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# Intense pulsed light, a promising technique to develop molybdenum sulfide catalysts for hydrogen evolution

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## Abstract

We have demonstrated a simple and scalable fabrication process for defect-rich MoS<sub>2</sub> directly from ammonium tetrathiomolybdate precursor using intense pulse light treatment in milliseconds durations. The formation of MoS<sub>2</sub> from the precursor film after intense pulsed light exposure was confirmed with XPS, XRD, electron microscopy and Raman spectroscopy. The resulting material exhibited high activity for the hydrogen evolution reaction (HER) in acidic media, requiring merely 200 mV overpotential to reach a current density of 10 mA cm<sup>-2</sup>. Additionally, the catalyst remained highly active for HER over extended durability testing with the overpotential increasing by 28 mV following 1000 cycles. The roll-to-roll amenable fabrication of this highly-active material could be adapted for mass production of electrodes comprised of earth-abundant materials for water splitting applications.

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

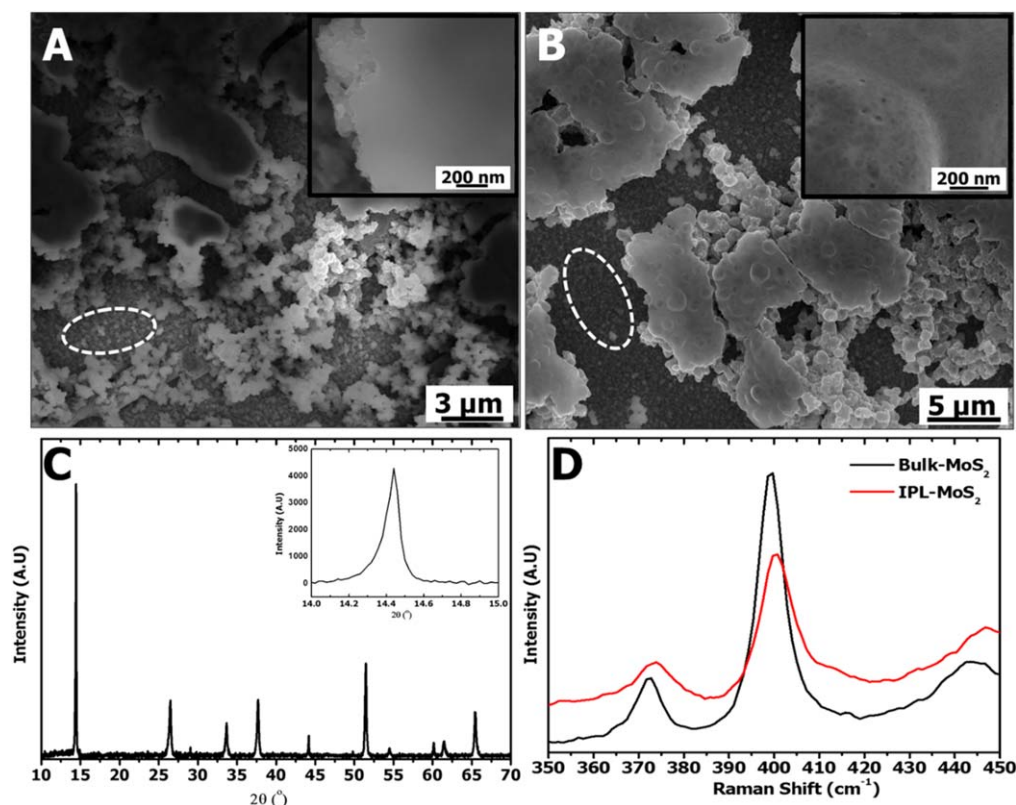
Keywords: MoS<sub>2</sub>, intense pulsed light, hydrogen evolution

(Some figures may appear in colour only in the online journal)

## 1. Introduction

Hydrogen production via electrocatalysis is a promising route for storing excess energy from renewable sources (such as wind or solar) during off-peak energy consumption hours. In addition to its use as an energy carrier, molecular hydrogen is an important chemical feedstock with applications in ammonia production, hydrocracking, hydrodesulfurization, and other industries. Platinum and other noble metals are efficient catalysts for the hydrogen evolution reaction (HER) [1]; however, they are scarce and expensive [2]. Earth-abundant alternative catalysts [3], including metal carbides, nitrides, and sulfides [4, 5], are promising candidates to achieve electrocatalytic hydrogen production [6].

