LCWS2024 International Workshop on Future Linear Colliders

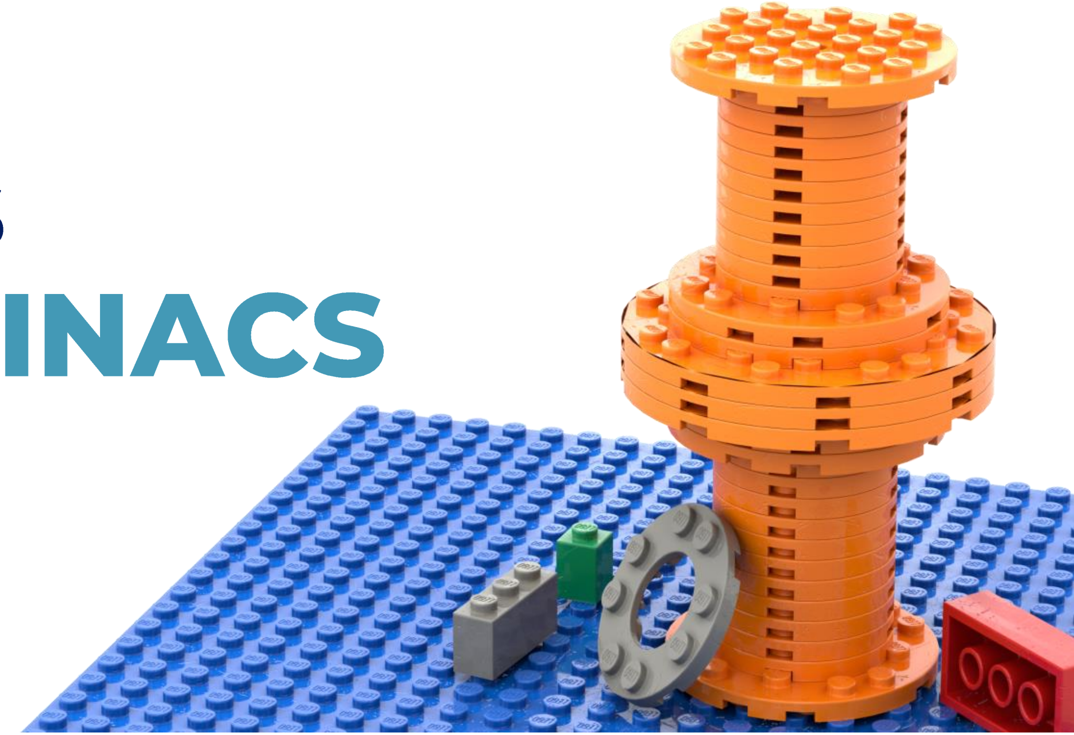
July 8–11, 2024
The University of Tokyo, Japan

Work supported by INFN CSN5 experiment SAMARA and INFN CSN1 experiments SRF and RD_FCC

This project has received funding from the European Union's Horizon-INFRA-2023-TECH-01 under GA No 101131435 – iSAS and from the European Union's Horizon 2020 Research and Innovation programme under GA No 101004730 – I.FAST

INFN LNL Cristian **Pira**

Nb_3Sn on Cu thin film SRF cavities for new generation LINACS operating at 4.5 K



Key word: sustainability

European Union

United Nations

Save energy

Reduce resources consumption and waste production

Clean and green procedures

Nb_3Sn motivation

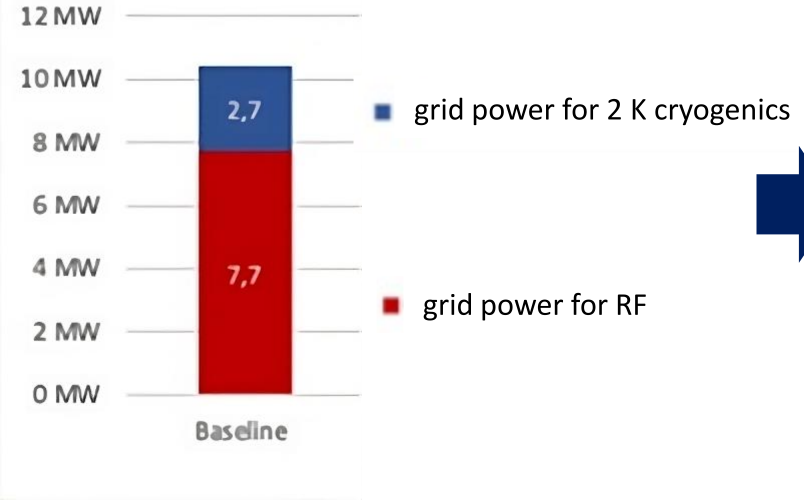
Energy saving *is mandatory for the* ***next generation accelerators***

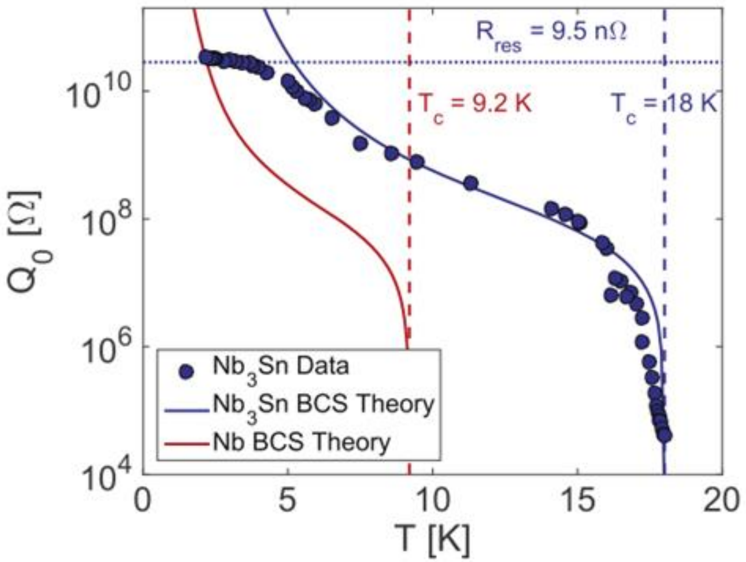
Cryogenics *is one of the* ***larger energy cost*** *in modern SRF accelerators*

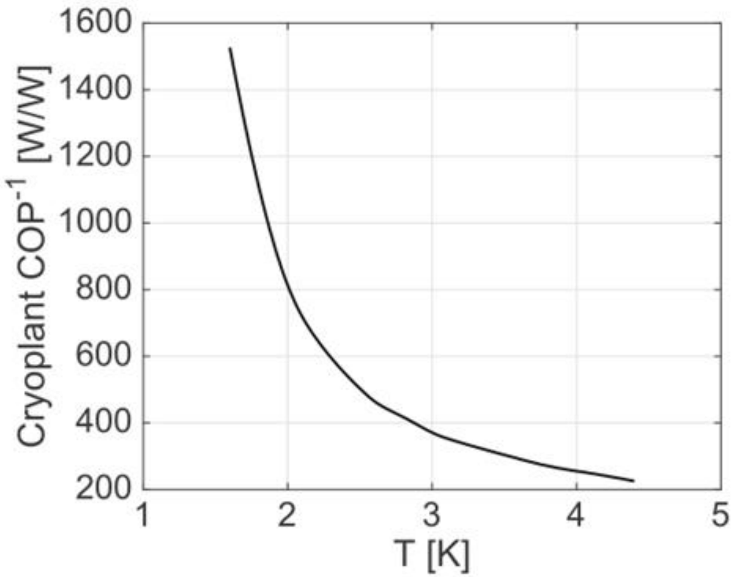
Move from bulk Nb @2K to Nb_3Sn @4.5 K

reduces cryogenic power by a factor of 3

7.5 GeV LINAC new construction





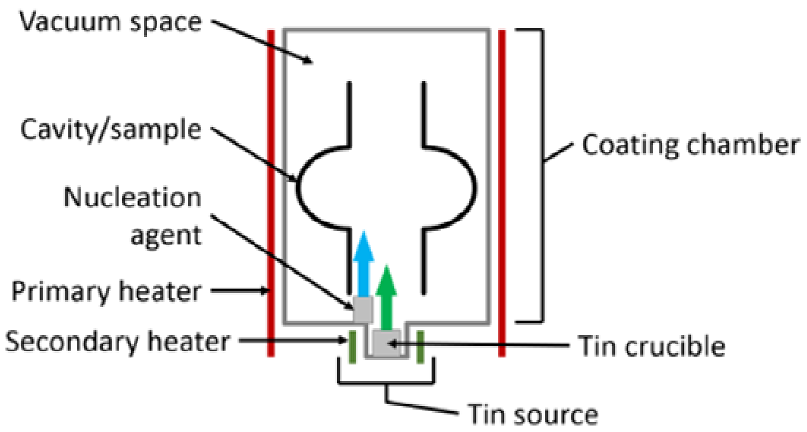


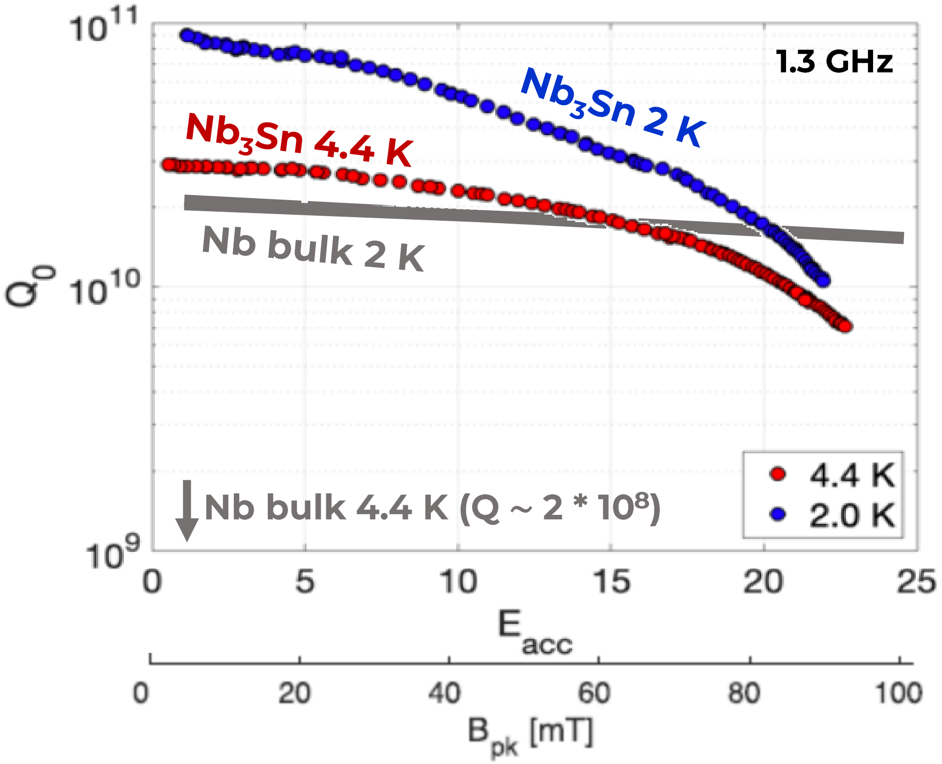
Supercond. Sci. Technol. 30 (2017) 033004

Nb_3Sn state of the art

Vapor Tin Diffusion

Cornell, Fermilab, JLab, KEK





S. Posen, SRF 2019 proceedings (elaborated)

Technology limitation:

- **Reproducibility**
- **Nb as Substrate** (expensive, chemistry, no interlayer possible)

A different approach: Nb_3Sn on Cu

Cu substrate as several advantages:

- **Cheaper** than Nb
- Higher **thermal conductivity**
- Higher **mechanical stability**
- **PVD technology** (Nb on Cu) already used for
  LEP, LHC, HIE-ISOLDE @ CERN
  ALPI @ INFN LNL

Nb_3Sn on Cu: Multiple challenges

- A15 are Brittle materials
- Complicated Phase Diagram
- Low melting point substrate
- Interface diffusion
- Coating Parameters
- Substrate preparation
- Target Production/Magnetron Design
- Trapped Flux
- Tuning

