



Cite this: *Sens. Diagn.*, 2024, **3**, 1406

Received 2nd May 2024,  
Accepted 24th July 2024

DOI: 10.1039/d4sd00140k

[rsc.li/sensors](https://rsc.li/sensors)

## Direct writing of graphene electrodes for point-of-care electrochemical sensing applications

Lei Zhao, <sup>\*abc</sup> Andrew Piper, <sup>\*b</sup> Giulio Rosati <sup>\*b</sup> and Arben Merkoçi <sup>\*bd</sup>

Electrochemical sensors are increasingly garnering attention as valuable tools for point-of-care (POC) testing due to their low costs, high sensitivities, and ease of miniaturization. Graphene-based materials, renowned for their tunable electrical conductivity, high specific surface areas, versatile functionality, and biocompatibility; are highly suited for the fabrication of electrochemical sensors with heightened sensitivities. Non-contact, maskless, direct writing methods allow the rapid, large-scale production of graphene electrodes with high design flexibility. Researchers globally are advancing graphene electrode production, aiming for smaller, faster, and more efficient sensors. This review provides a comprehensive overview of recent advances on the direct writing of graphene electrodes for electrochemical sensing applications. It covers the basics of direct writing techniques, the advancements in graphene ink/precursor preparation, structural design, and device integration, with a focus on POC platforms.

### 1 Introduction

The escalating significance of healthcare, food safety control, and environmental preservation underscores the pressing need for precise disease diagnostics and accurate contaminant detection. Established methodologies such as chromatography, mass spectrometry, spectroscopy, polymerase chain reaction, and enzyme-linked immunosorbent assays have conventionally addressed these exigencies.<sup>1–3</sup> Nevertheless, their protracted procedures and intricate protocols necessitate specialized personnel and sophisticated equipment, thereby presenting substantial challenges, particularly in resource-limited settings. Electrochemical sensors have emerged as a compelling

<sup>a</sup> Research Center for Translational Medicine, Medical Innovation Center and State Key Laboratory of Cardiology, Shanghai East Hospital, The Institute for Biomedical Engineering & Nano Science, Tongji University School of Medicine, Shanghai, 200120, China. E-mail: [leizhao@tongji.edu.cn](mailto:leizhao@tongji.edu.cn)

<sup>b</sup> Catalan Institute of Nanoscience and Nanotechnology (ICN2), BIST, and CSIC, Edifici ICN2, Campus UAB, Bellaterra, 08193, Barcelona, Spain.

E-mail: [andrew.piper@icn2.cat](mailto:andrew.piper@icn2.cat), [giulio.rosati@icn2.cat](mailto:giulio.rosati@icn2.cat), [arben.merkoci@icn2.cat](mailto:arben.merkoci@icn2.cat)

<sup>c</sup> Department of Chemical Engineering, School of Engineering, Campus UAB, Bellaterra, 08193, Barcelona, Spain

<sup>d</sup> Catalan Institution for Research and Advanced Studies (ICREA), Passeig de Luísls Companys, 23, 08010, Barcelona, Spain



Lei Zhao

Dr. Lei Zhao obtained his Master's degrees in Chemistry from Southwest University in China and doctor's degree in Biotechnology from UAB in Spain. His research is focused on low-cost fabrication of graphene and other nanomaterial-based electrochemical biosensors using direct writing techniques for practical applications. Currently he is a postdoctoral researcher at Tongji University focusing on the development of bioelectronics.



Andrew Piper

Dr. Andrew Piper has an undergraduate taught masters in Medicinal and Biological Chemistry and PhD in nanoelectrode biosensors from the University of Edinburgh. He has since held post-doctoral research positions at the University of Oxford, KTH Royal institute of technology, the Karolinska Institute and now the Catalan institute of nanoscience and nanotechnology (ICN2). His research is focused on the development of point-of-care diagnostics.



alternative owing to their cost-effectiveness, high sensitivity/selectivity, facile miniaturization, and user-friendly operation.<sup>4–7</sup> They facilitate the transformation of physical, biological, and chemical information into easily measurable electrical signals, which can be recorded using simple, portable setups. Consequently, electrochemical platforms hold great promise for revolutionizing point-of-care (POC) devices. In order to be considered true POC diagnostic devices, they should comply with the WHO's REASSURED criteria, which states that tests should have real time connectivity, be environmentally friendly, affordable, sensitive, specific, user-friendly, rapid, equipment free and deliverable.<sup>8</sup>

Graphene derivatives are excellent candidates for electrode fabrication in electrochemical sensing applications, owing to their remarkable attributes such as high surface area, tunable conductivity, and good biocompatibility.<sup>9–11</sup> Graphene is ideally a single carbon atom-thick sheet consisting of a hexagonal network with no defect sites.<sup>12</sup> It shows remarkable conductivity ( $200\,000\text{ cm}^2\text{ V}^{-1}\text{ s}^{-1}$ ) with a theoretical specific surface area as high as  $2630\text{ cm}^2\text{ g}^{-1}$ . Low-defect graphene is expensive to produce and tends to aggregate in most solvents, due to  $\pi$ - $\pi$  stacking and van der Waals interactions, making it difficult to process.<sup>13</sup> Graphene oxide (GO) retains the high surface area and flexibility of graphene, while the hydrophilic oxygen-containing groups (hydroxyl, carbonyl, carboxyl and epoxy groups) make it soluble and easy to functionalize in aqueous solutions.<sup>14</sup> The functional groups change the carbon atoms from  $\text{sp}^2$  to  $\text{sp}^3$ , which disrupts the graphene lattice, making GO thermally insulating and electrically resistive. The poor conductivity leads to an unfavorable electrochemical interface for sensing. To solve this problem, the oxygen-containing groups can be partially removed, resulting in reduced graphene oxide (rGO) with improved conductivity and fewer defect sites.<sup>15</sup>

Despite recent advances in graphene production, the fabrication of graphene electrodes remains slow and costly. Photolithography patterns graphene with high precision/resolution,<sup>16</sup> but is limited by the need for expensive equipment and clean room facilities. Screen printing,<sup>17</sup> gravure printing,<sup>18</sup> and contact-transfer printing<sup>19</sup> are promising alternatives, but require pre-patterned templates, which does not allow the rapid and facile iteration of electrode designs as well as being wasteful and expensive.

Recently, direct writing methods, also known as “digital writing” or “digital printing”, have been the subject of much research in the field of graphene electrode production.<sup>20,21</sup> Direct writing encompasses a set of maskless techniques for material patterning based on computer-aided digital designs; they show great potential for the simple, rapid, and scalable patterning of electrodes with high design flexibility.<sup>22,23</sup> Various direct writing systems have been employed to fabricate graphene electrodes, including direct ink writing,<sup>24–26</sup> 3D printing,<sup>27</sup> and direct laser writing.<sup>22</sup> These techniques allow customization of graphene electrode design, morphology, chemical composition, and conductivity. As such they can be used to make electrodes smaller, faster, and improve the sensing performance of the resulting electrodes. In this review, we present a comprehensive overview of the recent literature related to graphene electrode fabrication *via* direct writing, specifically focusing on designs and methods that have been used for electrochemical sensing. The review covers the fundamentals of direct writing techniques, advancements in graphene-based inks/precursors, electrode designs/structures, and their electrochemical sensing applications. The combination of different direct writing methods, low-cost tools, and integrated sensing platforms for smart sensing applications are also discussed. Notably, emphasis is placed on the creation of POC platforms.



**Giulio Rosati**

*Dr. Giulio Rosati is a senior postdoc researcher in the Nanobioelectronics and Biosensors Group at the Catalan Institute of Nanoscience and Nanotechnology (ICN2). Dr. Rosati is a biomedical engineer with a PhD in Biotechnology working on inkjet printing of nanofunctional inks for the fabrication of electronics and electrochemical devices and biosensors. Dr. Rosati has an H-index of 12 and has published*

*more than 30 scientific contributions. He collaborated and worked for several spinoffs, and he is interested in applications ranging from biomedicine to environment protection and agriculture.*



**Arben Merkoçi**

*Prof. Arben Merkoçi is an ICREA Research Professor and leader of the ICN2 Nanobioelectronics and Biosensors Group. He is also the Co-Editor in Chief of the Biosensors and Bioelectronics journal and member of the editorial board of Electroanalysis, Microchimica Acta. He published 319 articles (H-index/citations: Google Scholar 92/ 33381; WOS 79/ 23846) and supervised 35 Ph. D. thesis. He serves also as a scientific evaluator and member*

*of panels of experts of various international governmental and nongovernmental agencies (EU-FP and EU-ERC panels and other panels in Europe, USA, and other countries). More details at: Arben Merkoçi – Google Scholar; <https://nanobiosensors.org/>*



Table 1 Notable graphene inks from the literature

Ink	Filler	Solvent	Printing technique	Ref.
Gr/PANI	—	Water/ethanol	IJP	31
MoS <sub>2</sub> /Gr	EC	Cyclohexanone/terpineol, NMP, or IPA	IJP	32
Gr	EC	Ethylene glycol mixes with ethanol, DMF or NMP	IJP	33
Gr	Pyrene sulfonic acid sodium	Water	IJP	34
GO	—	Water	IJP	35
Gr/Ag nanoparticle	EC	Terpineol/cyclohexanone	IJP	36
Gr Ag@Au	—	Water	IJP	37
PANI/Gr	SDBS	Water	IJP	38
Gr	—	NMP	IJP	39
Gr	—	Ethanol	IJP	40
Gr	—	IPA/PVA	IJP	41
GO	Sodium dodecyl sulfate	EG/water	IJP	42
GO	—	Water/ethanol/EG	IJP	43
GO/Ti <sub>3</sub> C <sub>2</sub>	Nafion	Water	IJP	44
Gr, Gr/AgNPs, Gr/PEDOT: PSS	—	IPA/EG	IJP	45
Gr/polyurethane composite hydrogel	—	Organic solvent mixture	EXP	46
Gr/CNT	Ethyl cellulose	Ethanol/terpineol	EXP	47
GO	—	Water	EXP	48
GO/PANI/PEDOT:PSS, rGO/PEDOT: PSS	—	Water	EXP	49
Gr	Poly(ionic liquid)	Water	EXP	50
Gr/PDMS	—	—	EXP	51
GNPs/MWCNT/polyethylene oxide	—	Water	EXP	52
(PANI/GO) gel	—	<i>N</i> -methyl-2-pyrrolidinone/water	EXP	53
Gr nanoplatelets/PVB	—	Ethanol	EXP	54
GO mix with polymers, ceramics, or steel	—	Water	EXP	55
rGO/Pluronic F127	—	Water	EXP	56
GO/MWCNTs/Nafion	—	Water	EXP	57
Chitosan/ /rGO	—	Water	EXP	58
Fe <sub>2</sub> O <sub>3</sub> /Gr/Ag	PVDF	Nmp	EXP	59
Lignin/GO	—	Water	EXP	60
GO	Branched copolymer/glucono- $\delta$ -lactone	Water	EXP	61
GO	Hydroxypropyl methylcellulose	Water	EXP	62
Gr	Nitrocellulose/ethylene glycol	Glycerol/ethyl lactate	EXP	63
MOF/CNT/GO	—	Water	EXP	64
GO/ZnV <sub>2</sub> O <sub>6</sub> @Co <sub>3</sub> V <sub>2</sub> O <sub>8</sub> , GO/Co <sub>3</sub> V <sub>2</sub> O <sub>8</sub> , GO/VN	—	Water	EXP	65
Gr	PLG	DCM/EGBE/DBP	EXP	66
Gr/PDMS	—	—	EXP	67
Gr	EC	Terpineol/cyclohexanone	EHDP	68, 69
			AJP	70
GO	—	Water	EHDP	71
rGO	—	NMF	EHDP	72
Gr	BSA	Water	EHDP	73, 74
PEDOT:PSS/Gr/SWCNTs	Polyethylene oxide	Water	EHDP	75
Gr	Perylene	Dichloromethane	EHDP	76
MXene/rGO	PVDF	DMF/acetone	EHDP	77
Gr	Nitrocellulose	Dibutyl phthalate/ethyl lactate	AJP	78–80
Electrochemically exfoliated graphene	—	Water	AJP	81
Gr	Graphene quantum dot	Terpineol/cyclohexanone	AJP	82
Gr	EC	Ethanol/ethyl lactate	AJP	83
rGO/CNT/PEDOT:PSS	—	DMSO/water/methanol	AJP	84
Gr	1-Pyrenesulfonic acid sodium salt	Water	AJP	85
Gr/Ag NPs	EC	Ethanol/terpineol/water	AJP	86

Abbreviations: AJP, aerosol jet printing; EHDP, electrohydrodynamic printing; EXP, extrusion printing; Gr, graphene; PANI, polyaniline; PEDOT: PSS, poly(3,4-ethylenedioxythiophene)/poly(styrenesulfonate); MWCNT, multi-walled carbon nano-tube; PDMS, polydimethylsiloxane; EC, ethyl cellulose; SDBS, sodium dodecyl benzene sulfonate; PVDF, polyvinylidene difluoride; NMP, *N*-methylpyrrolidone; EG, ethylene glycol; PVP, polyvinyl pyrrolidone; SDS, sodium dodecyl sulfate.



## 2 Direct writing of graphene

### 2.1 Direct ink writing

Direct ink writing techniques allow the direct, controlled, maskless and contactless deposition of materials onto rigid, flexible, and even deformable substrates.<sup>20,26,28</sup> They do not require complicated and expensive exposure and etching processes, and have the advantage of working with a wide range of materials. They are easy-to-use, cheap, and produce less material waste than other printing techniques. Common examples of this technique include inkjet printing, aerosol jet printing, electrohydrodynamic printing, and extrusion printing. They have been used to prepare graphene micro/nano-structures for different applications. Moreover, the morphology and properties of these structures can be meticulously adjusted through modifications in ink composition and printing parameters.

**2.1.1 Graphene inks.** Printed electronic sensors can make POC devices more accessible. The core technology at the heart of printed electronics is the conductive ink. Conventionally, metallic nanoparticle/metal precursor inks are mainly being used,<sup>29</sup> however, newer inks have been developed containing carbon, two-dimensional materials, and polymers.<sup>30</sup> Among these, graphene-based inks stand out due to their remarkable electrical conductivity, biocompatibility, and scalability in manufacturing. The progress of graphene ink formulations has been particularly notable in direct writing techniques. A list of graphene inks and their compositions is reported in Table 1.

The choice of solvent plays an important role in creating stable and well-performing graphene dispersions, targeting the characteristics of each printing/writing method. A solvent is required that readily disperses the graphenic material, that does not damage the substrate or cause issues downstream.<sup>25</sup> A number of solvents or solvent mixtures have been used for graphene ink preparation, such as *N*-methyl-2-pyrrolidone, *N*, *N*-dimethylformamide and dimethyl sulfoxide, terpineol, ethanol, isopropanol, ethylene glycol, glycerol, ethylene acetate and deionized water.<sup>41,87–89</sup> Additives are frequently used to adjust the viscosity and surface tension of the inks, or to stabilize graphene flakes *via*  $\pi$ - $\pi$  stacking, van der Waals forces, hydrogen bonding or electrostatic interactions.<sup>90,91</sup>

Pure graphene-based inks suffer from poor conductivity mainly due to the deposition of disconnected flakes and making difficult the creation of a relatively direct percolation path, which limits their applicability.<sup>92</sup> Composites of graphene and metallic nanoparticles<sup>93</sup> or conductive polymers<sup>94</sup> is often used to address this. The integration of such additives not only hinders aggregation, improving the stability of the ink, but also increases the conductivity of the printed devices.

As an electrode material, graphene is known for its good electrochemical, biological, and thermal stability, making it ideal as a material choice for POC diagnostic device development. However, the stability and selectivity of any

biosensor towards the analyte largely depends on the bioreceptor (enzyme/antibody/aptamer/molecular imprinted polymer)<sup>4,7,95</sup> making a summary of these performance factors from the literature superfluous to the scope of this review.

**2.1.2 Inkjet printing.** Inkjet printing (IJP) is a well-established standard in the field of printed and flexible electronics. Ink droplets are ejected from nozzles by the mechanical force generated by a transducer (Fig. 1a).<sup>26,91</sup> The transducer can either be a piezoelectric crystal, which undergoes a physical deformation when an electrical signal is applied, or an electrical heater that generates air micro-bubbles rapidly vaporizing the ink in close proximity of the resistor. To achieve a stable printing process (free from satellite drops and nozzle clogging), the rheological properties of the inks must be tuned to obtain a Laplace number (*Z*) between 1 and 10.<sup>96</sup> Typically, graphene flakes with average sizes <0.02 times the nozzle diameter, are dispersed in low viscosity (4–30 cP) solutions, to formulate inks with surface tensions between 20–50 mN m<sup>-1</sup>.<sup>97</sup> It is important to note that while these parameters are recommended, practical printing often relies on a trial-and-error approach to identify the best combination of printers, inks, and substrates.<sup>98,99</sup> With *Z*  $\approx$  19, uniform features still can be printed on SiO<sub>2</sub>, glass and paper without satellite drops or nozzle blocking, yielding a high electrical conductivity of  $3.91 \times 10^4$  S m<sup>-1</sup> after annealing at 300 °C for 1 h (Fig. 1a).<sup>34</sup>

