buried oxide layer **100** is doped N-type dopant, the junction of the SOI diode is P+ **102**/N well **101**. The two terminals of this junction diode are V1 connected to P+ **102** and V2 connected to N well **101**. If V1 is positive relative to V2, the SOI diode is under forward biased. However, if V1 is negative relative to V2, the diode is under reverse biased. If the P+ **102**/N well **101** (or N+/P well) junction area in which the power is generated during an ESD event is smaller, then it will increase power density and heat. The heat is generated in a localized region at the P-N junction and the dominant component of the heat at the junction is Joule heat. Secondary breakdown is assumed to occur when the maximum temperature in the SOI diode reaches the intrinsic temperature ($T_{intrinsic}$). In order to get better ESD protection level, one should reduce the power density and Joule heat.

Accordingly, it is desirable to provide a diode with lower power density in silicon-on-insulator CMOS process for ESD protection.

SUMMARY OF THE INVENTION

It is one object of the present invention to provide a silicon-on-insulator diode with more junction area than a normal one, thereby a lower power density and heating are obtained, and the protection level offered for electrical overstress (EOS)/electrostatic discharge (ESD) is improved.

It is another object of the present invention to provide a silicon-on-insulator diode with more junction area than a normal one, which could be used in the I/O ESD protection circuit and the Vdd-to-Vss ESD protection circuit under forward biased condition.

It is a further object of the present invention to provide an I/O ESD protection circuit having SOI diodes with more junction area than normal ones, which can reduce the parasitic input capacitance, and could serve as the I/O ESD protection circuit in the RF circuits or HF circuits.

In order to achieve the above objects, the present invention provides a silicon-on-insulator diode and ESD protec-

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tion circuit thereof. The silicon-on-insulator diode comprises a substrate, an insulating layer, two shallow trench isolations, and a PN junction diode formed of a first well with a first conductive type having either of N type and P type and a second well with a second conductive type opposite to the first conductive type. The insulating layer is formed on the substrate and then the two shallow trench isolations are formed thereon. The PN junction diode is formed between the two shallow trench isolations. The ESD protection circuit having the SOI diodes comprises an electrically conductive pad, a conductor segment, a first voltage supply rail, a second voltage supply rail, a first diode, a second diode, a first plurality of diodes and a second plurality of diodes, all of which are fabricated on the insulating layer. The conductor segment connects the pad directly to a first node. The first diode connects between the first node and the first voltage supply rail, and the second diode connects between the first diode and the second voltage supply rail. The first plurality of diodes connect between the first node and the first voltage supply rail, which are opposite to the first diode's direction. The second plurality of diodes connect between the first node and the second voltage supply rail, which are opposite to the second diode's direction.

BRIEF DESCRIPTION OF THE DRAWINGS

The foregoing and other advantages and features of the invention will be apparent from the following more particular description of preferred embodiments of the invention, as illustrated in the accompanying drawings in which:

FIG. 1 is a cross-sectional view of the structure of a prior SOI polysilicon-bounded diode called a Lubistor diode;

FIG. 2 is a cross-sectional view of a diode with the junction at the middle region under the gate according to the present invention;

FIG. 3 is a cross-sectional view of another diode structure with the junction at the middle region under the gate according to the present invention;

FIG. 4 is a cross-sectional view of another diode structure on a SOI wafer with integrated source/drain implants and the junction is at the middle region under the gate;

FIG. 5 is a cross-sectional view of the structure of a gated diode in the fully-depleted SOI CMOS process;

FIG. 6 is a cross-sectional view of a gated diode with the junction at the middle region under the gate;

FIG. 7 is a cross-sectional view of a non-gated junction diode with the junction at the middle region;

FIG. 8 and FIG. 9 are schematic diagrams of SOI ESD protection circuits for I/O pins in accordance with alternative embodiments of FIG. 2 to FIG. 7 of the present invention;