Among these catalysts, molybdenum disulfide (MoS<sub>2</sub>) has been explored widely for hydrogen production [7, 8] due to its environmental benignity, high stability in acidic environments, and good catalytic activity. MoS<sub>2</sub> is a transition metal dichalcogenide with an Mo layer sandwiched between two sulfur layers with weak Van der Waals forces in a trigonal prismatic arrangement [9, 10]. The edges of sheet-like MoS<sub>2</sub> are active sites for HER, with the basal plane being catalytically inert, so a greater concentration of edge sites is associated with better catalytic activity [11]. There has been tremendous effort put into the preparation of active MoS<sub>2</sub> structures via solvent-assisted exfoliation [12], chemical exfoliation [13, 14], hydrothermal synthesis [15], intercalation-aided exfoliation [16], chemical vapor deposition [17, 18], thermal annealing of

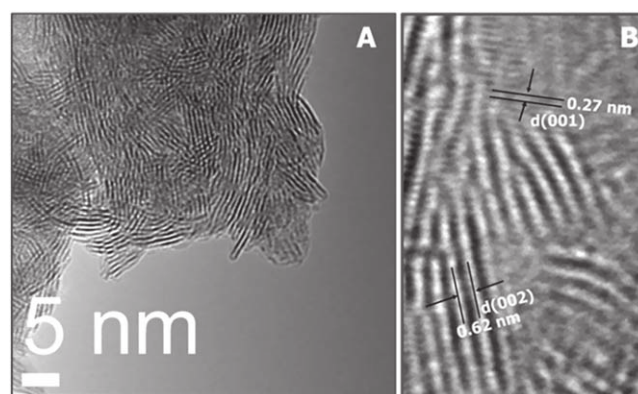


**Figure 1.** MoS<sub>2</sub> structural analysis (A) ammonium thiomolybdate precursor film on FTO-coated glass substrate (B) IPL treated MoS<sub>2</sub> film on FTO-coated glass substrates (white dotted circles display the FTO surface morphology) (C) XRD spectrum of IPL-MoS<sub>2</sub> film, (D) Raman spectra from bulk MoS<sub>2</sub> and IPL-MoS<sub>2</sub> structures.

MoS<sub>2</sub> precursor materials [19], and electrochemical synthesis [20]. The large-scale preparation of MoS<sub>2</sub> films by chemical vapor deposition, and nanosheets by solution-based chemical exfoliation, has also been reported [21]. Industrial implementation of most of these fabrication methods is somewhat impractical due to sophisticated synthesis procedures with processing steps including high vacuum, high temperature, H<sub>2</sub>S gas flow, and/or inert atmosphere conditions. Here, we report a novel one-step, extremely fast, and scalable fabrication method for defect-rich MoS<sub>2</sub> using the intense pulsed light (IPL) technique.

IPL, also known as photonic sintering, imparts rapid intense pulses of light to provide localized heating and/or induce chemical reactions in an absorbing thin film. The IPL unit essentially contains a xenon flash lamp, a capacitor bank, and coil circuitry which cooperatively generate a burst of intense light. The treatment is carried out within a millisecond time frame which is desirable from a processing standpoint. The light energy is absorbed by the thin film and almost immediately released as heat, inducing very localized temperatures of several hundred degrees centigrade. Process parameters include the input energy density, pulse duration, and number of pulses. The IPL technique has been utilized for processing metal nanoparticles and semiconductor materials for various applications [22].

This study highlights the rapid means of preparing MoS<sub>2</sub> structures with high edge site concentration from precursor-coated films using IPL for the first time. The structural



**Figure 2.** High-resolution TEM images of IPL-MoS<sub>2</sub> nanosheets (A) Defect-rich MoS<sub>2</sub> nanosheets (B) TEM image showing the interplanar spacing between (100) planes and layer-to-layer spacing.

properties of the resulting material (IPL-MoS<sub>2</sub>) were analyzed using x-ray diffraction (XRD), Raman, scanning electron microscopy, transmission electron microscopy (TEM) and x-ray photoelectron spectroscopy (XPS) and compared with those of bulk MoS<sub>2</sub>. IPL-MoS<sub>2</sub> was further characterized in terms of its electrochemical activity for HER and compared with bulk MoS<sub>2</sub>. Electrochemical characterization reveals that IPL-MoS<sub>2</sub> exhibits catalytic activity superior to bulk crystalline MoS<sub>2</sub> and is among the most highly active reported MoS<sub>2</sub> catalysts obtained from various treatments for HER [6].

