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Schubert et al.

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(54) **DEVICES, SYSTEMS, AND METHODS
RELATED TO REMOVING PARASITIC
CONDUCTION IN SEMICONDUCTOR
DEVICES**

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H01L 29/42316; H01L 29/7786
See application file for complete search history.

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5, 2012, now Pat. No. 9,082,748.

(57) **ABSTRACT**

(51) **Int. Cl.**

H01L 29/15 (2006.01)
H01L 29/423 (2006.01)

(Continued)

Semiconductor devices and methods for making semicon-
ductor devices are disclosed herein. A method configured in
accordance with a particular embodiment includes forming
a stack of semiconductor materials from an epitaxial sub-
strate, where the stack of semiconductor materials defines a
heterojunction, and where the stack of semiconductor mate-
rials and the epitaxial substrate further define a bulk region
that includes a portion of the semiconductor stack adjacent
the epitaxial substrate. The method further includes attach-
ing the stack of semiconductor materials to a carrier, where
the carrier is configured to provide a signal path to the
heterojunction. The method also includes exposing the bulk
region by removing the epitaxial substrate.

(52) **U.S. Cl.**

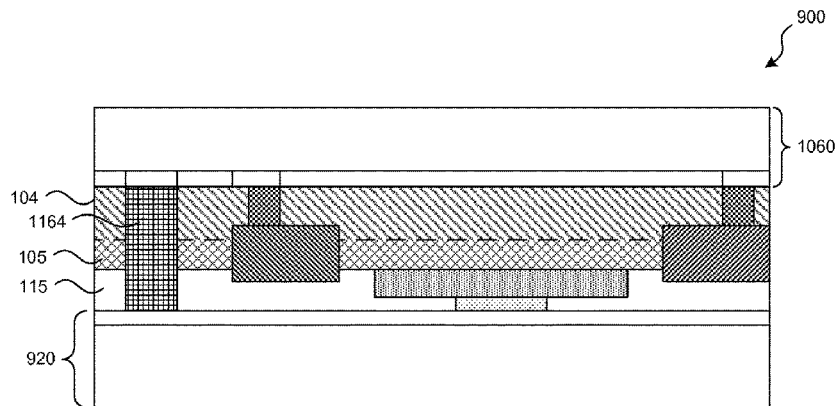
CPC **H01L 29/42316** (2013.01); **H01L 29/0603**
(2013.01); **H01L 29/205** (2013.01);

(Continued)

17 Claims, 6 Drawing Sheets

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H01L 29/778 (2006.01)
H01L 29/20 (2006.01)
H01L 29/417 (2006.01)

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29/4175 (2013.01); *H01L 2224/16227*
 (2013.01)

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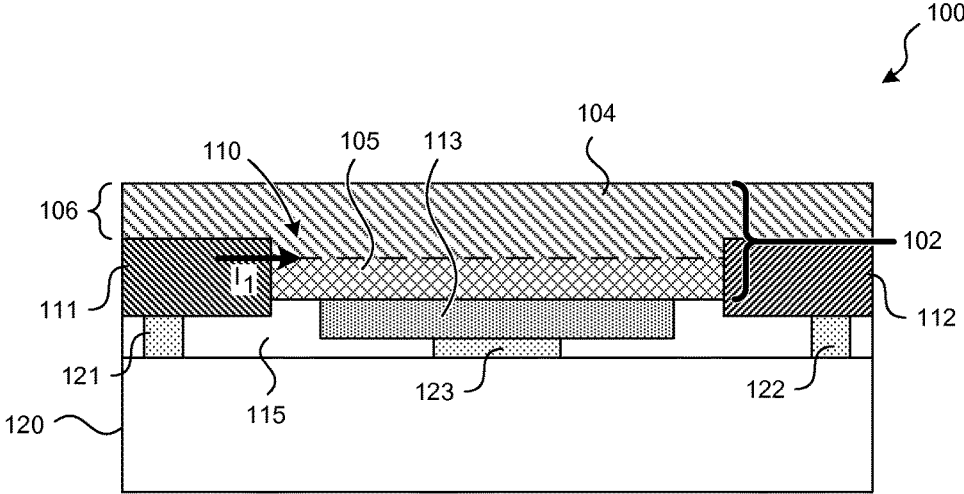


