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# Low-loss phase modulation using a MoS<sub>2</sub> monolayer integrated on silicon waveguides

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**Keywords:** MoS<sub>2</sub>, phase modulator, integrated photonics, silicon photonics, CVD grown TMDC

Supplementary material for this article is available [online](#)

## Abstract

Two dimensional (2D) materials are at the forefront of research in integrated modulators. However, achieving pure phase modulation with low insertion loss remains challenging in 2D material modulators. This work explores phase modulators based on monolayer MoS<sub>2</sub> integrated on a Si photonic platform. We investigated the electro-optical response of MoS<sub>2</sub> using two device architectures: a monolayer MoS<sub>2</sub> integrated on a doped Si waveguide and a MoS<sub>2</sub>–Al<sub>2</sub>O<sub>3</sub>–MoS<sub>2</sub> capacitor integrated on an undoped Si waveguide. At a wavelength of 1550 nm, the integration of MoS<sub>2</sub> in both architectures induces minimal optical insertion losses. Specifically, the single-layer device on a doped silicon waveguide achieves a phase modulation efficiency of 0.53 V·cm, with propagation losses dominantly originating from the doped silicon (108 dB cm<sup>-1</sup>). The MoS<sub>2</sub>–Al<sub>2</sub>O<sub>3</sub>–MoS<sub>2</sub> modulator has a low propagation loss of 6.4 dB cm<sup>-1</sup> and modulation efficiency of 1 V·cm. Depending on the resistance–capacitance constant, a trade-off exists between achievable modulation efficiency, electro-optical bandwidth, and insertion loss. The strong and lossless electro-refractive response makes MoS<sub>2</sub>-based phase modulators suitable for a variety of applications such as light detection and ranging, optical switching, quantum and optical neural networks, and coherent optical communication.

## 1. Introduction

Two-dimensional (2D) materials have attracted significant interest in integrated photonics due to their superior optoelectronic properties, natural surface passivation, high wafer-scale integration, and compatibility with various photonic platforms. Notably, electro-absorption modulators (EAMs) and photo-detectors based on 2D materials have been successfully integrated onto silicon photonic platforms [1–4]. However, an area that remains largely unexplored is their potential for efficient phase modulation. Energy-efficient phase modulators are desired to encode information on an optical carrier for

coherent communication schemes (e.g. quadrature amplitude modulation), and to replace energy-inefficient thermal phase shifters in applications such as light detection and ranging (LiDAR), quantum photonics, optical neural networks [5–9].

Graphene has been experimentally demonstrated as a viable material for phase modulation [10, 11]. Due to the gapless Dirac-cone band structure and fast carrier dynamics, graphene-based modulators have achieved high-speed optical communication, with reported 3 dB bandwidths up to 35 GHz [12, 13]. However, a key challenge is that phase modulation in graphene is inherently accompanied by absorption modulation. To minimize the absorption

and thus insertion losses, the graphene modulator is required to operate at a high Fermi level, typically in the transparent region associated with Pauli blocking. However, the reduced mobility of graphene at high carrier concentrations may diminish the speed of the electro-optical response in graphene devices. In defective graphene grown by chemical vapor deposition (CVD), the strong intra-band scattering further increases the insertion loss when operating away from the neutrality point.

Recently, transition metal dichalcogenides (TMDCs), a family of 2D semiconducting materials, have demonstrated potential for efficient phase modulation with minimal optical loss [14, 15]. The most promising candidates are tungsten disulfide ( $\text{WS}_2$ ), tungsten diselenide ( $\text{WSe}_2$ ), and molybdenum disulfide ( $\text{MoS}_2$ ), owing to their tunability of refractive index, both near excitonic resonances and at near-infrared wavelengths. This strong electrorefractive effect has been extensively studied in  $\text{WS}_2$  and  $\text{WSe}_2$ . A  $\text{WS}_2$ -SiN platform has shown a large doping-induced phase over absorption change ( $\frac{\Delta n}{\Delta k}$ ) of 125. The corresponding Mach-Zehnder interferometer (MZI)-based modulator demonstrated a high modulation efficiency, defined by the voltage length requirement to achieve  $\pi$  phase shift ( $V_\pi L$ ), of  $0.8 \text{ V}\cdot\text{cm}$  [14]. Later, the same group demonstrated a hybrid  $\text{WSe}_2$  and graphene modulator integrated on a silicon nitride (SiN) ring resonator, which achieved a  $V_\pi L$  of  $0.53 \text{ V}\cdot\text{cm}$  and an electro-optical (EO) bandwidth of  $14.8 \text{ GHz}$  [15]. In contrast, research on  $\text{MoS}_2$ -based phase modulators is still in its early stages, with only one experimental report showing a  $V_\pi L$  of  $1.7 \text{ V}\cdot\text{cm}$  [14].  $\text{MoS}_2$  is an important member of the TMDC family, with a thickness-dependent bandgap of  $1.2\text{--}1.8 \text{ eV}$  and mobility in excess of  $200 \text{ cm}^2/\text{Vs}$ . The monolithic integration of  $\text{MoS}_2$  is advancing rapidly, positioning it as a leading material for applications in nanoelectronics, integrated photonics, 3D integration, electrical interconnects, and sensors [16–18]. As such, exploring  $\text{MoS}_2$  phase modulators holds significant scientific and practical potential for future technologies [14, 15].