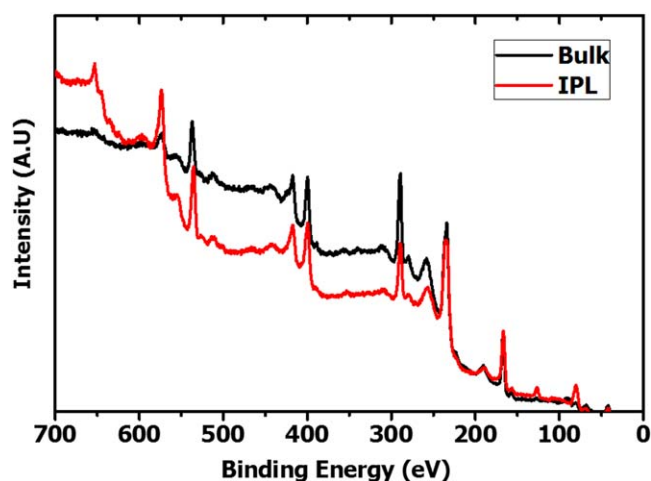


Figure 3. XPS spectrum of bulk MoS<sub>2</sub> and IPL-MoS<sub>2</sub> samples.

## 2. Methods

### 2.1. Materials

Bulk molybdenum sulfide powder with an average particle size of 6  $\mu\text{m}$  was purchased from Sigma Aldrich. Ammonium tetrathiomolybdate powder was supplied by Beantown Chemical. Ethanol (200 proof) was obtained from Decon Labs. Twice-deionized Millipore water (18 M $\Omega$  cm) was used. FTO-coated glass was obtained from Hartford Glass Company, Hartford City, IN. Sulfuric acid (ACS grade) was purchased from VWR. Compressed nitrogen and hydrogen gases were provided by Welders Supply, Louisville, KY.

### 2.2. MoS<sub>2</sub> film preparation and IPL processing

The precursor solution was prepared by mixing 0.157 g of ammonium tetrathiomolybdate in 2:1 v/v water and ethanol solvent for a total of 6 ml. The solution was sonicated for two hours and subsequently filtered through a 250 nm nylon filter. The same procedure was used to prepare the bulk crystalline MoS<sub>2</sub> solution. The filtered solution was drop casted on FTO-coated glass substrates (for material characterization) or glassy carbon electrodes (GCE, for electrochemical testing) with a loading of approximately 1.3 mg cm<sup>-2</sup>. The GCEs were rotated ( $\sim$ 400 RPM) during dropcasting to obtain a relatively uniform film, while the FTO substrates were not. The air-dried films were IPL treated with a total number of 10 repeated pulses with each pulse producing 25 J cm<sup>-2</sup> energy density and having a 2 ms duration. The Sinteron 2000-L IPL apparatus and full-spectrum UV-to-near-IR lamp were purchased from xenon.

### 2.3. Experimental set-up for HER

Electrochemical characterization was carried out using a Metrohm Autolab PGSTAT302N potentiostat/galvanostat in potentiostat mode with a MSR electrode rotator from Pine Research. Replaceable-tip glassy carbon working electrodes were purchased from Pine Research (E4TQ Changedisk

series). A five-neck electrochemical cell from Pine Research was filled with 0.5 M H<sub>2</sub>SO<sub>4</sub> electrolyte. A graphite rod inside a glass frit (Pine Research) was used as the counter electrode. An Ag/AgCl reference electrode, calibrated versus RHE (223.1 mV versus RHE), was used to determine the absolute potential throughout electrochemical experiments. A glass diffuser (Pine Research) was used to bubble gas into the electrolyte. Platinum meshes (Alfa Aesar, 99.9% metals basis) were used to calibrate measured potentials versus RHE. A platinum ring (Pine Research, E6R2 Fixed-Disk RRDE Tip) was used to measure the HER activity of platinum.

### 2.4. Characterization of MoS<sub>2</sub> films

XRD was carried out using a Bruker Discovery D8 x-ray diffractometer equipped with an x-ray source of Cu K $\alpha$  ( $\lambda = 0.1548$  nm) and operated at a scan rate of 2 s/step and a step size of 0.02°. Raman spectroscopy was performed using a Renishaw Raman Spectrometer equipped with a red laser of 632 nm. The power of the red laser was kept below 1 mW to prevent over heating of the sample, and the emission was collected with an integrated CCD camera by dispersing with a 1800 lines mm<sup>-1</sup> grating. TEM analysis was carried out using a FEI Tecnai F20 TEM equipped with a field emission gun (FEG) and operated at 200 kV of accelerating voltage. Microstructures of the films were characterized using a FEI Nova NanoSEM 600 with an accelerating voltage of 10 kV and a working distance of 5 mm. XPS was carried out using a VG Scientific MultiLab 3000 ultra-high vacuum surface analysis system with CLAM4 hemispherical electron energy analyzer and a dual-anode Mg/Al x-ray source. All measurements were performed using non-monochromatic Al K $\alpha$  ( $h\nu = 1486.6$  eV) x-ray radiation under a base chamber pressure in the low 10<sup>-8</sup> Torr range. For each sample, a survey scan from 0 to 1000 eV was collected to identify all elemental peaks. This was followed by the acquisition of high-resolution Mo 3d, S 2p, C 1s and O 1s spectra. An intrinsic C 1s peak at 284.5 eV was used for the binding energy calibration. The analysis of XPS spectra (background subtraction and peak deconvolution) was performed using XPSPEAK4.1 software. The background curves were fitted with a Shirley function.

