

CERAMIC COMPOSITION AND CERAMIC CAPACITOR

Field of the Invention

5 The present invention relates to a ceramic capacitor and ceramic compositions therefor; and, more particularly, to reduction resistive dielectric ceramic compositions suitable for use as a dielectric layer of a ceramic capacitor having internal electrodes made of a base metal
10 such as Ni and a ceramic capacitor fabricated by employing such ceramic compositions as a dielectric layer thereof.

Background of the Invention

15 Recently, a base metal, e.g., Ni, is widely used in forming internal electrodes of multilayer ceramic capacitors for the purpose of reducing manufacturing costs. In case the internal electrodes are composed of the base metal, it is required that chip-shaped laminated bodies including
20 therein the internal electrodes be sintered in a reductive atmosphere in order to prevent an oxidization of the internal electrodes. Accordingly, a variety of reduction resistive dielectric ceramic compositions have been developed.

25 Recent trend towards ever more miniaturized and dense electric circuits intensifies a demand for a further scaled



down multilayer ceramic capacitor with higher capacitance. Keeping up with such demand, there has been made an effort to fabricate thinner dielectric layers and to stack a greater number of the thus produced dielectric layers.

5 However, when the dielectric layers are thinned out, a voltage applied to a unit thickness intrinsically increases. Accordingly, the operating life of the dielectric layers is shortened and thus a reliability of the multilayer ceramic capacitor is also deteriorated.

10

Summary of the Invention

It is, therefore, an object of the present invention to provide highly reliable dielectric ceramic compositions and ceramic capacitors prepared by employing such dielectric
15 ceramic compositions in forming dielectric layers thereof, wherein the dielectric ceramic compositions exhibit such electrical characteristics as a dielectric constant equal to or greater than 3000, capacitance variation of -15% to
20 +15% (based on a capacitance obtained at a temperature of +25) in the temperature range from -55 to +125 , a dielectric loss " $\tan\delta$ " of 3.5% or less and an accelerated life of 200,000 seconds or greater.

In accordance with the present invention, there is
25 provided a dielectric ceramic composition comprising: 100 mole parts of oxides of Ba and Ti, a ratio Ba/Ti being 0.970 to 1.030; 0.25 to 1.5 mole parts of an oxide of Re, Re representing one or more elements selected from the group consisting of Sm, Eu, Gd, Tb, Dy, Ho, Er, Tm, Yb and Y; 0.2
30 to 1.5 mole parts of an oxide of Mg; and 0.03 to 0.6 mole

parts of oxides of one or more elements selected from the group consisting of Mn, V and Cr.

Brief Description of the Drawing

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The above and other objects and features of the present invention will become apparent from the following description of preferred embodiments given in conjunction with the accompanying drawing:

10 Drawing represents a schematic cross sectional view illustrating a multilayer ceramic capacitor.

Detailed Description of the Preferred Embodiments

15 Compound powders of TiO_2 , BaCO_3 , Re_2O_3 , MgO , Mn_2O_3 , V_2O_5 , Cr_2O_3 , MoO_3 and WO_3 were weighed in amounts as specified in the accompanying Tables 1-1 and 1-6, and mixed for about 20 hours by a wet method in a ball mill containing therein PSZ (partially sterilized zirconia) balls and water to thereby
20 obtain a ceramic slurry. The produced ceramic slurry was dehydrated and then dried by being heated at about 150 for 6 hours.

Table 1-1

Sample Number	Dielectric Composition mole parts								Ba/Ti Ratio
	Rare-earth (Re ₂ O ₃)		MgO				Total Content	MoO ₃	
	Element	Content		Mn ₂ O ₃	V ₂ O ₅	Cr ₂ O ₃			
1※	Ho	0.75	0.4	0.02			0.02	0.05	1.0050
2※	Ho	0.75	0.4		0.02		0.02	0.05	1.0050
3※	Ho	0.75	0.4			0.02	0.02	0.05	1.0050
4	Ho	0.75	0.4	0.03			0.03	0.05	1.0050
5	Ho	0.75	0.4		0.03		0.03	0.05	1.0050
6	Ho	0.75	0.4			0.03	0.03	0.05	1.0050
7	Ho	0.75	0.4	0.01	0.02		0.03	0.05	1.0050
8	Ho	0.75	0.4	0.05	0.02		0.07	0.05	1.0050
9	Ho	0.75	0.4	0.05		0.2	0.25	0.05	1.0050
10	Ho	0.75	0.4	0.05	0.01	0.2	0.26	0.05	1.0050
11	Ho	0.75	0.4	0.05	0.05	0.2	0.3	0.05	1.0050
12	Ho	0.75	0.4	0.2	0.2	0.2	0.6	0.05	1.0050
13	Ho	0.75	0.4	0.6			0.6	0.05	1.0050
14	Ho	0.75	0.4		0.6		0.6	0.05	1.0050
15	Ho	0.75	0.4			0.6	0.6	0.05	1.0050
16※	Ho	0.75	0.4	0.7			0.7	0.05	1.0050
17※	Ho	0.75	0.4		0.7		0.7	0.05	1.0050
18※	Ho	0.75	0.4			0.7	0.7	0.05	1.0050
19	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0	1.0050
20	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.025	1.0050
21	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.1	1.0050
22	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.2	1.0050
23	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.3	1.0050
24※	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.4	1.0050
25	Ho	0.75	0.4	0.025	0.05	0.2	0.275	0.05	1.0050
26※	Ho	0.00	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
27	Ho	0.25	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
28	Ho	0.5	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
29	Ho	1.0	0.4	0.15	0.05	0.2	0.4	0.05	1.0050

