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FUSION FORMABLE SODIUM CONTAINING GLASS

[0001] This application claims the benefit of priority to US Provisional Application Number 61/182386 filed on May 29, 2009 and to US Application Number 12787711 filed on May 26, 2010.

BACKGROUND**Field**

[0002] Embodiments relate generally to sodium containing glasses and more particularly to fusion formable sodium containing glasses which may be useful in photochromic, electrochromic, Organic Light Emitting Diode (OLED) lighting, or photovoltaic applications, for example, thin film photovoltaics.

Technical Background

[0003] The fusion forming process typically produces flat glass with optimal surface and geometric characteristics useful for many electronics applications, for instance, substrates used in electronics applications, for example, display glass for LCD televisions.

[0004] Over the last 10 years, Corning fusion glass products include 1737FTM, 1737GTM, Eagle2000FTM, EagleXGTM, JadeTM, and Codes 1317 and 2317 (Gorilla GlassTM). Efficient melting is generally believed to occur at a temperature corresponding to a melt viscosity of about 200 poise (p). These glasses share in common 200p temperatures in excess of 1600°C, which can translate to accelerated tank and electrode corrosion, greater challenges for fining due to still more elevated finer temperatures, and/or reduced platinum system life time, particularly around the finer. Many have temperatures at 3000 poise in excess of about 1300°C, and since this is a typical viscosity for an optical stirrer, the high temperatures at

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this viscosity can translate to excessive stirrer wear and elevated levels of platinum defects in the body of the glass.

[0005] Many of the above described glasses have delivery temperatures in excess of 1200°C, and this can contribute to creep of isopipe refractory materials, particularly for large sheet sizes.

[0006] These attributes combine so as to limit flow (because of slow melt rates), to accelerate asset deterioration, to force rebuilds on timescales much shorter than product lifetimes, to force unacceptable (arsenic), expensive (capsule) or unwieldy (vacuum fining) solutions to defect elimination, and thus contribute in significant ways to the cost of manufacturing glass.

[0007] In applications in which rather thick, comparatively low-cost glass with less extreme properties is required, these glasses are not only overkill, but prohibitively expensive to manufacture. This is particularly true when the competitive materials are made by the float process, a very good process for producing low cost glass with rather conventional properties. In applications that are cost sensitive, such as large-area photovoltaic panels and OLED lighting, this cost differential is so large as to make the price point of LCD-type glasses unacceptable.

[0008] To reduce such costs, it is advantageous to drive down the largest overall contributors (outside of finishing), and many of these track directly with the temperatures used in the melting and forming process. Therefore, there is a need for a glass that melts at a lower temperature than those aforementioned glasses.

[0009] Further, it would be advantageous to have a glass useful for low temperature applications, for instance, photovoltaic and OLED light applications. Further, it would be

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advantageous to have a glass whose processing temperatures were low enough that the manufacturing of the glass would not excessively consume the energy that these applications are aiming to save.

SUMMARY

[0010] A compositional range of fusion-formable, high strain point sodium-containing aluminosilicate and boroaluminosilicate glasses useful, for example, for thin-film photovoltaic applications are described herein. More specifically, these glasses are advantageous materials to be used in copper indium gallium diselenide (CIGS) photovoltaic modules where the sodium required to optimize cell efficiency is to be derived from the substrate glass. Current CIGS module substrates are typically made from soda-lime glass sheet that has been manufactured by the float process. However, use of higher strain point glass substrates can enable higher temperature CIGS processing, which is expected to translate into desirable improvements in cell efficiency. Moreover, it may be that the smoother surface of fusion-formed glass sheets yields additional benefits, such as improved film adhesion, etc.

[0011] Accordingly, the sodium-containing glasses described herein can be characterized by strain points $\geq 540^{\circ}\text{C}$ so as to provide advantage with respect to soda-lime glass and/or liquidus viscosity $\geq 50,000$ poise to allow manufacture via the fusion process. In order to avoid thermal expansion mismatch between the substrate and CIGS layer, the inventive glasses are further characterized by a thermal expansion coefficient in the range of from 6.5 to 9.5 ppm/ $^{\circ}\text{C}$. In one embodiment, the glass is fusion formable and has a strain point of 540°C or greater, a coefficient of thermal expansion of 50×10^{-7} or

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greater, and having a liquidus viscosity of 150,000 poise or greater.

[0012] One embodiment is a glass comprising, in weight percent:

50 to 75 percent SiO_2 ;
1 to 20 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;
0 to 10 percent B_2O_3 ;
8 to 25 percent total M_2O ; and
0 to 50 percent total RO;

wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr.

[0013] Another embodiment is a glass consisting essentially of, in weight percent:

50 to 75 percent SiO_2 ;
1 to 20 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;
0 to 10 percent B_2O_3 ;
8 to 25 percent total M_2O ; and
0 to 50 percent total RO;

wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr.

[0014] A glass comprising, in weight percent:

50 to 75 percent SiO_2 ;
1 to 20 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;
0 to 4 percent MgO ;
0 to 10 percent B_2O_3 ;

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8 to 25 percent total M_2O ; and

less than 14 percent total RO ;

wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr, wherein the glass is fusion formable and has a strain point of $540^{\circ}C$ or greater, a coefficient of thermal expansion of 50×10^{-7} or greater, and having a liquidus viscosity of 150,000 poise or greater.

[0015] Additional features and advantages will be set forth in the detailed description which follows, and in part will be readily apparent to those skilled in the art from the description or recognized by practicing the invention as described in the written description and claims hereof.

[0016] It is to be understood that both the foregoing general description and the following detailed description are merely exemplary of the invention, and are intended to provide an overview or framework for understanding the nature and character of the invention as it is claimed.

DETAILED DESCRIPTION

[0017] Reference will now be made in detail to various embodiments of the invention.

[0018] As used herein, the term "substrate" can be used to describe either a substrate or a superstrate depending on the configuration of the photovoltaic cell. For example, the substrate is a superstrate, if when assembled into a photovoltaic cell, it is on the light incident side of a photovoltaic cell. The superstrate can provide protection for the photovoltaic materials from impact and environmental degradation while allowing transmission of the appropriate wavelengths of the solar spectrum. Further, multiple

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photovoltaic cells can be arranged into a photovoltaic module. Photovoltaic device can describe either a cell, a module, or both.

[0019] As used herein, the term "adjacent" can be defined as being in close proximity. Adjacent structures may or may not be in physical contact with each other. Adjacent structures can have other layers and/or structures disposed between them.