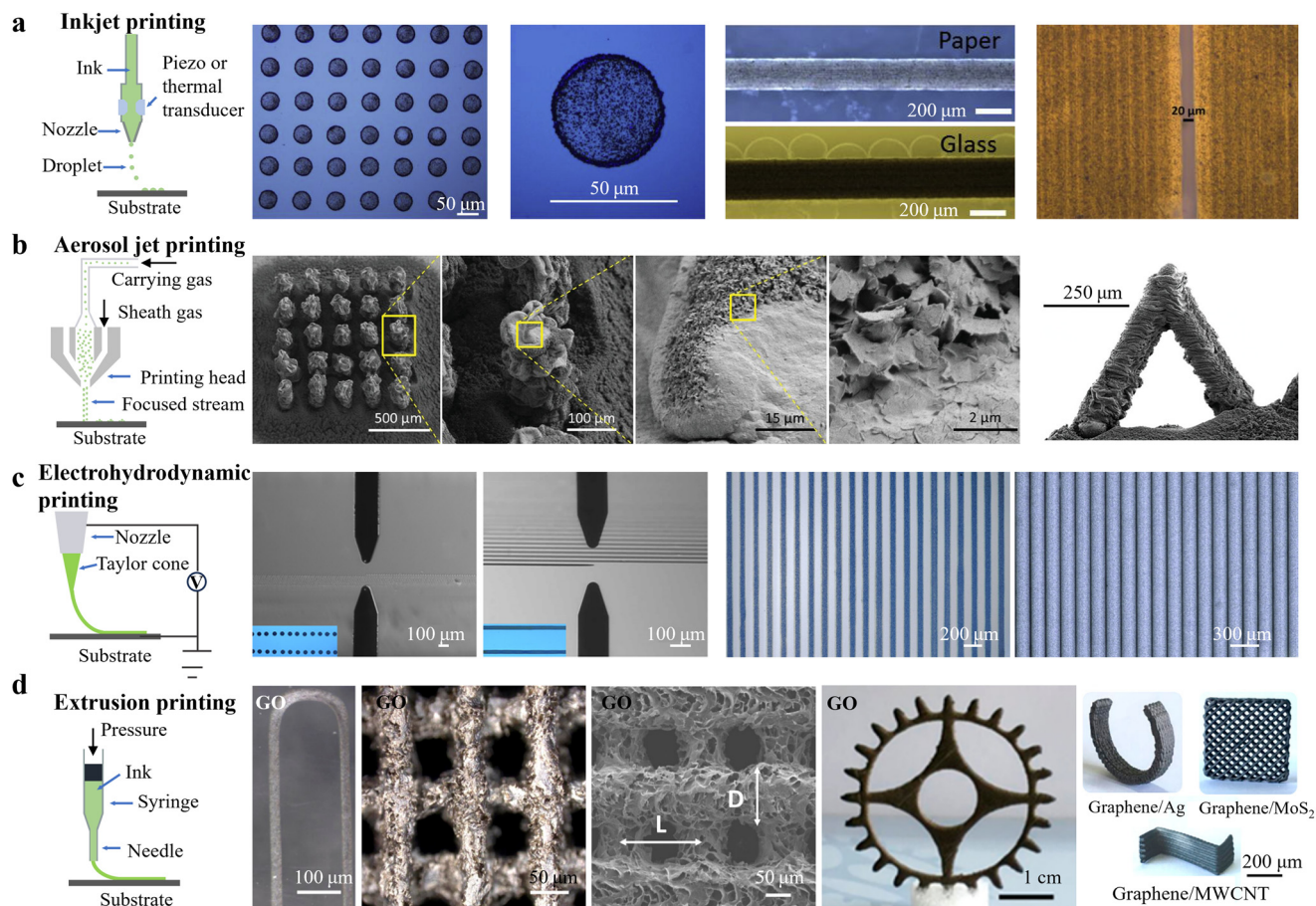
**2.1.3 Aerosol jet printing.** During aerosol jet printing (AJP), an ink is atomized into micrometer-sized aerosol droplets through pneumatic or ultrasonic methods; droplets are then transported into a deposition nozzle and directed onto a substrate using a sheath gas (Fig. 1b).<sup>102</sup> AJP demonstrates the capability to print inks with viscosities from 1 to 1000 cp, at resolutions down to a few micrometers, on both planar and non-planar surfaces.<sup>79,103</sup> To obtain consistent outcomes, relatively high volume of ink is required and various parameters such as atomizer power, atomizer/sheath gas flow rates, substrate temperature, and printing speed must be optimized.<sup>70,104</sup>

AJP can produce sophisticated 3D structures due to its compatibility with highly viscous inks. For example, a water-based graphene ink was used to construct graphene pillars at different angles with respect to the substrate without using supporting fillers (Fig. 1b).<sup>100</sup> By setting the plate temperature to 120 °C, the graphene microstructures obtained were conductive immediately after printing.

**2.1.4 Electrohydrodynamic printing.** In electrohydrodynamic printing (EHDP), an electric field is applied between the nozzle and the substrate to deposit continuous lines (or droplets) onto the substrate, forming 2D/3D structures (Fig. 1c).<sup>24</sup> EHDP exhibits excellent compatibility with a variety of materials, accommodating a wide range of ink viscosities from 0.1 to 10 000 cp, realizing the large-scale, high-resolution (down to nanometer) fabrication of electronics<sup>105,106</sup>. For example, graphene drops







**Fig. 1** Direct ink writing of graphene. From left to right: (a) inkjet printed graphene drops to show the drop size and uniformity, inkjet printed graphene lines on different substrates, and two printed graphene lines on paper separated by a gap of  $\sim 20\ \mu\text{m}$ . Reproduced from ref. 34 with permission from Elsevier, copyright 2019. (b) Aerosol jet printed graphene vertical and tilted micropillars. Reproduced from ref. 100 with permission from John Wiley and Sons, copyright 2023. (c) Electrohydrodynamic printed graphene traces with high accuracy and uniformity. Reproduced from ref. 69 with permission from IOP Publishing Ltd, copyright 2020. (d) Graphene-based 3D structures constructed by extrusion printing. Reproduced from ref. 101 with permission from American Chemical Society, copyright 2018.

and lines were printed, obtaining features with standard deviations down to  $1.9\ \mu\text{m}$  (Fig. 1c).<sup>69</sup> The strong electric field generates droplets far smaller than the nozzle diameter, avoiding nozzle clogging. Despite all these advantages, only a few works have been found that demonstrate graphene electrode production by EHDP, potentially due to the complexity of the technique.<sup>72,77,107</sup>

**2.1.5 Extrusion printing.** In extrusion printing (EXP), a pneumatic gas pump or a motor-driven screw pushes viscoelastic inks through a fine nozzle; instead of individual droplets, the ink emerges as a continuous flow that can be layered to construct complex 3D structures (Fig. 1d).<sup>108</sup> The wide range of ink viscosities, spanning from 0.5 to 1 000 000 cp, compatible with EXP means that it has been used to print: liquids, colloidal suspensions, hydrogels, and composites.<sup>109</sup> Printing parameters that must be tuned to the rheological properties of the ink include: the pressure applied, nozzle size, and printing speed.<sup>110,111</sup>

Using EXP, highly viscoelastic graphene inks have been used to produce self-supporting 3D graphene-based

architectures, with high specific surface areas, good electrical conductivity, and excellent electrochemical properties.<sup>110,112</sup> Novel printable graphene inks can be made by tuning the graphene preparation,<sup>113</sup> condensation,<sup>114</sup> ion linking<sup>111</sup> and polymer stabilization.<sup>60</sup> For example, negatively charged 0D, 1D and 2D materials were integrated into GO gels, yielding uniform graphene-based inks, in which aggregation was prevented by robust electrostatic repulsion between the GO and the other composite materials.<sup>101</sup> Complex architectures fashioned from these mixed-dimensional materials were printed on various substrates (Fig. 1d). Graphene aerogel electrodes were also printed by this method and exhibited excellent electrochemical performance owing to their efficient ion- and electron-transport.

Overall, the quality of the printed patterns is influenced by the rheological properties of the inks, surface properties of the substrates and sintering methods. These factors dramatically influence the properties of the printed devices, including their resolution, conductivity, adhesion, and structural integrity. Graphene printed from low-viscosity inks



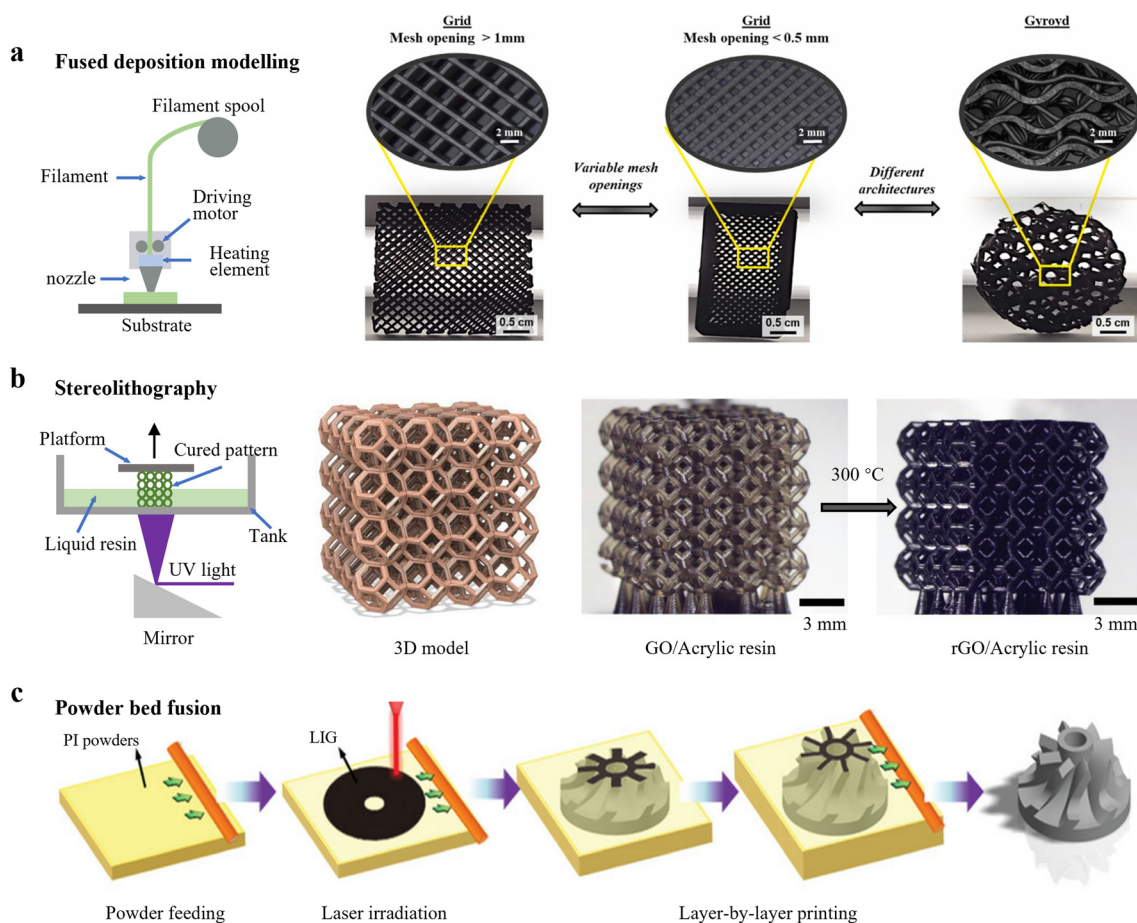
has lower contact resistances<sup>98</sup> and a strong affinity to the substrate after sintering.<sup>94,115</sup> This is highly favorable for low-cost, flexible, thin film-based electrochemical devices. However, the low graphene content within the ink, typically 0.002–1 wt%, requires extensive layer printing.<sup>42</sup> Additives such as ethyl cellulose and surfactants are helpful, but their subsequent removal through an annealing process is required (usually at temperatures  $\geq 300$  °C);<sup>47</sup> which limits the choice of substrates to heat-resistant materials. Complex 3D structures have been printed with highly viscous-elastic graphene inks and applied in energy devices and strain sensors.<sup>27,113,116</sup> However, their applications as electrochemical sensors are rarely reported, potentially due to the hydrophobicity and structural fragility of the 3D porous graphene matrix.<sup>58</sup> As well as 0D, 1D and 2D printing, EXP can also be used to 3D print devices.

## 2.2 3D printing

3D printing is a group of computer-controlled techniques for creating three-dimensional objects by depositing material

layer by layer along the Z-axis.<sup>26–28,117</sup> Common techniques include fused deposition modelling (FDM), stereolithography (SLA), and powder bed fusion (PBF).

FDM can be adapted to 3D print graphene-based electronics. Graphene-doped organic filaments are thermally melted, extruded through a nozzle, and deposited layer by layer on the support, obtaining free standing frameworks after solidification by cooling (Fig. 2a).<sup>118</sup> It has the advantage of being low cost, easy to use, and fast; drawbacks include low resolution, potential nozzle clogging, and electrical anisotropy of the final devices. Acrylonitrile butadiene styrene copolymers (ABS) and polylactic acid (PLA) are commonly utilized filaments for graphene electrode production.<sup>119,120</sup> For example, a PLA-based composite with a high content of oriented colloidal graphite and graphene (15–25 vol%) was used to print complex electrodes (Fig. 2a).<sup>121</sup> The structural anisotropy was tuned by changing the printing direction, showing conductivity as high as  $22 \text{ S m}^{-1}$ . Mechanical, chemical, electrochemical, or thermal treatments are generally necessary to expose and activate the graphene encapsulated within the polymer matrix.<sup>122–124</sup>



**Fig. 2** 3D printing of graphene. (a) Different architectures by fused deposition modelling. The printing direction affects graphene's properties. Reproduced from ref. 121 under creative commons CC-BY license. (b) Graphene cell printed by stereolithography. Reproduced from ref. 125 with permission from Wiley-VCH GmbH, copyright 2023. (c) Sophisticated graphene devices printed with a modified powder bed fusion method. Reproduced from ref. 126 under creative commons CC-BY license.





SLA employs radiation (often UV light lasers) to selectively solidify liquid polymers, achieving fast 3D printing with high spatial resolution (10–150  $\mu\text{m}$ ), high throughput, and smooth surfaces (Fig. 2b).<sup>127</sup> Patterning of graphene structures has been demonstrated by UV polymerization of monolayer GO blended acrylic resin (Fig. 2b).<sup>125</sup> Thermal treatment at 300  $^{\circ}\text{C}$  allows for the *in situ* thermal reduction of GO to rGO, while the resin remained unchanged, resulting in conductivities of up to 0.012  $\text{S m}^{-1}$ . Concentrated carbon-based materials tend to absorb and scatter light, which hinders the photopolymerization process, making it difficult to obtain graphene electrodes with high electrical conductivity by SLA.<sup>128,129</sup>

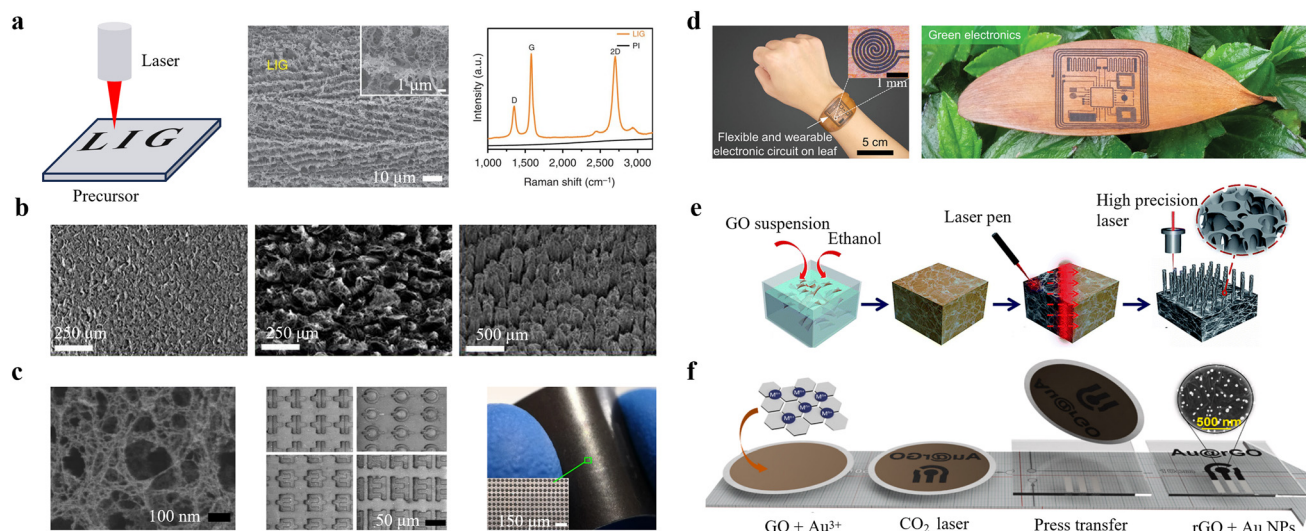
Graphene can be 3D printed by a modified FDM method. (Fig. 3e).<sup>126</sup> The strategy is based on selective laser sintering, in which  $\text{CO}_2$  laser irradiates polyimide powder-bed, realizing both particle-sintering and graphene-converting processes layer-by-layer by adjusting the laser power and layer thickness. This unique strategy could assemble various types of graphene architectures including identical-section, variable-section, and graphene/PI hybrid structures, forming bulk 3D graphene with freeform structures without introducing extra binders, templates, and catalysts. Direct conversion of liquid organic precursor into versatile 3D graphene could be done with a similar process.<sup>130</sup>

### 2.3 Direct laser writing

Direct laser writing (DLW) is an easy, efficient, low-cost, eco-friendly and maskless method to simultaneously produce

and pattern porous graphene electrodes without any catalysts or harmful solvents.<sup>137–139</sup> In the DLW process, a laser is used to irradiate the samples, inducing photochemical and/or photothermal reactions, resulting in laser induced graphene (LIG). LIGs are highly porous 3D networks with large active surface areas, good chemical/thermal stability, and fast electron transfer rates, making them ideal electrode materials for electrical/electrochemical sensing. Intensive studies have been conducted with different laser sources (ultraviolet-visible, infrared, and ultra-short pulse lasers) and precursors; as a result, it is now possible to tune the LIG morphology and composition, and thereby their physical, chemical and electrical properties.<sup>137,138</sup>

Polyimide has quickly become the most popular precursor for the production of LIG since it was first reported by Lin *et al.* in 2014.<sup>131,140</sup> While it is debatable whether or not this is truly graphene, it possesses many of the properties of layered, highly crystalline graphene. This method allows different patterns to be obtained with porous structures abundant in five- and seven-membered rings, as opposed to the conventional hexagonal lattice of graphene (Fig. 3a). LIG can be used to prepare graphene with a variety of sophisticated structures by changing the laser parameters, these structures could be designed such that their resistances changed upon structure deformation (Fig. 3b).<sup>132</sup> GO is another commonly used precursor to produce LIG with a low laser power.<sup>138</sup> Low cost, high performance, porous graphene was obtained with a LightScribe DVD writer (788 nm, 5 mW); which was capable of reducing and patterning GO with a 20  $\mu\text{m}$  resolution.<sup>141</sup> Spatially shaped femtosecond lasers (SSFL)



**Fig. 3** Laser induced graphene (LIG). (a) LIG from polyimide, showing porous structures with typical Raman signals of graphene. Reproduced from ref. 131 under creative commons CC-BY license. (b) Morphology variation led by different laser parameters. Reproduced from ref. 132 with permission from, American Chemical Society, copyright 2023. (c) High density, high resolution LIG/ $\text{MnO}_2$  patterns fabricated on an industrial scale. Reproduced from ref. 133 under creative commons CC-BY license. (d) Flexible, wearable electronics made from plants. Reproduced from ref. 134 with permission from Wiley-VCH Verlag GmbH & co. KGaA, Weinheim, copyright 2019. (e) Highly vertically ordered pillar array of graphene framework constructed with a two-step laser process. Reproduced from ref. 135 with permission from Royal Society of Chemistry, copyright 2018. (f) Selective transfer of laser reduced graphene composite by a press transfer process. Reproduced from ref. 136 under creative commons CC-BY license.



can produce graphene electrodes from GO on an industrial scale. In SSFL, the shape of the laser beam is modulated to allow it to pattern the graphene surface, this allows the laser to rapidly stamp the surface in a manner compatible with large scale fabrication. Using SSFL, over 30 000 graphene devices with dimensions as small as 10  $\mu\text{m}$ , separated by 500 nm could be produced in 10 minutes (Fig. 3c).<sup>133</sup> Renewable materials have proven to be great precursors to produce LIG.<sup>142,143</sup> Cellulose, hemicellulose, and lignin can be converted into graphene like materials using a UV femtosecond laser in ambient air; this greatly improves the sustainability of electronics manufacturing, and has been shown capable of producing electrical connections, flexible temperature sensors and supercapacitors (Fig. 3d).<sup>134</sup> A versatile method has also been developed to produce LIG from cross-linked polystyrene, epoxy resins, and cellulose.<sup>144</sup> A first laser irradiation step converts the substrates into amorphous carbon, and a second laser step transforms the amorphous carbon into graphene. The resulting LIG displayed a low sheet resistance of around 5  $\Omega \text{ sq}^{-1}$  and was used to create supercapacitors on the surface of a coconut. The method shows that any precursor that can be converted into amorphous carbon can be transformed into graphene.