FIG. 1

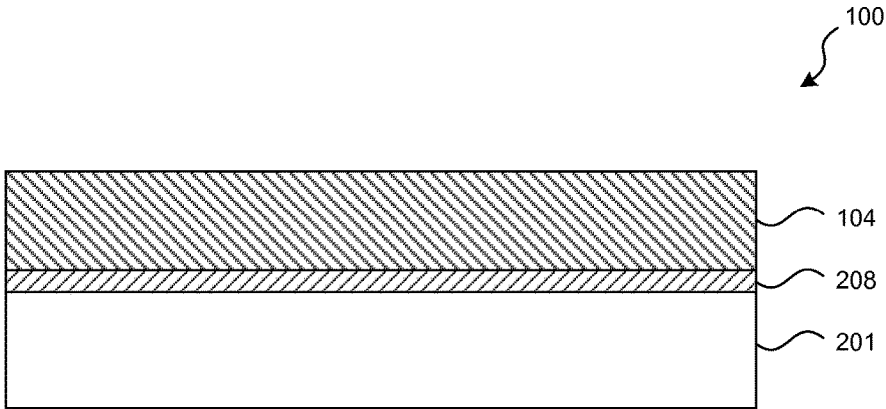


FIG. 2

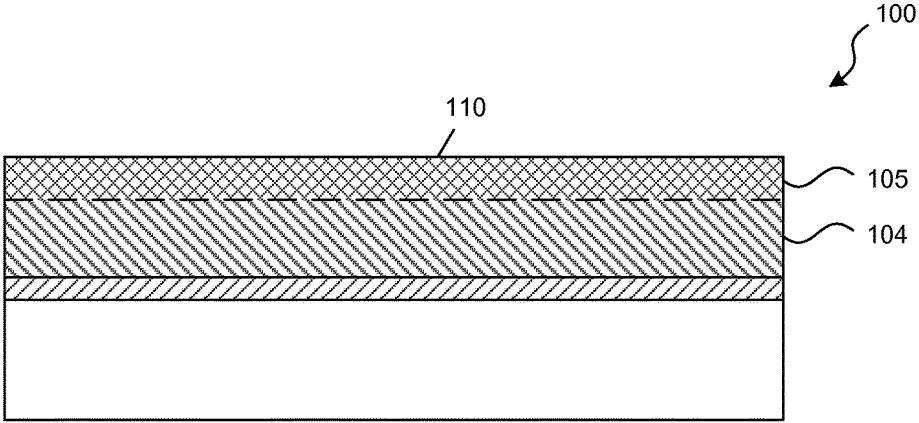


FIG. 3

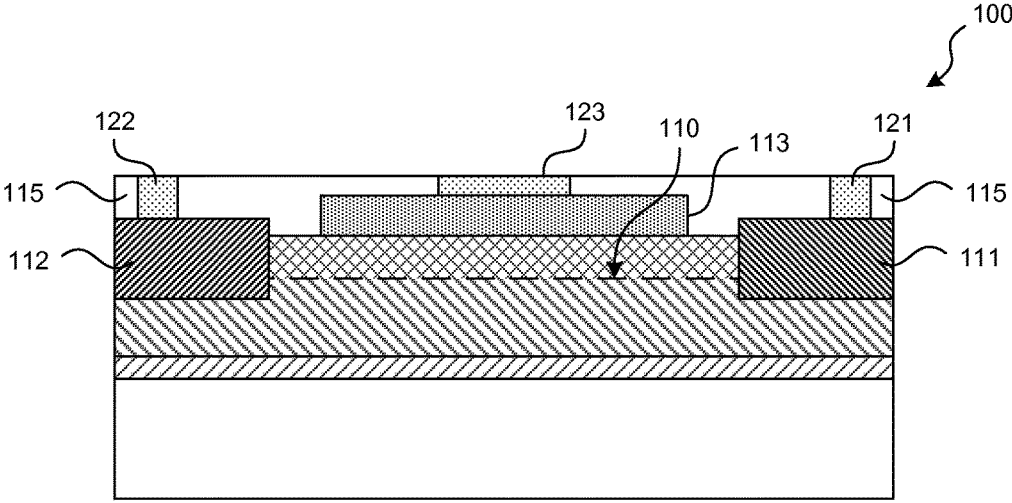


FIG. 4

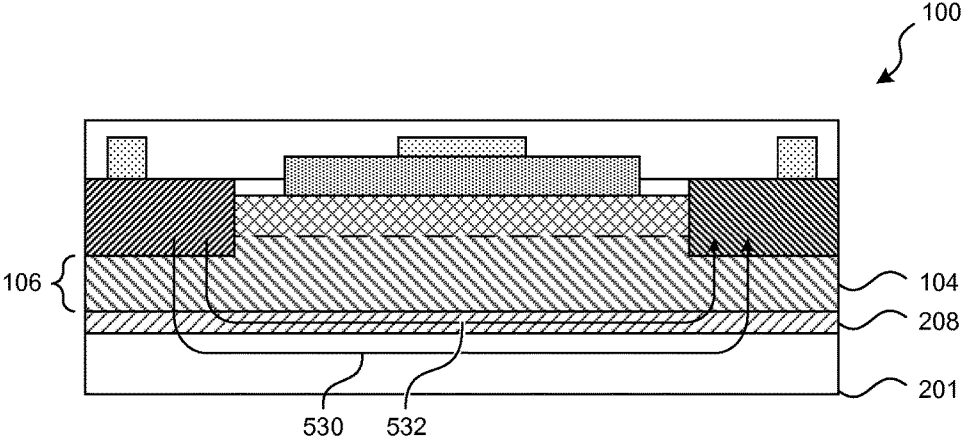


FIG. 5

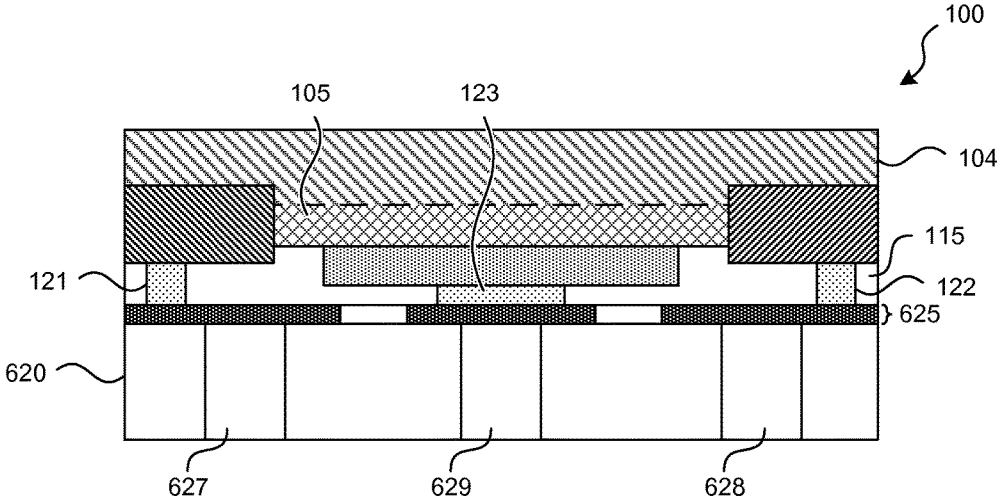


FIG. 6

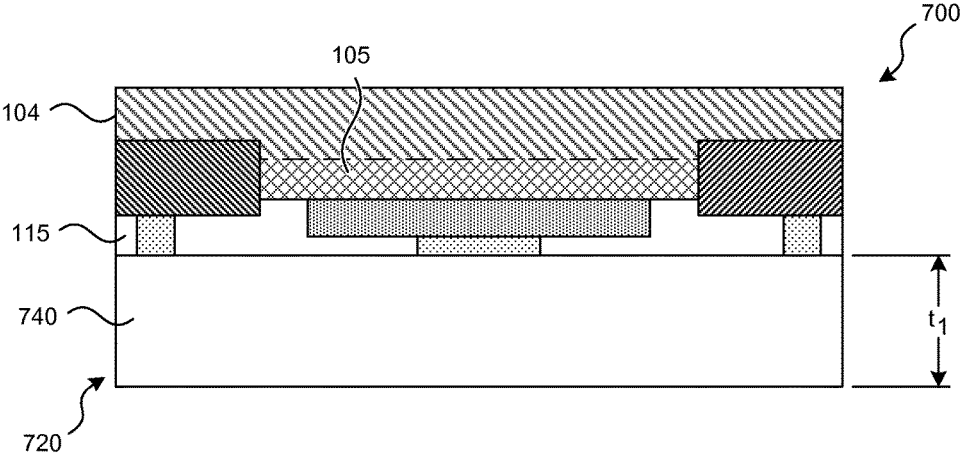


FIG. 7

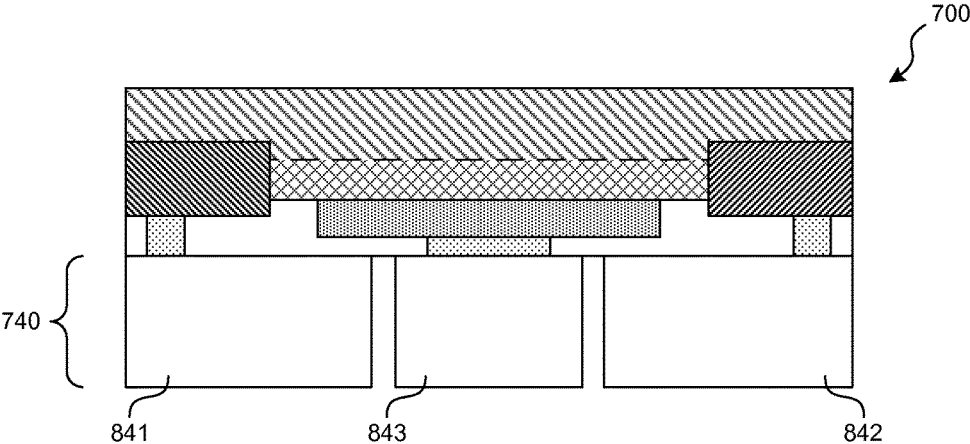


FIG. 8

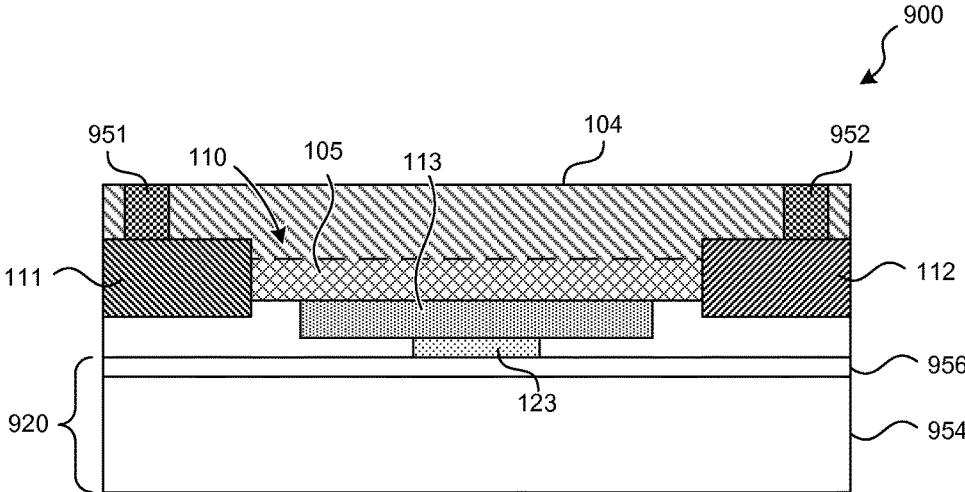


FIG. 9

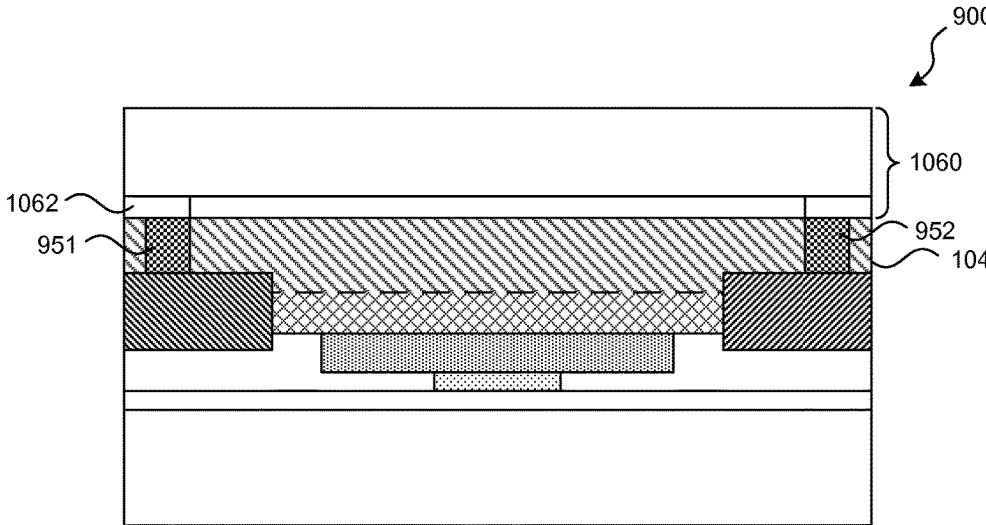


FIG. 10

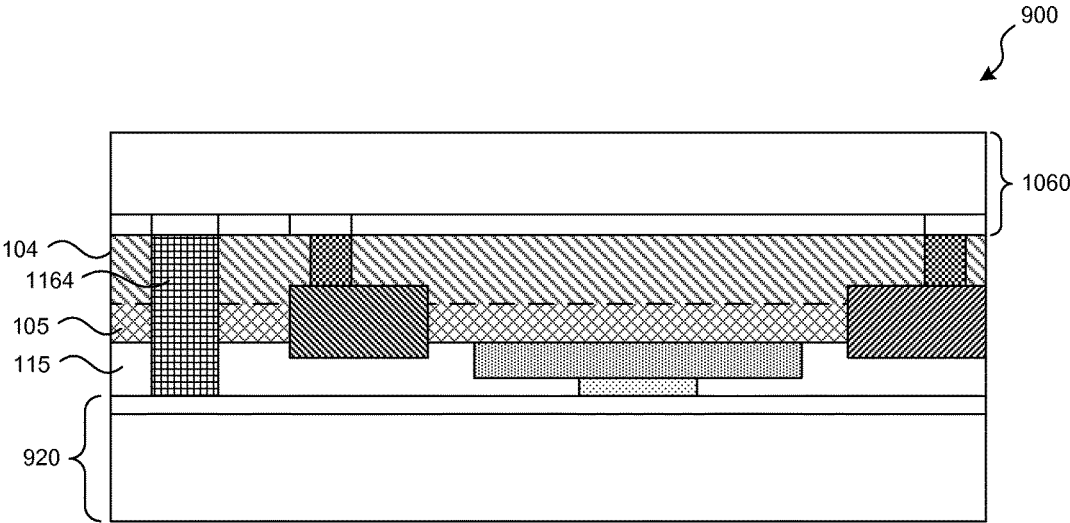


FIG. 11

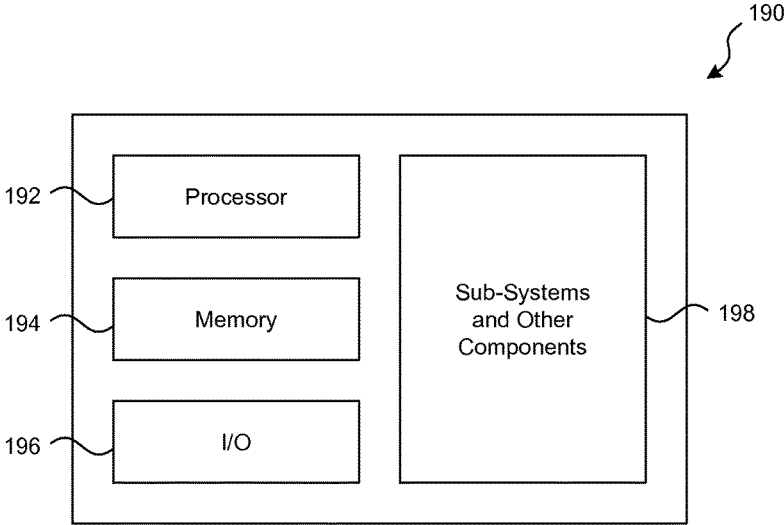


FIG. 12

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DEVICES, SYSTEMS, AND METHODS RELATED TO REMOVING PARASITIC CONDUCTION IN SEMICONDUCTOR DEVICES

CROSS-REFERENCE TO RELATED APPLICATION

This application is a divisional of U.S. application Ser. No. 13/646,307 filed Oct. 5, 2012, now U.S. Pat. No. 9,082,748, which is incorporated herein by reference in its entirety.

TECHNICAL FIELD

The present technology is related to semiconductor devices employed in high-power, high-voltage applications. In particular, some embodiments of the present technology are related to field effect transistor devices that employ heterojunctions, such as high electron mobility transistors.

BACKGROUND