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Table 1-2

Sample Number	Dielectric Composition mole parts								Ba/Ti Ratio
	Rare-earth (Re ₂ O ₃)		MgO				Total Content	MoO ₃	
	Element	Content		Mn ₂ O ₃	V ₂ O ₅	Cr ₂ O ₃			
30	Ho	1.5	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
31※	Ho	2.0	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
32※	Ho	4.0	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
33	Sm	0.25	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
34	Sm	0.75	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
35	Eu	0.75	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
36	Gd	0.75	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
37	Tb	0.75	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
38	Dy	0.75	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
39	Er	0.75	0.3	0.15	0.05	0.2	0.4	0.05	1.0050
40	Tm	0.75	0.3	0.15	0.05	0.2	0.4	0.05	1.0050
41	Yb	0.75	0.3	0.15	0.05	0.2	0.4	0.05	1.0050
42	Yb	1.0	0.3	0.15	0.05	0.2	0.4	0.05	1.0050
43	Y	1.0	0.3	0.15	0.05	0.2	0.4	0.05	1.0050
44	Ho/Dy	0.5/0.5	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
45	Ho/Dy/Yb	0.5/0.5/0.5	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
46	Sm/Ho/Yb	0.2/0.5/0.1	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
47	Sm/Yb	0.5/1.0	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
48※	Ho	0.75	0	0.15	0.05	0.2	0.4	0.05	1.0050
49	Ho	0.75	0.2	0.15	0.05	0.2	0.4	0.05	1.0050
50	Ho	0.75	1.5	0.15	0.05	0.2	0.4	0.05	1.0050
51※	Ho	0.75	2.0	0.15	0.05	0.2	0.4	0.05	1.0050
52※	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.05	0.960
53	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.05	0.970
54	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.05	1.0070
55	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.05	1.030
56※	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.05	1.040

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Table 1-3

Sample Number	Dielectric Composition mole parts								Ba/Ti Ratio
	Rare-earth (Re ₂ O ₃)		MgO				Total Content	WO ₃	
	Element	Content		Mn ₂ O ₃	V ₂ O ₅	Cr ₂ O ₃			
57※	Ho	0.75	0.4	0.02			0.02	0.05	1.0050
58※	Ho	0.75	0.4		0.02		0.02	0.05	1.0050
59※	Ho	0.75	0.4			0.02	0.02	0.05	1.0050
60	Ho	0.75	0.4	0.03			0.03	0.05	1.0050
61	Ho	0.75	0.4		0.03		0.03	0.05	1.0050
62	Ho	0.75	0.4			0.03	0.03	0.05	1.0050
63	Ho	0.75	0.4	0.01	0.02		0.03	0.05	1.0050
64	Ho	0.75	0.4	0.05	0.02		0.07	0.05	1.0050
65	Ho	0.75	0.4	0.05		0.2	0.25	0.05	1.0050
66	Ho	0.75	0.4	0.05	0.01	0.2	0.26	0.05	1.0050
67	Ho	0.75	0.4	0.05	0.05	0.2	0.3	0.05	1.0050
68	Ho	0.75	0.4	0.2	0.2	0.2	0.6	0.05	1.0050
69	Ho	0.75	0.4	0.6			0.6	0.05	1.0050
70	Ho	0.75	0.4		0.6		0.6	0.05	1.0050
71	Ho	0.75	0.4			0.6	0.6	0.05	1.0050
72※	Ho	0.75	0.4	0.7			0.7	0.05	1.0050
73※	Ho	0.75	0.4		0.7		0.7	0.05	1.0050
74※	Ho	0.75	0.4			0.7	0.7	0.05	1.0050
75	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0	1.0050
76	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.025	1.0050
77	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.05	1.0050
78	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.1	1.0050
79	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.2	1.0050
80	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.3	1.0050
81※	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.4	1.0050
82	Ho	0.75	0.4	0.025	0.05	0.2	0.275	0.05	1.0050
83※	Ho	0.00	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
84	Ho	0.25	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
85	Ho	0.5	0.4	0.15	0.05	0.2	0.4	0.05	1.0050

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Table 1-4

Sample Number	Dielectric Composition mole parts								Ba/Ti Ratio
	Rare-earth (Re ₂ O ₃)		MgO				Total Content	WO ₃	
	Element	Content		Mn ₂ O ₃	V ₂ O ₅	Cr ₂ O ₃			
86	Ho	1.0	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
87	Ho	1.5	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
88※	Ho	2.0	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
89※	Ho	4.0	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
90	Sm	0.25	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
91	Sm	0.75	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
92	Eu	0.75	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
93	Gd	0.75	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
94	Tb	0.75	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
95	Dy	0.75	0.6	0.15	0.05	0.2	0.4	0.05	1.0050
96	Er	0.75	0.3	0.15	0.05	0.2	0.4	0.05	1.0050
97	Tm	0.75	0.3	0.15	0.05	0.2	0.4	0.05	1.0050
98	Yb	0.75	0.3	0.15	0.05	0.2	0.4	0.05	1.0050
99	Yb	1.0	0.3	0.15	0.05	0.2	0.4	0.05	1.0050
100	Y	1.0	0.3	0.15	0.05	0.2	0.4	0.05	1.0050
101	Ho/Dy	0.5/0.5	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
102	Ho/Dy/Yb	0.5/0.5/0.5	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
103	Sm/Ho/Yb	0.2/0.5/0.1	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
104	Sm/Yb	0.5/1.0	0.4	0.15	0.05	0.2	0.4	0.05	1.0050
105※	Ho	0.75	0	0.15	0.05	0.2	0.4	0.05	1.0050
106	Ho	0.75	0.2	0.15	0.05	0.2	0.4	0.05	1.0050
107	Ho	0.75	1.5	0.15	0.05	0.2	0.4	0.05	1.0050
108※	Ho	0.75	2.0	0.15	0.05	0.2	0.4	0.05	1.0050
109※	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.05	0.960
110	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.05	0.970
111	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.05	1.0070
112	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.05	1.030
113※	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.05	1.040

