

20以内进位加法•多品强化训练

纯进位版



$8 + 3 =$	$7 + 3 =$	$4 + 9 =$	$5 + 5 =$	$5 + 6 =$
$9 + 2 =$	$5 + 15 =$	$5 + 15 =$	$8 + 4 =$	$1 + 9 =$
$9 + 2 =$	$2 + 9 =$	$8 + 5 =$	$6 + 5 =$	$4 + 16 =$
$16 + 4 =$	$6 + 8 =$	$8 + 2 =$	$12 + 8 =$	$7 + 4 =$
$7 + 6 =$	$6 + 5 =$	$4 + 7 =$	$5 + 6 =$	$8 + 3 =$
$4 + 9 =$	$9 + 2 =$	$3 + 7 =$	$5 + 8 =$	$8 + 3 =$
$7 + 6 =$	$4 + 7 =$	$1 + 9 =$	$4 + 9 =$	$12 + 8 =$
$7 + 5 =$	$8 + 9 =$	$8 + 3 =$	$9 + 3 =$	$8 + 8 =$
$17 + 3 =$	$9 + 3 =$	$3 + 8 =$	$6 + 9 =$	$7 + 4 =$
$6 + 8 =$	$8 + 2 =$	$5 + 6 =$	$6 + 4 =$	$5 + 6 =$
$5 + 6 =$	$4 + 9 =$	$9 + 2 =$	$6 + 6 =$	$6 + 5 =$
$9 + 2 =$	$7 + 3 =$	$4 + 9 =$	$8 + 7 =$	$5 + 6 =$
$7 + 5 =$	$6 + 4 =$	$6 + 8 =$	$9 + 3 =$	$7 + 6 =$
$2 + 8 =$	$9 + 4 =$	$9 + 2 =$	$6 + 5 =$	$1 + 19 =$
$3 + 17 =$	$9 + 9 =$	$8 + 5 =$	$7 + 6 =$	$5 + 6 =$
$9 + 4 =$	$7 + 5 =$	$17 + 3 =$	$6 + 7 =$	$6 + 5 =$
$9 + 1 =$	$6 + 4 =$	$7 + 6 =$	$7 + 13 =$	$2 + 9 =$
$6 + 7 =$	$6 + 5 =$	$3 + 7 =$	$5 + 5 =$	$3 + 8 =$
$4 + 9 =$	$3 + 7 =$	$3 + 7 =$	$1 + 9 =$	$1 + 9 =$
$17 + 3 =$	$6 + 6 =$	$13 + 7 =$	$3 + 9 =$	$6 + 5 =$

完成时间: _____

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$13 + 7 =$	$2 + 9 =$	$8 + 6 =$	$7 + 6 =$	$6 + 5 =$
$7 + 7 =$	$4 + 8 =$	$9 + 6 =$	$7 + 8 =$	$8 + 12 =$
$6 + 4 =$	$1 + 9 =$	$8 + 2 =$	$7 + 4 =$	$7 + 5 =$
$6 + 5 =$	$2 + 9 =$	$5 + 5 =$	$7 + 5 =$	$9 + 5 =$
$4 + 7 =$	$6 + 4 =$	$9 + 3 =$	$8 + 6 =$	$5 + 5 =$
$5 + 15 =$	$6 + 5 =$	$3 + 8 =$	$4 + 6 =$	$7 + 13 =$
$4 + 8 =$	$6 + 6 =$	$11 + 9 =$	$6 + 8 =$	$4 + 8 =$
$9 + 3 =$	$6 + 8 =$	$5 + 7 =$	$8 + 7 =$	$14 + 6 =$
$7 + 13 =$	$4 + 7 =$	$8 + 12 =$	$3 + 9 =$	$7 + 3 =$
$6 + 14 =$	$6 + 6 =$	$5 + 7 =$	$4 + 16 =$	$8 + 2 =$
$5 + 6 =$	$9 + 1 =$	$8 + 2 =$	$16 + 4 =$	$7 + 5 =$
$6 + 5 =$	$3 + 9 =$	$7 + 4 =$	$8 + 4 =$	$7 + 3 =$
$8 + 2 =$	$3 + 7 =$	$8 + 4 =$	$6 + 4 =$	$9 + 1 =$
$9 + 3 =$	$5 + 8 =$	$5 + 5 =$	$6 + 4 =$	$7 + 5 =$
$9 + 1 =$	$6 + 4 =$	$8 + 3 =$	$15 + 5 =$	$1 + 19 =$
$9 + 7 =$	$14 + 6 =$	$13 + 7 =$	$15 + 5 =$	$9 + 11 =$
$9 + 1 =$	$2 + 8 =$	$5 + 9 =$	$9 + 7 =$	$2 + 8 =$
$19 + 1 =$	$4 + 7 =$	$8 + 3 =$	$7 + 5 =$	$4 + 6 =$
$7 + 6 =$	$8 + 7 =$	$9 + 6 =$	$5 + 5 =$	$9 + 4 =$
$8 + 2 =$	$9 + 3 =$	$2 + 18 =$	$7 + 3 =$	$19 + 1 =$