Although DLW is a 2D patterning process, there have been attempts to use it for 3D device fabrication.<sup>126,130,145</sup> For example, a highly vertically ordered pillar array of graphene framework was produced from GO. GO hydrogel was transformed into rGO framework by laser irradiation, and then shaped into desired structures with macroporous networks using a highly precise laser (Fig. 3e).<sup>135</sup>

Typically, LIG remains on the surface where it was generated. However, the successful transfer of LIG onto various substrates has recently been achieved by mechanical pressing,<sup>146</sup> elastomer embedding,<sup>147,148</sup> and hydrogel<sup>149</sup>/adhesive tape<sup>150</sup>/solvent<sup>151</sup> assisted transfer. Stamp transfer methods have been proposed to transfer laser reduced graphene electrodes on a wide variety of substrates including PET, paper, nitrocellulose, glass, fabric, or silicon.<sup>152–154</sup> In this process, rGO formed by the laser reduction of GO is selectively transferred to other substrates with a mechanical press (Fig. 3f).<sup>136</sup>

## 2.4 Low-cost direct writers

The accessibility of affordable direct writing tools holds immense significance, as it empowers the creation of personalized sensing devices within laboratories with limited resources and even by non-professionals at home. Consumer-grade inkjet printers show distinct advantages over their high-end research-grade counterparts in terms of affordability, accessibility, printing speed, and the number of available ink channels.<sup>26,155,156</sup> For instance, AgNP and PEDOT: PSS inks were deposited on poly(ethylene terephthalate) substrate with a printer cost of only 60 \$.<sup>157</sup> One can find commercial desktop 3D printers or laser engravers on the market for less than 100 \$ easily.

Furthermore, several teams have created cost-effective extrusion printers (under 300 \$) using open-source software and commercial materials.<sup>158,159</sup>

## 2.5 Additional smart strategies

**2.5.1 Multi-material deposition.** The ability to print multiple materials simultaneously allows for the fabrication of more complex structures. One noteworthy example of this is the work published by Zeng *et al.*, in which a combinatorial aerosol jet printing approach was used to create patterns with compositional gradients with a microscale spatial resolution (Fig. 4a).<sup>148</sup> Two inks were atomized into aerosols containing microscale droplets. The combined ink streams were then mixed within a single nozzle and deposited onto the substrate using a sheath gas. This method facilitated *in situ* mixing ratio adjustments, leading to combinatorial doping, functional grading, and chemical reactions within versatile material libraries, including 0D, 1D, and 2D nanomaterials, and even seemingly incompatible materials like MXene and  $\text{Sb}_2\text{Te}_3$ . In another work, mono/co-axial microfibers were created using an extrusion printing process with GO and  $\text{Ti}_3\text{C}_2\text{T}_x$  dispersions with mono/coaxial needles (Fig. 4b).<sup>160</sup>

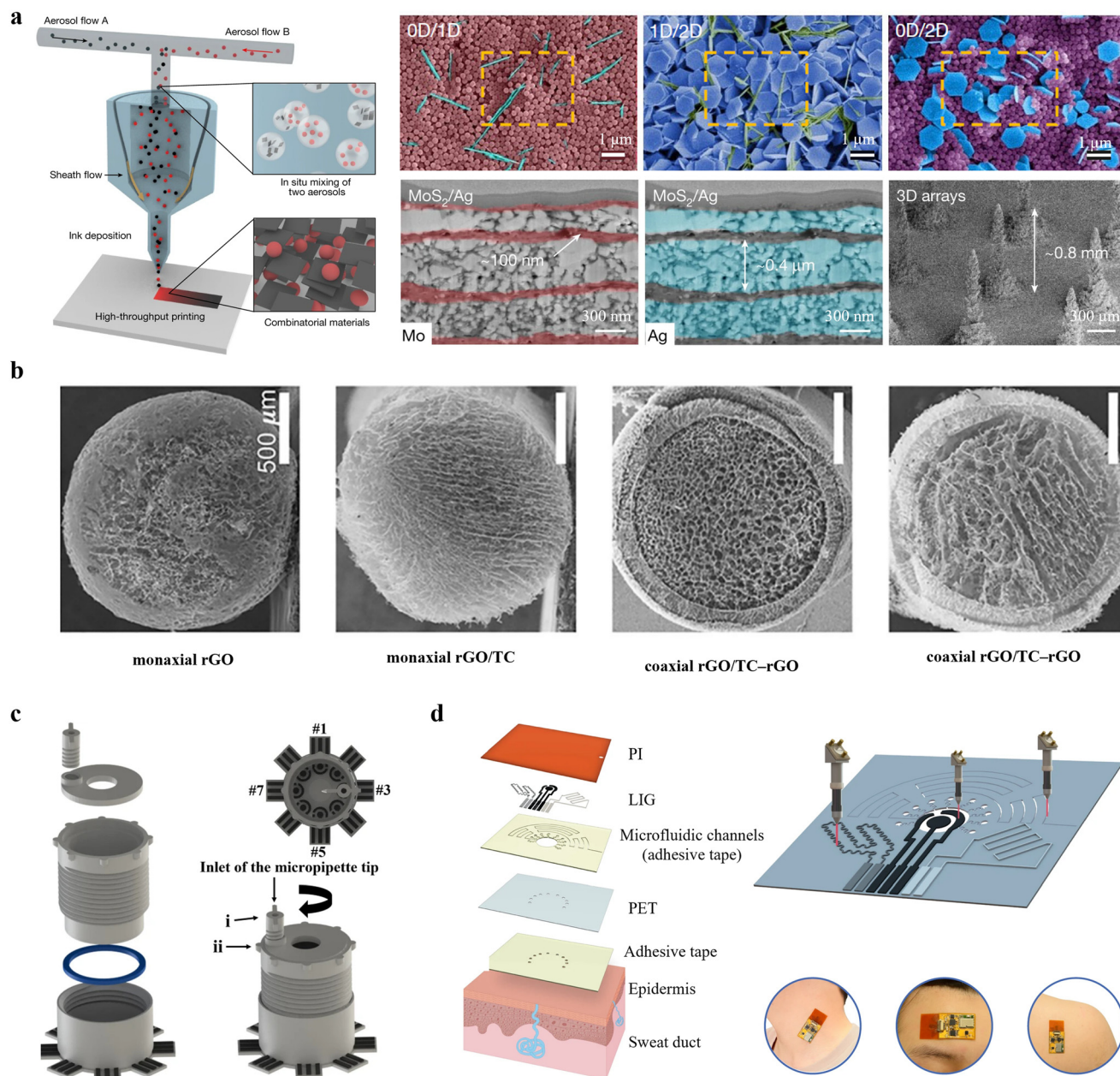
**2.5.2 Fully written devices.** Nowadays, there is a growing need for portable, wearable, miniaturized sensing devices. This requires the incorporation of various functional components, including electrodes, electrical circuits, electrochemical cells, microfluidics, and data processors/transmitters.<sup>163,164</sup> Direct writing methods are inherently suited for this purpose owing to the digital, maskless nature of fabrication with high design freedom. For example, a fully 3D printed portable analytical setup was described comprising a batch injection analysis cell and an electrochemical platform with eight sensing electrodes (Fig. 4c).<sup>161</sup> The device can be printed within 3.4 h using a multi-material printer equipped with insulating and conductive filaments at a cost of *ca.* ~1.2 \$ per unit. Direct laser writing exhibits notable advantages in the manufacturing process of multilayered, integrated devices. Utilizing a laser engraver, various components such as LIG electrode arrays, microfluidic channels, and adhesive layers can be precisely patterned. This approach yields to cost-effective, disposable, and wearable epidermal patches capable of simultaneous sweat sampling and signal monitoring (Fig. 4d).<sup>162</sup> The combination of different direct writing techniques can overcome their constraints, structures with higher resolution and special functions. For example, 3D needle-like electrodes and planar connections were printed by AJP and IJP techniques, displaying excellent performance for recording extracellular electrophysiological signals from living cells.<sup>165</sup>

## 2.6 Comparison with other patterning methods

While printing has many advantages as a method of ink deposition and patterning, there are alternative methods;







**Fig. 4** (a) Simultaneous multi-material printing at various dimensions by AJP. Reproduced from ref. 148 under creative commons CC-BY license. (b) rGO/ Ti<sub>3</sub>C<sub>2</sub>T<sub>x</sub> (TC) monaxial and coaxial fibers produced by EXP. Reproduced from ref. 160 with permission from American Chemical Society, copyright 2023. (c) A fully 3D printed electrochemical cell with 8 integrated electrodes. Reproduced from ref. 161 with permission from Springer Nature, copyright 2022. (d) A laser engraved wearable electrochemical sensor for simultaneous determination of various signals. Reproduced from ref. 162 with permission from Springer Nature, copyright 2019.

these include screen printing and photolithography. Screen printing typically has similar or lower resolution (μm)<sup>166</sup> to direct writing methods, requires pre-fabricated masks that are expensive and time consuming to iterate, also a lot of the ink is wasted when printing by this method, making the cost per device typically higher than those produced by direct writing. Photolithography can also be used to pattern electronic devices, however this requires a large upfront capital investment in the equipment and facilities.<sup>16</sup> Photolithography is not inherently iterative, requiring

complex optimization to produce working devices, however once the device fabrication has been optimized, it is inherently scalable and the costs of mass-produced devices can be low. Of all these techniques photolithography has the highest resolution/ precision, achieving low nm in three dimensions (depending on many factors).<sup>167</sup> Direct writing methods are advantageous over both of these alternatives since they are versatile, iterative and can produce small or large batches of devices at a low cost with minimal material waste. The drawbacks of direct written include the low



resolution, the reproducibility of fabricated devices, and the typical need to include ligands and stabilizers in the inks that need to be removed after fabrication.

### 3 Electrochemical sensing applications of direct-written graphene electrodes

Electrochemical sensors enable the real-time analysis of analytes in diverse matrices, making them important tools in healthcare, environmental monitoring, and food safety applications. Direct writing facilitates the customization of graphene electrodes, alternating their shape, morphology, conductivity and electrochemical properties. This means that graphene electrodes possess the versatility required for detecting a range of targets including pH, ions, molecules, proteins, and pathogens (Table 2).

The early detection of health-related biomarkers greatly aids disease prevention and enhances the efficiency of medical treatments. As well as traditional POC sensors, wearable biosensors are a hot topic for active real-time monitoring of health conditions.<sup>193</sup> Inkjet printing can use a wide variety of inks and design flexibility to fabricate wearable sensors for multiplexed biosensing (Fig. 5a).<sup>194</sup> The fully-printed system was capable of detecting glucose, alcohol, pH, and skin temperature in sweat. The influence of pH and temperature variations were monitored to allow the stable monitoring of glucose and alcohol for more than 30 h.

The electrochemical properties of graphene composites are well-suited to detecting biomarkers *in vivo*. For example, Li *et al.* used direct laser scribing of metal-complexed polyimide to fabricate stretchable, tissue-resembling electrodes, consisting of interconnected graphene/metal oxide nanoparticle/elastomer networks (Fig. 5b).<sup>195</sup> These electrodes were used for continuous, real-time, monoamine sensing in the brain, and serotonin detection in the gut without disturbing peristalsis. All the work was done in a living mouse *via* fast-scan cyclic voltammetry with a portable potentiostat.

3D printed graphene electrodes have been used for the detection of COVID-19, proving it could be a promising method of decentralized and low-cost manufacturing of POC diagnostic tools. Competitive immunosensors were developed to monitor COVID-19 in both buffered and diluted serological samples, realizing trace level response in 20 min (Fig. 5c).<sup>124</sup> Similarly, infectious pathogens were detected in spiked buffer and artificial urine with LIG-based immunosensors, exhibiting a wide dynamic range ( $917\text{--}2.1 \times 10^7$  CFU mL<sup>-1</sup>) with a low LOD (283 CFU mL<sup>-1</sup>) (Fig. 5d).<sup>152</sup> POC detection was demonstrated by incorporating a portable wireless system controlled and monitored by a smartphone.

Environmental monitoring and food safety have direct implications for both human and animal welfare. Both require POC analytical methods to accurately monitor relevant hazards. A recent work by Chen *et al.* has shown that

four different targets could be detected by integrating microfluidics and electrochemical cells through the direct laser writing of PI (Fig. 5e).<sup>178</sup> By tuning the laser parameters, the electrical conductivity, surface morphology, and wettability of the LIG were adjusted, meaning that both the microfluidics and electrodes could be fabricated by the laser on the same substrate. The developed ion-selective and enzymatic electrodes, capable of detecting K<sup>+</sup>, NO<sub>3</sub><sup>-</sup>, NH<sub>4</sub><sup>+</sup>, and parathion simultaneously. An aerosol jet-printed high-resolution interdigitated electrode with a line width of around 40 μm was developed for the detection of histamine using electrochemical impedance spectroscopy.<sup>78</sup> The functionalization of the electrode with monoclonal antibody resulted in a wide histamine sensing range of 56.25 μM–1.8 mM and a low detection limit of 30.7 μM, in tuna broth samples.

### 4 Conclusions, challenges and perspectives

Direct writing methods have been developed for the rapid prototyping of graphene electrodes using various graphene inks, filaments, or precursors. The choice of direct writing techniques, their parameters, and the chemistry of the materials being used, can be tuned to obtain graphene electrodes with different morphologies, geometries, and electrochemical performances. The advantages of direct writing, such as affordability, potential for mass production, ease of modification and integration, combined with the remarkable properties of graphene, have led to significant progresses in electrochemical sensing. This progress is driving a shift from traditional bulky electrochemical setups to flexible, portable, cost-effective, miniaturized POC devices. Despite the recent advancements in the literature, graphene-based devices for POC testing in real-life scenarios still encounter challenges in fabrication, operation, and data analysis.

The ongoing development of graphene inks faces challenges associated with non-uniform particle sizes and structures. While various methods exist for producing graphene-based materials, the industrial scale production has yet to accomplish. Achieving a balance between ideal printing and an electrode with good functional performance is difficult, as both depends factors such as the surface tension and viscosity of the ink, the substrate surface energy, and sintering conditions. This can potentially be overcome by preparing novel inks, pre-functionalizing the substrates, and post printing treatments. For 3D printing, the availability of graphene-based fillers is limited. The presence of polymer fillers can significantly diminish the advantages of graphene, such as its large specific surface area and conductivity. The underlying mechanism for LIG production is not yet fully understood, making it difficult to precisely tune the properties of LIG with high reproducibility. Nevertheless, doping with heteroatoms or nanoparticles can improve its performance.<sup>196</sup> Mechanical stability is also a concern, as the