Nb_3Sn on Cu: Multiple challenges

- A15 are Brittle materials
- Complicated Phase Diagram
- Low melting point substrate
- **Interface diffusion**
- **Coating Parameters**
- **Substrate preparation**
- **Target Production/Magnetron Design**
- **Trapped Flux**
- **Tuning**

iFAST

SRF cavities R&D for FCC-ee

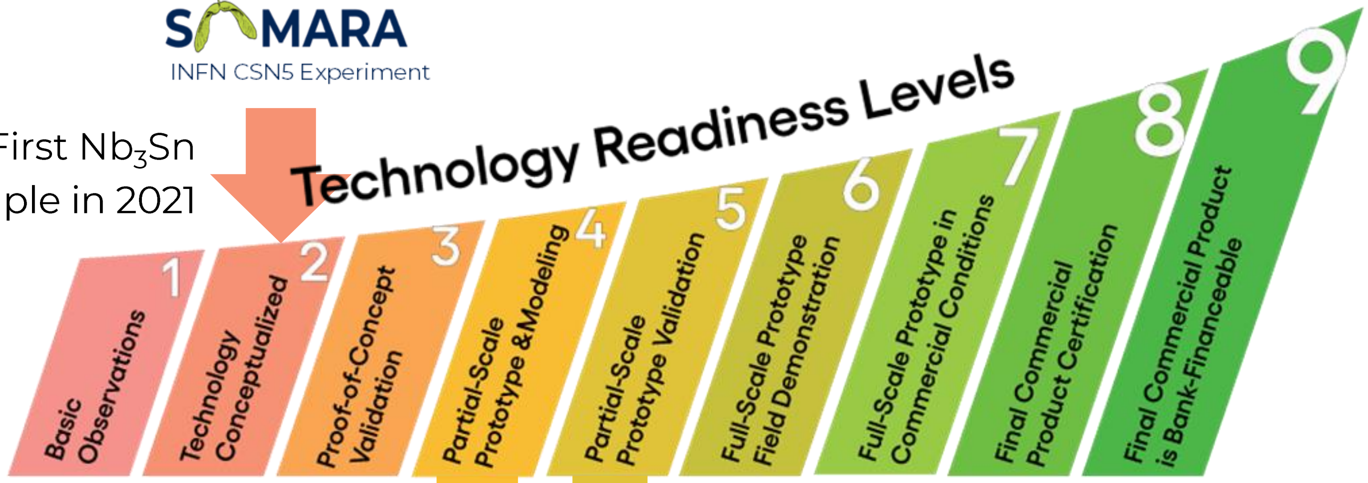
INFN Accelerators European Strategy Program

iSAS

Nb_3Sn on Cu TRL evolution @LNL

SAMARA
INFN CSN5 Experiment

First Nb_3Sn sample in 2021



iFAST

MAIN GOAL (2025):

Produce a prototype of high performance **1.3 GHz** thin film SRF elliptical cavity
$Q > 1 \cdot 10^{10}$ @ 4.5 K

iSAS

SRF cavities R&D for FCC-ee

INFN Accelerators European Strategy Program

A step forward in TRL

Focus on:

- minimizing **trapped flux**
- increasing coating mechanical strength
  (to allow **cavity tunability**)

I.FAST WP9 Collaboration

INFN: C. Pira, O. Azzolini, R. Caforio, E. Chyhyrynets, D. Fonnesu, D. Ford, V. Garcia, G. Keppel, G. Marconato, A. Salmaso, F. Stivanello (LNL)
M. Bertucci, R. Paparella (LASA)

UKRI Science and Technology Facilities Council: O.B. Malyshev, R. Valizadeh, C. Benjamin, T. Sian, L. Smith, D. Seal

cea: C.Z. Antoine, S. Berry, Y. Kalboussi, T. Proslier

IJCLab: D. Longuevergne, O. Hryhorenko,

HZB Helmholtz Zentrum Berlin: S. Keckert, O. Kugeler, J. Knobloch

HZDR Helmholtz Zentrum Dresden Rossendorf: S. Prucnal, S. Zhou

Universität Siegen: X. Jiang, T. Staedler, A. Zubtsovskii

ELÚ: E. Seiler, R. Ries

Rīgas Tehniskā Universitāte: A. Medvids, A. Mychko, P. Onufrievs

Lancaster University: G. Burt, N. Leicester, S. Marks, D. Turner

University of Liverpool: W. Bradley, S. Simon

Piccoli: R. Berton, D. Piccoli, F. Piccoli, G. Squizzato, F. Telatin

Associated Partners

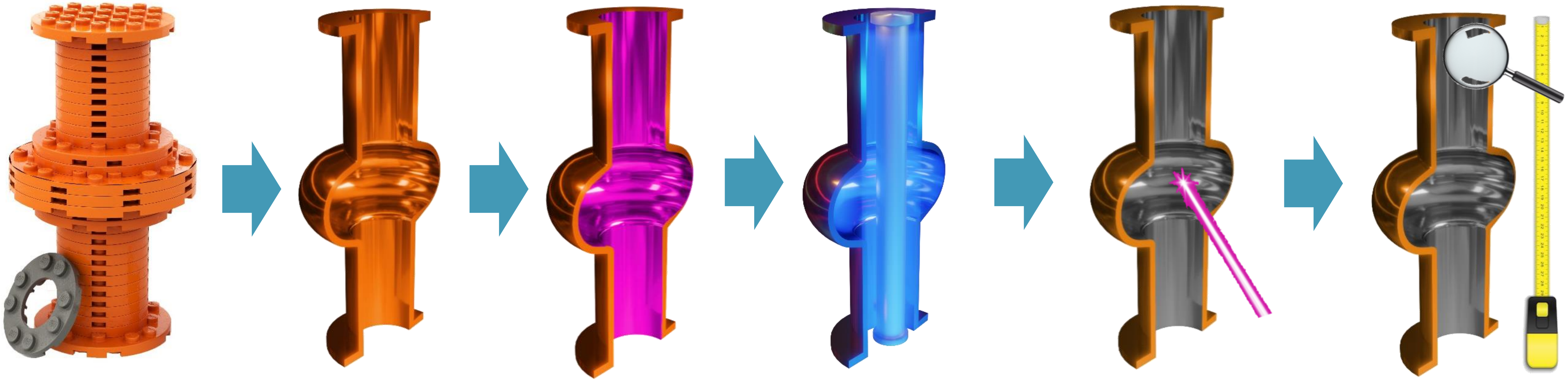
Jefferson Lab: A. M. Valente Feliciano

Informal Partners

CERN, DESY

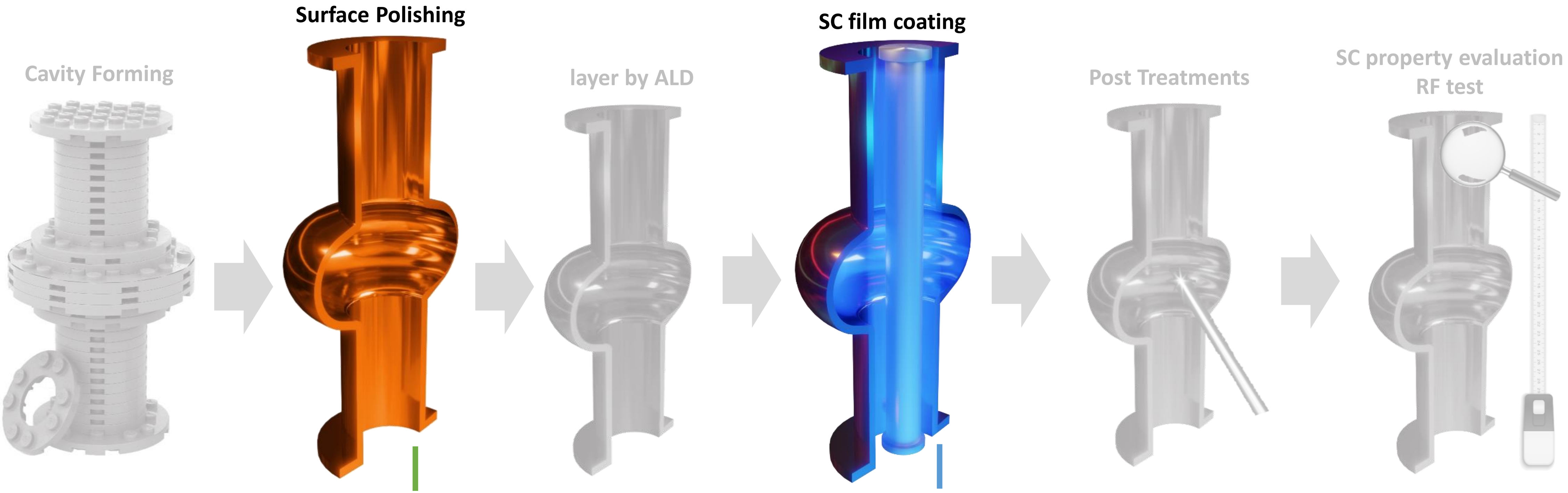
Nb_3Sn on Cu R&D activity covers all cavity production chain

Cavity Forming	Surface Polishing	layer by ALD	SC film coating	Post Treatments	SC property evaluation RF test



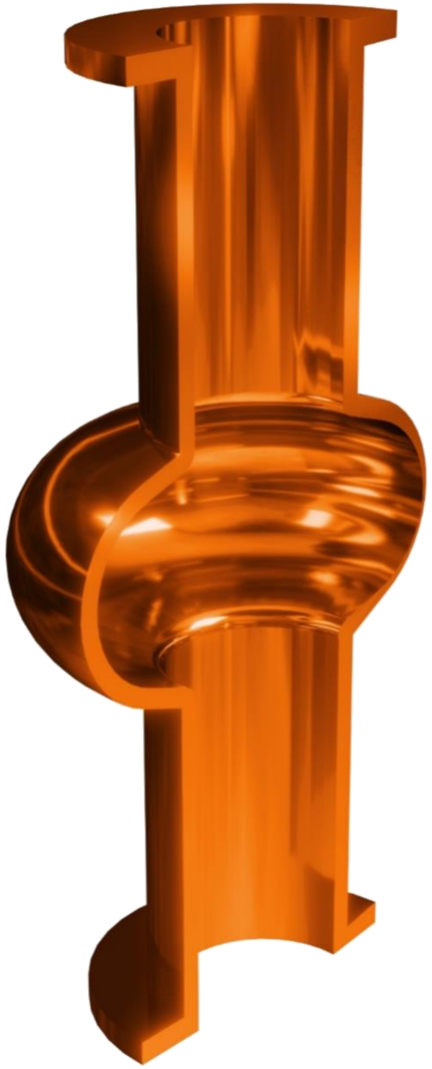
Seamless Spinning Additive Manufacturing	*Plasma Electrolytic Polishing*	*Atomic Layer Deposition*	*Nb_3Sn on Cu*	*Laser Annealing Millisecond Flash Annealing*	

