Article

Chemical Vapor Deposition of Uniform and Large-Domain Molybdenum Disulfide Crystals on Glass/Al₂O₃ Substrates

Qingguo Gao¹*, Jie Lu², Simin Chen¹, Lvcheng Chen¹, Zhequan Xu¹, Dexi Lin¹, Songyi Xu¹, Ping Liu¹*, Xueao Zhang²*, Weiwei Cai² and Chongfu Zhang¹,³

¹ School of Electronic Information, University of Electronic Science and Technology of China Zhongshan Institute, Zhongshan 528402, China
² College of Physical Science and Technology, Xiamen University, Xiamen 361005, China
³ School of Information and Communication Engineering, University of Electronic Science and Technology of China, Chengdu 611731, China
* Correspondence: gggemw@163.com

Abstract: Two-dimensional molybdenum disulfide (MoS₂) has attracted significant attention for next-generation electronics, flexible devices, and optical applications. Chemical vapor deposition is the most promising route for the production of large-scale, high-quality MoS₂ films. Recently, the chemical vapor deposition of MoS₂ films on soda-lime glass has attracted great attention due to its low cost, fast growth, and large domain size. Typically, a piece of Mo foil or graphite needs to be used as a buffer layer between the glass substrates and the CVD system to prevent the glass substrates from being fragmented. In this study, a novel method was developed for synthesizing MoS₂ on glass substrates. Inert Al₂O₃ was used as the buffer layer and high-quality, uniform, triangular monolayer MoS₂ crystals with domain sizes larger than 400 µm were obtained. To demonstrate the advantages of glass/Al₂O₃ substrates, a direct comparison of CVD MoS₂ on glass/Mo and glass/Al₂O₃ substrates was performed. When Mo foil was used as the buffer layer, serried small bilayer islands and bright core centers could be observed on the MoS₂ domains at the center and edges of glass substrates. As a control, uniform MoS₂ crystals were obtained when Al₂O₃ was used as the buffer layer, both at the center and the edge of glass substrates. Raman and PL spectra were further characterized to show the merit of glass/Al₂O₃ substrates. In addition, the thickness of MoS₂ domains was confirmed by an atomic force microscope and the uniformity of MoS₂ domains was verified by Raman mapping. This work provides a novel method for CVD MoS₂ growth on soda-lime glass and is helpful in realizing commercial applications of MoS₂.

Keywords: MoS₂; chemical vapor deposition; substrate; glass

1. Introduction

Two-dimensional transition metal dichalcogenides materials, specifically molybdenum disulfide (MoS₂), have emerged as an extremely important candidate for low-power, high-performance, and flexible electronics [1–7]. In order to achieve industry applications, batch production of high-quality and large-scale MoS₂ films at low cost has become a major requirement. Chemical vapor deposition (CVD) has demonstrated great potential in the large-scale production of high-quality MoS₂ films [8–11]. At present, CVD growth of large-area MoS₂ continuous films larger than 4 inches and the deposition of single MoS₂ domains with sizes up to the millimeter-scale have been realized by independent research groups [8–10,12–15], which greatly promote the industrialization process of MoS₂. Although those encouraging advancements have been made in the CVD growth of MoS₂, related studies are still at an early stage for the industrialization of MoS₂ films [16–18]. For example, the size of CVD-grown, single-crystalline graphene has reached up to the meter-scale with very fast growth rates [19,20]. However, there is an obvious gap between CVD MoS₂ and graphene both in crystal size and quality [14,15]. More efforts should be
made on designing a new growth set-up, searching for possible catalysts and promoters, testing appropriate growth substrates and carefully optimizing the CVD growth parameters to lower the cost and improve the quality and uniformity of CVD MoS$_2$ [18,21].