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$8 + 12 =$	$4 + 6 =$	$7 + 13 =$	$9 + 2 =$	$2 + 9 =$
$7 + 4 =$	$2 + 9 =$	$7 + 13 =$	$2 + 8 =$	$6 + 6 =$
$9 + 2 =$	$7 + 4 =$	$4 + 8 =$	$3 + 9 =$	$2 + 9 =$
$12 + 8 =$	$6 + 4 =$	$7 + 4 =$	$8 + 5 =$	$9 + 3 =$
$9 + 5 =$	$6 + 6 =$	$7 + 8 =$	$6 + 6 =$	$5 + 6 =$
$3 + 8 =$	$6 + 6 =$	$7 + 7 =$	$13 + 7 =$	$8 + 4 =$
$7 + 7 =$	$7 + 8 =$	$8 + 4 =$	$5 + 7 =$	$3 + 9 =$
$7 + 4 =$	$9 + 11 =$	$4 + 6 =$	$4 + 8 =$	$6 + 7 =$
$6 + 4 =$	$7 + 7 =$	$3 + 8 =$	$3 + 7 =$	$5 + 5 =$
$9 + 5 =$	$6 + 6 =$	$8 + 2 =$	$4 + 7 =$	$7 + 9 =$
$2 + 8 =$	$6 + 6 =$	$4 + 8 =$	$5 + 15 =$	$7 + 4 =$
$5 + 9 =$	$8 + 4 =$	$7 + 5 =$	$6 + 14 =$	$4 + 9 =$
$7 + 3 =$	$7 + 3 =$	$7 + 5 =$	$18 + 2 =$	$5 + 7 =$
$7 + 5 =$	$4 + 6 =$	$4 + 9 =$	$6 + 4 =$	$8 + 2 =$
$4 + 8 =$	$8 + 2 =$	$4 + 7 =$	$5 + 6 =$	$9 + 9 =$
$9 + 1 =$	$5 + 6 =$	$2 + 9 =$	$15 + 5 =$	$5 + 6 =$
$4 + 7 =$	$9 + 3 =$	$2 + 8 =$	$13 + 7 =$	$9 + 7 =$
$4 + 6 =$	$11 + 9 =$	$11 + 9 =$	$1 + 9 =$	$15 + 5 =$
$14 + 6 =$	$2 + 8 =$	$9 + 9 =$	$5 + 7 =$	$7 + 7 =$
$4 + 6 =$	$7 + 13 =$	$9 + 9 =$	$9 + 2 =$	$8 + 4 =$

