

July 5, 1987

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DIELECTRIC CERAMIC COMPOSITION AND MONOLITHIC CERAMIC
CAPACITOR USING SAME

FIELD OF THE INVENTION

The present invention relates to a dielectric ceramic composition and a monolithic ceramic capacitor to be used in electronic instruments, especially those having inner electrodes made of nickel or nickel alloys.

BACKGROUND OF THE INVENTION

Monolithic ceramic capacitors are generally produced as follows.

First, sheets of dielectric ceramic layers each as coated with an electrode material to be an inner electrode thereon are prepared. For example, the dielectric ceramic layers may consist essentially of BaTiO_3 . Next, a plurality of such sheets of dielectric ceramic layers each coated with the electrode material are laminated and integrated under heat and pressure, and the resulting laminate is baked in a natural atmosphere at from 1250°C to 1350°C to obtain a monolithic dielectric ceramic body having inner electrodes therein. To the both ends of the dielectric ceramic body, are fixed and baked outer electrodes that electrically communicate with the inner electrode. Thus is obtained a monolithic ceramic capacitor.

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Accordingly, the materials for such inner electrodes must satisfy the following requirements.

1. Since the ceramic laminate and the inner electrodes are baked together, the melting point of the materials for the inner electrodes must be not lower than the temperature at which the ceramic laminate can be baked.

2. The materials for the inner electrodes must not be oxidized even in high-temperature, oxidizing atmospheres and must not react with the dielectric ceramic layers.

As electrodes that satisfy these requirements, noble metals, such as platinum, gold, palladium and silver-palladium alloys, have heretofore been used.

However, these electrode materials are expensive, though having excellent characteristics. Accordingly, the cost of the electrode material reaches from 30 to 70 % of the total cost of one monolithic ceramic capacitor, which therefore is the essential factor of increasing the production costs of conventional monolithic ceramic capacitors.

Except for noble metals, known are base metals, such as Ni, Fe, Co, W and Mo, which have a high melting point. However, such base metals are easily oxidized in high-temperature, oxidizing atmospheres to lose their functions as electrodes. Therefore, if such base metals are used as the inner electrodes in monolithic ceramic capacitors, they



must be baked in neutral or reducing atmospheres along with dielectric ceramic layers. However, conventional dielectric ceramic materials were defective in that, if they are baked in such neutral or reducing atmospheres, they are greatly reduced into semiconductors.

In order to overcome these drawbacks, for example, proposed were a dielectric ceramic material comprising a solid solution of barium titanate where the ratio of barium sites/titanium sites is over the stoichiometric ratio thereof, such as that disclosed in Japanese Patent Publication No. 57-42588; and a dielectric ceramic material comprising a solid solution of barium titanate and containing oxides of rare earth metals, such as La, Nd, Sm, Dy and Y, added thereto, such as that disclosed in Japanese Patent Application Laid-Open No. 61-101459.

Also proposed were a dielectric ceramic material having a composition of $\text{BaTiO}_3\text{-CaZrO}_3\text{-MnO-MgO}$, such as that disclosed in Japanese Patent Application Laid-Open No. 62-256422; and a dielectric ceramic material having a composition of $\text{BaTiO}_3\text{-(Mg,Zn,Sr,Ca)O-B}_2\text{O}_3\text{-SiO}_2$, such as that disclosed in Japanese Patent Publication No. 61-14611.

Using these dielectric ceramic materials, ceramic laminates were obtained, which are not converted into semiconductors even when baked in reducing atmospheres. As a result, it has become possible to produce monolithic

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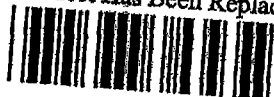
ceramic capacitors comprising inner electrodes of base metals such as nickel.

With the recent development in electronics, small-sized electronic parts have become required greatly in the art, and small-sized, large-capacity, monolithic ceramic capacitors are therefore required greatly therein.

For these reasons, the recent tendency in the art is rapidly toward dielectric ceramic materials having a higher dielectric constant and toward thinner dielectric layers. Accordingly, there is now a great demand for dielectric ceramic materials with high reliability having a high dielectric constant, in which the temperature-dependent variation is little.

However, the dielectric ceramic materials disclosed in Japanese Patent Publication No. 57-42588 and Japanese Patent Application Laid-Open No. 61-101459 were defective in that the crystals constituting the ceramic laminates made from the materials are large, though the ceramic laminates themselves may have a high dielectric constant, with the result that, if thin dielectric ceramic layers having a thickness of, for example, 10 μm or less are incorporated into monolithic ceramic capacitors, the number of ceramic crystals to be in one layer is reduced and therefore the reliability of the monolithic ceramic capacitors is lowered. In addition, the dielectric ceramic

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materials were further defective in that the temperature-dependent variation in the dielectric constant of the dielectric ceramics is great. For these reasons, the conventional dielectric ceramic materials could not meet the requirements in the market.

On the other hand, the dielectric ceramic material disclosed in Japanese Patent Application Laid-Open No. 62-256422 was defective in that CaZrO_3 and also CaTiO_3 that is formed during the baking step may often form secondary phases together with Mn and others and therefore the high-temperature reliability of the capacitor comprising the material is problematic, although the dielectric constant of the ceramic body of the material is relatively high, the crystals constituting the ceramic laminate are small, and the temperature-dependent variation in the dielectric constant is small.

The dielectric ceramic material disclosed in Japanese Patent Publication No. 61-14611 was defective in that the dielectric constant of the ceramic body of the material is from 2000 to 2800 and therefore the material is not suitable for small-sized, large-capacity monolithic ceramic capacitors. In addition, the material was further defective in that it does not satisfy the capacitance characteristic standard as stipulated in the EIA Standard, which indicates that the temperature-dependent variation in

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the capacitance within the range between -55°C and $+125^{\circ}\text{C}$ shall be $\pm 15\%$ or less.

Japanese Patent Application Laid-Open No. 63-103861 discloses a non-reducing dielectric ceramic material, which, however, was defective in that its insulating resistance and the temperature-dependent variation in its capacity are greatly influenced by the grain size of the crystals of BaTiO_3 which is the essential component constituting the material and therefore the material is difficult to control so as to obtain stable characteristics. In addition, for the insulating resistance of the material, the product of the insulating resistance value and the capacitance value (product of CR) falls between 1000 and 2000 ($\Omega\cdot\text{F}$). In view of this, the material could not be practicable.

Although some improvements were made in the non-reducing dielectric ceramic compositions that have heretofore been proposed in the art, such as those mentioned hereinabove, to make them have good insulation resistance in high-temperature load life tests, the improvement in their insulation resistance in moisture-resistant load tests was still unsatisfactory as yet.

In order to solve the above-mentioned problems, proposed were different compositions, for example, in Japanese Patent Application Laid-Open Nos. 05-9066, 05-9067 and 05-9068. However, these compositions could not still

satisfy the recent severe requirements for small-sized, large-capacity capacitors in the market. Specifically, the recent requirements for these in the market are to make them have much thinner dielectric ceramic layers and even have high reliability. Therefore, there is still a great demand for dielectric ceramic materials capable of producing much thinner dielectric ceramic layers in monolithic ceramic capacitors with much higher reliability. Given the situation, accordingly, it has become necessary to provide small-sized, large-capacity, high-reliability monolithic ceramic capacitors still having highly-reliable characteristics even in high-temperature and high-humidity conditions.

SUMMARY OF THE INVENTION

Accordingly, the subject matter of the present invention is to provide a low-priced, small-sized, large-capacity, monolithic ceramic capacitor, which has a dielectric constant of 3000 or more, which has a high insulation resistance, when measured at room temperature and 125°C, of 6000 MΩ·μF or more, in terms of its product with the capacitance (the product of CR), which has temperature-dependent capacitance that satisfies the B-level characteristic standard as stipulated in the JIS Standard and the X7R-level characteristic standard as

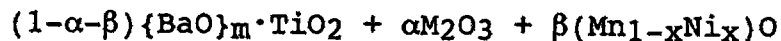


stipulated in the EIA Standard, and which has good weather resistance even in high-temperature and high-humidity load conditions.

The present invention has been made in consideration of the above-mentioned object.

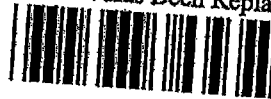
Specifically, the present invention provides a monolithic ceramic capacitor composed of; a plurality of dielectric ceramic layers, a plurality of inner electrodes as formed between the dielectric ceramic layers in such a manner that one end of each inner electrode is exposed out of either end of the dielectric ceramic layers, and outer electrodes as electrically connected with the exposed inner electrodes, which is characterized in that;

the dielectric ceramic layers each are made of a material comprising; barium titanate having a content of impurities, alkali metal oxides of 0.02 % by weight or less, and scandium oxide, yttrium oxide, manganese oxide and nickel oxide; and containing side components, magnesium oxide in an amount of from 0.5 to 3.0 mols in terms of MgO, and silicon oxide in an amount of from 0.2 to 5.0 mols in terms of SiO₂, relative to 100 mols of the essential component having the following compositional formula:



where M₂O₃ is at least one selected from Sc₂O₃ and Y₂O₃; and

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α , β , m and x are as follows:

$$0.0025 \leq \alpha \leq 0.020$$

$$0.0025 \leq \beta \leq 0.04$$

$$\beta/\alpha \leq 4$$

$$0 \leq x < 1.0$$

$$1.000 < m \leq 1.035; \text{ and}$$

the inner electrodes each are made of nickel or a nickel alloy.

Preferably, in the monolithic ceramic capacitor of the present invention, the outer electrodes each are made of a sintered layer of an electroconductive metal powder with glass frit added thereto. Further preferably, the outer electrodes each are composed of a first, sintered layer of an electroconductive metal powder with glass frit added thereto, and a second, plated layer formed on the first layer.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a cross-sectional view illustrating the outline of one embodiment of the monolithic ceramic capacitor of the present invention.

Fig. 2 is a plan view illustrating the outline of one embodiment of a dielectric ceramic layer having an inner electrode thereon, which is prepared in the present invention.

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Fig. 3 is a perspective, exploded view illustrating one embodiment of a ceramic laminate as prepared in the present invention.

PREFERRED MODES OF CARRYING OUT THE INVENTION

Now, preferred modes of carrying out the invention are described in detail hereinunder.

As the material for the dielectric ceramic layers constituting the monolithic ceramic capacitor of the present invention, herein used is a dielectric ceramic material comprising at least one oxide selected from scandium oxide and yttrium oxide, and also manganese oxide and nickel oxide, in a specifically conditioned compositional ratio such as that mentioned hereinabove, and containing magnesium oxide and silicon oxide within the range as defined hereinabove. Therefore, even in a reducing atmosphere, the dielectric ceramic material can be baked well without worsening its characteristics. As a result, according to the present invention, it is possible to obtain a high-reliability, monolithic ceramic capacitor having a temperature-dependent capacitance that satisfies the B-level characteristic standard as stipulated in the JIS Standard and also the X7R-level characteristic standard as stipulated in the EIA Standard, and having high insulation resistance at room temperature and even at high

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temperatures.

-- In addition, since the crystal grains existing in the sintered dielectric ceramics constituting the capacitor of the invention are small, or that is, not larger than 1 μm , the number of the crystal grains to be in one dielectric ceramic layer may be increased. Accordingly, even if the dielectric layers are thinned, the reliability of the capacitor comprising such thin dielectric layers is not lowered.

It has been confirmed that, of the essential components constituting the dielectric ceramic material for use in the present invention, such as barium titanate, at least one oxide selected from scandium oxide and yttrium oxide, and also manganese oxide and nickel oxide, the content of the impurities in the barium titanate, such as alkaline earth metal oxides, e.g., SrO and CaO ; alkali metal oxides, e.g., Na_2O and K_2O ; and other oxides, e.g., Al_2O_3 and SiO_2 , especially that of alkali metal oxides such as Na_2O and K_2O , has a great influence on the electric characteristics of the capacitor of the invention. Specifically, it has been confirmed that, if barium titanate having an alkali metal oxide impurity content of smaller than 0.02 % by weight is in the dielectric ceramic material, the capacitor of the invention comprising the dielectric ceramic may have a dielectric constant of 3000

or higher.

The reason why silicon oxide is added to the dielectric ceramic layers in the present invention is that said addition improves the sinterability of the layers if the sintering atmosphere is controlled to have an oxygen partial pressure near to the equilibrated oxygen partial pressure of Ni/NiO at relatively high temperatures during the sintering step, while also improving the moisture-resistant load characteristics of the capacitors comprising the layers.

If the dielectric ceramic material mentioned hereinabove is used to form the dielectric ceramic layers constituting the monolithic ceramic capacitor of the invention, it is possible to use base metals, nickel or nickel alloys to form the inner electrodes of the capacitor. In addition, it is also possible to add to the inner electrodes a ceramic additive comprising the same compositional material as that for the ceramic layers and containing a small amount of other oxides.

The composition of the outer electrodes of the capacitor of the invention is not specifically defined. Concretely, for example, the outer electrodes may be made of sintered layers comprising various electroconductive powders, such as Ag, Pd, Ag-Pd, Cu or Cu alloys, and various types of glass frit of $\text{B}_2\text{O}_3\text{-Li}_2\text{O-SiO}_2\text{-BaO}$, $\text{B}_2\text{O}_3\text{-}$

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$\text{SiO}_2\text{-BaO}$, $\text{Li}_2\text{O-SiO}_2\text{-BaO}$ or the like. More preferably, the sintered layers are coated with a plate layer. The plate layer may comprise Ni, Cu or the like, and may be further coated with any additional plate layer of solder, tin or the like.

Now, the present invention is described in more detail with reference to the following Examples, which, however, are not intended to restrict the scope of the invention.

One embodiment of the monolithic ceramic capacitor of the present invention is referred to. Fig. 1 is a cross-sectional view illustrating the outline of one embodiment of the monolithic ceramic capacitor of the invention. Fig. 2 is a plan view illustrating the outline of the dielectric ceramic layer having an inner electrode thereon, which is in this embodiment. Fig. 3 is a perspective, exploded view illustrating the ceramic laminate to be in this embodiment.

As in Fig. 1, the monolithic ceramic capacitor 1 of the present invention is in the form of a rectangular parallelepiped chip, in which the outer electrodes 5, the first plate layers 6 made of nickel, copper or the like, and the second plate layers 7 made of solder, tin or the like are formed on the both sides of the ceramic laminate 3 as formed through lamination of a plurality of dielectric ceramic layers 2a and 2b via the inner electrode 4 therebetween.



Now, a method for producing the monolithic ceramic capacitor 1 of the invention is described below in the order of the steps constituting the method.

First, the ceramic laminate 3 is formed. This ceramic laminate 3 is produced as follows. As in Fig. 2, a raw material powder comprising barium titanate; at least one oxide selected from scandium oxide and yttrium oxide; manganese oxide, nickel oxide, magnesium oxide; and oxides consisting essentially of silicon oxide is formed into a slurry, and then sheeted to prepare a dielectric ceramic layer 2a (green sheet). On one surface of the green sheet, formed is an internal electrode 4 of nickel or a nickel alloy. To form the internal electrode 4, employable is any method of screen printing, metal vapor deposition or plating.

A predetermined number of the dielectric ceramic layers 2b each with the inner electrode 4 formed thereon are laminated, and then sandwiched between two dielectric ceramic layers 2a not having the inner electrode 4, as in Fig. 3, and these are integrated under pressure to give a laminate. Next, the resulting laminate composed of the dielectric ceramic layers 2a, 2b, . . . 2b, 2a is baked in a reducing atmosphere at a predetermined temperature to obtain the ceramic laminate 3.

Next, on the both sides of the ceramic laminate 3,

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formed are two outer electrodes 5 that are connected with the inner electrodes 4. The material of the outer electrodes 5 may be the same as that of the inner electrodes 4. Apart from this, silver, palladium, silver-palladium alloys, copper, copper alloys and others can be used as the material of the outer electrodes 5, to which can be added glass frit, such as glass of the type of $B_2O_3-SiO_2-BaO$ or Li_2O-SiO_2-BaO . In consideration of the use of the monolithic ceramic capacitor of the invention and the site at which the capacitor is used, suitable materials are selected for the outer electrodes 5. The outer electrodes 5 can be formed by applying an electroconductive paste material of metal powder onto the baked ceramic laminate 3 followed by baking it. Alternatively, the paste material can be applied onto the non-baked ceramic laminate 3, which is baked all at a time. After this, the outer electrodes 5 may be plated with nickel, copper or the like to form a first plate layer 6 thereon. Last, the first plate layer 6 is coated with a second plate layer 7 of solder, tin or the like. Thus is produced the chip-type, monolithic ceramic capacitor 1 of the invention.

The following Example is to further illustrate the invention in more detail.

EXAMPLE 1

First, raw materials of $TiCl_4$ and $Ba(NO_3)_2$ having

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various degrees of purity were prepared and weighed. These were treated with oxalic acid to obtain a precipitate of barium titanyl oxalate ($\text{BaTiO}(\text{C}_2\text{O}_4) \cdot 4\text{H}_2\text{O}$). This precipitate was decomposed under heat at 1000°C or higher to obtain four types of barium titanate (BaTiO_3) as shown in Table 1.

Next, prepared were Sc_2O_3 , Y_2O_3 , MnO , NiO and MgO each having a purity of 99 % or more, and a colloidal silica containing silicon dioxide in an amount of 20 % by weight in terms of SiO_2 .

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TABLE 1
Samples with * are outside the invention.