Recently, low-cost soda-lime glass has been utilized as a growth substrate for CVD MoS$_2$ growth [12,22–28]. In 2017, Chen et al. synthesized large-size MoS$_2$ crystals on molten glass at 1050 °C [27]. In 2018, Gao et al. synthesized high-quality bilayer MoS$_2$ with domain sizes up to 200 µm on molten glass at 830 °C [25]. Zhang et al. reported single-crystal monolayer MoS$_2$ grown on molten glass at 850 °C with a domain size larger than 500 µm [24]. Yang et al. from Peking University developed a face-to-face metal precursor supply approach and deposited 6-inch uniform monolayer MoS$_2$ on the glass [12]. In 2020, Zeng et al. demonstrated bandgap tuning of MoS$_2$ grown on molten glass by a sphere diameter engineering technique [23]. In 2022, Li et al. reported the evolution of crystalline morphology of MoS$_2$ grown on glass substrates and provided an effective approach to engineering the morphology of MoS$_2$ crystals [22]. Commonly, due to the growth temperature of MoS$_2$ being higher than soda-lime glass’s melting point, a piece of Mo foil or graphite needed to be used as a buffer layer between the glass substrates and the CVD system in those works to prevent the adhesion of glass substrates and CVD systems [25–27]. However, the MoS$_2$ morphology and domain size may be critically affected by Mo foil because Mo foil also could be used as the Mo-source in the chemical vapor deposition process [26]. In addition, Mo foils and graphite are very easy to react with oxygen at high growth temperatures, which limits the research approaches to MoS$_2$ growth on glass substrates, although oxygen has been proven to be an effective gas for improving the size and quality of MoS$_2$ crystals [8,9,29–32]. For example, Zhang’s group obtained a 4-inch monolayer MoS$_2$ film on a sapphire substrate by epitaxial growth using an oxygen-assisted method [13]. Hence, for the aim of Mo-source precise control and to extend the capability of glass substrates for high-quality MoS$_2$ CVD growth at variable critical experimental conditions, a non-active buffer layer needs to be explored.

In this work, high-quality CVD monolayer MoS$_2$ films grown on glass/Al$_2$O$_3$ substrates were explored. Firstly, to demonstrate the advantages of glass/Al$_2$O$_3$ substrates, MoS$_2$ films were synthesized on glass/Al$_2$O$_3$ and glass/Mo substrates and characterized with optical microscopy in different regions. At the center of the glass/Mo substrates, serried bilayer seeds could be observed on the monolayer MoS$_2$ domains, while the MoS$_2$ domains grown on glass/Al$_2$O$_3$ substrates exhibited a uniform contrast. At the edge of the glass/Al$_2$O$_3$ substrates, monolayer MoS$_2$ domains with low nucleation density and uniform contrast were grown. As a control, monolayer MoS$_2$ domains with high nucleation density and multi-layer nucleation sites were grown on the edge region of glass/Mo substrates. Subsequently, the grown MoS$_2$ thin films were successfully transferred onto SiO$_2$/Si substrates and characterized with Raman and photoluminescence (PL) spectroscopy, as well as atomic force microscopy (AFM). A comparison of Raman and PL spectra of MoS$_2$ domains grown by those two methods further illustrates the advantages of the non-active buffer layer, where uniform MoS$_2$ domains were synthesized as a result of a onefold supply of Mo-source. Finally, the thickness and uniformity of MoS$_2$ domains on glass/Al$_2$O$_3$ substrates were confirmed by AFM and Raman mapping.

2. Experiments and Methods

As depicted in Figure 1, the MoS$_2$ crystals were grown in a CVD system with a 2-inch-diameter quartz tube and two individual furnaces. In this system, the temperatures of substrates and precursors, carrier gas flow rate, total pressure, and the weight of precursors could be controlled independently. Following the general conditions reported in previous literature [24,25], 1.4 g of sulfur powder and 2 mg of MoO$_3$ powder were weighed out and placed into separate boats. The boats were placed 25 cm apart in separate regions of the quartz tube to achieve the different temperatures for the S and Mo precursors. Both glass substrates and the buffer layers (Mo foils or Al$_2$O$_3$ lamina) were cleaned with acetone (10 min), isopropanol (10 min) and deionized water (10 min). The size of both the substrates...
and buffer layers was 20 mm × 20 mm. After loading precursors and substrates, the tube was first pumped down to 0.2 mBar and then filled with Ar to 1000 mBar. The pumping and filling processes were repeated three times to eliminate air and other containment gases in the quartz tube. After that, the temperatures of furnaces I and II were set to 200 and 1050 °C, respectively, with a ramping rate of 10 °C/min. During the growth, high-purity argon was loaded with a flow rate of 20 sccm. After a growth period of 10 min, the furnaces were naturally cooled to room temperature.

Figure 1. Schematic illustration of the CVD growth system setup.