Table 1-5

Sample Number	Dielectric Composition mole parts										Ba/Ti Ratio
	Rare-earth (Re ₂ O ₃)		MgO	Total Content			Total Content				
	Element	Content		Mn ₂ O ₃	V ₂ O ₅	Cr ₂ O ₃	MoO ₃	WO ₃	Total Content		
114※	Ho	0.75	0.4	0.02			0.02	0.025	0.025	0.05	1.0050
115※	Ho	0.75	0.4		0.02		0.02	0.025	0.025	0.05	1.0050
116※	Ho	0.75	0.4			0.02	0.02	0.025	0.025	0.05	1.0050
117	Ho	0.75	0.4	0.03			0.03	0.025	0.025	0.05	1.0050
118	Ho	0.75	0.4		0.03		0.03	0.025	0.025	0.05	1.0050
119	Ho	0.75	0.4			0.03	0.03	0.025	0.025	0.05	1.0050
120	Ho	0.75	0.4	0.01	0.02		0.03	0.025	0.025	0.05	1.0050
121	Ho	0.75	0.4	0.05	0.02		0.07	0.025	0.025	0.05	1.0050
122	Ho	0.75	0.4	0.05		0.2	0.25	0.025	0.025	0.05	1.0050
123	Ho	0.75	0.4	0.05	0.01	0.2	0.26	0.025	0.025	0.05	1.0050
124	Ho	0.75	0.4	0.05	0.05	0.2	0.3	0.025	0.025	0.05	1.0050
125	Ho	0.75	0.4	0.2	0.2	0.2	0.6	0.025	0.025	0.05	1.0050
126	Ho	0.75	0.4	0.6			0.6	0.025	0.025	0.05	1.0050
127	Ho	0.75	0.4		0.6		0.6	0.025	0.025	0.05	1.0050
128	Ho	0.75	0.4			0.6	0.6	0.025	0.025	0.05	1.0050
129※	Ho	0.75	0.4	0.7			0.7	0.025	0.025	0.05	1.0050
130※	Ho	0.75	0.4		0.7		0.7	0.025	0.025	0.05	1.0050
131※	Ho	0.75	0.4			0.7	0.7	0.025	0.025	0.05	1.0050
132	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0	0	0	1.0050
133	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.0125	0.0125	0.025	1.0050
134	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.05	0.05	0.1	1.0050
135	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.1	0.1	0.2	1.0050
136	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.15	0.15	0.3	1.0050
137※	Ho	0.75	0.4	0.05	0.1	0.1	0.25	0.2	0.2	0.4	1.0050
138	Ho	0.75	0.4	0.025	0.05	0.2	0.275	0.025	0.025	0.05	1.0050
139※	Ho	0.00	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
140	Ho	0.25	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
141	Ho	0.5	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
142	Ho	1.0	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050

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Table 1-6

Sample Number	Dielectric Composition mole parts										Ba/Ti Ratio
	Rare-earth (Re ₂ O ₃)		MgO				Total Content			Total Content	
	Element	Content		Mn ₂ O ₃	V ₂ O ₅	Cr ₂ O ₃		MoO ₃	WO ₃		
143	Ho	1.5	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
144※	Ho	2.0	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
145※	Ho	4.0	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
146	Sm	0.25	0.6	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
147	Sm	0.75	0.6	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
148	Eu	0.75	0.6	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
149	Gd	0.75	0.6	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
150	Tb	0.75	0.6	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
151	Dy	0.75	0.6	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
152	Er	0.75	0.3	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
153	Tm	0.75	0.3	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
154	Yb	0.75	0.3	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
155	Yb	1.0	0.3	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
156	Y	1.0	0.3	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
157	Ho/Dy	0.5/0.5	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
158	Ho/Dy/Yb	0.5/0.5/0.5	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
159	Sm/Ho/Yb	0.2/0.5/0.1	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
160	Sm/Yb	0.5/1.0	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
161※	Ho	0.75	0	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
162	Ho	0.75	0.2	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
163	Ho	0.75	1.5	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
164※	Ho	0.75	2.0	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0050
165※	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	0.960
166	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	0.970
167	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.0070
168	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.030
169※	Ho	0.75	0.4	0.15	0.05	0.2	0.4	0.025	0.025	0.05	1.040

Thereafter, the dried ceramic slurry was ground and then calcined in air at about 800°C for 6 hours. The calcined slurry was then disaggregated by a wet method in a ball mill added with ethanol for 6 hours. Next, the
5 disaggregated ceramic slurry was dried by being heated at about 150°C for 6 hours, thereby obtaining the powder of the calcined ceramic slurry.

In a following step, a dielectric ceramic slurry was obtained by mixing and grinding 1000 g (100 parts by weight)
10 of the powder of the dielectric ceramic slurry, 15 wt% of an organic binder and 50 wt% of water in a ball mill, wherein the organic binder includes acrylic ester polymer, glycerin, and a solution of condensed phosphate.

Next, the dielectric slurry was subjected to a vacuum
15 air separator to remove air bubbles therefrom and formed into a thin film coated on a polyester film by using a reverse roll coater. Thus produced ceramic thin film on the polyester film was heated and dried at about 100 °C, and then diced to thereby obtain square ceramic green sheets
20 having a thickness of about 5 μm and a size of about 10 cm x 10 cm.

Meanwhile, 0.9 g of ethyl cellulose dissolved in 9.1 g of butyl carbitol and 10 g of Nickel powder having an average diameter of about 0.5 μm were loaded and stirred in
25 a stirrer for 10 hours to form a conductive paste for use in forming internal electrodes of ceramic capacitor.

Thereafter, the conductive paste was printed on the prepared ceramic green sheets to form conductive patterns thereon and then the printed conductive paste was dried.

Subsequently, ten ceramic green sheets having the
5 conductive patterns thereon were stacked against each other with the conductive patterns facing upward, thereby forming a laminated body. Every two neighboring sheets were disposed in such a manner that the conductive patterns provided thereon were shifted by one half of a pattern size
10 along the length direction. The laminated body also included one or more ceramic dummy sheets stacked against each of the uppermost and the lowermost ceramic green sheets having conductive patterns thereon, the ceramic dummy sheets representing ceramic green sheets without having conductive
15 patterns thereon.

Next, the laminated body was pressed with a load of about 40 tons at about 50 °C along the stacking direction of the ceramic sheets in the laminated body. Afterwards, the pressed laminated body was diced into a multiplicity of chip
20 shaped ceramic bodies having a size of about 3.2 mm x 1.6 mm.

