CLAIMS

1. A casting mold comprising:

a part-forming cavity (296) having a lower end and an upper end (406);

a pour cone; and

a downsprue extending from the pour cone toward the part-forming cavity and comprising:

a lower portion (402) having a plurality of ports in communication with the part-forming cavity; and

an upper portion telescoping (404) relative to the lower portion and coupling the lower portion to the pour cone.

2. The casting mold of claim 7 wherein:

the mold along the part-forming cavity and the lower portion are formed as a single piece.

3. The casting mold of claim 7 wherein:

the part-forming cavity is one of a plurality of part-forming cavities;

each of the plurality of part-forming cavities coupled to a single said downsprue.

4. The casting mold of claim 7 wherein the part is a blade and the part-forming cavity comprises:

a root portion for casting an attachment root of the blade; and

an airfoil section for casting an airfoil of the blade, the airfoil having a first end and a second end and a span between the first end and the second end.

5. The casting mold of claim 7 further comprising a grain starter (298) below the part-forming cavity.

6. A method for using the casting mold of claim 7, the method comprising:

introducing a molten alloy to the part-forming cavity through the pour cone and a lower port of the plurality of ports;

extending the upper portion relative to the lower portion; and

introducing a molten alloy to the part-forming cavity through the pour cone and an upper port of the plurality of ports.

7. The method of claim 12 wherein the molten alloy introduced through the upper port is different from the molten alloy introduced through the lower port.

8. The method of claim 12 wherein the part is a blade and the part-forming cavity comprises:

a root portion for casting an attachment root of the blade; and

an airfoil portion for casting an airfoil of the blade, the airfoil having a first end and a second end and a span between the first end and the second end.

9. The method of claim 12 wherein:

a crystalline structure is initiated by a grain starter (298).

10. The method of claim 12 wherein:

a crystalline structure propagates across a transition from first alloy to a second alloy.

11. The method of claim 12 wherein the molten alloy introduced through the upper port is introduced after a partial solidification of the molten alloy introduced through the lower port.

12. The method of claim 12 wherein the molten alloy introduced through the upper port is introduced from a second ingot and the molten alloy introduced through the lower port is introduced from a first ingot.