FIG. 10 and FIG. 11 are schematic diagrams of SOI ESD protection circuits in accordance with alternative embodiments of FIG. 2 to FIG. 7 of the present invention; and

FIG. 12 and FIG. 13 respectively are variations of FIG. 10 and FIG. 11.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

FIG. 2 is a cross-sectional view of a gated diode according to the present invention. The structure of FIG. 2 comprises a substrate **200**, for example, a P- substrate or P+ substrate, and an insulating layer **201**, such as a buried silicon dioxide layer, formed thereon. Two shallow trench isolations **202** are

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formed on the insulating layer **201**, and a P-well **203** based on a silicon layer and an N-well **204** based on a silicon layer are formed on the insulating layer **201** between the two shallow trench isolations **202**. The P-well **203** and the N-well **204** constitute a PN junction. A first highly doped P+ diffusion region **205** is formed at the upper corner of the P-well **203** adjacent to the one shallow trench isolation **202**, and a second highly doped N+ diffusion region **206** is formed at the upper corner of N-well **204** adjacent to the other shallow trench isolation **202**. A MOS-like gate **207** is formed on the P-well **203** and the N well **204**, and the junction of the P well **203** and the N-well **204** is at the middle region under the MOS-like gate **207**. The MOS-like gate **207** comprises a dielectric layer **208**, a polysilicon gate formed on the dielectric layer **208**, consisting of a third highly doped P+ diffusion gate region **209a** and a fourth highly doped N+ diffusion gate region **209b**, and a dielectric spacer **210** formed on each side of the MOS-like gate **207**. The third highly doped P+ diffusion region **209a** and the fourth highly doped N+ diffusion region **209b** are connected together electrically by a conductor layer (not shown in the figure) formed on the polysilicon gate, preferably a silicide layer. Besides, the first highly doped P+ diffusion region **205** and the second highly doped N+ diffusion region **206** are respectively self-aligned with the third highly doped P+ diffusion region **209a** and the fourth highly doped N+ diffusion region **209b**.

The SOI diode is formed by the P-well **203** and the N-well **204**, and the PN junction of the SOI diode is at the middle region under the MOS-like gate **207**. Since the present diode with the P-well **203**/N-well **204** junction has more junction area than the normal Lubistor diode with P+/N-well or N+/P-well in FIG. 1, the ESD protection level are raised by the present diode due to the low power density and heating.

FIG. 3 is a cross-sectional view of an alternate embodiment that is a variation of FIG. 2. A first lightly doped P-diffusion region **305** is formed at the upper corner of the P-well **303** adjacent to one shallow trench isolation **302**, and a second lightly doped N- diffusion region **306** is formed at the upper corner of the N-well **304** adjacent to the other shallow trench isolation **302**. The MOS-like polysilicon gate **307** comprises a third lightly doped P- diffusion gate region **309a** and a fourth lightly doped N- diffusion gate region **309b**. The third lightly doped P- diffusion region **309a** and the fourth lightly doped N- diffusion region **309b** are connected together electrically with a conductor layer (not shown in the figure) formed on the MOS-like polysilicon gate **307**, preferably a silicide layer.

The SOI diode is also formed by the P-well **303** and the N-well **304**. The PN junction of the diode is at the middle region under the MOS-like polysilicon gate **307**.

FIG. 4 is a cross-sectional view of an alternate embodiment that is a variation of the embodiment shown FIG. 3. In this alternate embodiment, a fifth highly doped P+ diffusion region **410** is formed at the upper corner of the P-well **403** between one shallow trench isolation **402** and the first lightly doped P- diffusion region **405**, and a sixth highly doped N+ diffusion region **411** is formed at the upper corner of the N-well **404** between the other shallow trench isolation **402** and the second lightly doped N- diffusion region **406**. The MOS-like polysilicon gate **407** comprises a third lightly doped P- diffusion region **409a** and a fourth lightly doped N- diffusion region **409b**. The third lightly doped P- diffusion gate region **409a** and the fourth lightly doped N- diffusion gate region **409b** are connected together electrically by a conductor layer (not shown in the figure) formed on the MOS-like polysilicon gate **407**, preferably a silicide layer.