Electrochemical characterization was done using linear sweep voltammetry, cyclic voltammetry, and frequency response analysis techniques. To obtain polarization/Tafel plots, the potential was swept from 0.1 to  $-0.6$  V versus RHE at a rate of 5 mV s<sup>-1</sup>. For activation/durability testing, the potential was swept from 0.1 to  $-0.35$  and back to 0.1 V versus RHE at 50 mV s<sup>-1</sup> repeatedly. All measured potentials were calibrated to the RHE scale after the experiment (to avoid platinum contamination) by saturating the electrolyte with H<sub>2</sub> gas, conducting cyclic voltammetry repeatedly between platinum working and counter electrodes, and taking the average potential versus the reference electrode at zero current.



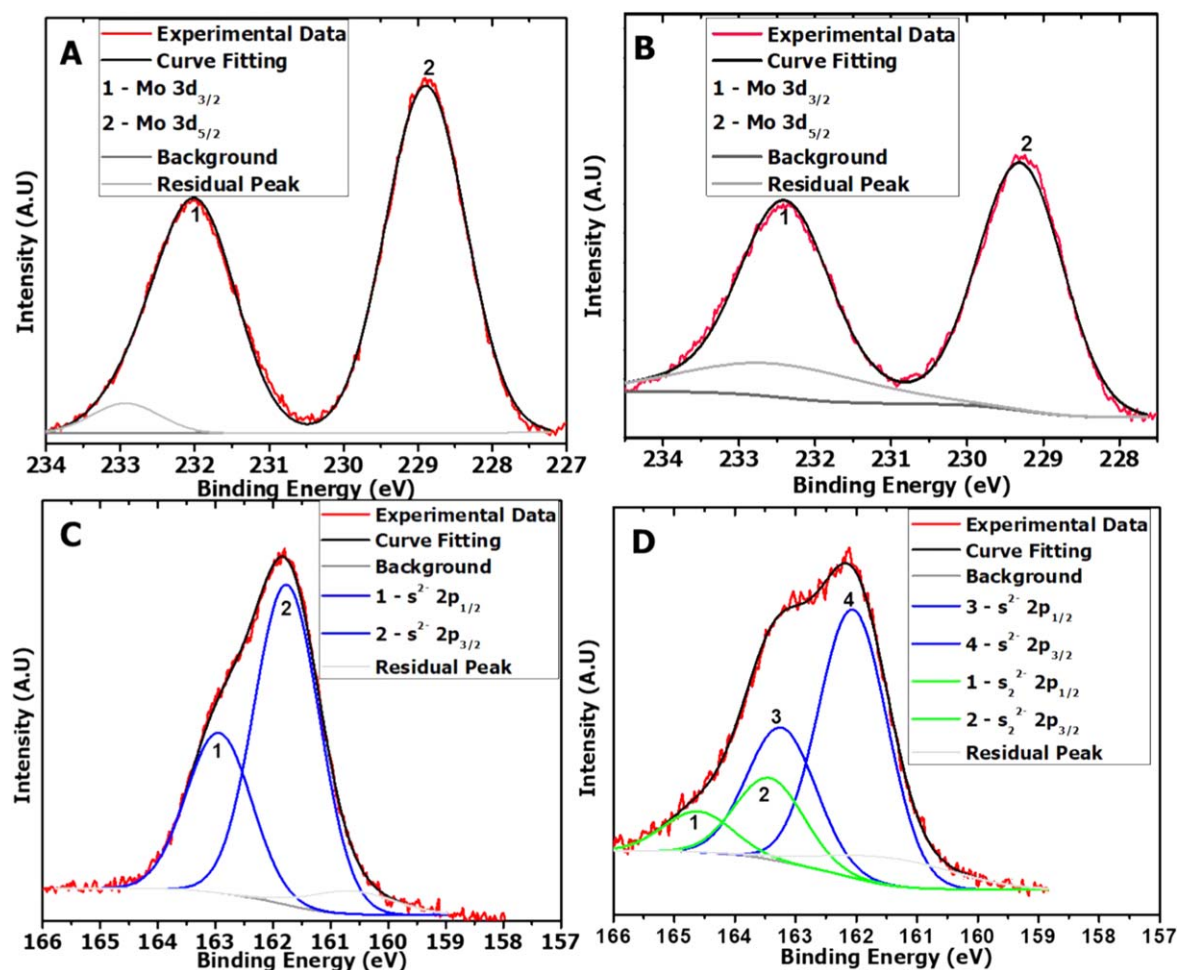


Figure 4. XPS elemental analysis of bulk MoS<sub>2</sub> (A) and (C) and IPL-MoS<sub>2</sub> (B) and (D) structures.

