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 1 wherein:

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

3. The casting mold of claim 1 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 1 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 1 further comprising a grain starter (298) below the part-forming cavity.

6. A method for using the casting mold of claim 1, 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 6 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 6 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 6 wherein:

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

10. The method of claim 6 wherein:

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

11. The method of claim 6 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 6 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.