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$4 + 6 =$	$2 + 18 =$	$7 + 6 =$	$2 + 8 =$	$4 + 16 =$
$3 + 7 =$	$1 + 9 =$	$9 + 5 =$	$6 + 4 =$	$2 + 8 =$
$19 + 1 =$	$3 + 8 =$	$6 + 14 =$	$7 + 4 =$	$8 + 3 =$
$5 + 7 =$	$8 + 12 =$	$8 + 2 =$	$9 + 11 =$	$9 + 5 =$
$5 + 7 =$	$3 + 7 =$	$5 + 6 =$	$16 + 4 =$	$9 + 9 =$
$9 + 2 =$	$1 + 19 =$	$4 + 8 =$	$6 + 4 =$	$7 + 7 =$
$5 + 7 =$	$7 + 3 =$	$4 + 6 =$	$9 + 1 =$	$5 + 6 =$
$5 + 15 =$	$8 + 5 =$	$7 + 7 =$	$9 + 11 =$	$6 + 7 =$
$6 + 6 =$	$4 + 6 =$	$6 + 7 =$	$14 + 6 =$	$5 + 5 =$
$3 + 8 =$	$5 + 15 =$	$7 + 13 =$	$9 + 7 =$	$5 + 6 =$
$6 + 8 =$	$9 + 2 =$	$3 + 8 =$	$7 + 5 =$	$7 + 6 =$
$14 + 6 =$	$4 + 7 =$	$8 + 2 =$	$8 + 6 =$	$7 + 3 =$
$2 + 9 =$	$7 + 3 =$	$5 + 7 =$	$7 + 13 =$	$14 + 6 =$
$5 + 9 =$	$4 + 8 =$	$9 + 1 =$	$7 + 4 =$	$8 + 12 =$
$15 + 5 =$	$7 + 3 =$	$8 + 9 =$	$5 + 7 =$	$8 + 6 =$
$4 + 9 =$	$6 + 7 =$	$4 + 7 =$	$1 + 9 =$	$15 + 5 =$
$11 + 9 =$	$5 + 7 =$	$8 + 8 =$	$14 + 6 =$	$7 + 3 =$
$9 + 11 =$	$4 + 6 =$	$17 + 3 =$	$9 + 6 =$	$8 + 5 =$
$7 + 5 =$	$5 + 15 =$	$5 + 7 =$	$7 + 3 =$	$7 + 3 =$
$9 + 2 =$	$8 + 8 =$	$3 + 17 =$	$5 + 5 =$	$5 + 8 =$

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$6 + 6 =$	$7 + 8 =$	$9 + 11 =$	$1 + 9 =$	$9 + 1 =$
$7 + 9 =$	$3 + 8 =$	$8 + 12 =$	$3 + 7 =$	$8 + 4 =$
$5 + 5 =$	$2 + 8 =$	$4 + 8 =$	$15 + 5 =$	$5 + 6 =$
$7 + 5 =$	$2 + 8 =$	$6 + 7 =$	$15 + 5 =$	$5 + 7 =$
$5 + 6 =$	$9 + 2 =$	$11 + 9 =$	$9 + 1 =$	$8 + 4 =$
$7 + 5 =$	$5 + 6 =$	$3 + 17 =$	$5 + 5 =$	$4 + 16 =$
$9 + 1 =$	$4 + 7 =$	$2 + 9 =$	$8 + 2 =$	$7 + 4 =$
$6 + 4 =$	$2 + 8 =$	$7 + 3 =$	$9 + 1 =$	$5 + 6 =$
$9 + 2 =$	$7 + 6 =$	$5 + 9 =$	$8 + 2 =$	$8 + 12 =$
$5 + 9 =$	$4 + 7 =$	$9 + 7 =$	$6 + 7 =$	$3 + 9 =$
$7 + 4 =$	$14 + 6 =$	$6 + 4 =$	$6 + 7 =$	$9 + 2 =$
$13 + 7 =$	$5 + 6 =$	$7 + 7 =$	$1 + 9 =$	$1 + 9 =$
$9 + 2 =$	$7 + 9 =$	$4 + 9 =$	$7 + 4 =$	$1 + 9 =$
$17 + 3 =$	$6 + 4 =$	$6 + 9 =$	$8 + 3 =$	$2 + 9 =$
$3 + 8 =$	$4 + 9 =$	$9 + 6 =$	$7 + 8 =$	$2 + 9 =$
$2 + 8 =$	$9 + 1 =$	$5 + 9 =$	$6 + 5 =$	$6 + 7 =$
$9 + 6 =$	$19 + 1 =$	$8 + 3 =$	$5 + 8 =$	$6 + 5 =$
$6 + 4 =$	$7 + 6 =$	$2 + 8 =$	$9 + 2 =$	$6 + 5 =$
$2 + 9 =$	$1 + 9 =$	$1 + 19 =$	$9 + 7 =$	$9 + 2 =$
$5 + 5 =$	$7 + 6 =$	$2 + 8 =$	$6 + 6 =$	$17 + 3 =$