Technologies in focus at INFN LNL



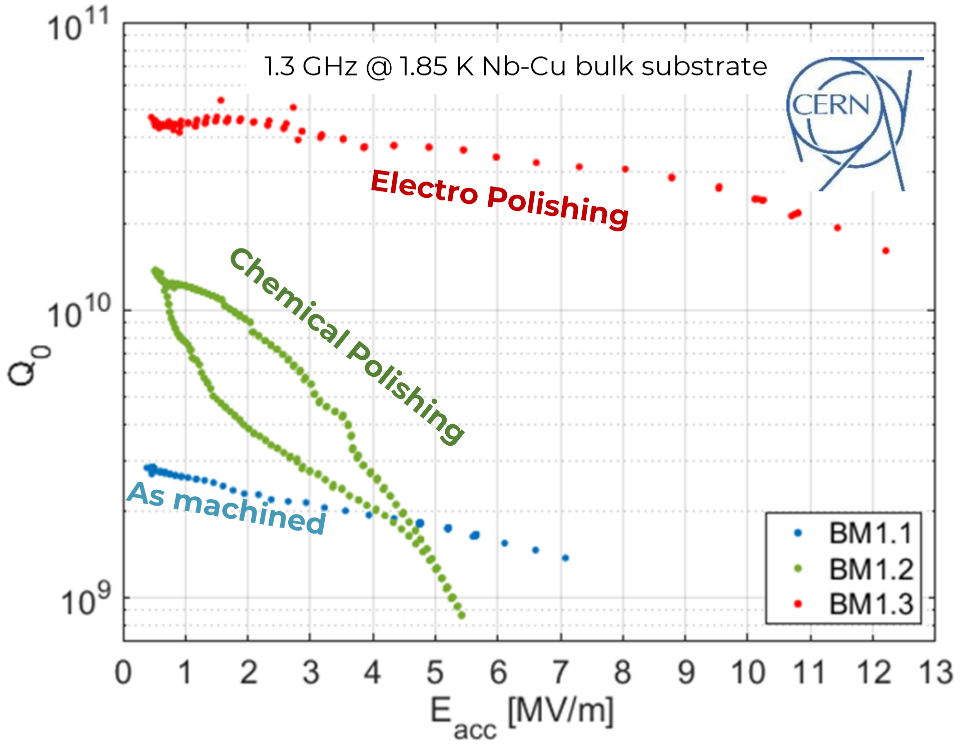
Plasma
Electrolytic
Polishing

Nb_3Sn on Cu
Coatings



Surface Polishing
PEP

Surface Polishing



L. Vega Cid, TTC meeting 2022 (elaborated)

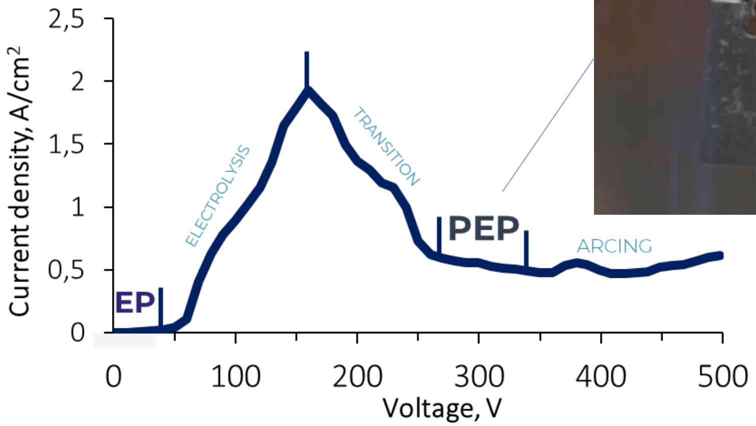
Cu substrate plays a fundamental role in SRF performances

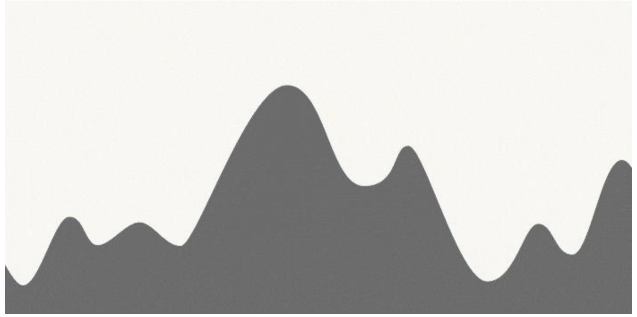
Roughness and defects reduction by **surface treatments are mandatory** for a good and uniform SRF coating

Cavity polishing requires **large amount of acids**. In particular **Nb** requires **HF** (extremely dangerous and poisoning process)

Plasma Electrolytic Polishing PEP

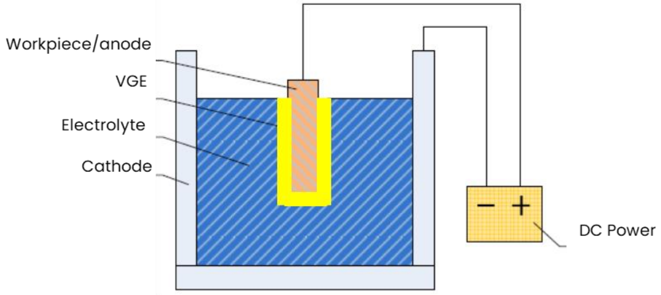
Mechanism





Same EP set-up

Different regime



J. Wang et al., AMR, 2012

Advantages

Green
Diluted water solutions, enviromentally friendly

Fast
The fastest non-destructive polishing

Efficiency
Equal thickness removal yield lowest roughness among competitors

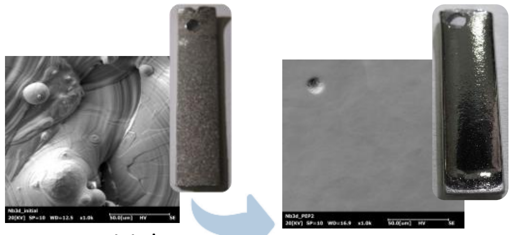
Versatility
Less sensitive to the cathode shape!
AM compatible

Plasma Electrolytic Polishing PEP Results

1x Nb 3x Cu

Solution Patents by INFN

Additive Manufacturing



Initial
Ra= 13 μm

PEP 30 min
Ra= 1.5 μm

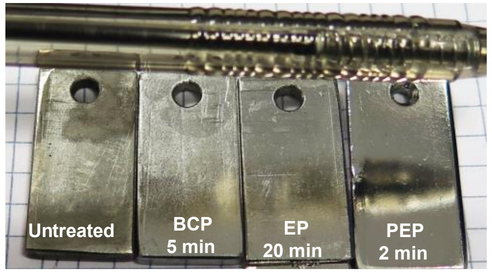
QPR Samples

Nb QPR polishing optimizaztion on-going

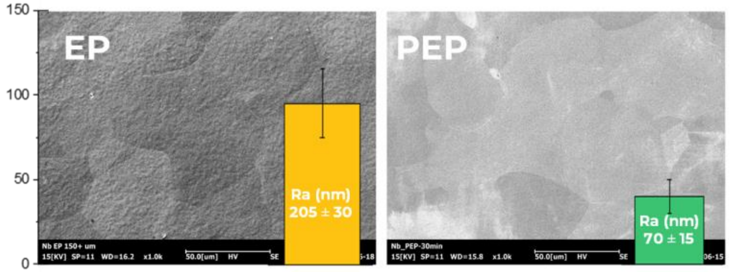
Full Cu QPR ready for coating

HZB Helmholtz Zentrum Berlin

Planar samples



6.5 μm removed



150 μm removed in ~ 5 h

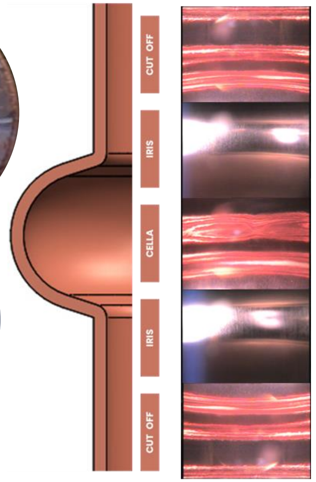
150 μm removed in ~ 40 min

Cu Photocatodes

DESY.

Ra ~ 8 nm!!!

6 GHz Cu cavity



Courtesy of E. Chyhyrynets

No internal cathode!

70 μm removed in 10 minutes

30 A (100 cm2 → 1.3 GHz ~ 300 A)

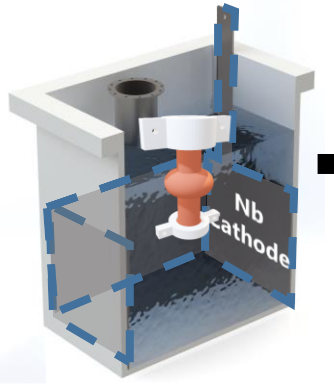
PEP Path to Final Prototype

Philosophy: scale 6 GHz set-up to 1.3 GHz converting LNL QWR polishing system

Priority: test RF performances after PEP

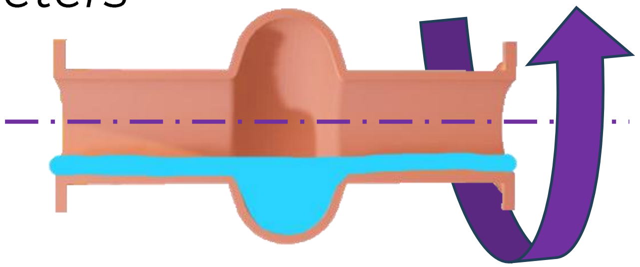
1. **Simpler set-up: cavity fully immersed**

2. **Alternative set-up to Reduce Process Power**
   - *Reduce Treated Area (rotating cavity)*
   - *Optimizing Process Parameters (Temperature, Voltage, …)*



6 GHz - 30 L

1.3 GHz - 300 L

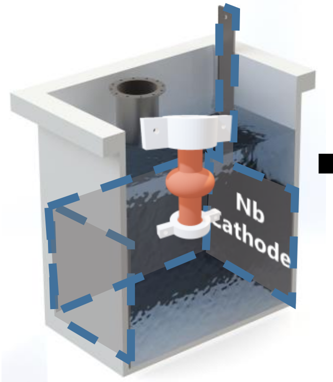


QWR Implant @LNL

PEP Path to Final Prototype

Philosophy: scale 6 GHz set-up to 1.3 GHz converting LNL QWR polishing system

Priority: test RF performances after PEP

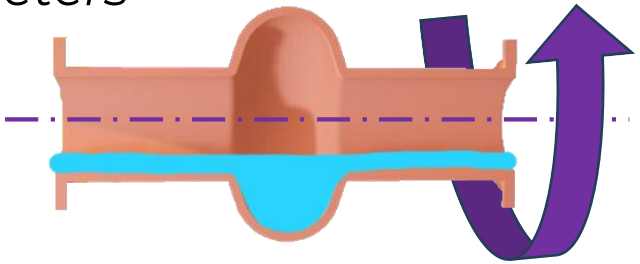


6 GHz - 30 L

1.3 GHz - 300 L

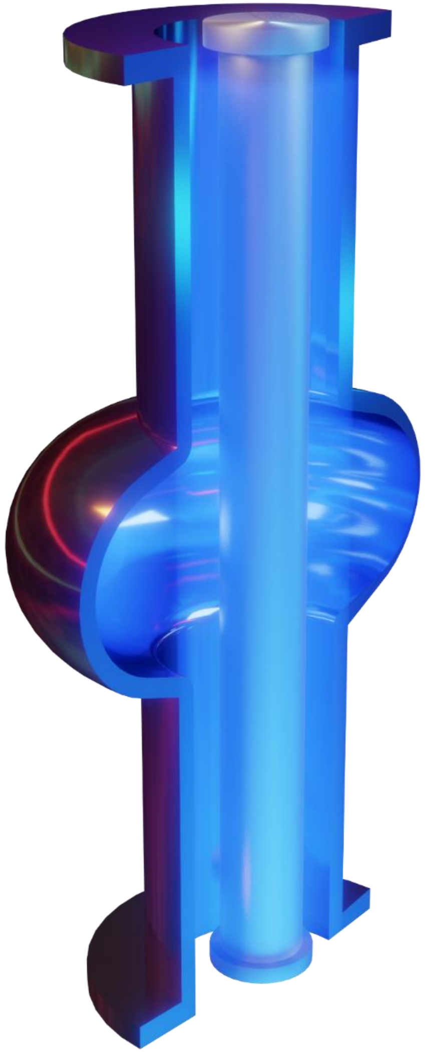
1. **Simpler set-up: cavity fully immersed**

2. **Alternative set-up to Reduce Process Power**
   - *Reduce Treated Area (rotating cavity)*
   - *Optimizing Process Parameters (Temperature, Voltage, …)*