Thereafter, Ni external electrodes were formed at two opposite sides of each respective chip shaped ceramic body by, e.g., a dipping method, one end portion of each of the internal electrodes being exposed to one of the two opposite
25 sides of each chip shaped ceramic body. Then, the chip shaped ceramic bodies were loaded into a furnace capable of

controlling an atmosphere therein and the organic binder contained in the loaded ceramic bodies was removed by heating the furnace in an N_2 atmosphere. Then, the binder-removed chip shaped ceramic bodies were sintered at about 1300 °C in a non-oxidative atmosphere with oxygen partial pressure being in 10^{-5} to 10^{-10} atm order range. Thereafter, the sintered chip-shaped ceramic bodies were re-oxidized in an oxidative atmosphere to thereby obtain multilayer ceramic capacitors as shown in the drawing wherein reference numerals 10, 12 and 14 represent dielectric layers, internal electrodes and external electrodes, respectively.

Tables 2-1 to 2-6 exhibit a measurement result of electrical characteristics obtained from the thus produced multilayer ceramic capacitors, wherein a thickness of each dielectric layer incorporated in the capacitors was about $3\mu m$.

The electrical characteristics of the multilayer ceramic capacitors were obtained as follows.

- (A) Relative permittivity (or dielectric constant) ϵ_s was computed based on a facing area of a pair of neighboring internal electrodes, a thickness of a dielectric layer positioned between the pair of neighboring internal electrodes, and the capacitance of a multilayer ceramic capacitor obtained under the condition of applying at 20 °C a voltage of 1.0 V (root mean square value) with

a frequency of 1kHz.

(B) Dielectric loss $\tan \delta$ (%) was obtained under the same condition as established for measuring the permittivity cited above.

5 (C) Resistivity (Ω cm) was acquired by measuring a resistance between a pair of external electrodes after DC 25 V was applied for 60 seconds at 20°C. The number following "E" in the notation of a resistivity value presented in the accompanying
10 Tables 2-1 to 2-6 represents an order. For instance, 2.5E + 12 represents 2.5×10^{12} .

(D) Accelerated life (second) was obtained by measuring time period until an insulation resistivity (ρ) becomes $1 \times 10^{10} \Omega$ cm in a DC
15 electric field of 20 V/ μ m at a temperature of 150°C.

(E) Capacitance variation $\Delta C/C_{25}$ (%) was obtained by measuring capacitances at -55°C, +25°C and +125°C in a thermostatic (or constant temperature) oven
20 under the condition of applying a voltage of 1 V (rms value) with a frequency of 1KHz, wherein C_{25} represents a capacitance at 25°C and ΔC represents the difference between C_{25} and a capacitance measured at -55°C to 125°C.

Table 2-1

Sample Number	Sintering Temperature (°C)	Permittivity	Tan δ (%)	Resistivity (Ω cm) at Room Temperature	Capacitance Variation $\Delta C/C_{25}$ (%)		Accelerated Life (sec)
					-55°C	125°C	
1*	1300	3780	3.3	2.5E+12	-13.4	-14.9	45,800
2*	1300	3860	3.2	6.7E+12	-14.6	-14.3	165,800
3*	1300	3850	3.7	2.0E+12	-14.8	-15	870
4	1300	3790	3.0	4.5E+12	-14	-14.9	287,900
5	1300	3530	2.9	6.9E+12	-13.4	-14.6	875,900
6	1300	3680	3.4	8.1E+11	-13.3	-14.4	458,900
7	1300	3790	3.4	9.4E+11	-12.5	-14.7	678,940
8	1300	3890	3.3	5.3E+12	-13.9	-13.5	897,500
9	1300	3850	3.4	7.4E+12	-14.5	-14.3	658,900
10	1300	3870	3.5	4.6E+12	-14.5	-14.9	764,900
11	1300	3750	3.4	5.6E+12	-14.4	-14.5	759,800
12	1300	3890	3.2	2.2E+12	9	-14.6	983,450
13	1300	3590	3.0	5.9E+12	-12.9	-14.9	398,500
14	1300	3740	3.0	9.5E+11	-14.5	-14.5	875,930
15	1300	3640	3.4	8.8E+12	-14.5	-14.1	754,900
16*	1300	3300	3.1	2.5E+12	-13.5	-13.4	987,500
17*	1300	3180	3.0	4.9E+12	-12.4	-13.5	1,496,000
18*	1300	3480	3.4	7.6E+12	-13	-14.9	289,540
19	1300	3870	3.4	4.3E+12	-14.4	-14.8	243,900
20	1300	3670	3.4	4.7E+13	-13.4	-14.4	456,700
21	1300	3890	3.5	5.3E+12	-14.9	-14.6	1,489,000
22	1300	3780	3.5	1.0E+13	-14.5	-15	2,985,000
23	1300	3680	3.1	2.0E+13	-13.9	-14.5	1,894,500
24*	1300	3650	3.8	4.4E+11	-14.6	-3.5	19,800
25	1300	3850	3.4	8.4E+13	-14.5	-14.9	598,700
26*	1300	5980	9.4	8.5E+12	-14.5	-25.2	390
27	1300	3560	3.5	5.6E+12	-14.5	-14.6	578,900
28	1300	3850	3.5	1.2E+12	-14.5	-15	459,680
29	1300	3500	3.4	9.5E+12	-14.5	-14.6	1,098,700

