30

$28+5=28+2+3=33$

$28+5=28+2+3=33$

$46+7=46+4+3=53$

$53+8=53+7+1=61$

$19+6=19+1+5=25$

$27+5=27+3+2=32$

$68+7=68+2+5=75$