



Once all of the thorns are done, put a tenon on the end of the stem for the petals using a grinder, mill or I use a 2x72. It doesn't have to be really round, in fact, if it's not quite round I find the petals don't rotate as easy.



Adding the Petals

Its time to add the petals. Drill the centers of the petals again to match the size of the tenon. I make this a very tight fit so that I have to hammer the petals on.

I flatten the center of the petals to ensure that I get a good tight stack. Through all of the shaping, sometimes the center portion has warped or twisted. I just use a small round hammer and put it in the press. Seat the petals with so that they are good and tight.



This way the petals dont rattle or rotate. Start with the bottom star, then the largest to the smallest last.

The bottom star should curve down as this was the shell of the rose before it opened.



Add each set of petals and ensure that they sit flat against the previous set. You will have to bend each layer progressively up so that they all sit flat.

Peen or weld the tenon over to lock in the petals. I actually do both to ensure a nice tight fit.



Shaping

When shaping the petals you need some very simple tools. A propane torch or something hotter, although propane quite sufficient for this. And some pliers for shaping. I use 3 different sets. Needle nose pliers, scrolling pliers and slip joint pliers.

Starting with one of the inner most leaves you want to make a very tight scroll for the center bud. Heat the petal and using the scrolling pliers or needle nose, roll it up as tight as you can, then ever so slightly roll the very edge lip outwards. I find the teeth on the needle nose pliers make nice serrations to the lip of the petal if you keep the pliers parallel to the edge.

Pick up the next petal to right wrap it around the first, always work counterclockwise, as a real rose is a spiral of leaves trying to open. Wrap things as tight as you can at this stage. You can always open it later, but you cant make it tighter later.



Keep picking up petals one at a time. As you pick up each petal, make sure the base is as tight as you can make it. Keeping the base tight will ensure that the petals go up as far as possible.

When pulling each petal up, progressively make the "lip" of each petal larger.



When shaping the bottom star, they actually curve the opposite direction of the petals



The last step is to now weld on the leaves you created



The basic rose is now finished and its time to clean it up with a wire brush, and then I like to add some brass highlights.

To add the brass highlights, you need a pure brass brush. I use one I found for a dremel, but I have found manual ones too. I just find the speed of the dremel helps to heat the brass to braze to the steel. With the dremel, I use around 20k rpm.



The last part the rose is delivery. I make a simple cedar box and some tissue paper. The box is made from a single piece of 2x8 and is just tacked together with finishing nails.





Templates:

<https://img1.wsimg.com/blobby/go/cdcb9f24-e321-4023-8b91-5ff0b922b0d3/2023-05-15%2007-24.pdf>

Disclaimer: I am not a professional, just a hobbyist. I dont know if this is the best way, its just my way of creating a rose.