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The SOI diode is formed by the P-well **403** and the N-well **404**. The PN junction of the diode is at the middle region under the MOS-like polysilicon gate **407**.

FIG. 5 is a cross-sectional view of an alternate embodiment that is a variation of FIG. 2. The silicon thickness in this silicon-on-insulator (SOI) structure is fully depleted by a first highly doped P+ diffusion region **505** and a second highly doped N+ diffusion region **506**. The SOI diode is also formed by the P-well **503** and the N-well **504**, and the PN junction of the diode is at the middle region under the MOS-like polysilicon gate **507**.

FIG. 6 is a cross-sectional view of an alternate embodiment that is a variation of FIG. 2. In this alternate embodiment, there is no diode in the MOS-like polysilicon gate **607**. However, the MOS-like polysilicon gate **607** can be a highly doped or lightly doped P type diffusion region or N-type diffusion region. The SOI diode is also formed by the P-well **603** and the N-well **604**, and the PN junction of the diode is at the middle region under the MOS-like polysilicon gate **607**.

FIG. 7 is a cross-sectional view of an alternate embodiment that is a variation of FIG. 2. In this embodiment, there is no gate structure and is named a non-gated junction diode. The SOI diode is also formed by the P-well **703** and the N-well **704**.

FIG. 8 is one embodiment of an SOI ESD protection circuit comprising SOI diodes in accordance with the alternative embodiments of FIG. 2 to FIG. 7. The ESD protection circuit **800** comprises an electrically conductive input pad **801**, two primary diodes D1 **803** and D2 **804**, a Vdd voltage supply rail **805**, a Vss voltage supply rail **806**, an input resistor **807**, a first plurality of diodes (Du1 to Dun) **808** connected in series and a second plurality of diodes (Dd1 to Ddn) **809** connected in series. All of these diodes are formed by the SOI diodes in accordance with the alternative embodiments of FIG. 2 to FIG. 7. The input pad **801**, the Vdd voltage supply rail **805**, the Vss voltage supply rail **806**, and the input resistor **807** are fabricated on the insulating layer as with the SOI diodes.

The input pad **801** is directly connected to a first node **802** through a conductor segment. The primary diode D1 **803** is connected between the first node **802** and the Vdd voltage supply rail **805**, and the primary diode D2 **804** is connected between the first node **802** and the Vss voltage supply rail **806**. The first plurality of diodes (Du1 to Dun) **808** are connected between the first node **802** and the Vdd voltage supply rail **805**, and these diodes' direction is opposite to the primary diode D1 **803**. The second plurality of diodes (Dd1 to Ddn) are connected between the first node **802** and the Vss voltage supply rail **806**, and these diodes' direction is opposite to the primary diode D2 **804**. The input resistor **807** is connected between the first node **802** and a portion of the internal circuit **810** to be protected by the ESD protection circuit **800**. The input resistor **807** can also be coupled to an input buffer of the internal circuit **810**, and then a second node is located between the input resistor **807** and the input buffer.

When the ESD event involves the application of a positive voltage to the input pad **801** relative to the Vdd voltage supply rail **805**, the primary diode D1 **803** is forward biased and the primary diode D2 **804** is not active because the Vss voltage supply rail **806** is floating. As a result, the associated ESD current is discharged to the Vdd voltage supply rail **805** through the primary diode D1 **803**.

Similarly, when the ESD protection event involves the application of a negative voltage to the input pad **801**

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relative to the Vss voltage supply rail **806**, the primary diode **D2 804** is forward biased and the primary diode **D1 803** is not active because the Vdd voltage supply rail **805** is floating. The ESD event is discharged to the Vss voltage supply rail **806** through the primary diode **D2 804**.