Type of BaTiO ₃	Content of Impurities (wt.%)					Mean Grain Size (μm)
	Alkali Metal Oxides	SrO	CaO	SiO ₂	Al ₂ O ₃	
A	0.003	0.012	0.001	0.010	0.005	0.60
B	0.020	0.010	0.003	0.019	0.008	0.56
C	0.012	0.179	0.018	0.155	0.071	0.72
D	0.062	0.014	0.001	0.019	0.004	0.58

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Next, these raw materials were mixed in various compositional ratios as shown in Table 2 to prepare various compositions. Each composition was wet-milled in a ball mill, evaporated to dryness and dressed to obtain a powdery raw material mixture.

The resulting mixture was wet-milled in a ball mill along with a polyvinyl butyral binder and an organic solvent such as ethanol to obtain a ceramic slurry. This ceramic slurry was sheeted according to doctor blading to obtain a rectangular green sheet having a thickness of 11 μm . Next, an electroconductive paste consisting essentially of Ni was printed on this ceramic green sheet to form thereon an electroconductive paste layer, which is formed into an inner electrode.

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TABLE 2

Samples with * are outside the invention.

Sample No.	Type of BaTiO ₃	(1- α - β) (BaO) _m ·TiO ₂ + α M ₂ O ₃ + β (Mn _{1-x} Ni _x)O										MgO (mol)	SiO ₂ (mol)		
		Y ₂ O ₃	Sc ₂ O ₃	α				Total	β		β/α			m	
* 1	A	-	-					0.0000	0.005	0.3		-	1.010	1.20	1.00
* 2	A	0.010						0.0100	0.000	-		0	1.010	1.20	1.00
* 3	A	0.010	0.002					0.0120	0.005	0.3		5/12	0.990	1.20	1.00
* 4	A	0.012						0.0120	0.005	0.3		5/12	1.000	1.00	1.00
* 5	A	0.0080						0.0080	0.0100	0.3		1	1.010	0.00	1.00
* 6	A	0.0100						0.0100	0.0100	0.3		1	1.015	1.20	0.00
* 7	A	0.0075						0.0075	0.0075	0.5		1	1.015	1.50	0.10
8	A	0.0025						0.0025	0.0025	0.1		1	1.005	0.50	0.20
9	A	0.0050	0.0050					0.0100	0.0080	0.5		4/5	1.010	1.00	1.00
10	A	0.0080	0.0040					0.0120	0.0080	0.0		2/3	1.010	1.50	1.50
11	A	0.0090						0.0090	0.0090	0.4		1	1.015	1.20	1.50
12	A	0.0080						0.0080	0.0080	0.3		1	1.010	1.20	1.00
13	C	0.0015	0.0050					0.0200	0.0400	0.8		2	1.005	1.00	2.00
14	B	0.0030						0.0030	0.0060	0.4		2	1.010	3.00	5.00
15	A	0.0080	0.0020					0.0100	0.0050	0.0		1/2	1.010	1.00	1.50
16	A	0.0060						0.0060	0.0240	0.6		4	1.035	0.50	2.50
17	A	0.010	0.010					0.0200	0.0050	0.1		1/4	1.015	2.00	1.50

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TABLE 2 - continued

Samples with * are outside the invention.

Sample No.	Type of BaTiO ₃	(1- α - β) (BaO) _m ·TiO ₂ + α MgO ₃ + β (Mn _{1-x} Ni _x)O										MgO (mol)	SiO ₂ (mol)			
		Y ₂ O ₃	Sc ₂ O ₃	α					Total	β				β/α	m	
* 18	A	0.0200	0.010						0.030	0.015	0.3		1/2	1.010	2.00	1.50
* 19	A	0.015							0.015	0.060	0.3		4.0	1.010	1.20	1.50
* 20	A	0.010							0.010	0.010	1.0		1.0	1.010	1.20	1.00
* 21	A	0.0040	0.0010						0.0050	0.040	0.3		8	1.010	1.20	1.00
* 22	A	0.0100							0.010	0.0050	0.3		1/2	1.050	1.20	2.00
* 23	A	0.0100							0.010	0.0050	0.3		1/2	1.010	5.0	2.00
* 24	A	0.0100							0.010	0.0050	0.3		1/2	1.010	1.20	8.00
* 25	D	0.0100							0.010	0.0050	0.3		1/2	1.010	1.20	1.50
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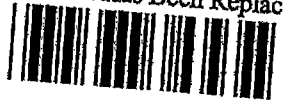


TABLE 3

Sample No.	Baking Temperature (°C)	Dielectric Constant, ϵ'	Dielectric Loss, $\tan \delta$ (%)	Temperature-Dependent Variation in Capacitance, $\Delta C/C_{25^\circ C}$ (%)				Product of CR (Ω·F), at 25°C	Mean Life Time (hr.)	Number of Test Pieces	Failed in Moisture-Resistant Load Test	Grain Size (μm)
				-25°C	85°C	-55°C	125°C	max				
1	1300	3090	2.3	-12.1	-4.5	-16.3	2.2	16.3	8200			0.77
2	1280											2.6
3	1280			As semiconductors were formed, the measurement was impossible.								
4	1280	3290	2.1	-3.1	-5.4	-3.4	-5.3	5.5	2250			2.1
5	1280	3380	2.0	0.5	-10.7	1.5	-17.0	17.0	4700			0.73
6	1360			As the sample was sintered insufficiently, the measurement was impossible.								
7	1330	3220	1.9	-2.7	-5.1	-3.0	-4.9	5.2	4200			0.61
8	1300	4050	2.4	-8.1	-6.5	-12.3	-12.7	12.7	7140			0.68
9	1280	3290	1.8	-2.5	-5.2	-2.5	-5.6	5.6	6380			0.72
10	1300	3100	1.7	-2.7	-4.9	-2.9	-5.1	5.1	6170			0.68
11	1280	3510	2.1	-1.7	-6.2	-2.0	-9.3	9.8	6820			0.69
12	1280	3590	2.2	-1.2	-7.7	-1.1	-9.9	10.2	6760			0.71
13	1300	3020	1.7	-2.0	-5.1	-2.0	-5.2	5.2	6010			0.72
14	1260	3470	2.0	-4.0	-6.7	-5.3	10.7	10.7	7220			0.78
15	1280	3310	1.9	-2.0	-5.8	-2.2	-6.6	6.6	6190			0.64
16	1300	3370	1.9	-1.0	-8.8	-1.4	-11.6	11.8	6630			0.69
17	1300	3000	1.4	-1.9	-4.5	1.8	-4.2	4.5	6040			0.68
18	1360	2120	1.2	2.1	2.4	3.0	1.9	3.2	3690			0.68
19	1280	3080	1.8	0.1	-9.8	0.2	16.2	16.2	5420			0.65
20	1300	3550	2.2	-1.3	-6.6	-2.4	-7.3	7.3	2760			0.70
21	1300	3630	2.3	-1.5	-11.0	-2.2	-17.7	17.7	6650			0.71
22	1360			As the sample was sintered insufficiently, the measurement was impossible.								
23	1360	2350	1.5	-2.3	-3.3	-2.9	-2.2	3.4	6080			0.61
24	1200	1950	1.2	-1.3	-2.5	-2.0	3.3	3.3	3620			0.66
25	1280	2640	1.7	-2.1	-1.9	-3.3	-4.8	4.8	6250			0.69
									501			0.64

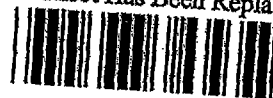
A plurality of these ceramic green sheets each having the electroconductive paste layer formed thereon were laminated in such a manner that the side of one sheet with the electroconductive paste exposed out of it was alternated with that of another sheet with the electroconductive paste not exposed out of it. Thus was obtained a laminate. This laminate was heated in an N₂ atmosphere at 350°C whereby the binder was burnt out, and then baked for 2 hours in a reducing atmosphere comprising gases of H₂, N₂ and H₂O and having an oxygen partial pressure of from 10⁻¹¹ to 10⁻⁸ MPa, at various temperatures shown in Table 3, to obtain sintered ceramic bodies.

The surface of each sintered ceramic body was observed with a scanning, electronic microscope at a magnification of 1500 times, to determine the grain sizes of the grains seen in the field of view.

A silver paste containing glass frit of the type of B₂O₃-Li₂O-SiO₂-BaO was applied onto the both sides of each sintered ceramic body, and baked again in an N₂ atmosphere at 600°C to thereby form outer electrodes as electrically connected with the inner electrodes.

The outer dimension of each of these monolithic capacitors thus obtained was 1.6 mm width x 3.2 mm length x 1.2 mm thickness, and the thickness of each dielectric ceramic layer as sandwiched between the inner electrodes





was 8 μm .

The total number of the effective dielectric ceramic layers was 19, and the area of the facing electrodes per one ceramic layer was 2.1 mm².

The capacitance (C) and the dielectric loss ($\tan \delta$) of each sample were measured, using an automatic bridge-type meter at a frequency of 1 KHz, at 1 V rms and at 25°C. From the capacitance thus measured, obtained was the dielectric constant (ϵ) through calculation. Next, to measure the insulation resistance (R) of each sample, a direct current voltage of 16 V was applied to each sample at 25°C for 2 minutes, using an insulation resistance meter. After having thus measured the insulation resistance (R) of each sample, the product of the capacitance (C) and the insulation resistance (R) or, that is, the product of CR of each sample was obtained. In addition, the temperature-dependent variation in the capacitance of each sample was determined.

For the temperature-dependent variation in the capacitance, obtained were the variation in the capacitance between -25°C and 85°C based on the capacitance at 20°C ($\Delta C/C_{20^\circ\text{C}}$), the variation in the capacitance between -55°C and 125°C based on the capacitance at 25°C ($\Delta C/C_{25^\circ\text{C}}$), and the maximum variation, in terms of the absolute value, between -55°C and 125°C ($|\Delta C|_{\text{max}}$).

To determine the high-temperature load life of each sample, 36 pieces of each sample were subjected to a high-temperature load test, in which a direct current voltage of 100 V was applied to each piece at 150°C, while measuring the insulation resistance of each test piece which varied time-dependently. In this test, the period of time within which the insulation resistance value (R) of each piece being tested reached $10^6 \frac{1}{2}$ or lower was measured, which is referred to as the life time of each test piece. The average of all the tested pieces was calculated to obtain the average life time of each sample.

In addition, to measure the moisture-resistant load life of each sample, 72 pieces of each sample were subjected to a high-humidity load test, in which a direct current voltage of 16 V was applied to each piece at 121°C under 2 atmospheres (relative humidity: 100 %), while measuring the insulation resistance of each test piece which varied time-dependently. In this test, the number of the test pieces that had an insulation resistance value (R) of $10^6 \frac{1}{2}$ or lower within a period of 250 hours was counted. The results obtained in these tests are shown in Table 3.

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As is obvious from Table 1, Table 2 and Table 3, the monolithic ceramic capacitor samples falling within the scope of the present invention all were found to have a high dielectric constant of not lower than 3,000, and have a dielectric loss tangent, $\tan \delta$, of not larger than 2.5 %, while satisfying the B-level characteristic standard as stipulated in the JIS Standard within the temperature range between -25°C and 85°C and also the X7R-level characteristic standard as stipulated in the EIA Standard within the temperature range between -55°C and 125°C with respect to the temperature-dependent variation in the capacitance.

Moreover, these samples of the invention were found to have high insulation resistance values, when measured at 25°C , of not smaller than $6,000 \text{ M}\Omega \mu\text{F}$, in terms of the product of CR. Further, these were found to have a long mean life time of not shorter than 300 hours, and none of these failed in the moisture-resistant load test.

In addition, these were sintered at relatively low temperatures of not higher than 1300°C , and the crystal grains in the sintered samples were small to have grain sizes of not larger than $1 \mu\text{m}$. Since the crystal grains existing in the dielectric ceramic layers in these samples are small, or that is, not larger than $1 \mu\text{m}$, the number of the crystal grains to be in one dielectric ceramic layer is



large. Accordingly, even if the ceramic laminate comprising these layers is thinned, the reliability of the capacitor comprising the laminate is not lowered.

Now, the reasons for defining the compositions for use in the present invention are mentioned below.

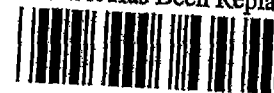
First referred to are the reasons for defining α to fall within the range of $0.0025 \leq \alpha \leq 0.020$ in the composition of $(1-\alpha-\beta)\{\text{BaO}\}_m \cdot \text{TiO}_2 + \alpha\text{M}_2\text{O}_3 + \beta(\text{Mn}_{1-x}\text{Ni}_x)\text{O}$, in which M_2O_3 is at least one selected from Sc_2O_3 and Y_2O_3 . As in Sample No. 1, if the amount, α , of M_2O_3 is smaller than 0.0025, the temperature-dependent variation in the capacitance is great, and the mean life time is very short.

On the other hand, as in Sample No. 18, if the amount, α , of M_2O_3 is larger than 0.020, the dielectric constant is not larger than 3,000, the insulation resistance at 25°C and 125°C is low, the mean life time is short, some test pieces failed in the moisture-resistant load test, and the sintering temperature is high.

The reasons for defining β to fall within the range of $0.0025 \leq \beta \leq 0.04$ are as follows. As in Sample No. 2, if the amount, β , of $(\text{Mn},\text{Ni})\text{O}$ is smaller than 0.0025, the dielectric ceramics were reduced into semiconductors, when baked in the reducing atmosphere, to thereby lower the insulation resistance.

As in Sample No. 19, if the amount, β , of $(\text{Mn},\text{Ni})\text{O}$ is





larger than 0.04, the insulation resistance at 25°C is lower than 6,000 MΩ·μF, the mean life time is shorter than 300 hours, and the temperature-dependent variation in the capacitance is too large to satisfy the X7R-level characteristic standard of the EIA Standard.

The reasons for defining x to fall within the range of $0 \leq x < 1.0$ are as follows. As in Sample No. 20, if the amount of NiO, x , is 1.0, the insulation resistance at 25°C is lower than 6,000 MΩ·μF, and the mean life time is shorter than 300 hours.

The reasons for defining β/α to fall within the range of $\beta/\alpha \leq 4$ are as follows. As in Sample No. 21, if the ratio, β/α , of the amount β of (Mn,Ni)O to the amount α of M_2O_3 is larger than 4, the temperature-dependent variation in the capacitance is large, and the mean life time is shorter than 300 hours.

The reasons for defining m to fall within the range of $1.000 < m \leq 1.035$ are as follows. As in Sample Nos. 3 and 4, if the molar ratio, m , of barium titanate is not larger than 1.000, the dielectric ceramic was converted into semiconductors when baked in the reducing atmosphere, whereby the insulation resistance of the capacitor was lowered (Sample No. 3); or the insulation resistance of the capacitor was lowered and the mean life time thereof was short so that the dielectric ceramic could not be used in



preparing thin ceramic laminates (Sample No. 4).

On the other hand, as in Sample No. 22, if the molar ratio, m , is larger than 1.035, the sinterability of the sample is very poor.

The reasons for defining the magnesium oxide content to fall between 0.5 mols and 3.0 mols in terms of MgO are as follows. As in Sample No. 5, if the amount of MgO is smaller than 0.5 mols, the insulation resistance is low, and the temperature-dependent variation in the capacitance could not satisfy the X7R-level characteristic standard of the EIA standard though satisfying the B-level characteristic standard of the JIS Standard.

On the other hand, as in Sample No. 23, if the amount of MgO is larger than 3.0 mols, the sintering temperature shall be too high, the dielectric constant could not be over 3,000, and many test pieces of the sample failed in the moisture-resistant load test.

The reasons for defining the silicon oxide content to fall between 0.2 mols and 5.0 mols in terms of SiO_2 are as follows. As in Sample No. 6, if the SiO_2 content is 0 (zero), the sample could not be sintered. As in Sample No. 7, if the SiO_2 content is smaller than 0.2 mols, the sintering temperature shall be too high, the insulation resistance is low, and many test pieces of the sample failed in the moisture-resistant load test.



On the other hand, as in Sample No. 24, if the SiO_2 content is larger than 5.0 mols, the dielectric constant could not be over 3000, and the insulation resistance at 25°C could not be over $6,000 \text{ M}\Omega \cdot \mu\text{F}$.

The reasons for defining the impurity, alkali metal oxide content of barium titanate to be not larger than 0.02 % by weight are as follows. As in Sample No. 25, if the impurity, alkali metal oxide content of barium titanate is larger than 0.02 % by weight, the dielectric constant is lowered.

In the above-mentioned Example, used was a powder of barium titanate as prepared according to the oxalic acid method, which, however, is not limitative. Apart from this, also employable are powders of barium titanate as prepared according to an alkoxide method or a hydrothermal reaction method. If the latter powders are used, the characteristics of the capacitors may often be improved more than those of the samples as demonstrated in the Example herein.

Powders of scandium oxide, yttrium oxide, manganese oxide, nickel oxide and others were used in the Example, which, however, are not also limitative. Solutions of alkoxides or organic metal compounds for such oxides can also be employed, in place of such oxide powders, without interfering with the characteristics of the capacitors



produced, provided that they are formulated to constitute the dielectric ceramic layers falling within the scope of the present invention.

In the monolithic ceramic capacitor of the present invention, the dielectric ceramic layers are made from a dielectric ceramic material that can be baked even in a reducing atmosphere without being reduced into semiconductors. Therefore, a base metal of nickel or a nickel alloy can be used as the material for the electrodes in the capacitor. In addition, since the dielectric ceramic material can be baked at relatively low temperatures of 1300°C or lower, the production costs of the capacitor can be reduced.