In this work, we demonstrate  $\text{MoS}_2$ -based phase modulators integrated with silicon waveguides. Two distinct  $\text{MoS}_2$  device configurations are explored: (1)  $\text{MoS}_2$  on a doped silicon waveguide, enabling back-gating for electro-optical modulation, and (2) a double-layer  $\text{MoS}_2$  modulator on top of a silicon waveguide, used to reduce insertion loss while retaining a strong phase modulation response. The former device achieves a phase modulation efficiency of  $0.53 \text{ V}\cdot\text{cm}$  but with relatively high propagation losses of  $108 \text{ dB cm}^{-1}$  originating from the doped waveguide. The latter has a modulation efficiency of  $1 \text{ V}\cdot\text{cm}$  and a lower propagation loss of  $6.4 \text{ dB cm}^{-1}$ .

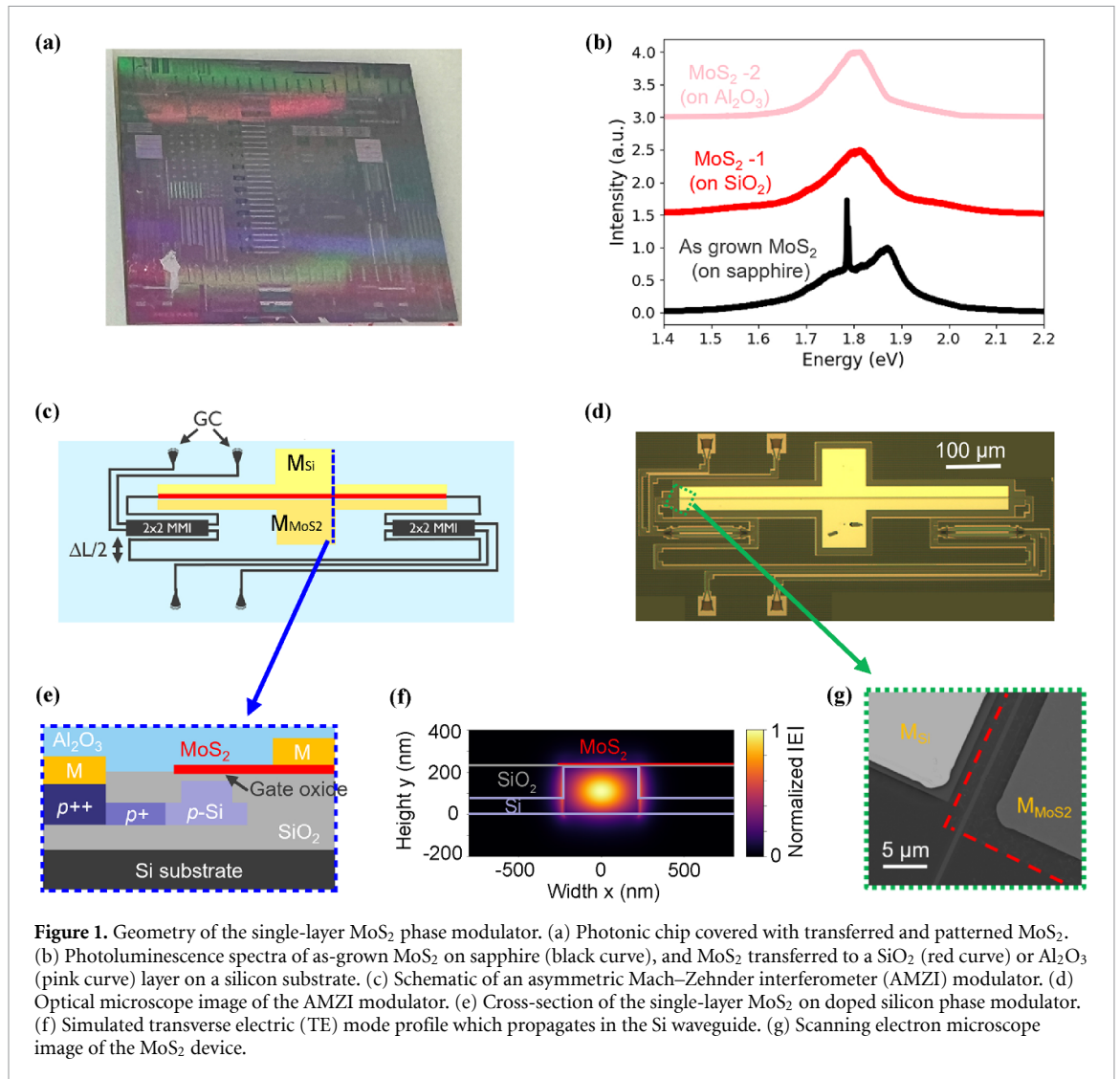
The tunable refractive index and low optical losses of our demonstrated  $\text{MoS}_2$  modulators pave the way for energy-efficient and effective optical phase modulators.