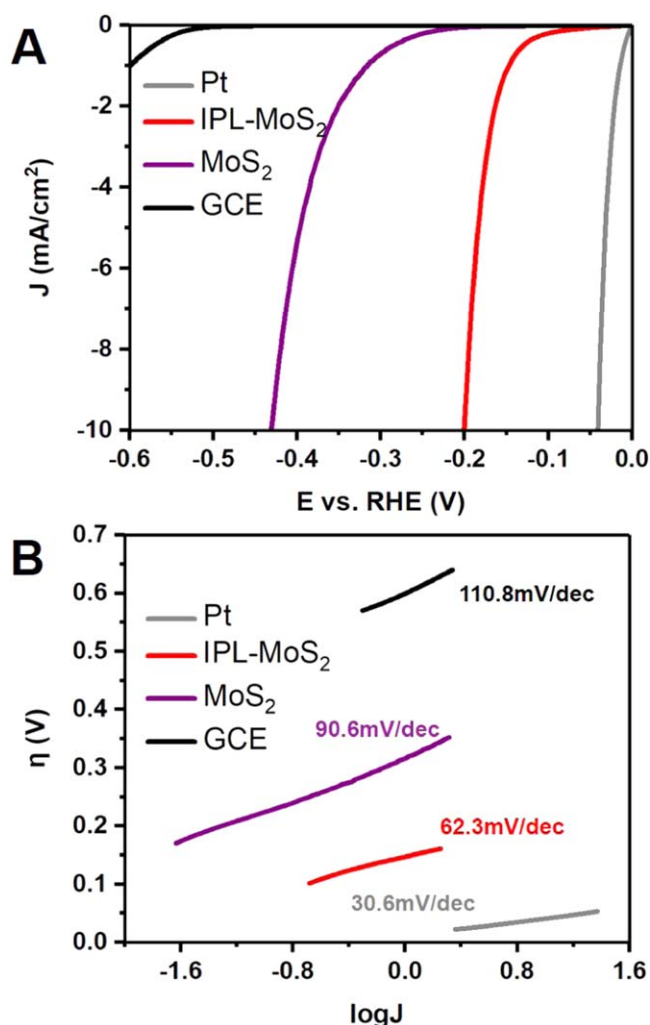
### 3. Results and discussion

The surface morphology analysis of the ammonium tetrathiomolybdate precursor film before and after IPL exposure reveals an obvious morphological change after IPL treatment (figures 1(A) and (B)). The films consist of thick micron-scale assemblies. However, the larger features with smooth surface morphology transformed to aggregates after IPL, which is similar to sintering that has been demonstrated before with IPL [23–25]. The high-resolution images of IPL-treated film clearly exhibit rough surface morphology compared to as-deposited precursor film. To investigate whether this morphological change led to MoS<sub>2</sub> structure, XRD was carried out on IPL-MoS<sub>2</sub>. The crystallographic structural analysis of IPL-MoS<sub>2</sub> revealed the successful conversion of precursor material into MoS<sub>2</sub> structure. The XRD reflection peak at 14.4°, corresponds to hexagonal MoS<sub>2</sub> phase (JCPDS card No. 73-1508) (figure 1(C)). The majority of the other reflections (26.5°, 33.5°, 37.7°, 51.6°, 54.4°, 61.6° and 65.5°) originate from the underlying FTO substrate. Comparative XRD patterns (figure S1 is available online at [stacks.iop.org/NANO/30/175401/mmedia](https://stacks.iop.org/NANO/30/175401/mmedia)) show the presence of the reflection at 14.4° in IPL-MoS<sub>2</sub> and the absence of this reflection in the precursor. The calculated d-spacing, using the

diffraction angle at 14.4° which corresponds to the (002) crystal plane, is 0.615 nm which is similar to that of 2H-MoS<sub>2</sub> (0.62 nm).