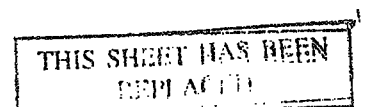
Moreover, the monolithic ceramic capacitor of the invention that comprises ceramic layers made from such dielectric ceramic materials has a dielectric constant of 3000 or higher, and the temperature-dependent variation in the high dielectric constant of the capacitor is small. Further, the capacitor has high insulation resistance and has good characteristics, and their characteristics are not worsened even in high-temperature and high-humidity conditions.

In addition, since the crystals constituting the dielectric layers are small to have grain sizes of 1 μm or smaller, the layers can be thinned well, without reducing

the number of the crystals to be therein, being different from the ceramic layers constituting conventional monolithic ceramic capacitors. Therefore, according to the present invention, it is possible to obtain high-reliability, small-sized, large-capacity, monolithic ceramic capacitors.

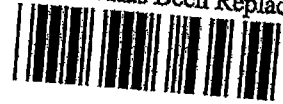
While the invention has been described in detail and with reference to specific embodiments thereof, it will be apparent to one skilled in the art that various changes and modifications can be made therein without departing from the spirit and scope thereof.

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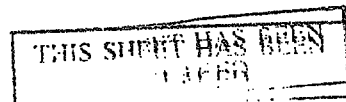
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WHAT IS CLAIMED IS:

1. A dielectric ceramic composition comprising:
barium titanate;
scandium oxide, yttrium oxide, manganese oxide and
nickel oxide,
magnesium oxide, as a side component, in an amount of
from 0.5 to 3.0 mols in terms of MgO, and silicon oxide in
an amount of from 0.2 to 5.0 mols in terms of SiO₂,
relative to 100 mols of the essential component having the
following compositional formula:
$$(1-\alpha-\beta)\{\text{BaO}\}_m \cdot \text{TiO}_2 + \alpha \text{M}_2\text{O}_3 + \beta (\text{Mn}_{1-x}\text{Ni}_x)\text{O}$$

where M₂O₃ is at least one selected from Sc₂O₃ and
Y₂O₃; and
 α , β , m and x are as follows:
$$0.0025 \leq \alpha \leq 0.020$$
$$0.0025 \leq \beta \leq 0.04$$
$$\beta/\alpha \leq 4$$
$$0 \leq x < 1.0$$
$$1.000 < m \leq 1.035.$$
2. The dielectric ceramic composition according to
claim 1, wherein said barium titanate having at least one
alkali metal oxide as an impurity.
3. The dielectric ceramic composition according to





claim 2, wherein said barium titanate includes alkali metal oxide oxides of 0.02 % by weight or less.

4. The dielectric ceramic composition according to claim 2, wherein said alkali metal oxide includes at least one oxide selected from SrO , CaO , SiO_2 and Al_2O_3 .

5. A monolithic ceramic capacitor composed of;
a dielectric ceramic layers,
at least two inner electrodes as formed between the dielectric ceramic layers in such a manner that one end of each inner electrode is exposed out of either end of the dielectric ceramic layers, and

outer electrodes as electrically connected with the exposed inner electrodes,

the monolithic ceramic capacitor being characterized in that;

the dielectric ceramic layers each are made of a material comprising;

barium titanate;

scandium oxide, yttrium oxide, manganese oxide and nickel oxide;

magnesium oxide, as a side component, in an amount of from 0.5 to 3.0 mols in terms of MgO , and silicon oxide in an amount of from 0.2 to 5.0 mols in terms of SiO_2 ,

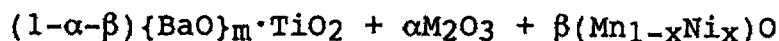
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relative to 100 mols of the essential component having the following compositional formula:



where M_2O_3 is at least one selected from Sc_2O_3 and Y_2O_3 ; and

α , β , m and x are as follows:

$$0.0025 \leq \alpha \leq 0.020$$

$$0.0025 \leq \beta \leq 0.04$$

$$\beta/\alpha \leq 4$$

$$0 \leq x < 1.0$$

$$1.000 < m \leq 1.035.$$

6. The monolithic ceramic capacitor according to claim 5, wherein said barium titanate having at least one alkali metal oxide as an impurity.

7. The monolithic ceramic capacitor according to claim 6, wherein said barium titanate includes alkali metal oxides of 0.02% by weight or less.

8. The dielectric ceramic capacitor according to claim 6, wherein said alkali metal oxide includes at least one oxide selected from SrO , CaO , SiO_2 and Al_2O_3 .

9. The monolithic ceramic capacitor according to

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claim 5, wherein at least one of said inner electrodes is made of at least one base metal.

10. The monolithic ceramic capacitor according to claim 9, wherein said base metal includes ceramic powder.

11. The monolithic ceramic capacitor according to claim 9, wherein said base metal is nickel or nickel alloy.

12. The monolithic ceramic capacitor according to claim 5, wherein at least one of said outer electrodes is made of a sintered layer of an electroconductive metal powder.

13. The monolithic ceramic capacitor according to claim 5, wherein at least one of said outer electrodes is made of an electroconductive metal powder with glass frit added thereto.

14. The monolithic ceramic capacitor according to claim 5, wherein the outer electrodes each comprising a first, sintered layer of an electroconductive metal powder or of an electroconductive metal powder with glass frit added thereto, and a second, plated layer formed on the first layer.

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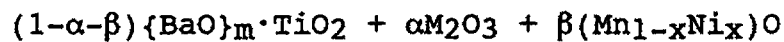
ABSTRACT

A dielectric ceramic composition and a monolithic ceramic capacitor using same are provided. The dielectric ceramic composition includes:

barium titanate;

scandium oxide, yttrium oxide, manganese oxide and nickel oxide,

magnesium oxide, as a side component, in an amount of from 0.5 to 3.0 mols in terms of MgO, and silicon oxide in an amount of from 0.2 to 5.0 mols in terms of SiO₂, relative to 100 mols of the essential component having the following compositional formula:



where M₂O₃ is at least one selected from Sc₂O₃ and Y₂O₃; and

α , β , m and x are as follows:

$$0.0025 \leq \alpha \leq 0.020$$

$$0.0025 \leq \beta \leq 0.04$$

$$\beta/\alpha \leq 4$$

$$0 \leq x < 1.0$$

$$1.000 < m \leq 1.035.$$

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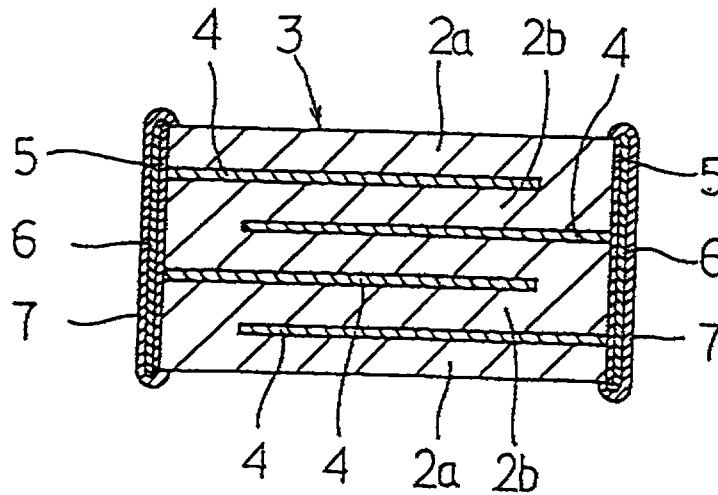
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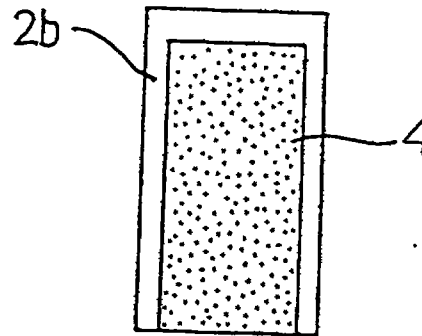
【図1】 Fig.1

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コード 【図2】 Fig.2
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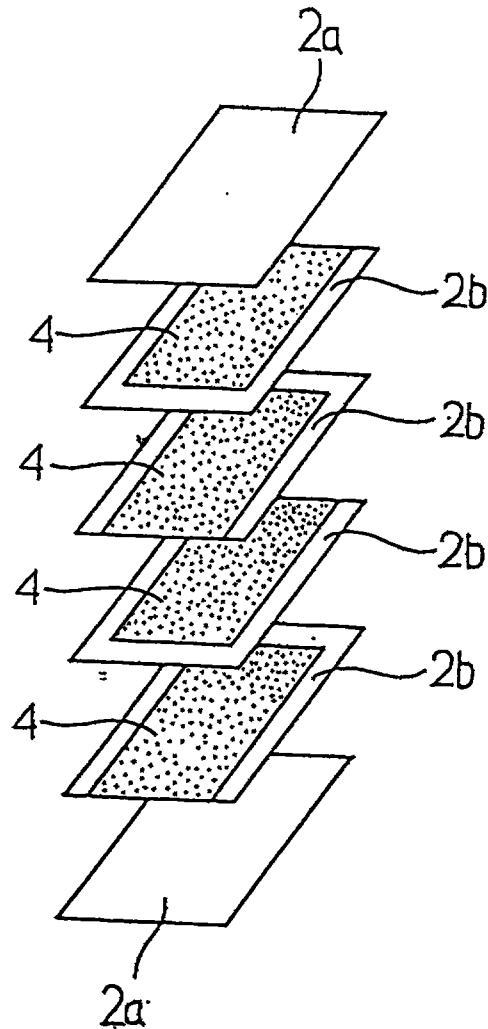


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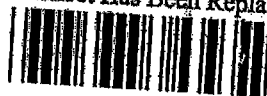
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コード 【図3】 Fig. 3

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DIELECTRIC CERAMIC COMPOSITION AND MONOLITHIC CERAMIC
CAPACITOR USING SAME

FIELD OF THE INVENTION

The present invention relates to a dielectric ceramic composition and a monolithic ceramic capacitor to be used in electronic instruments, especially those having inner electrodes made of nickel or nickel alloys.

BACKGROUND OF THE INVENTION

Monolithic ceramic capacitors are generally produced as follows.

First, sheets of dielectric ceramic layers each as coated with an electrode material to be an inner electrode thereon are prepared. For example, the dielectric ceramic layers may consist essentially of BaTiO_3 . Next, a plurality of such sheets of dielectric ceramic layers each coated with the electrode material are laminated and integrated under heat and pressure, and the resulting laminate is baked in a natural atmosphere at from 1250°C to 1350°C to obtain a monolithic dielectric ceramic body having inner electrodes therein. To the both ends of the dielectric ceramic body, are fixed and baked outer electrodes that electrically communicate with the inner electrode. Thus is obtained a monolithic ceramic capacitor.

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Accordingly, the materials for such inner electrodes must satisfy the following requirements.

1. Since the ceramic laminate and the inner electrodes are baked together, the melting point of the materials for the inner electrodes must be not lower than the temperature at which the ceramic laminate can be baked.

2. The materials for the inner electrodes must not be oxidized even in high-temperature, oxidizing atmospheres and must not react with the dielectric ceramic layers.

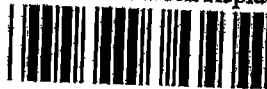
As electrodes that satisfy these requirements, noble metals, such as platinum, gold, palladium and silver-palladium alloys, have heretofore been used.

However, these electrode materials are expensive, though having excellent characteristics. Accordingly, the cost of the electrode material reaches from 30 to 70 % of the total cost of one monolithic ceramic capacitor, which therefore is the essential factor of increasing the production costs of conventional monolithic ceramic capacitors.

Except for noble metals, known are base metals, such as Ni, Fe, Co, W and Mo, which have a high melting point. However, such base metals are easily oxidized in high-temperature, oxidizing atmospheres to lose their functions as electrodes. Therefore, if such base metals are used as the inner electrodes in monolithic ceramic capacitors, they

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must be baked in neutral or reducing atmospheres along with dielectric ceramic layers. However, conventional dielectric ceramic materials were defective in that, if they are baked in such neutral or reducing atmospheres, they are greatly reduced into semiconductors.

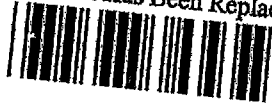
In order to overcome these drawbacks, for example, proposed were a dielectric ceramic material comprising a solid solution of barium titanate where the ratio of barium sites/titanium sites is over the stoichiometric ratio thereof, such as that disclosed in Japanese Patent Publication No. 57-42588; and a dielectric ceramic material comprising a solid solution of barium titanate and containing oxides of rare earth metals, such as La, Nd, Sm, Dy and Y, added thereto, such as that disclosed in Japanese Patent Application Laid-Open No. 61-101459.

Also proposed were a dielectric ceramic material having a composition of $\text{BaTiO}_3\text{-CaZrO}_3\text{-MnO-MgO}$, such as that disclosed in Japanese Patent Application Laid-Open No. 62-256422; and a dielectric ceramic material having a composition of $\text{BaTiO}_3\text{-(Mg,Zn,Sr,Ca)O-B}_2\text{O}_3\text{-SiO}_2$, such as that disclosed in Japanese Patent Publication No. 61-14611.

Using these dielectric ceramic materials, ceramic laminates were obtained, which are not converted into semiconductors even when baked in reducing atmospheres. As a result, it has become possible to produce monolithic

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ceramic capacitors comprising inner electrodes of base metals such as nickel.

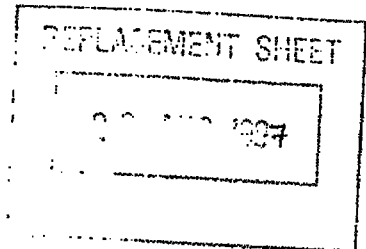
With the recent development in electronics, small-sized electronic parts have become required greatly in the art, and small-sized, large-capacity, monolithic ceramic capacitors are therefore required greatly therein.

For these reasons, the recent tendency in the art is rapidly toward dielectric ceramic materials having a higher dielectric constant and toward thinner dielectric layers. Accordingly, there is now a great demand for dielectric ceramic materials with high reliability having a high dielectric constant, in which the temperature-dependent variation is little.

However, the dielectric ceramic materials disclosed in Japanese Patent Publication No. 57-42588 and Japanese Patent Application Laid-Open No. 61-101459 were defective in that the crystals constituting the ceramic laminates made from the materials are large, though the ceramic laminates themselves may have a high dielectric constant, with the result that, if thin dielectric ceramic layers having a thickness of, for example, 10 μm or less are incorporated into monolithic ceramic capacitors, the number of ceramic crystals to be in one layer is reduced and therefore the reliability of the monolithic ceramic capacitors is lowered. In addition, the dielectric ceramic

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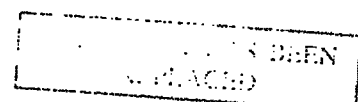
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materials were further defective in that the temperature-dependent variation in the dielectric constant of the dielectric ceramics is great. For these reasons, the conventional dielectric ceramic materials could not meet the requirements in the market.

On the other hand, the dielectric ceramic material disclosed in Japanese Patent Application Laid-Open No. 62-256422 was defective in that CaZrO_3 and also CaTiO_3 that is formed during the baking step may often form secondary phases together with Mn and others and therefore the high-temperature reliability of the capacitor comprising the material is problematic, although the dielectric constant of the ceramic body of the material is relatively high, the crystals constituting the ceramic laminate are small, and the temperature-dependent variation in the dielectric constant is small.

The dielectric ceramic material disclosed in Japanese Patent Publication No. 61-14611 was defective in that the dielectric constant of the ceramic body of the material is from 2000 to 2800 and therefore the material is not suitable for small-sized, large-capacity monolithic ceramic capacitors. In addition, the material was further defective in that it does not satisfy the capacitance characteristic standard as stipulated in the EIA Standard, which indicates that the temperature-dependent variation in



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the capacitance within the range between -55°C and $+125^{\circ}\text{C}$ shall be $\pm 15\%$ or less.

Japanese Patent Application Laid-Open No. 63-103861 discloses a non-reducing dielectric ceramic material, which, however, was defective in that its insulating resistance and the temperature-dependent variation in its capacity are greatly influenced by the grain size of the crystals of BaTiO_3 which is the essential component constituting the material and therefore the material is difficult to control so as to obtain stable characteristics. In addition, for the insulating resistance of the material, the product of the insulating resistance value and the capacitance value (product of CR) falls between 1000 and 2000 ($\Omega\cdot\text{F}$). In view of this, the material could not be practicable.

Although some improvements were made in the non-reducing dielectric ceramic compositions that have heretofore been proposed in the art, such as those mentioned hereinabove, to make them have good insulation resistance in high-temperature load life tests, the improvement in their insulation resistance in moisture-resistant load tests was still unsatisfactory as yet.

In order to solve the above-mentioned problems, proposed were different compositions, for example, in Japanese Patent Application Laid-Open Nos. 05-9066, 05-9067 and 05-9068. However, these compositions could not still



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satisfy the recent severe requirements for small-sized, large-capacity capacitors in the market. Specifically, the recent requirements for these in the market are to make them have much thinner dielectric ceramic layers and even have high reliability. Therefore, there is still a great demand for dielectric ceramic materials capable of producing much thinner dielectric ceramic layers in monolithic ceramic capacitors with much higher reliability. Given the situation, accordingly, it has become necessary to provide small-sized, large-capacity, high-reliability monolithic ceramic capacitors still having highly-reliable characteristics even in high-temperature and high-humidity conditions.