High electron mobility transistors (HEMTs) employ a heterojunction defined by semiconductor materials having different bandgap energy levels. A gate provides an applied electric field to the heterojunction, which causes a conductive channel to be formed between the source and drain of the HEMT. Another electrical field applied across the source and drain causes an electrical current to flow through the conductive channel. When the applied field of the gate is removed, the electrical current between the source and drain will cease flowing, even when the applied field between the source and drain is not removed.

High voltage HEMTs are used in applications where the applied voltages are much higher than portable semiconductor devices. These transistors are employed in a variety of devices and applications, including power supplies, electric cars, solar cells, and large solid state transistors, to name a few. The breakdown voltage of a high voltage device is proportional to the amount of parasitic electrical current that leaks away from the current flowing between the source and the drain. When a voltage larger than the breakdown voltage is applied, parasitic current will flow regardless of whether there is an applied field provided by the gate (i.e., when the device is in an off state). This parasitic current limits device performance, including the maximum operational voltage.

BRIEF DESCRIPTION OF THE DRAWINGS

Many aspects of the present technology can be better understood with reference to the following drawings. The components in the drawings are not necessarily to scale. Instead, emphasis is placed on illustrating clearly the principles of the present technology.

FIG. 1 is a partially schematic cross-sectional view illustrating a semiconductor device configured in accordance with an embodiment of the present technology.

FIGS. 2-6 are partially schematic cross-sectional views illustrating a semiconductor device at selected steps in a method of manufacture in accordance with an embodiment of the present technology.

FIGS. 7-8 are partially schematic cross-sectional views illustrating a semiconductor device at selected steps in a method of manufacture in accordance with another embodiment of the present technology.

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FIGS. 9-11 are partially schematic cross-sectional views illustrating a semiconductor device at selected steps in a method of manufacture in accordance with yet another embodiment of the present technology.

FIG. 12 is a block diagram illustrating a system that incorporates a semiconductor device in accordance with an embodiment of the present technology.