3. Results and Discussion

Figure 2a,b are the optical photographs of glass/Mo and glass/Al2O3 substrates after the growth of MoS2, respectively. The Mo foil buffer layer displays a color of gray, and the Al2O3 buffer layer shows different a color of white. Furthermore, the glass substrates shrunk obviously, and the edge of Mo foil and Al2O3 lamina showed up after the high-temperature growth process [23,26]. As we all know, the shape, distribution, and thickness of MoS2 domains depend on the weight of precursors provided to the substrates. Consequently, as illustrated in Figure 2a,b, non-uniform MoS2 film growth could be observed in different regions due to the different precursors’ concentration distributions on the glass substrates [12,33,34]. Typically, in our growth setup, thicker continuous MoS2 films could be grown upstream, closer to the Mo-source. Individual monolayer MoS2 domains tend to be synthesized downstream, farther away from the Mo-source, and abundant growth phenomena could be observed in these regions. Therefore, in order to clearly demonstrate the advantages of glass/Al2O3 substrates, the MoS2 morphology on the center and edge regions, as shown in Figure 2, was analyzed.

The MoS2 domains grown on different regions of glass/Al2O3 and glass/Mo substrates are illustrated in Figures 3 and 4. Figure 3a,b are the typical optical microscopy images obtained from the MoS2 domains grown on the center region of glass/Mo substrates. The MoS2 domains exhibited triangle shapes and demonstrated lateral sizes larger than 400 μm, which is comparable to the MoS2 domain sizes on glass substrates reported in other works [12,26]. The large crystal size could be attributed to the smooth, molten surface together with the catalytic role of the glass substrates, as reported in previous works [12,26,27,35,36]. As shown in Figure 3b, numerous tiny islands could be observed on the large MoS2 triangle domains after additional magnification. The small bilayer islands could be attributed to the Mo foil buffer layer, which provides additional Mo-source during the growth of MoS2 domains. Figure 3c,d are the representative optical microscopy images obtained from the MoS2 domains grown on the center region of glass/Al2O3 substrates. Triangle MoS2 domains larger than 400 μm with uniform color contrast could be observed.
In addition, no small bilayer islands could be observed on the amplified image of the MoS₂ domain, which demonstrates the thickness uniformity of MoS₂ crystal domains grown on the glass/Al₂O₃ substrates.

Figure 4 shows the MoS₂ domains on the edge of the glass/Mo and the glass/Al₂O₃ substrates. As shown in Figure 4a, the MoS₂ domains on the edge region of glass/Mo substrates generally exhibit star shapes with bright core centers. In contrast, the MoS₂ domains on the edge region of glass/Al₂O₃ substrates are sparse and generally exhibit triangle shapes with uniform thickness, as shown in Figure 4c. In addition, both the MoS₂ domains grown on glass/Mo and glass/Al₂O₃ were successfully transferred to SiO₂/Si substrates. Figure 4b shows the transferred MoS₂ domains with bright core centers that were grown on glass/Mo substrates. Figure 4d shows the transferred MoS₂ domains with uniform thickness that were grown on glass/Al₂O₃ substrates. The details of the transfer method have been reported in our previous works [24,25,37,38].

To provide a clear explanation of the different morphologies of the MoS₂ domains grown on glass/Mo and glass/Al₂O₃ substrates, a schematic illustration of the underlying growth mechanism was plotted. Typically, as shown in Figure 5a,b, the flat glass plane will be condensed into an oblate, sphere-like shape at a temperature higher than its molten point [23]. Subsequently, the Mo foil or Al₂O₃ buffer layer under glass substrates would be exposed to the CVD system. The Mo foil could be used as the Mo-source in the high-temperature CVD process, which has been demonstrated in previous work [26]. Therefore, excess Mo-source would be supplied and diffused on the glass/Mo substrates’ surface. Consequently, the MoS₂ domains with small bilayer islands and bright core centers were grown at the center and edge regions, respectively. On the contrary, the strong chemical bonds of Al₂O₃ make it stable at high temperatures. Therefore, as shown in Figure 5c,d, the Al₂O₃ buffer layer would not affect the Mo-source supply during the process of MoS₂ growth and MoS₂ crystals with uniform thickness were grown. Furthermore, as discussed in previous works [12,26,27,35,36], the large domain size of MoS₂ at the center region of glass substrates could be ascribed to the smooth, molten glass surface under high temperature, together with the catalytic role of Na in the glass substrates, which reduce the energy barrier in the CVD process.

![Figure 2](image_url)

**Figure 2.** (a) Optical photograph of the glass/Mo substrates after the growth of MoS₂. (b) Optical photograph of the glass/Al₂O₃ substrates after the growth of MoS₂. The red rectangle corresponds to the center region, and the blue rectangle corresponds to the edge region.
Figure 3. (a,b) Optical microscope images of the MoS$_2$ domains synthesized on the center region of glass/Mo substrates. (c,d) Optical microscope images of the MoS$_2$ domains synthesized on the center region of glass/Al$_2$O$_3$ substrates. Scale bar represents 200 μm for (a,c), and 10 μm for (b,d).