## 2. $\text{MoS}_2$ synthesis, transfer and characterization

The  $\text{MoS}_2$  used was grown on a 200 mm sapphire wafer using CVD [19–21]. Utilizing a semi-dry transfer method, the  $\text{MoS}_2$  was released from the sapphire substrate using thermal release tape immersed in water. After transferring it to the target substrate, the  $\text{MoS}_2$  was dried. The thermal release tape was then removed by heating the entire substrate, followed by a solvent bath process to eliminate any remaining polymer residues. The  $\text{MoS}_2$  was patterned into active channels for the waveguide-integrated modulators using e-beam lithography followed by a chlorine ( $\text{Cl}_2$ ) and oxygen ( $\text{O}_2$ ) dry etching process.

Figure 1(a) shows an optical microscope image of a photonic chip covered with patterned  $\text{MoS}_2$  nanosheets. Photoluminescence (PL) characterization confirms the successful integration of a monolayer of  $\text{MoS}_2$  on the target photonic chip. The well-pronounced PL signal confirms the monolayer nature of the CVD-grown  $\text{MoS}_2$  due to its band structure with a direct bandgap. In contrast, multilayer  $\text{MoS}_2$  has an indirect bandgap which cannot sustain efficient radiative recombination, resulting in significantly weaker PL signals [22]. In addition, the quality of the transferred  $\text{MoS}_2$  is also monitored by means of photoluminescence. As shown in figure 1(b), the as-grown  $\text{MoS}_2$  on the sapphire substrate exhibits PL peaks at  $1.87 \text{ eV}$  and  $1.78 \text{ eV}$ , corresponding to the monolayer  $\text{MoS}_2$  and sapphire, respectively. After transfer to the  $\text{SiO}_2$  or  $\text{Al}_2\text{O}_3$  film on a silicon substrate, the  $\text{MoS}_2$  PL peak red-shifts to  $1.81 \text{ eV}$  and  $1.80 \text{ eV}$ , respectively. This shift indicates the bandgap narrowing of the transferred  $\text{MoS}_2$ , which can be attributed to several factors such as selective doping, strain effects, the dielectric environment, and alteration of the surface quality [22, 23].

To characterize the phase-modulation properties of  $\text{MoS}_2$ -based devices, we integrated them into asymmetric Mach-Zehnder interferometric (AMZI) modulators. These modulators exhibit wavelength-dependent interference patterns, allowing for the evaluation of the electro-optical performance of the integrated  $\text{MoS}_2$  modulators. Two distinct types of  $\text{MoS}_2$  phase modulators were investigated: (1) a single-layer  $\text{MoS}_2$  modulator, in which a monolayer of  $\text{MoS}_2$  is integrated on a doped silicon waveguide coated with a  $5 \text{ nm}$  thick  $\text{SiO}_2$  gate, used for electro-optical modulation. (2) a double-layer  $\text{MoS}_2$



modulator, consisting of a MoS<sub>2</sub>-Al<sub>2</sub>O<sub>3</sub>-MoS<sub>2</sub> capacitor integrated on an undoped Si waveguide.

### 3. Single layer MoS<sub>2</sub> modulator

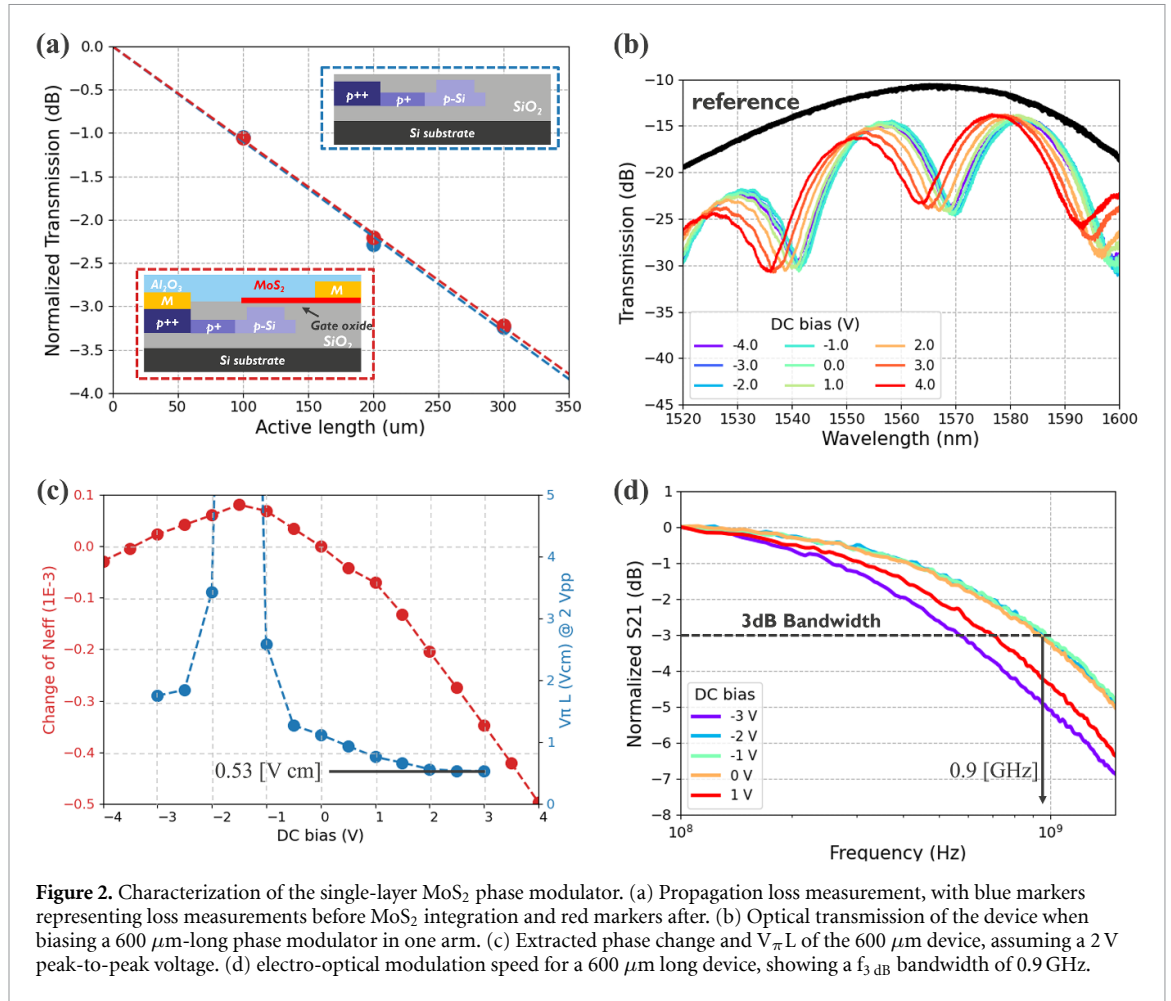
The single-layer MoS<sub>2</sub> (SL-MoS<sub>2</sub>) modulator is integrated into one arm of a 2 × 2 AMZI, shown in figures 1(c) and (d), while the other arm contains only a strip waveguide. Light is coupled to and from the AMZI using grating couplers, and multi-mode interferometers are used to split and recombine light between the arms of the AMZI. The AMZI interference fringes were designed to have a FSR of 30 nm as shown in figure 2(b).