DETAILED DESCRIPTION

Specific details of several embodiments of methods for making semiconductor devices are described herein along with related methods, devices, and systems. The term “semiconductor device” generally refers to a solid-state device that includes semiconductor material. Examples of semiconductor devices include logic devices, memory devices, and diodes, among others. Furthermore, the term “semiconductor device” can refer to a finished device or to an assembly or other structure at various stages of processing before becoming a finished device. Depending upon the context in which it is used, the term “substrate” can refer to a wafer-level substrate or to a singulated, die-level substrate. A person having ordinary skill in the relevant art will recognize that suitable steps of the methods described herein can be performed at the wafer-level or at the die-level. Furthermore, unless the context indicates otherwise, structures disclosed herein can be formed using conventional semiconductor-manufacturing techniques. Materials can be removed, for example, using plasma etching, wet etching, chemical-mechanical planarization, or other suitable techniques. Similarly, materials can be deposited, for example, using chemical vapor deposition, physical vapor deposition, atomic material deposition, spin coating, and/or other suitable techniques. The terms “epitaxy” and “epitaxial” refer to deposition techniques involving crystalline semiconductor materials that cause the semiconductor materials to be in registry with one another. For example, an epitaxial semiconductor material can be grown or otherwise deposited on an epitaxial substrate of a different semiconductor material and exhibit a crystalline order similar to that substrate.

Many embodiments of the present technology are described below in the context of heterojunctions, such as those semiconductor devices that are formed to have adjacent regions of semiconductor materials with different band gap energy levels. A person having ordinary skill in the relevant art will also recognize that the present technology may have additional embodiments, such as multiple heterojunctions (e.g., heterostructures) and/or graded heterojunctions, and that the present technology may be practiced without several of the details of the embodiments described herein with reference to FIGS. 1-12. For ease of reference, throughout this disclosure identical reference numbers are used to identify similar or analogous components or features, but the use of the same reference number does not imply that the parts should be construed to be identical. Indeed, in many examples described herein, the identically-numbered parts are distinct in structure and/or function. Furthermore, the same shading may be used to indicate materials in a cross section that can be compositionally similar, but the use of the same shading does not imply that the materials should be construed to be identical.

FIG. 1 is a partially schematic cross-sectional side view of a semiconductor device 100 configured in accordance with an embodiment of the present technology for inhibiting parasitic conduction. The semiconductor device 100 includes a stack of epitaxial semiconductor material 102 having a first epitaxial semiconductor material 104 and a

second epitaxial semiconductor material **105**. The first and second semiconductor materials **104** and **105** include different or dissimilar semiconductor materials that define a heterojunction region **110**. The first semiconductor material **104** also defines a bulk region **106** adjacent to the heterojunction region **110**. In general, the bulk region **106** has a high resistance corresponding to the resistivity of the semiconductor material of the first semiconductor material **104**.

Embodiments of the semiconductor device **100** employ a carrier **120** that is coupled to the first and second semiconductor materials **104** and **105** and configured for carrying the semiconductor materials. In particular, the carrier **120** is a substrate or structural material that is separate from an epitaxial substrate or material (not shown in FIG. **1**) used to form the first and second semiconductor materials **104** and **105**. The carrier **120** and the first and second semiconductor materials **104** and **105** are configured such that the bulk region **106** is separate and electrically isolated from the bulk of the epitaxial substrate. The isolation at least substantially eliminates parasitic conduction through the semiconductor device that would otherwise be a component of an electrical current I_1 through the semiconductor device **100**. It also eliminates parasitic conduction that would occur when a voltage higher than the breakdown voltage is applied to the semiconductor device **100** when it is in an off state.

In FIG. **1**, the carrier **120** is employed in a semiconductor device **100** that is configured as a transistor device having a gate region **113** and conductive regions **111** and **112**. The gate region **113** and the conductive regions **111** and **112** can provide, respectively, a source, a drain, and a gate of the transistor device. Interconnects **121-123** can electrically couple the gate region **113** and the conductive regions **111** and **112** to the carrier **120** through a dielectric material **115**. In one embodiment, the transistor device is a high voltage HEMT device that employs, for example, Gallium Nitride (GaN) as the first semiconductor material **104** and Aluminum Gallium Nitride (AlGaN) as the second semiconductor material **105** to form a GaN/AlGaN heterojunction region **110**. In other embodiments, the first and second semiconductor materials **104** and **105** can include other III-V semiconductor materials or other compound semiconductor materials, such as II-VI semiconductor materials or other combinations of dissimilar semiconductor materials that form a heterojunction region **110**. For example, Gallium Arsenide (GaAs) and Aluminum Gallium Arsenide (AlGaAs) can form a heterojunction region **110**.

Conventional semiconductor devices, in contrast to the semiconductor device **100**, typically retain the epitaxial substrate used to form a heterojunction. This epitaxial substrate, while useful for structurally supporting the device, creates additional parasitic conduction paths through its bulk region. In particular, these parasitic conduction paths extend through the much lower resistivity semiconductor material of the epitaxial substrate. As discussed above, parasitic conduction limits the breakdown voltage of semiconductor devices, including the breakdown voltages of high voltage devices. Previous techniques to reduce the parasitic conduction include selectively removing semiconductor material from the epitaxially grown semiconductor materials. For example, a conventional technique includes removing semiconductor material from below the channel region. While increasing breakdown voltage, removal of material from this region causes undesirable heating in the channel when the device is operated. Not only that, it also increases the complexity of manufacturing and reduces yield. For example, removing too much or too little material from

below the channel region can alter threshold voltage and cause a device not to comport with manufacturing tolerances.

Methods and devices in accordance with embodiments of the present technology remove the material of the epitaxial substrate and employ the carrier **120** to overcome these and other limitations associated with conventional devices. In particular, parasitic conductance through the bulk of the epitaxial substrate is eliminated. This can allow higher breakdown voltages in the semiconductor devices. Further, device yields after manufacturing the semiconductor device are improved because material is not required to be removed from directly under the channel region of the device (e.g., between a heterojunction region and the bulk of an epitaxial semiconductor material used to form the heterojunction region). In some embodiments, the removed material from the epitaxial substrate exposes the first semiconductor material and allows for one or more electrodes to be electrically coupled through the first semiconductor material **104** to the heterojunction region **110** (described further with reference to FIGS. **9-11**).