Table 2-2

Sample Number	Sintering Temperature (°C)	Permittivity	Tan δ (%)	Resistivity (Ω cm) at Room Temperature	Capacitance Variation $\Delta C/C_{25}$ (%)		Accelerated Life (sec)
					-55°C	125°C	
30	1300	3690	3.5	8.6E+12	-14.6	-15	476,900
31*	1300	Incapable of obtaining a sintered ceramic with high density					
32*	1300	Incapable of obtaining a sintered ceramic with high density					
33	1300	3780	3.5	1.4E+12	-14.5	-14.6	475,980
34	1300	3690	3.4	4.6E+12	-14.5	-14.8	389,500
35	1300	3890	3.5	2.5E+12	-14.4	-14.9	389,700
36	1300	3650	3.5	1.4E+12	-13.8	-13.4	498,030
37	1300	3780	3.4	8.4E+12	-15	-13.3	274,900
38	1300	3890	3.5	3.5E+12	-14.5	-15	367,800
39	1300	3840	3.5	1.0E+12	-14.3	-14.5	389,500
40	1300	3510	3.5	1.8E+12	-14.5	-15	398,000
41	1300	3670	3.1	6.5E+12	-14.5	-14.5	489,700
42	1300	3790	3.0	4.6E+12	-14.6	-14.6	354,700
43	1300	3890	3.5	5.7E+11	-14.5	-14.5	897,600
44	1300	3890	3.3	5.5E+12	-14.4	-14.9	456,900
45	1300	4020	3.5	1.0E+11	-14.5	-15	498,700
46	1300	3790	3.5	5.5E+12	-14.1	-14.5	569,000
47	1300	3580	3.3	1.4E+12	-14.5	-14.5	328,800
48*	1300	7960	14.4	2.6E+11	-35.9	-1.4	760
49	1300	3890	3.5	4.1E+12	-14.5	-14.6	289,700
50	1300	3870	2.6	1.6E+12	-13.5	-14.1	240,040
51*	1300	2340	3.5	1.4E+12	-13.9	-16.7	480
52*	1300	Incapable of obtaining a sintered ceramic with high density					
53	1300	3690	3.5	2.1E+13	-14.6	-14.9	348,990
54	1300	3650	3.3	4.4E+13	-14.5	-14.5	387,500
55	1300	3790	3.5	4.1E+13	-14.5	-14.7	365,900
56*	1300	3080	3.1	4.9E+13	-14.5	-14.5	4,800

Table 2-3

Sample Number	Sintering Temperature (°C)	Permittivity	Tan δ (%)	Resistivity (Ω cm) at Room Temperature	Capacitance Variation $\Delta C/C_{25}$ (%)		Accelerated Life (sec)
					-55°C	125°C	
57*	1300	3850	3.3	8.3E+12	-14.1	-14.9	147,500
58*	1300	3740	3.4	7.7E+12	-14.8	-14.2	165,900
59*	1300	3920	3.9	5.2E+12	-14.6	-14.3	63,200
60	1300	3820	3.3	4.8E+12	-14.2	-14.6	274,500
61	1300	3790	3.2	3.8E+12	-14.5	-13.9	636,400
62	1300	3810	3.4	1.6E+12	-14.3	-13.7	503,500
63	1300	3840	3.2	7.4E+12	-13.4	-14.8	462,800
64	1300	3860	3.1	8.3E+12	-14.1	-14.4	587,700
65	1300	3710	3.3	3.3E+12	-13.7	-14.8	1,376,200
66	1300	3830	3.5	8.1E+11	-13.9	-14.1	739,900
67	1300	3720	3.1	7.3E+12	-13.8	-14.5	356,200
68	1300	3620	3.3	5.5E+12	-14.2	-13.2	478,300
69	1300	3530	3.4	2.9E+12	-13.7	-14.6	368,400
70	1300	3620	3.4	8.2E+12	-13.6	-13.9	635,800
71	1300	3580	3.4	6.1E+12	-14.3	-14.2	739,200
72*	1300	3460	3.0	6.4E+12	-14.8	-14.0	642,300
73*	1300	3340	2.8	8.2E+12	-14.2	-13.6	1,738,500
74*	1300	3410	3.4	4.5E+12	-14.5	-12.5	350,600
75	1300	3780	3.3	7.3E+12	-14.1	-13.9	227,500
76	1300	3850	3.4	2.7E+12	-13.8	-14.6	468,300
77	1300	3820	3.1	6.6E+12	-14.3	-13.6	1,045,600
78	1300	3840	3.2	3.1E+13	-14.6	-13.7	1,736,500
79	1300	3770	3.4	1.1E+13	-14.7	-14.4	1,056,200
80	1300	3640	3.5	4.0E+13	-13.9	-14.9	943,600
81*	1300	3660	3.5	4.4E+12	-14.8	-13.2	163,600
82	1300	3590	3.4	8.4E+13	-14.5	-14.9	598,700
83*	1300	3660	4.8	8.5E+12	-12.8	-18.6	1,700
84	1300	3850	3.5	5.6E+12	-14.5	-14.6	365,200
85	1300	3740	3.5	1.2E+12	-14.5	-15	573,800

Table 2-4

Sample Number	Sintering Temperature (°C)	Permittivity	Tan δ (%)	Resistivity (Ω cm) at Room Temperature	Capacitance Variation $\Delta C/C_{25}(\%)$		Accelerated Life (sec)
					-55°C	125°C	
86	1300	3850	3.4	9.5E+12	-14.5	-14.6	356,200
87	1300	3760	3.5	8.6E+12	-14.6	-15	104,300
88*	1300	Incapable of obtaining a sintered ceramic with high density					
89*	1300	Incapable of obtaining a sintered ceramic with high density					
90	1300	3880	3.4	4.8E+12	-14.6	-13.7	437,200
91	1300	3690	3.1	7.6E+12	-13.8	-14.8	747,800
92	1300	3650	3.4	3.6E+12	-14.3	-14.2	457,600
93	1300	3710	3.4	3.7E+12	-14.2	-14.2	235,600
94	1300	3770	3.3	9.5E+11	-14.2	-14.5	460,400
95	1300	3690	3.2	8.4E+12	-13.5	-14.8	467,500
96	1300	3730	3.3	2.6E+12	-14.5	-14.2	845,600
97	1300	3810	3.2	4.4E+12	-14.2	-14.8	873,500
98	1300	3830	3.5	7.3E+12	-13.8	-14.3	630,100
99	1300	3690	3.2	3.3E+12	-14.1	-14.3	264,600
100	1300	3780	3.3	8.6E+11	-14.8	-14.9	358,300
101	1300	3850	3.4	5.1E+12	-14.5	-14.2	356,900
102	1300	3920	3.2	3.0E+12	-13.9	-14.4	704,800
103	1300	3660	3.4	7.7E+12	-14.6	-13.8	569,400
104	1300	3830	3.2	8.3E+12	-14.7	-13.6	479,600
105*	1300	4890	28.8	8.1E+10	-36.2	1.7	26,300
106	1300	3650	3.4	5.9E+12	-14.4	-13.6	264,800
107	1300	3520	2.9	2.9E+12	-14.3	-14.2	326,900
108*	1300	3440	2.5	6.2E+12	-13.8	-14.8	105,600
109*	1300	Incapable of obtaining a sintered ceramic with high density					
110	1300	3850	3.4	4.2E+12	-14.2	-13.7	365,200
111	1300	3740	3.5	8.9E+12	-14.7	-13.9	303,500
112	1300	3640	3.4	7.6E+12	-14.3	-14.2	402,800
113*	1300	3310	3.2	6.9E+12	-14.8	-14.4	62,300