**Table 2** Representatives of electrochemical sensors based on direct written graphene electrodes

Precursors	Patterning methods	Sensing platform	Targets	Dynamic range	Limit of detection	Ref.
Gr dispersion	AJP	Gr/antibody	Histamine	56.25 $\mu\text{M}$ –1.8 mM	30.7 $\mu\text{M}$	78
Gr dispersion	AJP	Gr/antibody	Interferon gamma	0.1–5 $\text{ng ml}^{-1}$	25 $\text{pg ml}^{-1}$	79
Gr dispersion	AJP	Gr/antibody	Interleukin 10	0.1–2 $\text{ng ml}^{-1}$	46 $\text{pg ml}^{-1}$	168
			Spike RBD	1–1000 $\text{ng ml}^{-1}$	22.91 $\pm$ 4.72 $\text{pg ml}^{-1}$	
			Spike s1 (COVID - 19)		110.38 $\pm$ 9.00 $\text{pg ml}^{-1}$	
Paperboard	DLW	LIG/aluminosilicate particle	Ascorbic acid	2.0–5.0 mM	—	169
			Caffeic acid	0.91–2.86 mM		
			Picric acid	0.48–2.0 mM		
GO/noble metal ions	DLW	rGO/Au	Caffeic acid	0.5–100 $\mu\text{M}$	50 nM	170
		rGO/Au	$\text{NO}_2^-$	1–100 $\mu\text{M}$	120 $\mu\text{M}$	
		Pt@rGO	$\text{H}_2\text{O}_2$	5–2000 $\mu\text{M}$	0.6 $\mu\text{M}$	
PI	DLW	LIG/PEDOT/MIP	Chloramphen	1 nM–10 mM	0.62 nM	171
PI	DLW	LIG	Clothianidin	10–40 $\mu\text{M}$	823 nM	172
			Imidacloprid		384 nM	
			Thiamethoxam		338 nM	
			Dinotefuran		682 nM	
PI	DLW	LI/PPPA/anti-cortisol	Cortisol	0.43–50.2 $\text{ng ml}^{-1}$	0.08 $\text{ng ml}^{-1}$	173
PI	DLW	LIG/magmatic bead/DNA	<i>Cryptosporidium parvum</i>	0.1 pM–25 nM	3 pM (ECL)	174
					47 pM (EC)	
GO	DLW	rGO/anti- <i>E. coli</i>	<i>E. coli</i> O157:H7	917–2.1 $\times 10^7$ cfu $\text{ml}^{-1}$	283 cfu $\text{ml}^{-1}$	152
GO	DLW	rGO/Cu NPs	Glucose	1 $\mu\text{M}$ –4.54 mM	0.35 $\mu\text{M}$	175
GO	DLW	rGO/Ag NPs	$\text{H}_2\text{O}_2$	0.1–10 mM	7.9 $\mu\text{M}$	176
PI	DLW	LIG/AuNS/aptamer	Human epidermal growth factor receptor 2	0.1–200 $\text{ng ml}^{-1}$	0.008 $\text{ng ml}^{-1}$	177
PI	DLW	LIG/ion selective membrane	$\text{K}^+$	$10^{-6}$ – $10^{-2}$ M	$10^{-5.01}$ M	178
			$\text{NO}_3^-$		$10^{-5.07}$ M	
		LIG/enzyme	$\text{NH}_4^+$	40–120 pM	$10^{-4.89}$ M	
PI	DLW	LIG/anti-Salmonella	Parathion		15.4 pM	
PI	DLW	LIG	<i>Salmonella enterica</i>	25– $10^5$ cfu $\text{ml}^{-1}$	13 $\pm$ 7 cfu $\text{ml}^{-1}$	179
			Uric acid	20–80 $\mu\text{M}$	0.74 $\mu\text{M}$	162
			Tyrosine	50–200 $\mu\text{M}$	3.6 $\mu\text{M}$	
PI	DLW	LIG	<i>Trans-resveratrol</i>	0.2–50 $\mu\text{M}$	0.16 $\mu\text{M}$	180
GO/MWCNTs/Nafion	EXP	rGO/MWCNTs/Nafion aerogel	Acetone vapor	0–100 ppm	5 ppm	57
CNT/GO	EXP	Field effect transistor, with CNT/rGO electrodes, PEDOT: PSS channel	Dopamine	0.1–10 $\mu\text{M}$		
			Dopamine	1 $\mu\text{M}$ –10 mM	6 $\mu\text{M}$	181
Chitosan/rGO	EXP	Chitosan/rGO	Glucose	0.5–4 mM	0.45 mM	58
Gr/PLA	FDM	rGO-PLA/tyrosinase	Catechol	30–700 $\mu\text{M}$	0.26 $\mu\text{M}$	182
			Serotonin	0.3–10 $\mu\text{M}$	0.032 $\mu\text{M}$	
Gr/PLA	FDM	Gr/PLA/Bi NPs	$\text{Cd}^{2+}$	100–500 nM	82 nM	183
		Gr/PLA/Bi NPs	$\text{Pb}^{2+}$	80–500 nM	11 nM	
		Gr/PLA	$\text{Hg}^{2+}$	20–100 nM	6.1 nM	
Gr/PLA	FDM	Gr/PLA	Cocaine	20–100 $\mu\text{M}$	6 $\mu\text{M}$	184
Gr/PLA	FDM	Gr/PLA/Au NPs/DNA	COVID-19	1.0–50.0 $\mu\text{M}$	0.30 $\mu\text{M}$	185
		Gr/PLA/Au NPs	Creatinine	0.050–3.2 mM	0.02 mM	
Gr/PLA	FDM	Gr/PLA/GOx	Glucose	0.5–6 mM	15 $\mu\text{M}$	186
		Gr/PLA	Uric acid	0.5–250 $\mu\text{M}$	0.02 $\mu\text{M}$	
		Gr/PLA	Nitrite	0.5–250 $\mu\text{M}$	0.03 $\mu\text{M}$	
Gr/PLA	FDM	Gr/PLA/Au NPs/HRP	$\text{H}_2\text{O}_2$	150–600 $\mu\text{M}$	9.1 $\mu\text{M}$	187
Gr/PLA	FDM	Gr/PLA	L-methionine	5.0–3000 $\mu\text{M}$	1.39 $\mu\text{M}$	188
Gr dispersion	IJP	Gr/Au NPs/anti-cortisol	Cortisol	0.2–1.0 mM	10 $\mu\text{M}$	189
		Gr/GOx/PB	Glucose	10 pm–100 nM	10 pm	
Gr dispersion	IJP	Gr/aminated montmorillonite clay mineral	Gentisic acid	1–21 $\mu\text{M}$	0.33 $\mu\text{M}$	190
Gr dispersion	IJP	Gr gate electrode/GOx	Glucose	30–5000 $\mu\text{M}$	100 nM	191
		Gr gate electrode/lactate oxidase	Lactate	2–30 mM	100 nM	
GO dispersion	IJP	rGO/anti-HT-2	Ht-2 mycotoxin	6.3–100 $\text{ng ml}^{-1}$	1.6 $\text{ng ml}^{-1}$	42

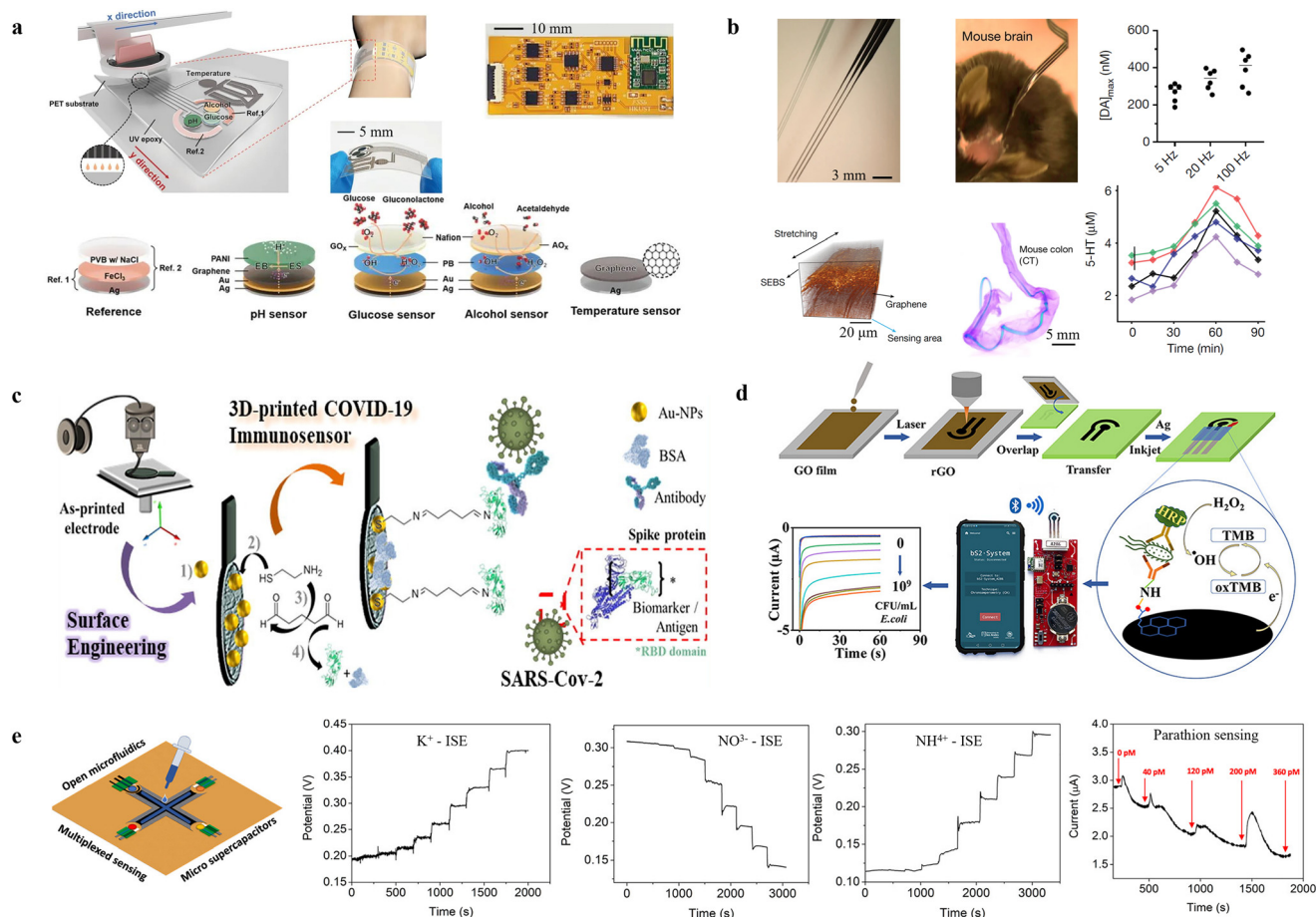




Table 2 (continued)

Precursors	Patterning methods	Sensing platform	Targets	Dynamic range	Limit of detection	Ref.
FeO NPs/rGO/graphite dispersion	IJP	FeO NPs/rGO/graphite	Lurasidone	50–2150 ng ml <sup>-1</sup>	15.64 ng ml <sup>-1</sup>	192

Abbreviations: AJP, aerosol jet printing; EHDP, electrohydrodynamic printing; EXP, extrusion printing; FDM, fused deposition modelling; DLW, direct laser writing; Gr, graphene; MWCNTs, multi-walled carbon nanotube; CNT, carbon nanotube; PPPA, poly (pyrrole propionic acid); Gox, glucose oxidase; NPs, nanoparticles.



**Fig. 5** Direct written graphene-based sensors for electrochemical sensing. (a) A fully inkjet printed wearable system for multiplexed epidermal sweat analysis. Reproduced from ref. 194 under creative commons CC-BY license. (b) Stretchable, implantable LIG-based neurochemical sensors, for the detection of dopamine (DA) in the brain and serotonin in the gut. Reproduced from ref. 195 with permission from Springer Nature, copyright 2022. (c) 3D printed graphene electrodes for the POC detection of COVID-19. Reproduced from ref. 124 with permission from Elsevier, copyright 2021. (d) A laser-reduced graphene oxide electrode-based portable platform for *E. coli* detection. Reproduced from ref. 152 under creative commons CC-BY license. (e) LIG-based open microfluidic system for multiplexed environmental biosensing. Reproduced from ref. 178 with permission from American Chemical Society, copyright 2022.

delicate porous structure of LIG may degrade over long-term exposure to the atmosphere. This becomes more pressing when flexible/portable or wearable sensors are highly desired these days. Combining with elastomers<sup>195</sup> and hydrogels<sup>197</sup> can be promising to obtaining robust, flexible, stretchable graphene electrodes.

There are still difficulties for the commercialization of electrochemical sensors, so as to graphene-based ones. One

of the main reasons is the fouling of sensors due to the complexity of the biomatrix. Nanoengineered structures and coatings can be a promising avenue for antifouling.<sup>198</sup> Notably, most biosensing processes necessitate multiple washing steps, which are both time-consuming and relying on trained personnel, thereby rendering them less user-friendly for POC testing. Label-free sensing strategies<sup>199</sup> and automatic sample processing setups<sup>200</sup> present a potential

solution. However, it is crucial to thoughtfully select stable, specific bioreceptors with strong affinity towards the targets.

Machine learning could guide the entire design-to-fabrication process, eliminating the intricate and time-consuming optimization of the printing process.<sup>201</sup> It can also aid in eliminating signals stemming from contaminants and facilitates the interpretation of extensive data, thereby achieving heightened sensitivity, accuracy, and a broader response range.<sup>202</sup>

Miniaturized, integrated, multifunctional devices are highly desired for electrochemical sensing, but significant challenges persist.<sup>203</sup> Such devices require sampling and sensing structures, software, data transmission/analysis, and power sources. New functional inks and improved printing resolutions, could help to enhance the detection sensitivity and reduce the device size. Moreover, the ability to direct write many of other components, such as: substrates, electronics, microfluidics and batteries<sup>204–206</sup> means that we are heading towards a truly whole printed system.

With all the fabrication techniques described in this review, there is a constant need to improve their respective devices compliance with the REASSURED criteria established by the WHO. All devices and fabrication methods can be improved to reduce their costs, make them more environmentally friendly, more sensitive, specific, and deliverable. User friendliness can be improved by incorporating with sister technological developments such as smartphones. Direct writing methods are inherently suited to these requirements, since the devices can be quickly fabricated at the point of use at a low cost and typically with less waste than other methods, but there is always scope for improvement in all of these aspects of the device performance.

## Data availability

No primary research results, software or code have been included and no new data were generated or analysed as part of this review.

## Conflicts of interest

There are no conflicts to declare.

## Acknowledgements

ICN2 is funded by CERCA programme, Generalitat de Catalunya. The ICN2 is supported by the Severo Ochoa Centres of Excellence programme, Grant CEX2021-001214-S, funded by MCIU/AEI/10.13039/501100011033. We acknowledge Departament de Recerca i Universitats of Generalitat de Catalunya for the grant 2021 SGR 01464 and Grant PID2021-124795NB-I00 funded by MCIN/AEI/ 10.13039/501100011033 and by “ERDF A way of making Europe. Lei Zhao acknowledge the financial support from China Scholarship Council (CSC) and the Fundamental Research Funds for the Central Universities. This project has received funding from the EMERGE project, European Union's Horizon 2020 research and innovation

programme, under Grant Agreement No. 101008701. Views and opinions expressed are however those of the author(s) only and do not necessarily reflect those of the European Union. The European Union can not be held responsible for them.

## References

- 1 E. R. Kim, C. Joe, R. J. Mitchell and M. B. Gu, Biosensors for Healthcare: Current and Future Perspectives, *Trends Biotechnol.*, 2023, **41**(3), 374, DOI: [10.1016/j.tibtech.2022.12.005](#).
- 2 C. Dincer, R. Bruch, E. Costa-Rama, M. T. Fernandez-Abedu, A. Merkoci, A. Manz, G. A. Urban and F. Guder, Disposable Sensors in Diagnostics, Food, and Environmental Monitoring, *Adv. Mater.*, 2019, **31**(30), 1806739, DOI: [10.1002/adma.201806739](#).
- 3 M. Khatib and H. Haick, Sensors for Volatile Organic Compounds, *ACS Nano*, 2022, **16**(5), 7080, DOI: [10.1021/acsnano.1c10827](#).
- 4 E. Cesewski and B. N. Johnson, Electrochemical Biosensors for Pathogen Detection, *Biosens. Bioelectron.*, 2020, **159**, 112214, DOI: [10.1016/j.bios.2020.112214](#).
- 5 A. L. Furst and M. B. Francis, Impedance-Based Detection of Bacteria, *Chem. Rev.*, 2019, **119**(1), 700, DOI: [10.1021/acs.chemrev.8b00381](#).
- 6 Y. Dai and C. C. Liu, Recent Advances on Electrochemical Biosensing Strategies toward Universal Point-of-Care Systems, *Angew. Chem., Int. Ed.*, 2019, **58**(36), 12355, DOI: [10.1002/anie.201901879](#).
- 7 J. Wu, H. Liu, W. Chen, B. Ma and H. Ju, Device Integration of Electrochemical Biosensors, *Nat. Rev. Bioeng.*, 2023, **1**(5), 346, DOI: [10.1038/s44222-023-00032-w](#).
- 8 K. J. Land, D. I. Boeras, X.-S. Chen, A. R. Ramsay and R. W. Peeling, Reassured Diagnostics to Inform Disease Control Strategies, Strengthen Health Systems and Improve Patient Outcomes, *Nat. Microbiol.*, 2019, **4**(1), 46, DOI: [10.1038/s41564-018-0295-3](#).
- 9 A. Ambrosi, C. K. Chua, A. Bonanni and M. Pumera, Electrochemistry of Graphene and Related Materials, *Chem. Rev.*, 2014, **114**(14), 7150, DOI: [10.1021/cr500023c](#).
- 10 V. P. Wanjari, A. S. Reddy, S. P. Duttagupta and S. P. Singh, Laser-Induced Graphene-Based Electrochemical Biosensors for Environmental Applications: A Perspective, *Environ. Sci. Pollut. Res.*, 2022, **30**, 42643, DOI: [10.1007/s11356-022-21035-x](#).
- 11 S. K. Krishnan, E. Singh, P. Singh, M. Meyyappan and H. S. Nalwa, A Review on Graphene-Based Nanocomposites for Electrochemical and Fluorescent Biosensors, *RSC Adv.*, 2019, **9**(16), 8778, DOI: [10.1039/c8ra09577a](#).
- 12 K. S. Novoselov, A. K. Geim, S. V. Morozov, D. Jiang, Y. Zhang, S. V. Dubonos, I. V. Grigorieva and A. A. Firsov, Electric Field Effect in Atomically Thin Carbon Films, *Science*, 2004, **306**(5696), 666, DOI: [10.1126/science.1102896](#).
- 13 Y. Ma and L. Zhi, Functionalized Graphene Materials: Definition, Classification, and Preparation Strategies, *Acta Phys.-Chim. Sin.*, 2021, 2101004, DOI: [10.3866/PKU.WHXB202101004](#).