When the ESD event involves the application of a voltage to the input pad **801**, which is negative with respect to the Vdd voltage supply rail **805**, the primary diode **D1 803** is reversed. At this condition, the Vss voltage supply rail **806** is floating. The first plurality of diodes (Du1 to Dun) **808** is forward biased under this ESD zapping condition, therefore the ESD current is discharged through the first plurality of diodes (Du1 to Dun).

When the ESD event involves the application of a voltage to the input pad **801** which is positive with respect to the Vss voltage supply rail **806**. The primary diode **D2 804** is reverse biased. At this condition, the Vdd voltage supply rail **805** is floating. The secondary plurality of diodes (Dd1 to Ddn) **809** is forward biased under this ESD zapping condition, therefore, the ESD current is discharged through the secondary plurality of diodes (Dp1 to Dpn).

FIG. 9 illustrates another embodiment of an SOI ESD protection circuit comprising the SOI diodes in accordance with the alternative embodiments of FIG. 2 to FIG. 7. The ESD protection circuit **900** comprises an electrically conductive output pad **901**, primary diodes **D1 903** and **D2 904**, a Vdd voltage supply rail **905**, a Vss voltage supply rail **906**, a first plurality of diodes (Du1 to Dun) **908** connected in series, and a second plurality of diodes (Dd1 to Ddn) **909** connected in series. All of these diodes are formed of the SOI diodes in accordance with the alternative embodiments of FIG. 2 to FIG. 7. The output pad **901**, the Vdd voltage supply rail **905**, and the Vss voltage supply rail **906** are fabricated on the insulating layer as with the SOI diodes.

The output pad **901** is directly connected to a node **902** by a conductor segment. The primary diode **D1 903** is connected between the node **902** and the Vdd voltage supply rail **905**, and the primary diode **D2 904** is connected between the node **902** and the Vss voltage supply rail **906**. The first plurality of diodes (Du1 to Dun) **908** are connected between the node **902** and the Vdd voltage supply rail **905**, and these diodes' direction is opposite to the primary diode **D1 903**. The second plurality of diodes (Dd1 to Ddn) **909** are connected between the node **902** and the Vss voltage supply rail **906**, and these diodes' direction is opposite to the primary diode **D2 904**. The node **902** is connected to the output terminal of an output buffer formed of a P-channel transistor **910** and an N-channel transistor **911**. The input terminal of the output buffer is connected to a pre-driver **912**.

When the ESD event involves the application of a positive voltage to the output pad **901** relative to the Vdd voltage supply rail **905**, the primary diode **D1 903** is forward biased and the primary diode **D2 904** is not active because the Vss voltage supply rail **906** is floating. As a result, the associated ESD current is discharged to the Vdd voltage supply rail **905** through the primary diode **D1 903**.

Similarly, when the ESD event involves the application of a negative voltage to the output pad **901** relative to the Vss voltage supply rail **906**, the primary diode **D2 904** is forward biased and the primary diode **D1 903** is not active because the Vdd voltage supply rail **905** is floating. The ESD event is discharged to the Vss voltage supply rail **906** through the primary diode **D2 904**.

When the ESD event involves the application of a voltage to the output pad **901**, which is negative with respect to the

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Vdd voltage supply rail **905**, the primary diode **D1 903** is reverse biased. The Vss voltage supply rail **906** is floating under this condition. The first plurality of diodes (Du1 to Dun) **908** is forward biased under this ESD-zapping condition, therefore the ESD current is discharged through the first plurality of diodes (Du1 to Dun). When the ESD event involves the application of a voltage to the output pad **901** which is positive with respect to the Vss voltage supply rail **906**, the primary diode **D2 904** is reverse biased. The Vdd voltage supply rail **905** is floating during this ESD event. The secondary plurality of diodes (Dd1 to Ddn) **909** is forward biased under this ESD-zapping condition, therefore, the ESD current is discharged through the secondary plurality of diodes (Dd1 to Ddn) **909**.