[0020] One embodiment is a glass comprising, in weight percent:

- 50 to 75 percent SiO_2 ;
- 1 to 20 percent Al_2O_3 ;
- 0 to 3 percent TiO_2 ;
- 0 to 10 percent B_2O_3 ;
- 8 to 25 percent total M_2O ; and
- 0 to 50 percent total RO;

wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr.

[0021] A glass comprising, in weight percent:

- 50 to 75 percent SiO_2 ;
- 1 to 20 percent Al_2O_3 ;
- 0 to 3 percent TiO_2 ;
- 0 to 4 percent MgO;
- 0 to 10 percent B_2O_3 ;
- 8 to 25 percent total M_2O ; and
- less than 14 percent total RO;

wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr, wherein the glass is fusion formable and has a strain point of

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540°C or greater, a coefficient of thermal expansion of 50×10^{-7} or greater, T_{200} less than 1630°C, and having a liquidus viscosity of 150,000 poise or greater.

[0022] According to one embodiment, the glass comprises:

53 to 72 percent SiO_2 ;
2 to 17 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;
0 to 8 percent B_2O_3 ;
8 to 25 percent total M_2O ; and
0 to 50 percent total RO.

[0023] According to another embodiment, the glass comprises:

55 to 72 percent SiO_2 ;
2 to 9 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;
0 to 8 percent B_2O_3 ;
8 to 20 percent total M_2O ; and
0 to 30 percent total RO;

wherein, the glass comprises at least 2 weight percent Na_2O .

[0024] In another embodiment, the glass comprises:

1 to 8 percent Na_2O ;
5 to 16 percent K_2O ;
0 to 8 percent MgO ;
0 to 7 percent CaO ;
0 to 7 percent SrO ; and
0 to 21 percent BaO .

[0025] In another embodiment, the glass comprises:

2 to 5 percent Na_2O ;
8 to 15 percent K_2O ;
0 to 5 percent MgO ;
1 to 6 percent CaO ;
0 to 6 percent SrO ; and
0 to 12 percent BaO .

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[0026] In another embodiment, the glass comprises:

53 to 71 SiO_2 ;
2 to 17 Al_2O_3 ;
8 to 22 total M_2O ; and
0 to 40 total RO;

wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr.

[0027] In another embodiment, the glass comprises:

53 to 71 SiO_2 ;
2 to 17 Al_2O_3 ;
8 to 22 total M_2O ; and
0 to 40 total RO;

wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr.

[0028] In another embodiment, the glass comprises:

65 to 76 SiO_2 ;
1 to 7 Al_2O_3 ;
2.5 to 5 Na_2O ;
5.5 to 11 K_2O ;
0 to 8 MgO ;
1 to 7 CaO ; and
0 to 6 BaO .

[0029] The glass, in one embodiment, is rollable. The glass, in one embodiment, is down-drawable. The glass can be slot drawn or fusion drawn, for example. According to another embodiment the glass can be float formed.

[0030] The glass can further comprise 3 weight percent or less, for example, 0 to 3 weight percent, for example, greater than

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0 to 3 weight percent, for example, 1 to 3 weight percent of TiO_2 , MnO , ZnO , Nb_2O_5 , MoO_3 , Ta_2O_5 , WO_3 , ZrO_2 , Y_2O_3 , La_2O_3 , HfO_2 , CdO , SnO_2 , Fe_2O_3 , CeO_2 , As_2O_3 , Sb_2O_3 , Cl , Br , or combinations thereof. In some embodiments, the glass is substantially free of ZrO_2 . In some embodiments, the glass is substantially free of ZnO . The glass, in one embodiment, comprises 3 weight percent or less, for example, 0 to 3 weight percent, for example, greater than 0 to 3 weight percent, for example, 1 to 3 weight percent of TiO_2 .

[0031] As mentioned above, the glasses, according some embodiments, comprise 0 to 10 weight percent, for example, greater than 0 to 10 weight percent B_2O_3 , for example, 0.5 to 10 weight percent B_2O_3 , for example 1 to 10 weight percent B_2O_3 . B_2O_3 is added to the glass to reduce melting temperature, to decrease liquidus temperature, to increase liquidus viscosity, and to improve mechanical durability relative to a glass containing no B_2O_3 .

[0032] The glass, according to one embodiment, comprises greater than 0 to 50 percent RO, for example, 0.5 to 50 percent RO, for example, 1 to 50 percent RO wherein, R is an alkaline earth metal. The glass, according to one embodiment, comprises less than 14 percent RO, for example, 0.5 to less than 14 percent RO, for example, 0.5 to 13 percent RO.

[0033] The glass can comprise, for example, 0 to 8, greater than 0 to 8 weight percent, for example, 1 to 8 weight percent MgO . The glass can comprise, for example, 0 to 5, greater than 0 to 5 weight percent, for example, 1 to 5 weight percent MgO , for example, 1 to 4 percent MgO . MgO can be added to the glass to reduce melting temperature and to increase strain point. It can disadvantageously lower CTE relative to other alkaline earths (e.g., CaO , SrO , BaO), and so other adjustments may be made to keep the CTE within the desired

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range. Examples of suitable adjustments include increase SrO at the expense of CaO, increasing alkali oxide concentration, and replacing a smaller alkali oxide (e.g., Na₂O) in part with a larger alkali oxide (e.g., K₂O).

[0034] According to another embodiment, the glass is substantially free of BaO. For example, the content of BaO can be 0.05 weight percent or less, for example, zero weight percent.

[0035] In some embodiments, the glass is substantially free of Sb₂O₃, As₂O₃, or combinations thereof, for example, the glass comprises 0.05 weight percent or less of Sb₂O₃ or As₂O₃ or a combination thereof. For example, the glass can comprise zero weight percent of Sb₂O₃ or As₂O₃ or a combination thereof.

[0036] The glasses, in some embodiments, comprise 0 to 7 weight percent CaO, for example, greater than 0, for example, 1 to 7 weight percent CaO, for example, 1 to 6 weight percent CaO. Relative to alkali oxides or SrO, CaO contributes to higher strain point, lower density, and lower melting temperature. It is a primary component of certain possible devitrification phases, particularly anorthite (CaAl₂Si₂O₈), and this phase has complete solid solution with an analogous sodium phase, albite (NaAlSi₃O₈). High Na and Ca contents taken alone can cause liquidus temperatures to be unacceptably high. However, the chemical sources for CaO include limestone, a very inexpensive material, so to the extent that high volume and low cost are factors, it is typically useful to make the CaO content as high as can be reasonably achieved relative to other alkaline earth oxides.