A schematic cross-section of the SL-MoS<sub>2</sub> modulator is shown in figure 1(e) in which the doped silicon waveguide shown serves both as an optical waveguide and as an electrode to bias the MoS<sub>2</sub> layer. The waveguide has a thickness of 220 nm, a width of 480 nm, and has three increasing doping levels from the waveguide to the contact regions. This configuration optimizes the balance between contact

resistance, sheet resistance, and optical propagation losses. Figure 1(f) shows the transverse electric mode propagating in the Si waveguide, as simulated by Lumerical MODE. Its evanescent field overlaps with the monolayer MoS<sub>2</sub> when using a 5 nm-thick gate dielectric, which confirms the light-MoS<sub>2</sub> interaction for phase modulation. It should be noted only the 480 nm wide MoS<sub>2</sub> layer above the waveguide gets modulated through electro-static gating. The part of MoS<sub>2</sub> that gets modulated has a mode overlap of 0.14 %. Figure 1(g) presents a scanning electron microscope image of the fabricated devices showing the transferred MoS<sub>2</sub> layer, a waveguide, a gate oxide, and metal contacts.

#### 3.1. Fabrication of the SL-MoS<sub>2</sub> modulator

The optical circuit was defined on imec's 200 mm silicon photonics platform, consisting of a 220 nm thick silicon on a 2 μm thick oxide insulator layer [24]. To enable the electrical contact, the Si waveguide is partially etched, forming a rib structure with a 70 nm-thick Si slab layer. We employed a three-stage p-type



doping process resulting in a highly doped  $p^{++}$  for the contact region,  $p^+$  for the slab region, and  $p\text{-Si}$  at the waveguide core. Following waveguide patterning, chemical mechanical polishing was used to planarize the surface topology to a step variation below 5 nm. A 5 nm thick thermal oxide layer was grown to electrically isolate the MoS<sub>2</sub> from the Si waveguide. Metal contacts to the silicon and MoS<sub>2</sub> were fabricated using e-beam lithography and a metal lift-off process. The metal contact to the MoS<sub>2</sub> layer is composed of a 20 nm Pd on 10 nm Ni stack, while the silicon was contacted with a 30 nm Au on 20 nm Pt on 20 nm Ti metal stack. Before metallization, the thermal oxide layer in the silicon contact region is selectively removed via wet etching in buffered hydrofluoric acid. Finally, the whole chip is encapsulated by a 10 nm Al<sub>2</sub>O<sub>3</sub> layer grown by atomic layer deposition (ALD). Supplementary figure A1 provides a schematic of the process flow. The Al<sub>2</sub>O<sub>3</sub> layer not only acts as an encapsulation layer to protect the MoS<sub>2</sub>, but also influences carrier concentration in MoS<sub>2</sub> through selective doping [22]. Without the Al<sub>2</sub>O<sub>3</sub> encapsulation MoS<sub>2</sub> is highly depleted, leading to exhaustion of free carriers. As a result, MoS<sub>2</sub> exhibits high resistance as demonstrated by unstable capacitance

voltage measurements in the 1 kHz–1 MHz frequency range (supplementary figure A2). Doping of MoS<sub>2</sub> through the Al<sub>2</sub>O<sub>3</sub> layer resolves this issue, significantly improving the device's AC performance.