FIG. 10 illustrates a further embodiment of an SOI ESD protection circuit comprising the SOI diodes in accordance with the alternative embodiments of FIG. 2 to FIG. 7. The ESD protection circuit comprises an electrically conductive input pad **1001**, primary diodes **D1 1003**, **D2 1004**, **D3 1005** and **D4 1006**, an input resistor **1010**, an n-channel transistor **1011**, a Vdd voltage supply rail **1007**, a Vss voltage supply rail **1008** and an ESD clamp circuit **1009**. The primary diodes **D1 1003** and **D2 1004** are connected in series, and the primary diodes **D3 1005** and **D4 1006** are connected in series. All of these diodes are formed by the SOI diodes in accordance with the alternative embodiments of FIG. 2 to FIG. 7. The input pad **1001**, the input resistor **1010**, the Vdd voltage supply rail **1007**, and the Vss voltage supply rail **1008** are fabricated on the insulating layer as with the SOI diodes.

The input pad **1001** is directly connected to a first node **1002** through a conductor segment. The primary diodes **D1 1003** and **D2 1004** are connected between the first node **1002** and the Vdd voltage supply rail **1007**. The primary diodes **D3 1005** and **D4 1006** are connected between the first node **1002** and the Vss voltage supply rail **1008**. The input resistor **1010** and the n channel transistor **1011** are coupled in series between the input pad **1001** and the Vss voltage supply rail **1008**. And, the input resistor **1010**, the n channel transistor **1011** and the internal circuit **1013** are coupled through a second node **1012**. The gate and source of the n channel transistor **1011** are coupled to the Vss voltage supply rail **1008**. The ESD clamp circuit **1009** is connected between the Vdd voltage supply rail **1007** and the Vss voltage supply rail **1008**.

Two primary diodes **D1 1003** and **D2 1004** are connected between the input pad **1001** and the Vdd voltage supply rail **1007** instead of one diode **D1** in FIG. 8, and other two diodes **D3 1005** and **D4 1006** are connected between the input pad **1001** and the Vss voltage supply rail **1008** instead of one diode **D2** in FIG. 8. If diode **D1**'s parasitic junction capacitance is **C1**, diode **D2**'s parasitic junction capacitance is **C2**, diode **D3**'s parasitic junction capacitance is **C3**, and diode **D4** parasitic junction capacitance is **C4**. The input capacitance is $C_{in}=C1+C2$ in FIG. 8, but in this embodiment, the input capacitance becomes $C_{in}'=[C1C2/(C1+C2)]+[C3C4/(C3+C4)]$. If the diodes (**D1**, **D2**, **D3**, **D4**) are identity, that means $C1=C2=C3=C4=C$, then $C_{in}'=2C$ in FIG. 8 and $C_{in}'=C$ in FIG. 10. Therefore, the parasitic input capacitance of this embodiment is reduced, and then the RC time constant is also reduced. By the lowering of the input delay, the ESD protection circuit of this embodiment could be applied in RF circuits or in HF circuits.

FIG. 11 is an alternative of FIG. 10. The Vdd-to-Vss ESD clamping circuit comprises a plurality of first SOI diodes (Dp1 to Dpn) **1109** and a second SOI diode **1110** connected in parallel between the Vdd voltage supply rail and the Vss

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voltage supply rail. All the diodes used in this ESD protection circuit are in accordance with the alternative embodiments illustrated in FIG. 2 to FIG. 7.