2300 cm2 tube treated by PEP (150 A,

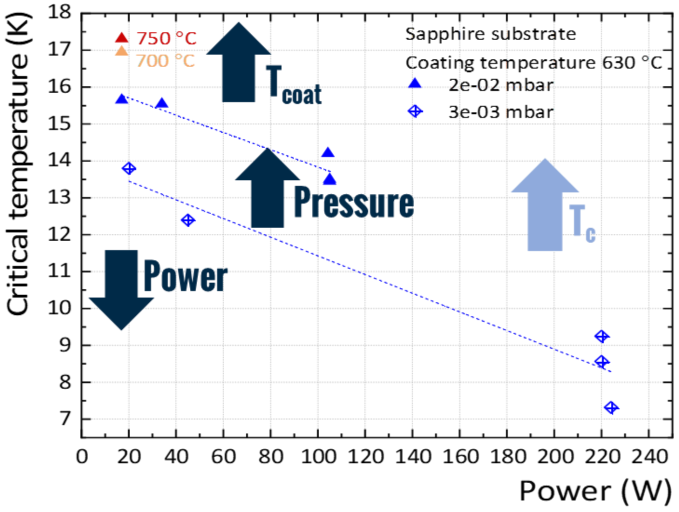
cristian.pira@lnl.infn.it

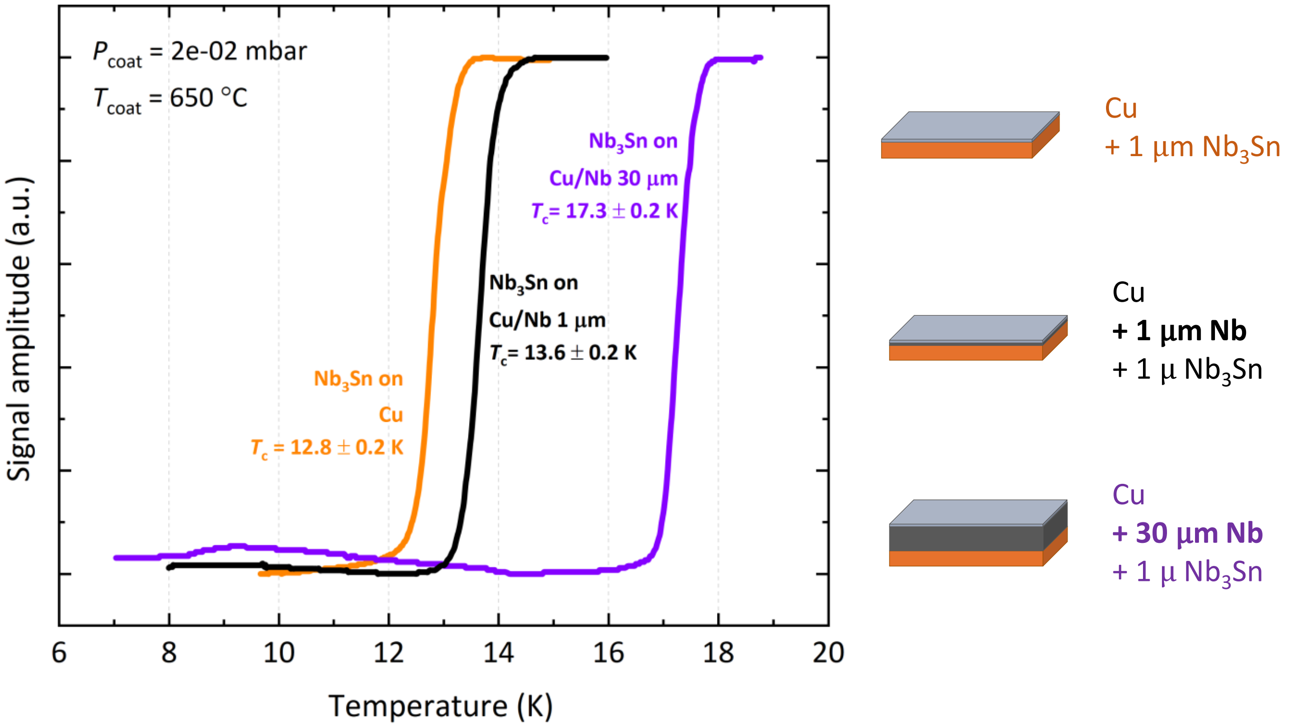


Nb_3Sn on Cu Coatings

Nb_3Sn Coatings

Long R&D phase on PVD Parameter Optimization





Optimized Coating Recipe

- Coating Parameters:
  - Pressure = $2*10^{-2}$ mbar
  - Power = 16 W
  - T substrate ≥ 600 C
- **Nb Thick Barrier Layer > 30 um**

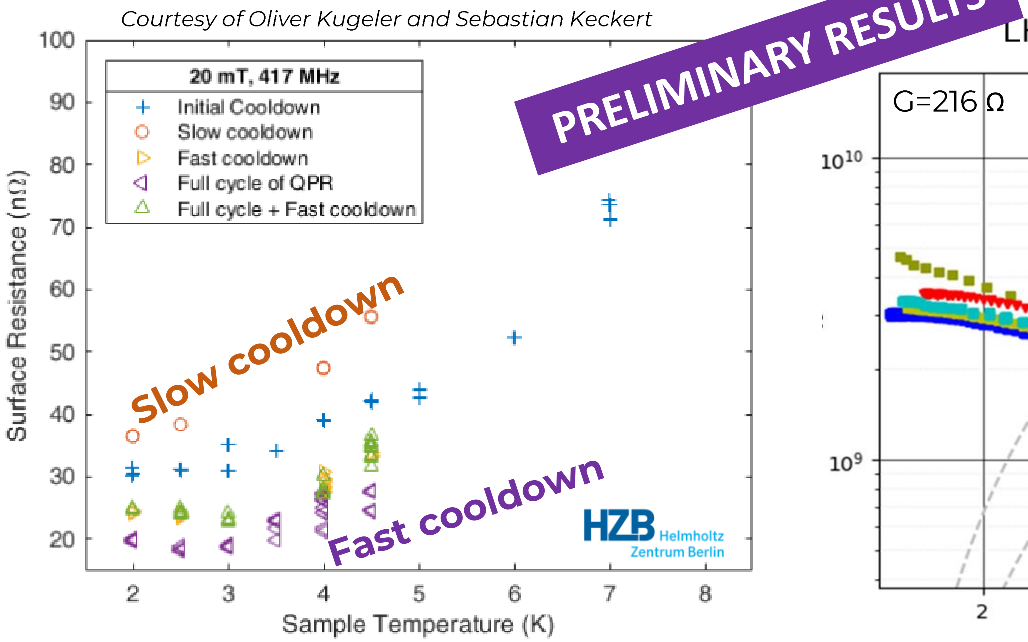
A thick Nb buffer layer accommodates the Nb_3Sn coating

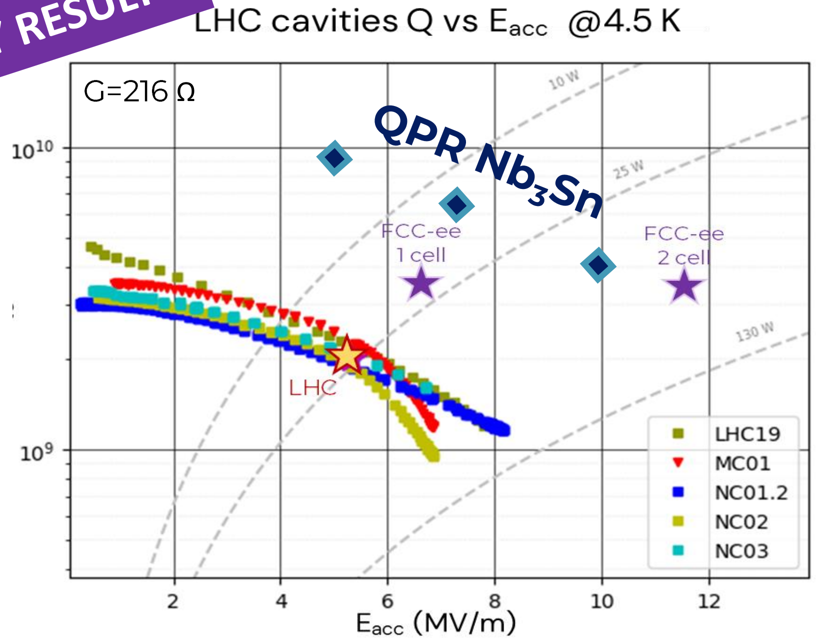
Nb substrate can be used to validate Nb_3Sn Coating Performances

First Nb_3Sn RF Results
(on a small Nb planar resonator)

Rs of 23 nΩ
@ 4.5 K, 20 mT

Quench >70 mT
@ 4.5 K





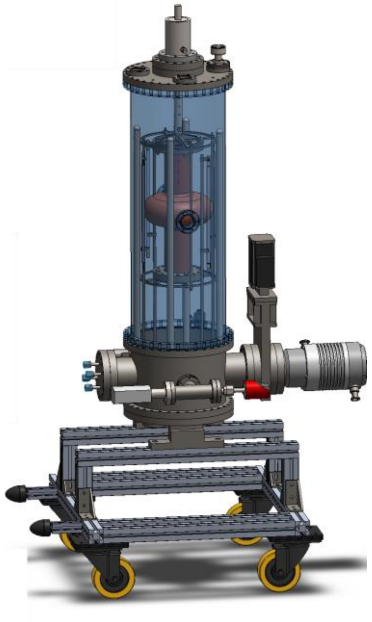
- **Nb_3Sn coating suffer flux trapping**
- **Cooldown procedure influence Rs**

Equivalent to a Q of $9{\cdot}10^9$ @5 MV/m @4.5 K

5 times better than LHC → FCC-ee compatible

Room for improvement

Nb_3Sn Path to Final Prototype

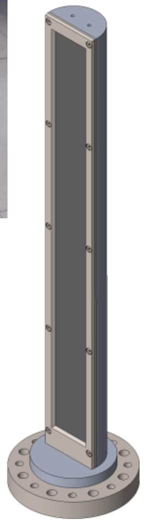


Nb_3Sn on bulk Nb to validate coating performances (2025)
on 1.3 GHz Elliptical Cavities (2025)

Develop Nb thick barrier/accommodation layer
on 1.3 GHz Elliptical Cavities (2025)
(proof of concept on 6 GHz cavities already done)

Nb_3Sn on Cu with thick Nb coating
on 1.3 GHz Elliptical Cavities (2026-2028)