Raman spectroscopy is one commonly used spectroscopic technique to investigate phonons as well as the vibrational, rotational and other low-frequency modes in two-dimensional materials, which could be used to provide information about both crystal quality as well as estimate the number of layers of MoS$_2$ domains [39–42]. Therefore, Raman spectra were collected to further characterize the properties of MoS$_2$ grown on glass/Mo and glass/Al$_2$O$_3$. Figure 6a,c display the Raman spectra of the transferred MoS$_2$ domains on SiO$_2$/Si substrates that were grown on the center regions of glass/Mo and glass/Al$_2$O$_3$ substrates, respectively. As shown in Figure 6a, two characteristic Raman peaks were found at 385.4 cm$^{-1}$ and 405.2 cm$^{-1}$ in the spectral range, which can be assigned to in-plane vibration modes of Mo and S in the opposite direction ($E_{12g}$) and an out-of-plane vibration mode of S atoms ($A_{1g}$). The frequency difference for the MoS$_2$ domains grown on glass/Mo substrates was 19.7 cm$^{-1}$. For the MoS$_2$ domains grown on glass/Al$_2$O$_3$ substrates, the $E_{12g}$ and $A_{1g}$ peaks are located at 387.3 cm$^{-1}$ and 405.2 cm$^{-1}$. Compared with the MoS$_2$ domains grown on glass/Mo substrates, the frequency difference was reduced to 17.9 cm$^{-1}$, indicating a monolayer thickness for the measured MoS$_2$ domains. Moreover, the full width at half maximum (FWHM) of the $E_{12g}$ peak also reduced from 5.6 cm$^{-1}$ to 3.8 cm$^{-1}$, demonstrating the high quality of the MoS$_2$ domains grown on glass/Al$_2$O$_3$ substrates. The reduced frequency difference and FWHM results from the different morphologies of MoS$_2$ domains grown on glass/Mo and glass/Al$_2$O$_3$ substrates,
as shown in Figure 3. In addition, PL spectroscopy was performed for the transferred MoS\textsubscript{2} domains grown on glass/Mo and glass/Al\textsubscript{2}O\textsubscript{3} substrates, and the obtained spectra are shown in Figure 6b,d. Both those two types of MoS\textsubscript{2} have a characteristic peak (A exciton peak) at 1.84 eV, which is in agreement with previous studies [24,25]. The FWHMs of the A exciton peaks for MoS\textsubscript{2} domains grown on glass/Mo and glass/Al\textsubscript{2}O\textsubscript{3} substrates are 1.02 and 0.96 eV, respectively. The reduced PL FWHMs of MoS\textsubscript{2} domains grown on glass/Al\textsubscript{2}O\textsubscript{3} could also be attributed to its uniform thickness and high crystal quality.

Figure 4. (a,b) Optical microscope images of the MoS\textsubscript{2} domains synthesized on the edge region of glass/Mo substrates. (c,d) Optical microscope images of the MoS\textsubscript{2} domains synthesized on the edge region of glass/Al\textsubscript{2}O\textsubscript{3} substrates. Scale bar represents 50 µm for (a–d).
Figure 5. (a,b) Schematic illustration of the CVD growth process on glass/Mo substrates. (c,d) Schematic illustration of the CVD growth process on glass/Al₂O₃ substrates. The blue balls and yellow balls in (b,d) represent Mo and S atoms, respectively.

In order to further characterize the MoS₂ domains grown on glass/Al₂O₃ substrates, atomic force microscopy (AFM) and Raman mapping were performed after they were transferred onto SiO₂/Si substrates. Figure 7a displays the AFM images obtained from a typical triangle-shaped MoS₂ domain. A thickness of 0.7 nm was demonstrated through the AFM characterization, as shown in Figure 7b. This is consistent with the thickness of the monolayer MoS₂. Figure S1 displays the optical microscope and AFM images of the CVD-grown MoS₂ on the center region of glass/Al₂O₃ substrates. As shown in Figure S1b, numerous tiny islands could be observed on the large MoS₂ triangle domains. Figure 7c,d show the Raman intensity mappings recorded at 387.3 cm⁻¹ and 405.2 cm⁻¹, respectively. The Raman mappings on the intensity of $E_{12g}$ mode and $A_{1g}$ mode reveal a uniform color contrast, further demonstrating the thickness uniformity and good crystallinity of MoS₂ grown on glass/Al₂O₃ substrates.
Figure 6. (a,b) Raman and PL spectral of the CVD-grown MoS$_2$ on the center region of glass/Mo substrates. (c,d) Raman and PL spectral of the CVD-grown MoS$_2$ on the center region of glass/Al$_2$O$_3$ substrates.

