15. The casting mold of claim 14 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.

16. The casting mold of claim 15 wherein the apex (550; 550-2) is at a level along the span.

17. The casting mold of claim 14 further comprising a grain starter (298) below the part-forming cavity.

18. The casting mold of claim 14 wherein the overflow passageway comprises an up-pass (304; 304-2) from the part-forming cavity to the apex and a downpass (310; 310-2) from the apex and including an enlarged chamber (302; 302-2).

19. The casting mold of claim 14 further comprising:

a pour cone (406); and

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

a lower portion (402) having a plurality of ports (422, 428) in communication with the part-forming cavity; and

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

20. The casting mold of claim 14 further comprising:

a first pour cone (602);

a downsprue (606, 360) extending from the first pour cone toward the part-forming cavity; and

a second pour cone (604) in communication with the part-forming cavity.

21. The casting mold of claim 14 having a casting apparatus, the casting apparatus having:

a first molten metal source (802-1; 902-1) in the form of:

a first ingot feeder (804);

a first induction melter (808) or first hearth positioned to receive an ingot from

15. The casting mold of claim 14 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.

16. The casting mold of claim 15 wherein the apex (550; 550-2) is at a level along the span.

17. The casting mold of claim 14 further comprising a grain starter (298) below the part-forming cavity.

18. The casting mold of claim 14 wherein the overflow passageway comprises an up-pass (304; 304-2) from the part-forming cavity to the apex and a downpass (310; 310-2) from the apex and including an enlarged chamber (302; 302-2).

19. The casting mold of claim 14 further comprising:

a pour cone (406); and

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

a lower portion (402) having a plurality of ports (422, 428) in communication with the part-forming cavity; and

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

20. The casting mold of claim 14 further comprising:

a first pour cone (602);

a downsprue (606, 360) extending from the first pour cone toward the part-forming cavity; and

a second pour cone (604) in communication with the part-forming cavity.

21. A casting apparatus incorporating the casting mold of claim 14 wherein the casting apparatus comprises:

a first molten metal source (802-1; 902-1) in the form of:

a first ingot feeder (804);

a first induction melter (808) or first hearth positioned to receive an ingot from