Further investigation of structural transformation from precursor to MoS<sub>2</sub> nanosheets was carried out using Raman spectroscopy and compared with the spectra from bulk MoS<sub>2</sub> structures. The Raman spectra reveal that E<sub>2g</sub> (373.8 cm<sup>-1</sup>) and A<sub>1g</sub> (400.2 cm<sup>-1</sup>) peaks from IPL-MoS<sub>2</sub> match the corresponding E<sub>2g</sub> (372.3 cm<sup>-1</sup>) and A<sub>1g</sub> (399.2 cm<sup>-1</sup>) peaks from bulk MoS<sub>2</sub>, confirming the IPL-assisted conversion of precursor film to MoS<sub>2</sub> (figure 1(D)). Raman spectra from 300 to 500 cm<sup>-1</sup> are shown in figure S2. The dominant phase exhibited by both IPL and bulk MoS<sub>2</sub> materials was 2H-MoS<sub>2</sub>. There is a broad peak between 440 and 450 cm<sup>-1</sup>, and attributing this peak to MoS<sub>2</sub> is an open question. The peak at 454 cm<sup>-1</sup> was previously assigned to the double frequency of the LA(M) mode (227 cm<sup>-1</sup>), and the peak at 440 cm<sup>-1</sup> was predicted to be Mo–S vibrations for oxysulfide species [26–28]. However, further investigation is required to confirm if there is any oxysulfide species in IPL and bulk MoS<sub>2</sub> materials which is beyond the scope of this study.

Further probing of morphological and structural properties of the IPL-MoS<sub>2</sub> was conducted using TEM. Analysis of the films reveals that there are highly-corrugated lattice



**Figure 5.** Electrochemical activity of the molybdenum sulfide catalyst following IPL treatment (IPL-MoS<sub>2</sub>, red trace) in 0.5 M H<sub>2</sub>SO<sub>4</sub>. Included for comparison purposes are electrochemical activities of platinum metal (Pt, gray trace), bulk crystalline molybdenum sulfide (MoS<sub>2</sub>, purple trace), and bare glassy carbon electrode (GCE, black trace) in 0.5 M H<sub>2</sub>SO<sub>4</sub>. The polarization plot (A) shows that the molybdenum sulfide catalyst exhibits high activity for HER, and the Tafel plot (B) compares kinetic attributes of various materials for HER.

fringes across the sample. This implies that there are many defects and distortions within the structures. TEM images reveal mostly short clusters with discontinuous, bending, disjointed, and curved basal planes resulting in a highly defective MoS<sub>2</sub> structure (figure 2(A)). The interlayer d-spacing is found to be 0.62 nm (figure 2(B)), confirming the XRD results. The individual planes are curved or bent which indicates disordered atomic arrangement. This, together with the fact that most clusters are short segments, indicates high density of edge sites, which are responsible for improved HER performance. High-resolution TEM images were obtained at different areas of the sample (figure S3); these micrographs exhibited very similar defect structure which signifies homogeneity of the sample. To investigate the mechanism of IPL-assisted MoS<sub>2</sub> formation from the

precursor materials, XPS analysis of molybdenum (Mo) and sulfur (S) elements in both bulk MoS<sub>2</sub> and IPL-MoS<sub>2</sub> was carried out.

A survey scan was acquired from 1 to 1000 eV. Detailed analysis on Mo and S elements was subsequently conducted by collecting high-resolution spectra of main Mo and S peaks. The survey spectra from IPL-MoS<sub>2</sub> and bulk MoS<sub>2</sub> are similar to each other (figure 3).

Mo and S peaks were detected in addition to C and O impurity peaks. The binding energies of Mo 3d<sub>5/2</sub> are 228.9 and 229.3 eV for bulk MoS<sub>2</sub> and IPL-MoS<sub>2</sub> respectively, indicating +4 oxidation state for the Mo ion [29], whereas the binding energies for the Mo 3d<sub>3/2</sub> are 232 and 232.4 eV for the bulk and IPL-MoS<sub>2</sub> samples respectively (figures 4(A) and (B)). The binding energy difference between Mo 3d<sub>5/2</sub> and Mo 3d<sub>3/2</sub> is 3.1 eV for the both bulk and IPL-MoS<sub>2</sub> samples. The energy difference of 3.1 eV is a characteristic of Mo species. The S 2p spectrum of IPL-MoS<sub>2</sub> exhibited a broad peak which was further deconvoluted. This resulted in two doublets with the S 2p<sub>3/2</sub> and S 2p<sub>1/2</sub> states. The highest area doublet exhibited peaks at 162.0 and 163.3 eV for S 2p<sub>3/2</sub> and S 2p<sub>1/2</sub> states respectively, whereas the lowest area doublet displayed peaks at 163.5 and 164.6 eV for S 2p<sub>3/2</sub> and S 2p<sub>1/2</sub> states respectively. In case of bulk MoS<sub>2</sub>, the S 2p<sub>3/2</sub> and S 2p<sub>1/2</sub> states showed peaks at 161.8 and 163 eV, respectively. The single doublet with S 2p<sub>3/2</sub> around 161.8 eV is typical for S<sup>2-</sup> ligands that form MoS<sub>2</sub>. This suggests that the bulk MoS<sub>2</sub> powder might not have any other forms of S ligands, whereas the second doublet peak from IPL-MoS<sub>2</sub> with S 2p<sub>3/2</sub> at 163.5 eV indicates the existence of S<sub>2</sub><sup>2-</sup> ligands.