[0037] The glasses can comprise, in some embodiments, 0 to 7 weight percent SrO, for example, greater than zero to 7 weight percent, for example, 1 to 7 weight percent SrO, or for example, 0 to 6 weight percent SrO, for example, greater than

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zero to 6 weight percent, for example, 1 to 6 weight percent SrO. In some embodiments, the glass comprises less than 15 weight percent SrO, for example, 1 to 12 weight percent SrO. In certain embodiments, the glass contains no deliberately batched SrO, though it may of course be present as a contaminant in other batch materials. SrO contributes to higher coefficient of thermal expansion, and the relative proportion of SrO and CaO can be manipulated to improve liquidus temperature, and thus liquidus viscosity. SrO is not as effective as CaO or MgO for improving strain point, and replacing either of these with SrO tends to cause the melting temperature to increase.

[0038] Also as mentioned above, the glasses, according to some embodiments, include 8 to 25 percent M_2O , for example, 8 to 22 M_2O , 8 to 20 M_2O , where M is one of the alkali cations Li, Na, K, Rb and Cs. The alkali cations raise the CTE steeply, but also lower the strain point and, depending upon how they are added, increase melting temperatures. The least effective alkali oxide for CTE is Li_2O , and the most effective alkali oxide is Cs_2O . As noted above, sodium can participate in one of the possible devitrification phases of the inventive glasses, and while adjustments in other components can be used to counteract this, e.g., changing the $CaO/(CaO+SrO)$ ratio, this tendency may make it advantageous to replace sodium with other alkalis, or to use a mix of alkalis instead of sodium alone. If high volume and low cost are important, then it is desirable to as much as possible confine the alkali oxides to Na_2O and K_2O or combinations thereof.

[0039] In one embodiment, the glass comprises 1 to 8 weight percent Na_2O , for example, 2 to 8 weight percent Na_2O , for example, 3 to 8 weight percent Na_2O , for example, 4 to 8 weight percent Na_2O . In another embodiment, the glass comprises 1 to

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5 weight percent Na_2O , for example, 1 to 4 weight percent Na_2O , for example, 1 to 3 weight percent Na_2O , for example, 1 to 2 weight percent Na_2O .

[0040] In some embodiments, the weight percent of the combination of Na_2O and K_2O is greater than 3 percent, for example, greater than 5 percent, for example, greater than 10 percent, for example, greater than 12 percent.

[0041] Another embodiment is a glass consisting essentially of, in weight percent:

50 to 75 percent SiO_2 ;
1 to 20 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;
0 to 10 percent B_2O_3 ;
8 to 25 percent total M_2O ; and
0 to 50 percent total RO ;

wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr.

[0042] The glass, according to some embodiments, is down-drawable; that is, the glass is capable of being formed into sheets using down-draw methods such as, but not limited to, fusion draw and slot draw methods that are known to those skilled in the glass fabrication arts. Such down-draw processes are used in the large-scale manufacture of ion-exchangeable flat glass.

[0043] The fusion draw process uses a drawing tank that has a channel for accepting molten glass raw material. The channel has weirs that are open at the top along the length of the channel on both sides of the channel. When the channel fills with molten material, the molten glass overflows the weirs. Due to gravity, the molten glass flows down the outside

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surfaces of the drawing tank. These outside surfaces extend down and inwardly so that they join at an edge below the drawing tank. The two flowing glass surfaces join at this edge to fuse and form a single flowing sheet. The fusion draw method offers the advantage that, since the two glass films flowing over the channel fuse together, neither outside surface of the resulting glass sheet comes in contact with any part of the apparatus. Thus, the surface properties are not affected by such contact.

[0044] The slot draw method is distinct from the fusion draw method. Here the molten raw material glass is provided to a drawing tank. The bottom of the drawing tank has an open slot with a nozzle that extends the length of the slot. The molten glass flows through the slot/nozzle and is drawn downward as a continuous sheet therethrough and into an annealing region. Compared to the fusion draw process, the slot draw process provides a thinner sheet, as only a single sheet is drawn through the slot, rather than two sheets being fused together, as in the fusion down-draw process.

[0045] In order to be compatible with down-draw processes, the aluminoborosilicate glass described herein has a high liquidus viscosity. In one embodiment, the glass has a liquidus viscosity of 50,000 poise or greater, for example, 150,000 poise or greater, for example, 200,000 poise or greater, for example, 250,000 poise or greater, for example, 300,000 poise or greater, for example, 350,000 poise or greater, for example, 400,000 poise or greater, for example, greater than or equal to 500,000 poise. The liquidus viscosities of some exemplary glasses are closely correlated with the difference between the liquidus temperature and the softening point. For downdraw processes, some exemplary glasses advantageously have

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liquidus - softening point less than about 230°C, for example, less than 200°C.

[0046] Accordingly, in one embodiment, the glass has a strain point of 540°C or greater, for example, 540°C to 600°C. In some embodiments, the glass has a coefficient of thermal expansion of 50×10^{-7} or greater, for example, 60×10^{-7} or greater, for example, 70×10^{-7} or greater, for example, 80×10^{-7} or greater. In one embodiment, the glass has a strain point of from 50×10^{-7} to 90×10^{-7} .

[0047] In one embodiment, the glass has a coefficient of thermal expansion of 50×10^{-7} or greater and a strain point of 540°C or greater.

[0048] According to one embodiment, the glass is ion exchanged in a salt bath comprising one or more salts of alkali ions. The glass can be ion exchanged to change its mechanical properties. For example, smaller alkali ions, such as lithium or sodium, can be ion-exchanged in a molten salt containing one or more larger alkali ions, such as sodium, potassium, rubidium or cesium. If performed at a temperature well below the strain point for sufficient time, a diffusion profile will form in which the larger alkali moves into the glass surface from the salt bath, and the smaller ion is moved from the interior of the glass into the salt bath. When the sample is removed, the surface will go under compression, producing enhanced toughness against damage. Such toughness may be desirable in instances where the glass will be exposed to adverse environmental conditions, such as photovoltaic grids exposed to hail. A large alkali already in the glass can also be exchanged for a smaller alkali in a salt bath. If this is performed at temperatures close to the strain point, and if the glass is removed and its surface rapidly reheated to high temperature and rapidly cooled, the surface of the glass will

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show considerable compressive stress introduced by thermal tempering. This will also provide protection against adverse environmental conditions. It will be clear to one skilled in the art that any monovalent cation can be exchanged for alkalis already in the glass, including copper, silver, thallium, etc., and these also provide attributes of potential value to end uses, such as introducing color for lighting or a layer of elevated refractive index for light trapping.