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$6 + 4 =$	$16 + 4 =$	$8 + 2 =$	$5 + 9 =$	$19 + 1 =$
$4 + 7 =$	$9 + 3 =$	$2 + 9 =$	$9 + 5 =$	$4 + 7 =$
$2 + 8 =$	$6 + 4 =$	$5 + 15 =$	$5 + 6 =$	$6 + 6 =$
$2 + 8 =$	$7 + 4 =$	$4 + 6 =$	$6 + 6 =$	$4 + 6 =$
$6 + 6 =$	$8 + 7 =$	$8 + 2 =$	$6 + 7 =$	$13 + 7 =$
$17 + 3 =$	$9 + 8 =$	$4 + 7 =$	$8 + 7 =$	$3 + 17 =$
$7 + 3 =$	$4 + 9 =$	$8 + 12 =$	$3 + 9 =$	$8 + 3 =$
$5 + 5 =$	$9 + 2 =$	$9 + 7 =$	$3 + 8 =$	$3 + 9 =$
$5 + 6 =$	$9 + 2 =$	$5 + 7 =$	$4 + 6 =$	$1 + 9 =$
$6 + 5 =$	$3 + 9 =$	$8 + 2 =$	$8 + 7 =$	$2 + 8 =$
$8 + 12 =$	$8 + 12 =$	$4 + 6 =$	$5 + 15 =$	$8 + 2 =$
$9 + 1 =$	$8 + 7 =$	$5 + 8 =$	$8 + 6 =$	$19 + 1 =$
$3 + 8 =$	$2 + 8 =$	$9 + 2 =$	$7 + 5 =$	$8 + 7 =$
$7 + 4 =$	$14 + 6 =$	$6 + 6 =$	$5 + 7 =$	$3 + 8 =$
$7 + 5 =$	$6 + 6 =$	$8 + 3 =$	$6 + 6 =$	$8 + 7 =$
$7 + 3 =$	$5 + 15 =$	$8 + 7 =$	$6 + 8 =$	$3 + 9 =$
$6 + 4 =$	$2 + 8 =$	$3 + 8 =$	$7 + 3 =$	$3 + 9 =$
$11 + 9 =$	$3 + 17 =$	$4 + 6 =$	$6 + 6 =$	$9 + 2 =$
$5 + 9 =$	$8 + 3 =$	$7 + 6 =$	$3 + 8 =$	$9 + 11 =$
$4 + 6 =$	$5 + 6 =$	$4 + 6 =$	$8 + 2 =$	$4 + 7 =$

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$4 + 6 =$	$14 + 6 =$	$13 + 7 =$	$4 + 6 =$	$3 + 7 =$
$8 + 3 =$	$17 + 3 =$	$7 + 5 =$	$2 + 18 =$	$3 + 7 =$
$9 + 2 =$	$6 + 7 =$	$8 + 3 =$	$9 + 9 =$	$7 + 9 =$
$3 + 9 =$	$5 + 6 =$	$7 + 8 =$	$4 + 6 =$	$7 + 6 =$
$3 + 9 =$	$8 + 2 =$	$1 + 9 =$	$7 + 6 =$	$2 + 8 =$
$6 + 5 =$	$7 + 13 =$	$3 + 7 =$	$8 + 7 =$	$3 + 9 =$
$6 + 7 =$	$6 + 4 =$	$4 + 9 =$	$7 + 7 =$	$17 + 3 =$
$3 + 7 =$	$8 + 2 =$	$7 + 13 =$	$6 + 4 =$	$3 + 8 =$
$4 + 7 =$	$4 + 7 =$	$1 + 9 =$	$8 + 4 =$	$1 + 9 =$
$5 + 5 =$	$7 + 13 =$	$7 + 5 =$	$4 + 6 =$	$5 + 5 =$
$3 + 7 =$	$5 + 9 =$	$8 + 2 =$	$6 + 14 =$	$9 + 11 =$
$1 + 9 =$	$9 + 8 =$	$3 + 7 =$	$6 + 7 =$	$9 + 4 =$
$8 + 4 =$	$5 + 5 =$	$9 + 1 =$	$9 + 4 =$	$5 + 5 =$
$5 + 9 =$	$6 + 8 =$	$3 + 17 =$	$6 + 5 =$	$3 + 17 =$
$6 + 4 =$	$5 + 6 =$	$9 + 4 =$	$6 + 6 =$	$4 + 6 =$
$8 + 7 =$	$4 + 6 =$	$3 + 9 =$	$7 + 7 =$	$5 + 7 =$
$4 + 6 =$	$8 + 2 =$	$7 + 8 =$	$9 + 1 =$	$7 + 3 =$
$7 + 3 =$	$1 + 9 =$	$6 + 4 =$	$2 + 9 =$	$13 + 7 =$
$8 + 12 =$	$7 + 4 =$	$3 + 9 =$	$5 + 7 =$	$8 + 5 =$
$5 + 8 =$	$7 + 9 =$	$9 + 2 =$	$3 + 8 =$	$9 + 1 =$