### 3.2. Characterization of the SL-MoS<sub>2</sub> modulator

Propagation loss measurements were conducted in the AMZI before and after MoS<sub>2</sub> integration, as shown in figure 2(a). Using the cut-back method, the fitted slope of the dashed lines represents the propagation loss, which are 109 dB cm<sup>-1</sup> and 108 dB cm<sup>-1</sup> prior to and after MoS<sub>2</sub> integration, respectively. Thus, the addition of the MoS<sub>2</sub> monolayer did not introduce measurable additional losses. The observed propagation losses are primarily attributed to the doped waveguide. The lowly doped  $p\text{-Si}$  region in the waveguide core, as described above and illustrated in the insets of figure 2(a), does not induce high propagation losses. In contrast, the  $p^+\text{-Si}$  in the slab region, with a higher carrier concentration and in close proximity (50 nm) to the waveguide core, is the main contributor to the losses due to strong light scattering. This attribute of losses could be mitigated through further optimization of the

waveguide doping strategy. Alternatively, the possible losses from the MoS<sub>2</sub> monolayer are expected to come from the absorption and scattering occurring at the grain boundaries, surface traps, edge defects and transfer-induced organic residues. The static phase modulation was evaluated by applying a DC voltage between the MoS<sub>2</sub> layer and a 600 μm long doped silicon waveguide, which is integrated into a single arm of an AMZI. The wavelength-dependent transmission of the AMZI under a bias range of −4 V to 4 V is shown in figure 2(b) which clearly shows interference fringes at the designed 30 nm free spectral range (FSR). The lack of change in extinction ratio confirms that biasing does not introduce additional optical losses. The observed shift in interference wavelength when applying a voltage indicates phase shifting. The effective refractive index, and consequently the  $V_{\pi}L$  (assuming a 2 V<sub>pp</sub> electrical signal), were extracted by tracking the shift in interference wavelength with the applied voltage, as shown in figure 2(c). The optimal result was achieved at a 2.5 V bias, resulting in a  $V_{\pi}L$  of 0.53 V·cm.

The EO modulation speed was characterized by measuring the frequency response of the device using a vector network analyzer, from which the 3 dB EO bandwidth was extracted. The modulation bandwidth varied depending on the carrier state of the p-doped silicon beneath the MoS<sub>2</sub> layer [25]. A 3 dB EO modulation speed of 0.91 GHz was measured at a bias of −1 V for a 600 μm long device, as shown in figure 2(d).

The modulation speed varies depending on DC bias, which aligns with the measured bias-dependent capacitance detailed in supplementary figure A2. Consequently, the device's EO bandwidth is limited by the resistance–capacitance (RC) time constant, influenced by the carrier concentration of the MoS<sub>2</sub> and the p-doped silicon beneath the MoS<sub>2</sub> layer. For a 600 μm long device, a 3 dB electro-optical modulation speed of 0.91 GHz was obtained at a bias of −1 V.

#### 4. Double layer MoS<sub>2</sub> modulator

In order to reduce optical losses, a double-layer MoS<sub>2</sub> (DL-MoS<sub>2</sub>) modulator was investigated. This device consists of a MoS<sub>2</sub>–Al<sub>2</sub>O<sub>3</sub>–MoS<sub>2</sub> capacitor structure, with a schematic cross-sectional shown in figure 3(a). Electro-static gating can be achieved by applying a bias between the two MoS<sub>2</sub> layers, eliminating the need for doped waveguides. This reduces optical losses and allows for potential integration on insulator-based platforms such as silicon nitride (SiN) and lithium niobate on insulator (LNOI) [26, 27]. Compared to double-layer graphene modulators, which suffer from high optical insertion losses (around 30 dB cm<sup>−1</sup>), our MoS<sub>2</sub>-based design reduces losses while maintaining a large phase modulation efficiency. However, since MoS<sub>2</sub> has a

lower mobility compared to graphene, the EO 3 dB bandwidth is expected to be lower [11].

The DL-MoS<sub>2</sub> modulator was integrated into an AMZI with a 34 μm imbalance, corresponding to a FSR of 10 nm. Figures 3(b) and (c) show a top-down micrograph and a schematic of the AMZI. The double-layer MoS<sub>2</sub> phase modulators with lengths up to 400 μm were integrated into both arms, allowing push-pull operation to further enhance modulation efficiency.