[0049] According to another embodiment, the glass can be float formed as known in the art of float forming glass.

[0050] In one embodiment, the glass is in the form of a sheet. The glass in the form of a sheet can be thermally tempered.

[0051] In one embodiment, an Organic Light Emitting Diode device comprises the glass in the form of a sheet.

[0052] The glass, according to one embodiment, is transparent.

[0053] In one embodiment, a photovoltaic device comprises the glass in the form of a sheet. The photovoltaic device can comprise more than one of the glass sheets, for example, as a substrate and/or as a superstrate. In one embodiment, the photovoltaic device comprises the glass sheet as a substrate and/or superstrate, a conductive material adjacent to the substrate, and an active photovoltaic medium adjacent to the conductive material. In one embodiment, the active photovoltaic medium comprises a CIGS layer. In one embodiment, the active photovoltaic medium comprises a cadmium telluride (CdTe) layer. In one embodiment, the photovoltaic device comprises a functional layer comprising copper indium gallium diselenide or cadmium telluride. In one embodiment, the photovoltaic device the functional layer is copper indium gallium diselenide. In one embodiment, the functional layer is cadmium telluride.

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[0054] In one embodiment, the glass sheet is transparent. In one embodiment, the glass sheet as the substrate and/or superstrate is transparent.

[0055] According to some embodiments, the glass sheet has a thickness of 4.0mm or less, for example, 3.5mm or less, for example, 3.2mm or less, for example, 3.0mm or less, for example, 2.5mm or less, for example, 2.0mm or less, for example, 1.9mm or less, for example, 1.8mm or less, for example, 1.5mm or less, for example, 1.1mm or less, for example, 0.5mm to 2.0mm, for example, 0.5mm to 1.1mm, for example, 0.7mm to 1.1mm. Although these are exemplary thicknesses, the glass sheet can have a thickness of any numerical value including decimal places in the range of from 0.1mm up to and including 4.0mm.

[0056] In one embodiment, an electrochromic device comprises the glass in the form of a sheet. The electrochromic device can be, for example, an electrochromic window. In one embodiment, the electrochromic window comprises one or more of the glass sheets, such as in a single, double, or triple pane window.

[0057] The fusion formable glasses of this invention, by virtue of their relatively high strain point, represent advantaged substrate materials for CIGS photovoltaic modules. When manufactured by the fusion process, their superior surface quality relative to that of float glass may also result in further improvements to the photovoltaic module making process. Advantageous embodiments of this invention are characterized by liquidus viscosity in excess of 400,000 poise, thereby enabling the fabrication of the relatively thick glass sheet that may be required by some module manufacturers. Finally, the most advantageous embodiments of this invention comprise glasses for which the 200 poise

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temperature is less than 1580°C, providing for the possibility of significantly lower cost melting/forming.

Examples

[0058] The following is an example of how to fabricate a sample of an exemplary glass, according to one embodiment of the invention, as shown in Table 1. This composition corresponds to composition number 12 shown in Table 4.

oxide	mol%
SiO ₂	74.75
Al ₂ O ₃	1.76
MgO	5.23
CaO	5.66
SrO	2.78
Na ₂ O	3.00
K ₂ O	6.72
SnO ₂	0.10

Table 1.

In some embodiments, the total does not add up to 100%, since certain tramp elements are present at non-negligible concentrations.

[0059] Batch materials, as shown in Table 2 were weighed and added to a 4 liter plastic container:

Batch Components	batch weight
sand	1656.84
alumina	65.71
Magnesia	79.80
Limestone	221.90
Strontium carbonate	161.38
Sodium carbonate	117.06
Potassium carbonate	353.91
10% SnO ₂ and 90% sand	57.6

Table 2.

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[0060] It should be appreciated that in the batch, limestone, depending on the source can contain tramp elements and/or vary amounts of one or more oxides, for example, MgO and/or BaO. The sand is advantageously beneficiated so that at least 80% by mass passes 60 mesh, for example 80 mesh, for example 100 mesh. The SnO₂ added, in this example, was pre-mixed with sand at a level of 10% by weight so as to ensure homogeneous mixing with the other components. The bottle containing the batch materials was mounted to a tumbler and the batch materials were mixed so as to make a homogeneous batch and to break up soft agglomerates. The mixed batch was transferred to a 1800cc platinum crucible and placed into a high-temperature ceramic backer. The platinum in its backer was loaded into a glo-bar furnace idling at a temperature of 1600°C. After 16 hours, the crucible+backer was removed and the glass melt was poured onto a cold surface, such as a steel plate, to form a patty, and then transferred to an annealer held at a temperature of 615°C. The glass patty was held at the annealer temperature for 2 hours, then cooled at a rate of 1°C per minute to room temperature.

[0061] Table 3, Table 4, Table 5, Table 6, Table 7, Table 8, and Table 9 show exemplary glasses, according to embodiments of the invention, and made according to the above example. Properties data for some exemplary glasses are also shown in Table 3, Table 4, Table 5, Table 6, Table 7, Table 8, and Table 9.

[0062] In the Tables T_{str} (°C) is the strain point which is the temperature when the viscosity is equal to $10^{14.7}$ P as measured by beam bending or fiber elongation. T_{ann} (°C) is the annealing point which is the temperature when the viscosity is equal to $10^{13.18}$ P as measured by beam bending or fiber elongation. T_s (°C) is the softening point which is the temperature when the

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viscosity is equal to $10^{7.6}$ P as measured by beam bending or fiber elongation. $\alpha(10^{-7}/^{\circ}\text{C})$ or $a(10^{-7}/^{\circ}\text{C})$ in the Tables is the coefficient of thermal expansion (CTE) which is the amount of dimensional change from either 0 to 300°C or 25 to 300°C depending on the measurement. CTE is typically measured by dilatometry. $r(\text{g/cc})$ is the density which is measured with the Archimedes method (ASTM C693). $T_{200}(^{\circ}\text{C})$ is the two-hundred Poise (P) temperature. This is the temperature when the viscosity of the melt is 200P as measured by HTV (high temperature viscosity) measurement which uses concentric cylinder viscometry. $T_{\text{liq}}(^{\circ}\text{C})$ is the liquidus temperature. This is the temperature where the first crystal is observed in a standard gradient boat liquidus measurement (ASTM C829-81). Generally this test is 72 hours but can be as short as 24 hours to increase throughput at the expense of accuracy (shorter tests could underestimate the liquidus temperature). $\eta_{\text{liq}}(^{\circ}\text{C})$ is the liquidus viscosity. This is the viscosity of the melt corresponding to the liquidus temperature.