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$7 + 7 =$	$13 + 7 =$	$7 + 6 =$	$8 + 6 =$	$4 + 7 =$
$4 + 7 =$	$7 + 4 =$	$4 + 9 =$	$5 + 5 =$	$4 + 6 =$
$6 + 9 =$	$7 + 7 =$	$6 + 7 =$	$8 + 2 =$	$7 + 8 =$
$4 + 7 =$	$5 + 15 =$	$7 + 4 =$	$8 + 7 =$	$3 + 7 =$
$6 + 4 =$	$19 + 1 =$	$9 + 6 =$	$3 + 8 =$	$6 + 8 =$
$7 + 5 =$	$4 + 8 =$	$2 + 18 =$	$5 + 6 =$	$5 + 9 =$
$4 + 7 =$	$9 + 11 =$	$7 + 7 =$	$3 + 8 =$	$9 + 5 =$
$7 + 6 =$	$7 + 3 =$	$8 + 6 =$	$1 + 9 =$	$5 + 6 =$
$5 + 8 =$	$8 + 4 =$	$9 + 3 =$	$2 + 8 =$	$3 + 8 =$
$8 + 2 =$	$13 + 7 =$	$5 + 8 =$	$3 + 17 =$	$2 + 9 =$
$9 + 2 =$	$9 + 2 =$	$1 + 9 =$	$4 + 8 =$	$9 + 5 =$
$8 + 3 =$	$9 + 2 =$	$6 + 4 =$	$5 + 6 =$	$9 + 11 =$
$16 + 4 =$	$6 + 14 =$	$5 + 8 =$	$7 + 4 =$	$4 + 16 =$
$8 + 4 =$	$7 + 13 =$	$4 + 7 =$	$9 + 3 =$	$4 + 8 =$
$8 + 3 =$	$2 + 9 =$	$7 + 5 =$	$4 + 8 =$	$4 + 6 =$
$3 + 8 =$	$11 + 9 =$	$6 + 8 =$	$7 + 3 =$	$5 + 9 =$
$2 + 9 =$	$6 + 5 =$	$4 + 8 =$	$9 + 5 =$	$5 + 9 =$
$8 + 7 =$	$4 + 9 =$	$7 + 8 =$	$8 + 5 =$	$19 + 1 =$
$7 + 13 =$	$8 + 6 =$	$5 + 6 =$	$19 + 1 =$	$7 + 6 =$
$3 + 7 =$	$17 + 3 =$	$7 + 3 =$	$4 + 6 =$	$2 + 18 =$