Figure 7. (a,b) AFM image and height profile of the CVD-grown MoS$_2$ on glass/Al$_2$O$_3$ substrates. (c,d) Raman mapping of the CVD-grown MoS$_2$ on glass/Al$_2$O$_3$ substrates. Scale bar are 5 μm for (a), and Scale bars are 3 μm for (c,d).
4. Conclusions

In this work, the two-dimensional semiconductor MoS$_2$ was successfully synthesized on glass/Al$_2$O$_3$ substrates for the first time. The advantages of glass/Al$_2$O$_3$ substrates for CVD MoS$_2$ growth were demonstrated by a direct comparison of glass/Mo substrates. Optical microscopy revealed that MoS$_2$ crystals grown on both glass/Mo and glass/Al$_2$O$_3$ substrates were conventionally triangle-shaped and had a lateral size larger than 400 µm. Numerous bilayer islands and bright core centers could be observed on the surface of MoS$_2$ domains at the center region and edge region of glass/Mo substrates. As a control, MoS$_2$ domains grown on glass/Al$_2$O$_3$ substrates exhibited uniform optical contrast, demonstrating the thickness uniformity of those MoS$_2$ domains. The Raman and PL comparison of MoS$_2$ domains further confirmed this. In addition, the thickness of MoS$_2$ domains was characterized by atomic force microscopy and the homogeneity of MoS$_2$ domains grown on glass/Al$_2$O$_3$ substrates was further demonstrated by Raman mapping. These results demonstrate a novel method to produce MoS$_2$ films on glass substrates and are of great value for future commercial applications of MoS$_2$ films.

Supplementary Materials: The following supporting information can be downloaded at: https://www.mdpi.com/article/10.3390/nano12152719/s1, Figure S1: AFM image of the CVD growth MoS$_2$ on glass/Mo substrates.

Author Contributions: Conceptualization, Q.G.; methodology, Q.G., J.L., L.C., Z.X. and S.C.; validation, Q.G. and S.C.; formal analysis, Q.G.; investigation, Q.G., S.C. and L.C.; resources, Q.G., P.L., X.Z. and W.C.; data curation, Q.G.; writing—original draft preparation, Q.G.; writing—review and editing, Q.G.; visualization, Q.G., D.L. and S.X.; supervision, Q.G.; project administration, Q.G. and C.Z.; funding acquisition, Q.G. and C.Z. All authors have read and agreed to the published version of the manuscript.

Funding: This work was funded in part by the Natural Science Foundation of China (Grant Nos. 62104033, 62071088 and 11775047), in part by the Guangdong Basic and Applied Basic Research Foundation (Grant No. 2019A1515110752), in part by the Youth Innovative Talent Project of Guangdong Education Department (Grant No. 2019KQNCX187), in part by the Outstanding Chinese and Foreign Youth Exchange Program of China Association for Science and Technology (CAST) 2019, in part by the Project for Innovation Team of Guangdong University (Grant Nos. 2018KCXTD033, 2020KCXTD030 and 2021KCXTD040), in part by the Construction Project of Professional Quality Engineering in 2022 (Grant No. YLZY202201), in part by the Key scientific research project of the Department of Education of Guangdong Province (Grant No. 2021ZDZX1052), and in part by National Key R&D Program of China (Grant No. 2018YFB1801302).

Data Availability Statement: The data that support the findings of this study are available from the corresponding author upon reasonable request.

Conflicts of Interest: The authors declare no conflict of interest.