FIGS. **2-6** are partially schematic cross-sectional views illustrating a portion of the semiconductor device **100**. As shown in FIG. **2**, the semiconductor device **100** can include an epitaxial substrate **201** and the first semiconductor material **104** formed from the epitaxial substrate **201**. For example, the epitaxial substrate **201** can provide a seed material for the epitaxial growth of the first semiconductor material **104**. Embodiments of the epitaxial substrate **201** include silicon, sapphire, silicon carbide, silicon on poly-aluminum nitride, or another suitable substrate. As shown in FIG. **2**, embodiments can have a buffer material **208** that separates the first semiconductor material **104** from the epitaxial substrate **201**. The buffer material **208** can be an epitaxial material that provides lattice matching to the first semiconductor material **104**. For example, if the first semiconductor material **104** is GaN, the buffer material **208** can be Aluminum Nitride (AlN) or other suitable material. In other embodiments, and depending on the material of the epitaxial substrate **201**, the buffer material **208** may be omitted and the first semiconductor material **104** may be formed directly on the epitaxial substrate **201**.

FIG. **3** shows the semiconductor device **100** after the second semiconductor material **105** has been formed. The first semiconductor material **104** can act as a seed material for epitaxially forming the second semiconductor material **105**. The first and second semiconductor materials **104** and **105** together define the heterojunction region **110**. The heterojunction region **110** is configured so that a channel (e.g., a two-dimensional electron gas channel) is formed when an electric field is applied to the heterojunction. In some embodiments, the heterojunction region **110** can be alloyed and/or doped with impurities, such as to provide gradation in the lattice constant in the heterojunction. In another embodiment, the heterojunction region **110** can include another epitaxial material formed between the first and second semiconductor materials **104** and **105**.

FIG. **4** shows the semiconductor device **100** after forming the conductive regions **111** and **112**, the gate region **113**, and the dielectric material **115**. The conductive regions **111** and **112** are configured to provide low resistance, conductive paths to the heterojunction region **110**. In one embodiment, the first and second semiconductor regions **104** and **105** may be doped with impurities to form the conductive regions **111** and **112**. For example, an ion implantation process can provide a concentration of impurities that convert semiconductor regions into conductive regions. In another embodi-

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ment, the conductive regions **111** and **112** may be formed from a different material, such as by removing material from areas of the first and second semiconductor materials **104** and **105** to form depressions and depositing metal at the depressions. Further, in some embodiments, the conductive regions **111** and **112** can be positioned differently or conductive regions may be added or omitted depending on the type of semiconductor device to be manufactured.

As shown in FIG. 4, the gate region **113** is aligned with the heterojunction region **110** and can include an individual material or stacked materials of insulative, conductive, or semi-conductive materials. The gate region **113** provides a conductive path for delivering an electric field to the heterojunction region **110**. The dielectric material **115** electrically insulates the gate region **113** from the conductive regions **111** and **112**. The dielectric material **115** also electrically insulates the carrier **120** (not visible in FIG. 4) from the semiconductor materials. The semiconductor device **100** also includes interconnects **121-123** that extend through the dielectric material **115** and are configured to provide electrical connections to the gate region **113** and the conductive regions **111** and **112**. The interconnects **121-123** may be formed, for example, using photolithographic and etching processes to pattern the dielectric material **115**. A metallic material, such as tungsten or copper, can be deposited in the patterned portion of the dielectric material **115** to form an ohmic contact. In some embodiments, more or fewer interconnects may be employed depending on the configuration of the semiconductor device **100**.

FIG. 5 shows the semiconductor device **100** after removing material from the epitaxial substrate **201** using, for example, backgrinding, etching, planarizing, or other processes for thinning the epitaxial substrate **201**. By removing material from the epitaxial substrate **201**, parasitic conduction between the conductive regions can be reduced or eliminated. In particular, removing the epitaxial substrate material **201** reduces the size of a parasitic conduction path **530** through the bulk of the epitaxial substrate **201**. Complete removal of the epitaxial substrate **201** accordingly eliminates the parasitic conduction path **530** altogether. In some embodiments, the buffer material **208** may also be thinned or removed to reduce or eliminate another potential parasitic conduction path **532** through the buffer material **208**. In other embodiments, the bulk region **106** of the first semiconductor material **104** may be thinned to further reduce parasitic conduction.

FIG. 6 shows the semiconductor device **100** after coupling the first and second semiconductor materials **104** and **105** to a carrier substrate **620**. Embodiments of the carrier substrate **620** can include a semiconductor wafer, die, or other suitable material or substrate. As shown in FIG. 6, the carrier substrate **620** is pre-formed to include features that align with features of the dielectric material **115**. For example, the carrier substrate **620** can include through-substrate electrodes **627-629** configured to be aligned with the interconnects **121-123**. In the embodiment of FIG. 6, the through-substrate electrodes **627-629** are coupled to the interconnects **121-123** through a patterned metal bond line **625**. In one embodiment, the through-substrate electrodes **627-629** are through-substrate silicon vias (TSVs). In other embodiments, the carrier substrate **620** may be aligned with other features, such as metal traces or bond pads.

Embodiments of the carrier substrate **620** can be coupled with the first and second semiconductor materials **104** and **105** in a variety of ways. For example, additional or alternative materials or intermediary materials can intercouple the carrier substrate **620** with the first and second semicon-

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ductor materials **104** and **105**, such as bond pads, bump bonds, adhesives, epoxies, or other conductive and/or insulative materials. In some embodiments, the carrier substrate **620** is not pre-formed. The through-substrate electrodes **627-629** may be omitted or they may be formed after attaching the carrier substrate **620** to the dielectric material **115**. Further, although not illustrated, additional dielectric and metallization structures can be employed to complete a suitable network of electrical connections within the semiconductor device **100** or to other devices located on or off chip.

Also, in some embodiments, a carrier **120** can be coupled to the first and second semiconductor materials **104** and **105** prior to removal of the epitaxial substrate **201** (see FIG. 5). For example, the carrier substrate **620** in FIG. 6 can be coupled to the dielectric material **115** before removing material from the epitaxial substrate **201**. In these embodiments, the carrier **120** provides structural support to the semiconductor device **100** during the removal of substrate material and/or material from the buffer material **208** or first semiconductor material **104**. The structural support can also support the semiconductor device **100** when transporting the semiconductor device **100** between different manufacturing steps.