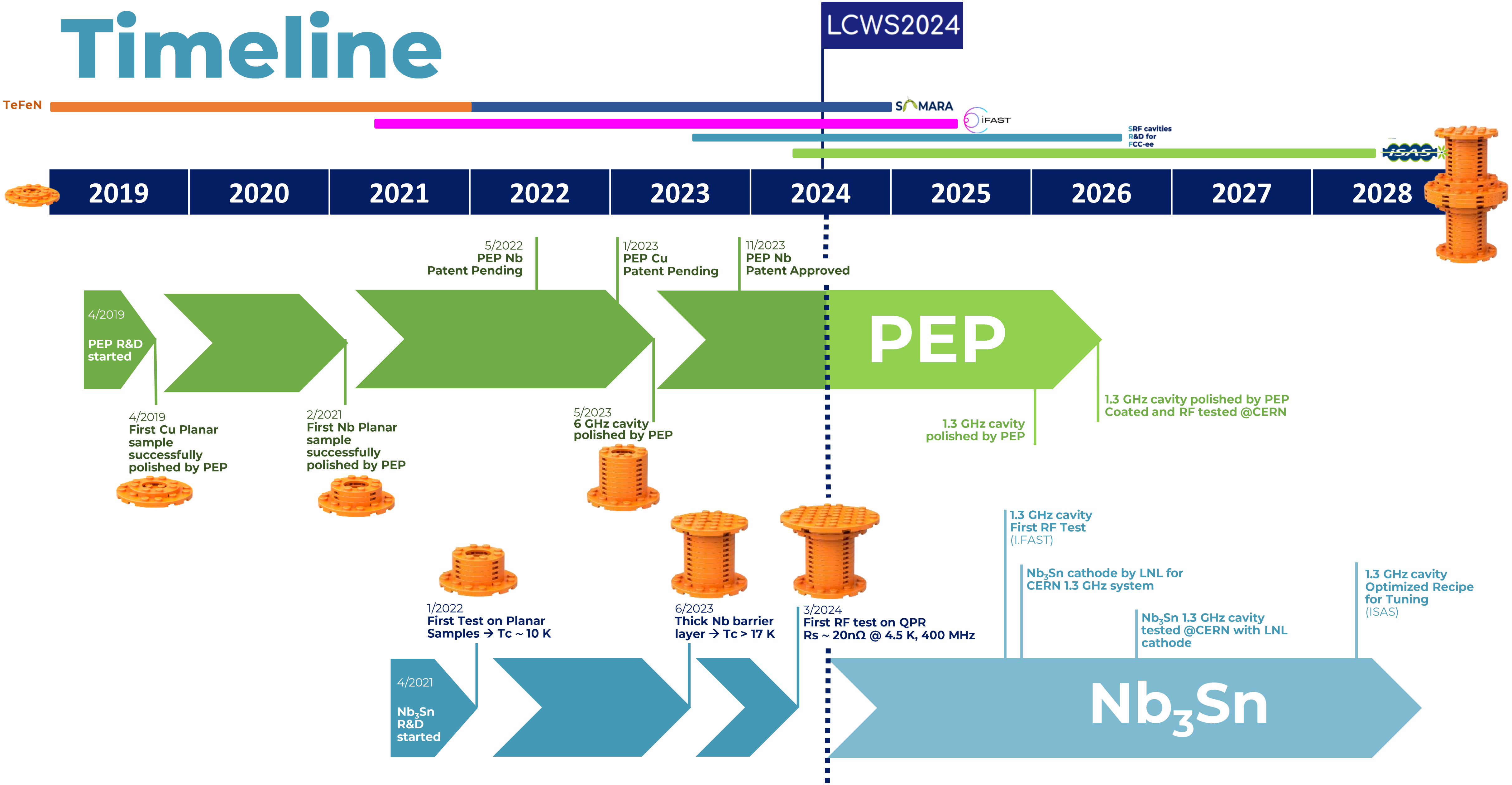
- **1.3 GHz Vacuum system ready**
- **Magnetron source commissioned**



In parallel:

- *Study on alternative buffer layer* cea
- *Study on flux trapping* UKRI Science and Technology Facilities Council; HZB Helmholtz Zentrum Berlin

Timeline



LCWS2024
TeFeN
SAMARA
iFAST
SRF cavities R&D for FCC-ee
ISAS
2019
2020
2021
2022
2023
2024
2025
2026
2027
2028
5/2022
PEP Nb
Patent Pending
1/2023
PEP Cu
Patent Pending
11/2023
PEP Nb
Patent Approved
4/2019
PEP R&D started
PEP
1.3 GHz cavity polished by PEP
Coated and RF tested @CERN
1.3 GHz cavity polished by PEP
4/2019
First Cu Planar sample successfully polished by PEP
2/2021
First Nb Planar sample successfully polished by PEP
5/2023
6 GHz cavity polished by PEP
1.3 GHz cavity
First RF Test
(I.FAST)
Nb$_3$Sn cathode by LNL for CERN 1.3 GHz system
1.3 GHz cavity
Optimized Recipe for Tuning
(ISAS)
Nb$_3$Sn 1.3 GHz cavity tested @CERN with LNL cathode
1/2022
First Test on Planar Samples → Tc ~ 10 K
6/2023
Thick Nb barrier layer → Tc > 17 K
3/2024
First RF test on QPR
Rs ~ 20nΩ @ 4.5 K, 400 MHz
4/2021
Nb$_3$Sn R&D started
Nb$_3$Sn

Conclusion

- **PEP and Nb_3Sn films** are possible **game changer technologies** for SRF accelerating cavities
- **Big steps forward** in the last two years with transition from planar to 3D samples
- **Very promising results from first RF test**
- **Validation with 1.3 GHz cavities is necessary** prior to evaluating the feasibility of implementing these technologies in real accelerators
- **End of 2025** we expect to have the **first tests** available on **1.3 GHz cavities**
- **In 2028 optimized prototypes** are expected

Work supported by INFN CSN5 experiment SAMARA and INFN CSN1 experiments SRF and RD_FCC
This project has received funding from the European Union's Horizon-INFRA-2023-TECH-01 under GA No 101131435 – ISAS and from the European Union's Horizon 2020 Research and Innovation programme under GA No 101004730 – I.FAST

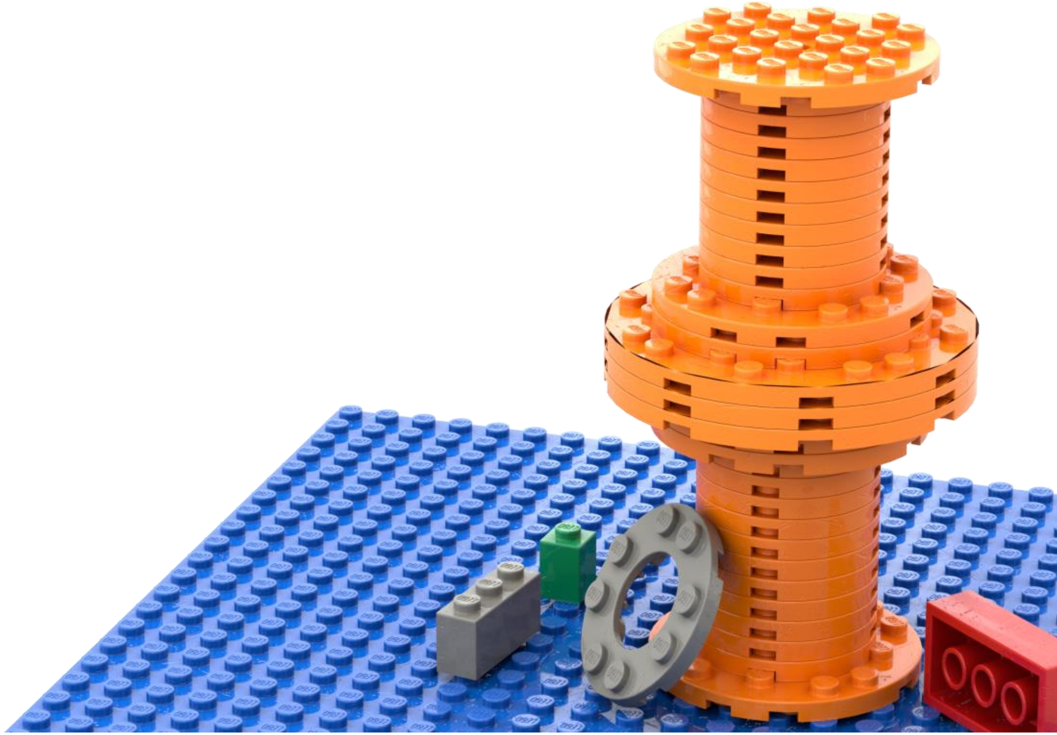
Work supported by INFN CSN5 experiment SAMARA and INFN CSN1 experiments SRF and RD_FCC

This project has received funding from the European Union's Horizon-INFRA-2023-TECH-01 under GA No 101131435 – iSAS and from the European Union's Horizon 2020 Research and Innovation programme under GA No 101004730 – I.FAST

INFN LNL

Cristian **Pira**

Backup Slides



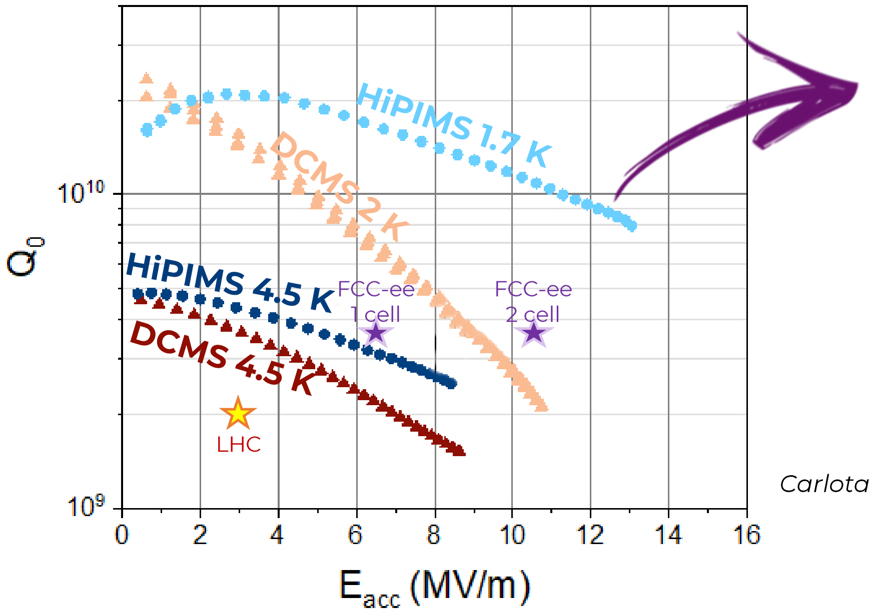
Nb_3Sn motivation

Energy saving *is mandatory for* ***FCC-ee*** *and the* ***next generation accelerators****…*

*…****cryogenics*** *is one of the* ***larger energy cost*** *in modern SRF accelerators*

Move from thin film Nb @4.5 K to Nb_3Sn @4.5 K

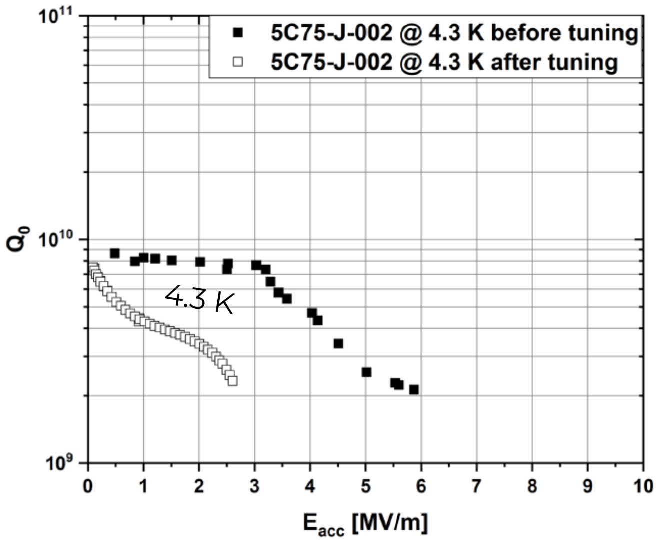
Reduce T_{op}/T_c → Suppress R_{BCS} → Increase Q



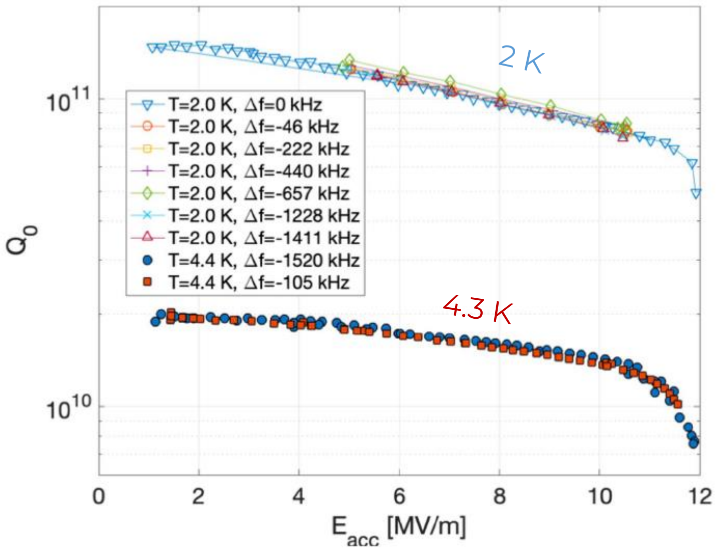
Expected Performances for Nb_3Sn

Carlota Pereira Carlos, FCC week 2023 (elaborated)

Cavity Tunability



Strong performance degradation after **room temperature** tuning for 200 kHz



Little change in the coated cavity performance after tuning up to 1400 kHz at **cryogenic temperatures**