References

1. Wu, F.; Tian, H.; Shen, Y.; Hou, Z.; Ren, J.; Gou, G.; Sun, Y.; Yang, Y.; Ren, T.-L. Vertical MoS$_2$ transistors with sub-1-nm gate lengths. *Nature* 2022, 603, 259–264. [CrossRef] [PubMed]
2. Shen, P.-C.; Su, C.; Lin, Y.; Chou, A.-S.; Cheng, C.-C.; Park, J.-H.; Chiu, M.-H.; Lu, A.-Y.; Tang, H.-L.; Tavakoli, M.M.; et al. Ultralow contact resistance between semimetal and monolayer semiconductors. *Nature* 2021, 593, 211–217. [CrossRef]
3. Meng, W.; Xu, F.; Yu, Z.; Tao, T.; Shao, L.; Liu, L.; Li, T.; Wen, K.; Wang, J.; He, L.; et al. Three-dimensional monolithic micro-LED display driven by atomically thin transistor matrix. *Nat. Nanotechnol.* 2021, 16, 1231–1236. [CrossRef] [PubMed]
4. Zhang, X.; Grajal, J.; Vazquez-Roy, J.L.; Radhakrishna, U.; Wang, X.; Chern, W.; Zhou, L.; Lin, Y.; Shen, P.-C.; Ji, X.; et al. Two-dimensional MoS$_2$-enabled flexible rectenna for Wi-Fi-band wireless energy harvesting. *Nature* 2019, 566, 368–372. [CrossRef] [PubMed]
5. Lin, Z.; Liu, Y.; Halim, U.; Ding, M.; Liu, Y.; Wang, Y.; Jia, C.; Chen, P.; Duan, X.; Wang, C.; et al. Solution-processable 2D semiconductors for high-performance large-area electronics. *Nature* 2018, 562, 254–258. [CrossRef] [PubMed]
6. Desai, S.B.; Madhvapathy, S.R.; Sachid, A.B.; Llinas, J.P.; Wang, Q.; Ahn, G.H.; Pitner, G.; Kim, M.J.; Bokor, J.; Hu, C.; et al. MoS$_2$ transistors with 1-nanometer gate lengths. *Science* 2016, 354, 99–102. [CrossRef]
7. Akinwande, D.; Petrone, N.; Hone, J. Two-dimensional flexible nanoelectronics. *Nat. Commun.* 2014, 5, 5678. [CrossRef]
8. Li, T.; Guo, W.; Ma, L.; Li, W.; Yu, Z.; Han, Z.; Gao, S.; Liu, L.; Fan, D.; Wang, Z.; et al. Epitaxial growth of wafer-scale molybdenum disulfide semiconductor single crystals on sapphire. Nat. Nanotechnol. 2021, 16, 1201–1207. [CrossRef]

9. Liu, L.; Li, T.; Ma, L.; Li, W.; Sun, W.; Dong, R.; Zou, X.; Fan, D.; Shao, L.; et al. Uniform nucleation and epitaxy of bilayer molybdenum disulfide on sapphire. Nature 2022, 605, 69–75. [CrossRef]

10. Yang, P.; Zhang, S.; Pan, S.; Tang, B.; Liang, Y.; Zhao, X.; Zhang, Z.; Shi, J.; Huan, Y.; Shi, Y.; et al. Epitaxial Growth of Nanometer-Scale Single-Crystal MoS2 Monolayer on Au(111). ACS Nano 2020, 14, 5036–5045. [CrossRef]

11. Wang, Q.; Li, N.; Tang, J.; Zhu, J.; Zhang, Q.; Jia, Q.; Lu, Y.; Wei, Z.; Yu, H.; Zhao, Y.; et al. Wafer-Scale Highly Oriented Monolayer MoS2 with Large Domain Sizes. Nano Lett. 2020, 20, 7193–7199. [CrossRef] [PubMed]

12. Yang, P.; Zou, X.; Zhang, Z.; Zhongfian, L.; Shi, J.; Chen, S.; Shulin, C.; Zhao, L.; Jiang, S.; Zhou, X.; et al. Batch production of 6-inch uniform monolayer molybdenum disulfide catalyzed by sodium in glass. Nat. Commun. 2018, 9, 979. [CrossRef] [PubMed]

13. Yu, H.; Liao, M.; Zhao, W.; Liu, G.; Zhou, X.J.; Wei, Z.; Xu, Z.; Liu, K.; Hu, Z.; Deng, K.; et al. Wafer-Scale Growth and Transfer of Highly-Oriented Monolayer MoS2 Continuous Films. ACS Nano 2017, 11, 12001–12007. [CrossRef]

14. Zhou, J.; Lin, J.; Huang, X.; Zhou, Y.; Chen, Y.; Xia, J.; Wang, H.; Xie, Y.; Yu, H.; Lei, J.; et al. A library of atomically thin metal chalcogenides. Nature 2018, 556, 355–359. [CrossRef] [PubMed]

15. Ji, Q.; Su, C.; Mao, N.; Tian, X.; Idrobo, J.-C.; Miao, J.; Tisdale, W.A.; Zettl, A.; Li, J.; Kong, J. Revealing the Brønsted-Evans-Polanyi relation in halide-activated fast MoS2 growth toward millimeter-sized 2D crystals. Sci. Adv. 2021, 7, eabj3324. [CrossRef] [PubMed]