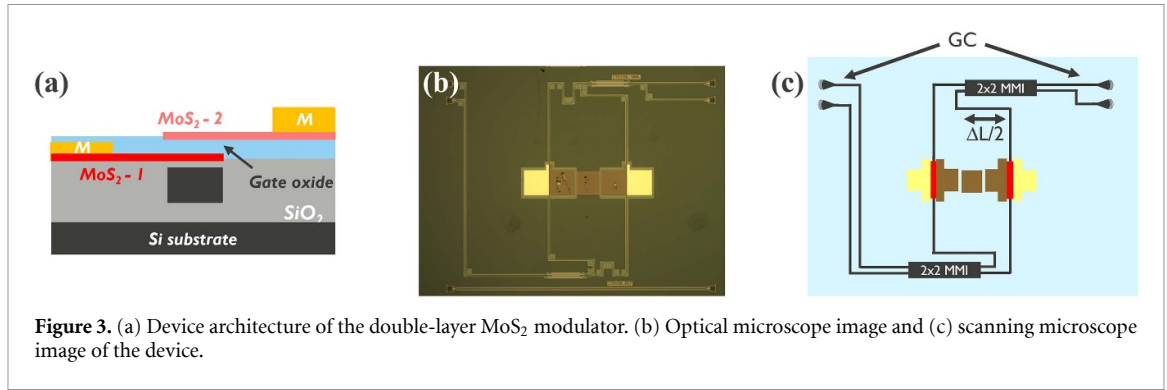
##### 4.1. Fabrication of double layer MoS<sub>2</sub> modulator

The schematic of the process flow of the DL-MoS<sub>2</sub> modulator is shown in supplementary figure A4. The AMZIs were fabricated on imec's 200 mm silicon photonics platform, as described before. Since the silicon waveguide no longer serves as a gate for the MoS<sub>2</sub> layers, fully etched 450 nm-wide waveguides were used in the MoS<sub>2</sub> phase modulation region. The MoS<sub>2</sub> layers were grown and patterned similarly to the single-layer MoS<sub>2</sub> process described in section 2. A 20 nm Pd on 10 nm Ni metal stack was used for electrical contacts. After transferring and defining the first MoS<sub>2</sub> layer, a 10 nm Al<sub>2</sub>O<sub>3</sub> gate dielectric was deposited using ALD. The second MoS<sub>2</sub> layer was then transferred and patterned, identically to the first layer. The region where both MoS<sub>2</sub> layers overlap have a width of 750 nm. In this modulated region the bottom MoS<sub>2</sub> layer has an optical mode overlap of 0.17% and the top 0.14%. The DL-MoS<sub>2</sub> device used in this experiment was not encapsulated.

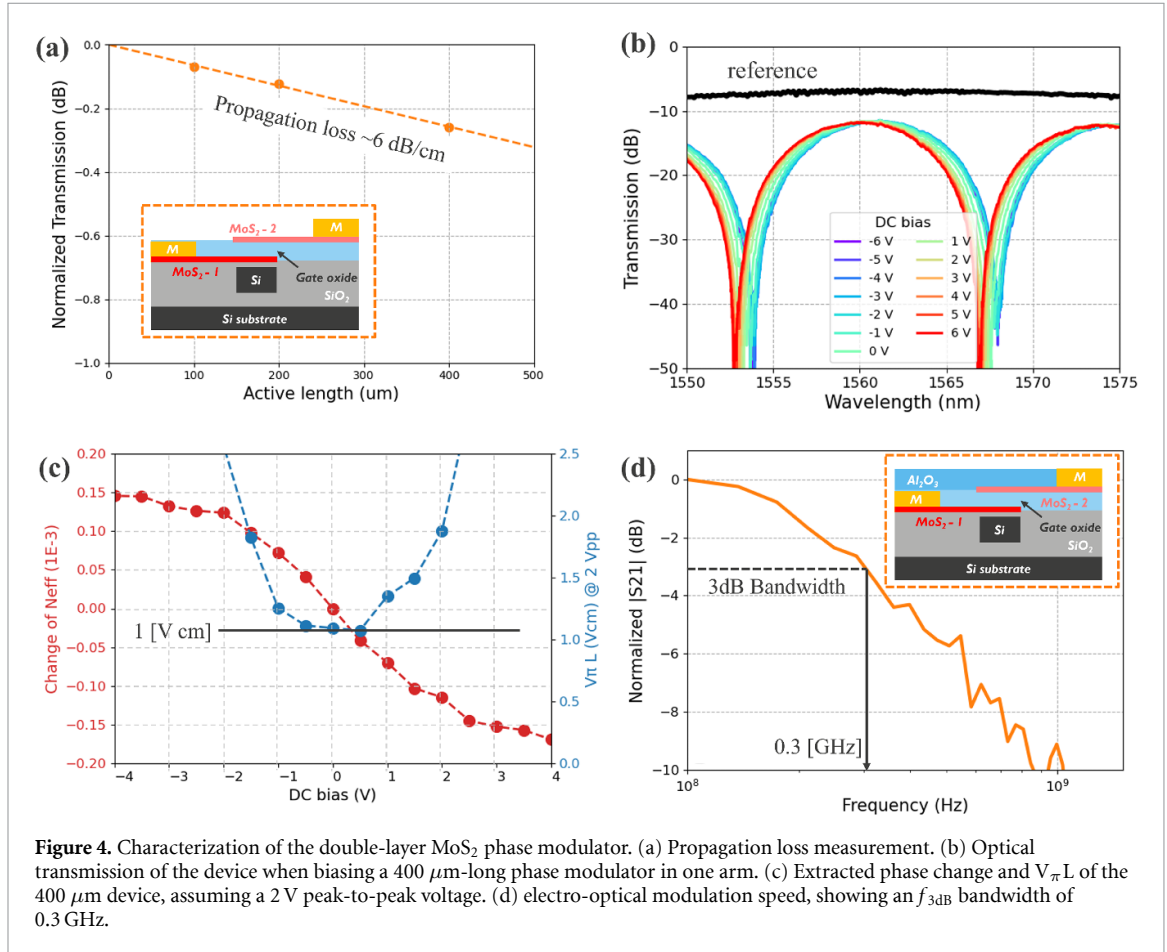
##### 4.2. Characterization of the double layer MoS<sub>2</sub> modulator