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Example	1	2	3	4	5	6	7	8	9	10	11
Composition (mol%)											
Na ₂ O	6	2	3	3	2	3	3.92	3.92	3.16	3.16	3.14
K ₂ O	6	10	9	9	10.5	9.5	7.83	7.83	10.03	9.03	9.95
MgO	5.74	5.74	6.25	5.5	11	11	5.63	5.62	7.08	7.07	7.02
CaO	2.23	2.23	6.75	5.9	3.1	3.1	3.43	3.43	3.27	3.93	3.25
SrO	1.55	1.55	3.3	2.9	1	1	2.35	2.35	1.05	1.39	1.04
BaO	0	0	2	4	0	0	0	0	0	0	0
TiO ₂	0	0	0	0	0	0	0	0	0	0	0
B ₂ O ₃	0.8	0.8	0	0	1.65	1.65	0.78	0.78	0.72	0.72	1.5
Al ₂ O ₃	4.8	4.8	2.35	2.35	3.15	3.15	4.7	6.66	4.34	4.35	5.3
SiO ₂	72.81	72.81	67.25	67.25	67.5	67.5	71.29	69.34	70.25	70.25	68.7
SnO ₂	0.07	0.07	0.1	0.1	0.1	0.1	0.07	0.07	0.1	0.1	0.1
Composition (wt%)	1	2	3	4	5	6	7	8	9	10	11
Na ₂ O	5.81	1.9	2.81	2.73	1.95	2.94	3.74	3.7	3.03	3.04	2.99
K ₂ O	8.84	14.5	12.8	12.5	15.6	14.2	11.4	11.3	14.7	13.2	14.4
MgO	3.62	3.55	3.81	3.26	6.98	7.03	3.51	3.46	4.43	4.44	4.36
CaO	1.96	1.92	5.73	4.87	2.74	2.76	2.97	2.94	2.84	3.43	2.81
SrO	2.52	2.47	5.18	4.42	1.64	1.65	3.76	3.72	1.69	2.24	1.66
BaO	0	0	4.64	9.02	0	0	0	0	0	0	0
TiO ₂	0	0	0	0	0	0	0	0	0	0	0
B ₂ O ₃	0.87	0.86	0	0	1.81	1.82	0.84	0.83	0.78	0.78	1.61
Al ₂ O ₃	7.66	7.51	3.63	3.53	5.07	5.09	7.4	10.4	6.86	6.9	8.32
SiO ₂	68.5	67.1	61.1	59.4	63.9	64.2	66.2	63.5	65.4	65.7	63.5
SnO ₂	0.17	0.16	0.23	0.22	0.24	0.24	0.16	0.16	0.23	0.23	0.23
T _{sr} (°C)	548	581	552	544	573	559	560	577	560	567	562
T _{ann} (°C)	595	632	599	591	622	607	609	627	611	617	612
T _s (°C)	824	879	796	787							
a (10 ⁻⁷ /°C)	79.2	80.5	90.4	92.5	83	83.9	82.2	82.2			
r (gm/cc)	2.457	2.448	2.635	2.699	2.474	2.479	2.489	2.497	2.467	2.476	2.469
T ₂₀₀ (°C)				1392		1499	1575	1616	1581	1569	1570
T _{liq} (°C)	970	995	1015	970	1115	1060	1000	1100	1035	1062	1077
h _{liq} (kp)				105		56	351	88	175	101	71

Table 3.

SP09-155PCT

Example	12	13	14	15	16	17	18	19	20	21	22
Composition (mol%)											
Na ₂ O	3	3	3	3	3	3	3.75	3.75	3.75	4.61	3.95
K ₂ O	7.17	7.17	6.97	6.65	6.59	6.59	6.96	6.69	6.43	6	7.89
MgO	6.59	6.59	6.47	5.18	5.13	5.13	5.01	4.82	4.63	4.31	6.67
CaO	5.54	5.54	5.42	5.6	5.55	5.55	5.41	5.2	4.99	4.66	3.46
SrO	2.47	2.47	2.41	2.75	2.72	2.72	3.67	3.53	3.38	3.16	2.37
BaO	0	0	0	1	2	2	0	0	0	0	0
TiO ₂	0	0	0	0	0	0	0	0	0	0	0
B ₂ O ₃	0	0	0	0	0	0	0.7	0.67	0.64	0.6	0
Al ₂ O ₃	1.88	3.38	2.38	2.74	1.72	2.72	4.18	4.02	3.86	5.3	4.39
SiO ₂	73.25	71.75	73.25	72.98	73.19	72.19	70.24	71.24	72.24	71.28	71.2
SnO ₂	0.1	0.1	0.1	0.1	0.1	0.1	0.08	0.08	0.08	0.08	0.07
Composition (wt%)											
Na ₂ O	2.94	2.91	2.94	2.87	2.85	2.83	3.58	3.59	3.6	4.39	3.8
K ₂ O	10.7	10.6	10.4	9.7	9.54	9.48	10.1	9.74	9.39	8.7	11.6
MgO	4.22	4.17	4.13	3.24	3.18	3.16	3.12	3.01	2.9	2.68	4.18
CaO	4.93	4.88	4.81	4.87	4.79	4.76	4.67	4.51	4.34	4.03	3.02
SrO	4.07	4.02	3.96	4.42	4.34	4.31	5.86	5.65	5.42	5.04	3.82
BaO	0	0	0	2.38	4.72	4.69	0	0	0	0	0
TiO ₂	0	0	0	0	0	0	0	0	0	0	0
B ₂ O ₃	0	0	0	0	0	0	0.75	0.72	0.69	0.64	0
Al ₂ O ₃	3.04	5.42	3.84	4.33	2.7	4.24	6.57	6.33	6.1	8.32	6.95
SiO ₂	69.8	67.7	69.6	67.9	67.6	66.3	65.1	66.2	67.3	65.9	66.5
SnO ₂	0.24	0.24	0.24	0.23	0.23	0.23	0.19	0.19	0.19	0.19	0.16
T _{sur} (°C)	567	580	573	569	557	567	563	563	563	565	564
T _{ann} (°C)	618	632	623	620	607	617	611	611	611	614	615
T _s (°C)											
a (10 ⁻⁷ /°C)	79	78.8	79.2	78.5	79.9	79.9	81.7	81.1	78.9	79.4	83.3
r (gm/cc)	2.496	2.503	2.494	2.541	2.584	2.584	2.541	2.529	2.521	2.516	2.494
T ₂₀₀ (°C)	1542	1570	1559	1549	~1520	1529	~1530	1546	~1565	1585	1585
T _{liq} (°C)	1020	1075	1030	1045	955	1015	1055	1055	1050	1030	1020
h _{liq} (kp)	194	92	190	121	~630	194	~70	80	~110	175	292