SUMMARY OF THE INVENTION

Accordingly, the subject matter of the present invention is to provide a low-priced, small-sized, large-capacity, monolithic ceramic capacitor, which has a dielectric constant of 3000 or more, which has a high insulation resistance, when measured at room temperature and 125°C, of 6000 MΩ·μF or more, in terms of its product with the capacitance (the product of CR), which has temperature-dependent capacitance that satisfies the B-level characteristic standard as stipulated in the JIS Standard and the X7R-level characteristic standard as

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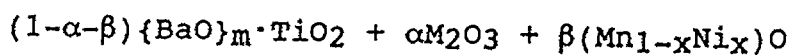
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stipulated in the EIA Standard, and which has good weather resistance even in high-temperature and high-humidity load conditions.

The present invention has been made in consideration of the above-mentioned object.

Specifically, the present invention provides a monolithic ceramic capacitor composed of; a plurality of dielectric ceramic layers, a plurality of inner electrodes as formed between the dielectric ceramic layers in such a manner that one end of each inner electrode is exposed out of either end of the dielectric ceramic layers, and outer electrodes as electrically connected with the exposed inner electrodes, which is characterized in that;

the dielectric ceramic layers each are made of a material comprising; barium titanate having a content of impurities, alkali metal oxides of 0.02 % by weight or less, and scandium oxide, yttrium oxide, manganese oxide and nickel oxide; and containing side components, magnesium oxide in an amount of from 0.5 to 3.0 mols in terms of MgO, and silicon oxide in an amount of from 0.2 to 5.0 mols in terms of SiO₂, relative to 100 mols of the essential component having the following compositional formula:



where M₂O₃ is at least one selected from Sc₂O₃ and Y₂O₃; and



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α , β , m and x are as follows:

$$0.0025 \leq \alpha \leq 0.020$$

$$0.0025 \leq \beta \leq 0.04$$

$$\beta/\alpha \leq 4$$

$$0 \leq x < 1.0$$

$$1.000 < m \leq 1.035; \text{ and}$$

the inner electrodes each are made of nickel or a nickel alloy.

Preferably, in the monolithic ceramic capacitor of the present invention, the outer electrodes each are made of a sintered layer of an electroconductive metal powder with glass frit added thereto. Further preferably, the outer electrodes each are composed of a first, sintered layer of an electroconductive metal powder with glass frit added thereto, and a second, plated layer formed on the first layer.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a cross-sectional view illustrating the outline of one embodiment of the monolithic ceramic capacitor of the present invention.

Fig. 2 is a plan view illustrating the outline of one embodiment of a dielectric ceramic layer having an inner electrode thereon, which is prepared in the present invention.

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Fig. 3 is a perspective, exploded view illustrating one embodiment of a ceramic laminate as prepared in the present invention.

PREFERRED MODES OF CARRYING OUT THE INVENTION

Now, preferred modes of carrying out the invention are described in detail hereinunder.

As the material for the dielectric ceramic layers constituting the monolithic ceramic capacitor of the present invention, herein used is a dielectric ceramic material comprising at least one oxide selected from scandium oxide and yttrium oxide, and also manganese oxide and nickel oxide, in a specifically conditioned compositional ratio such as that mentioned hereinabove, and containing magnesium oxide and silicon oxide within the range as defined hereinabove. Therefore, even in a reducing atmosphere, the dielectric ceramic material can be baked well without worsening its characteristics. As a result, according to the present invention, it is possible to obtain a high-reliability, monolithic ceramic capacitor having a temperature-dependent capacitance that satisfies the B-level characteristic standard as stipulated in the JIS Standard and also the X7R-level characteristic standard as stipulated in the EIA Standard, and having high insulation resistance at room temperature and even at high

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temperatures.

In addition, since the crystal grains existing in the sintered dielectric ceramics constituting the capacitor of the invention are small, or that is, not larger than $1\text{ }\mu\text{m}$, the number of the crystal grains to be in one dielectric ceramic layer may be increased. Accordingly, even if the dielectric layers are thinned, the reliability of the capacitor comprising such thin dielectric layers is not lowered.

It has been confirmed that, of the essential components constituting the dielectric ceramic material for use in the present invention, such as barium titanate, at least one oxide selected from scandium oxide and yttrium oxide, and also manganese oxide and nickel oxide, the content of the impurities in the barium titanate, such as alkaline earth metal oxides, e.g., SrO and CaO ; alkali metal oxides, e.g., Na_2O and K_2O ; and other oxides, e.g., Al_2O_3 and SiO_2 , especially that of alkali metal oxides such as Na_2O and K_2O , has a great influence on the electric characteristics of the capacitor of the invention. Specifically, it has been confirmed that, if barium titanate having an alkali metal oxide impurity content of smaller than 0.02 % by weight is in the dielectric ceramic material, the capacitor of the invention comprising the dielectric ceramic may have a dielectric constant of 3000

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or higher.

The reason why silicon oxide is added to the dielectric ceramic layers in the present invention is that said addition improves the sinterability of the layers if the sintering atmosphere is controlled to have an oxygen partial pressure near to the equilibrated oxygen partial pressure of Ni/NiO at relatively high temperatures during the sintering step, while also improving the moisture-resistant load characteristics of the capacitors comprising the layers.

If the dielectric ceramic material mentioned hereinabove is used to form the dielectric ceramic layers constituting the monolithic ceramic capacitor of the invention, it is possible to use base metals, nickel or nickel alloys to form the inner electrodes of the capacitor. In addition, it is also possible to add to the inner electrodes a ceramic additive comprising the same compositional material as that for the ceramic layers and containing a small amount of other oxides.

The composition of the outer electrodes of the capacitor of the invention is not specifically defined. Concretely, for example, the outer electrodes may be made of sintered layers comprising various electroconductive powders, such as Ag, Pd, Ag-Pd, Cu or Cu alloys, and various types of glass frit of B_2O_3 - Li_2O - SiO_2 - BaO , B_2O_3 -

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$\text{SiO}_2\text{-BaO}$, $\text{Li}_2\text{O-SiO}_2\text{-BaO}$ or the like. More preferably, the sintered layers are coated with a plate layer. The plate layer may comprise Ni, Cu or the like, and may be further coated with any additional plate layer of solder, tin or the like.

Now, the present invention is described in more detail with reference to the following Examples, which, however, are not intended to restrict the scope of the invention.

One embodiment of the monolithic ceramic capacitor of the present invention is referred to. Fig. 1 is a cross-sectional view illustrating the outline of one embodiment of the monolithic ceramic capacitor of the invention. Fig. 2 is a plan view illustrating the outline of the dielectric ceramic layer having an inner electrode thereon, which is in this embodiment. Fig. 3 is a perspective, exploded view illustrating the ceramic laminate to be in this embodiment.

As in Fig. 1, the monolithic ceramic capacitor 1 of the present invention is in the form of a rectangular parallelepiped chip, in which the outer electrodes 5, the first plate layers 6 made of nickel, copper or the like, and the second plate layers 7 made of solder, tin or the like are formed on the both sides of the ceramic laminate 3 as formed through lamination of a plurality of dielectric ceramic layers 2a and 2b via the inner electrode 4 therebetween.

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Now, a method for producing the monolithic ceramic capacitor 1 of the invention is described below in the order of the steps constituting the method.

First, the ceramic laminate 3 is formed. This ceramic laminate 3 is produced as follows. As in Fig. 2, a raw material powder comprising barium titanate; at least one oxide selected from scandium oxide and yttrium oxide; manganese oxide, nickel oxide, magnesium oxide; and oxides consisting essentially of silicon oxide is formed into a slurry, and then sheeted to prepare a dielectric ceramic layer 2a (green sheet). On one surface of the green sheet, formed is an internal electrode 4 of nickel or a nickel alloy. To form the internal electrode 4, employable is any method of screen printing, metal vapor deposition or plating.

A predetermined number of the dielectric ceramic layers 2b each with the inner electrode 4 formed thereon are laminated, and then sandwiched between two dielectric ceramic layers 2a not having the inner electrode 4, as in Fig. 3, and these are integrated under pressure to give a laminate. Next, the resulting laminate composed of the dielectric ceramic layers 2a, 2b, . . . 2b, 2a is baked in a reducing atmosphere at a predetermined temperature to obtain the ceramic laminate 3.

Next, on the both sides of the ceramic laminate 3,

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formed are two outer electrodes 5 that are connected with the inner electrodes 4. The material of the outer electrodes 5 may be the same as that of the inner electrodes 4. Apart from this, silver, palladium, silver-palladium alloys, copper, copper alloys and others can be used as the material of the outer electrodes 5, to which can be added glass frit, such as glass of the type of $B_2O_3-SiO_2-BaO$ or Li_2O-SiO_2-BaO . In consideration of the use of the monolithic ceramic capacitor of the invention and the site at which the capacitor is used, suitable materials are selected for the outer electrodes 5. The outer electrodes 5 can be formed by applying an electroconductive paste material of metal powder onto the baked ceramic laminate 3 followed by baking it. Alternatively, the paste material can be applied onto the non-baked ceramic laminate 3, which is baked all at a time. After this, the outer electrodes 5 may be plated with nickel, copper or the like to form a first plate layer 6 thereon. Last, the first plate layer 6 is coated with a second plate layer 7 of solder, tin or the like. Thus is produced the chip-type, monolithic ceramic capacitor 1 of the invention.

The following Example is to further illustrate the invention in more detail.

EXAMPLE 1

First, raw materials of $TiCl_4$ and $Ba(NO_3)_2$ having

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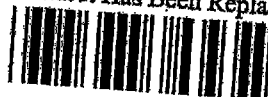
28 AUG 1957

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various degrees of purity were prepared and weighed. These were treated with oxalic acid to obtain a precipitate of barium titanyl oxalate ($\text{BaTiO}(\text{C}_2\text{O}_4) \cdot 4\text{H}_2\text{O}$). This precipitate was decomposed under heat at 1000°C or higher to obtain four types of barium titanate (BaTiO_3) as shown in Table 1.

Next, prepared were Sc_2O_3 , Y_2O_3 , MnO , NiO and MgO each having a purity of 99 % or more, and a colloidal silica containing silicon dioxide in an amount of 20 % by weight in terms of SiO_2 .

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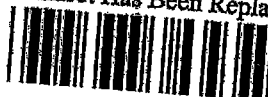


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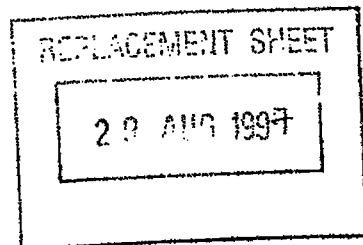
TABLE 1
Samples with * are outside the invention.

Type of BaTiO ₃	Content of Impurities (wt.%)					Mean Grain Size (μm)
	Alkali Metal Oxides	SrO	CaO	SiO ₂	Al ₂ O ₃	
A	0.003	0.012	0.001	0.010	0.005	0.60
B	0.020	0.010	0.003	0.019	0.008	0.56
C	0.012	0.179	0.018	0.155	0.071	0.72
D	0.062	0.014	0.001	0.019	0.004	0.58

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Next, these raw materials were mixed in various compositional ratios as shown in Table 2 to prepare various compositions. Each composition was wet-milled in a ball mill, evaporated to dryness and dressed to obtain a powdery raw material mixture.

The resulting mixture was wet-milled in a ball mill along with a polyvinyl butyral binder and an organic solvent such as ethanol to obtain a ceramic slurry. This ceramic slurry was sheeted according to doctor blading to obtain a rectangular green sheet having a thickness of 11 μm . Next, an electroconductive paste consisting essentially of Ni was printed on this ceramic green sheet to form thereon an electroconductive paste layer, which is formed into an inner electrode.

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TABLE 2

Samples with * are outside the invention.
(1- α - β) (BaO)_m-TiO₂ + α MgO₃ + β (Mn_{1-x}Ni_x)O

Sample No.	Type of BaTiO ₃	α					β		β/α	m	MgO (mol)	SiO ₂ (mol)
		Y ₂ O ₃	Sc ₂ O ₃			Total		x				
* 1	A	-	-			0.0000	0.005	0.3	-	1.010	1.20	1.00
* 2	A	0.010				0.0100	0.000	-	0	1.010	1.20	1.00
* 3	A	0.010	0.002			0.0120	0.005	0.3	5/12	0.990	1.20	1.00
* 4	A	0.012				0.0120	0.005	0.3	5/12	1.000	1.00	1.00
* 5	A	0.0080				0.0080	0.0100	0.3	1	1.010	0.00	1.00
* 6	A	0.0100				0.0100	0.0100	0.3	1	1.015	1.20	0.00
* 7	A	0.0075				0.0075	0.0075	0.5	1	1.015	1.50	0.10
8	A	0.0025				0.0025	0.0025	0.1	1	1.005	0.50	0.20
9	A	0.0050	0.0050			0.0100	0.0080	0.5	4/5	1.010	1.00	1.00
10	A	0.0080	0.0040			0.0120	0.0080	0.0	2/3	1.010	1.50	1.50
11	A	0.0090				0.0090	0.0090	0.4	1	1.015	1.20	1.50
12	A	0.0080				0.0080	0.0080	0.3	1	1.010	1.20	1.00
13	C	0.0015	0.0050			0.0200	0.0400	0.8	2	1.005	1.00	2.00
14	B	0.0030				0.0030	0.0060	0.4	2	1.010	3.00	5.00
15	A	0.0080	0.0020			0.0100	0.0050	0.0	1/2	1.010	1.00	1.50
16	A	0.0060				0.0060	0.0240	0.6	4	1.035	0.50	2.50
17	A	0.010	0.010			0.0200	0.0050	0.1	1/4	1.015	2.00	1.50

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TABLE 2 - continued

Samples with * are outside the invention.

Sample No.	Type of BaTiO ₃	(1-α-β) (BaO) _m ·TiO ₂ + αMgO ₃ + β (Mn _{1-x} Ni _x)O											MgO		SiO ₂	
		Y ₂ O ₃	Sc ₂ O ₃	α					Total	β		β / α	m	(mol)	(mol)	
				x												
* 18	A	0.0200	0.010					0.030	0.015	0.3		1/2	1.010	2.00	1.50	
* 19	A	0.015						0.015	0.060	0.3		4.0	1.010	1.20	1.50	
* 20	A	0.010						0.010	0.010	1.0		1.0	1.010	1.20	1.00	
* 21	A	0.0040	0.0010					0.0050	0.040	0.3		8	1.010	1.20	1.00	
* 22	A	0.0100						0.010	0.0050	0.3		1/2	1.050	1.20	2.00	
* 23	A	0.0100						0.010	0.0050	0.3		1/2	1.010	5.0	2.00	
* 24	A	0.0100						0.010	0.0050	0.3		1/2	1.010	1.20	8.00	
* 25	D	0.0100						0.010	0.0050	0.3		1/2	1.010	1.20	1.50	
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A plurality of these ceramic green sheets each having the electroconductive paste layer formed thereon were laminated in such a manner that the side of one sheet with the electroconductive paste exposed out of it was alternated with that of another sheet with the electroconductive paste not exposed out of it. Thus was obtained a laminate. This laminate was heated in an N₂ atmosphere at 350°C whereby the binder was burnt out, and then baked for 2 hours in a reducing atmosphere comprising gases of H₂, N₂ and H₂O and having an oxygen partial pressure of from 10⁻¹¹ to 10⁻⁸ MPa, at various temperatures shown in Table 3, to obtain sintered ceramic bodies.

The surface of each sintered ceramic body was observed with a scanning, electronic microscope at a magnification of 1500 times, to determine the grain sizes of the grains seen in the field of view.

A silver paste containing glass frit of the type of B₂O₃-Li₂O-SiO₂-BaO was applied onto the both sides of each sintered ceramic body, and baked again in an N₂ atmosphere at 600°C to thereby form outer electrodes as electrically connected with the inner electrodes.

The outer dimension of each of these monolithic capacitors thus obtained was 1.6 mm width x 3.2 mm length x 1.2 mm thickness, and the thickness of each dielectric ceramic layer as sandwiched between the inner electrodes

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was 8 μm .

The total number of the effective dielectric ceramic layers was 19, and the area of the facing electrodes per one ceramic layer was 2.1 mm^2 .

The capacitance (C) and the dielectric loss ($\tan \delta$) of each sample were measured, using an automatic bridge-type meter at a frequency of 1 KHz, at 1 V rms and at 25°C. From the capacitance thus measured, obtained was the dielectric constant (ϵ) through calculation. Next, to measure the insulation resistance (R) of each sample, a direct current voltage of 16 V was applied to each sample at 25°C for 2 minutes, using an insulation resistance meter. After having thus measured the insulation resistance (R) of each sample, the product of the capacitance (C) and the insulation resistance (R) or, that is, the product of CR of each sample was obtained. In addition, the temperature-dependent variation in the capacitance of each sample was determined.

For the temperature-dependent variation in the capacitance, obtained were the variation in the capacitance between -25°C and 85°C based on the capacitance at 20°C ($\Delta C/C_{20^\circ\text{C}}$), the variation in the capacitance between -55°C and 125°C based on the capacitance at 25°C ($\Delta C/C_{25^\circ\text{C}}$), and the maximum variation, in terms of the absolute value, between -55°C and 125°C ($|\Delta C|_{\text{max}}$).