The DL-MoS<sub>2</sub> phase modulator exhibited a propagation loss of 6 dB cm<sup>−1</sup>, which was measured by comparing the transmission of the AMZI structures with varying active lengths (figure 4). This propagation loss is a significant improvement over the SL-MoS<sub>2</sub> modulator (6 dB cm<sup>−1</sup> vs. 108 dB cm<sup>−1</sup>) as the DL-MoS<sub>2</sub> device eliminates the loss induced by doped silicon waveguides. In addition to the possible loss from MoS<sub>2</sub>, the propagation loss in the DL-MoS<sub>2</sub> modulator also originates from the 10 nm Al<sub>2</sub>O<sub>3</sub> gate dielectric.

The phase shift was determined by applying a DC voltage between the two MoS<sub>2</sub> layers of a 400 μm long modulator while keeping the modulator in the other arm shorted. The transmission for various DC voltages, shown in figure 4(b), shows a clear shift in interference wavelength with minimal change in extinction ratio. From these measurements, the change in effective index was extracted for a 2 V peak-to-peak signal from which the  $V_{\pi}L$  was calculated, as shown in figure 4(c). From these calculations an optimal  $V_{\pi}L$  of 1 V·cm was found. The modulation efficiency of the DL-MoS<sub>2</sub> device (0.53 V·cm) is lower than that of the SL-MoS<sub>2</sub> device (1 V·cm), which can



**Figure 3.** (a) Device architecture of the double-layer MoS<sub>2</sub> modulator. (b) Optical microscope image and (c) scanning microscope image of the device.



**Figure 4.** Characterization of the double-layer MoS<sub>2</sub> phase modulator. (a) Propagation loss measurement. (b) Optical transmission of the device when biasing a 400  $\mu\text{m}$ -long phase modulator in one arm. (c) Extracted phase change and  $V_{\pi}L$  of the 400  $\mu\text{m}$  device, assuming a 2 V peak-to-peak voltage. (d) electro-optical modulation speed, showing an  $f_{3\text{dB}}$  bandwidth of 0.3 GHz.

be attributed to its thicker gate oxide. To evaluate the device property as an efficient phase shifter with low loss, we introduce a phase modulation figure of merit ( $\text{FoM}_{\text{PM}}$ ), defined as  $\text{FoM}_{\text{PM}} = \alpha V_{\pi}L$ , where  $\alpha$  is the insertion loss. The DL-MoS<sub>2</sub> device achieved an optimal  $\text{FoM}_{\text{PM}}$  of 6.2 dBV, outperforming the SL-MoS<sub>2</sub> modulator ( $\text{FoM}_{\text{PM}} = 57.0$  dBV) and even Si-based MZI modulators, which typically have an  $\text{FoM}_{\text{PM}}$  in the range of 15 dBV to 22 dBV [28].

The electro-optical response of a 200  $\mu\text{m}$ -long DL-MoS<sub>2</sub> device (figure 4(d)) revealed a  $f_{3\text{dB}}$  bandwidth of 0.3 GHz. S-parameter analysis in supplementary figure A4 estimated a capacitance of 436 fF

and a resistance of 677  $\Omega$ , yielding an RC bandwidth of 0.5 GHz, in agreement with experimental data. This electro-optical speed is lower than that of the doped silicon waveguide (0.91 GHz), primarily due to the higher resistance of the MoS<sub>2</sub> gate compared to the doped silicon waveguide.

## 5. Discussion on MoS<sub>2</sub> based phase modulators

In this work, we demonstrated phase modulators based on MoS<sub>2</sub>, exhibiting low propagation losses ( $6 \text{ dB cm}^{-1}$ ) and a strong modulation efficiency (as

**Table 1.** Comparison of phase modulators integrated on a silicon platform.

MZM (references)	oxide thickness (nm)	Loss (dB cm <sup>-1</sup> )	V <sub>π</sub> L (V cm)	FOM <sub>PM</sub> (dBV)	Bandwidth (GHz)
Si PIN junction [28]	—	28	2	56	37
Si-oxide-graphene [12]	10	236	0.28	66.1	5
Graphene-oxide-graphene [11]	10	289	0.0954	27.6	4.2
WS <sub>2</sub> -oxide-ITO [14]	—	135	0.8	108	0.33
G-O-WSe <sub>2</sub> [15]	45	—	1.08	—	14.9
SL-MoS <sub>2</sub> (this work)	5	100	0.57	57.0	0.91
DL-MoS <sub>2</sub> (this work)	9.5	6.4	0.97	6	0.3

low as 0.53 V·cm), exceeding the performance of other MZI-based phase modulators used on silicon platforms (table 1). Targeting at applications requiring CMOS compatible voltages, we prioritize modulation efficiency over modulation speed. To maximize modulation efficiency, we used a thin gate oxide (5 nm for SL-MoS<sub>2</sub> and 10 nm for DL-MoS<sub>2</sub>), ensuring strong electrostatic gating at the cost of increased capacitance (0.3–0.8 μF cm<sup>-2</sup>). The large capacitance, combined with the inherent high resistivity of MoS<sub>2</sub>, limits the EO bandwidth to below 1 GHz. The high modulation efficiency and low optical losses of these devices are advantageous for applications such as LiDAR, laser Doppler vibrometers, optical neural networks, and quantum networks. Additionally, the demonstrated MoS<sub>2</sub> devices are energy-efficient alternatives to thermal phase shifters, which are widely used in optical switches, phased arrays, and tunable lasers.

