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Tips on preventing thread galling on Stainless Steel Fasteners

- 1. Slowing down the installation RPM speed will frequently reduce, or sometimes solve completely, the problem. As the installation RPM increases, the heat generated during tightening increases. As the heat increases, so does the tendency for the occurrence of thread galling.**
- 2. Lubricating the internal and/or external threads frequently eliminates thread galling. The suggested lubricants should contain substantial amounts of molybdenum disulfide (moly), graphite, mica, or talc. Some proprietary, extreme pressure waxes may also be effective. You must be aware of the end use of the fasteners before settling on a lubricant. Stainless steel is frequently used in food related applications, which may make some lubricants unacceptable. Lubricants can be applied at the point of assembly or pre-applied as a batch process similar to plating. Several chemical companies offer anti-galling lubricants.**
- 3. Using different stainless alloy grades for the bolt and the nut reduces galling. The key here is the mating of materials having different hardnesses. If one of the components is 316 and the other is 304 they're less likely to gall than if they're both of the same alloy grade. This is because different alloys work-harden at different rates.**