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TABLE 3

Sample No.	Baking Temperature (°C)	Dielectric Constant, ϵ'	Dielectric Loss, $\tan \delta$ (%)	Temperature-Dependent Variation in Capacitance, $\Delta C/C_{20^\circ\text{C}}$ (%)		Temperature-Dependent Variation in Capacitance, $\Delta C/C_{25^\circ\text{C}}$ (%)		Product of CR ($\Omega \cdot \text{F}$), at 25°C	Mean Life Time (hr.)	Number of Test Pieces Failed in Moisture-Resistant Load Test	Grain Size (μm)
				-25°C	85°C	-55°C	125°C	max			
1	1300	3090	2.3	-12.1	-4.5	-16.3	2.2	16.3	7	0/72	0.77
2	1280										
3	1280										
4	1280	3290	2.1	-3.1	-5.4	-3.4	-5.3	5.5	201	0/72	2.1
5	1280	3380	2.0	0.5	-10.7	1.5	-17.0	17.0	300	0/72	0.73
6	1360										
7	1330	3220	1.9	-2.7	-5.1	-3.0	-4.9	5.2	307	53/72	0.61
8	1300	4050	2.4	-8.1	-6.5	-12.3	-12.7	12.7	311	0/72	0.68
9	1280	3290	1.8	-2.5	-5.2	-2.5	-5.6	5.6	489	0/72	0.72
10	1300	3100	1.7	-2.7	-4.9	-2.9	-5.1	5.1	497	0/72	0.68
11	1280	3510	2.1	-1.7	-6.2	-2.0	-9.3	9.8	530	0/72	0.69
12	1280	3590	2.2	-1.2	-7.7	-1.1	-9.9	10.2	512	0/72	0.71
13	1300	3020	1.7	-2.0	-5.1	-2.0	-5.2	5.2	589	0/72	0.72
14	1260	3470	2.0	-4.0	-6.7	-5.3	10.7	10.7	311	0/72	0.78
15	1280	3310	1.9	-2.0	-5.8	-2.2	-6.6	6.6	509	0/72	0.64
16	1300	3370	1.9	-1.0	-8.8	-1.4	-11.6	11.8	307	0/72	0.68
17	1300	3000	1.4	-1.9	-4.5	1.8	-4.2	4.5	567	0/72	0.68
18	1360	2120	1.2	2.1	2.4	3.0	1.9	3.2	202	9/72	0.65
19	1280	3080	1.8	0.1	-9.8	0.2	16.2	16.2	104	0/72	0.70
20	1300	3550	2.2	-1.3	-6.6	-2.4	-7.3	7.3	282	0/72	0.71
21	1300	3630	2.3	-1.5	-11.0	-2.2	-17.7	17.7	192	0/72	0.72
22	1360										
23	1360	2350	1.5	-2.3	-3.3	-2.9	-2.2	3.4	332	49/72	0.61
24	1200	1950	1.2	-1.3	-2.5	-2.0	3.3	3.3	399	0/72	0.66
25	1280	2640	1.7	-2.1	-1.9	-3.3	-4.8	4.8	501	0/72	0.69

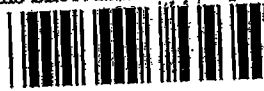
Samples with * are outside the invention.

As the sample was sintered insufficiently, the measurement was impossible.

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To determine the high-temperature load life of each sample, 36 pieces of each sample were subjected to a high-temperature load test, in which a direct current voltage of 100 V was applied to each piece at 150°C, while measuring the insulation resistance of each test piece which varied time-dependently. In this test, the period of time within which the insulation resistance value (R) of each piece being tested reached $10^6 \frac{1}{2}$ or lower was measured, which is referred to as the life time of each test piece. The average of all the tested pieces was calculated to obtain the average life time of each sample.

In addition, to measure the moisture-resistant load life of each sample, 72 pieces of each sample were subjected to a high-humidity load test, in which a direct current voltage of 16 V was applied to each piece at 121°C under 2 atmospheres (relative humidity: 100 %), while measuring the insulation resistance of each test piece which varied time-dependently. In this test, the number of the test pieces that had an insulation resistance value (R) of $10^6 \frac{1}{2}$ or lower within a period of 250 hours was counted. The results obtained in these tests are shown in Table 3.

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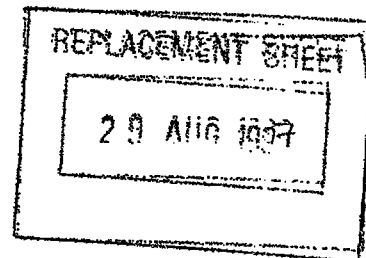
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As is obvious from Table 1, Table 2 and Table 3, the monolithic ceramic capacitor samples falling within the scope of the present invention all were found to have a high dielectric constant of not lower than 3,000, and have a dielectric loss tangent, $\tan \delta$, of not larger than 2.5 %, while satisfying the B-level characteristic standard as stipulated in the JIS Standard within the temperature range between -25°C and 85°C and also the X7R-level characteristic standard as stipulated in the EIA Standard within the temperature range between -55°C and 125°C with respect to the temperature-dependent variation in the capacitance.

Moreover, these samples of the invention were found to have high insulation resistance values, when measured at 25°C , of not smaller than $6,000 \text{ M}\Omega \mu\text{F}$, in terms of the product of CR. Further, these were found to have a long mean life time of not shorter than 300 hours, and none of these failed in the moisture-resistant load test.

In addition, these were sintered at relatively low temperatures of not higher than 1300°C , and the crystal grains in the sintered samples were small to have grain sizes of not larger than $1 \mu\text{m}$. Since the crystal grains existing in the dielectric ceramic layers in these samples are small, or that is, not larger than $1 \mu\text{m}$, the number of the crystal grains to be in one dielectric ceramic layer is

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large. Accordingly, even if the ceramic laminate comprising these layers is thinned, the reliability of the capacitor comprising the laminate is not lowered.

Now, the reasons for defining the compositions for use in the present invention are mentioned below.

First referred to are the reasons for defining α to fall within the range of $0.0025 \leq \alpha \leq 0.020$ in the composition of $(1-\alpha-\beta)\{\text{BaO}\}_m \cdot \text{TiO}_2 + \alpha\text{M}_2\text{O}_3 + \beta(\text{Mn}_{1-x}\text{Ni}_x)\text{O}$, in which M_2O_3 is at least one selected from Sc_2O_3 and Y_2O_3 . As in Sample No. 1, if the amount, α , of M_2O_3 is smaller than 0.0025, the temperature-dependent variation in the capacitance is great, and the mean life time is very short.

On the other hand, as in Sample No. 18, if the amount, α , of M_2O_3 is larger than 0.020, the dielectric constant is not larger than 3,000, the insulation resistance at 25°C and 125°C is low, the mean life time is short, some test pieces failed in the moisture-resistant load test, and the sintering temperature is high.

The reasons for defining β to fall within the range of $0.0025 \leq \beta \leq 0.04$ are as follows. As in Sample No. 2, if the amount, β , of $(\text{Mn},\text{Ni})\text{O}$ is smaller than 0.0025, the dielectric ceramics were reduced into semiconductors, when baked in the reducing atmosphere, to thereby lower the insulation resistance.

As in Sample No. 19, if the amount, β , of $(\text{Mn},\text{Ni})\text{O}$ is



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larger than 0.04, the insulation resistance at 25°C is lower than 6,000 MΩ·μF, the mean life time is shorter than 300 hours, and the temperature-dependent variation in the capacitance is too large to satisfy the X7R-level characteristic standard of the EIA Standard.

The reasons for defining x to fall within the range of $0 \leq x < 1.0$ are as follows. As in Sample No. 20, if the amount of NiO, x , is 1.0, the insulation resistance at 25°C is lower than 6,000 MΩ·μF, and the mean life time is shorter than 300 hours.

The reasons for defining β/α to fall within the range of $\beta/\alpha \leq 4$ are as follows. As in Sample No. 21, if the ratio, β/α , of the amount β of (Mn,Ni)O to the amount α of M_2O_3 is larger than 4, the temperature-dependent variation in the capacitance is large, and the mean life time is shorter than 300 hours.

The reasons for defining m to fall within the range of $1.000 < m \leq 1.035$ are as follows. As in Sample Nos. 3 and 4, if the molar ratio, m , of barium titanate is not larger than 1.000, the dielectric ceramic was converted into semiconductors when baked in the reducing atmosphere, whereby the insulation resistance of the capacitor was lowered (Sample No. 3); or the insulation resistance of the capacitor was lowered and the mean life time thereof was short so that the dielectric ceramic could not be used in

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preparing thin ceramic laminates (Sample No. 4).

On the other hand, as in Sample No. 22, if the molar ratio, m , is larger than 1.035, the sinterability of the sample is very poor.

The reasons for defining the magnesium oxide content to fall between 0.5 mols and 3.0 mols in terms of MgO are as follows. As in Sample No. 5, if the amount of MgO is smaller than 0.5 mols, the insulation resistance is low, and the temperature-dependent variation in the capacitance could not satisfy the X7R-level characteristic standard of the EIA standard though satisfying the B-level characteristic standard of the JIS Standard.

On the other hand, as in Sample No. 23, if the amount of MgO is larger than 3.0 mols, the sintering temperature shall be too high, the dielectric constant could not be over 3,000, and many test pieces of the sample failed in the moisture-resistant load test.

The reasons for defining the silicon oxide content to fall between 0.2 mols and 5.0 mols in terms of SiO_2 are as follows. As in Sample No. 6, if the SiO_2 content is 0 (zero), the sample could not be sintered. As in Sample No. 7, if the SiO_2 content is smaller than 0.2 mols, the sintering temperature shall be too high, the insulation resistance is low, and many test pieces of the sample failed in the moisture-resistant load test.

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On the other hand, as in Sample No. 24, if the SiO_2 content is larger than 5.0 mols, the dielectric constant could not be over 3000, and the insulation resistance at 25°C could not be over $6,000 \text{ M}\Omega \cdot \mu\text{F}$.

The reasons for defining the impurity, alkali metal oxide content of barium titanate to be not larger than 0.02 % by weight are as follows. As in Sample No. 25, if the impurity, alkali metal oxide content of barium titanate is larger than 0.02 % by weight, the dielectric constant is lowered.

In the above-mentioned Example, used was a powder of barium titanate as prepared according to the oxalic acid method, which, however, is not limitative. Apart from this, also employable are powders of barium titanate as prepared according to an alkoxide method or a hydrothermal reaction method. If the latter powders are used, the characteristics of the capacitors may often be improved more than those of the samples as demonstrated in the Example herein.

Powders of scandium oxide, yttrium oxide, manganese oxide, nickel oxide and others were used in the Example, which, however, are not also limitative. Solutions of alkoxides or organic metal compounds for such oxides can also be employed, in place of such oxide powders, without interfering with the characteristics of the capacitors



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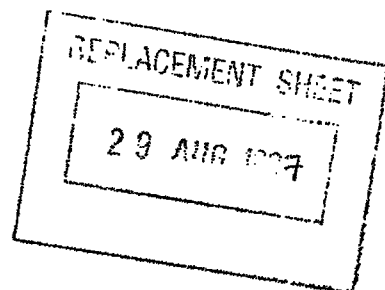
produced, provided that they are formulated to constitute the dielectric ceramic layers falling within the scope of the present invention.

In the monolithic ceramic capacitor of the present invention, the dielectric ceramic layers are made from a dielectric ceramic material that can be baked even in a reducing atmosphere without being reduced into semiconductors. Therefore, a base metal of nickel or a nickel alloy can be used as the material for the electrodes in the capacitor. In addition, since the dielectric ceramic material can be baked at relatively low temperatures of 1300°C or lower, the production costs of the capacitor can be reduced.

Moreover, the monolithic ceramic capacitor of the invention that comprises ceramic layers made from such dielectric ceramic materials has a dielectric constant of 3000 or higher, and the temperature-dependent variation in the high dielectric constant of the capacitor is small. Further, the capacitor has high insulation resistance and has good characteristics, and their characteristics are not worsened even in high-temperature and high-humidity conditions.

In addition, since the crystals constituting the dielectric layers are small to have grain sizes of 1 μm or smaller, the layers can be thinned well, without reducing

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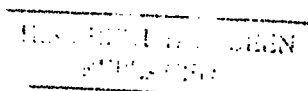


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the number of the crystals to be therein, being different from the ceramic layers constituting conventional monolithic ceramic capacitors. Therefore, according to the present invention, it is possible to obtain high-reliability, small-sized, large-capacity, monolithic ceramic capacitors.

While the invention has been described in detail and with reference to specific embodiments thereof, it will be apparent to one skilled in the art that various changes and modifications can be made therein without departing from the spirit and scope thereof.

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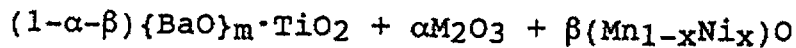


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WHAT IS CLAIMED IS:

1. A dielectric ceramic composition comprising:
barium titanate;
scandium oxide, yttrium oxide, manganese oxide and
nickel oxide,

magnesium oxide, as a side component, in an amount of
from 0.5 to 3.0 mols in terms of MgO, and silicon oxide in
an amount of from 0.2 to 5.0 mols in terms of SiO₂,
relative to 100 mols of the essential component having the
following compositional formula:



where M₂O₃ is at least one selected from Sc₂O₃ and
Y₂O₃; and

α , β , m and x are as follows:

$$0.0025 \leq \alpha \leq 0.020$$

$$0.0025 \leq \beta \leq 0.04$$

$$\beta/\alpha \leq 4$$

$$0 \leq x < 1.0$$

$$1.000 < m \leq 1.035.$$

2. The dielectric ceramic composition according to
claim 1, wherein said barium titanate having at least one
alkali metal oxide as an impurity.

3. The dielectric ceramic composition according to

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claim 2, wherein said barium titanate includes alkali metal oxide oxides of 0.02 % by weight or less.

4. The dielectric ceramic composition according to claim 2, wherein said alkali metal oxide includes at least one oxide selected from SrO , CaO , SiO_2 and Al_2O_3 .

5. A monolithic ceramic capacitor composed of;
a dielectric ceramic layers,

at least two inner electrodes as formed between the dielectric ceramic layers in such a manner that one end of each inner electrode is exposed out of either end of the dielectric ceramic layers, and

outer electrodes as electrically connected with the exposed inner electrodes,

the monolithic ceramic capacitor being characterized in that;

the dielectric ceramic layers each are made of a material comprising;

barium titanate;

scandium oxide, yttrium oxide, manganese oxide and nickel oxide;

magnesium oxide, as a side component, in an amount of from 0.5 to 3.0 mols in terms of MgO , and silicon oxide in an amount of from 0.2 to 5.0 mols in terms of SiO_2 ,

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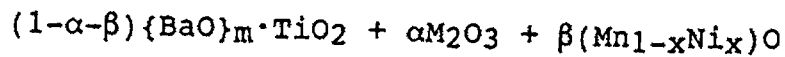


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relative to 100 mols of the essential component having the following compositional formula:



where M_2O_3 is at least one selected from Sc_2O_3 and Y_2O_3 ; and

α , β , m and x are as follows:

$$0.0025 \leq \alpha \leq 0.020$$

$$0.0025 \leq \beta \leq 0.04$$

$$\beta/\alpha \leq 4$$

$$0 \leq x < 1.0$$

$$1.000 < m \leq 1.035.$$

6. The monolithic ceramic capacitor according to claim 5, wherein said barium titanate having at least one alkali metal oxide as an impurity.

7. The monolithic ceramic capacitor according to claim 6, wherein said barium titanate includes alkali metal oxides of 0.02% by weight or less.

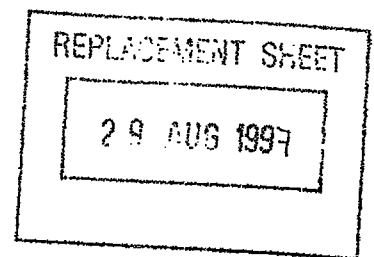
8. The dielectric ceramic capacitor according to claim 6, wherein said alkali metal oxide includes at least one oxide selected from SrO , CaO , SiO_2 and Al_2O_3 .

9. The monolithic ceramic capacitor according to

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claim 5, wherein at least one of said inner electrodes is made of at least one base metal.

10. The monolithic ceramic capacitor according to claim 9, wherein said base metal includes ceramic powder.

11. The monolithic ceramic capacitor according to claim 9, wherein said base metal is nickel or nickel alloy.

12. The monolithic ceramic capacitor according to claim 5, wherein at least one of said outer electrodes is made of a sintered layer of an electroconductive metal powder.

13. The monolithic ceramic capacitor according to claim 5, wherein at least one of said outer electrodes is made of an electroconductive metal powder with glass frit added thereto.

14. The monolithic ceramic capacitor according to claim 5, wherein the outer electrodes each comprising a first, sintered layer of an electroconductive metal powder or of an electroconductive metal powder with glass frit added thereto, and a second, plated layer formed on the first layer.