16. Zhang, L.; Dong, J.; Ding, F. Strategies, Status, and Challenges in Wafer Scale Single Crystalline Two-Dimensional Materials Synthesis. Chem. Rev. 2021, 121, 6321–6372. [CrossRef] [PubMed]

17. Li, S. Salt-assisted chemical vapor deposition of two-dimensional transition metal dichalcogenides. iScience 2021, 24, 103229. [CrossRef]

18. Zhou, J.; Liao, M.; Li, W.; Guo, W.; Ma, L.; Yu, Z.; Han, Z.; Gao, S.; Liu, L.; Fan, D.; et al. Ultrathin MoS2 single-crystal flakes on wafer scale. Adv. Mater. 2021, 33, 2004276. [CrossRef]

19. Xu, X.; Zhang, Z.; Qu, L.; Zhuang, J.; Zhang, L.; Wang, H.; Liao, C.; Song, H.; Qiao, R.; Gao, P.; et al. Ultrafast growth of single-crystal graphene assisted by a continuous oxygen supply. Nat. Nanotechnol. 2016, 11, 930–935. [CrossRef]

20. Zhang, Z.; Xu, X.; Qu, L.; Wang, S.; Wu, T.; Ding, F.; Peng, H.; Liu, K. The Way towards Ultrafast Growth of Single-Crystal Graphene on Copper. Adv. Sci. 2017, 4, 1700087. [CrossRef] [PubMed]

21. Xiong, L.; Wang, K.; Li, D.; Luo, X.; Weng, J.; Liu, Z.; Zhang, H. Research progress on the preparations, characterizations and applications of large scale 2D transition metal dichalcogenides films. FlatChem 2020, 21, 100161. [CrossRef]

22. Li, Q.; Zhang, L.; Li, C.; He, J.; Wei, Y.; Zhao, J.; Zhang, R.; Wang, P.; Fu, S.; Chen, F.; et al. Morphological Evolution of Monolayer MoS2 Single-Crystalline Flakes. J. Phys. Chem. C 2022, 126, 3549–3559. [CrossRef]

23. Zeng, M.; Liu, J.; Zhou, L.; Mendes, R.G.; Dong, Y.; Zhang, M.-Y.; Cui, Z.-H.; Cai, Z.; Zhang, Z.; Zhu, D.; et al. Bandgap tuning of two-dimensional materials by sphere diameter engineering. Nat. Mater. 2020, 19, 528–533. [CrossRef] [PubMed]

24. Zhang, Z.; Xu, X.; Song, J.; Gao, Q.; Li, S.; Hu, Q.; Li, X.; Wu, Y. High-performance transistors based on monolayer CVD MoS2 grown on molten glass. Appl. Phys. Lett. 2018, 113, 201203. [CrossRef]

25. Gao, Q.; Zhang, Z.; Xu, X.; Song, J.; Li, X.; Wu, Y. Scalable high performance radio frequency electronics based on large domain bilayer MoS2. Nat. Commun. 2018, 9, 4778. [CrossRef]

26. Chen, J.; Zhao, X.; Grinblat, G.; Chen, Z.; Tan, S.J.R.; Fu, W.; Ding, Z.; Abdelwahab, I.; Li, Y.; Geng, D.; et al. Homoepitaxial Growth of Large-Scale Highly Organized Transition Metal Dichalcogenide Patterns. Adv. Mater. 2017, 30, 1704674. [CrossRef] [PubMed]

27. Chen, J.; Zhao, X.; Tan, S.J.R.; Xu, H.; Wu, B.; Liu, B.; Fu, D.; Wu, G.; Geng, D.; Liu, Y.; et al. Chemical Vapor Deposition of Large-Size Monolayer MoSe2 Crystals on Molten Glass. J. Am. Chem. Soc. 2017, 139, 1073–1076. [CrossRef]

28. Cai, Z.; Lai, Y.; Zhao, S.; Zhang, R.; Tan, J.; Feng, S.; Zou, J.; Tang, L.; Lin, J.; Liu, B.; et al. Dissolution-precipitation growth of uniform and clean two dimensional transition metal dichalcogenides. Natl. Sci. Rev. 2020, 7, 115. [CrossRef]

29. Tang, J.; Wei, Z.; Wang, Q.; Wang, Y.; Han, B.; Li, X.; Huang, B.; Liao, M.; Liu, J.; Li, N.; et al. In Situ Oxygen Doping of Monolayer MoS2 for Novel Electronics. Small 2020, 16, 2004276. [CrossRef]