Nb_3Sn is extremally brittle

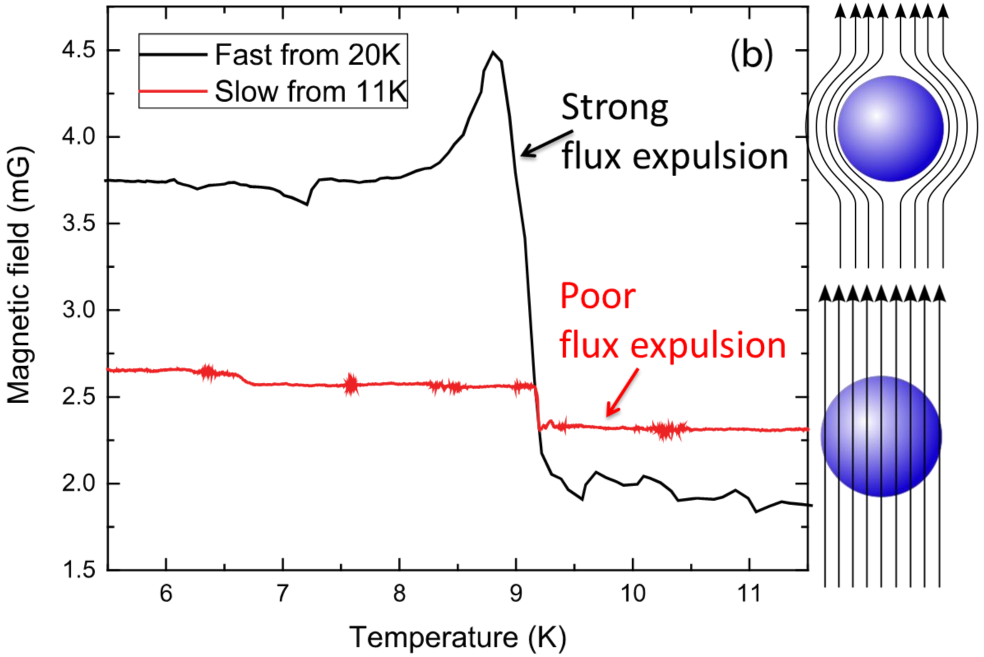
Eremeev, G. (2023). Tunability/robustness of Nb3Sn (No. FERMILAB-SLIDES-23-402-TD). Fermi National Accelerator Laboratory (FNAL), Batavia, IL (United States).

- **Vapor Tin Diffusion Nb_3Sn on Nb cavities can be tuned only at cryogenic T**
- **An interlayer in Nb_3Sn on Cu coatings can be added to enhance film mechanical stability and tunability**

Trapped Flux

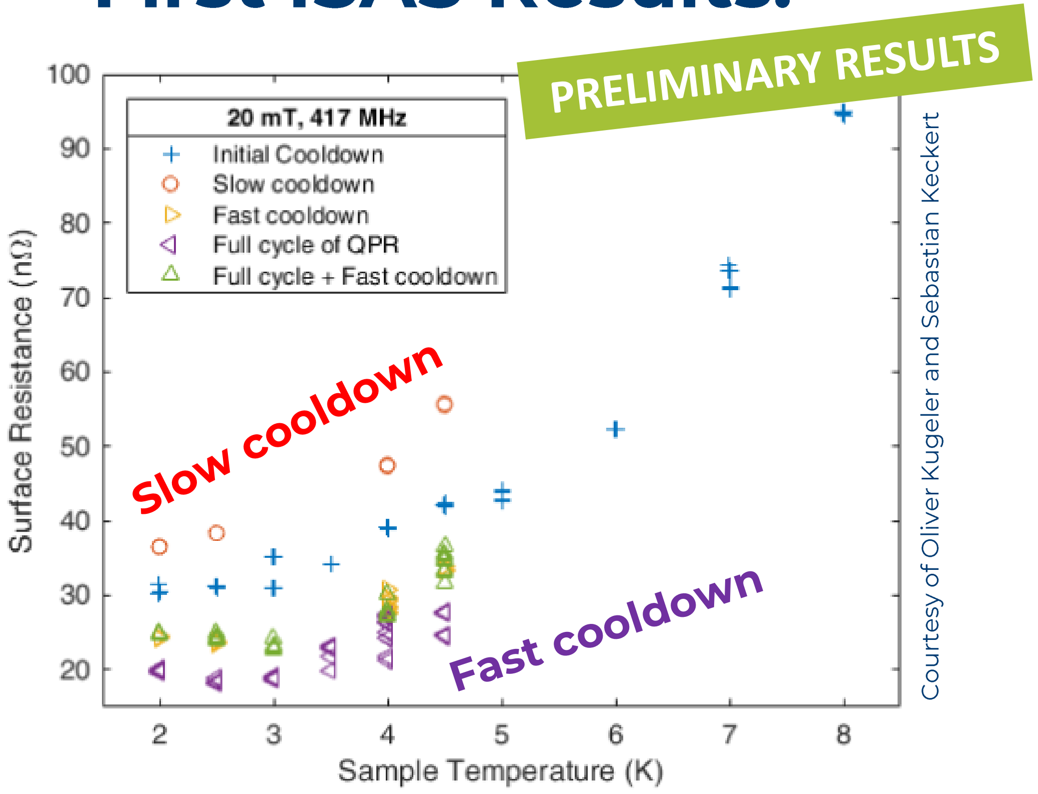
$$Q_0 \propto \frac{1}{R_{BCS} + R_{res} + \eta\, S\, B}$$

Fraction of Trapped Flux (η) — Sensitivity (S)



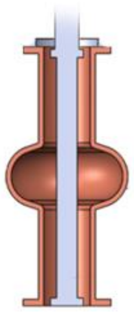
A. Romanenko, A. Grassellino, O. Melnychuk, D. A. Sergatskov, J. Appl. Phys. 115, 184903 (2014)

First ISAS Results:



- Nb_3Sn coating suffer flux trapping
- Cooldown procedure influence Rs

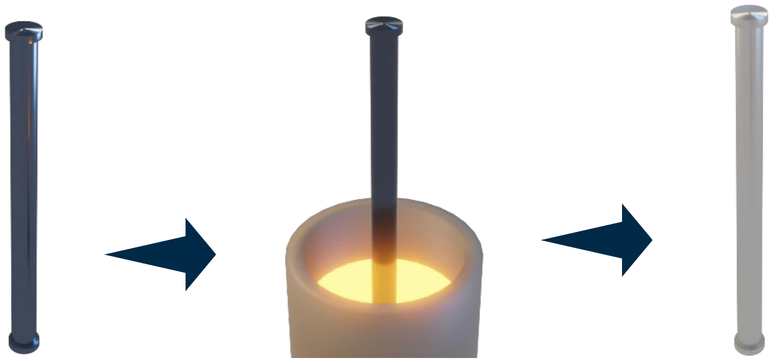
Nb_3Sn coatings: target production



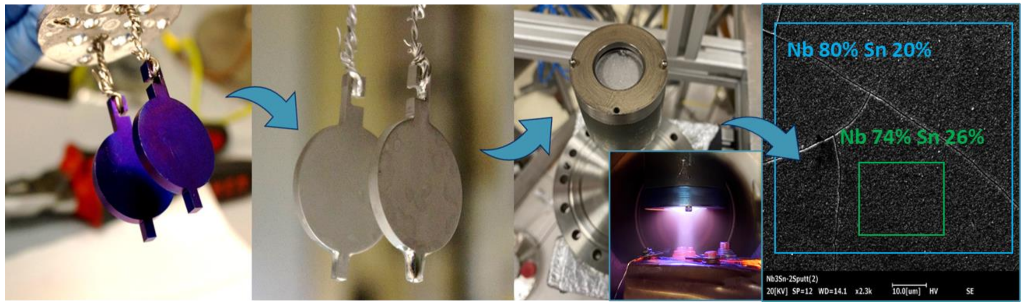
Single target configuration easiest to scale onto elliptical geometry

Nb_3Sn cylindrical targets are not commercially available

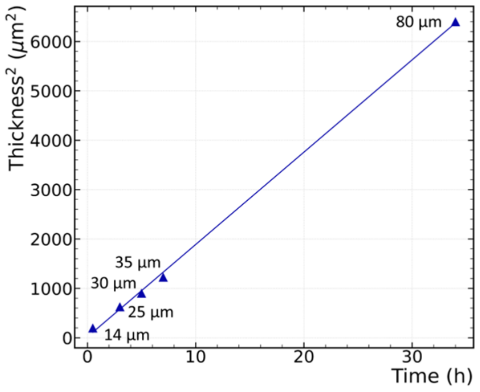
LNL Strategy for Nb_3Sn cylindrical targets production for 6 GHz cavities



Raw Nb target → ***Dipping in liquid Sn*** → *Nb_3Sn cylindrical target*



Proof of concept



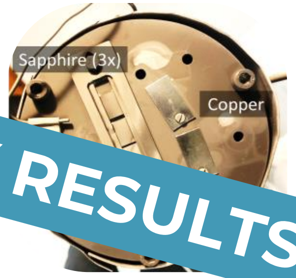
Nb_3Sn **thickness** related to **dipping time**