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DIELECTRIC CERAMIC COMPOSITION AND MONOLITHIC CERAMICCAPACITOR USING SAME

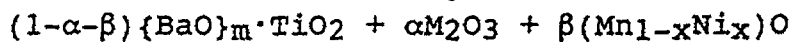
ABSTRACT

A dielectric ceramic composition and a monolithic ceramic capacitor using same are provided. The dielectric ceramic composition includes:

barium titanate;

scandium oxide, yttrium oxide, manganese oxide and nickel oxide,

magnesium oxide, as a side component, in an amount of from 0.5 to 3.0 mols in terms of MgO, and silicon oxide in an amount of from 0.2 to 5.0 mols in terms of SiO₂, relative to 100 mols of the essential component having the following compositional formula:



where M₂O₃ is at least one selected from Sc₂O₃ and Y₂O₃; and

α , β , m and x are as follows:

$$0.0025 \leq \alpha \leq 0.020$$

$$0.0025 \leq \beta \leq 0.04$$

$$\beta/\alpha \leq 4$$

$$0 \leq x < 1.0$$

$$1.000 < m \leq 1.035.$$

FIG. 1

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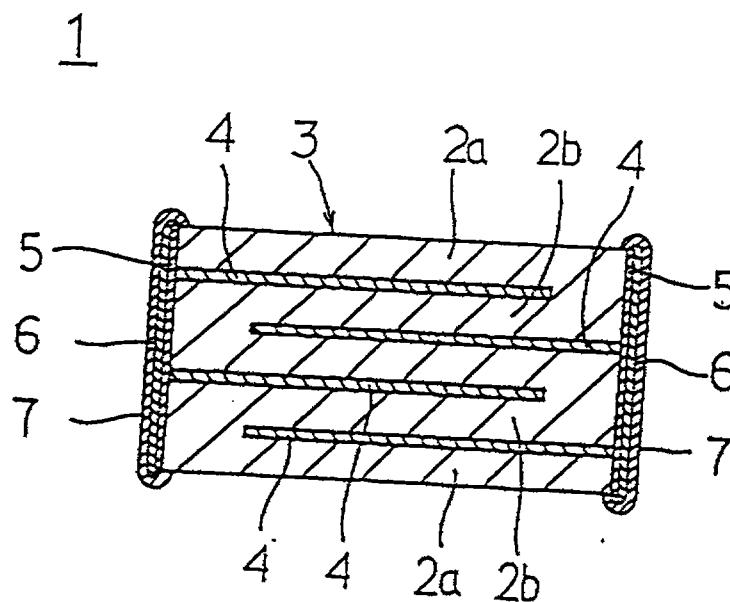


FIG. 1

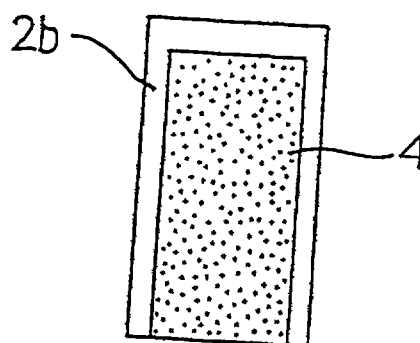


FIG. 2

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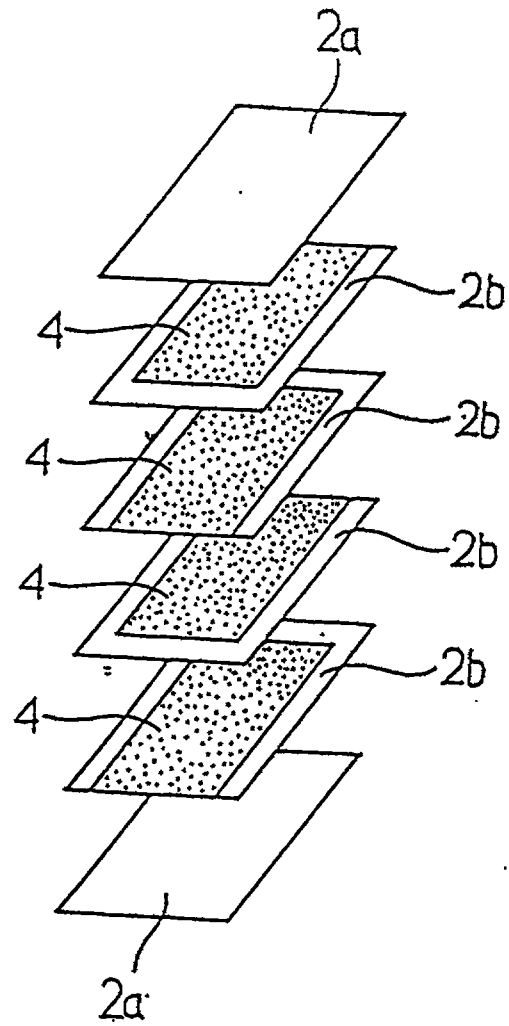


FIG. 3

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DIELECTRIC CERAMIC COMPOSITION AND
MONOLITHIC CERAMIC CAPACITOR USING SAME

FIELD OF THE INVENTION

5 The present invention relates to a dielectric ceramic composition and a monolithic ceramic capacitor to be used in electronic instruments, especially those having inner electrodes made of nickel or nickel alloys.

BACKGROUND OF THE INVENTION

10 Monolithic ceramic capacitors are generally produced as follows.

First, sheets of dielectric ceramic layers coated with an electrode material intended to be an inner electrode are prepared. For example, the dielectric ceramic layers may consist essentially of BaTiO_3 . Next, 15 a plurality of such sheets of dielectric ceramic layers each coated with the electrode material are laminated and integrated under heat and pressure, and the resulting laminate is baked at from 1250°C to 1350°C to obtain a monolithic dielectric ceramic body having inner 20 electrodes therein. To the both ends of the dielectric ceramic body, outer electrodes that electrically communicate with the inner electrode are fixed and baked. Thus is obtained a monolithic ceramic capacitor.

25 Accordingly, the materials for such inner electrodes must satisfy the following requirements.

1. Since the ceramic laminate and the inner electrodes are baked together, the melting point of the materials for the inner electrodes must be not lower than

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the temperature at which the ceramic laminate will be baked.

2. The materials for the inner electrodes must not be oxidized even in high-temperature, oxidizing atmospheres and must not react with the dielectric ceramic layers.

As electrodes that satisfy these requirements, noble metals, such as platinum, gold, palladium and silver-palladium alloys, have heretofore been used. However, these electrode materials are expensive, although having excellent characteristics. Accordingly, the cost of the electrode material reaches from 30 to 70% of the total cost of each monolithic ceramic capacitor, which therefore is an essential factor of increasing the production costs of conventional monolithic ceramic capacitors.

Also known are base metals, such as Ni, Fe, Co, W and Mo, which have a high melting point. However, such base metals are easily oxidized in high-temperature, oxidizing atmospheres and lose their ability to function as electrodes. Therefore, if such base metals are used as the inner electrodes in monolithic ceramic capacitors, they must be baked along with the dielectric ceramic layers in neutral or reducing atmospheres. However, conventional dielectric ceramic materials are defective in that if they are baked in such neutral or reducing atmospheres, they are greatly reduced into semiconductors.

In order to overcome these drawbacks, for example, proposed were a dielectric ceramic material comprising a solid solution of barium titanate where the ratio of barium sites/titanium sites is greater than the stoichiometric ratio thereof, such as that disclosed in

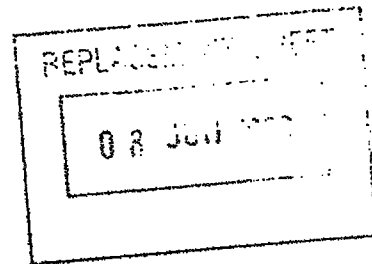
Japanese Patent Publication No. 57-42588; and a dielectric ceramic material comprising a solid solution of barium titanate and containing oxides of rare earth metals, such as La, Nd, Sm, Dy and Y, added thereto, such as that disclosed in Japanese Patent Application Laid-Open No. 61-101459.

Also proposed were a dielectric ceramic material having a composition of $\text{BaTiO}_3\text{-CaZrO}_3\text{-MnO-MgO}$, such as that disclosed in Japanese Patent Application Laid-Open No. 62-256422; and a dielectric ceramic material having a composition of $\text{BaTiO}_3\text{-(Mg, Zn, Sr, Ca)O-B}_2\text{O}_3\text{-SiO}_2$, such as that disclosed in Japanese Patent Publication No. 61-14611.

Using these dielectric ceramic materials, ceramic laminates were obtained which are not converted into semiconductors even when baked in reducing atmospheres. As a result, it has become possible to produce monolithic ceramic capacitors comprising inner electrodes of base metals such as nickel.

With the recent development in electronics, small-sized electronic parts have become required greatly in the art, and small-sized, large-capacity, monolithic ceramic capacitors are therefore greatly required for use therein. For these reasons, the recent tendency in the art is rapidly toward dielectric ceramic materials having a higher dielectric constant and toward thinner dielectric layers. Accordingly, there is now a great demand for dielectric ceramic materials with high reliability having a high dielectric constant, in which the temperature-dependent variation is small.

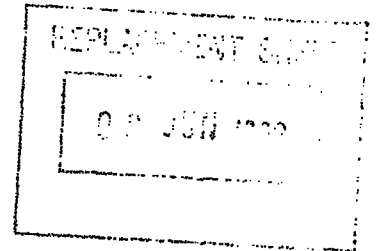
However, the dielectric ceramic materials disclosed in Japanese Patent Publication No. 57-42588 and Japanese Patent Application Laid-Open No. 61-101459 are



defective in that the crystals constituting the ceramic laminates made from the materials are large, though the ceramic laminates themselves may have a high dielectric constant, with the result that if thin dielectric ceramic layers having a thickness of, for example, 10 μm or less are incorporated into monolithic ceramic capacitors, the number of ceramic crystals in each layer is reduced and therefore the reliability of the monolithic ceramic capacitors is lowered. In addition, the dielectric ceramic materials were further defective in that the temperature-dependent variation in the dielectric constant of the dielectric ceramics is great. For these reasons, the conventional dielectric ceramic materials could not meet the requirements of the market.

On the other hand, the dielectric ceramic material disclosed in Japanese Patent Application Laid-Open No. 62-256422 was defective in that CaZrO_3 , and also CaTiO_3 , that are formed during the baking step may often form secondary phases together with Mn and others and therefore the high-temperature reliability of the capacitor comprising the material is problematic, although the dielectric constant of the ceramic body of the material is relatively high, the crystals constituting the ceramic laminate are small, and the temperature-dependent variation in the dielectric constant is small.

The dielectric ceramic material disclosed in Japanese Patent Publication No. 61-14611 was defective in that the dielectric constant of the ceramic body of the material is from 2000 to 2800 and therefore the material is not suitable for small-sized, large-capacity monolithic ceramic capacitors. In addition, the material was further defective in that it does not satisfy the



capacitance characteristic standard as stipulated in the EIA Standard, which indicates that the temperature-dependent variation in the capacitance within the range between -55°C and +125°C shall be +/- 15 % or less.

5 Japanese Patent Application Laid-Open No. 63-103861 discloses a non-reducing dielectric ceramic material which, however, was defective in that its insulating resistance and the temperature-dependent variation in capacity are greatly influenced by the grain
10 size of the crystals of BaTiO₃, which is the essential component constituting the material and therefore the material is difficult to control so as to obtain stable characteristics. In addition, for the insulating resistance of the material, the product of the insulating
15 resistance value and the capacitance value (product CR) falls between 1000 and 2000 (Ω.F). In view of this, the material is not practicable.

Although some improvements were made in the non-reducing dielectric ceramic compositions that have
20 heretofore been proposed in the art, such as those mentioned hereinabove, to make them have good insulation resistance in high-temperature load life tests, the improvement in their insulation resistance in moisture-resistant load tests is still unsatisfactory.

25 In order to solve the above-mentioned problems, proposed were different compositions, for example, in Japanese Patent Application Laid-Open Nos. 05-9066, 05-9067 and 05-9068. However, these compositions still could not satisfy the recent severe requirements for
30 small-sized, large-capacity capacitors in the market. Specifically, the recent requirements for these in the market are to make them have much thinner dielectric ceramic layers and higher reliability. Therefore, there

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is still a great demand for dielectric ceramic materials capable of producing much thinner dielectric ceramic layers in monolithic ceramic capacitors with much higher reliability. Given the situation, accordingly, it has
5 become necessary to provide small-sized, large-capacity, high-reliability monolithic ceramic capacitors which still have highly-reliable characteristics even in high-temperature and high-humidity conditions.

SUMMARY OF THE INVENTION

10 Accordingly, the subject matter of the present invention is to provide a low-priced, small-sized, large-capacity, monolithic ceramic capacitor, which has a dielectric constant of 3000 or more, which has a high insulation resistance, when measured at room temperature
15 and 125°C, of 6000 MΩ·μF or more, in terms of its product with the capacitance (the product CR), which has temperature-dependent capacitance that satisfies the B-level characteristic standard as stipulated in the JIS Standard and the X7R-level characteristic standard as
20 stipulated in the EIA Standard, and which has good weather resistance even in high-temperature and high-humidity load conditions.

The present invention has been made in consideration of the above-mentioned object.

25 Specifically, the present invention provides a monolithic ceramic capacitor composed of a plurality of dielectric ceramic layers, a plurality of inner electrodes formed between the dielectric ceramic layers in such a manner that one end of each inner electrode is
30 exposed out of an end of the dielectric ceramic layers, and outer electrodes electrically connected with the exposed inner electrodes, which is characterized in that

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the dielectric ceramic layers are made of a material comprising barium titanate having a content of alkali metal oxide impurities of about 0.02 % by weight or less, and scandium oxide, yttrium oxide, manganese oxide and nickel oxide; and containing as side components, magnesium oxide in an amount of from about 0.5 to 3.0 mols in terms of MgO, and silicon oxide in an amount of from about 0.2 to 5.0 mols in terms of SiO₂, relative to 100 mols of the essential component having the following compositional formula:



where M₂O₃ is at least one selected from Sc₂O₃ and Y₂O₃; and

α , β , m and x are as follows:

$$0.0025 \leq \alpha \leq 0.020$$

$$0.0025 \leq \beta \leq 0.04$$

$$\beta/\alpha \leq 4$$

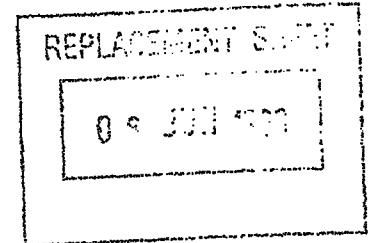
$$0 \leq x < 1.0$$

$$1.000 < m \leq 1.035; \text{ and}$$

the inner electrodes each are made of nickel or a nickel alloy.

Preferably, the barium titanate has a content of alkali metal oxide impurities of about 0.012 % by weight or less, magnesium oxide in an amount of from about 1 to 20 mols in terms of MgO, and silicon oxide in an amount of from about 1 to 2.5 mols in terms of SiO₂, relative to 100 mols of the essential component, $0.003 \leq \alpha \leq 0.012$, $0.005 \leq \beta \leq 0.024$, $\beta/\alpha \leq 2$, $0.1 \leq x < 0.8$, $1.005 < m \leq 1.015$.

Preferably, the outer electrodes in the monolithic ceramic capacitor of the present invention, are made of a sintered layer of an electroconductive metal powder with glass frit added thereto. Further



preferably, the outer electrodes each are composed of a first sintered layer of an electroconductive metal powder with glass frit added thereto, and a second plated layer formed on the first layer.

5 BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a cross-sectional view illustrating the outline of one embodiment of the monolithic ceramic capacitor of the present invention.

10 Fig. 2 is a plan view illustrating the outline of one embodiment of a dielectric ceramic layer having an inner electrode thereon, which is prepared in the present invention.

15 Fig. 3 is a perspective, exploded view illustrating one embodiment of a ceramic laminate as prepared in the present invention.

DETAILED DESCRIPTION OF THE INVENTION

Now, preferred modes of carrying out the invention are described in detail hereinunder.

20 As the material for the dielectric ceramic layers constituting the monolithic ceramic capacitor of the present invention, used herein is a dielectric ceramic material comprising at least one oxide selected from scandium oxide and yttrium oxide, and also manganese oxide and nickel oxide, in the specifically conditioned
25 compositional ratio mentioned hereinabove, and containing magnesium oxide and silicon oxide within the range defined hereinabove. Therefore, even in a reducing atmosphere, the dielectric ceramic material can be baked well without worsening its characteristics. As a result,
30 according to the present invention, it is possible to obtain a high-reliability, monolithic ceramic capacitor

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having a temperature-dependent capacitance that satisfies the B-level characteristic standard as stipulated in the JIS Standard and also the X7R-level characteristic standard as stipulated in the EIA Standard, and having high insulation resistance at room temperature and even at high temperatures.

In addition, since the crystal grains existing in the sintered dielectric ceramics constituting the capacitor of the invention are small, or that is, not larger than about 1 μm , the number of the crystal grains in each dielectric ceramic layer may be increased. Accordingly, even if the dielectric layers are thinned, the reliability of the capacitor comprising such thin dielectric layers is not lowered.

It has been confirmed that of the essential components constituting the dielectric ceramic material for use in the present invention, such as barium titanate, at least one oxide selected from scandium oxide and yttrium oxide, and also manganese oxide and nickel oxide, the content of the impurities in the barium titanate, such as alkaline earth metal oxides, e.g., SrO and CaO ; alkali metal oxides, e.g., Na_2O and K_2O ; and other oxides, e.g., Al_2O_3 and SiO_2 , especially that of alkali metal oxides such as Na_2O and K_2O , has a great influence on the electric characteristics of the capacitor of the invention. Specifically, it has been confirmed that if barium titanate having an alkali metal oxide impurity content of smaller than about 0.02 % by weight is in the dielectric ceramic material, the capacitor of the invention comprising the dielectric ceramic may have a dielectric constant of 3000 or higher.