30. Durairaj, S.; Ponnusamy, K.; Shinde, N.B.; Eswaran, S.K.; Asokan, V.; Park, J.B.; Chandramohan, S. Oxygen-Driven Growth Regulation and Defect Passivation in Chemical Vapor Deposited MoS2 Monolayers. Cryst. Growth Des. 2021, 21, 6793–6801. [CrossRef]

31. Yao, B.; Li, R.; Zhang, C.; Zhou, Z.; Fu, Z.; Huang, X.; Yuan, G.; Xu, J.; Gao, L. Tuning the morphology of 2D transition metal dichalcogenides via oxidizing conditions. I. Physics Condens. Matter 2022, 34, 195001. [CrossRef] [PubMed]

32. Chen, W.; Zhao, J.; Zhang, J.; Gu, L.; Yang, Z.; Li, X.; Yu, H.; Zhu, X.; Yang, R.; Shi, D.; et al. Oxygen-Assisted Chemical Vapor Deposition Growth of Large Single-Crystal and High-Quality Monolayer MoS2. J. Am. Chem. Soc. 2015, 137, 15632–15635. [CrossRef] [PubMed]

33. Tang, L.; Li, T.; Luo, Y.; Feng, S.; Cai, Z.; Zhang, H.; Liu, B.; Cheng, H.-M. Vertical Chemical Vapor Deposition Growth of Highly Uniform 2D Transition Metal Dichalcogenides. ACS Nano 2020, 14, 4646–4653. [CrossRef]

34. Tang, L.; Tan, J.; Nong, H.; Liu, B.; Cheng, H.-M. Chemical Vapor Deposition Growth of Two-Dimensional Compound Materials: Controllability, Material Quality, and Growth Mechanism. Accounts Mater. Res. 2021, 2, 36–47. [CrossRef]
35. Zhang, Z.; Zhu, L.; Wang, D.; Tang, B.; Yang, P.; Shi, Y.; Zhou, F.; Fu, J.; Huan, Y.; Cui, F.; et al. Ultrafast Growth of Large-Area Uniform, Millimeter-Size MoSe$_2$ Single Crystals on Low-Cost Soda-Lime Glass. *Adv. Mater. Interfaces* **2021**, *8*, 2100415. [CrossRef]

36. Han, W.; Liu, K.; Yang, S.; Wang, F.; Su, J.; Jin, B.; Li, H.; Zhai, T. Salt-assisted chemical vapor deposition of two-dimensional materials. *Sci. China Ser. B Chem.* **2019**, *62*, 1300–1311. [CrossRef]

37. Gao, Q.; Zhang, C.; Yang, K.; Pan, X.; Zhang, Z.; Yang, J.; Yi, Z.; Chi, F.; Liu, L. High-Performance CVD Bilayer MoS$_2$ Radio Frequency Transistors and Gigahertz Mixers for Flexible Nanoelectronics. *Micromachines* **2021**, *12*, 451. [CrossRef]

38. Gao, Q.; Zhang, C.; Liu, P.; Hu, Y.; Yang, K.; Yi, Z.; Liu, L.; Pan, X.; Zhang, Z.; Yang, J.; et al. Effect of Back-Gate Voltage on the High-Frequency Performance of Dual-Gate MoS$_2$ Transistors. *Nanomaterials* **2021**, *11*, 1594. [CrossRef]

39. Wang, Y.; Cong, C.; Qiu, C.; Yu, T. Raman Spectroscopy Study of Lattice Vibration and Crystallographic Orientation of Monolayer MoS$_2$ under Uniaxial Strain. *Small* **2013**, *9*, 2857–2861. [CrossRef]

40. Li, H.; Zhang, Q.; Yap, C.C.R.; Tay, B.K.; Edwin, T.H.T.; Olivier, A.; Baillargeat, D. From Bulk to Monolayer MoS$_2$: Evolution of Raman Scattering. *Adv. Funct. Mater.* **2012**, *22*, 1385–1390. [CrossRef]

41. Chakraborty, B.; Bera, A.; Muthu, D.V.S.; Bhowmick, S.; Waghmare, U.V.; Sood, A.K. Symmetry-dependent phonon renormalization in monolayer MoS$_2$ transistor. *Phys. Rev. B* **2012**, *85*, 161403. [CrossRef]

42. Zobel, A.; Boson, A.; Wilson, P.M.; Muratov, D.S.; Kuznetsov, D.V.; Sinitskii, A. Chemical vapour deposition and characterization of uniform bilayer and trilayer MoS$_2$ crystals. *J. Mater. Chem. C* **2016**, *4*, 11081–11087. [CrossRef]