For certain applications, such as phase modulators used in high-speed coherent communication systems, faster EO modulation speeds tend to be required than that demonstrated by the phase modulators in this work. The EO modulation speed in the MoS<sub>2</sub> modulator can be increased by reducing the capacitance, which can be achieved by increasing the gate oxide thickness which reduces the gate capacitance. As a trade-off, with an increase in gate oxide thickness the modulation efficiency would decrease meaning a higher voltage or longer modulator would be required to reach the same level of phase tuning. An alternative approach is to reduce the device resistance which can be achieved by reducing MoS<sub>2</sub> sheet or contact resistance, or by using an alternative material for gating with a higher conductivity. One recent example of achieving larger EO modulation speeds is a demonstration using a graphene-oxide-WeS<sub>2</sub> modulator which has a 45 nm thick Al<sub>2</sub>O<sub>3</sub> gate dielectric to reduce capacitance, and uses a graphene gate to lower device resistance [15]. While this demonstration shows a significant improvement in modulation speed (14.9 GHz at a wavelength of 1646 nm), the modulation efficiency was low with a V<sub>π/2</sub> of 18 V, despite being integrated in a ring resonator with a 20k Q-factor. These required modulating voltages are

not CMOS compatible and would require dedicated modulator drivers which come at the cost of increased system complexity and higher power consumption from the driver IC. Furthermore the higher propagation losses arising from the graphene layer results in a total insertion loss of 3.18 dB. Ultimately, the choice of design depends on the application-specific trade-offs between required EO bandwidth, insertion loss, and modulation efficiency or driving voltage requirements.

In addition to the demonstrated capability and flexibility of individual MoS<sub>2</sub> modulators, our study also implies their high potential for scalable photonic integration. The MoS<sub>2</sub> used in the phase modulators was initially grown by CVD on 200 mm sapphire wafers, followed by a semi-dry transfer onto the targeted optical chip. Notably, this semi-dry transfer method has been successfully applied to integrate graphene onto optical waveguides, particularly for EAMs [11]. However, the submersion of the substrate in liquid could lead to unwanted variation in performance of transition metal dichalcogenide based devices, which could be avoided by harnessing dry transfer techniques [29]. These wafer-scale processing demonstrates the feasibility of wafer-scale, CMOS-compatible MoS<sub>2</sub> integration. The ever-growing advances in the MoS<sub>2</sub> growth and transfer methods provide improved channel crystallinity, interface cleanness and device reliability, suggesting a promising path forward for scalable 2D material integration in photonics [18, 30, 31]. Furthermore, ensuring wafer-scale performance and yield also relies on the development of quick and non-destructive characterization techniques over large areas, another critical requirement to realize the promise of 2D materials in integrated photonics [11, 29]. In addition, the stability limitation of MoS<sub>2</sub>-based devices has come into focus, particularly when exposed to air and moisture. This issue is mainly caused by oxide defects at the MoS<sub>2</sub>/oxide interface, creating charge trapping centres that lead to unwanted hysteresis under gate bias, performance instability and device degradation [32]. Addressing this bottleneck demands optimization of the ALD deposition and encapsulation techniques.

## 6. Conclusion

This research demonstrates the use of MoS<sub>2</sub> as a promising material for phase modulation on Si photonic waveguides. We explored both SL-MoS<sub>2</sub> and DL-MoS<sub>2</sub> phase modulators integrated in asymmetric MZIs. The electro-optic performance of these modulators is competitive with alternative phase modulators integrated on silicon photonic platforms. The integration of MoS<sub>2</sub> induces minimal losses to the photonic circuit at a wavelength around 1550 nm. The SL-MoS<sub>2</sub> modulator achieves a phase modulation efficiency of 0.53 V·cm with propagation losses primarily originating from the doped silicon (108 dB cm<sup>-1</sup>). The DL-MoS<sub>2</sub> modulator exhibits a modulation efficiency of 1 V·cm with low propagation losses (6.4 dB cm<sup>-1</sup>). The devices presented in this paper have oxide thicknesses of less than 10 nm, ensuring a high phase modulation efficiency and EO modulation speeds up to 0.9 GHz. The trade-off between achievable modulation efficiency and EO modulation speed was discussed, highlighting the balance required for different applications. This work contributes to the expanding field of two-dimensional materials-based photonics, demonstrating MoS<sub>2</sub> as a potential material for use in future optical devices and applications.

## Data availability statement

All data that support the findings of this study are included within the article (and any supplementary files).

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## Conflicts of interest

The authors declare no conflicts of interest.

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