Muijsers *et al* conducted a sulfidation study on molybdenum oxide. The peak positions of S 2p for different intermediate compounds and the final MoS<sub>2</sub> structure after thermal decomposition has been assigned [29, 30]. In the case of the IPL-MoS<sub>2</sub> sample, the S 2p<sub>3/2</sub> peak at 163.5 eV can be attributed to bridging/apical S<sup>2-</sup>. This indicates the existence of a small portion of intermediate complexes present in the IPL-MoS<sub>2</sub> sample. The area ratio of the lowest intensity doublet to the highest intensity doublet is 0.3, which signifies that most of the precursor transformed to MoS<sub>2</sub> with minor amounts of intermediate complexes. The melting temperature of ammonium tetrathiomolybdate is approximately 155 °C, which is much lower than the temperature attained from the IPL process. This rapid thermal process might cause decomposition and sublimation of the sulfur and ammonium, which might create a large defect density in the film.

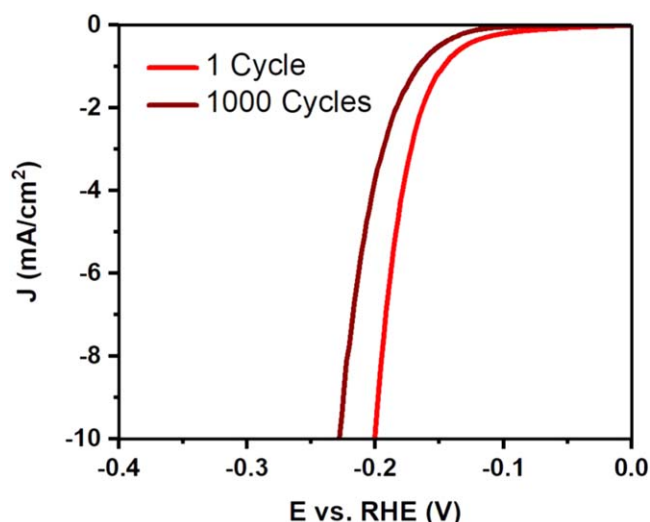
In addition, rapid heat treatment of the samples in milliseconds time scale might not fully reduce some of the sulfur atoms which can form bridging or terminal groups of MoS<sub>2</sub> structure. The IPL treated films still might have different forms of S atoms along with the S<sup>2-</sup> basal plane.

Based on the preceding observations, and other observations reported in literature, we propose the following mechanism for the conversion of tetrathiomolybdate to molybdenum disulfide [31]:



**Table 1.** Comparison of HER overpotentials and Tafel slopes for IPL-MoS<sub>2</sub> and other reported molybdenum sulfide catalysts.

MoS <sub>2</sub> catalyst	Overpotential (mV) @ 10 mA cm <sup>-2</sup>	Tafel slope (mV dec <sup>-1</sup> )
IPL-MoS <sub>2</sub> (this study)	200	62.3
Core-shell MoO <sub>3</sub> -MoS <sub>2</sub> nanowires [34]	~250	50–60
MoS <sub>2</sub> NSs-550 [35]	~200	68
Amorphous molybdenum sulfide [36]	200	60
1T-MoS <sub>2</sub> [13]	187	43
Defect-rich MoS <sub>2</sub> nanosheets [37]	~150	50
MoS <sub>2</sub> /RGO [38]	~150	41

**Figure 6.** Polarization curves for IPL-MoS<sub>2</sub> after activation (1 Cycle, red trace) and after 1000 cycles at reductive potential (1000 cycles, brown trace).

Electrochemical characterization was carried out on GCEs in a three-electrode cell. Dropcasting the precursor solution onto the GCE over rotation and then treating with IPL yields a rough IPL-MoS<sub>2</sub> film with thickness of approximately 20  $\mu\text{m}$  (figure S4). The diffusion length of a light pulse through a metal or semiconductor film has been shown to be on the order of hundreds of micrometers [32]. Therefore, local variations of film thickness should not significantly affect the conversion. Other factors affecting the conversion include number of pulses, energy density, and pulse duration [33]. Detailed mechanistic and optimization studies on the IPL-assisted conversion of ammonium tetrathiomolybdate to IPL-MoS<sub>2</sub> are currently underway. All potentials have been iR compensated and calibrated versus RHE. A polarization plot comparing the activity of IPL-MoS<sub>2</sub> with other representative HER catalysts is depicted in figure 5(A). IPL-MoS<sub>2</sub> exhibits an onset overpotential for HER around 100 mV with an overpotential required to reach 10 mA cm<sup>-2</sup> (a benchmark for solar water-splitting applications) of approximately 200 mV. IPL-MoS<sub>2</sub> shows similar activity on FTO-coated glass substrate (figure S5). The low overpotential observed for IPL-MoS<sub>2</sub> is compared with

overpotentials reported for other highly-active MoS<sub>2</sub> electrocatalysts in table 1.