- 14 W. Yu, L. Sisi, Y. Haiyan and L. Jie, Progress in the Functional Modification of Graphene/Graphene Oxide: A Review, *RSC Adv.*, 2020, **10**(26), 15328, DOI: [10.1039/d0ra01068e](#).
- 15 R. Tarcan, O. Todor-Boer, I. Petrovai, C. Leordean, S. Astilean and I. Botiz, Reduced Graphene Oxide Today, *J. Mater. Chem. C*, 2020, **8**(4), 1198, DOI: [10.1039/c9tc04916a](#).
- 16 T. Wei, L. P. Bao, F. Hauke and A. Hirsch, Recent Advances in Graphene Patterning, *ChemPlusChem*, 2020, **85**(8), 1655, DOI: [10.1002/cplu.202000419](#).
- 17 D. S. Kim, J.-M. Jeong, H. J. Park, Y. K. Kim, K. G. Lee and B. G. Choi, Highly Concentrated, Conductive, Defect-Free Graphene Ink for Screen-Printed Sensor Application, *Nano-Micro Lett.*, 2021, **13**(1), 87, DOI: [10.1007/s40820-021-00617-3](#).
- 18 E. B. Secor, S. Lim, H. Zhang, C. D. Frisbie, L. F. Francis and M. C. Hersam, Gravure Printing of Graphene for Large-Area Flexible Electronics, *Adv. Mater.*, 2014, **26**(26), 4533, DOI: [10.1002/adma.201401052](#).
- 19 X. J. Ruan, J. J. Luo, R. Wang, Y. B. Yao, J. J. Guan and T. Liu, Microcontact Printing with Laser Direct Writing Carbonization for Facile Fabrication of Carbon-Based Ultrathin Disk Arrays and Ordered Holey Films, *Small*, 2019, **15**(44), 1902819, DOI: [10.1002/smll.201902819](#).
- 20 R. Y. Tay, Y. Song, D. R. Yao and W. Gao, Direct-Ink-Writing 3d-Printed Bioelectronics, *Mater. Today*, 2023, **71**, 135, DOI: [10.1016/j.mattod.2023.09.006](#).
- 21 K. Muzyka and G. Xu, Laser-Induced Graphene in Facts, Numbers, and Notes in View of Electroanalytical Applications: A Review, *Electroanalysis*, 2022, **34**(4), 574, DOI: [10.1002/elan.202100425](#).
- 22 Y. Z. N. Htwe and M. Mariatti, Printed Graphene and Hybrid Conductive Inks for Flexible, Stretchable, and Wearable Electronics: Progress, Opportunities, and Challenges, *J. Sci.: Adv. Mater. Devices*, 2022, **7**(2), 100435, DOI: [10.1016/j.jsamd.2022.100435](#).
- 23 T.-S. D. Le, H.-P. Phan, S. Kwon, S. Park, Y. Jung, J. Min, B. J. Chun, H. Yoon, S. H. Ko, S.-W. Kim and Y.-J. Kim, Recent Advances in Laser-Induced Graphene: Mechanism, Fabrication, Properties, and Applications in Flexible Electronics, *Adv. Funct. Mater.*, 2022, **32**(48), 2205158, DOI: [10.1002/adfm.202205158](#).
- 24 S. X. Cai, Y. L. Sun, Z. Wang, W. G. Yang, X. Y. Li and H. B. Yu, Mechanisms, Influencing Factors, and Applications of Electrohydrodynamic Jet Printing, *Nanotechnol. Rev.*, 2021, **10**(1), 1046, DOI: [10.1515/ntrev-2021-0073](#).
- 25 H. Abdolmaleki, P. Kidmose and S. Agarwala, Droplet-Based Techniques for Printing of Functional Inks for Flexible Physical Sensors, *Adv. Mater.*, 2021, **33**(20), e2006792, DOI: [10.1002/adma.202006792](#).
- 26 K. Zub, S. Hoepfner and U. S. Schubert, Inkjet Printing and 3d Printing Strategies for Biosensing, Analytical, and Diagnostic Applications, *Adv. Mater.*, 2022, **34**(31), e2105015, DOI: [10.1002/adma.202105015](#).
- 27 J. Du, G. Fu, X. Xu, A. M. Elshahawy and C. Guan, 3d Printed Graphene-Based Metamaterials: Guesting Multi-Functionality in One Gain, *Small*, 2023, **19**, 2207833, DOI: [10.1002/smll.202207833](#).
- 28 J. Z. Y. Tan, M. A. Ávila-López, A. Jahanbakhsh, X. Lu, J. Bonilla-Cruz, T. E. Lara-Ceniceros, J. M. Andresen and M. M. Maroto-Valer, 3d Direct Ink Printed Materials for Chemical Conversion and Environmental Remediation Applications: A Review, *J. Mater. Chem. A*, 2023, **11**(11), 5408, DOI: [10.1039/D2TA08922J](#).
- 29 D. J. Kang, L. González-García and T. Kraus, Soft Electronics by Inkjet Printing Metal Inks on Porous Substrates, *Flexible Printed Electron.*, 2022, **7**(3), 033001, DOI: [10.1088/2058-8585/ac8360](#).
- 30 K.-S. Kwon, M. K. Rahman, T. H. Phung, S. Hoath, S. Jeong and J. S. Kim, Review of Digital Printing Technologies for Electronic Materials, *Flexible Printed Electron.*, 2020, **5**(4), 043003, DOI: [10.1088/2058-8585/abc8ca](#).
- 31 K. Chi, Z. Zhang, J. Xi, Y. Huang, F. Xiao, S. Wang and Y. Liu, Freestanding Graphene Paper Supported Three-Dimensional Porous Graphene-Polyaniline Nanocomposite Synthesized by Inkjet Printing and in Flexible All-Solid-State Supercapacitor, *ACS Appl. Mater. Interfaces*, 2014, **6**(18), 16312, DOI: [10.1021/am504539k](#).
- 32 R. F. Hossain, I. G. Deaguero, T. Boland and A. B. Kaul, Biocompatible, Large-Format, Inkjet Printed Heterostructure Mos2-Graphene Photodetectors on Conformable Substrates, *npj 2D Mater. Appl.*, 2017, **1**, 28, DOI: [10.1038/s41699-017-0034-2](#).
- 33 S. Majee, M. Song, S.-L. Zhang and Z.-B. Zhang, Scalable Inkjet Printing of Shear-Exfoliated Graphene Transparent Conductive Films, *Carbon*, 2016, **102**, 51, DOI: [10.1016/j.carbon.2016.02.013](#).
- 34 K. Parvez, R. Worsley, A. Alieva, A. Felten and C. Casiraghi, Water-Based and Inkjet Printable Inks Made by Electrochemically Exfoliated Graphene, *Carbon*, 2019, **149**, 213, DOI: [10.1016/j.carbon.2019.04.047](#).
- 35 L. Huang, Y. Huang, J. Liang, X. Wan and Y. Chen, Graphene-Based Conducting Inks for Direct Inkjet Printing of Flexible Conductive Patterns and Their Applications in Electric Circuits and Chemical Sensors, *Nano Res.*, 2011, **4**(7), 675, DOI: [10.1007/s12274-011-0123-z](#).
- 36 G. Wang, Z. Wang, Z. Liu, J. Xue, G. Xin, Q. Yu, J. Lian and M. Y. Chen, Annealed Graphene Sheets Decorated with Silver Nanoparticles for Inkjet Printing, *Chem. Eng. J.*, 2015, **260**, 582, DOI: [10.1016/j.cej.2014.09.037](#).
- 37 L. Li, M. Gao, Y. Guo, J. Sun, Y. Li, F. Li, Y. Song and Y. Li, Transparent Ag@Au-Graphene Patterns with Conductive Stability Via Inkjet Printing, *J. Mater. Chem. C*, 2017, **5**(11), 2800, DOI: [10.1039/c6tc05227d](#).
- 38 Y. Xu, I. Hennig, D. Freyberg, A. James Strudwick, M. Georg Schwab, T. Weitz and K. Chih-Pei Cha, Inkjet-Printed Energy Storage Device Using Graphene/Polyaniline Inks, *J. Power Sources*, 2014, **248**, 483, DOI: [10.1016/j.jpowsour.2013.09.096](#).
- 39 F. Torrisi, T. Hasan, W. Wu, Z. Sun, A. Lombardo, T. S. Kulmala, G. W. Hsieh, S. Jung, F. Bonaccorso, P. J. Paul, D. Chu and A. C. Ferrari, Inkjet-Printed Graphene Electronics, *ACS Nano*, 2012, **6**(4), 2992, DOI: [10.1021/nn2044609](#).





- 40 T. Carey, S. Cacovich, G. Divitini, J. S. Ren, A. Mansouri, J. M. Kim, C. X. Wang, C. Ducati, R. Sordan and F. Torrisi, Fully Inkjet-Printed Two-Dimensional Material Field-Effect Heterojunctions for Wearable and Textile Electronics, *Nat. Commun.*, 2017, **8**, 1202, DOI: [10.1038/s41467-017-01210-2](https://doi.org/10.1038/s41467-017-01210-2).
- 41 T. Juntunen, H. Jussila, M. Ruoho, S. Liu, G. Hu, T. Albrow-Owen, L. W. T. Ng, R. C. T. Howe, T. Hasan, Z. Sun and I. Tittonen, Inkjet Printed Large-Area Flexible Few-Layer Graphene Thermoelectrics, *Adv. Funct. Mater.*, 2018, **28**(22), 1800480, DOI: [10.1002/adfm.201800480](https://doi.org/10.1002/adfm.201800480).
- 42 J. Kudr, L. Zhao, E. P. Nguyen, H. Arola, T. K. Nevanen, V. Adam, O. Zitka and A. Merkoci, Inkjet-Printed Electrochemically Reduced Graphene Oxide Microelectrode as a Platform for Ht-2 Mycotoxin Immunoenzymatic Biosensing, *Biosens. Bioelectron.*, 2020, **156**, 112109, DOI: [10.1016/j.bios.2020.112109](https://doi.org/10.1016/j.bios.2020.112109).
- 43 L. Pei and Y.-F. Li, Rapid and Efficient Intense Pulsed Light Reduction of Graphene Oxide Inks for Flexible Printed Electronics, *RSC Adv.*, 2017, **7**(81), 51711, DOI: [10.1039/c7ra10416b](https://doi.org/10.1039/c7ra10416b).
- 44 J. Zheng, J. Diao, Y. Jin, A. Ding, B. Wang, L. Wu, B. Weng and J. Chen, An Inkjet Printed Ti3C2-Go Electrode for the Electrochemical Sensing of Hydrogen Peroxide, *J. Electrochem. Soc.*, 2018, **165**(5), B227, DOI: [10.1149/2.0051807jes](https://doi.org/10.1149/2.0051807jes).
- 45 D. S. Saidina, M. Mariatti, S. A. Zubir, S. Fontana and C. Hérold, Performance of Graphene Hybrid-Based Ink for Flexible Electronics, *J. Mater. Sci.: Mater. Electron.*, 2019, **30**(22), 19906, DOI: [10.1007/s10854-019-02357-y](https://doi.org/10.1007/s10854-019-02357-y).
- 46 C.-T. Huang, L. K. Shrestha, K. Ariga and S.-H. Hsu, A Graphene-Polyurethane Composite Hydrogel as a Potential Bioink for 3d Bioprinting and Differentiation of Neural Stem Cells, *J. Mater. Chem. B*, 2017, **5**(44), 8854, DOI: [10.1039/c7tb01594a](https://doi.org/10.1039/c7tb01594a).
- 47 Y. L. Wang, Y. Zhang, G. L. Wang, X. W. Shi, Y. D. Qiao, J. M. Liu, H. G. Liu, A. Ganesh and L. Li, Direct Graphene-Carbon Nanotube Composite Ink Writing All-Solid-State Flexible Microsupercapacitors with High Areal Energy Density, *Adv. Funct. Mater.*, 2020, **30**(16), 1907284, DOI: [10.1002/adfm.201907284](https://doi.org/10.1002/adfm.201907284).
- 48 Q. Zhang, F. Zhang, S. P. Medarametla, H. Li, C. Zhou and D. Lin, 3d Printing of Graphene Aerogels, *Small*, 2016, **12**(13), 1702, DOI: [10.1002/smll.201503524](https://doi.org/10.1002/smll.201503524).
- 49 Y. Q. Liu, B. B. Zhang, Q. Xu, Y. Y. Hou, S. Seyedin, S. Qin, G. G. Wallace, S. Beirne, J. M. Razal and J. Chen, Development of Graphene Oxide/Polyaniline Inks for High Performance Flexible Microsupercapacitors Via Extrusion Printing, *Adv. Funct. Mater.*, 2018, **28**(21), 1706592, DOI: [10.1002/adfm.201706592](https://doi.org/10.1002/adfm.201706592).
- 50 T. Tuan Sang, N. K. Dutta and N. R. Choudhury, Poly(Ionic Liquid)-Stabilized Graphene Nanoinks for Scalable 3d Printing of Graphene Aerogels, *ACS Appl. Nano Mater.*, 2020, **3**(11), 11608, DOI: [10.1021/acsnm.0c02781](https://doi.org/10.1021/acsnm.0c02781).
- 51 K. Huang, S. Dong, J. Yang, J. Yan, Y. Xue, X. You, J. Hu, L. Gao, X. Zhang and Y. Ding, Three-Dimensional Printing of a Tunable Graphene-Based Elastomer for Strain Sensors with Ultrahigh Sensitivity, *Carbon*, 2019, **143**, 63, DOI: [10.1016/j.carbon.2018.11.008](https://doi.org/10.1016/j.carbon.2018.11.008).
- 52 Y. Luo, D. Wu, Y. Zhao, Q. Chen, Y. Xie, M. Wang, L. Lin, L. Wang and D. Sun, Direct Write of a Flexible High-Sensitivity Pressure Sensor with Fast Response for Electronic Skins, *Org. Electron.*, 2019, **67**, 10, DOI: [10.1016/j.orgel.2019.01.001](https://doi.org/10.1016/j.orgel.2019.01.001).
- 53 Z. Wang, Q. E. Zhang, S. Long, Y. Luo, P. Yu, Z. Tan, J. Bai, B. Qu, Y. Yang, J. Shi, H. Zhou, Z.-Y. Xiao, W. Hong and H. Bai, Three-Dimensional Printing of Polyaniline/Reduced Graphene Oxide Composite for High-Performance Planar Supercapacitor, *ACS Appl. Mater. Interfaces*, 2018, **10**(12), 10437, DOI: [10.1021/acsami.7b19635](https://doi.org/10.1021/acsami.7b19635).
- 54 K. Huang, J. S. Yang, S. M. Dong, Q. Feng, X. Y. Zhang, Y. S. Ding and J. B. Hu, Anisotropy of Graphene Scaffolds Assembled by Three-Dimensional Printing, *Carbon*, 2018, **130**, 1, DOI: [10.1016/j.carbon.2017.12.120](https://doi.org/10.1016/j.carbon.2017.12.120).
- 55 E. Garcia-Tunon, E. Feilden, H. Zheng, E. D'Elia, A. Leong and E. Saiz, Graphene Oxide: An All-in-One Processing Additive for 3d Printing, *ACS Appl. Mater. Interfaces*, 2017, **9**(38), 32977, DOI: [10.1021/acsami.7b07717](https://doi.org/10.1021/acsami.7b07717).
- 56 V. G. Rocha, E. Garcia-Tunon, C. Botas, F. Markoulidis, E. Feilden, E. D'Elia, N. Ni, M. Shaffer and E. Saiz, Multimaterial 3d Printing of Graphene-Based Electrodes for Electrochemical Energy Storage Using Thermoresponsive Inks, *ACS Appl. Mater. Interfaces*, 2017, **9**(42), 37136, DOI: [10.1021/acsami.7b10285](https://doi.org/10.1021/acsami.7b10285).
- 57 B. Weng, A. Ding, Y. Liu, J. Diao, J. Razal, K. T. Lau, R. Shepherd, C. Li and J. Chen, Hierarchical Nafion Enhanced Carbon Aerogels for Sensing Applications, *Nanoscale*, 2016, **8**(6), 3416, DOI: [10.1039/C5NR08631K](https://doi.org/10.1039/C5NR08631K).
- 58 A. Sanati, E. Bidram, A. Poursamar, M. Rabbani and M. Rafienia, Water-Based Chitosan/Reduced Graphene Oxide Ink for Extrusion Printing of a Disposable Amperometric Glucose Sensor, *FlatChem*, 2022, **36**, 100443, DOI: [10.1016/j.flatc.2022.100443](https://doi.org/10.1016/j.flatc.2022.100443).
- 59 K. Tang, H. Ma, Y. Tian, Z. Liu, H. Jin, S. Hou, K. Zhou and X. Tian, 3d Printed Hybrid-Dimensional Electrodes for Flexible Micro-Supercapacitors with Superior Electrochemical Behaviours, *Virtual Phys. Prototyp.*, 2020, **15**, 511, DOI: [10.1080/17452759.2020.1842619](https://doi.org/10.1080/17452759.2020.1842619).
- 60 J. Roman, W. Neri, V. Fierro, A. Celzard, A. Bentalb, I. Ly, J. Zhong, A. Derre and P. Poulin, Lignin-Graphene Oxide Inks for 3d Printing of Graphitic Materials with Tunable Density, *Nano Today*, 2020, **33**, 100881, DOI: [10.1016/j.nantod.2020.100881](https://doi.org/10.1016/j.nantod.2020.100881).
- 61 E. Garcia-Tunon, S. Barg, J. Franco, R. Bell, S. Eslava, E. D'Elia, R. C. Maher, F. Guitian and E. Saiz, Printing in Three Dimensions with Graphene, *Adv. Mater.*, 2015, **27**(10), 1688, DOI: [10.1002/adma.201405046](https://doi.org/10.1002/adma.201405046).
- 62 B. Yao, S. Chandrasekaran, J. Zhang, W. Xiao, F. Qian, C. Zhu, E. B. Duoss, C. M. Spadaccini, M. A. Worsley and Y. Li, Efficient 3d Printed Pseudocapacitive Electrodes with Ultrahigh MnO<sub>2</sub> Loading, *Joule*, 2019, **3**(2), 459, DOI: [10.1016/j.joule.2018.09.020](https://doi.org/10.1016/j.joule.2018.09.020).
- 63 E. B. Secor, M. H. Dos Santos, S. G. Wallace, N. P. Bradshaw and M. C. Hersam, Tailoring the Porosity and