Table 4.

SP09-155PCT

Example	23	24	25	26	27	28	29	30	31	32	33
Composition (mol%)											
Na ₂ O	3.1	3.12	3.62	3.2	3.33	3.02	4.3	4	3	3.98	4.3
K ₂ O	8.59	8.64	7.25	10.14	7.52	6.82	7.6	4.93	6	6.88	9.75
MgO	10.06	10.11	6.25	5	3.12	2.86	3.3	4.22	0	9.06	4.5
CaO	2.85	2.86	4.55	3.31	5.22	4.73	5.6	7.77	0	2.56	1.75
SrO	0.91	0.91	2.18	1.07	0.36	0.34	1	2.4	0.21	1.76	0.8
BaO	0	0	0	0	0	0	0	1.43	10.12	1.44	1.05
TiO ₂	0	0	0	0	0	0	0	0	0	0	1
B ₂ O ₃	1.51	1	1	1.76	2.71	2.46	2.4	2.51	7.83	0.88	1.15
Al ₂ O ₃	2.88	2.9	4.8	5.36	4.59	4.54	7.2	5.42	6	4.44	7.1
SiO ₂	70	70.36	70.25	70.08	73.06	75.24	68.5	66.89	66.83	68.9	68.6
SnO ₂	0.15	0.15	0.1	0.08	0.1	0.1	0.1	0.1	0.1	0.1	0
Composition (wt%)	23	24	25	26	27	28	29	30	31	32	33
Na ₂ O	3.05	3.07	3.48	3.02	3.21	2.91	4.05	3.78	2.47	3.8	3.96
K ₂ O	12.9	13	10.6	14.6	11	10	10.9	7.09	7.52	10	13.7
MgO	6.46	6.49	3.92	3.08	1.96	1.8	2.03	2.6	0	5.64	2.7
CaO	2.54	2.56	3.97	2.84	4.56	4.13	4.78	6.66	0	2.22	1.46
SrO	1.5	1.5	3.51	1.7	0.58	0.54	1.58	3.8	0.29	2.82	1.23
BaO	0	0	0	0	0	0	0	3.35	20.7	3.41	2.4
TiO ₂	0	0	0	0	0	0	0	0	0	0	1.19
B ₂ O ₃	1.67	1.11	1.08	1.87	2.94	2.67	2.55	2.67	7.26	0.95	1.19
Al ₂ O ₃	4.68	4.71	7.61	8.35	7.29	7.22	11.2	8.44	8.14	6.99	10.8
SiO ₂	66.9	67.3	65.6	64.3	68.4	70.5	62.7	61.4	53.4	63.9	61.4
SnO ₂	0.24	0.24	0.23	0.18	0.02	0.23	0.23	0.23	0.2	0.23	0
T _{sr} (°C)	560	561	571	562	561	571	565	568	551	562	553
T _{ann} (°C)	609	611	620	611	607	621	610	612	590	608	601
T _s (°C)							831				
a (10 ⁻⁷ /°C)	81.6	82.4	79.7	86	76.7	69.9	80.2	75.7	74.9	79.1	87.3
r (gm/cc)	2.462	2.462	2.498	2.463	2.445	2.421	2.472	2.582	2.796	2.538	2.498
T ₂₀₀ (°C)	1558	1549	1595	1610	1613	1660	1584		1410	1548	1623
T _{liq} (°C)	1065	1070	1095	1010	1020	1040	1070	1090	930	1050	1100
h _{liq} (kp)	90	81	71	344	142	270	69		124	110	67

Table 5.

SP09-155PCT

Example	34	35	36	37	38	39	40	41	42	43	44
Composition (mol%)											
Na ₂ O	4.2	3.5	4.2	4.2	3	3	3.3	4	4	6.42	7.15
K ₂ O	6.2	7.5	6.2	6.2	7	7	6.8	7.5	6.5	6.06	5.7
MgO	6	0	6	6	5.4	5.4	5.5	4.9	5.3	0	0
CaO	2.3	0	2.3	2.3	5.8	5.8	4.9	4.9	5.3	5.34	5.7
SrO	1.6	0.18	1.6	1.6	2.9	2.9	2.6	0.05	0.05	0.05	0.04
BaO	2.1	8.62	2.1	2.1	0	0	0.5	2.35	2.55	2.29	1.91
TiO ₂	1	0	2	2	2	2	2	0	0	0	0
B ₂ O ₃	0.8	6.6	0.8	0.8	0	0	0.2	0.8	0.8	3.36	2.8
Al ₂ O ₃	5	6	6	7	1.9	2.9	3.4	7	7	9.8	11
SiO ₂	70.8	67.6	68.8	67.8	72	71	70.8	68.5	68.5	65.48	64.7
SnO ₂	0	0	0	0	0	0	0	0	0	0	0
Composition (wt%)	34	35	36	37	38	39	40	41	42	43	44
Na ₂ O	3.93	2.92	3.9	3.87	2.91	2.89	3.16	3.7	3.72	5.76	6.42
K ₂ O	8.85	9.55	8.77	8.71	10.4	10.3	9.91	10.6	9.2	8.29	7.81
MgO	3.66	0	3.63	3.61	3.42	3.4	3.43	2.96	3.21	0	0
CaO	1.95	0	1.94	1.92	5.11	5.07	4.25	4.12	4.47	4.35	4.65
SrO	2.51	0.25	2.49	2.47	4.72	4.69	4.17	0.08	0.08	0.08	0.06
BaO	4.88	17.9	4.83	4.8	0	0	1.19	5.4	5.88	5.1	4.26
TiO ₂	1.21	0	2.4	2.38	2.51	2.49	2.47	0	0	1.39	1.16
B ₂ O ₃	0.84	6.21	0.84	0.83	0	0	0.22	0.83	0.84	3.4	2.83
Al ₂ O ₃	7.72	8.27	9.18	10.6	3.04	4.61	5.37	10.7	10.7	14.5	16.3
SiO ₂	64.4	54.9	62	60.8	67.9	66.6	65.8	61.6	61.9	57.1	56.5
SnO ₂	0	0	0	0	0	0	0	0	0	0	0
T _{sr} (°C)	563	546	571	580	567	574	568	567	574	555	559
T _{ann} (°C)	611	585	618	628	615	622	616	617	623	599	603
T _s (°C)											
a (10 ⁻⁷ /°C)	77.2	80.5	77.3	76.9	77.2	77	77.3	83.1	78	81.1	82.9
r (gm/cc)	2.546	2.747	2.565	2.566	2.525	2.532	2.538	2.536	2.547	2.543	2.537
T ₂₀₀ (°C)	1597	1423	1595	1603	1513	1536	1555	1596	1587	1571	1611
T _{liq} (°C)	1000	950	1040	1070	1015	1065	1020	1100	1125	1030	1060
h _{liq} (kp)	364	78	164	111	140	67	162	65	43	98	106