The thermodynamics involved in the hydrogen evolution process for MoS<sub>2</sub> have previously been detailed extensively via density functional theory [11]. The active sites for hydrogen evolution in MoS<sub>2</sub> are the sulfur edges. At more positive potentials ( $> -80$  mV versus RHE), proton coverage (number of protons bound to sulfur edges sites) is low and proton adsorption is thermodynamically downhill, but proton reduction is thermodynamically unfavorable due to the strength of S–H bonds. At more negative potentials ( $< -80$  mV versus RHE), proton coverage is higher, so both proton adsorption and proton reduction to yield H<sub>2</sub> are thermodynamically favorable. The  $-100$  mV versus RHE onset of hydrogen evolution for IPL-MoS<sub>2</sub> is consistent with these calculations and suggests that IPL-MoS<sub>2</sub> effectively minimizes energetic and kinetic barriers for HER in contrast with bulk crystalline MoS<sub>2</sub> for which hydrogen evolution begins around  $-200$  mV versus RHE.

HER kinetics can be expressed by the following three steps: the Volmer step (adsorption of proton onto the catalyst surface), the Heyrovsky step (combination of an adsorbed hydrogen with an electron and solution proton), or alternatively the Tafel step (combination of two adsorbed hydrogens). Combination of either the Volmer and Heyrovsky steps or the Volmer and Tafel steps yields H<sub>2</sub>. Tafel slopes are used to give insights into the rate-limiting step for a given HER catalyst. However, determination of the HER mechanism from the Tafel slope alone is unfeasible as multiple mechanisms often occur simultaneously. Nevertheless, the significant difference between the Tafel slopes of IPL-MoS<sub>2</sub> and bulk crystalline MoS<sub>2</sub> (figure 5(B)) implies vastly different surface chemistry between the two materials with IPL-MoS<sub>2</sub> having faster reaction kinetics. The Tafel slope observed for IPL-MoS<sub>2</sub> is in line with Tafel slopes previously reported for other highly-active MoS<sub>2</sub> catalysts ( $\sim 60$  mV dec<sup>-1</sup>) [34, 36, 39]. On other hand, the Tafel slope for bulk MoS<sub>2</sub> is around 90.6 mV dec<sup>-1</sup>. These results indicate that the proton adsorption is the limiting step for the bulk MoS<sub>2</sub>.

Included for comparison purposes in figure 5 are the polarization curves and Tafel plots for platinum metal (Pt) and bare GCE substrate. Platinum, which is currently regarded as the best HER catalyst, significantly outperforms both IPL-MoS<sub>2</sub> and bulk crystalline MoS<sub>2</sub> in terms of onset,



overpotential, and Tafel slope. Although the performance gap between IPL-MoS<sub>2</sub> and Pt remains significant, IPL-MoS<sub>2</sub> represents significant progress when compared to bulk crystalline MoS<sub>2</sub>.

In order to investigate the long-term durability of the IPL-MoS<sub>2</sub> material under reductive operating conditions, the material was cycled from 0.1 to −0.35 and back to 0.1 V versus RHE 1000 times. Throughout this extended cycling, an LSV was taken periodically in order to quantify the performance/degradation of the material at various points. Figure 6 compares polarization curves taken immediately after activation and after 1000 reductive cycles. The overpotential of the material increases by only 28 mV after 1000 cycles, implying high stability for HER in acidic media.

#### 4. Conclusions

In conclusion, we report an extremely rapid and benign way to prepare a class of MoS<sub>2</sub> catalysts using an IPL technique. The precursor can be readily converted to MoS<sub>2</sub> with short pulses of light in a few seconds. The conversion of the precursor was demonstrated with XRD and Raman. TEM analysis confirmed that the IPL processed MoS<sub>2</sub> had multiple edge sites that would be beneficial to the HER reaction. A large amount of defect states presented by varying sulfur species at the defects was shown with XPS and confirms the mechanism of improved HER. This presents a significant opportunity to prepare several classes of catalysts that are practically feasible and do not employ vacuum or hydrothermal techniques.

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