The reason why silicon oxide is added to the dielectric ceramic layers in the present invention is

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that said addition improves the sinterability of the layers if the sintering atmosphere is controlled to have an oxygen partial pressure near to the equilibrated oxygen partial pressure of Ni/NiO at relatively high
5 temperatures during the sintering step, while also improving the moisture-resistant load characteristics of the capacitors comprising the layers.

If the dielectric ceramic material mentioned hereinabove is used to form the dielectric ceramic layers
10 constituting the monolithic ceramic capacitor of the invention, it is possible to use base metals, nickel or nickel alloys to form the inner electrodes of the capacitor. In addition, it is also possible to add to the inner electrodes a ceramic additive comprising the
15 same compositional material as that for the ceramic layers and containing a small amount of other oxides.

The composition of the outer electrodes of the capacitor of the invention is not specifically limited. Concretely, for example, the outer electrodes may be made
20 of sintered layers comprising various electroconductive powders, such as Ag, Pd, Ag-Pd, Cu or Cu alloys, and various types of glass frit, such as of B_2O_3 - Li_2O - SiO_2 -BaO, B_2O_3 - SiO_2 -BaO, Li_2O - SiO_2 -BaO or the like. More preferably, the sintered layers are coated with a plate layer. The
25 plate layer may comprise Ni, Cu or the like, and may be further coated with any additional plate layer of solder, tin or the like.

Now, the present invention is described in more detail with reference to the following Examples, which,
30 however, are not intended to restrict the scope of the invention.

Fig. 1 is a cross-sectional view illustrating the outline of one embodiment of the monolithic ceramic

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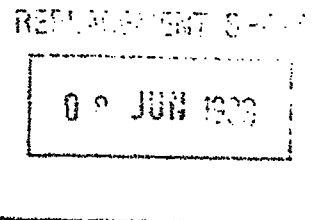
capacitor of the invention. Fig. 2 is a plan view illustrating the outline of the dielectric ceramic layer having an inner electrode thereon, which is in this embodiment. Fig. 3 is a perspective, exploded view illustrating the ceramic laminate to be in this embodiment.

In Fig. 1, the monolithic ceramic capacitor 1 of the present invention is in the form of a rectangular parallelepiped chip, in which the outer electrodes 5 constitute first plate layers 6 made of nickel, copper or the like, and second plate layers 7 made of solder, tin or the like formed on the both sides of the ceramic laminate 3 formed through lamination of a plurality of dielectric ceramic layers 2a and 2b with inner electrodes 4 therebetween.

Now, a method for producing the monolithic ceramic capacitor 1 of the invention is described below in the order of the steps constituting the method.

First, the ceramic laminate 3 is formed. This ceramic laminate 3 is produced as seen. As in Fig. 2. A raw material powder comprising barium titanate; at least one oxide selected from scandium oxide and yttrium oxide; manganese oxide, nickel oxide, magnesium oxide; and oxides consisting essentially of silicon oxide is formed into a slurry, and then sheeted to prepare a dielectric ceramic layer 2b (green sheet). On one surface of the green sheet, formed is an internal electrode 4 of nickel or a nickel alloy. To form the internal electrode 4, employable is any method of screen printing, metal vapor deposition or plating.

A predetermined number of the dielectric ceramic layers 2b each with the inner electrode 4 formed thereon are laminated, and then sandwiched between two



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dielectric ceramic layers 2a not having the inner electrode 4, as seen in Fig. 3, and these are integrated under pressure to give a laminate. Next, the resulting laminate composed of the dielectric ceramic layers 2a, 2b, . . . 2b, 2a is baked in a reducing atmosphere at a predetermined temperature to obtain the ceramic laminate 3.

Next, on the both sides of the ceramic laminate 3, formed are two outer electrodes 5 that are connected with the inner electrodes 4. The material of the outer electrodes 5 may be the same as that of the inner electrodes 4. Apart from this, silver, palladium, silver-palladium alloys, copper, copper alloys and others can be used as the material of the outer electrodes 5, to which can be added glass frit, such as glass of the type of B_2O_3 - SiO_2 - BaO or Li_2O - SiO_2 - BaO . In consideration of the use of the monolithic ceramic capacitor of the invention and the site at which the capacitor is used, suitable materials are selected for the outer electrodes 5. The outer electrodes 5 can be formed by applying an electroconductive paste material of metal powder onto the baked ceramic laminate 3 followed by baking. Alternatively, the paste material can be applied onto the non-baked ceramic laminate 3, and the combination is baked all at a time. After this, the outer electrodes 5 may be plated with nickel, copper or the like to form a first plate layer 6 thereon. Last, the first plate layer 6 is coated with a second plate layer 7 of solder, tin or the like. Thus is produced the chip-type, monolithic ceramic capacitor 1 of the invention.

The following Example is to further illustrate the invention in more detail.

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First, raw materials of TiCl_4 and $\text{Ba}(\text{NO}_3)_2$ having various degrees of purity were prepared and weighed. These were treated with oxalic acid to obtain a precipitate of barium titanyl oxalate ($\text{BaTiO}(\text{C}_2\text{O}_4)4\text{H}_2\text{O}$).

5 This precipitate was decomposed under heat at 1000°C or higher to obtain four types of barium titanate (BaTiO_3) as shown in Table 1.

Next, prepared were Sc_2O_3 , Y_2O_3 , MnO , NiO and MgO each having a purity of 99 % or more, and a colloidal
10 silica containing silicon dioxide in an amount of 20 % by weight in terms of SiO_2 .

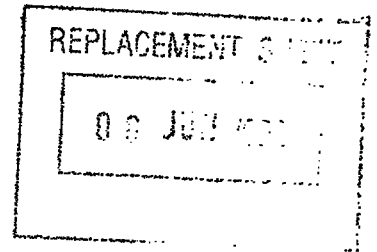
TABLE 1

Type of BaTiO_3	Content of Impurities (wt. %)					Mean Grain Size (μm)
	Alkali Metal Oxides	SrO	CaO	SiO_2	Al_2O_3	
<u>A</u>	0.003	0.012	0.001	0.010	0.005	0.60
<u>B</u>	0.020	0.010	0.003	0.019	0.008	0.56
<u>C</u>	0.012	0.179	0.018	0.155	0.071	0.72
<u>D</u>	0.062	0.014	0.001	0.019	0.004	0.58

Samples with * are outside the invention.

Next, these raw materials were mixed in various compositional ratios as shown in Table 2 to prepare various compositions. Each composition was wet-milled in
25 a ball mill, and evaporated to dryness to obtain a powdery raw material mixture.

The resulting mixture was wet-milled in a ball mill along with a polyvinyl butyral binder and an organic solvent such as ethanol to obtain a ceramic slurry. This
30 ceramic slurry was doctor blade sheeted to obtain a rectangular green sheet having a thickness of 11 μm .



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Next, an electroconductive paste consisting essentially of Ni was printed on this ceramic green sheet to form thereon an electroconductive paste layer, which is formed into an inner electrode.

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TABLE 2

Samples with * are outside the invention.

Sample No.	$(1-\alpha-\beta)(\text{BaO}) \cdot \text{TiO}_2 + \alpha \text{MgO} + \beta (\text{Mn}_{1-x}\text{Ni}_x)\text{O}$											
	Type of BaTiO ₃	α				β		x	β/α	m	MgO (mol)	SiO ₂ (mol)
		Y ₂ O ₃	Sc ₂ O ₃		Total							
* 1	A	-	-		0.0000	0.0005	0.3	-		1.010	1.20	1.00
* 2	A	0.010			0.0100	0.0000	-	0		1.010	1.20	1.00
* 3	A	0.010	0.002		0.0120	0.0005	0.3	5/12		0.990	1.20	1.00
* 4	A	0.012			0.0120	0.0005	0.3	5/12		1.000	1.00	1.00
* 5	A	0.0080			0.0080	0.0100	0.3	1		1.010	0.00	1.00
* 6	A	0.0100			0.0100	0.0100	0.3	1		1.015	1.20	0.00
* 7	A	0.0075			0.0075	0.0075	0.5	1		1.015	1.50	0.10
8	A	0.0025			0.0025	0.0025	0.1	1		1.005	0.50	0.20
9	A	0.0050	0.0050		0.0100	0.0080	0.5	4/5		1.010	1.00	1.00
10	A	0.0080	0.0040		0.0120	0.0080	0.0	2/3		1.010	1.50	1.50
11	A	0.0090			0.0090	0.0090	0.4	1		1.015	1.20	1.50
12	A	0.0080			0.0080	0.0080	0.3	1		1.010	1.20	1.00
13	C	0.0015	0.0050		0.0200	0.0400	0.8	2		1.005	1.00	2.00
14	B	0.0030			0.0030	0.0060	0.4	2		1.010	3.00	5.00
15	A	0.0080	0.0020		0.0100	0.0050	0.0	1/2		1.010	1.00	1.50
16	A	0.0060			0.0060	0.0240	0.6	4		1.035	0.50	2.50
17	A	0.010	0.010		0.0200	0.0050	0.1	1/4		1.015	2.00	1.50

$-x$ Ni $_x$ O	MgO	SiO $_2$
----------------	-----	----------

[illegible]

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5 A plurality of these ceramic green sheets each having the electroconductive paste layer formed thereon were laminated in such a manner that the side of one sheet with the electroconductive paste exposed out of it was alternated with then side of another sheet with the electroconductive paste not exposed out of it. Thus was obtained a laminate. This laminate was heated in an N_2 atmosphere at 350°C whereby the binder was burnt out, and then baked for 2 hours in a reducing atmosphere comprising gases of H_2 , N_2 and H_2O and having an oxygen partial pressure of from 10^{-11} to 10^{-8} MPa, at various temperatures shown in Table 3, to obtain sintered ceramic bodies.

15 The surface of each sintered ceramic body was observed with a scanning electronic microscope at a magnification of 1500 times to determine the grain sizes of the grains seen in the field of view.

20 A silver paste containing glass frit of the type of B_2O_3 - Li_2O - SiO_2 - BaO was applied onto the both sides of each sintered ceramic body, and baked again in an N_2 atmosphere at 600°C to thereby form outer electrodes electrically connected with the inner electrodes.

25 The outer dimension of each of these monolithic capacitors thus obtained was 1.6 mm width x 3.2 mm length x 1.2 mm thickness, and the thickness of each dielectric ceramic layer as sandwiched between the inner electrodes was 8 μm .

30 The total number of the effective dielectric ceramic layers was 19, and the area of the facing electrodes per ceramic layer was 2.1 mm^2 .

02 JUN 1973

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5 The capacitance (C) and the dielectric loss ($\tan \delta$) of each sample were measured using an automatic bridge-type meter at a frequency of 1 KHz, at 1 V rms and 25°C. From the capacitance thus measured, obtained was the dielectric constant (ϵ) through calculation. Next, to measure the insulation resistance (R) of each sample, a direct current voltage of 16 V was applied to each sample at 25°C for 2 minutes, using an insulation resistance meter. After having thus measured the
10 insulation resistance (R) of each sample, the product of the capacitance (C) and the insulation resistance (R) or, that is, the product CR of each sample was obtained. In addition, the temperature-dependent variation in the capacitance of each sample was
15 determined.

For the temperature-dependent variation in the capacitance, obtained were the variation in the capacitance between -25°C and 85°C based on the capacitance at 20°C ($\Delta C/C_{20^\circ\text{C}}$), the variation in the
20 capacitance between -55°C and 125°C based on the capacitance at 25°C ($\Delta C/C_{25^\circ\text{C}}$), and the maximum variation, in terms of the absolute value, between -55°C and 125°C ($|\Delta C|_{\text{max}}$).

To determine the high-temperature load life of
25 each sample, 36 pieces of each sample were subjected to a high-temperature load test in which a direct current voltage of 100 V was applied to each piece at 150°C, while measuring the insulation resistance of each test piece which varied time-dependently. In this test, the
30 period of time within which the insulation resistance

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5 value (R) of each piece being tested reached $10^6 \Omega$ or lower was measured, which is referred to as the life time of each test piece. The average of all the tested pieces was calculated to obtain the average life time of each sample.

10 In addition, to measure the moisture-resistant load life of each sample, 72 pieces of each sample were subjected to a high-humidity load test, in which a direct current voltage of 16 V was applied to each piece at 121°C under 2 atmospheres (relative humidity: 100 %), while measuring the insulation resistance of each test piece which varied time-dependently. In this test, the number of the test pieces that had an insulation resistance value (R) of $10^6 \Omega$ or lower
15 within a period of 250 hours was counted. The results obtained in these tests are shown in Table 3.

TABLE 3

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Samples with * are outside the invention.

Sample No.	Baking Temperature (°C)	Dielectric Constant, ϵ'	Dielectric Loss, $\tan \delta$ (%)	Temperature-Dependent Variation in Capacitance, $\Delta C/C_{20^\circ C}$ (%)	Temperature-Dependent Variation in Capacitance, $\Delta C/C_{25^\circ C}$ (%)	Product of CR ($\Omega \cdot F$), at 25°C	Mean Life Time (hr.)	Number of Test Pieces Failed in Moisture-Resistant Load Test	Grain Size (μm)
* 1	1300	3090	2.3	-25°C -12.1	-55°C -16.3	max 16.3	16V	7	0.77
* 2	1280			-4.5	2.2		8200		2.6
* 3	1280			As semiconductors were formed, the measurement was impossible.					
* 4	1280	3290	2.1	-3.1	-5.4	-5.3	2250	201	2.1
* 5	1280	3380	2.0	0.5	-10.7	-17.0	4700	300	0.73
* 6	1360			As the sample was sintered insufficiently, the measurement was impossible.					
* 7	1330	3220	1.9	-2.7	-5.1	-3.0	4200	307	0.61
* 8	1300	4050	2.4	-8.1	-6.5	-12.3	7140	311	0.68
* 9	1280	3290	1.8	-2.5	-5.2	-8.6	6380	489	0.72
* 10	1300	3100	1.7	-2.7	-4.9	-5.1	6170	497	0.68
* 11	1280	3510	2.1	-1.7	-6.2	-2.0	6820	530	0.69
* 12	1280	3590	2.2	-1.2	-7.7	-9.9	6760	512	0.71
* 13	1300	3020	1.7	-2.0	-5.1	-5.2	6010	589	0.72
* 14	1260	3470	2.0	-4.0	-6.7	-5.3	7220	311	0.78
* 15	1280	3310	1.9	-2.0	-5.8	-6.6	6190	509	0.64
* 16	1300	3370	1.9	-1.0	-8.8	-11.6	6630	307	0.69
* 17	1300	3000	1.4	-1.9	-4.5	-4.2	6040	567	0.68
* 18	1360	2120	1.2	2.1	2.4	3.0	3690	202	0.68
* 19	1280	3080	1.8	0.1	-9.8	0.2	5420	104	0.65
* 20	1300	3550	2.2	-1.3	-6.6	-7.3	2760	282	0.70
* 21	1300	3630	2.3	-1.5	-11.0	-17.7	6650	192	0.71
* 22	1360			As the sample was sintered insufficiently, the measurement was impossible.					
* 23	1360	2350	1.5	-2.3	-3.3	-2.9	6080	332	0.72
* 24	1200	1950	1.2	-1.3	-2.5	-2.0	3620	399	0.61
* 25	1280	2640	1.7	-2.1	-1.9	-3.3	6250	501	0.66

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As is obvious from Table 1, Table 2 and Table 3, the monolithic ceramic capacitor samples falling within the scope of the present invention all were found to have a high dielectric constant of not lower than 3,000, and have a dielectric loss tangent, $\tan \delta$, of not larger than 2.5%, while satisfying the B-level characteristic standard stipulated in the JIS Standard within the temperature range between -25°C and 85°C and also the X7R-level characteristic standard stipulated in the EIA Standard within the temperature range between -55°C and 125°C with respect to the temperature-dependent variation in the capacitance.

Moreover, these samples of the invention were found to have high insulation resistance values when measured at 25°C , of not smaller than $6,000 \text{ M}\Omega \cdot \mu\text{F}$, in terms of the product CR. Further, these were found to have a long mean life time of not shorter than 300 hours, and none of these failed in the moisture-resistant load test.

In addition, these were sintered at relatively low temperatures of not higher than 1300°C , and the crystal grains in the sintered samples were small having grain sizes of not larger than $1 \mu\text{m}$. Since the crystal grains existing in the dielectric ceramic layers in these samples are small, or that is, not larger than about $1 \mu\text{m}$, the number of the crystal grains in each dielectric ceramic layer is large. Accordingly, even if the ceramic laminate comprising these layers is thinned, the reliability of the capacitor comprising the laminate is not lowered.

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Now, the reasons for defining the compositions for use in the present invention are mentioned below.

First, referred to are the reasons for defining α to fall within the range of $0.0025 \leq \alpha \leq 0.020$ in the composition of $(1-\alpha-\beta)\{\text{BaO}\}_m \cdot \text{TiO}_2 + \alpha\text{M}_2\text{O}_3 + \beta(\text{Mn}_{1-x}\text{Ni}_x)\text{O}$, in which M_2O_3 is at least one selected from Sc_2O_3 and Y_2O_3 . As shown in Sample No. 1, if the amount, α , of M_2O_3 is smaller than about 0.0025, the temperature-dependent variation in the capacitance is great, and the mean life time is very short.