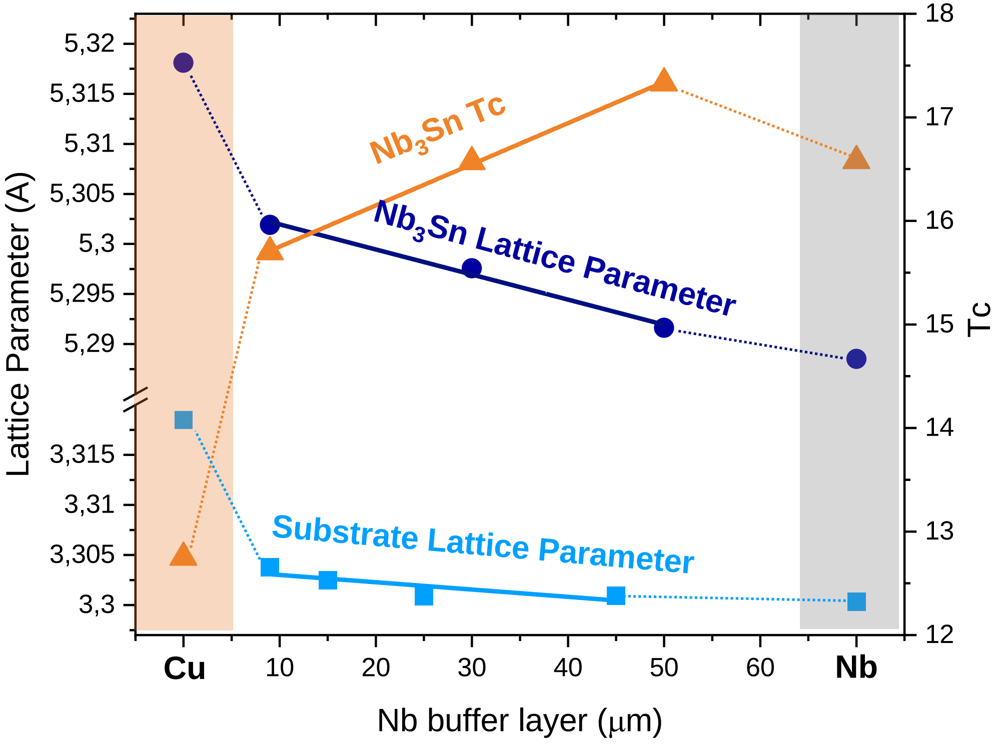
Possible **tin content modulation**

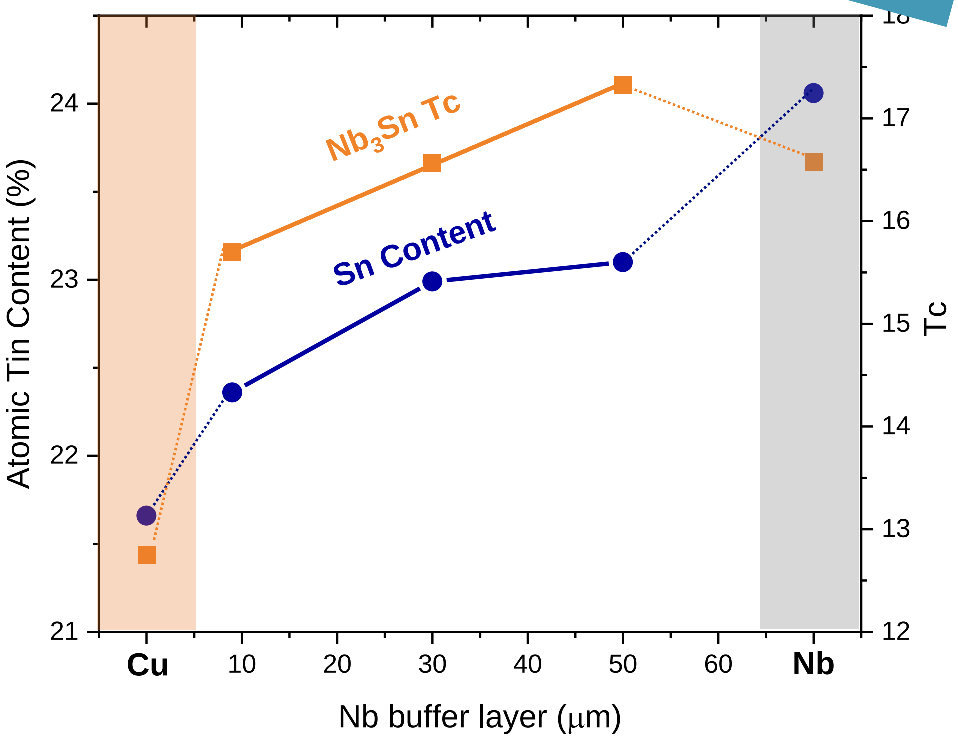
Nb_3Sn coatings

Sputtering parameter optimization

PRELIMINARY RESULTS







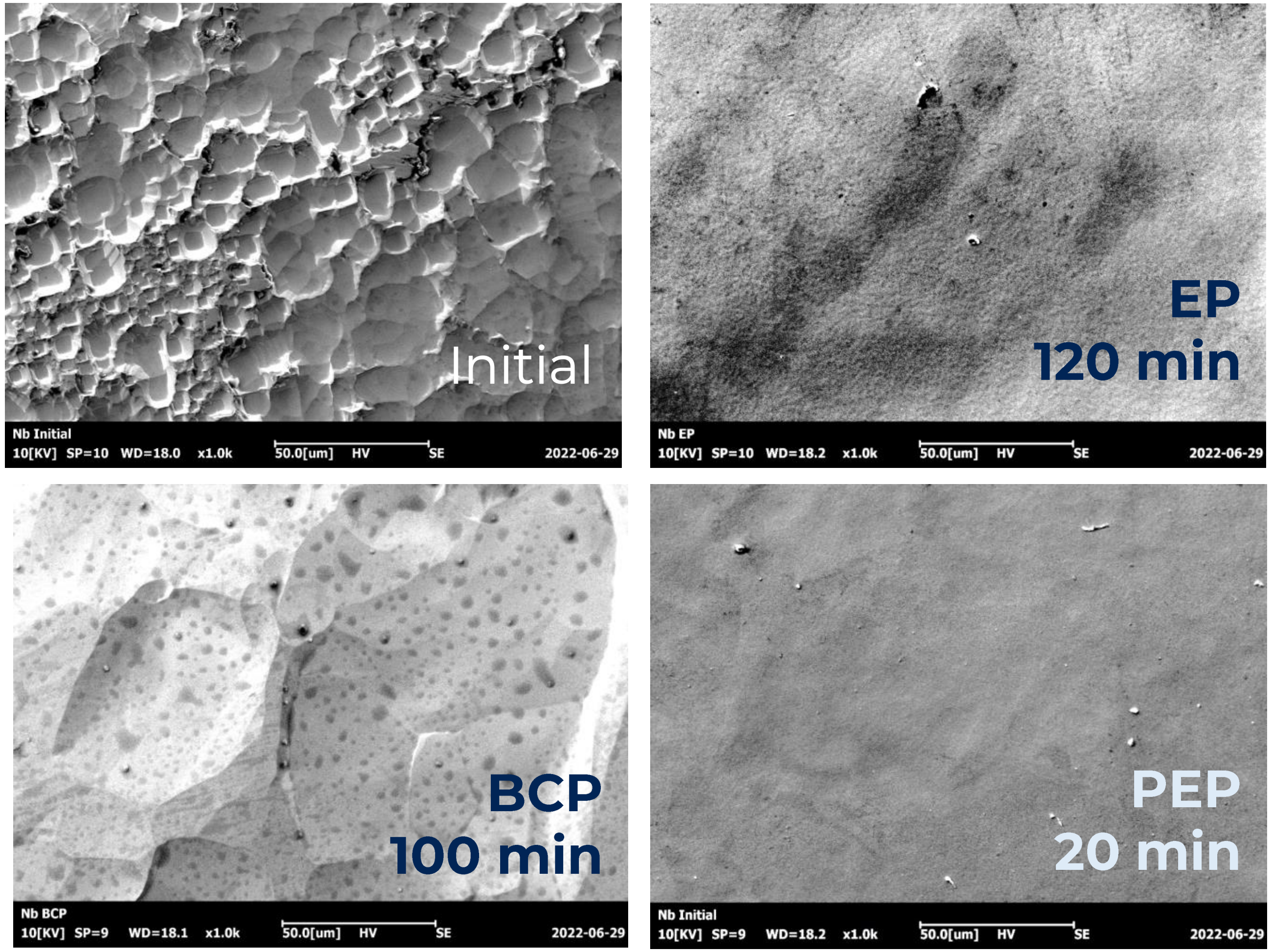
The role of the thick Nb layer is to accommodate the Nb_3Sn lattice parameter