- Microstructure of Printed Graphene Electrodes Via Polymer Phase Inversion, *J. Phys. Chem. C*, 2018, **122**(25), 13745, DOI: [10.1021/acs.jpcc.8b00580](https://doi.org/10.1021/acs.jpcc.8b00580).
- 64 J. Zhao, Y. Zhang, H. Lu, Y. Wang, X. D. Liu, H. M. K. Sari, J. Peng, S. Chen, X. Li, Y. Zhang, X. Sun and B. Xu, Additive Manufacturing of Two-Dimensional Conductive Metal-Organic Framework with Multidimensional Hybrid Architectures for High-Performance Energy Storage, *Nano Lett.*, 2022, **22**(3), 1198, DOI: [10.1021/acs.nanolett.1c04367](https://doi.org/10.1021/acs.nanolett.1c04367).
  - 65 J. Zhao, Y. Zhang, X. Zhao, R. Wang, J. Xie, C. Yang, J. Wang, Q. Zhang, L. Li, C. Lu and Y. Yao, Direct Ink Writing of Adjustable Electrochemical Energy Storage Device with High Gravimetric Energy Densities, *Adv. Funct. Mater.*, 2019, **29**(26), 1900809, DOI: [10.1002/adfm.201900809](https://doi.org/10.1002/adfm.201900809).
  - 66 A. E. Jakus, E. B. Secor, A. L. Rutz, S. W. Jordan, M. C. Hersam and R. N. Shah, Three-Dimensional Printing of High-Content Graphene Scaffolds for Electronic and Biomedical Applications, *ACS Nano*, 2015, **9**(4), 4636, DOI: [10.1021/acs.nano.5b01179](https://doi.org/10.1021/acs.nano.5b01179).
  - 67 X. You, J. Yang, M. Wang, J. Hu, Y. Ding, X. Zhang and S. Dong, Graphene-Based Fiber Sensors with High Stretchability and Sensitivity by Direct Ink Extrusion, *2D Mater.*, 2020, **7**(1), 015025, DOI: [10.1088/2053-1583/ab559f](https://doi.org/10.1088/2053-1583/ab559f).
  - 68 K. Li, D. Z. Wang, S. S. Yi, H. R. Jia, J. H. Qian, Z. Y. Du, T. Q. Ren, J. S. Liang, S. O. Martinez-Chapa and M. Madou, Instrument for Fine Control of Drop-on-Demand Electrohydrodynamic Jet Printing by Current Measurement, *Rev. Sci. Instrum.*, 2019, **90**(11), 115001, DOI: [10.1063/1.5090415](https://doi.org/10.1063/1.5090415).
  - 69 K. Zhao, D. Wang, K. Li, C. Jiang, Y. Wei, J. Qian, L. Feng, Z. Du, Z. Xu and J. Liang, Drop-on-Demand Electrohydrodynamic Jet Printing of Graphene and Its Composite Microelectrode for High Performance Electrochemical Sensing, *J. Electrochem. Soc.*, 2020, **167**(10), 107508, DOI: [10.1149/1945-7111/ab9c7e](https://doi.org/10.1149/1945-7111/ab9c7e).
  - 70 E. Jabari and E. Toyserkani, Micro-Scale Aerosol-Jet Printing of Graphene Interconnects, *Carbon*, 2015, **91**, 321, DOI: [10.1016/j.carbon.2015.04.094](https://doi.org/10.1016/j.carbon.2015.04.094).
  - 71 B. Zhang, J. Lee, M. Kim, N. Lee, H. Lee and D. Byun, Direct Patterning and Spontaneous Self-Assembly of Graphene Oxide Via Electrohydrodynamic Jet Printing for Energy Storage and Sensing, *Micromachines*, 2020, **11**(1), 13, DOI: [10.3390/mi11010013](https://doi.org/10.3390/mi11010013).
  - 72 B. W. An, K. Kim, M. Kim, S.-Y. Kim, S.-H. Hur and J.-U. Park, Direct Printing of Reduced Graphene Oxide on Planar or Highly Curved Surfaces with High Resolutions Using Electrohydrodynamics, *Small*, 2015, **11**(19), 2263, DOI: [10.1002/smll.201403131](https://doi.org/10.1002/smll.201403131).
  - 73 A. Niaraki, M. Abbasi Shirsavar, S. S. Aykar, M. Taghavimehr, R. Montazami and N. N. Hashemi, Minute-Sensitive Real-Time Monitoring of Neural Cells through Printed Graphene Microelectrodes, *Biosens. Bioelectron.*, 2022, **210**, 114284, DOI: [10.1016/j.bios.2022.114284](https://doi.org/10.1016/j.bios.2022.114284).
  - 74 A. E. Niaraki Asli, J. Guo, P. L. Lai, R. Montazami and N. N. Hashemi, High-Yield Production of Aqueous Graphene for Electrohydrodynamic Drop-on-Demand Printing of Biocompatible Conductive Patterns, *Biosensors*, 2020, **10**(1), 6, DOI: [10.3390/bios10010006](https://doi.org/10.3390/bios10010006).
  - 75 H. F. Dong, L. B. Zhang, T. Wu, H. J. Song, J. Q. Luo, F. L. Huang and C. C. Zuo, Flexible Pressure Sensor with High Sensitivity and Fast Response for Electronic Skin Using near-Field Electrohydrodynamic Direct Writing, *Org. Electron.*, 2021, **89**, 106044, DOI: [10.1016/j.orgel.2020.106044](https://doi.org/10.1016/j.orgel.2020.106044).
  - 76 S. Ali, J. Bae, C. H. Lee, K. H. Choi and Y. H. Doh, Flexible and Passive Photo Sensor Based on Perylene/Graphene Composite, *Sens. Actuators, B*, 2015, **220**, 634, DOI: [10.1016/j.snb.2015.05.128](https://doi.org/10.1016/j.snb.2015.05.128).
  - 77 H. Liang, L. Zhang, T. Wu, H. Song and C. Tang, Dual-Mode Flexible Sensor Based on PvdF/Mxene Nanosheet/Reduced Graphene Oxide Composites for Electronic Skin, *Nanomaterials*, 2023, **13**(1), 102, DOI: [10.3390/nano13010102](https://doi.org/10.3390/nano13010102).
  - 78 K. Parate, C. C. Pola, S. V. Rangnekar, D. L. Mendivelso-Perez, E. A. Smith, M. C. Hersam, C. L. Gomes and J. C. Claussen, Aerosol-Jet-Printed Graphene Electrochemical Histamine Sensors for Food Safety Monitoring, *2D Mater.*, 2020, **7**(3), 034002, DOI: [10.1088/2053-1583/ab8919](https://doi.org/10.1088/2053-1583/ab8919).
  - 79 K. Parate, S. V. Rangnekar, D. Jing, D. L. Mendivelso-Perez, S. Ding, E. B. Secor, E. A. Smith, J. M. Hostetter, M. C. Hersam and J. C. Claussen, Aerosol-Jet-Printed Graphene Immunosensor for Label-Free Cytokine Monitoring in Serum, *ACS Appl. Mater. Interfaces*, 2020, **12**(7), 8592, DOI: [10.1021/acsami.9b22183](https://doi.org/10.1021/acsami.9b22183).
  - 80 L. Gamba, Z. T. Johnson, J. Atterberg, S. Diaz-Arauzo, J. R. Downing, J. C. Claussen, M. C. Hersam and E. B. Secor, Systematic Design of a Graphene Ink Formulation for Aerosol Jet Printing, *ACS Appl. Mater. Interfaces*, 2023, **15**, 3325, DOI: [10.1021/acsami.2c18838](https://doi.org/10.1021/acsami.2c18838).
  - 81 Y.-T. Kwon, H. Kim, M. Mahmood, Y.-S. Kim, C. Demolder and W.-H. Yeo, Printed, Wireless, Soft Bioelectronics and Deep Learning Algorithm for Smart Human-Machine Interfaces, *ACS Appl. Mater. Interfaces*, 2020, **12**(44), 49398, DOI: [10.1021/acsami.0c14193](https://doi.org/10.1021/acsami.0c14193).
  - 82 M. Zeng, W. Kuang, I. Khan, D. Huang, Y. Du, M. Saeidi-Javash, L. Zhang, Z. Cheng, A. J. Hoffman and Y. Zhang, Colloidal Nanosurfactants for 3d Conformal Printing of 2d Van Der Waals Materials, *Adv. Mater.*, 2020, **32**(39), e2003081, DOI: [10.1002/adma.202003081](https://doi.org/10.1002/adma.202003081).
  - 83 L. Kuo, V. K. Sangwan, S. V. Rangnekar, T.-C. Chu, D. Lam, Z. Zhu, L. J. Richter, R. Li, B. M. Szydłowska, J. R. Downing, B. J. Luijten, L. J. Lauhon and M. C. Hersam, All-Printed Ultrahigh-Responsivity Mos2 Nanosheet Photodetectors Enabled by Megasonic Exfoliation, *Adv. Mater.*, 2022, **34**(34), 2203772, DOI: [10.1002/adma.202203772](https://doi.org/10.1002/adma.202203772).
  - 84 Y. Zhou, C. B. Parker, P. Joshi, A. K. Naskar, J. T. Glass and C. Cao, 4d Printing of Stretchable Supercapacitors Via Hybrid Composite Materials, *Adv. Mater. Technol.*, 2021, **6**(1), 2001055, DOI: [10.1002/admt.202001055](https://doi.org/10.1002/admt.202001055).
  - 85 M. Saeidi-Javash, Y. Du, M. Zeng, B. C. Wyatt, B. Zhang, N. Kempf, B. Anasori and Y. Zhang, All-Printed Mxene-Graphene Nanosheet-Based Bimodal Sensors for Simultaneous Strain and Temperature Sensing, *ACS Appl. Electron. Mater.*, 2021, **3**(5), 2341, DOI: [10.1021/acsaelm.1c00218](https://doi.org/10.1021/acsaelm.1c00218).



- 86 E. Jabari and E. Toyserkani, Aerosol-Jet Printing of Highly Flexible and Conductive Graphene/Silver Patterns, *Mater. Lett.*, 2016, **174**, 40, DOI: [10.1016/j.matlet.2016.03.082](#).
- 87 Z. Peng, A. Grillo, A. Pelella, X. Liu, M. Boyes, X. Xiao, M. Zhao, J. Wang, Z. Hu, A. Di Bartolomeo and C. Casiraghi, Fully Printed Memristors Made with Mos2 and Graphene Water-Based Inks, *Mater. Horiz.*, 2024, **11**(5), 1344, DOI: [10.1039/D3MH01224G](#).
- 88 D. McManus, S. Vranic, F. Withers, V. Sanchez-Romaguera, M. Macucci, H. Yang, R. Sorrentino, K. Parvez, S. K. Son, G. Iannaccone, K. Kostarelos, G. Fiori and C. Casiraghi, Water-Based and Biocompatible 2d Crystal Inks for All-Inkjet-Printed Heterostructures, *Nat. Nanotechnol.*, 2017, **12**(4), 343, DOI: [10.1038/nnano.2016.281](#).
- 89 G. Hu, L. Yang, Z. Yang, Y. Wang, X. Jin, J. Dai, Q. Wu, S. Liu, X. Zhu, X. Wang, T. C. Wu, R. C. T. Howe, T. Albrow-Owen, L. W. T. Ng, Q. Yang, L. G. Occhipinti, R. I. Woodward, E. J. R. Kelleher, Z. Sun, X. Huang, M. Zhang, C. D. Bain and T. Hasan, A General Ink Formulation of 2d Crystals for Wafer-Scale Inkjet Printing, *Sci. Adv.*, 2020, **6**(33), eaba5029, DOI: [10.1126/sciadv.aba5029](#).
- 90 D. Song, A. Mahajan, E. B. Secor, M. C. Hersam, L. F. Francis and C. D. Frisbie, High-Resolution Transfer Printing of Graphene Lines for Fully Printed, Flexible Electronics, *ACS Nano*, 2017, **11**(7), 7431, DOI: [10.1021/acsnano.7b03795](#).
- 91 ACS Nano, K. Cho, T. Lee and S. Chung, Inkjet Printing of Two-Dimensional Van Der Waals Materials: A New Route Towards Emerging Electronic Device Applications, *Nanoscale Horiz.*, 2022, **7**(10), 1161, DOI: [10.1039/d2nh00162d](#).
- 92 D. Zhu, Z. Wang and D. Zhu, Highly Conductive Graphene Electronics by Inkjet Printing, *J. Electron. Mater.*, 2020, **49**(3), 1765, DOI: [10.1007/s11664-019-07920-1](#).
- 93 N. Karim, S. Afroj, S. R. Tan, K. S. Novoselov and S. G. Yeates, All Inkjet-Printed Graphene-Silver Composite Ink on Textiles for Highly Conductive Wearable Electronics Applications, *Sci. Rep.*, 2019, **9**, 8035, DOI: [10.1038/s41598-019-44420-y](#).
- 94 J. L. Diao, J. Yuan, A. L. Ding, J. S. Zheng and Z. S. Lu, Flexible Supercapacitor Based on Inkjet-Printed Graphene@Polyaniline Nanocomposites with Ultrahigh Capacitance, *Macromol. Mater. Eng.*, 2018, **303**(6), 1800092, DOI: [10.1002/mame.201800092](#).
- 95 O. Simoska, E. M. Gaffney, S. D. Minter, A. Franzetti, P. Cristiani, M. Grattieri and C. Santoro, Recent Trends and Advances in Microbial Electrochemical Sensing Technologies: An Overview, *Curr. Opin. Electrochem.*, 2021, **30**, 100762, DOI: [10.1016/j.coelec.2021.100762](#).
- 96 M. You, J. Zhong, Y. Hong, Z. Duan, M. Lin and F. Xu, Inkjet Printing of Upconversion Nanoparticles for Anti-Counterfeit Applications, *Nanoscale*, 2015, **7**(10), 4423, DOI: [10.1039/c4nr06944g](#).
- 97 T. S. Tran, N. K. Dutta and N. R. Choudhury, Graphene Inks for Printed Flexible Electronics: Graphene Dispersions, Ink Formulations, Printing Techniques and Applications, *Adv. Colloid Interface Sci.*, 2018, **261**, 41, DOI: [10.1016/j.cis.2018.09.003](#).
- 98 S. Chung, K. Cho and T. Lee, Recent Progress in Inkjet-Printed Thin-Film Transistors, *Adv. Sci.*, 2019, **6**(6), 1801445, DOI: [10.1002/advs.201801445](#).
- 99 J. Kathirvelan, Recent Developments of Inkjet-Printed Flexible Sensing Electronics for Wearable Device Applications: A Review, *Sensor Review*, 2020, **41**(1), 46, DOI: [10.1108/sr-08-2020-0190](#).
- 100 B. N. Smith, P. Ballentine, J. L. Doherty, R. Wence, H. A. Hobbie, N. X. Williams and A. D. Franklin, Aerosol Jet Printing Conductive 3d Microstructures from Graphene without Post-Processing, *Small*, 2024, **20**(12), 2305170, DOI: [10.1002/sml.202305170](#).
- 101 X. Tang, H. Zhou, Z. Cai, D. Cheng, P. He, P. Xie, D. Zhang and T. Fan, Generalized 3d Printing of Graphene-Based Mixed-Dimensional Hybrid Aerogels, *ACS Nano*, 2018, **12**(4), 3502, DOI: [10.1021/acsnano.8b00304](#).
- 102 C. Fisher, L. N. Skolrood, K. Li, P. C. Joshi and T. Aytug, Aerosol-Jet Printed Sensors for Environmental, Safety, and Health Monitoring: A Review, *Adv. Mater. Technol.*, 2023, **8**(15), 2300030, DOI: [10.1002/admt.202300030](#).
- 103 M. A. Ali, C. S. Hu, B. Yuan, S. Jahan, M. S. Saleh, Z. T. Guo, A. J. Gellman and R. Panat, Breaking the Barrier to Biomolecule Limit-of-Detection Via 3d Printed Multi-Length-Scale Graphene-Coated Electrodes, *Nat. Commun.*, 2021, **12**(1), 7077, DOI: [10.1038/s41467-021-27361-x](#).
- 104 M. Sloma, 3d Printed Electronics with Nanomaterials, *Nanoscale*, 2023, **15**(12), 5623, DOI: [10.1039/D2NR06771D](#).
- 105 W. Zou, H. Yu, P. Zhou, Y. Zhong, Y. Wang and L. Liu, High-Resolution Additive Direct Writing of Metal Micro/Nanostructures by Electrohydrodynamic Jet Printing, *Appl. Surf. Sci.*, 2021, **543**, 148800, DOI: [10.1016/j.apsusc.2020.148800](#).
- 106 X. Zheng, M. Hu, Y. Liu, J. Zhang, X. Li, X. Li and H. Yang, High-Resolution Flexible Electronic Devices by Electrohydrodynamic Jet Printing: From Materials toward Applications, *Sci. China Mater.*, 2022, **65**(8), 2089, DOI: [10.1007/s40843-021-1988-8](#).
- 107 P. Ren and J. Dong, Electrohydrodynamic Printed Pedot:Pss/Graphene/Pva Circuits for Sustainable and Foldable Electronics, *Adv. Mater. Technol.*, 2023, **8**(22), 2301045, DOI: [10.1002/admt.202301045](#).
- 108 M. Saadi, A. Maguire, N. T. Pottackal, M. S. H. Thakur, M. M. Ikram, A. J. Hart, P. M. Ajayan and M. M. Rahman, Direct Ink Writing: A 3d Printing Technology for Diverse Materials, *Adv. Mater.*, 2022, **34**(28), 2108855, DOI: [10.1002/adma.202108855](#).
- 109 X. Yan, Y. Tong, X. Wang, F. Hou and J. Liang, Extrusion-Based 3d-Printed Supercapacitors: Recent Progress and Challenges, *Energy Environ. Mater.*, 2022, **5**(3), 800, DOI: [10.1002/eem2.12260](#).
- 110 Y. Liu, H. Wang, H. Yang, Z. Wang, Z. Huang, D. Pan, Z. Zhang, Z. Duan, T. Xu, D. Kong, X. Li, Y. Wang and J. Sun, Longevous Sodium Metal Anodes with High Areal Capacity Enabled by 3d-Printed Sodiophilic Monoliths, *ACS Nano*, 2023, **17**(11), 10844, DOI: [10.1021/acsnano.3c02506](#).