Table 2-5

Sample Number	Sintering Temperature (°C)	Permittivity	Tan δ (%)	Resistivity (Ω cm) at Room Temperature	Capacitance Variation $\Delta C/C_{25}(\%)$		Accelerated Life (sec)
					-55°C	125°C	
114*	1300	3690	3.4	5.4E+12	-13.5	-14.8	44,300
115*	1300	3970	3.4	7.8E+12	-14.7	-14.4	179,200
116*	1300	3940	3.6	8.4E+12	-14.7	-14.9	1,430
117	1300	3810	3.2	7.3E+12	-14.3	-15	312,900
118	1300	3540	3.1	7.8E+12	-13.6	-14.9	726,700
119	1300	3590	3.4	2.2E+11	-13.6	-14.5	503,800
120	1300	3740	3.5	7.1E+11	-12.3	-14.4	907,500
121	1300	3620	3.2	4.9E+12	-13.7	-13.6	930,200
122	1300	3720	3.4	8.2E+12	-14.7	-14.5	754,900
123	1300	3530	3.4	5.5E+12	-14.6	-15	880,300
124	1300	3640	3.4	4.1E+12	-14.3	-14.4	699,800
125	1300	3880	3.3	3.4E+12	7.2	-14.6	856,700
126	1300	3510	3.1	7.3E+12	-13.2	-14.7	324,800
127	1300	3680	3.1	1.3E+11	-14.6	-14.3	994,000
128	1300	3550	3.4	7.5E+12	-14.7	-14	887,500
129*	1300	3420	3.1	2.5E+12	-13.5	-13.4	987,500
130*	1300	3210	3.1	5.8E+12	-12.6	-13.7	1,296,700
131*	1300	3390	3.5	4.3E+12	-13.3	-14.8	230,900
132	1300	3790	3.4	6.4E+12	-14.5	-14.7	239,400
133	1300	3570	3.5	3.7E+13	-13.7	-14.2	645,500
134	1300	3780	3.4	4.9E+12	-14.8	-14.7	1,396,700
135	1300	3610	3.5	8.9E+12	-14.6	-14.8	3,005,800
136	1300	3640	3.3	4.5E+13	-13.8	-14.6	1,674,700
137*	1300	3520	3.9	5.8E+11	-14.7	-4.3	21,000
138	1300	3790	3.5	7.7E+13	-14.6	-14.8	663,800
139*	1300	6030	8.9	7.6E+12	-14.1	-29.3	1,290
140	1300	3580	3.5	7.4E+12	-14.6	-14.5	703,700
141	1300	3920	3.5	4.5E+12	-14.6	-14.8	553,200
142	1300	3630	3.4	7.3E+12	-14.6	-14.7	1,329,700

Table 2-6

Sample Number	Sintering Temperature (°C)	Permittivity	Tan δ (%)	Resistivity (Ω cm) at Room Temperature	Capacitance Variation $\Delta C/C_{25}$ (%)		Accelerated Life (sec)
					-55°C	125°C	
143	1320	3740	3.5	7.8E+12	-14.9	-14.7	664,800
144*	1320	Incapable of obtaining a sintered ceramic with high density					
145*	1320	Incapable of obtaining a sintered ceramic with high density					
146	1320	3840	3.5	4.3E+12	-14.6	-14.9	507,400
147	1320	3710	3.4	5.3E+12	-14.8	-14.7	408,300
148	1320	4010	3.5	3.5E+12	-14.5	-14.6	498,300
149	1320	3740	3.5	2.8E+12	-13.9	-13.3	520,800
150	1320	3690	3.4	7.5E+12	-14.9	-13.1	372,500
151	1320	3930	3.5	4.2E+12	-14.7	-14.8	479,800
152	1320	3900	3.5	3.2E+12	-14.5	-14.7	378,200
153	1320	3660	3.5	5.3E+12	-14.6	-14.9	378,200
154	1320	3720	3.2	4.3E+12	-14.7	-14.4	593,700
155	1320	3800	3.1	5.8E+12	-14.6	-14.8	339,700
156	1320	3920	3.5	6.6E+11	-14.4	-14.6	945,700
157	1320	3920	3.4	4.5E+12	-14.2	-14.8	519,800
158	1320	3890	3.4	3.6E+11	-14.6	-14.9	504,900
159	1320	3590	3.3	9.8E+12	-13.9	-14.7	554,300
160	1320	3640	3.4	4.3E+12	-14.4	-14.5	387,400
161*	1320	8030	11.4	7.2E+11	-40.5	0.4	1,200
162	1320	3770	3.5	4.0E+12	-14.6	-14.5	337,200
163	1320	3730	2.7	3.5E+12	-13.7	-14.3	293,600
164*	1320	2490	3.6	6.6E+12	-13.8	-16.5	1,600
165*	1320	Incapable of obtaining a sintered ceramic with high density					
166	1320	3740	3.4	7.5E+13	-14.7	-15	447,300
167	1320	3740	3.4	5.6E+13	-14.7	-14.6	406,500
168	1320	3650	3.5	3.8E+13	-14.4	-14.6	350,700
169*	1320	3120	3.2	6.9E+13	-14.5	-14.2	79,500

As clearly seen from Tables 1-1 to 1-6 and Tables 2-1 to 2-6, multilayer ceramic capacitors with highly improved reliability having relative permittivity ϵ_s equal to or greater than 3500, capacitance variation $\Delta C/C_{25}$ within the
5 range from -15% to +15% at temperatures ranging from -55 to +125, $\tan \delta$ of 3.5% or less and accelerated life of 200,000 seconds or greater could be obtained from samples sintered in a non-oxidative atmosphere even at a temperature of 1300 or lower in accordance with the present invention.

