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Ernst Gombrich: The Man and His Art \*. Ernst Gombrich: Essays in Iconology \*. Ernst Gombrich: The Story of Art \*. 100% Done! Download the Gombrich Book Now!.The present invention is directed to a method of manufacturing a semiconductor device and, more particularly, to a method of manufacturing a semiconductor device having a high-k metal gate and a titanium nitride cap. To meet the high integration demands of semiconductor devices, the gate dielectric layer used in a metal oxide semiconductor field-effect transistor (MOSFET) must have a dielectric constant of 3.0 or lower. The dielectric constant of conventional silicon oxide is in the range of about 4.0 to about 4.2, which is higher than that of a silicon oxide layer formed from high-k material. In particular, the high-k material is used as a gate dielectric layer to achieve a high-k metal gate. The high-k metal gate allows the gate dielectric layer to have a high dielectric constant, e.g., greater than or equal to about 4.0, while still maintaining a low leakage current, e.g., less than or equal to about 0.1  $\mu\text{A}/\text{cm}^2$ . However, the high-k metal gate requires a capping layer for preventing metal contamination into the interface between the high-k metal gate and the source/drain regions of the substrate. A gate and a capping layer are typically formed by depositing a high-k metal layer, a nitride cap layer, and a gate cap layer on a substrate, and then annealing the deposited layers to form a gate structure. The capping layer, including the gate cap layer, protects the interface between the high-k metal gate and the semiconductor substrate from metal contamination. However, the fabrication of the high-k metal gate requires a high temperature anneal process, e.g., greater than or equal to about 850°C., which may damage the gate cap layer. Accordingly, there is a need for a method of manufacturing a semiconductor device which does not have the above mentioned drawbacks. An advantage of the present invention is a method of manufacturing a semiconductor device, including forming a first high-k metal gate electrode layer on a semiconductor substrate. A capping layer is formed on the first metal gate

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