- 111 S.-C. Han, J.-L. Quan, F.-G. Zhou, Y.-H. Xue, N. Li, F.-Y. Li and D. Wang, 3d Printing of Architected Graphene-Based Aerogels by Cross-Linking Go Inks with Adjustable Viscoelasticity for Energy Storage Devices, *Rare Met.*, 2023, **42**(3), 971, DOI: [10.1007/s12598-022-02202-y](https://doi.org/10.1007/s12598-022-02202-y).
- 112 Z. Jiang, B. Diggle, M. L. Tan, J. Viktorova, C. W. Bennett and L. A. Connal, Extrusion 3d Printing of Polymeric Materials with Advanced Properties, *Adv. Sci.*, 2020, **7**(17), 2001379, DOI: [10.1002/advs.202001379](https://doi.org/10.1002/advs.202001379).
- 113 L. Zhang, J. Qin, P. Das, S. Wang, T. Bai, F. Zhou, M. Wu and Z.-S. Wu, Electrochemically Exfoliated Graphene Additive-Free Inks for 3d Printing Customizable Monolithic Integrated Micro-Supercapacitors on a Large Scale, *Adv. Mater.*, 2024, 2313930, DOI: [10.1002/adma.202313930](https://doi.org/10.1002/adma.202313930).
- 114 X. Zhang, C. Song, H. Nong, K. Xu, X. Wu, W. Zhong, M. Xing and L. Wang, Development of an Asymmetric Hydrophobic/Hydrophilic Ultrathin Graphene Oxide Membrane as Actuator and Conformable Patch for Heart Repair, *Adv. Funct. Mater.*, 2023, **33**(32), 2300866, DOI: [10.1002/adfm.202300866](https://doi.org/10.1002/adfm.202300866).
- 115 T. Pandhi, C. Cornwell, K. Fujimoto, P. Barnes, J. Cox, H. Xiong, P. H. Davis, H. Subbaraman, J. E. Koehne and D. Estrada, Fully Inkjet-Printed Multilayered Graphene-Based Flexible Electrodes for Repeatable Electrochemical Response, *RSC Adv.*, 2020, **10**(63), 38205, DOI: [10.1039/d0ra04786d](https://doi.org/10.1039/d0ra04786d).
- 116 H. Chen, F. Zhuo, J. Zhou, Y. Liu, J. Zhang, S. Dong, X. Liu, A. Elmarakbi, H. Duan and Y. Fu, Advances in Graphene-Based Flexible and Wearable Strain Sensors, *Chem. Eng. J.*, 2023, **464**, 142576, DOI: [10.1016/j.cej.2023.142576](https://doi.org/10.1016/j.cej.2023.142576).
- 117 T. D. Ngo, A. Kashani, G. Imbalzano, K. T. Q. Nguyen and D. Hui, Additive Manufacturing (3d Printing): A Review of Materials, Methods, Applications and Challenges, *Composites, Part B*, 2018, **143**, 172, DOI: [10.1016/j.compositesb.2018.02.012](https://doi.org/10.1016/j.compositesb.2018.02.012).
- 118 J. Muñoz, J. Oliver-De La Cruz, G. Forte and M. Pumera, Graphene-Based 3d-Printed Nanocomposite Bioelectronics for Monitoring Breast Cancer Cell Adhesion, *Biosens. Bioelectron.*, 2023, **226**, 115113, DOI: [10.1016/j.bios.2023.115113](https://doi.org/10.1016/j.bios.2023.115113).
- 119 C. L. M. Palenzuela, F. Novotny, P. Krupicka, Z. Sofer and M. Pumera, 3d-Printed Graphene/Poly(lactic Acid) Electrodes Promise High Sensitivity in Electroanalysis, *Anal. Chem.*, 2018, **90**(9), 5753, DOI: [10.1021/acs.analchem.8b00083](https://doi.org/10.1021/acs.analchem.8b00083).
- 120 X. Wei, D. Li, W. Jiang, Z. Gu, X. Wang, Z. Zhang and Z. Sun, 3d Printable Graphene Composite, *Sci. Rep.*, 2015, **5**, 11181, DOI: [10.1038/srep11181](https://doi.org/10.1038/srep11181).
- 121 O. Urrea Sanchez, H. Besharatloo, J. Yus, A. J. Sanchez-Herencia and B. Ferrari, Material Thermal Extrusion of Conductive 3d Electrodes Using Highly Loaded Graphene and Graphite Colloidal Feedstock, *Addit. Manuf.*, 2023, **72**, 103643, DOI: [10.1016/j.addma.2023.103643](https://doi.org/10.1016/j.addma.2023.103643).
- 122 C. Kalinke, N. V. Neumsteir, G. D. O. Aparecido, T. V. de Barros Ferraz, P. L. dos Santos, B. C. Janegitz and J. A. Bonacin, Comparison of Activation Processes for 3d Printed Pla-Graphene Electrodes: Electrochemical Properties and Application for Sensing of Dopamine, *Analyst*, 2020, **145**(4), 1207, DOI: [10.1039/c9an01926j](https://doi.org/10.1039/c9an01926j).
- 123 M. P. Browne, F. Novotny, Z. Sofer and M. Pumera, 3d Printed Graphene Electrodes' Electrochemical Activation, *ACS Appl. Mater. Interfaces*, 2018, **10**(46), 40294, DOI: [10.1021/acsami.8b14701](https://doi.org/10.1021/acsami.8b14701).
- 124 J. Munoz and M. Pumera, 3d-Printed Covid-19 Immunosensors with Electronic Readout, *Chem. Eng. J.*, 2021, **425**, 131433, DOI: [10.1016/j.cej.2021.131433](https://doi.org/10.1016/j.cej.2021.131433).
- 125 D. Tilve-Martinez, W. Neri, D. Horaud, N. Vukadinovic, B. Berton, A. Desmedt, J. Yuan and P. Poulin, Graphene Oxide Based Transparent Resins for Accurate 3d Printing of Conductive Materials, *Adv. Funct. Mater.*, 2023, **33**(21), 2214954, DOI: [10.1002/adfm.202214954](https://doi.org/10.1002/adfm.202214954).
- 126 F. Liu, Y. Gao, G. Wang, D. Wang, Y. Wang, M. He, X. Ding, H. Duan and S. Luo, Laser-Induced Graphene Enabled Additive Manufacturing of Multifunctional 3d Architectures with Freeform Structures, *Adv. Sci.*, 2023, **10**(4), e2204990, DOI: [10.1002/advs.202204990](https://doi.org/10.1002/advs.202204990).
- 127 E. M. Maines, M. K. Porwal, C. J. Ellison and T. M. Reineke, Sustainable Advances in Sls/Dlp 3d Printing Materials and Processes, *Green Chem.*, 2021, **23**(18), 6863, DOI: [10.1039/d1gc01489g](https://doi.org/10.1039/d1gc01489g).
- 128 Y. Yang, X. Li, M. Chu, H. Sun, J. Jin, K. Yu, Q. Wang, Q. Zhou and Y. Chen, Electrically Assisted 3d Printing of Nacre-Inspired Structures with Self-Sensing Capability, *Sci. Adv.*, 2019, **5**(4), eaau9490, DOI: [10.1126/sciadv.aau9490](https://doi.org/10.1126/sciadv.aau9490).
- 129 T. Xiao, C. Qian, R. X. Yin, K. M. Wang, Y. Gao and F. Z. Xuan, 3d Printing of Flexible Strain Sensor Array Based on Uv-Curable Multiwalled Carbon Nanotube/Elastomer Composite, *Adv. Mater. Technol.*, 2021, **6**(1), 2000745, DOI: [10.1002/admt.202000745](https://doi.org/10.1002/admt.202000745).
- 130 W. Yu, W. Zhao, S. Wang, Q. Chen and X. Liu, Direct Conversion of Liquid Organic Precursor into 3d Laser-Induced Graphene Materials, *Adv. Mater.*, 2023, **35**(9), 2209545, DOI: [10.1002/adma.202209545](https://doi.org/10.1002/adma.202209545).
- 131 J. Lin, Z. Peng, Y. Liu, F. Ruiz-Zepeda, R. Ye, E. L. Samuel, M. J. Yacaman, B. I. Yakobson and J. M. Tour, Laser-Induced Porous Graphene Films from Commercial Polymers, *Nat. Commun.*, 2014, **5**(1), 5714, DOI: [10.1038/ncomms6714](https://doi.org/10.1038/ncomms6714).
- 132 L. Huang, Y. Liu, G. Li, Y. Song, J. Su, L. Cheng, W. Guo, G. Zhao, H. Shen, Z. Yan, B. Z. Tang and R. Ye, Ultrasensitive, Fast-Responsive, Directional Airflow Sensing by Bioinspired Suspended Graphene Fibers, *Nano Lett.*, 2023, **23**(2), 597, DOI: [10.1021/acs.nanolett.2c04228](https://doi.org/10.1021/acs.nanolett.2c04228).
- 133 Y. Yuan, L. Jiang, X. Li, P. Zuo, C. Xu, M. Tian, X. Zhang, S. Wang, B. Lu, C. Shao, B. Zhao, J. Zhang, L. Qu and T. Cui, Laser Photonic-Reduction Stamping for Graphene-Based Micro-Supercapacitors Ultrafast Fabrication, *Nat. Commun.*, 2020, **11**(1), 6185, DOI: [10.1038/s41467-020-19985-2](https://doi.org/10.1038/s41467-020-19985-2).
- 134 T. S. D. Le, S. Park, J. An, P. S. Lee and Y. J. Kim, Ultrafast Laser Pulses Enable One-Step Graphene Patterning on Woods and Leaves for Green Electronics, *Adv. Funct. Mater.*, 2019, **29**(33), 1902771, DOI: [10.1002/adfm.201902771](https://doi.org/10.1002/adfm.201902771).



- 135 P. Zhang, Q. Liao, H. Yao, H. Cheng, Y. Huang, C. Yang, L. Jiang and L. Qu, Three-Dimensional Water Evaporation on a Macroporous Vertically Aligned Graphene Pillar Array under One Sun, *J. Mater. Chem. A*, 2018, **6**(31), 15303, DOI: [10.1039/c8ta05412f](https://doi.org/10.1039/c8ta05412f).
- 136 D. Echeverri, E. Calucho, J. Marrugo-Ramírez, R. Álvarez-Diduk, J. Orozco and A. Merkoçi, Capacitive Immunosensing at Gold Nanoparticle-Decorated Reduced Graphene Oxide Electrodes Fabricated by One-Step Laser Nanostructuration, *Biosens. Bioelectron.*, 2024, **252**, 116142, DOI: [10.1016/j.bios.2024.116142](https://doi.org/10.1016/j.bios.2024.116142).
- 137 Z. Zhang, H. Zhu, W. Zhang, Z. Zhang, J. Lu, K. Xu, Y. Liu and V. Saetang, A Review of Laser-Induced Graphene: From Experimental and Theoretical Fabrication Processes to Emerging Applications, *Carbon*, 2023, **214**, 118356, DOI: [10.1016/j.carbon.2023.118356](https://doi.org/10.1016/j.carbon.2023.118356).
- 138 N. Kurra, Q. Jiang, P. Nayak and H. N. Alshareef, Laser-Derived Graphene: A Three-Dimensional Printed Graphene Electrode and Its Emerging Applications, *Nano Today*, 2019, **24**, 81, DOI: [10.1016/j.nantod.2018.12.003](https://doi.org/10.1016/j.nantod.2018.12.003).
- 139 M. Devi, H. Wang, S. Moon, S. Sharma and V. Strauss, Laser-Carbonization – a Powerful Tool for Micro-Fabrication of Patterned Electronic Carbons, *Adv. Mater.*, 2023, **35**(38), 2211054, DOI: [10.1002/adma.202211054](https://doi.org/10.1002/adma.202211054).
- 140 M. Khandelwal, C. Van Tran, J. Lee and J. B. In, Nitrogen and Boron Co-Doped Densified Laser-Induced Graphene for Supercapacitor Applications, *Chem. Eng. J.*, 2022, **428**, 131119, DOI: [10.1016/j.cej.2021.131119](https://doi.org/10.1016/j.cej.2021.131119).
- 141 M. F. El-Kady, V. Strong, S. Dubin and R. B. Kaner, Laser Scribing of High-Performance and Flexible Graphene-Based Electrochemical Capacitors, *Science*, 2012, **335**(6074), 1326, DOI: [10.1126/science.1216744](https://doi.org/10.1126/science.1216744).
- 142 A. C. Bressi, A. Dallinger, Y. Steksova and F. Greco, Bioderived Laser-Induced Graphene for Sensors and Supercapacitors, *ACS Appl. Mater. Interfaces*, 2023, **15**(30), 35788, DOI: [10.1021/acsami.3c07687](https://doi.org/10.1021/acsami.3c07687).
- 143 C. H. Dreimol, H. Guo, M. Ritter, T. Keplinger, Y. Ding, R. Günther, E. Poloni, I. Burgert and G. Panzarasa, Sustainable Wood Electronics by Iron-Catalyzed Laser-Induced Graphitization for Large-Scale Applications, *Nat. Commun.*, 2022, **13**(1), 3680, DOI: [10.1038/s41467-022-31283-7](https://doi.org/10.1038/s41467-022-31283-7).
- 144 Y. Chyan, R. Ye, Y. Li, S. P. Singh, C. J. Arnusch and J. M. Tour, Laser-Induced Graphene by Multiple Lasing: Toward Electronics on Cloth, Paper, and Food, *ACS Nano*, 2018, **12**(3), 2176, DOI: [10.1021/acs.nano.7b08539](https://doi.org/10.1021/acs.nano.7b08539).
- 145 D. X. Luong, A. K. Subramanian, G. A. L. Silva, J. Yoon, S. Cofer, K. Yang, P. S. Owuor, T. Wang, Z. Wang, J. Lou, P. M. Ajayan and J. M. Tour, Laminated Object Manufacturing of 3d-Printed Laser-Induced Graphene Foams, *Adv. Mater.*, 2018, **30**(28), e1707416, DOI: [10.1002/adma.201707416](https://doi.org/10.1002/adma.201707416).
- 146 J. T. Li, M. G. Stanford, W. Chen, S. E. Presutti and J. M. Tour, Laminated Laser-Induced Graphene Composites, *ACS Nano*, 2020, **14**(7), 7911, DOI: [10.1021/acs.nano.0c02835](https://doi.org/10.1021/acs.nano.0c02835).
- 147 S. Zhang, M. Sharifuzzam, S. M. S. Rana, M. A. Zahed, S. Sharma, Y. Shin, H. Song and J. Y. Park, Highly Conductive, Stretchable, Durable, Skin-Conformal Dry Electrodes Based on Thermoplastic Elastomer-Embedded 3d Porous Graphene for Multifunctional Wearable Bioelectronics, *Nano Res.*, 2023, **16**(5), 7627, DOI: [10.1007/s12274-023-5429-5](https://doi.org/10.1007/s12274-023-5429-5).
- 148 M. Zeng, Y. Du, Q. Jiang, N. Kempf, C. Wei, M. V. Bimrose, A. N. M. Tanvir, H. Xu, J. Chen, D. J. Kirsch, J. Martin, B. C. Wyatt, T. Hayashi, M. Saeidi-Javash, H. Sakaue, B. Anasori, L. Jin, M. D. McMurtrey and Y. Zhang, High-Throughput Printing of Combinatorial Materials from Aerosols, *Nature*, 2023, **617**(7960), 292, DOI: [10.1038/s41586-023-05898-9](https://doi.org/10.1038/s41586-023-05898-9).
- 149 Y. Lu, G. Yang, S. Wang, Y. Zhang, Y. Jian, L. He, T. Yu, H. Luo, D. Kong, Y. Xianyu, B. Liang, T. Liu, X. Ouyang, J. Yu, X. Hu, H. Yang, Z. Gu, W. Huang and K. Xu, Stretchable Graphene-Hydrogel Interfaces for Wearable and Implantable Bioelectronics, *Nat. Electron.*, 2024, **7**(1), 51, DOI: [10.1038/s41928-023-01091-y](https://doi.org/10.1038/s41928-023-01091-y).
- 150 A. Prabhakaran and P. Nayak, Surface Engineering of Laser-Scribed Graphene Sensor Enables Non-Enzymatic Glucose Detection in Human Body Fluids, *ACS Appl. Nano Mater.*, 2019, **3**(1), 391, DOI: [10.1021/acsanm.9b02025](https://doi.org/10.1021/acsanm.9b02025).
- 151 T. Pinheiro, R. Correia, M. Morais, J. Coelho, E. Fortunato, M. G. F. Sales, A. C. Marques and R. Martins, Water Peel-Off Transfer of Electronically Enhanced, Paper-Based Laser-Induced Graphene for Wearable Electronics, *ACS Nano*, 2022, **16**(12), 20633, DOI: [10.1021/acs.nano.2c07596](https://doi.org/10.1021/acs.nano.2c07596).
- 152 L. Zhao, G. Rosati, A. Piper, C. de Carvalho Castro e Silva, L. Hu, Q. Yang, F. Della Pelle, R. R. Alvarez-Diduk and A. Merkoçi, Laser Reduced Graphene Oxide Electrode for Pathogenic Escherichia Coli Detection, *ACS Appl. Mater. Interfaces*, 2023, **15**(7), 9024, DOI: [10.1021/acsami.2c20859](https://doi.org/10.1021/acsami.2c20859).
- 153 C. Giacomelli, R. Álvarez-Diduk, A. Testolin and A. Merkoçi, Selective Stamping of Laser Scribed Rgo Nanofilms: From Sensing to Multiple Applications, *2D Mater.*, 2020, **7**(2), 024006, DOI: [10.1088/2053-1583/ab68a7](https://doi.org/10.1088/2053-1583/ab68a7).
- 154 F. Della Pelle, Q. U. A. Bukhari, R. Alvarez Diduk, A. Scroccarello, D. Compagnone and A. Merkoçi, Freestanding Laser-Induced Two Dimensional Heterostructures for Self-Contained Paper-Based Sensors, *Nanoscale*, 2023, **15**(15), 7164, DOI: [10.1039/D2NR07157F](https://doi.org/10.1039/D2NR07157F).
- 155 G. Rosati, M. Urban, L. Zhao, Q. Yang, C. D. C. Castro E Silva, S. Bonaldo, C. Parolo, E. P. Nguyen, G. Ortega, P. Fornasiero, A. Paccagnella and A. Merkoçi, A Plug, Print & Play Inkjet Printing and Impedance-Based Biosensing Technology Operating through a Smartphone for Clinical Diagnostics, *Biosens. Bioelectron.*, 2022, **196**, 113737, DOI: [10.1016/j.bios.2021.113737](https://doi.org/10.1016/j.bios.2021.113737).
- 156 Q. Yang, G. Rosati, V. Abarintos, M. A. Aroca, J. F. Osma and A. Merkoçi, Wearable and Fully Printed Microfluidic Nanosensor for Sweat Rate, Conductivity, and Copper Detection with Healthcare Applications, *Biosens. Bioelectron.*, 2022, **202**, 114005, DOI: [10.1016/j.bios.2022.114005](https://doi.org/10.1016/j.bios.2022.114005).
- 157 A. Rivadeneyra, M. Bobinger, A. Albrecht, M. Becherer, P. Lugli, A. Falco and J. F. Salmerón, Cost-Effective Pedot:Pss Temperature Sensors Inkjetted on a Bendable Substrate by