10 However, samples 1 to 3, 16 to 18, 24, 26, 31, 32, 48, 51, 52, 56 to 59, 72 to 74, 81, 83, 88, 89, 105, 108, 109, 113 to 116, 129 to 131, 137, 139, 144, 145, 161, 164, 165 and 169 (marked with " " at the column of sample number in Tables) could not satisfy the above-specified electrical
15 characteristics. Therefore, it appears that such samples fall outside a preferable compositional range of the present invention.

The reasons why the preferable compositional range for dielectric ceramics for use in forming dielectric layers of
20 the multilayer ceramic capacitor in accordance with the present invention should be limited to certain values will now be described. In Tables 1-1 to 1-6, the amount of oxides of Ba and Ti was 100 mole parts in terms of BaTiO_3 (i.e., assuming Ba and Ti are in the form of BaTiO_3).

25 First, when the content of an oxide of a rare-earth element represented by Re (Re is selected, e.g., from the group consisting of Sm, Eu, Gd, Tb, Dy, Ho, Er, Tm, Yb and Y) is 0 mole parts in terms of Re_2O_3 (i.e., assuming the oxide of Re is in the form of Re_2O_3 as in the samples 26, 83

and 139, the capacitance variation $\Delta C/C_{25}$ of a produced multilayer ceramic capacitor goes beyond the range from -15% to +15% when temperature varies from -55 to +125 and a desired accelerated life may not be attained; whereas when
5 the oxide of Re is set to be 0.25 mole parts in terms of Re_2O_3 as in samples 27, 84 and 140, the desired electrical characteristics can be successfully obtained.

Further, when the content of the oxide of the rare-earth element Re is equal to or greater than 2.0 mole parts
10 in terms of Re_2O_3 as in the samples 31, 32, 88, 89, 144 and 145, highly densified ceramic bodies with a highly enhanced density may not be obtained by the sintering at 1300 ; whereas when the oxide of the rare-earth element Re is set to be 1.5 mole parts in terms of Re_2O_3 as in the samples 30,
15 87 and 143, the desired electrical characteristics can be successfully obtained.

Accordingly, the preferable range of the total content of the oxide of rare-earth element Re is from 0.25 to 1.5 mole parts in terms of Re_2O_3 .

20 It is noted that same effects can be produced regardless of whether a single rare-earth element is used or two or more of rare-earth elements are used together as long as the above-described preferable content range of the rare-earth element Re is satisfied.

25 When the content of an oxide of Mg is 0 mole parts in terms of MgO , as in the samples 48, 105 and 161, the capacitance variation $\Delta C/C_{25}$ of the produced multilayer ceramic capacitors may exceed the range from -15% to +15% when the temperature varies from -55 to +125 and the
30 desired accelerated life may not be obtained; whereas when

the content of the oxide of Mg is set to be 0.2 mole parts in terms of MgO as in samples 49, 106 and 162, the desired electrical characteristics can be successfully obtained.

5 In addition, when the content of the oxide of Mg is 2.0 mole parts in terms of MgO as in the samples 51, 108 and 164, the relative permittivity of the produced multilayer ceramic capacitors may become equal to or less than 3500 and the desired accelerated life can not be obtained. Further, the capacitance variation $\Delta C/C_{25}$ sometimes may go beyond the
10 range of -15% to +15% when the temperature varies from -55 to 125 . However, when the content of the oxide of Mg is set to be 1.5 mole parts in terms of MgO as in samples 50, 107 and 163, the desired electrical characteristics can be successfully obtained.

15 Accordingly, the content of the oxide of Mg optimally ranges from 0.2 to 1.5 mole parts in terms of MgO.

When the content of an oxide of Mn, V or Cr is 0.02 mole parts in terms of Mn_2O_3 , V_2O_5 or Cr_2O_3 as in the samples 1 to 3, 57 to 59 and 114 to 116, the desired accelerated
20 life of the produced multilayer ceramic capacitors may not be obtained; whereas when the content of sum of the oxides of Mn, V and Cr is set to be 0.03 mole parts in terms of Mn_2O_3 , V_2O_5 and Cr_2O_3 as in the samples 4 to 7, 60 to 63 and 117 to 120, the desired electrical characteristics can be
25 successfully obtained.

Further, when the content of an oxide of the Mn, V, or Cr is 0.7 mole parts in terms of Mn_2O_3 , V_2O_5 or Cr_2O_3 as in the samples 16 to 18, 72 to 74 and 129 to 131, the relative permittivity of the produced capacitors becomes equal to or
30 less than 3500. However, when the total content of oxides

of Mn, V and Cr is set to be 0.6 moles in terms of Mn_2O_3 , V_2O_5 and Cr_2O_3 as in samples 12 to 15, 68 to 71 and 125 to 128, the desired electrical characteristics can be successfully obtained.

5 Accordingly, it is preferable that the total amount of the oxides of Mn, V and Cr ranges from 0.03 to 0.6 mole parts in terms of Mn_2O_3 , V_2O_5 and Cr_2O_3 .

 Further, it is to be noted that same effects can be obtained regardless of whether an oxide of one of the
10 elements Mn, V and Cr is used or two or more thereof are used together as long as the total content thereof satisfies the above specified range, as in the samples 4 to 15, 60 to 71 and 117 to 128.

 When the total content of the oxides of Mo and W is
15 0.4 mole parts in terms of MoO_3 and WO_3 as in the samples 24, 81 and 137, $\tan\delta$ of the produced capacitors becomes equal to or greater than 3.5 and the desired accelerated life thereof cannot be obtained. However, if the total content of oxides of Mo and W is set to be 0.3 mole parts in
20 terms of MoO_3 and WO_3 , respectively, as in samples 23, 80 and 136, the desired electrical characteristics can be successfully obtained.

 Accordingly, it is preferable that the total content the oxides of Mo and W is between 0 and 0.3 mole parts in
25 terms of MoO_3 and WO_3 .