ALD layer could be an alternative to explore

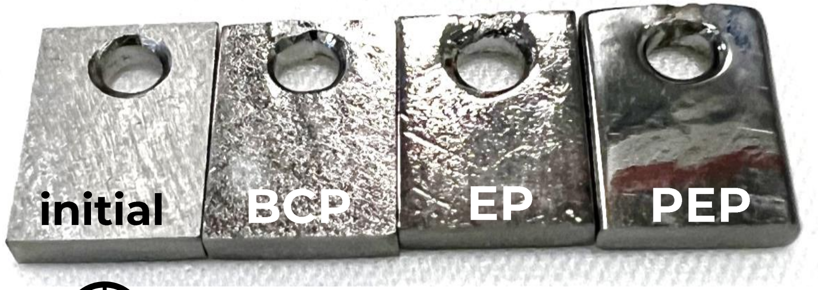
PEP is Efficient

Comparision with EP and BCP

Plasma Electrolytic Polishing



Nb, Magnification **1000x**;
100 µm Removal

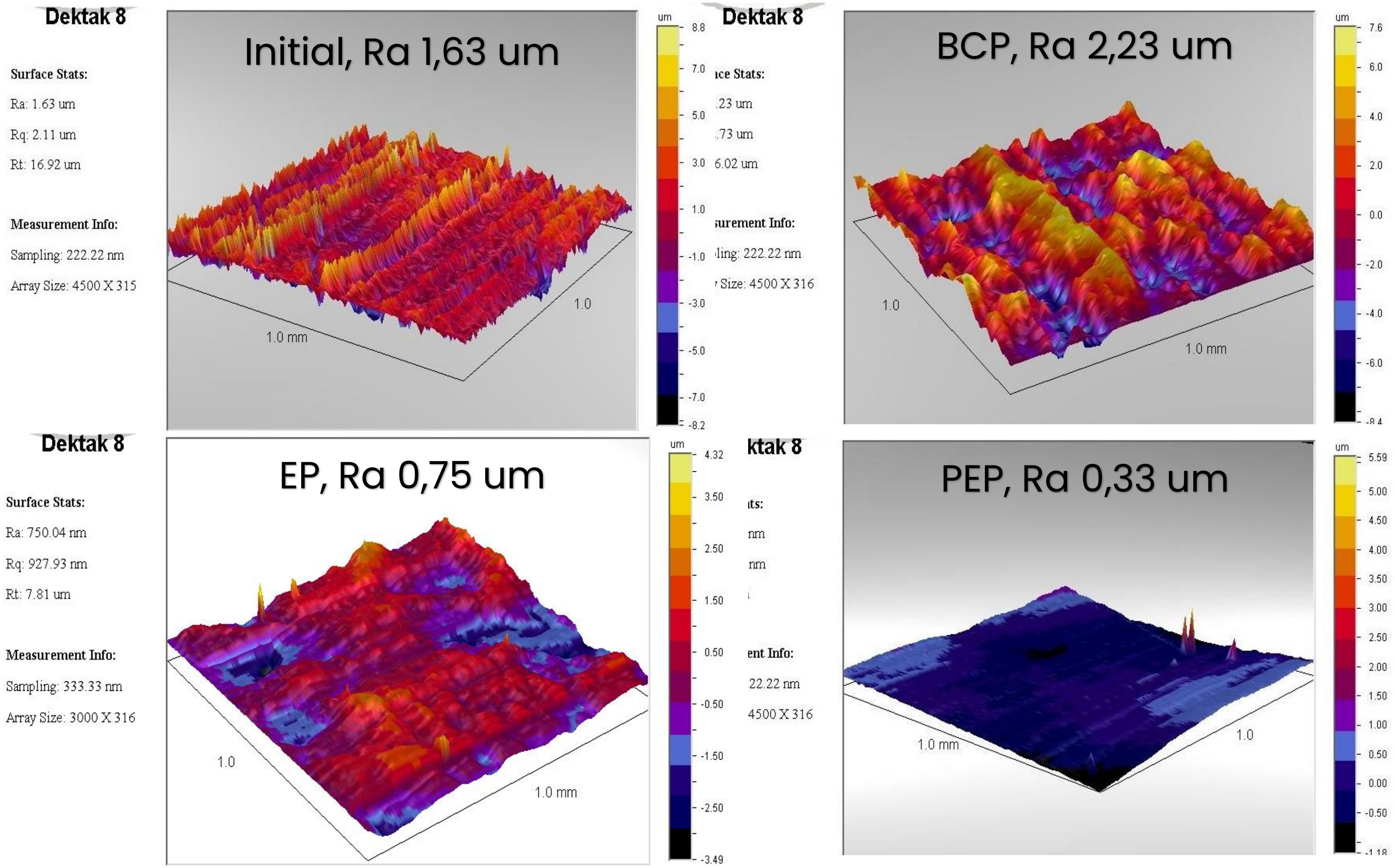


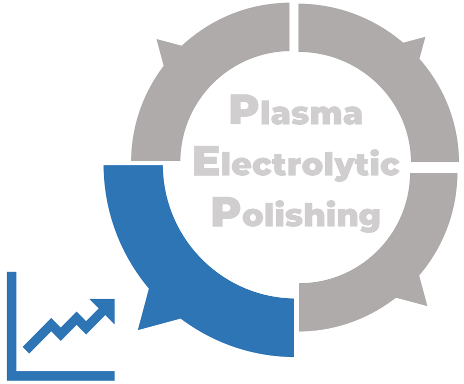
100 min | 120 min | 20 min

Both micro and macro **roughness is improved significantly**

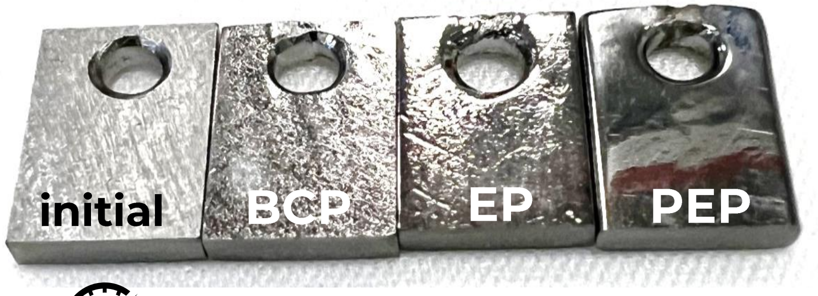
PEP is Efficient

Comparision with EP and BCP





Nb, Magnification **1000x**; 100 μm Removal



100 min | 120 min | 20 min

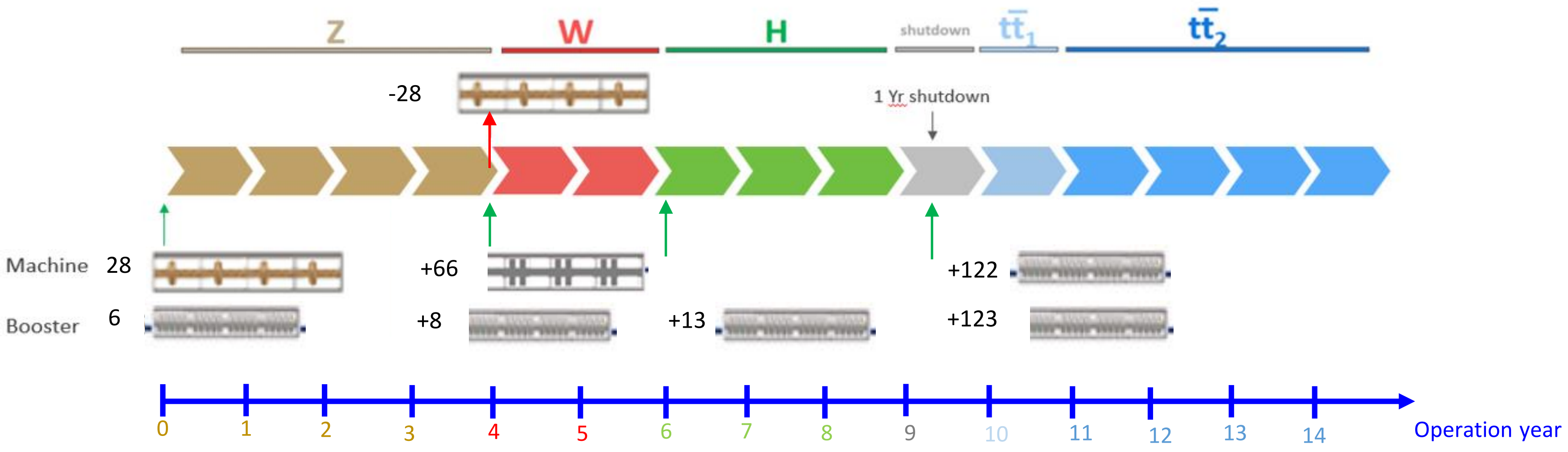
Both micro and macro **roughness is improved significantly**

Comparison

Copper treatments

Process / parameters	"SUBU5"	EP (3:2)	PEP in "SUBU5"
Solution composition	Sulfamic acid 5 g/l; NH_4-citrate 1 g/l Butanol 50 ml/l; H_2O_2 50 ml/l	85 % H_3PO_4 60 p. 99% n-Butanol 40p.	Sulfamic acid 5 g/l; NH_4-citrate 1 g/l Butanol 50 ml/l; H_2O_2 50 ml/l
Voltage	-	2-6 V	300 V
Current density	-	0,01 – 0,03 A/cm^2	0,25-0,8 A/cm^2
Power draw	-	0,06 – 0,18 W/cm^2	75 – 240 W/cm^2
Removing rate	1,5 μm/min (70±2 ℃)	0,15-0,5 μm/min (25 ℃)	20-30 μm/min (80 ℃)

SRF System Baseline for FCC



In total: 366 CM, 1'464 cavities (4 cavities/CM, present assumption):

- **400 MHz single-cell (Nb/Cu): 28 CM, 112 cavities → 4.5 K** *(to be removed after Z)*
- **400 MHz two-cell (Nb/Cu): 66 CM, 264 cavities → 4.5 K**
- 800 MHz five-cell (bulk Nb): 272 CM, 1'088 cavities → 2 K

Collider (ttbar2): 188 CM (264 cavities 400 MHz, 488 cavities 800 MHz)

Booster (ttbar2): 150 CM (600 cavities 800 MHz)

Performance of thin film 400 MHz are one of the main challenges of FCC SRF System

SRF System Baseline from Vittorio Parma, FCC week 2023

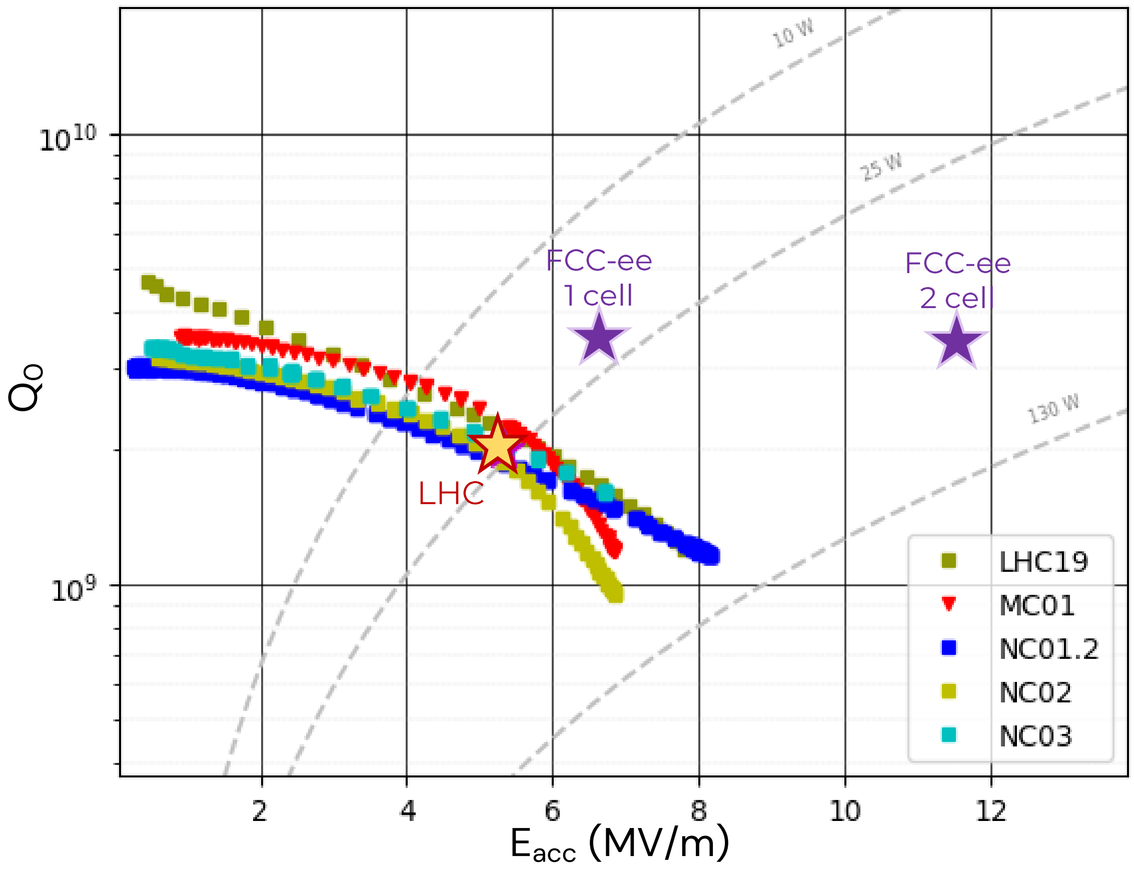
400 MHz requirements

FCC-ee requires
higher cavities performances than LHC

Nb on Cu “baseline”, Solid scheme with good margin for reliable operation Clear R&D paths identified (seamless copper cavities, HiPIMS coating, High Q0 bulk Nb cavities)

Franck Peauger , FCC week 2023

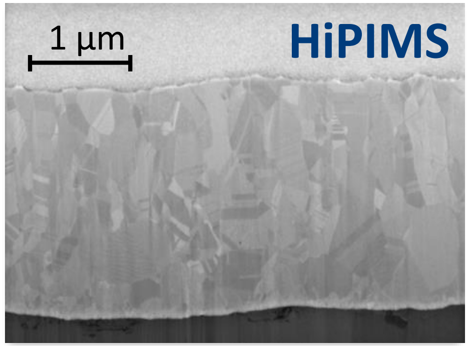
LHC cavities Q vs E_{acc} @4.5 K

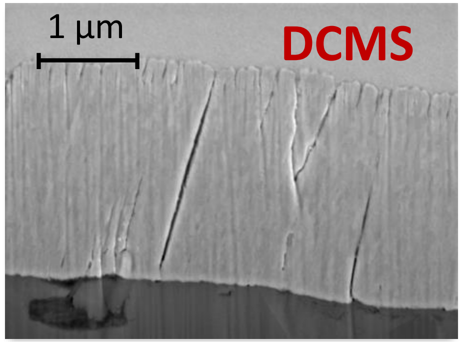


Graph from Carlota Pereira Carlos, FCC week 2023

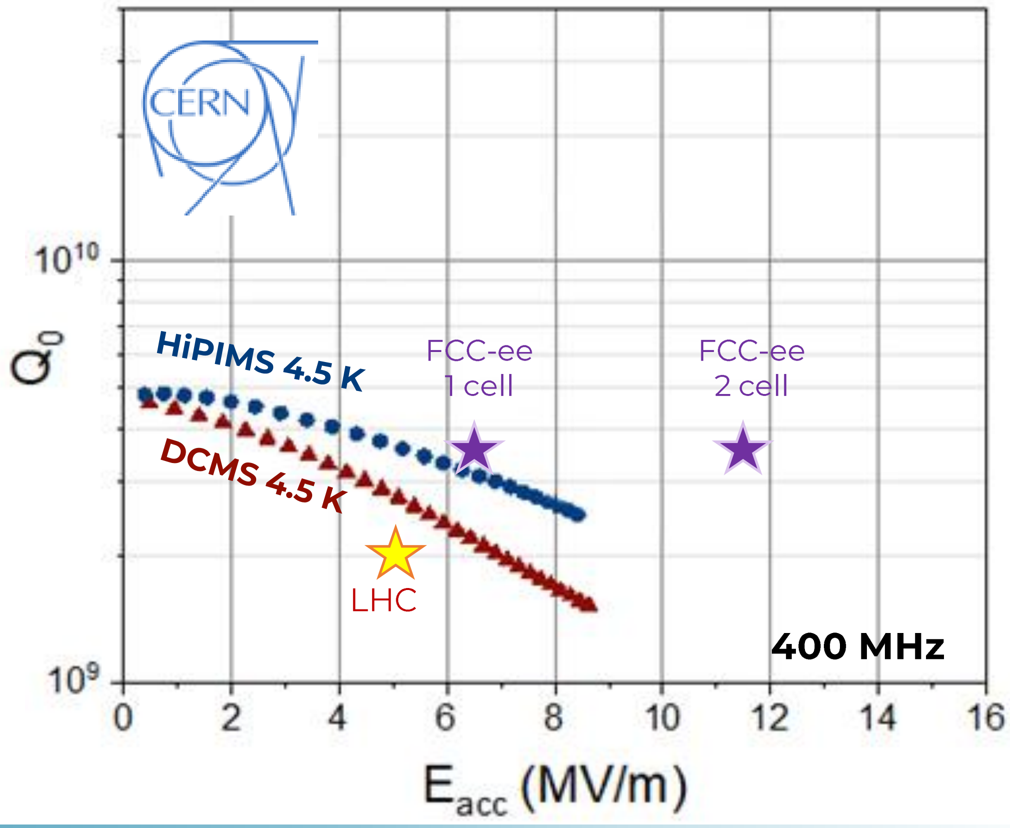
SRF R&D @CERN for FCC

HiPIMS technology densifies the Nb coating and increases RF performances compared to DCMS





Carlota Pereira Carlos, FCC week 2023 (elaborated)



R&D @CERN also on cavity forming (hydroforming), polishing (EP), Cu oxide layer, Nb_3Sn by HiPIMS