FIGS. 7 and 8 are partially schematic cross-sectional views illustrating a portion of a semiconductor device **700** in accordance with another embodiment of the technology. The semiconductor device **700** is an embodiment of the semiconductor device **100** and is formed in a manner similar to the method of FIGS. 2-6. However, the semiconductor device **700** has a carrier material **720** which is an alternate embodiment of the carrier **120**. The carrier material **720** includes a metal material **740** coupled to the first and second semiconductor materials **104** and **105** through the dielectric material **115**. Suitable materials for the metal material **740** include plated metal, such as plated copper or copper alloy. The metal material **740** can have a thickness t_1 configured to provide structural support. In one embodiment, the metal material **740** has a thickness of 100 μm or greater. In other embodiments, the carrier material **720** includes multiple materials of metal or combinations of materials of different materials.

FIG. 8 shows the semiconductor device **700** after patterning the metal material **740** to form metal contacts **841-843**. For example, photolithographic and etching processes can be employed to define the pattern of the metal contacts **841-843** in the metal material **740**. In one embodiment, the pattern is defined such that the contact **843** is a gate contact and the contacts **841** and **842** are source and drain contacts of a transistor device.

FIGS. 9-11 are partially schematic cross-sectional views illustrating a semiconductor device **900** at selected steps in a method of manufacture in accordance with another embodiment of the technology. The semiconductor device **900** is an embodiment of the semiconductor device **100** and is formed in a manner similar to the method of FIGS. 2-6. However, the semiconductor device **900** includes interconnects **951** and **952** extending through the first semiconductor material **104** and electrically coupled to the conductive regions **111** and **112**. The interconnects **951** and **952** may be formed, for example, by etching a pattern in the first semiconductor material **104** (such as through a photoresist or other mask material) and depositing a suitable metal in the patterned portions of the first semiconductor material **104**.

As shown in FIG. 9, a carrier **920** includes a substrate **954** and a bond material **956** electrically coupled to the gate region **113** through the interconnect **123**. In this configura-

tion the heterojunction region **110** is electrically coupled to an opposite side of the semiconductor device **900**. Accordingly, the heterojunction region **110** is electrically coupled at opposite sides of the semiconductor stack **102** of the first and second semiconductor materials **104** and **105**. FIG. **10** shows the first semiconductor material **104** of the semiconductor device **900** coupled to another substrate or structure **1060**, such as a semiconductor wafer, die, material, or other suitable substrate, material, or stack of material. In one embodiment, the substrate/structure **1060** includes one or more metal bond lines **1062** electrically coupled to the interconnects **951** and **952**. In another embodiment, the substrate/structure **1060** is coupled to the interconnects **951** and **952** through a bond wire, bump bond, or other feature (not shown). FIG. **11** shows an embodiment where an electrode **1164** of the semiconductor device **900** extends through the dielectric material **115** and the first and second semiconductor materials **104** and **105**. The electrode **1164** in this configuration electrically couples the substrate/structure **1060** to the carrier **920**.

Like the semiconductor device **100**, embodiments of the semiconductor devices **700** and **900** also inhibit parasitic conduction by removal of the epitaxial substrate used to form the semiconductor devices **700** and **900**. In addition, embodiments of the semiconductor devices **700** and **900** can be manufactured with a buffer material (e.g., the buffer material **208**) that is subsequently removed or thinned. Also, the bulk region **106** of the first semiconductor material **104** of the stack of semiconductor materials **102** can also be thinned. Further, although not illustrated, additional dielectric and metallization structures can be formed over the contacts **841-843** of the semiconductor device **700** or the interconnects **951** and **952** of the semiconductor device **900** to complete a suitable network of electrical connections within the semiconductor devices **700**, **900** or to other devices located on or off chip.

Although illustrated as a transistor device, other embodiments of the semiconductor device **100** can include different configurations, such as a diode, a light emitting diode, or other semiconductor structure employing epitaxial grown materials, heterojunctions, heterostructures, or the like. Also, semiconductor devices **100**, **700**, **900** can be incorporated alone or with other semiconductor devices into a suitable package (not shown). For example, the semiconductor device **100** can be connected to leads (not shown) of the package using wire bonds (not shown), solder bumps (not shown), or other suitable structures. The semiconductor device **100** and associated structures can also be encapsulated for protection and to facilitate heat dissipation during operation.

Any one of the semiconductor devices having the features described above with reference to FIGS. **1-11** can be incorporated into any of a myriad of larger and/or more complex systems, a representative example of which is system **190** shown schematically in FIG. **12**. The system **190** can include a processor **192**, a memory **194** (e.g., SRAM, DRAM, flash, and/or other memory devices), input/output devices **196**, and/or other subsystems or components **198**. The semiconductor device **100** described above with reference to FIGS. **1-11** can be included in any of the elements shown in FIG. **12**. The resulting system **190** can be configured to perform any of a wide variety of suitable computing, processing, storage, sensing, imaging, and/or other functions. Accordingly, representative examples of the system **190** include, without limitation, computers and/or other data processors, such as desktop computers, laptop computers, Internet appliances, hand-held devices (e.g., palm-top computers, wear-

able computers, cellular or mobile phones, personal digital assistants, music players, etc.), tablets, multi-processor systems, processor-based or programmable consumer electronics, network computers, and minicomputers. Additional representative examples of the system **190** include lights, cameras, vehicles, etc. With regard to these and other examples, the system **190** can be housed in a single unit or distributed over multiple interconnected units, e.g., through a communication network. The components of the system **190** can accordingly include local and/or remote memory storage devices and any of a wide variety of suitable computer-readable media.

This disclosure is not intended to be exhaustive or to limit the present technology to the precise forms disclosed herein. Although specific embodiments are disclosed herein for illustrative purposes, various equivalent modifications are possible without deviating from the present technology, as those of ordinary skill in the relevant art will recognize. In some cases, well-known structures and functions have not been shown or described in detail to avoid unnecessarily obscuring the description of the embodiments of the present technology. Although steps of methods may be presented herein in a particular order, alternative embodiments may perform the steps in a different order. Similarly, certain aspects of the present technology disclosed in the context of particular embodiments can be combined or eliminated in other embodiments. Furthermore, while advantages associated with certain embodiments of the present technology may have been disclosed in the context of those embodiments, other embodiments can also exhibit such advantages, and not all embodiments need necessarily exhibit such advantages or other advantages disclosed herein to fall within the scope of the technology. Accordingly, the disclosure and associated technology can encompass other embodiments not expressly shown or described herein.