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$1 + 9 =$	$5 + 6 =$	$6 + 8 =$	$7 + 9 =$	$6 + 7 =$
$7 + 4 =$	$6 + 7 =$	$6 + 4 =$	$7 + 9 =$	$7 + 3 =$
$9 + 7 =$	$3 + 17 =$	$7 + 13 =$	$9 + 6 =$	$5 + 7 =$
$9 + 1 =$	$2 + 9 =$	$7 + 5 =$	$6 + 5 =$	$9 + 8 =$
$7 + 7 =$	$3 + 8 =$	$5 + 6 =$	$6 + 9 =$	$4 + 8 =$
$1 + 9 =$	$5 + 8 =$	$7 + 7 =$	$9 + 3 =$	$7 + 4 =$
$8 + 4 =$	$8 + 5 =$	$5 + 7 =$	$4 + 8 =$	$3 + 7 =$
$7 + 13 =$	$7 + 3 =$	$12 + 8 =$	$7 + 9 =$	$9 + 1 =$
$3 + 7 =$	$7 + 4 =$	$7 + 3 =$	$8 + 3 =$	$5 + 5 =$
$9 + 5 =$	$8 + 4 =$	$7 + 3 =$	$3 + 9 =$	$9 + 8 =$
$5 + 5 =$	$5 + 5 =$	$7 + 6 =$	$4 + 8 =$	$8 + 5 =$
$5 + 5 =$	$6 + 6 =$	$4 + 9 =$	$5 + 15 =$	$14 + 6 =$
$4 + 7 =$	$5 + 7 =$	$9 + 11 =$	$4 + 8 =$	$8 + 5 =$
$8 + 4 =$	$5 + 6 =$	$5 + 6 =$	$6 + 7 =$	$5 + 8 =$
$5 + 15 =$	$14 + 6 =$	$2 + 8 =$	$5 + 6 =$	$8 + 3 =$
$8 + 3 =$	$8 + 6 =$	$6 + 4 =$	$7 + 9 =$	$15 + 5 =$
$4 + 9 =$	$8 + 12 =$	$6 + 8 =$	$9 + 5 =$	$3 + 8 =$
$5 + 7 =$	$8 + 4 =$	$8 + 6 =$	$7 + 8 =$	$5 + 8 =$
$9 + 5 =$	$9 + 1 =$	$4 + 7 =$	$8 + 3 =$	$7 + 4 =$
$2 + 9 =$	$4 + 6 =$	$1 + 19 =$	$5 + 6 =$	$1 + 9 =$

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$3 + 8 =$	$7 + 5 =$	$8 + 6 =$	$5 + 8 =$	$6 + 6 =$
$6 + 7 =$	$2 + 8 =$	$5 + 8 =$	$1 + 9 =$	$7 + 7 =$
$5 + 7 =$	$6 + 6 =$	$12 + 8 =$	$4 + 6 =$	$3 + 8 =$
$8 + 3 =$	$7 + 4 =$	$5 + 5 =$	$7 + 3 =$	$6 + 8 =$
$7 + 4 =$	$4 + 7 =$	$7 + 6 =$	$4 + 7 =$	$5 + 6 =$
$9 + 11 =$	$9 + 2 =$	$9 + 1 =$	$15 + 5 =$	$7 + 6 =$
$1 + 9 =$	$9 + 5 =$	$7 + 4 =$	$7 + 9 =$	$8 + 9 =$
$8 + 8 =$	$4 + 7 =$	$8 + 2 =$	$2 + 8 =$	$5 + 9 =$
$2 + 8 =$	$6 + 6 =$	$6 + 5 =$	$4 + 8 =$	$2 + 8 =$
$6 + 7 =$	$9 + 3 =$	$9 + 4 =$	$16 + 4 =$	$7 + 4 =$
$9 + 1 =$	$7 + 3 =$	$8 + 3 =$	$6 + 4 =$	$6 + 4 =$
$8 + 3 =$	$7 + 7 =$	$5 + 8 =$	$6 + 6 =$	$8 + 4 =$
$5 + 5 =$	$4 + 6 =$	$5 + 6 =$	$7 + 8 =$	$4 + 7 =$
$5 + 6 =$	$7 + 4 =$	$9 + 6 =$	$8 + 3 =$	$8 + 7 =$
$5 + 8 =$	$4 + 8 =$	$4 + 16 =$	$5 + 7 =$	$8 + 9 =$
$7 + 3 =$	$4 + 6 =$	$7 + 3 =$	$4 + 7 =$	$1 + 9 =$
$5 + 5 =$	$4 + 8 =$	$6 + 6 =$	$16 + 4 =$	$6 + 8 =$
$3 + 7 =$	$8 + 5 =$	$6 + 9 =$	$7 + 4 =$	$7 + 13 =$
$1 + 9 =$	$9 + 11 =$	$3 + 8 =$	$9 + 1 =$	$4 + 8 =$
$1 + 9 =$	$7 + 5 =$	$8 + 4 =$	$6 + 6 =$	$6 + 5 =$

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