- a Consumer Printer, *Polymers*, 2019, **11**(5), 31067809, DOI: [10.3390/polym11050824](https://doi.org/10.3390/polym11050824).
- 158 I. M. Lei, Y. Sheng, C. L. Lei, C. Leow and Y. Y. S. Huang, A Hackable, Multi-Functional, and Modular Extrusion 3d Printer for Soft Materials, *Sci. Rep.*, 2022, **12**(1), 12294, DOI: [10.1038/s41598-022-16008-6](https://doi.org/10.1038/s41598-022-16008-6).
  - 159 J. L. Dávila, B. M. Manzini, M. A. d'Ávila and J. V. L. da Silva, Open-Source Syringe Extrusion Head for Shear-Thinning Materials 3d Printing, *Rapid Prototyp. J.*, 2022, **28**(8), 1452, DOI: [10.1108/RPJ-09-2021-0245](https://doi.org/10.1108/RPJ-09-2021-0245).
  - 160 H. Ma, Q. Jiang, X. Ma, R. Chen, K. Hua, X. Yang, J. Ge, J. Ji and M. Xue, Coaxial Graphene/Mxene Microfibers with Interfacial Buffer-Based Lightweight Distance Sensors Assisting Lossless Grasping of Fragile and Deformable Objects, *Langmuir*, 2023, **39**(12), 4530, DOI: [10.1021/acs.langmuir.3c00374](https://doi.org/10.1021/acs.langmuir.3c00374).
  - 161 H. A. Silva-Neto, A. A. Dias and W. K. T. Coltro, 3d-Printed Electrochemical Platform with Multi-Purpose Carbon Black Sensing Electrodes, *Microchim. Acta*, 2022, **189**(6), 235, DOI: [10.1007/s00604-022-05323-4](https://doi.org/10.1007/s00604-022-05323-4).
  - 162 Y. Yang, Y. Song, X. Bo, J. Min, O. S. Pak, L. Zhu, M. Wang, J. Tu, A. Kogan, H. Zhang, T. K. Hsiai, Z. Li and W. Gao, A Laser-Engraved Wearable Sensor for Sensitive Detection of Uric Acid and Tyrosine in Sweat, *Nat. Biotechnol.*, 2020, **38**(2), 217, DOI: [10.1038/s41587-019-0321-x](https://doi.org/10.1038/s41587-019-0321-x).
  - 163 Y. C. Qiao, X. S. Li, T. Hirtz, G. Deng, Y. H. Wei, M. R. Li, S. R. Ji, Q. Wu, J. M. Jian, F. Wu, Y. Shen, H. Tian, Y. Yang and T. L. Ren, Graphene-Based Wearable Sensors, *Nanoscale*, 2019, **11**(41), 18923, DOI: [10.1039/c9nr05532k](https://doi.org/10.1039/c9nr05532k).
  - 164 H. Wang, S. Li, H. Lu, M. Zhu, H. Liang, X. Wu and Y. Zhang, Carbon-Based Flexible Devices for Comprehensive Health Monitoring, *Small Methods*, 2023, **7**(2), 2201340, DOI: [10.1002/smt.202201340](https://doi.org/10.1002/smt.202201340).
  - 165 S. Zips, L. Grob, P. Rinklin, K. Terkan, N. Y. Adly, L. J. K. Weiss, D. Mayer and B. Wolfrum, Fully Printed Mu-Needle Electrode Array from Conductive Polymer Ink for Bioelectronic Applications, *ACS Appl. Mater. Interfaces*, 2019, **11**(36), 32778, DOI: [10.1021/acsami.9b11774](https://doi.org/10.1021/acsami.9b11774).
  - 166 A. Qureshi and J. H. Niazi, Graphene-Interfaced Flexible and Stretchable Micro-Nano Electrodes: From Fabrication to Sweat Glucose Detection, *Mater. Horiz.*, 2023, **10**(5), 1580, DOI: [10.1039/D2MH01517J](https://doi.org/10.1039/D2MH01517J).
  - 167 A. Piper, B. M. Alston, D. J. Adams and A. R. Mount, Functionalised Microscale Nanoband Edge Electrode (Mnee) Arrays: The Systematic Quantitative Study of Hydrogels Grown on Nanoelectrode Biosensor Arrays for Enhanced Sensing in Biological Media, *Faraday Discuss.*, 2018, **210**, 201, DOI: [10.1039/C8FD00063H](https://doi.org/10.1039/C8FD00063H).
  - 168 C. C. Pola, S. V. Rangnekar, R. Sheets, J. R. Downing, K. W. Parate, S. G. Wallace, D. Tsai, M. C. Hersam, C. L. Gomes and J. C. Claussen, Aerosol-Jet-Printed Graphene Electrochemical Immunosensors for Rapid and Label-Free Detection of Sars-Cov-2 in Saliva, *2D Mater.*, 2022, **9**(3), 035016, DOI: [10.1088/2053-1583/ac7339](https://doi.org/10.1088/2053-1583/ac7339).
  - 169 W. R. de Araujo, C. M. R. Frasson, W. A. Ameku, J. R. Silva, L. Angnes and T. Paixao, Single-Step Reagentless Laser Scribing Fabrication of Electrochemical Paper-Based Analytical Devices, *Angew. Chem., Int. Ed.*, 2017, **56**(47), 15113, DOI: [10.1002/anie.201708527](https://doi.org/10.1002/anie.201708527).
  - 170 A. Scroccarello, R. Álvarez-Diduk, F. Della Pelle, C. de Carvalho Castro e Silva, A. Idili, C. Parolo, D. Compagnone and A. Merkoçi, One-Step Laser Nanostructuring of Reduced Graphene Oxide Films Embedding Metal Nanoparticles for Sensing Applications, *ACS Sens.*, 2023, **8**(2), 598, DOI: [10.1021/acssensors.2c01782](https://doi.org/10.1021/acssensors.2c01782).
  - 171 A. R. Cardoso, A. C. Marques, L. Santos, A. F. Carvalho, F. M. Costa, R. Martins, M. G. F. Sales and E. Fortunato, Molecularly-Imprinted Chloramphenicol Sensor with Laser-Induced Graphene Electrodes, *Biosens. Bioelectron.*, 2019, **124**, 167, DOI: [10.1016/j.bios.2018.10.015](https://doi.org/10.1016/j.bios.2018.10.015).
  - 172 Z. T. Johnson, K. Williams, B. Chen, R. Sheets, N. Jared, J. Li, E. A. Smith and J. C. Claussen, Electrochemical Sensing of Neonicotinoids Using Laser-Induced Graphene, *ACS Sens.*, 2021, **6**(8), 3063, DOI: [10.1021/acssensors.1c01082](https://doi.org/10.1021/acssensors.1c01082).
  - 173 R. M. Torrente-Rodriguez, J. B. Tu, Y. R. Yang, J. H. Min, M. Q. Wang, Y. Song, Y. Yu, C. H. Xu, C. Ye, W. W. IsHak and W. Gao, Investigation of Cortisol Dynamics in Human Sweat Using a Graphene-Based Wireless Mhealth System, *Matter*, 2020, **2**(4), 921, DOI: [10.1016/j.matt.2020.01.021](https://doi.org/10.1016/j.matt.2020.01.021).
  - 174 F. Gerstl, U. Pongkitdachoti, F. Unob and A. J. Baeumner, Miniaturized Sensor for Electroanalytical and Electrochemiluminescent Detection of Pathogens Enabled through Laser-Induced Graphene Electrodes Embedded in Microfluidic Channels, *Lab Chip*, 2022, **22**(19), 3721, DOI: [10.1039/D2LC00593J](https://doi.org/10.1039/D2LC00593J).
  - 175 S. Lin, W. Feng, X. Miao, X. Zhang, S. Chen, Y. Chen, W. Wang and Y. Zhang, A Flexible and Highly Sensitive Nonenzymatic Glucose Sensor Based on Dvd-Laser Scribed Graphene Substrate, *Biosens. Bioelectron.*, 2018, **110**, 89, DOI: [10.1016/j.bios.2018.03.019](https://doi.org/10.1016/j.bios.2018.03.019).
  - 176 E. Aparicio-Martínez, A. Ibarra, I. A. Estrada-Moreno, V. Osuna and R. B. Dominguez, Flexible Electrochemical Sensor Based on Laser Scribed Graphene/Ag Nanoparticles for Non-Enzymatic Hydrogen Peroxide Detection, *Sens. Actuators, B*, 2019, **301**, 127101, DOI: [10.1016/j.snb.2019.127101](https://doi.org/10.1016/j.snb.2019.127101).
  - 177 S. Rauf, A. A. Lahcen, A. Aljedaibi, T. Beduk, J. I. de Oliveira Filho and K. N. Salama, Gold Nanostructured Laser-Scribed Graphene: A New Electrochemical Biosensing Platform for Potential Point-of-Care Testing of Disease Biomarkers, *Biosens. Bioelectron.*, 2021, **180**, 113116, DOI: [10.1016/j.bios.2021.113116](https://doi.org/10.1016/j.bios.2021.113116).
  - 178 B. Chen, Z. T. Johnson, D. Sanborn, R. G. Hjort, N. T. Garland, R. R. A. Soares, B. Van Belle, N. Jared, J. Li, D. Jing, E. A. Smith, C. L. Gomes and J. C. Claussen, Tuning the Structure, Conductivity, and Wettability of Laser-Induced Graphene for Multiplexed Open Microfluidic Environmental Biosensing and Energy Storage Devices, *ACS Nano*, 2022, **16**(1), 15, DOI: [10.1021/acsnano.1c04197](https://doi.org/10.1021/acsnano.1c04197).
  - 179 R. R. A. Soares, R. G. Hjort, C. C. Pola, K. Parate, E. L. Reis, N. F. F. Soares, E. S. McLamore, J. C. Claussen and C. L. Gomes, Laser-Induced Graphene Electrochemical





- Immunosensors for Rapid and Label-Free Monitoring of Salmonella Enterica in Chicken Broth, *ACS Sens.*, 2020, 5(7), 1900, DOI: [10.1021/acssensors.9b02345](https://doi.org/10.1021/acssensors.9b02345).
- 180 C. Zhang, J. F. Ping and Y. B. Ying, Evaluation of Trans-Resveratrol Level in Grape Wine Using Laser-Induced Porous Graphene-Based Electrochemical Sensor, *Sci. Total Environ.*, 2020, 714, 136687, DOI: [10.1016/j.scitotenv.2020.136687](https://doi.org/10.1016/j.scitotenv.2020.136687).
- 181 M. Massetti, S. Zhang, P. C. Harikesh, B. Burtscher, C. Diacci, D. T. Simon, X. Liu, M. Fahlman, D. Tu, M. Berggren and S. Fabiano, Fully 3d-Printed Organic Electrochemical Transistors, *npj Flexible Electron.*, 2023, 7(1), 11, DOI: [10.1038/s41528-023-00245-4](https://doi.org/10.1038/s41528-023-00245-4).
- 182 V. Silva, W. S. Fernandes, D. P. Rocha, J. S. Stefano, R. A. A. Munoz, J. A. Bonacin and B. C. Janegitz, 3d-Printed Reduced Graphene Oxide/Poly(lactic Acid) Electrodes: A New Prototyped Platform for Sensing and Biosensing Applications, *Biosens. Bioelectron.*, 2020, 170, 112684, DOI: [10.1016/j.bios.2020.112684](https://doi.org/10.1016/j.bios.2020.112684).
- 183 J. G. Walters, S. Ahmed, I. M. T. Rodriguez and G. D. O'Neil, Trace Analysis of Heavy Metals (Cd, Pb, Hg) Using Native and Modified 3d Printed Graphene/Poly(Lactic Acid) Composite Electrodes, *Electroanalysis*, 2020, 32(4), 859, DOI: [10.1002/elan.201900658](https://doi.org/10.1002/elan.201900658).
- 184 R. G. Rocha, J. S. Ribeiro, M. H. P. Santana, E. M. Richter and R. A. A. Munoz, 3d-Printing for Forensic Chemistry: Voltammetric Determination of Cocaine on Additively Manufactured Graphene-Poly(lactic Acid) Electrodes, *Anal. Methods*, 2021, 13(15), 1788, DOI: [10.1039/d1ay00181g](https://doi.org/10.1039/d1ay00181g).
- 185 L. R. G. Silva, J. S. Stefano, L. O. Orzari, L. C. Brazaca, E. Carrilho, L. H. Marcolino-Junior, M. F. Bergamini, R. A. A. Munoz and B. C. Janegitz, Electrochemical Biosensor for Sars-Cov-2 Cdna Detection Using Aups-Modified 3d-Printed Graphene Electrodes, *Biosensors*, 2022, 12(8), 622, DOI: [10.3390/bios12080622](https://doi.org/10.3390/bios12080622).
- 186 R. M. Cardoso, P. R. L. Silva, A. P. Lima, D. P. Rocha, T. C. Oliveira, T. M. do Prado, E. L. Fava, O. Fatibello-Filho, E. M. Richter and R. A. A. Munoz, 3d-Printed Graphene/Poly(lactic Acid) Electrode for Bioanalysis: Biosensing of Glucose and Simultaneous Determination of Uric Acid and Nitrite in Biological Fluids, *Sens. Actuators, B*, 2020, 307, 127621, DOI: [10.1016/j.snb.2019.127621](https://doi.org/10.1016/j.snb.2019.127621).
- 187 A. M. L. Marzo, C. C. Mayorga-Martinez and M. Pumera, 3d-Printed Graphene Direct Electron Transfer Enzyme Biosensors, *Biosens. Bioelectron.*, 2020, 151, 111980, DOI: [10.1016/j.bios.2019.111980](https://doi.org/10.1016/j.bios.2019.111980).
- 188 C. Kalinke, N. V. Neumsteir, P. R. de Oliveira, B. C. Janegitz and J. A. Bonacin, Sensing of L-Methionine in Biological Samples through Fully 3d-Printed Electrodes, *Anal. Chim. Acta*, 2021, 1142, 135, DOI: [10.1016/j.aca.2020.10.034](https://doi.org/10.1016/j.aca.2020.10.034).
- 189 A. R. Naik, Y. Zhou, A. A. Dey, D. L. G. Arellano, U. Okoroanyanwu, E. B. Secor, M. C. Hersam, J. Morse, J. P. Rothstein, K. R. Carter and J. J. Watkins, Printed Microfluidic Sweat Sensing Platform for Cortisol and Glucose Detection, *Lab Chip*, 2022, 22(1), 156, DOI: [10.1039/D1LC00633A](https://doi.org/10.1039/D1LC00633A).
- 190 L. M. Dongmo, L. S. Guenang, S. L. Z. Jiokeng, A. T. Kamdem, G. Doungmo, B. C. Victor, M. Jović, A. Lesch, I. K. Tonlé and H. Girault, A New Sensor Based on an Amino-Montmorillonite-Modified Inkjet-Printed Graphene Electrode for the Voltammetric Determination of Gentisic Acid, *Microchim. Acta*, 2021, 188(2), 36, DOI: [10.1007/s00604-020-04651-7](https://doi.org/10.1007/s00604-020-04651-7).
- 191 S. Demuru, C.-H. Huang, K. Parvez, R. Worsley, G. Mattana, B. Piro, V. Noël, C. Casiraghi and D. Briand, All-Inkjet-Printed Graphene-Gated Organic Electrochemical Transistors on Polymeric Foil as Highly Sensitive Enzymatic Biosensors, *ACS Appl. Nano Mater.*, 2022, 5(1), 1664, DOI: [10.1021/acsanm.1c04434](https://doi.org/10.1021/acsanm.1c04434).
- 192 S. Y. Al-nami, A. Q. Alorabi, Z. A. Al-Ahmed, A. T. Mogharbel, H. M. Abumelha, M. A. Hussein and N. M. El-Metwaly, Superficial and Inkjet Scalable Printed Sensors Integrated with Iron Oxide and Reduced Graphene Oxide for Sensitive Voltammetric Determination of Lurasidone, *ACS Omega*, 2023, 8(11), 10449, DOI: [10.1021/acsomega.3c00040](https://doi.org/10.1021/acsomega.3c00040).
- 193 M. Q. Wang, Y. R. Yang, J. H. Min, Y. Song, J. B. Tu, D. Mukasa, C. Ye, C. H. Xu, N. Hefflin, J. S. McCune, T. K. Hsiai, Z. P. Li and W. Gao, A Wearable Electrochemical Biosensor for the Monitoring of Metabolites and Nutrients, *Nat. Biomed. Eng.*, 2022, 6(11), 1225, DOI: [10.1038/s41551-022-00916-z](https://doi.org/10.1038/s41551-022-00916-z).
- 194 S. Ma, Z. A. Wan, C. Wang, Z. Song, Y. Ding, D. Zhang, C. L. J. Chan, L. Shu, L. Huang, Z. Yang, F. Wang, J. Bai, Z. Fan and Y. Lin, Ultra-Sensitive and Stable Multiplexed Biosensors Array in Fully Printed and Integrated Platforms for Reliable Perspiration Analysis, *Adv. Mater.*, 2024, 2311106, DOI: [10.1002/adma.202311106](https://doi.org/10.1002/adma.202311106).
- 195 J. Li, Y. Liu, L. Yuan, B. Zhang, E. S. Bishop, K. Wang, J. Tang, Y.-Q. Zheng, W. Xu, S. Niu, L. Beker, T. L. Li, G. Chen, M. Diyaolu, A.-L. Thomas, V. Mottini, J. B. H. Tok, J. C. Y. Dunn, B. Cui, S. P. Paşca, Y. Cui, A. Habtezion, X. Chen and Z. Bao, A Tissue-Like Neurotransmitter Sensor for the Brain and Gut, *Nature*, 2022, 606(7912), 94, DOI: [10.1038/s41586-022-04615-2](https://doi.org/10.1038/s41586-022-04615-2).
- 196 Q. Zhang, F. Zhang, X. Liu, Z. Yue, X. Chen and Z. Wan, Doping of Laser-Induced Graphene and Its Applications, *Adv. Mater. Technol.*, 2023, 8(16), 2300244, DOI: [10.1002/admt.202300244](https://doi.org/10.1002/admt.202300244).
- 197 L. Zhao, Z. Chang, B. Guo, Y. Lu, X. Lu, Q. Ren, A. Lv, J. Nie, D. Ji, M. Y. Rotenberg, B. Wang, Y. Zhang and Y. Fang, Robust, Stretchable Bioelectronic Interfaces for Cardiac Pacing Enabled by Interfacial Transfer of Laser-Induced Graphene Via Water-Response, Nonswellable Pva Gels, *Biosens. Bioelectron.*, 2024, 261, 116453, DOI: [10.1016/j.bios.2024.116453](https://doi.org/10.1016/j.bios.2024.116453).
- 198 M. J. Russo, M. Han, P. E. Desroches, C. S. Manasa, J. Dennaoui, A. F. Quigley, R. M. I. Kapsa, S. E. Moulton, R. M. Guijt, G. W. Greene and S. M. Silva, Antifouling Strategies for Electrochemical Biosensing: Mechanisms and Performance toward Point of Care Based Diagnostic Applications, *ACS Sens.*, 2021, 6(4), 1482, DOI: [10.1021/acssensors.1c00390](https://doi.org/10.1021/acssensors.1c00390).



- 199 K. L. Rahn, U. Peramune, T. Zhang and R. K. Anand, Label-Free Electrochemical Methods for Disease Detection, *Annu. Rev. Anal. Chem.*, 2023, **16**, 49, DOI: [10.1146/annurev-anchem-091622-085754](https://doi.org/10.1146/annurev-anchem-091622-085754).
- 200 C. Ye, M. Wang, J. Min, R. Y. Tay, H. Lukas, J. R. Sempionatto, J. Li, C. Xu and W. Gao, A Wearable Aptamer Nanobiosensor for Non-Invasive Female Hormone Monitoring, *Nat. Nanotechnol.*, 2024, **19**(3), 330, DOI: [10.1038/s41565-023-01513-0](https://doi.org/10.1038/s41565-023-01513-0).
- 201 H. Zhang and S. K. Moon, Reviews on Machine Learning Approaches for Process Optimization in Noncontact Direct Ink Writing, *ACS Appl. Mater. Interfaces*, 2021, **13**(45), 53323, DOI: [10.1021/acsami.1c04544](https://doi.org/10.1021/acsami.1c04544).
- 202 Y. Zhang, Y. Hu, N. Jiang and A. K. Yetisen, Wearable Artificial Intelligence Biosensor Networks, *Biosens. Bioelectron.*, 2023, **219**, 114825, DOI: [10.1016/j.bios.2022.114825](https://doi.org/10.1016/j.bios.2022.114825).
- 203 J. Tu, J. Min, Y. Song, C. Xu, J. Li, J. Moore, J. Hanson, E. Hu, T. Parimon, T.-Y. Wang, E. Davoodi, T.-F. Chou, P. Chen, J. J. Hsu, H. B. Rossiter and W. Gao, A Wireless Patch for the Monitoring of C-Reactive Protein in Sweat, *Nat. Biomed. Eng.*, 2023, **7**(10), 1293, DOI: [10.1038/s41551-023-01059-5](https://doi.org/10.1038/s41551-023-01059-5).
- 204 Y. Song, R. Y. Tay, J. Li, C. Xu, J. Min, E. Shirzaei Sani, G. Kim, W. Heng, I. Kim and W. Gao, 3d-Printed Epifluidic Electronic Skin for Machine Learning-Powered Multimodal Health Surveillance, *Sci. Adv.*, 2023, **9**(37), eadi6492, DOI: [10.1126/sciadv.adi6492](https://doi.org/10.1126/sciadv.adi6492).
- 205 J. Ma, S. Zheng, L. Chi, Y. Liu, Y. Zhang, K. Wang and Z.-S. Wu, 3d Printing Flexible Sodium-Ion Microbatteries with Ultrahigh Areal Capacity and Robust Rate Capability, *Adv. Mater.*, 2022, **34**(39), 2205569, DOI: [10.1002/adma.202205569](https://doi.org/10.1002/adma.202205569).
- 206 Y.-T. Kwon, Y.-S. Kim, S. Kwon, M. Mahmood, H.-R. Lim, S.-W. Park, S.-O. Kang, J. J. Choi, R. Herbert, Y. C. Jang, Y.-H. Choa and W.-H. Yeo, All-Printed Nanomembrane Wireless Bioelectronics Using a Biocompatible Solderable Graphene for Multimodal Human-Machine Interfaces, *Nat. Commun.*, 2020, **11**(1), 3450, DOI: [10.1038/s41467-020-17288-0](https://doi.org/10.1038/s41467-020-17288-0).