Table 6.

SP09-155PCT

Example	45	46	47	48	49	50	51
Composition (mol%)							
Na ₂ O	4	4	4.3	3.93	3.95	3.2	2.95
K ₂ O	8	6	6.45	7.86	7.89	9.81	9.04
MgO	5.74	5.74	6.16	5.65	5.67	0.51	0.46
CaO	2.23	2.23	2.39	3.44	3.46	5.09	4.69
SrO	1.55	1.55	1.65	2.36	2.37	0	0
BaO	0	2	2.15	0	0	0	0
TiO ₂	0	0	0	0	0	0	0
B ₂ O ₃	0.8	0.8	0.86	0.4	0	2.34	2.15
Al ₂ O ₃	4.8	4.8	5.15	4.72	4.74	5.06	4.97
SiO ₂	72.81	72.78	70.78	71.57	71.85	74.01	75.65
SnO ₂	0.07	0.1	0.1	0.07	0.07	0.1	0.1
Composition (wt%)	45	46	47	48	49	50	51
Na ₂ O	3.83	3.76	4.02	3.75	3.77	3.02	2.79
K ₂ O	11.7	8.6	9.18	11.4	11.5	14.1	13
MgO	3.59	3.52	3.76	3.52	3.53	0.31	0.28
CaO	1.94	1.9	2.03	2.98	3	4.35	4.02
SrO	2.49	2.45	2.61	3.78	3.8	0	0
BaO	0	4.67	4.99	0	0	0	0
TiO ₂	0	0	0	0	0	0	0
B ₂ O ₃	0.86	0.85	0.91	0.43	0	2.49	2.29
Al ₂ O ₃	7.59	7.45	7.93	7.43	7.47	7.87	7.76
SiO ₂	67.8	66.5	64.3	66.4	66.7	67.8	69.6
SnO ₂	0.16	0.23	0.23	0.16	0.16	0.02	0.23
T_{sr} (°C)	560	560	555	558	564	560	565
T_{ann} (°C)	609	614	605	608	616	605	613
T_s (°C)	846	856	839				
a (10⁻⁷/°C)	80.4	75.3	77.7	83.2	83.3	80.7	77.4
r (gm/cc)	2.521	2.528	2.551	2.489	2.488	2.435	2.425
T₂₀₀ (°C)	1630	1613	1588	1607	1622	1603	1660
T_{liq} (°C)	930	990	1000	905	990	910	930
h_{liq} (kp)	2843	705	429	5378	781	1524	1679

Table 7.

SP09-155PCT

Example	52	53	54	55	56	57	58	59
Composition (mol%)								
Na ₂ O	3.13	3.2	3	3.95	4.5	4.2	3.5	3.5
K ₂ O	9.93	10.14	6.72	7.89	6	6.2	7.5	7.5
MgO	7	5	5.23	5.67	1.6	6	0	0
CaO	3.24	3.31	5.66	3.46	3.4	2.3	3.9	3.9
SrO	1.04	1.07	2.78	3.37	0.1	1.6	0.08	0.08
BaO	0	0	0	0	5.2	2.1	3.82	3.82
TiO ₂	0	0	0	0	0	2	2	2
B ₂ O ₃	1.72	1.76	0	0	7.1	0.8	5.6	5.6
Al ₂ O ₃	3.29	3.36	1.76	4.39	6	5	5	6
SiO ₂	70.55	72.06	74.75	71.2	66.1	69.8	68.6	67.6
SnO ₂	0.1	0.1	0.1	0.07	0	0	0	0
Composition (wt%)	52	53	54	55	56	57	58	59
Na ₂ O	3.02	3.06	2.93	3.76	3.98	3.92	3.13	3.11
K ₂ O	14.6	14.8	10	11.4	8.09	8.82	10.2	10.2
MgO	4.4	3.12	3.34	3.52	0.92	3.65	0	0
CaO	2.83	2.87	5.01	2.99	2.73	1.95	3.16	3.14
SrO	1.68	1.72	4.56	5.37	0.15	2.5	0.12	0.12
BaO	0	0	0	0	11.4	4.86	8.47	8.42
TiO ₂	0	0	0	0	0	2.41	2.31	2.3
B ₂ O ₃	1.87	1.9	0	0	7.08	0.84	5.64	5.6
Al ₂ O ₃	5.23	5.3	2.84	6.88	8.76	7.7	7.37	8.79
SiO ₂	66.1	67	71	65.8	56.9	63.3	59.6	58.4
SnO ₂	0.24	0.23	0.24	0.16	0	0	0	0
T _{str} (°C)	553	549	565	559	540	564	549	549
T _{ann} (°C)	600	597	615	609	580	611	589	590
T _s (°C)								
a (10 ⁻⁷ /°C)	84.8	86.3	77.4	84.8	78	76.2	77.5	77.9
r (gm/cc)	2.466	2.463	2.498	2.52	2.468	2.559	2.604	2.601
T ₂₀₀ (°C)	1529	1553	1568	1578	1425	1566	1476	1485
T _{liq} (°C)	910	845	995	980	865	980	880	900
h _{liq} (kp)	1693	9012	422	514	650	468	933	518

Table 8.