FIG. 12 is a variation of FIG. 10. In this ESD protection circuit, there are three diodes D1 1203, D2 1204, and D3 1205 in series between the Vdd voltage supply rail 1209 and the input pad 1201, and three diodes D4 1206, D5 1207, and D6 1208 in series between the Vss voltage supply rail 1210 and the input pad 1201. All of the diodes used in this ESD protection circuit are in accordance with the alternative embodiments of FIG. 2 to FIG. 7. The input capacitance becomes $C_{in}' = [C1C2C3 / (C1C2 + C2C3 + C1C3)] + [C4C5C6 / (C4C5 + C5C6 + C4C6)] = \frac{2}{3}C$, which further to be reduced.

FIG. 13 is an alternative of FIG. 12. The Vdd-to-Vss ESD clamping circuit comprises a plurality of first SOI diodes (Dp1 to Dpn) 1311 and a second SOI diode 1312 connected in parallel between the Vdd voltage supply rail and the Vss voltage supply rail. All the diodes used in this ESD protection circuit are in accordance with the alternative embodiments of FIG. 2 to FIG. 7.

According to the foregoing, the present invention provides advantages as follows:

1. The present invention provides a SOI diode with low power density due to increasing the PN junction area.
2. The present invention provides a SOI diode with improved ESD protection level.
3. The present invention provides that a SOI diode could be used in mixed-voltage and analog/digital circuits. The present SOI diodes also could serve as the I/O ESD protection circuit, and the Vdd-to-Vss protection circuit under forward biased condition.
4. The present invention provides an ESD protection circuit with reduced input capacitance, and could serve as the I/O ESD protection circuit in the RF circuits or HF circuits.

The preferred embodiments are only used to illustrate the present invention, not intended to limit the scope thereof. Many modifications of the preferred embodiments can be made without departing from the spirit of the present invention.

What is claimed is:

1. An electrostatic discharge (ESD) protection circuit for protecting a silicon-on-insulator integrated circuit formed over an insulating layer, said ESD protection circuit comprising:

- an electrically conductive pad fabricated over said insulating layer;
- a conductor segment fabricated over said insulating layer, said conductor segment connecting said pad directly to a first node;
- a first voltage supply rail fabricated over said insulating layer;
- a second voltage supply rail fabricated over said insulating layer;

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a first primary diode fabricated over said insulating layer and connected between said first node and said first voltage supply rail;

a second primary diode fabricated over said insulating layer and connected between said first node and said second voltage supply rail;

an ESD clamp circuit fabricated over said insulating layer and connected between said first voltage supply rail and said second voltage supply rail;

a resistor fabricated over said insulating layer and coupled between said first node and a second node coupled to a portion of said integrated circuit; and

an channel transistor fabricated over said insulating layer, both of the gate and source of said n channel transistor connected to said second voltage supply rail, and the drain of said n channel transistor coupled to said second node.

2. The ESD protection circuit of claim 1, wherein said ESD clamp circuit comprises a plurality of diodes, and coupled in series between said first voltage supply rail and said second voltage supply rail, said diode's direction being opposite to said first primary diode and said second primary diode.

3. The ESD protection circuit of claim 1, further comprising a third primary diode fabricated over said insulating layer and connected between said first primary diode and said first voltage supply rail, and a fourth primary diode fabricated over said insulating layer and connected between said second primary diode and said second voltage supply rail.

4. The ESD protection circuit of claim 3, wherein said ESD clamp circuit comprises a plurality of diodes, and coupled in series between said first voltage supply rail and said second voltage supply rail, said diode's direction being opposite to said first primary diode and said second primary diode.

5. The ESD protection circuit of claim 3, further comprising a fifth primary diode fabricated over said insulating layer and connected between said third primary diode and said first voltage supply rail, and a sixth primary diode fabricated over said insulating layer and connected between said fourth primary diode and said second voltage supply rail.

6. The ESD protection circuit of claim 5, wherein said ESD clamp circuit comprises a plurality of diodes, and coupled in series between said first voltage supply rail and said second voltage supply rail, said diode's direction being opposite to said first primary diode and said second primary diode.

7. The ESD protection circuit of claim 1, wherein all of said diodes are formed of SOI diodes in said ESD protection circuit.

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