On the other hand, as in Sample No. 18, if the amount, α , of M_2O_3 is larger than about 0.020, the dielectric constant is not larger than 3,000, the insulation resistance at 25°C and 125°C is low, the mean life time is short, some test pieces failed in the moisture-resistant load test, and the sintering temperature is high.

The reasons for defining β to fall within the range of $0.0025 \leq \beta \leq 0.04$ are as follows. As seen in Sample No. 2, if the amount, β , of $(\text{Mn},\text{Ni})\text{O}$ is smaller than about 0.0025, the dielectric ceramics were reduced into semiconductors when baked in the reducing atmosphere, to thereby lower the insulation resistance.

As seen in Sample No. 19, if the amount, β , of $(\text{Mn},\text{Ni})\text{O}$ is larger than about 0.04, the insulation resistance at 25°C is lower than 6,000 $\text{M}\Omega \cdot \mu\text{F}$, and the mean life time is shorter than 300 hours.

The reasons for defining β/α to fall within the range of $\beta/\alpha \leq 4$ are as follows. As noted in Sample No. 21, if the ratio, β/α , of the amount β of $(\text{Mn},\text{Ni})\text{O}$

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to the amount α of M_2O_3 is larger than about 4, the temperature-dependent variation in the capacitance is large, and the mean life time is shorter than 300 hours.

5 The reasons for defining m to fall within the range of $1.000 < m \leq 1.035$ are as follows. As shown in Sample Nos. 3 and 4, if the molar ratio, m , of barium titanate is not larger than about 1.000, the dielectric ceramic was converted into semiconductors when baked in
10 the reducing atmosphere, whereby the insulation resistance of the capacitor was lowered (Sample No. 3); or the insulation resistance of the capacitor was lowered and the mean life time thereof was short so that the dielectric ceramic could not be used in
15 preparing thin ceramic laminates (Sample No. 4).

On the other hand, as shown in Sample No. 22, if the molar ratio, m , is larger than about 1.035, the sinterability of the sample is very poor.

20 The reasons for defining the magnesium oxide content to fall between about 0.5 moles and about 3.0 mols in terms of MgO are as follows. As noted in Sample No. 5, if the amount of MgO is smaller than about 0.5 mols, the insulation resistance is low and the temperature-dependent variation in the capacitance
25 could not satisfy the X7R-level characteristic standard of the EIA standard although satisfying the B-level characteristic standard of the JIS Standard.

30 On the other hand, as noted in Sample No. 23, if the amount of MgO is larger than about 3.0 mols, the sintering temperature is too high, the dielectric

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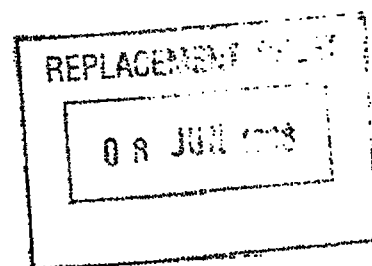
constant could not be over 3,000, and many tests pieces of the sample failed in the moisture-resistant load test.

5 The reasons for defining the silicon oxide content to fall between about 0.2 mols and 5.0 mols in terms of SiO_2 are as follows. As seen in Sample No. 6, if the SiO_2 content is 0 (zero), the sample could not be sintered. As seen in Sample No. 7, if the SiO_2 content is smaller than about 0.2 mols, the sintering
10 temperature is too high, the insulation resistance is low, and many test pieces of the sample failed in the moisture-resistant load test.

On the other hand, as seen in Sample No. 24, if the SiO_2 content is larger than about 5.0 mols, the
15 dielectric constant could not be over 3000 and the insulation resistance at 25°C could be not over 6,000 $\text{M}\Omega \cdot \mu\text{F}$.

The reasons for defining the alkali metal oxide content impurity of barium titanate to be not larger
20 than about 0.02 % by weight are as follows. As noted in Sample No. 25, if the impurity, alkali metal oxide content of barium titanate is larger than about 0.02 % by weight, the dielectric constant is lowered.

In the above-mentioned Example, used was a powder
25 of barium titanate prepared according to the oxalic acid method, which, however, is not limitative. Apart from this, also employable are powders of barium titanate as prepared according to the alkoxide method or hydrothermal reaction method. If the latter powders
30 are used, the characteristics of the capacitors may



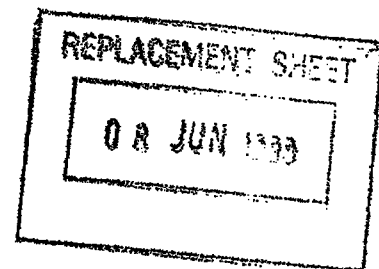
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often by improved more than those of the samples as demonstrated in the Example herein.

5 Powders of scandium oxide, yttrium oxide, manganese oxide, nickel oxide and others were used in the Example, which, however, are not also limitative. Solutions of alkoxides or organic metal compounds for such oxides can also be employed, in place of such oxide powders, without interfering with the characteristics of the capacitors produced, provided
10 that they are formulated to constitute the dielectric ceramic layers falling within the scope of the present invention.

15 In the monolithic ceramic capacitor of the present invention, the dielectric ceramic layers are made from a dielectric ceramic material that can be baked even in a reducing atmosphere without being reduced into semiconductors. Therefore, a base metal of nickel or a nickel alloy can be used as the material for the electrodes in the capacitor. In addition, since the
20 dielectric ceramic material can be baked at relatively low temperatures of 1300°C or lower, the production costs of the capacitor can be reduced.

25 Moreover, the monolithic ceramic capacitor of the invention that comprises ceramic layers made from such dielectric ceramic materials has a dielectric constant of 3000 or higher, and the temperature-dependent variation in the high dielectric constant of the capacitor is small. Further, the capacitor has high insulation resistance and has good characteristics, and



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their characteristics are not worsened even in high-temperature and high-humidity conditions.

5 In addition, since the crystals constituting the dielectric layers are small, having grain sizes of 1 μ m or smaller, the layers can be thinned well, without reducing the number of the crystals therein, being different from the ceramic layers constituting conventional monolithic ceramic capacitors. Therefore,
10 according to the present invention, it is possible to obtain high-reliability, small-sized, large-capacity, monolithic ceramic capacitors.

15 While the invention has been described in detail and with reference to specific embodiments thereof, it will be apparent to one skilled in the art that various changes and modifications can be made therein without departing from the spirit and scope thereof.

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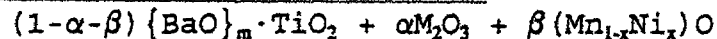
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WHAT IS CLAIMED IS:

1. A dielectric ceramic composition comprising:
a main component of barium titanate, scandium oxide, yttrium oxide, manganese oxide and nickel oxide having the compositional formula:



where M_2O_3 is at least one member selected from the group consisting of Sc_2O_3 and Y_2O_3 , and

α , β , m and x are as follows:

$$0.0025 \leq \alpha \leq 0.020$$

$$0.0025 \leq \beta \leq 0.04$$

$$\beta/\alpha \leq 4$$

$$0 \leq x < 1$$

$$1.000 < m \leq 1.035;$$

magnesium oxide in an amount of from about 0.5 to 3.0 mols in terms of MgO and silicon oxide in an amount of from about 0.2 to 5.0 mols in terms of SiO_2 , relative to 100 mols of the main component

2. The dielectric ceramic composition according to claim 1, wherein said barium titanate has an alkali metal oxide impurity content of about 0.02 % by weight or less.

3. The dielectric ceramic composition according to claim 2, wherein the barium titanate has a content of alkali metal oxide impurities of about 0.012 % by weight or less, the magnesium oxide is in an amount of

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from about 1 to 20 mols in terms of MgO, the silicon oxide is in an amount of from about 1 to 2.5 mols in terms of SiO₂, $0.003 \leq \alpha \leq 0.012$, $0.005 \leq \beta \leq 0.024$, $\beta/\alpha \leq 2$, $0.1 \leq x < 0.8$, $1.005 < m \leq 1.015$.

4. A monolithic ceramic capacitor composed of:
at least three dielectric ceramic layers,
at least two inner electrodes each disposed
between adjacent dielectric ceramic layers in such a
manner that one end of two inner electrode are exposed
at different ends of the dielectric ceramic layers, and
outer electrodes electrically connected with
the exposed inner electrodes,
the monolithic ceramic capacitor being
characterized in that each dielectric ceramic layer
comprises the composition of claim 1.

5. The monolithic ceramic capacitor according to
claim 4, wherein said barium titanate includes alkali
metal oxide impurity of about 0.02% by weight or less.

6. The dielectric ceramic capacitor according to
claim 5, wherein the barium titanate has a content of
alkali metal oxide impurities of about 0.012 % by
weight or less, the magnesium oxide is in an amount of
from about 1 to 20 mols in terms of MgO, the silicon
oxide is in an amount of from about 1 to 2.5 mols in
terms of SiO₂, $0.003 \leq \alpha \leq 0.012$, $0.005 \leq \beta \leq 0.024$,
 $\beta/\alpha \leq 2$, $0.1 \leq x < 0.8$, $1.005 < m \leq 1.015$.

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7. The monolithic ceramic capacitor according to claim 6, wherein at least one of said inner electrodes comprises at least one base metal.

8. The monolithic ceramic capacitor according to claim 7, wherein said base metal includes ceramic powder.

9. The monolithic ceramic capacitor according to claim 8, wherein said base metal is nickel or nickel alloy.

10. The monolithic ceramic capacitor according to claim 9, wherein at least one of said outer electrodes is a sintered layer of an electroconductive metal powder.

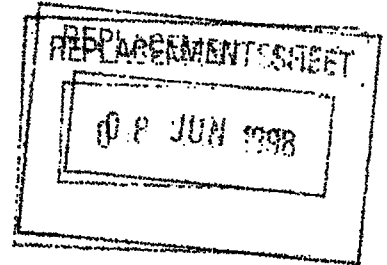
11. The monolithic ceramic capacitor according to claim 9, wherein at least one of said outer electrodes comprises electroconductive metal powder and glass frit.

12. The monolithic ceramic capacitor according to claim 9, wherein the outer electrodes each comprise a first sintered layer of an electroconductive metal powder or of an electroconductive metal powder with glass frit added thereto, and a second plated layer formed on the first layer.

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13. The monolithic ceramic capacitor according to claim 4, wherein at least one of said inner electrodes comprises at least one base metal.

14. The monolithic ceramic capacitor according to claim 13, wherein said base metal includes ceramic powder.

15. The monolithic ceramic capacitor according to claim 14, wherein said base metal is nickel or nickel alloy.

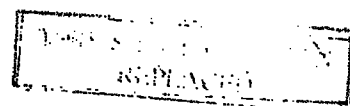
16. The monolithic ceramic capacitor according to claim 15, wherein the outer electrodes each comprise a first sintered layer of an electroconductive metal powder or of an electroconductive metal powder with glass frit added thereto, and a second plated layer formed on the first layer.

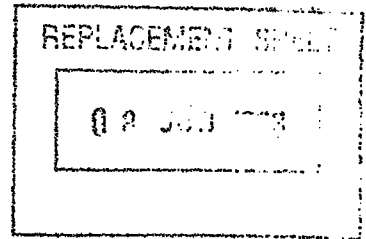
17. The monolithic ceramic capacitor according to claim 4, wherein at least one of said outer electrodes is a sintered layer of an electroconductive metal powder.

18. The monolithic ceramic capacitor according to claim 4, wherein at least one of said outer electrodes comprises electroconductive metal powder and glass frit.

19. The monolithic ceramic capacitor according to claim 4, wherein the outer electrodes each comprise a

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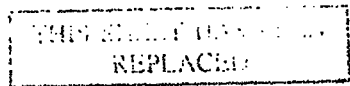
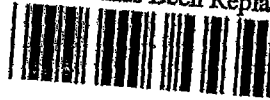




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first sintered layer of an electroconductive metal powder or of an electroconductive metal powder with glass frit added thereto, and a second plated layer formed on the first layer.

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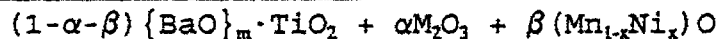
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DIELECTRIC CERAMIC COMPOSITION AND
MONOLITHIC CERAMIC CAPACITOR USING SAME

ABSTRACT OF THE DISCLOSURE

A dielectric ceramic composition and a monolithic ceramic capacitor using same are provided. The dielectric ceramic composition includes a main component of barium titanate, scandium oxide, yttrium oxide, manganese oxide and nickel oxide, having the compositional formula:



where M_2O_3 is at least one of Sc_2O_3 and Y_2O_3 ; $0.0025 \leq \alpha \leq 0.020$, $0.0025 \leq \beta \leq 0.04$, $\beta/\alpha \leq 4$, $0 \leq x < 1.0$, $1.000 < m \leq 1.035$, and

magnesium oxide in an amount of from about 0.5 to 3.0 mols in terms of MgO , and silicon oxide in an amount of from about 0.2 to 5.0 mols in terms of SiO_2 , relative to 100 mols of the main component.

Fig. 1

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WHAT IS CLAIMED IS:

1. A dielectric ceramic composition comprising:
a main component of barium titanate, scandium oxide, yttrium oxide, manganese oxide and nickel oxide having the compositional formula:



where M_2O_3 is at least one member selected from the group consisting of Sc_2O_3 and Y_2O_3 , and

α , β , m and x are as follows:

$$0.0025 \leq \alpha \leq 0.020$$

$$0.0025 \leq \beta \leq 0.04$$

$$\beta/\alpha \leq 4$$

$$0 \leq x < 1$$

$$1.000 < m \leq 1.035;$$

magnesium oxide in an amount of from about 0.5 to 3.0 mols in terms of MgO and silicon oxide in an amount of from about 0.2 to 5.0 mols in terms of SiO_2 , relative to 100 mols of the main component

2. The dielectric ceramic composition according to claim 1, wherein said barium titanate has an alkali metal oxide impurity content of about 0.02 % by weight or less.

3. The dielectric ceramic composition according to claim 2, wherein the barium titanate has a content of alkali metal oxide impurities of about 0.012 % by weight or less, the magnesium oxide is in an amount of



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from about 1 to 2 mols in terms of MgO, the silicon oxide is in an amount of from about 1 to 2.5 mols in terms of SiO₂, $0.003 \leq \alpha \leq 0.012$, $0.005 \leq \beta \leq 0.024$, $\beta/\alpha \leq 2$, $0.1 \leq x < 0.8$, $1.005 < m \leq 1.015$.

4. A monolithic ceramic capacitor composed of:
at least three dielectric ceramic layers,
at least two inner electrodes each disposed between adjacent dielectric ceramic layers in such a manner that one end of two inner electrode are exposed at different ends of the dielectric ceramic layers, and outer electrodes electrically connected with the exposed inner electrodes,
the monolithic ceramic capacitor being characterized in that each dielectric ceramic layer comprises the composition of claim 1.

5. The monolithic ceramic capacitor according to claim 4, wherein said barium titanate includes alkali metal oxide impurity of about 0.02% by weight or less.

6. The dielectric ceramic capacitor according to claim 5, wherein the barium titanate has a content of alkali metal oxide impurities of about 0.012 % by weight or less, the magnesium oxide is in an amount of from about 1 to 2 mols in terms of MgO, the silicon oxide is in an amount of from about 1 to 2.5 mols in terms of SiO₂, $0.003 \leq \alpha \leq 0.012$, $0.005 \leq \beta \leq 0.024$, $\beta/\alpha \leq 2$, $0.1 \leq x < 0.8$, $1.005 < m \leq 1.015$.



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7. The monolithic ceramic capacitor according to claim 6, wherein at least one of said inner electrodes comprises at least one base metal.

8. The monolithic ceramic capacitor according to claim 7, wherein said base metal includes ceramic powder.

9. The monolithic ceramic capacitor according to claim 8, wherein said base metal is nickel or nickel alloy.

10. The monolithic ceramic capacitor according to claim 9, wherein at least one of said outer electrodes is a sintered layer of an electroconductive metal powder.

11. The monolithic ceramic capacitor according to claim 9, wherein at least one of said outer electrodes comprises electroconductive metal powder and glass frit.

12. The monolithic ceramic capacitor according to claim 9, wherein the outer electrodes each comprise a first sintered layer of an electroconductive metal powder or of an electroconductive metal powder with glass frit added thereto, and a second plated layer formed on the first layer.

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13. The monolithic ceramic capacitor according to claim 4, wherein at least one of said inner electrodes comprises at least one base metal.

14. The monolithic ceramic capacitor according to claim 13, wherein said base metal includes ceramic powder.

15. The monolithic ceramic capacitor according to claim 14, wherein said base metal is nickel or nickel alloy.

16. The monolithic ceramic capacitor according to claim 15, wherein the outer electrodes each comprise a first sintered layer of an electroconductive metal powder or of an electroconductive metal powder with glass frit added thereto, and a second plated layer formed on the first layer.

17. The monolithic ceramic capacitor according to claim 4, wherein at least one of said outer electrodes is a sintered layer of an electroconductive metal powder.

18. The monolithic ceramic capacitor according to claim 4, wherein at least one of said outer electrodes comprises electroconductive metal powder and glass frit.

19. The monolithic ceramic capacitor according to claim 4, wherein the outer electrodes each comprise a



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first sintered layer of an electroconductive metal powder or of an electroconductive metal powder with glass frit added thereto, and a second plated layer formed on the first layer.