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Example	60	61	62
Composition (mol%)			
Na ₂ O	3.2	3.07	3.71
K ₂ O	9.14	8.77	7.16
MgO	5	4.8	5.28
CaO	4.06	3.89	4.77
SrO	1.32	1.27	0.94
BaO	0	0	4
TiO ₂	0	0	0
B ₂ O ₃	1.76	5.76	1.55
Al ₂ O ₃	5.36	5.14	4.71
SiO ₂	70.08	67.23	67.8
SnO ₂	0.08	0.08	0.08
Composition (wt%)			
Na ₂ O	3.03	2.9	3.39
K ₂ O	13.21	12.63	9.96
MgO	3.09	2.96	3.14
CaO	3.49	3.34	3.95
SrO	2.1	2.02	1.44
BaO	0	0	9.06
TiO ₂	0	0	0
B ₂ O ₃	1.88	6.14	1.59
Al ₂ O ₃	8.39	8.01	7.09
SiO ₂	64.6	61.77	60.16
SnO ₂	0.18	0.18	0.18
T _{str} (°C)	565	558	561
T _{ann} (°C)	614	602	609
T _s (°C)			
a (10 ⁻⁷ /°C)	83.3	75.2	78
r (gm/cc)	2.472	2.46	2.63
T ₂₀₀ (°C)	1601	1537	1514
T _{liq} (°C)	1000	1020	980
h _{liq} (kp)	405	104	257

Table 9.

[0063] It will be apparent to those skilled in the art that various modifications and variations can be made to the present invention without departing from the spirit or scope of the invention. Thus, it is intended that the present invention cover the modifications and variations of this invention provided they come within the scope of the appended claims and their equivalents.

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CLAIMS

What is claimed is:

1. A glass comprising, in weight percent:
50 to 75 percent SiO_2 ;
1 to 20 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;
0 to 10 percent B_2O_3 ;
8 to 25 percent total M_2O ; and
0 to 50 percent total RO;
wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr.
2. The glass according to claim 1, comprising: 0.5 to less than 14 percent RO.
3. The glass according to claim 1, comprising: greater than 0 to 10 percent B_2O_3 .
4. The glass according to claim 1, comprising:
53 to 72 percent SiO_2 ;
2 to 17 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;
0 to 8 percent B_2O_3 ;
8 to 25 percent total M_2O ; and
0 to 50 percent total RO.
5. The glass according to claim 1, comprising:
55 to 72 percent SiO_2 ;
2 to 9 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;

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0 to 8 percent B_2O_3 ;
8 to 20 percent total M_2O ; and
0 to 30 percent total RO ;
wherein, the glass comprises at least 2 weight percent Na_2O .

6. The glass according to claim 1, comprising:

1 to 8 percent Na_2O ;
5 to 16 percent K_2O ;
0 to 8 percent MgO ;
0 to 7 percent CaO ;
0 to 7 percent SrO ; and
0 to 21 percent BaO .

7. The glass according to claim 1, comprising:

2 to 5 percent Na_2O ;
8 to 15 percent K_2O ;
0 to 5 percent MgO ;
1 to 6 percent CaO ;
0 to 6 percent SrO ; and
0 to 12 percent BaO .

8. The glass according to claim 1, wherein the glass is fusion formable and has a strain point of $540^{\circ}C$ or greater, a coefficient of thermal expansion of 50×10^{-7} or greater, T_{200} less than $1630^{\circ}C$, and having a liquidus viscosity of 150,000 poise or greater.

9. The glass according to claim 1, having a strain point of $540^{\circ}C$ or greater.

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10. The glass according to claim 1, having a coefficient of thermal expansion of 50×10^{-7} or greater.
11. The glass according to claim 1, having a liquidus viscosity of 50,000 poise or greater.
12. The glass according to claim 1, having a T_{200} less than 1580°C and a liquidus viscosity of 400,000 poise or greater.
13. The glass according to claim 1, comprising 1 to 8 weight percent Na_2O .
14. The glass according to claim 1, comprising:
 - 53 to 71 SiO_2 ;
 - 2 to 17 Al_2O_3 ;
 - 8 to 22 total M_2O ; and
 - 0 to 40 total RO ;wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr.
15. The glass according to claim 1, comprising:
 - 53 to 71 SiO_2 ;
 - 2 to 17 Al_2O_3 ;
 - 8 to 22 total M_2O ; and
 - 0 to 40 total RO ;wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an

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alkaline earth metal selected from Mg, Ca, Ba, and Sr.

16. The glass according to claim 1, comprising:

65 to 76 SiO₂;
1 to 7 Al₂O₃;
2.5 to 5 Na₂O;
5.5 to 11 K₂O;
0 to 8 MgO;
1 to 7 CaO; and
0 to 6 BaO.

17. The glass according to claim 1, wherein the glass is in the form of a sheet.

18. The glass according to claim 17, wherein the sheet has a thickness in the range of from 0.5mm to 3.0mm.

19. A photovoltaic device comprising the glass according to claim 1.

20. The photovoltaic device according to claim 19, wherein the glass is in the form of a sheet and is a substrate or a superstrate.

21. The photovoltaic device according to claim 20, comprising a functional layer comprising copper indium gallium diselenide or cadmium telluride adjacent to the substrate or superstrate.

22. A glass comprising, in weight percent:

50 to 75 percent SiO₂;

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1 to 20 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;
0 to 4 percent MgO ;
0 to 10 percent B_2O_3 ;
8 to 25 percent total M_2O ; and
less than 14 percent total RO;

wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr, wherein the glass is fusion formable and has a strain point of 540°C or greater, a coefficient of thermal expansion of 50×10^{-7} or greater, T_{200} less than 1630°C , and having a liquidus viscosity of 150,000 poise or greater.

23. A glass consisting essentially of, in weight percent:

50 to 75 percent SiO_2 ;
1 to 20 percent Al_2O_3 ;
0 to 3 percent TiO_2 ;
0 to 10 percent B_2O_3 ;
8 to 25 percent total M_2O ; and
0 to 50 percent total RO;

wherein, M is an alkali metal selected from Na, K, Li, Rb, and Cs and wherein the glass comprises at least 1 weight percent Na_2O ; and wherein, R is an alkaline earth metal selected from Mg, Ca, Ba, and Sr.