 Furthermore, same effects can be obtained regardless of whether the oxides of Mo and W are used separately as in the samples 20 to 23 and 76 to 80 or used together as in samples 133 to 136 as long as the total content thereof is
30 maintained at or below 0.3 mole parts.

It is more preferable that the total content of the oxides of Mo and W ranges from 0.025 to 0.3 mole parts in terms of MoO_3 and WO_3 since the addition of Mo and/or W in that range gives rise to a further increased operation and reliability of a ceramic capacitor.

When the ratio of Ba/Ti is 0.960, as in the samples 52, 109 and 165, the sintering at 1300 can not produce highly densified ceramic bodies; whereas when the ratio of Ba/Ti is set to be 0.970 as in the samples 53, 110 and 166, the desired electrical characteristics can be successfully obtained.

Moreover, if the ratio of Ba/Ti is 1.040, as in the samples 56, 113 and 169, the desired accelerated life may

not be obtained though $\tan \delta$ of the produced capacitors becomes equal to or less than 3.5. However, when the ratio of Ba to Ti is set to be 1.030 as in samples 55, 112 and 168, the desired electrical characteristics can be successfully
5 obtained.

Accordingly, the optimum ratio of Ba/Ti ranges from 0.970 and 1.030.

Further, Ca or Sr can be used instead of Ba for adjusting Ba/Ti ratio. That is, as long as the ratio of the
10 sum of Ba, Ca and Sr to Ti. i.e., (Ba+Ca)/Ti ratio, (Ba+Sr)/Ti ratio or (Ba+Ca+Sr)/Ti satisfies the optimum range from 0.970 to 1.030, the desired characteristics can be obtained.

Still further, barium carbonate, barium acetate,
15 barium nitrate, calcium acetate, strontium nitrate or the like can be used in controlling the ratio.

The present invention can produce a multilayer ceramic capacitor capable of providing a desired operating life with a highly improved reliability, wherein the capacitor
20 exhibits a relative permittivity ϵ_s of 3500 or greater, $\tan \delta$ of 3.5% or less and a capacitance variation $\Delta C/C_{25}$ ranging from -15% and +15% within the temperature range from -55°C to + 125°C.

Although the present invention has been described with
25 reference to the multilayer ceramic capacitors in this specification, it will be apparent to those skilled in the

art that the present invention is also applicable to single layer ceramic capacitors.

While the invention has been shown and described with respect to the preferred embodiments, it will be understood
5 by those skilled in the art that various changes and modifications may be made without departing from the spirit and scope of the invention as defined in the following claims.

What is claimed is:

1. A dielectric ceramic composition comprising:
100 mole parts of an oxide of Ba and Ti, a ratio Ba/Ti
5 being 0.970 to 1.030;
0.25 to 1.5 mole parts of an oxide of Re, Re
representing one or more elements selected from the group
consisting of Sm, Eu, Gd, Tb, Dy, Ho, Er, Tm, Yb and Y;
0.2 to 1.5 mole parts of an oxide of Mg; and
10 0.03 to 0.6 mole parts of an oxide of Mn and oxides of
one or more elements selected from the group consisting of V
and Cr.
2. The dielectric ceramic composition of claim 1, wherein
15 the content of the oxide of Ba and Ti is calculated by
assuming that the oxide of Ba and Ti is BaTiO_3 ; the content
of the oxide of Re is calculated by assuming that the oxide
of Re is Re_2O_3 ; the content of the oxide of Mg is calculated
by assuming that the oxide of Mg is MgO ; and the content of
20 oxides of Mn, V and Cr is calculated by assuming that the
oxides of Mn, V and Cr are Mn_2O_3 , V_2O_5 and Cr_2O_3 ,
respectively.
3. The dielectric ceramic composition of claim 1, further
25 comprising not greater than 0.3 mole parts and greater than
0 mole parts oxides of one or two elements selected from the
group consisting of Mo and W, the content being calculated
by assuming that oxides of Mo and W are MoO_3 and WO_3 ,
respectively.

30

4. The dielectric ceramic composition of claim 3, wherein the content of oxides of one or two elements of Mo and W is not less than 0.025 mole parts.

5 5. The dielectric ceramic composition of claim 2, further comprising not greater than 0.3 mole parts and greater than 0 mole parts oxides of one or two elements selected from the group consisting of Mo and W, the content being calculated by assuming that oxides of Mo and W are MoO_3 and WO_3 ,
10 respectively.

6. The dielectric ceramic composition of claim 5, wherein the content of oxides of one or two elements of Mo and W is not less than 0.025 mole parts.

15

7. A ceramic capacitor comprising one or more dielectric layers made of the dielectric ceramic composition of claim 1.

20 8. The ceramic capacitor of claim 7, wherein the content of the oxide of Ba and Ti is calculated by assuming that the oxide of Ba and Ti is BaTiO_3 ; the content of the oxide of Re is calculated by assuming that the oxide of Re is Re_2O_3 ; the content of the oxide of Mg is calculated by assuming that
25 the oxide of Mg is MgO ; and the content of oxides of Mn, V and Cr is calculated by assuming that the oxides of Mn, V and Cr are Mn_2O_3 , V_2O_5 and Cr_2O_3 , respectively.

9. The ceramic capacitor of claim 7, wherein the
30 dielectric ceramic composition further comprises not greater

than 0.3 mole parts and greater than 0 mole parts oxides of one or two elements selected from the group consisting of Mo and W, the content being calculated by assuming that oxides of Mo and W are MoO_3 and WO_3 , respectively.

5

10. The ceramic capacitor of claim 9, wherein the content of oxides of one or two elements of Mo and W is not less than 0.025 mole parts.

10 11. The ceramic capacitor of claim 8, wherein the dielectric ceramic composition further comprises not greater than 0.3 mole parts and greater than 0 mole parts oxides of one or two elements selected from the group consisting of Mo and W, the content being calculated by assuming that oxides
15 of Mo and W are MoO_3 and WO_3 , respectively.

12. The ceramic capacitor of claim 11, wherein the content of oxides of one or two elements of Mo and W is not less than 0.025 mole parts.

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