Throughout this disclosure, the singular terms “a,” “an,” and “the” include plural referents unless the context clearly indicates otherwise. Similarly, unless the word “or” is expressly limited to mean only a single item exclusive from the other items in reference to a list of two or more items, then the use of “or” in such a list is to be interpreted as including (a) any single item in the list, (b) all of the items in the list, or (c) any combination of the items in the list. Additionally, the term “comprising” is used throughout to mean including at least the recited feature(s) such that any greater number of the same feature and/or additional types of other features are not precluded. Directional terms, such as “upper,” “lower,” “front,” “back,” “vertical,” and “horizontal,” may be used herein to express and clarify the relationship between various elements. It should be understood that such terms do not denote absolute orientation. Reference herein to “one embodiment,” “an embodiment,” or similar formulations means that a particular feature, structure, operation, or characteristic described in connection with the embodiment can be included in at least one embodiment of the present technology. Thus, the appearances of such phrases or formulations herein are not necessarily all referring to the same embodiment. Furthermore, various particular features, structures, operations, or characteristics may be combined in any suitable manner in one or more embodiments.

We claim:

1. A semiconductor device having a first side and a second side opposite the first side, wherein the semiconductor device is formed from an epitaxial substrate, the semiconductor device comprising:

a stack of semiconductor materials comprising a heterojunction region formed from the epitaxial substrate, wherein at least one of the semiconductor materials defines a bulk region adjacent the heterojunction region;

a carrier comprising a substrate at the first side of the semiconductor device, wherein the carrier is configured to carry the stack of semiconductor materials such that the bulk region is between the substrate and the heterojunction region;

conductive regions adjacent the heterojunction region and configured to provide an electrical current through the heterojunction region;

a dielectric material between the heterojunction region and the substrate of the carrier: a first electrode extending through the bulk region and coupled to one of the conductive regions;

a second electrode extending through the bulk region and coupled to another one of the conductive regions;

a third electrode extending through the bulk region, the dielectric material and the heterojunction region; and wherein the epitaxial substrate is removed from the second side of the semiconductor device, and wherein the semiconductor device further comprises a structure at the second side of the semiconductor device from which the epitaxial substrate was removed.

2. The semiconductor device of claim 1, wherein the heterojunction region and the carrier form a portion of a high electron mobility transistor (HEMT) device.

3. The semiconductor device of claim 1, wherein the heterojunction region is a Gallium Nitride (GaN)/Aluminum Gallium Nitride (AlGaN) heterojunction region.

4. The semiconductor device of claim 1, wherein the third electrode contacts the structure at the second side of the semiconductor device.

5. The semiconductor device of claim 1, further comprising a gate region between the heterojunction region and the substrate of the carrier.

6. The semiconductor device of claim 1 wherein the structure at the second side of the semiconductor device includes conductive lines coupled to corresponding ones of the conductive regions.

7. A semiconductor device having a first side and a second side opposite the first side, the semiconductor device comprising:

a carrier comprising a first substrate at the first side of the semiconductor device;

a heterojunction region and a bulk material from which the heterojunction region is formed while the bulk region is attached to a common substrate that is subsequently removed from the second side of the semiconductor device, wherein the heterojunction region is between the first substrate and the bulk material;

a second substrate at the second side of the semiconductor device where the common substrate was removed;

conductive regions adjacent the heterojunction region and configured to provide an electrical current through the heterojunction region;

a dielectric material between the heterojunction region and the first substrate;

a first interconnect extending through the bulk material and coupled to one of the conductive regions;

a second interconnect extending through the bulk material and coupled to another one of the conductive regions; and

a third interconnect extending through the bulk material, the heterojunction region, and the dielectric material.

8. The semiconductor device of claim 7, further comprising conductive lines formed between the second substrate and the base material, wherein the conductive lines are electrically coupled to corresponding ones of the conductive regions via the first and second and second interconnects.

9. The semiconductor device of claim 7 wherein the semiconductor device further comprises a metallization structure at the second side of the semiconductor device, wherein the third interconnect is coupled to the metallization structure.

10. The semiconductor device of claim 7 wherein the semiconductor device further comprises a gate region coupled between the heterojunction region and the first substrate, wherein the third interconnect is coupled to the gate region.

11. The semiconductor device of claim 7, further comprising a source contact coupled to the first interconnect, a drain contact coupled to the second interconnect, and a gate contact coupled to the third interconnect.

12. The semiconductor device of claim 7 wherein the heterojunction and the carrier form a gate region of a high electron mobility transistor (HEMT) device.

13. The semiconductor device of claim 7 wherein the heterojunction region comprises Gallium Nitride (GaN) and Aluminum Gallium Nitride (AlGaN) adjacent the GaN.

14. A semiconductor device, comprising:

a carrier;

a bulk material and a heterojunction formed from the bulk material, wherein the heterojunction is between the carrier and the bulk material;

a substrate over the bulk material, wherein the bulk material is between the substrate and the heterojunction;

conductive regions adjacent the heterojunction and configured to provide an electrical current through the heterojunction;

a dielectric material between the heterojunction and the carrier;

a first interconnect and a second interconnect each extending through the bulk material and coupled to a corresponding one of the conductive regions; and

a third interconnect extending through the bulk material, the heterojunction, and the dielectric material.

15. The semiconductor device of claim 14 wherein the carrier comprises a metal substrate and a bond material bonding the metal substrate to the dielectric material.

16. The semiconductor device of claim 14 further comprising a gate region adjacent the heterojunction and the dielectric material.

17. The semiconductor device of claim 16, further comprising a fourth interconnect coupled to the heterojunction, wherein the fourth interconnect is between the heterojunction and the carrier, and wherein the carrier electrically couples the third and further interconnects.